

NOTES (UNLESS OTHERWISE SPECIFIED):

1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X873049-COVER-CHASSIS-REAR-ASSY-REVB.ASM
2. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
3. ACCESSIBLE SHARP EDGES NOT PERMITTED. BURR SHALL BE TOWARDS SURFACE INDICATED IN PART DRAWING. MAX BURR SIZE TO BE 10% OF MATERIAL THICKNESS AND IN COMPLIANCE WITH UL1439 STANDARD ON ALL ACCESSIBLE EDGES.
4. REFERENCE THE LATEST REVISION OF THE FOLLOWING DOCUMENTS FOR INSPECTION AND ACCEPTANCE CRITERIA:

A. MICROSOFT METAL QUALIFICATION PROCESS (D00435)

B. MICROSOFT SHEET METAL PART WORKMANSHIP STANDARDS (D00034)

C. MICROSOFT RESTRICTED SUBSTANCES FOR HARDWARE PRODUCTS (H00594)

D. MICROSOFT RESTRICTED SUBSTANCES CONTROL SYSTEM (H00642)

E. MICROSOFT PAINTED PRODUCT WORKMANSHIP AND TEST SPECIFICATION (H00388)

F. MICROSOFT SYSTEM EMC DESIGN RULES AND GUIDELINES (D00755)
5. FAI IQC/OQC FIXTURES REQUIRED AND MUST BE APPROVED BY MICROSOFT ENGINEERING. FREE STATE INSPECTION CONDITIONS REQUIRED FOR FAI. ON-GOING PROCESS CONTROL INSPECTIONS SHALL BE DONE IN FREE STATE.

6. THE FOLLOWING INFORMATION SHALL BE MARKED IN A PERMANENT AND LEGIBLE MANNER, LOCATED WHERE INDICATED. CHARACTERS SHALL BE A MINIMUM OF 3.0mm TALL.

A. MICROSOFT ASSEMBLY NUMBER

B. CURRENT REVISION

7. PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.

8. METHOD OF JOINING ASSEMBLY AND QUANTITY OF JOINTS SHALL COMPLY WITH THE FOLLOWING SPECIFICATIONS:

- A. REAR COVER RIB BEAM (ITEM 2) SHALL BE FIXED TO REAR COVER PLATE (ITEM 1) WITH RIVET, NORMAL (ITEM #) (10X).

RIVETED PARTS SHALL MEET THE FOLLOWING REQUIREMENTS:

- A. MINIMUM PUSH OUT FORCE 68 KGF (150 LBS)
- B. MINIMUM PULL OUT FORCE 63.5 KGF (140 LBS)
- C. MINIMUM TORQUE OUT FORCE 20 KGF-CM (17 LBS-IN)
- D. MINIMUM LATERAL LOAD FORCE 65 KG (143 LBS) (FORCE EXERTED ON TOP EDGE)

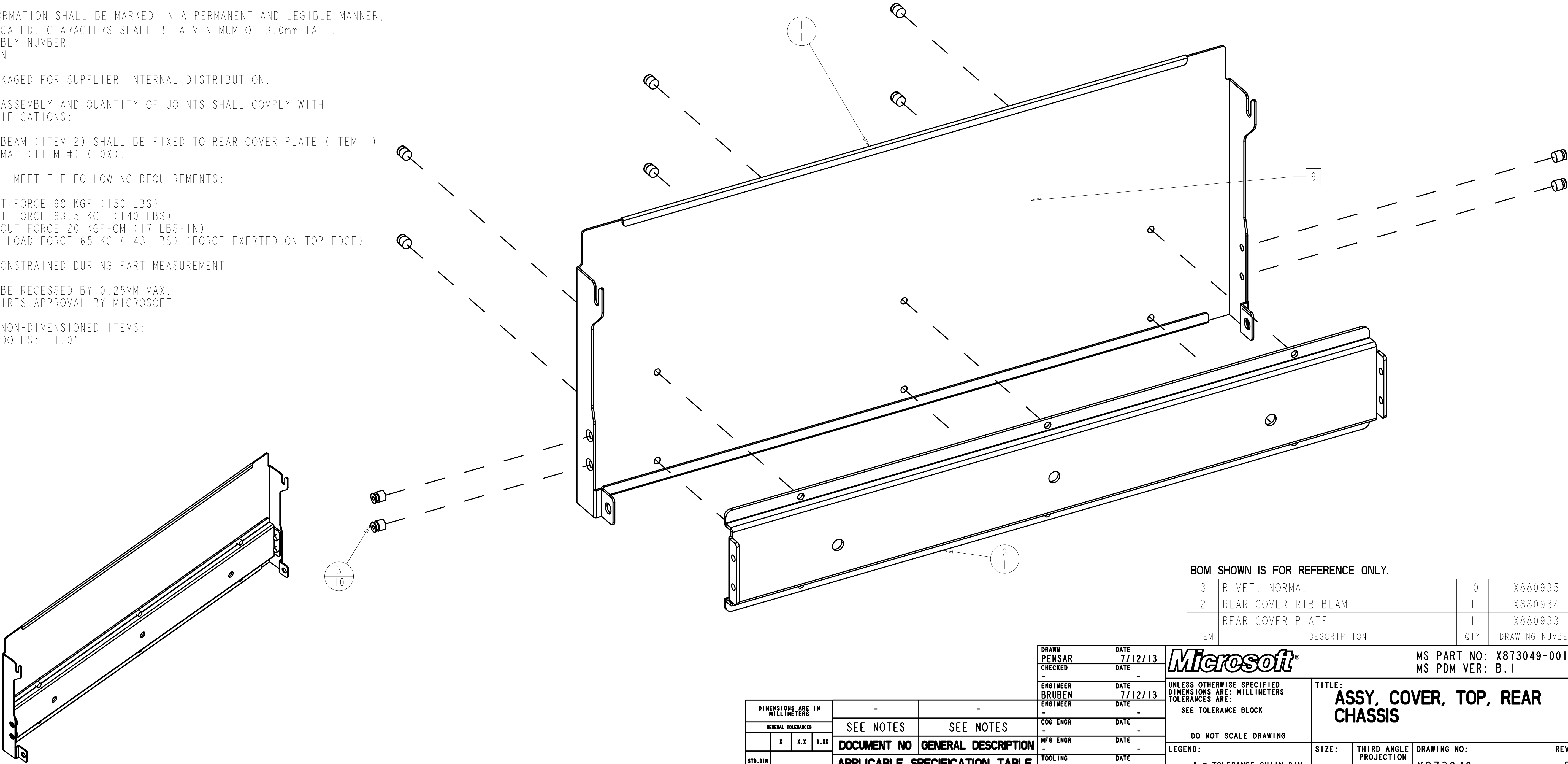
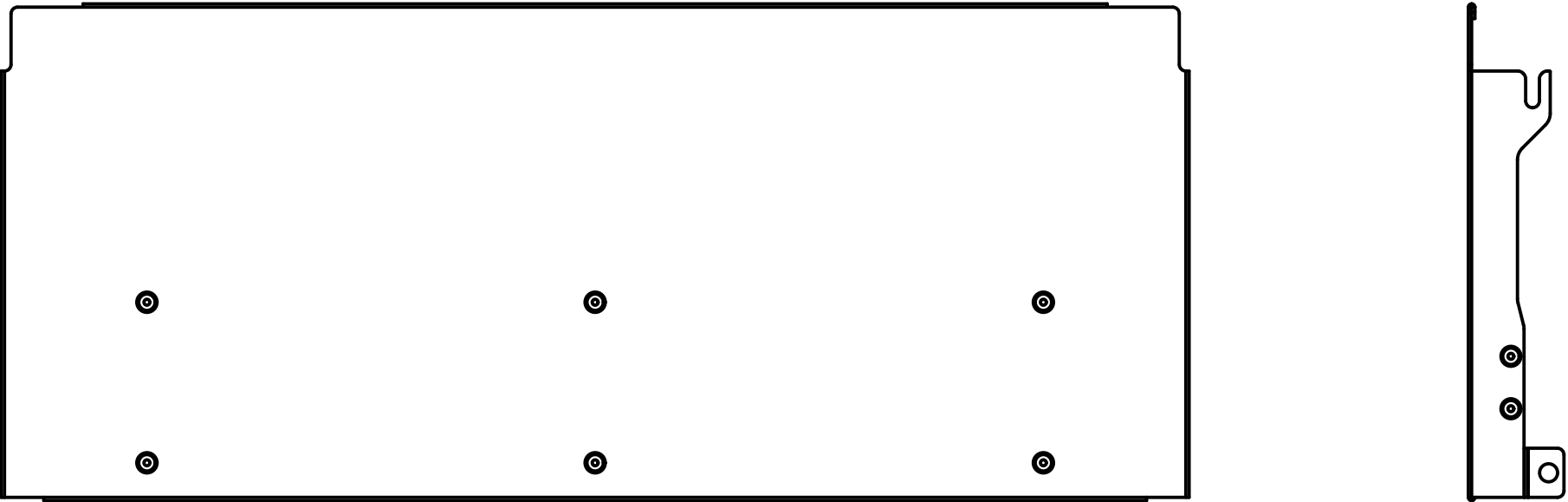
9. SIDE WALLS TO BE CONSTRAINED DURING PART MEASUREMENT

10. CARRY POINT SHALL BE RECESSED BY 0.25MM MAX. ANY DEVIATION REQUIRES APPROVAL BY MICROSOFT.

11. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:

ASSEMBLED STANDOFFS: ±1.0°

REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A	C50993	INITIAL RELEASE.	PENSAR	7/12/13
B	C53863	REMOVED SHEETS 2,3. CHANGED NOTES.	BROILI	3/17/14



BOM SHOWN IS FOR REFERENCE ONLY.

3	RIVET, NORMAL	10	X880935
2	REAR COVER RIB BEAM	1	X880934
1	REAR COVER PLATE	1	X880933
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

DIMENSIONS ARE IN MILLIMETERS			
GENERAL TOLERANCES			
	X	X.X	X.XX
STD. DIM	SEE NOTES		
ANGLE	SEE NOTES		
RADIUS	SEE NOTES		

DOCUMENT NO	GENERAL DESCRIPTION
APPLICABLE SPECIFICATION TABLE	
THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN ARE PROPRIETARY TO MICROSOFT CORPORATION AND SHALL NOT BE USED BY, OR DISCLOSED IN WHOLE OR IN PART TO ANYONE OUTSIDE OF MICROSOFT CORPORATION WITHOUT THE PRIOR WRITTEN PERMISSION OF MICROSOFT CORPORATION.	

DRAWN	DATE
PENSAR	7/12/13
CHECKED	DATE
-	-
ENGINEER	DATE
BRUBEN	7/12/13
ENGINEER	DATE
-	-
COG ENGR	DATE
-	-
MFG ENGR	DATE
-	-
TOOLING	DATE
-	-
QUALITY	DATE
-	-
RELEASED	DATE
-	-

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK	
DO NOT SCALE DRAWING	
LEGEND:	
★ = TOLERANCE CHAIN DIM	
■ = CRITICAL DIM	
● = TOOLING DIM	
▲ = PROCESS DIM	
Ⓢ = DIMENSION ID	

TITLE: ASSY, COVER, TOP, REAR CHASSIS		MS PART NO: X873049-001 MS PDM VER: B.1	
SIZE: D	THIRD ANGLE PROJECTION	DRAWING NO: X873049	REV: B
SCALE: 1.000		SHEET: 1 OF 1	