REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A	C51989	INITIAL RELEASE.	PENSAR	11/14/13
B	C53863	DFM FEEDBACK CHANGES	L CANNON	3/14/14

NOTES (UNLESS OTHERWISE SPECIFIED):

1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X887753-BULKHEAD-BLANK-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. 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.

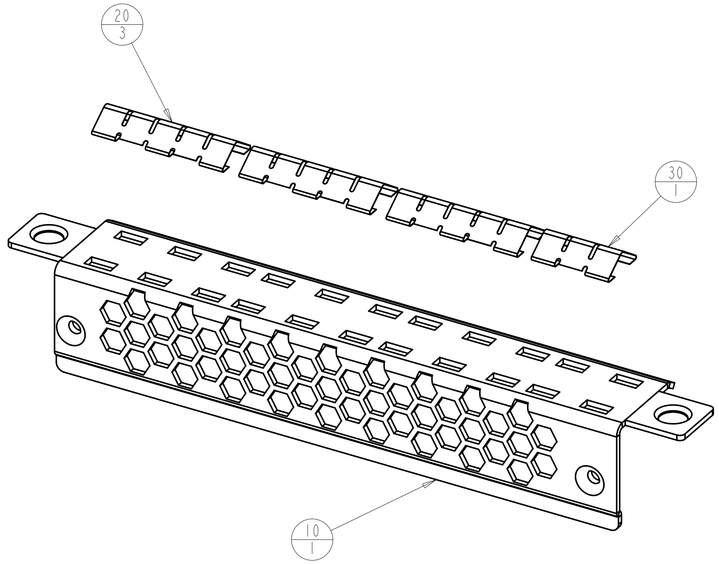
6. PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.

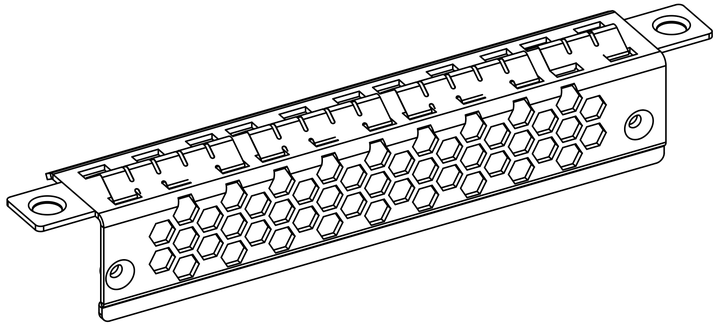
7. FLATNESS SHALL BE DEFINED AS 0.13MM/25.4MM X 25.4MM

8. ASSEMBLY:

   A. 6-FINGER EMI GASKET (ITEM 20) (QTY 3) SHALL BE SNAPPED INTO BULKHEAD BLANK (ITEM 10).
   B. 4-FINGER EMI GASKET (ITEM 30) SHALL BE SNAPPED INTO BULKHEAD BLANK (ITEM 10).

9. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
   HOLE DIAMETER: ±0.08
   HOLE TO HOLE: ±0.13
   HOLE TO EDGE: ±0.13
   EDGE TO EDGE: ±0.13
   HOLE TO BEND: ±0.13
   EDGE TO BEND: ±0.21
   BEND TO BEND: ±0.26
   EMBOSS DEPTH: ±0.26
   ANGLE: ±1.0°





BOM SHOWN IS FOR REFERENCE ONLY. SEE TEAM CENTER FOR COMPLETE BOM.

ITEM	DESCRIPTION	QTY	DRAWING NUMBER
30	GASKET, EMI, SNAP-IN STRIP, 4-FINGER	1	X887754
20	GASKET, EMI, SNAP-IN STRIP, 6-FINGER	3	X882357
10	STAMPING, BULKHEAD BLANK	1	X887752

DRAWN PENSAR	DATE 11/5/13	Microsoft®	MS PART NO: X887753-001 MS PDM VER: B.1
CHECKED -	DATE -		
ENGINEER BRUBEN	DATE 11/5/13	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK DO NOT SCALE DRAWING	TITLE: ASSY, BULKHEAD BLANK
ENGINEER -	DATE -		
COG ENGR -	DATE -		
MFG ENGR -	DATE -	LEGEND: ★ = TOLERANCE CHAIN DIM ▣ = CRITICAL DIM ◉ = TOOLING DIM △ = PROCESS DIM ⓓ = DIMENSION ID	SIZE: D THIRD ANGLE PROJECTION
TOOLING -	DATE -		DRAWING NO: X887753 REV: B
QUALITY -	DATE -		SCALE: 2.000 SHEET: 1 OF 1
RELEASED -	DATE -		

DIMENSIONS ARE IN MILLIMETERS				-	-
GENERAL TOLERANCES				SEE NOTES	SEE NOTES
	X	X.X	X.XX	DOCUMENT NO	GENERAL DESCRIPTION
STD.DIM	SEE NOTES			APPLICABLE SPECIFICATION TABLE	
ANGLE					
RADIUS					

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