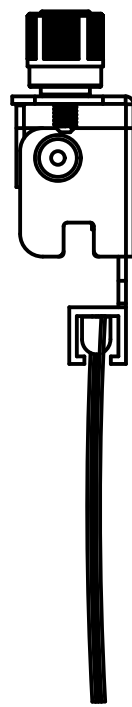
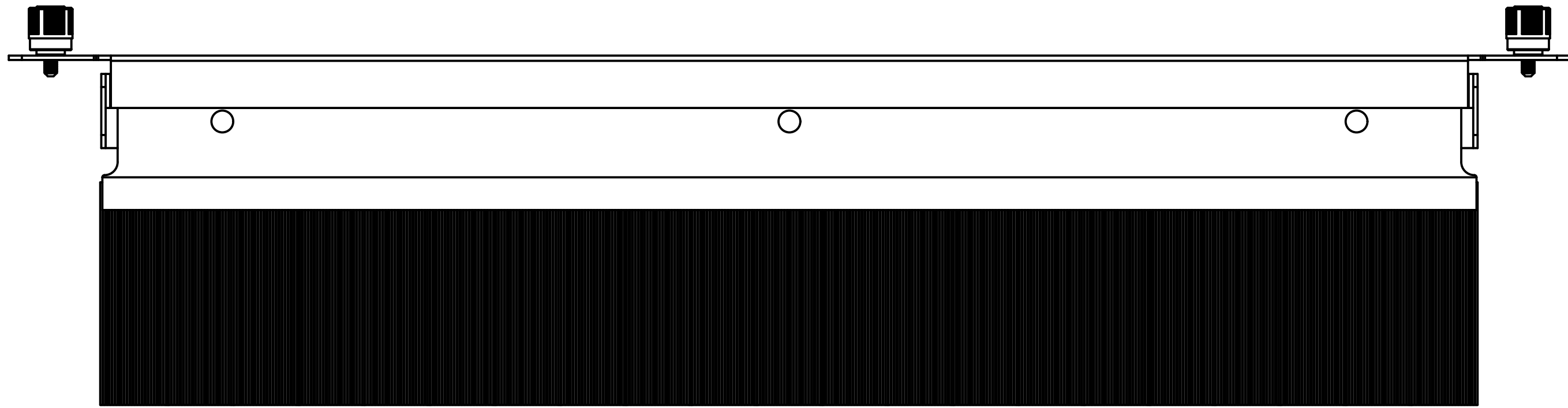
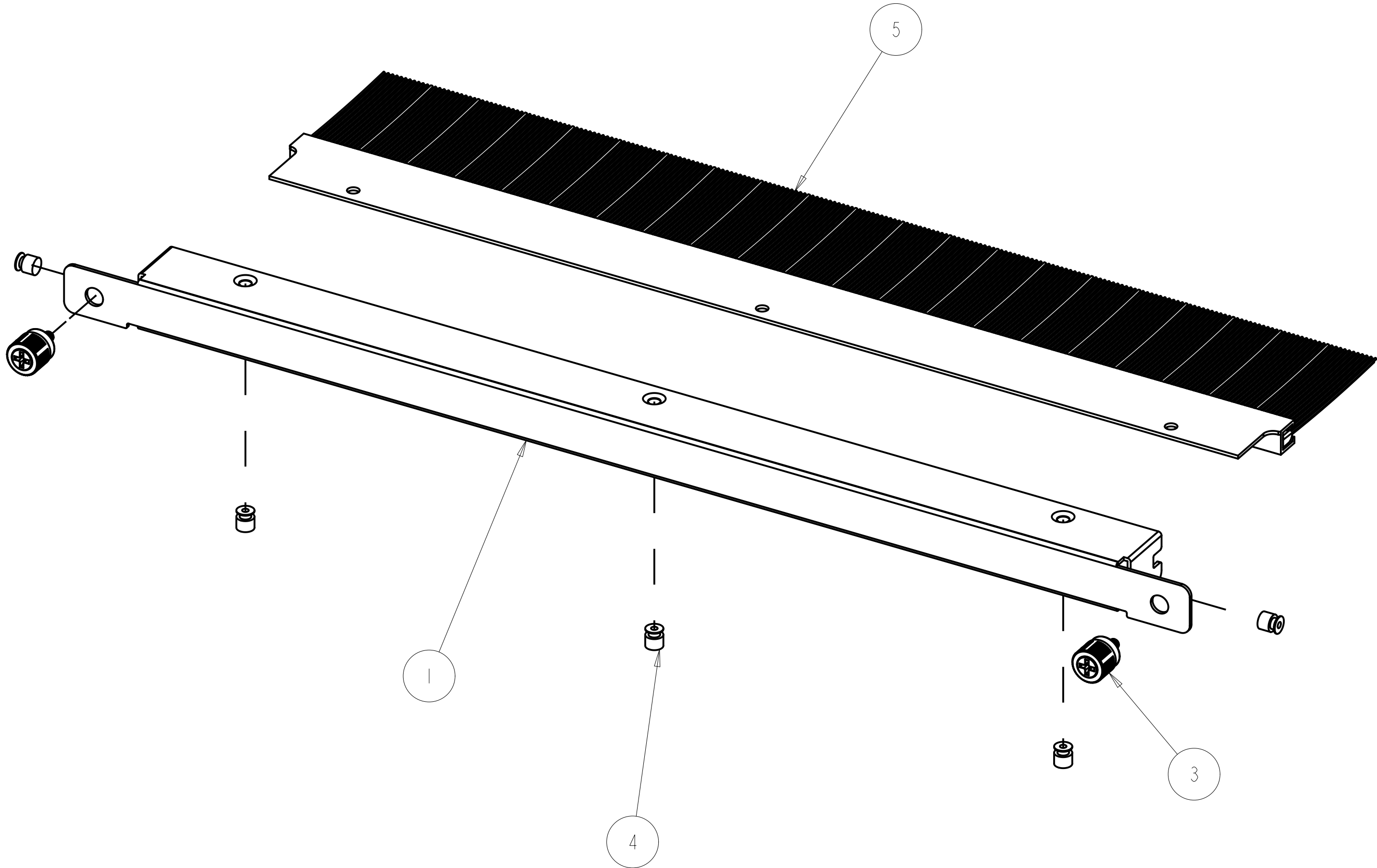


NOTES (UNLESS OTHERWISE SPECIFIED):

- DRAWINGS ARE FOR INSPECTION PURPOSES ONLY. ACTUAL PART SHALL CONFORM TO THE FOLLOWING 3D ELECTRONIC FILE: X881057-RR-SIDE-BEAM-ASSY-REV.B.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. BRUSH, RR COVER, ASSY (ITEM 2) SHALL BE FIXED TO BEAM, CHASSIS, REAR, SIDE (ITEM 1) BY RIVET, NORMAL (3X ITEM 4).
B. M3, SECURITY SCREW (2X ITEM 3) SHALL BE PRESSED INTO BEAM, CHASSIS, REAR, SIDE (ITEM 1).
ALL ASSEMBLY MUST MEET THE REQUIREMENTS IN NOTE 8 BELOW.
- 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 65 KG (143 LBS) (FORCE EXERTED ON TOP EDGE)
- TOLERANCE KEY FOR NON-DIMENSIONED ITEMS:
ASSEMBLED STANDOFFS: $\pm 1.0^{\circ}$



BOM SHOWN IS FOR REFERENCE ONLY.

5	ASSY, CHASSIS BRUSH, LONG	1	X881059
4	RIVET, NORMAL	5	X880935
3	M3 SECURITY SCREW	2	X881061
1	CHASSIS REAR SIDE BEAM	1	X881058
ITEM	DESCRIPTION	QTY	DRAWING NUMBER

DRAWN PENSAR CHECKED - ENGINEER BRUBEN ENGINEER - COG ENGR - MFG ENGR - TOOLING - QUALITY - RELEASED -		DATE 7/12/13 - 7/12/13 - - - - - - - -		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: CHASSIS REAR SIDE, BEAM ASSY		MS PART NO: X881057-001 MS PDM VER: B.1	
DIMENSIONS ARE IN MILLIMETERS		-		-		SEE NOTES		SEE NOTES	
GENERAL TOLERANCES		SEE NOTES		SEE NOTES		DOCUMENT NO		GENERAL DESCRIPTION	
STD. DIM		SEE NOTES		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.		SIZE: D	
ANGLE		SEE NOTES		THIRD ANGLE PROJECTION		DRAWING NO: X881057		REV: B	
RADIUS		SEE NOTES		SCALE: 1.000		SHEET: 1 OF 1			