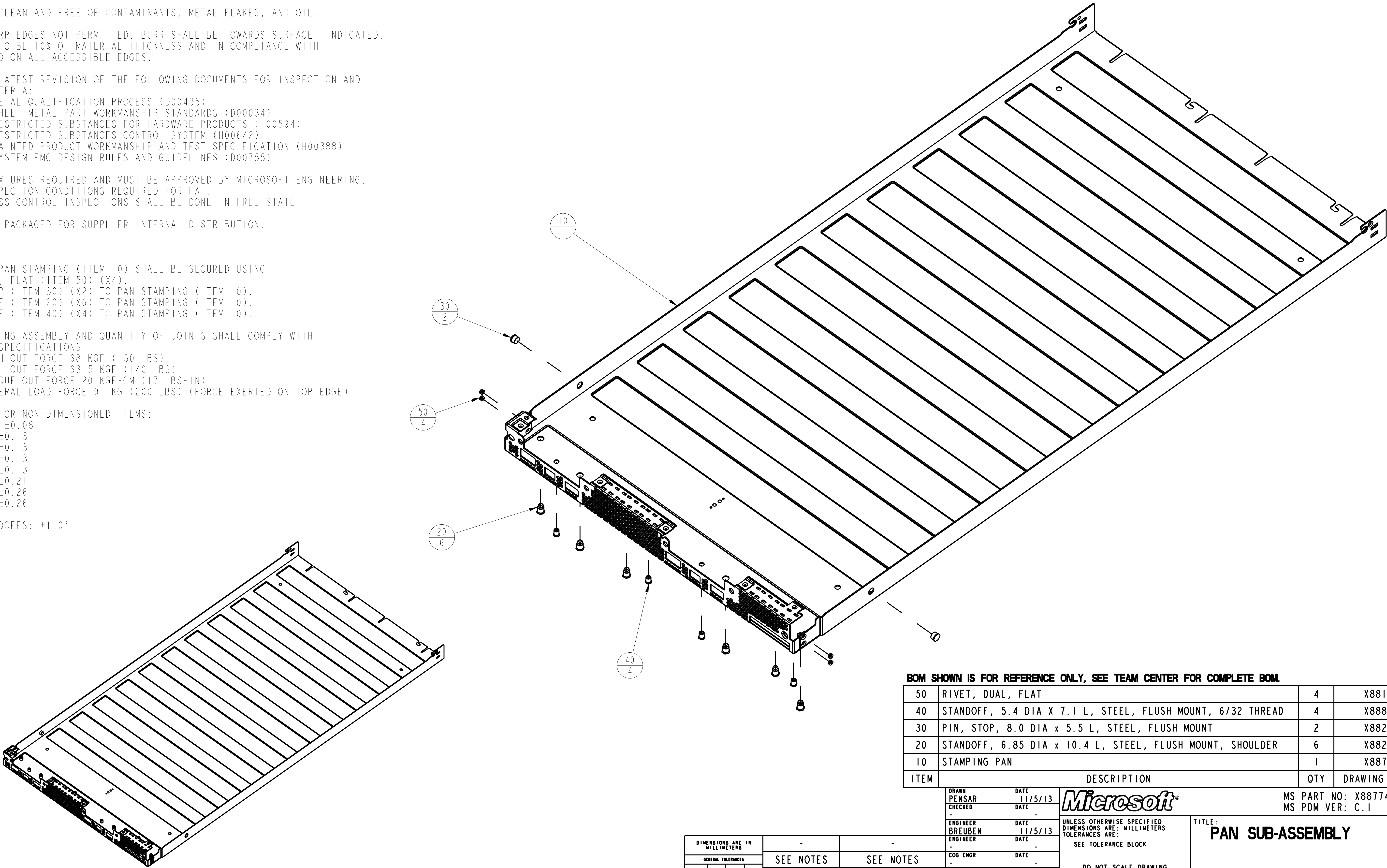


NOTES (UNLESS OTHERWISE SPECIFIED):

- DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X887748-PAN-SUB-ASSY-REVC.ASM
- PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
- ACCESSIBLE SHARP EDGES NOT PERMITTED. BURR SHALL BE TOWARDS SURFACE INDICATED. MAX BURR SIZE TO BE 10% OF MATERIAL THICKNESS AND IN COMPLIANCE WITH ULI439 STANDARD ON ALL ACCESSIBLE EDGES.
- 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)
- 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.
- PARTS SHALL BE PACKAGED FOR SUPPLIER INTERNAL DISTRIBUTION.
- ASSEMBLY:
A. CORNERS OF PAN STAMPING (ITEM 10) SHALL BE SECURED USING RIVET, DUAL, FLAT (ITEM 50) (X4).
B. FIX PIN STOP (ITEM 30) (X2) TO PAN STAMPING (ITEM 10).
C. FIX STANDOFF (ITEM 20) (X6) TO PAN STAMPING (ITEM 10).
D. FIX STANDOFF (ITEM 40) (X4) TO PAN STAMPING (ITEM 10).
- METHOD OF JOINING ASSEMBLY AND QUANTITY OF JOINTS SHALL COMPLY WITH THE FOLLOWING SPECIFICATIONS:
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 91 KG (200 LBS) (FORCE EXERTED ON TOP EDGE)
- 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: $\pm 1.0^\circ$
ASSEMBLED STANDOFFS: $\pm 1.0^\circ$

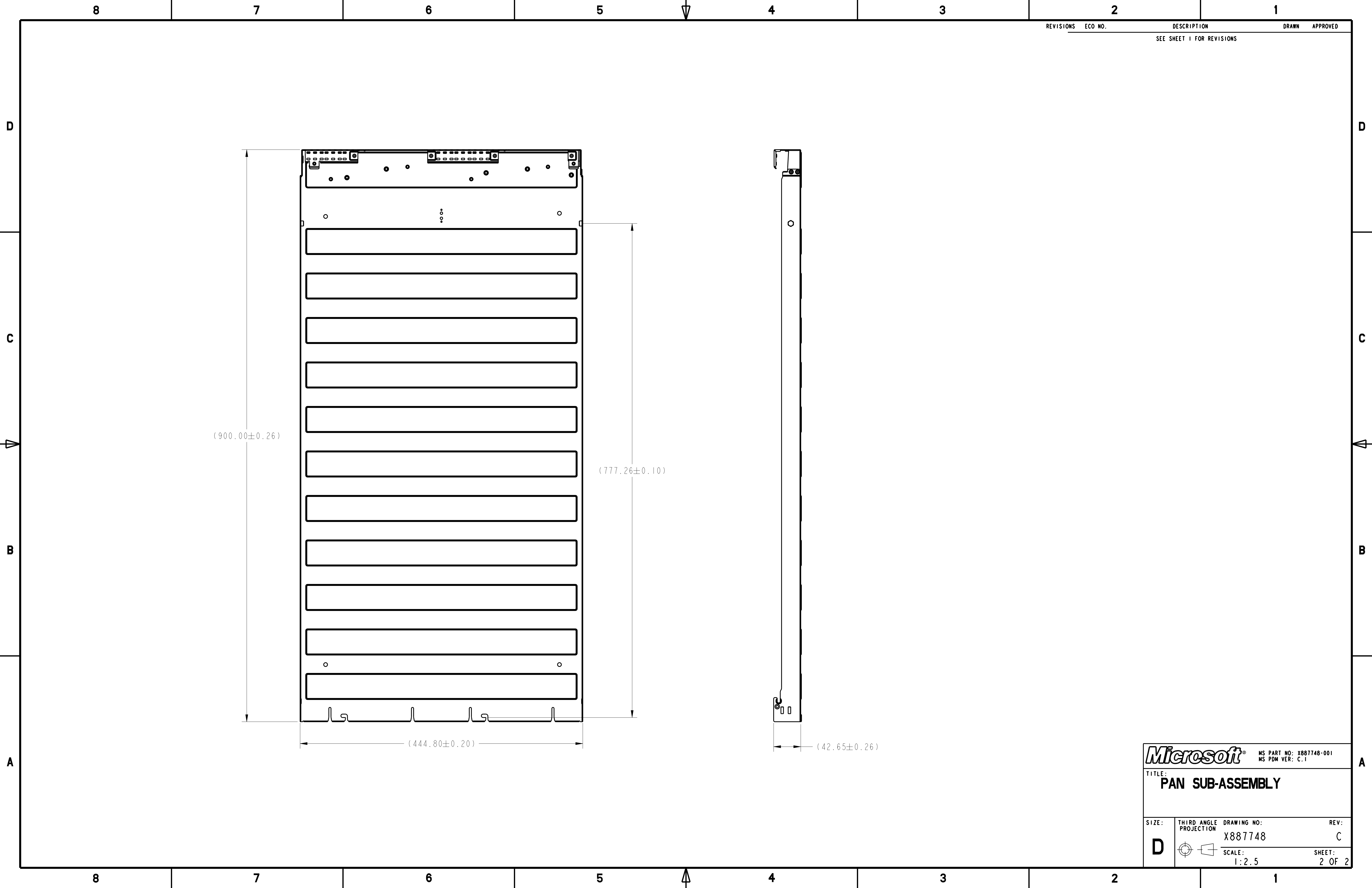
REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A		INITIAL RELEASE	PENSAR	11/14/13
B		DFM FEEDBACK CHANGES	L CANNON	3/14/14
C		MOD PART X887749	B BROILLI	5/30/14



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

ITEM	DESCRIPTION	QTY	DRAWING NUMBER
50	RIVET, DUAL, FLAT	4	X881053
40	STANDOFF, 5.4 DIA X 7.1 L, STEEL, FLUSH MOUNT, 6/32 THREAD	4	X888659
30	PIN, STOP, 8.0 DIA x 5.5 L, STEEL, FLUSH MOUNT	2	X882328
20	STANDOFF, 6.85 DIA x 10.4 L, STEEL, FLUSH MOUNT, SHOULDER	6	X882327
10	STAMPING PAN	1	X887749

DIMENSIONS ARE IN MILLIMETERS		-		-	
GENERAL TOLERANCES		SEE NOTES		SEE NOTES	
STD. DIM	X	X.X	X.XX	DOCUMENT NO	GENERAL DESCRIPTION
ANGLE	SEE NOTES				APPLICABLE SPECIFICATION TABLE
RADIUS					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 PENSAR		DATE 11/5/13		Microsoft	
CHECKED		DATE		MS PART NO: X887748-001	
ENGINEER BREUBEN		DATE 11/5/13		MS PDM VER: C.1	
ENGINEER		DATE		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK	
COG ENGR		DATE		DO NOT SCALE DRAWING	
MFG ENGR		DATE		LEGEND: ★ = TOLERANCE CHAIN DIM □ = CRITICAL DIM ○ = TOOLING DIM △ = PROCESS DIM Ⓢ = DIMENSION ID	
TOOLING		DATE		SIZE: D	
QUALITY		DATE		THIRD ANGLE PROJECTION	
RELEASED		DATE		DRAWING NO: X887748	
				REV: C	
				SCALE: 1:2	
				SHEET: 1 OF 2	



MS PART NO: X887748-001
MS PDM VER: C.1

TITLE:
PAN SUB-ASSEMBLY

SIZE:
D

THIRD ANGLE
PROJECTION

DRAWING NO:
X887748

REV:
C

SCALE:
1:2.5

SHEET:
2 OF 2