



STG - Systems

## Server Packaging Instructions : x3200 M2 (4367, 4368), x3200 M3 (7327, 7328)

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### General Information

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Author(s)	Frank SF Chen/Taiwan/IBM
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- Information contained in this document is for reference purposes only .
- Process and Part Numbers may vary in each manufacturing location .
- Refer to local site procedures and Bill of Materials for any substitutions .
- No deviation is to be made to the overall assembly without prior written approval from the responsible Packaging Engineer .

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## Section 1 - Applicable Systems, MTM Listing

These packaging instructions apply to the following machine types:

### Server

4367, 4368

## Section 2 - Unit Packaging

2.1 - Assemble carton 43W4814 and tape the bottom flaps shut as shown.



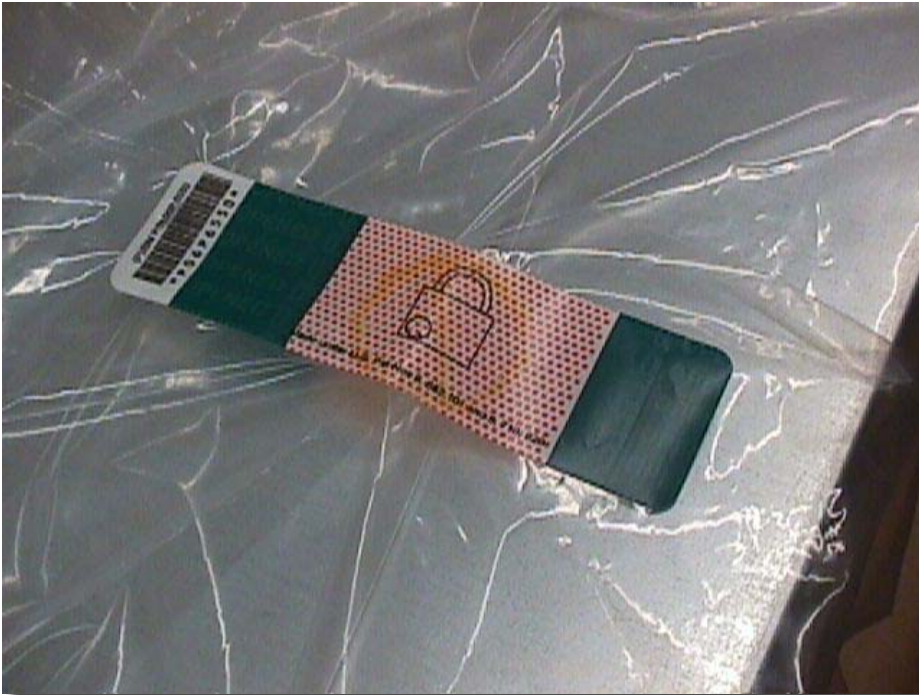
2.2 - Call machine to the packaging station. Verify the feet of unit are secure, verify unit is cosmetically clean and cover is correctly installed. Rotate machine and inspect all sides.

2.3 - Place bag 6165640 over the unit. (see illustration below).

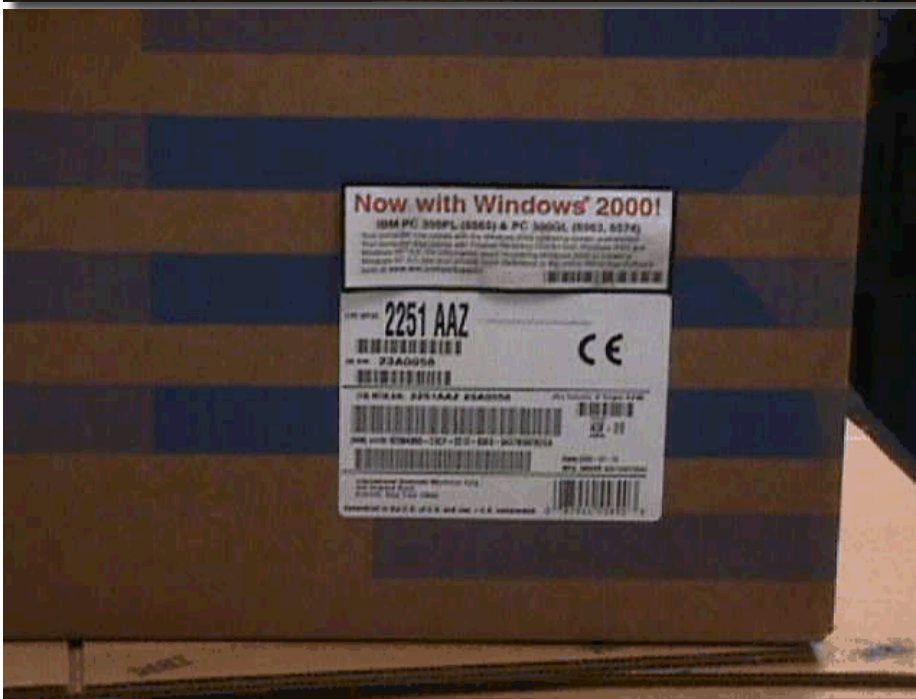
**Note:** Bag part number can vary depending on geography , and availability. Refer to Packaging BOM for clarification .



2.4 - Fold bag over, and seal bag closed with 06P6550 padlock label. (illustrated below).



2.5 - Remove labels from the printer and apply one carton label to the long side (length) panel using the tick mark provided. Align the bottom of the carton label with the bottom edge of the tick mark. With the carton on its side and while facing the length panel with label (just applied), apply second carton label to the adjacent short side (width) panel to the immediate right. Align the bottom of the carton label with the bottom edge of the tick mark. Orient the carton so its opening faces upwards.



If label 43W8515 (China RoHS label) is called out, place label adjacent to carton label directly to the left or right. This label must not be within 2" (50mm) of the edge or top of the carton.

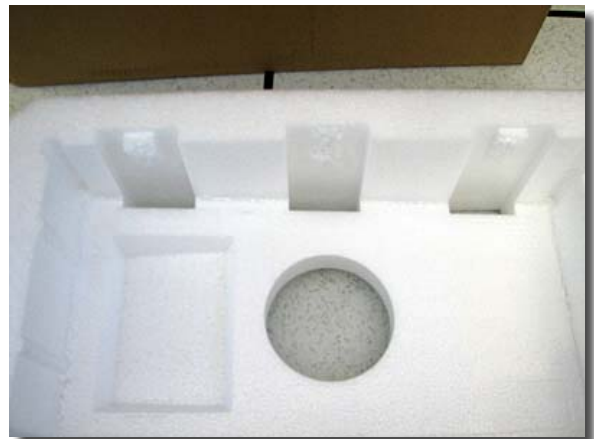
Examples of China RoHS label placement:



2.6 - For molded cushions using 43W4772 and 43W4773, rip off (3) T-shape ribs molded on the sidewall from each part. The ribs are no longer required and can be discarded.

Skip this step for cushions 43W4867 and 43W4868.

Skip this step for fabricated cushions 41Y4366 and 43W4921.



2.7 - Insert rear of system into rear cushion 43W4772 (or 43W4867/43W4921) as shown (plastic bag was removed here).



2.8 - Lift the cushioned system as shown and place it into bottom of carton . Inspect if the clearance is now on the bottom side of chassis .



2.9 - Place pads into the space on one side of carton.



2.10 - Fold cardboard filler 43W4815 and insert it into the space at the bottom of chassis.



2.11 - Insert keyboard set into the compartment of filler. Skip this step if there's no keyboard bundled in the build.



2.12 - Place powercord, mouse etc. into the compartment of filler shown below.



2.13 - Miscellaneous accessories (floppy drive, CD etc.) can be placed above keyboard set.



2.14 - Place rear cushion 43W4773 (or 43W4868/43W4921) on the rear side of chassis.

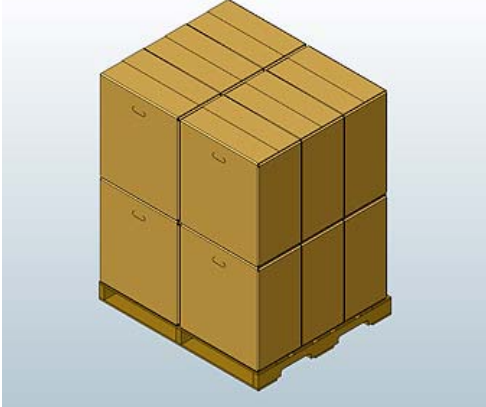


2.15 - Close and seal carton with IBM logo tape 74F5698 or 74F5699.



## Section 3 - Manufacturing Palletization and Distribution

### 3.1 - Distribution

Quantity	Half Pallet	Full Pallet	Ship Individual	Empty Box w/Label
1 - 2			x	
3	x			
4		x		2
5		x		1
6		x		
7 - 8		x	1 - 2	
9		x		3
10		x		2
11		x		1
12		x		
				

3.2 - Secure load to pallet utilizing "Best of Breed" palletization methods. See 92F6168 - "Best of Breed" Pallet Unitization or QMX document P-04146.

3.3 - Place two pallet labels on the front and left sides of the pallet load.

3.4 - Label load for shipment as necessary.

## Section 4 - Materials BOM Reference

Refer to BOM in PM for current BOM listing and BOM structure.

### WW Common Parts BOM - 43W4823

Part Number	Description	Qty
43W4814	Outer Carton	1
43W4867 or 43W4772	Molded Front Cushion (Geo dependant, refer to BOM for detail)	1
43W4868 or 43W4773	Molded Rear Cushion (Geo dependant, refer to BOM for detail)	1
41Y4366	Fabricated Front Cushion	Optional to 43W4867 or 43W4772
43W4921	Fabricated Rear Cushion	Optional to 43W4868 or 43W4773
43W4815	Cardboard Filler	1
6165640 or 43W4918	Bag (Geo dependant, refer to BOM for detail)	1
33G9780 or 44E1942	Label (Geo dependant, refer to BOM for detail)	2
06P6550*	Padlock Label	1
74F5698 or 74F5699	IBM Logo Tape	as needed

\* Indicates part number not on WW common parts, but in appropriate Local BOM.

### Records and Controlled Documents

#### References

Document Management

Revision History

Approval Information

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