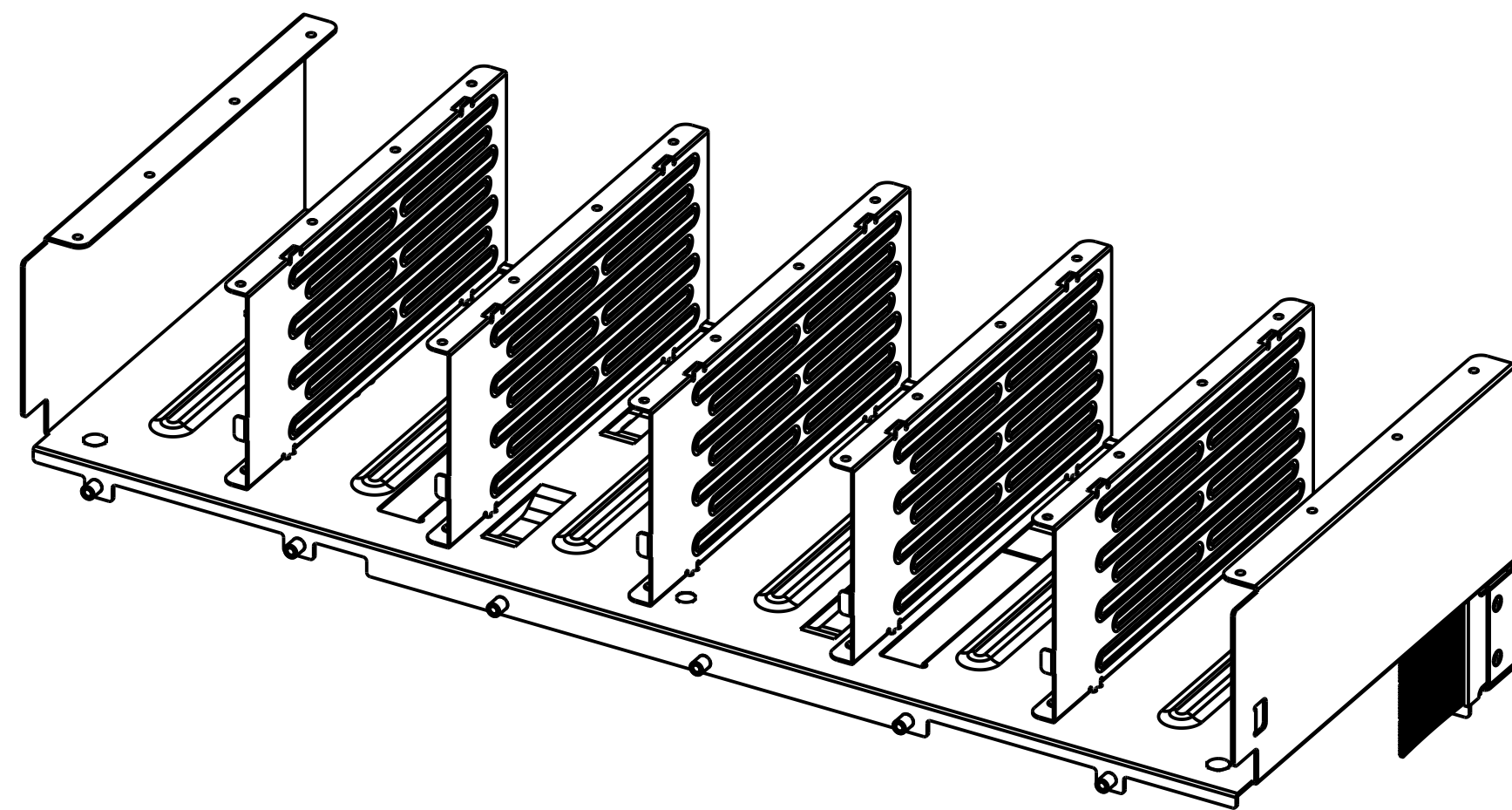
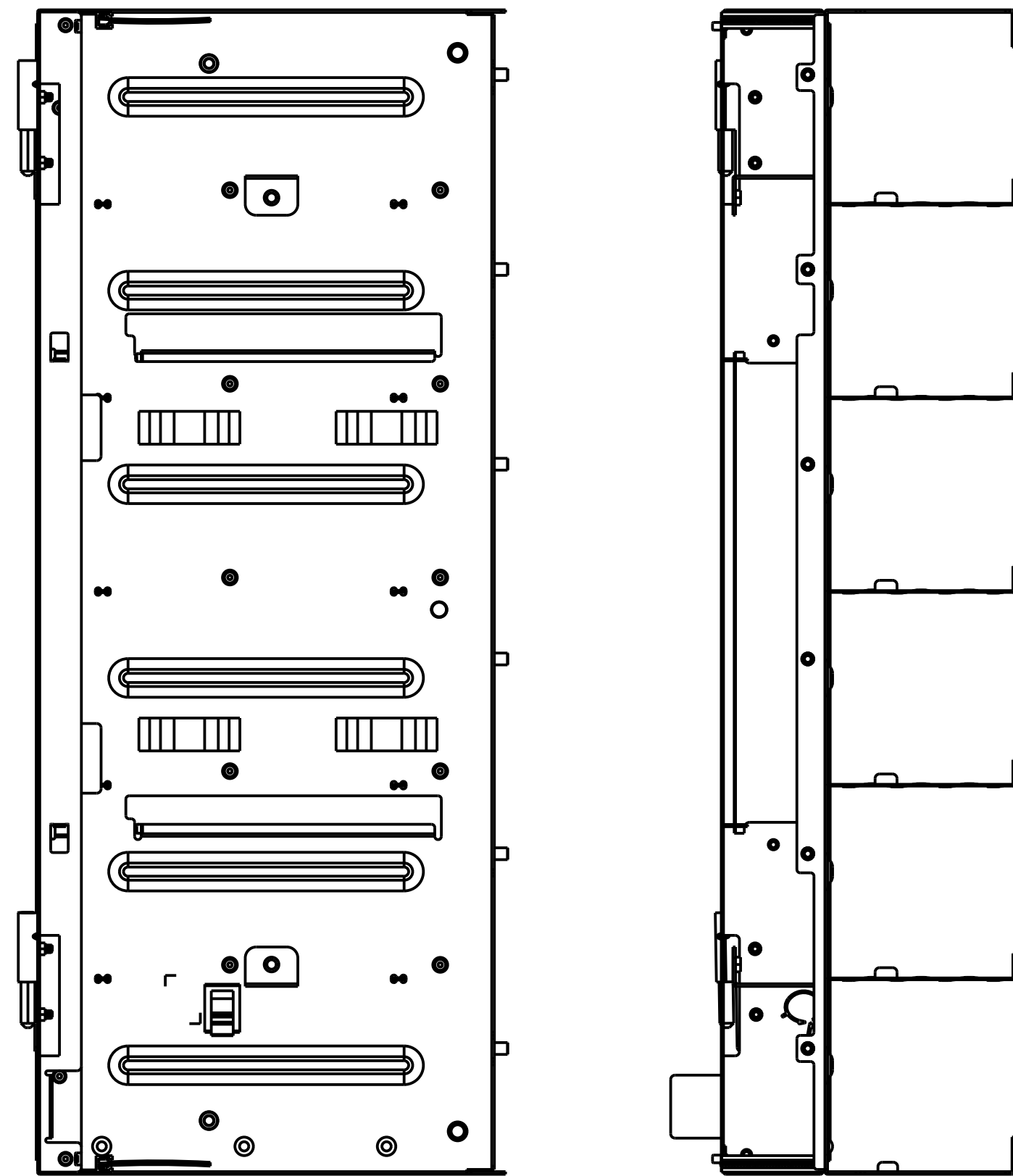
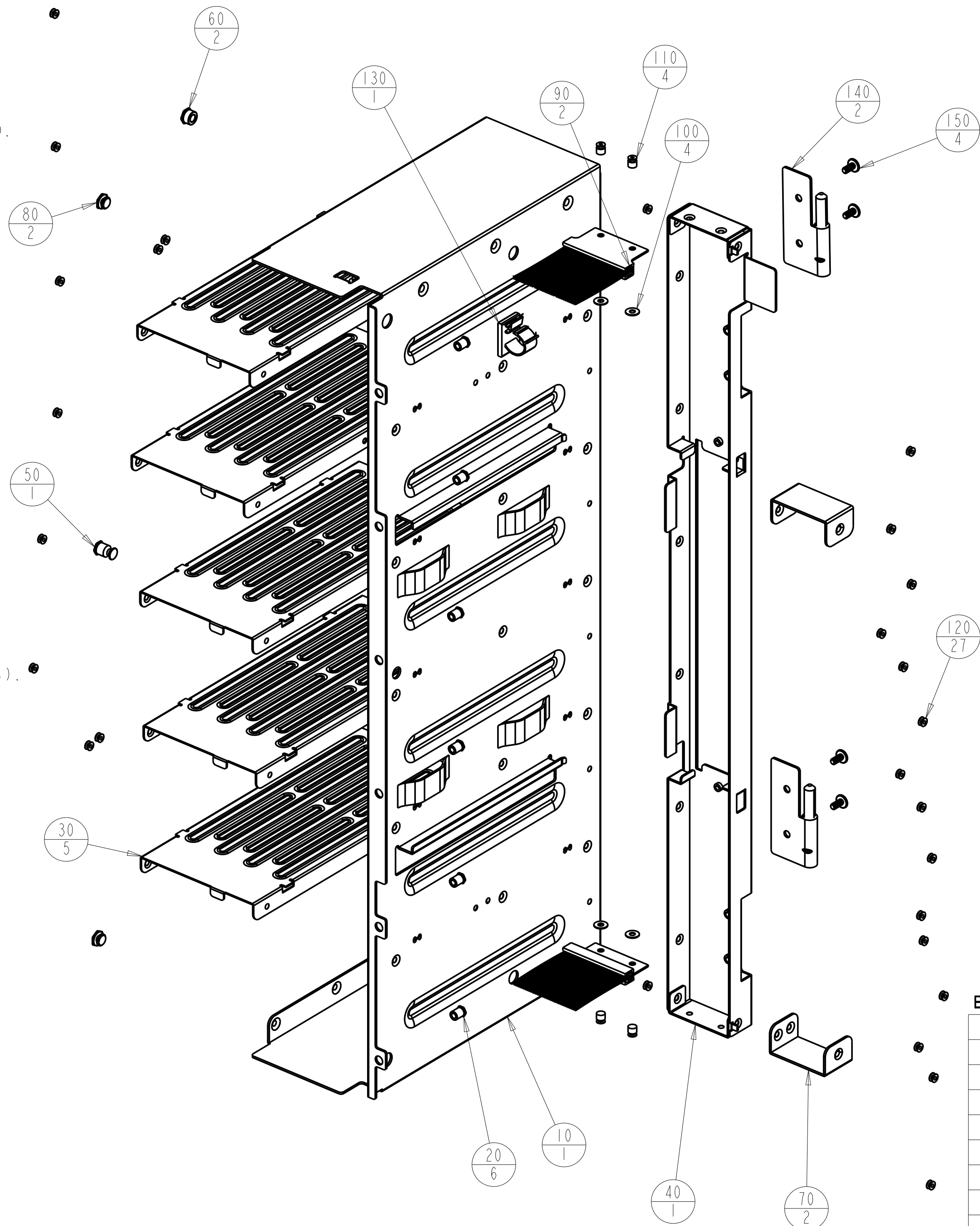


1. DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X891480-PSU-CAGE-LFF-ASSY-REVD.ASM
2. PART SHALL BE CLEAN AND FREE OF CONTAMINANTS, METAL FLAKES, AND OIL.
3. ACCESSIBLE SHARP EDGES NOT PERMITTED. BURR SHALL BE TOWARDS SURFACE INDICATED. MAX 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 IOC/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. ASSEMBLY:
 - A. GUIDE PIN (ITEM 50) AND STANDOFFS (ITEM 20, X6) (ITEM 60, X2) (ITEM 80, X2) SHALL BE PRESSED INTO PSU CAGE BRKT (ITEM 10).
 - B. PSU CAGE DIVIDER (ITEM 30, X5) SHALL BE FIXED TO PSU CAGE BRKT (ITEM 10) USING RIVET, DUAL, FLAT (ITEM 120, X15).
 - C. CABLE DUCT HOLDER BRKT (ITEM 70, X2) SHALL BE FIXED TO PSU CAGE BRKT (ITEM 10) USING RIVET, DUAL, FLAT (ITEM 120, X4).
 - D. FAN MODULE HOLDER (ITEM 40) SHALL BE FIXED TO PSU CAGE BRKT (ITEM 10) USING RIVET, DUAL, FLAT (ITEM 120, X6).
 - E. REAR COVER BRUSH (ITEM 90, X2) SHALL BE FIXED TO FAN MODULE HOLDER (ITEM 40) USING RIVET, NORMAL (ITEM 110, X4) AND WASHER, FLAT (ITEM 100, X4).
 - F. MALE HINGE ASSY (ITEM 140, X2) SHALL BE FIXED TO FAN MODULE HOLDER (ITEM 40) USING M4 X 8.0 SCREW (ITEM 150, X4).
 - G. CABLE CLIP (ITEM 130) SHALL BE FIXED TO PSU CAGE BRKT (ITEM 10).
- ALL ASSEMBLY MUST MEET THE REQUIREMENTS IN NOTE 8 BELOW.
8. 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)
9. TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
ASSEMBLED STANDOFFS: $\pm 1.0^\circ$



REV	ECO NO	DESCRIPTION	DRAWN	APVD DATE
A		INITIAL RELEASE.	PENSAR	11/6/13
B		REMOVED SHEET 2,3. CHANGED NOTES	BROILI	3/17/14
C		CHANGED 3D LOCATION OF CABLE CLIP X882382	BROILI	7/11/14
D		TITLE WAS: PSU CAGE LES ASSY.	G. HAZEN	07/31/14



150	SCREW, M4 X 8.0 L, 1-HEAD	4	X885973
140	ASSY, FAN HINGE, MALE	2	X885969
130	CLIP, FAN TRAY	1	X882382
120	RIVET, DUAL, FLAT	27	X881053
110	RIVET, NORMAL	4	X880935
100	WASHER, FLAT, 8.0 DIA x 0.5 THICK, STEEL	4	X885965
90	BRUSH, REAR COVER	2	X885962
80	STANDOFF, 8.5 DIA x 3.9 L, STEEL, FLUSH MOUNT, SHOULDER	2	X881041
70	BRKT, HOLDER, CABLE DUCT	2	X885960
60	STANDOFF, 8.0 DIA x 5.0 L, STEEL, FLUSH MOUNT, M5	2	X881042
50	PIN, GUIDE, 7.0 DIA x 11.4 L, STEEL, FLUSH MOUNT	1	X885958
40	HOLDER, MODULE, FAN	1	X885957
30	PSU DIVIDER LFF	5	X890862
20	STANDOFF, 5.4 DIA x 7.3 L, STEEL, FLUSH MOUNT, 6/32 THREAD	6	X885955
10	PSU CAGE BRACKET LFF	1	X891479
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

DRAWN	PENSAR	DATE	11/1/13	Microsoft®		MS PART NO: X891480-001			
CHECKED	-	DATE	-			MS PDM VER: D.I			
ENGINEER	-	DATE	11/1/13	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE: MILLIMETERS TOLERANCES ARE: SEE TOLERANCE BLOCK		TITLE:		PSU CAGE LFF ASSY	
ENGINEER	-	DATE	-						
COG EMGR	-	DATE	-						
MFG EMGR	-	DATE	-	DO NOT SCALE DRAWING					
TOOLING	-	DATE	-	LEGEND:		SIZE:		DRAWING NO: REV:	
QUALITY	-	DATE	-	★ = TOLERANCE CHAIN DIM		D		X891480 D	
RELEASED	-	DATE	-	■ = CRITICAL DIM				SCALE: SHEET:	
				● = TOOLING DIM				0.550 I OF	
				▲ = PROCESS DIM					
				Ⓜ = DIMENSION ID					

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