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Server Packaging Instructions: 5U x3400, [Subscribe](#)..[Unsubscribe](#)  
x3500 (7977, 7975, 7973) Molded Cushion

Packaging

No. [SG-P-01444](#) Rev. 7 Production Date:

04/20/2009

Owner: Jeffrey Miller

**Online Version is the Master**

**NOTE:** This document is designed to be used on-line. You are responsible to use only the "Production" version on-line.

\*\*\*\*\*

\* IMPORTANT NOTICE: The Federal Aviation Administration requires \*

\* certification that packages shipped by air do not contain

explosives, \*

\* hazardous materials, incendiaries or other destructive devices. \*

\* Therefore, just prior to sealing the carton, you must inspect its \*

\* contents to confirm that it contains only parts specified on the

IBM \*

\* bill of materials. If the contents meet specifications, then seal

the \*

\* carton with IBM logo tape or another tamper evident indicator \*

\* specified on the bill of materials. The logo tape or tamper evident

\*,

\* seal will indicate that the carton can be certified to meet FAA \*

\* standards for air shipment. If you discover parts or devices that \*

\* appear suspicious (whether or not potentially explosive), carefully

\*,

\* secure the carton on the line and notify IBM management promptly. \*

\*\*\*\*\*

- 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 package assembly without prior written approval from

the Responsible Packaging Engineer.

## **Table of Contents**

Section 1 - Applicable Systems, MTM Listing

Section 2 - Unit Packaging

Section 3 - Manufacturing Palletization

Section 4 - Distribution

Section 5 - Material Listing (BOM)

## **Section 1 - Applicable Systems, MTM Listing**

These packaging instructions apply to the following machine types:

7977, 7975, 7973 - (x3400, x3500)

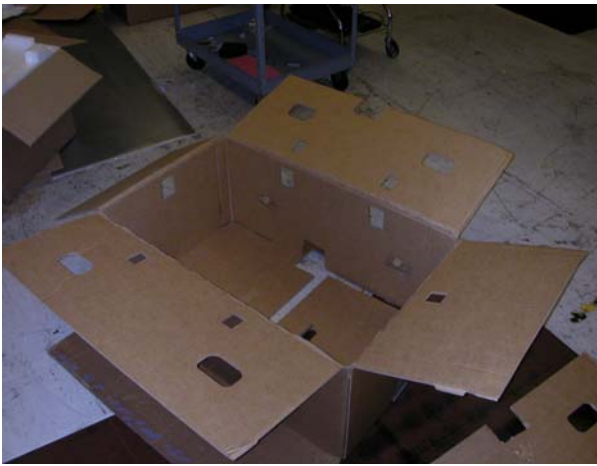
## **Section 2 - Unit Packaging**

2.1 Inspect system to make sure there are no scuffs or scratches on unit.



2.2 Make sure voltage setting is correct.

2.3 Assemble unit carton (39Y7777) by folding bottom flaps inward as pictured below (carton is shown upside down).

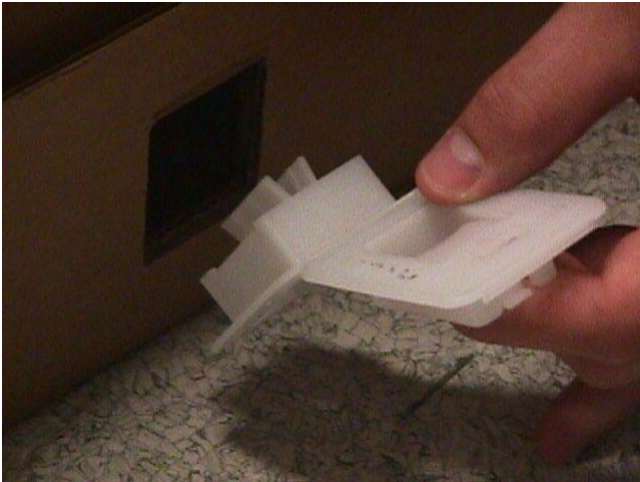


2.4 Place system tray (39Y7778) into unit carton as pictured below.





2.5 Place corrugated clip (6X) (37L0511) into square holes in bottom tray and snap shut. Insure that clips go through carton and tray securing carton and tray together.



2.6 Place tamper label (74F8851) over two clips on tray (1 label on and end and 1 label on a side).



2.7 Break apart molded cushion 39Y7769 and place in unit carton . Be sure to leave the space between the front cushion and the carton for the shipgroup (Front and rear cushions should have "FRONT" and



"REAR" molded into them).

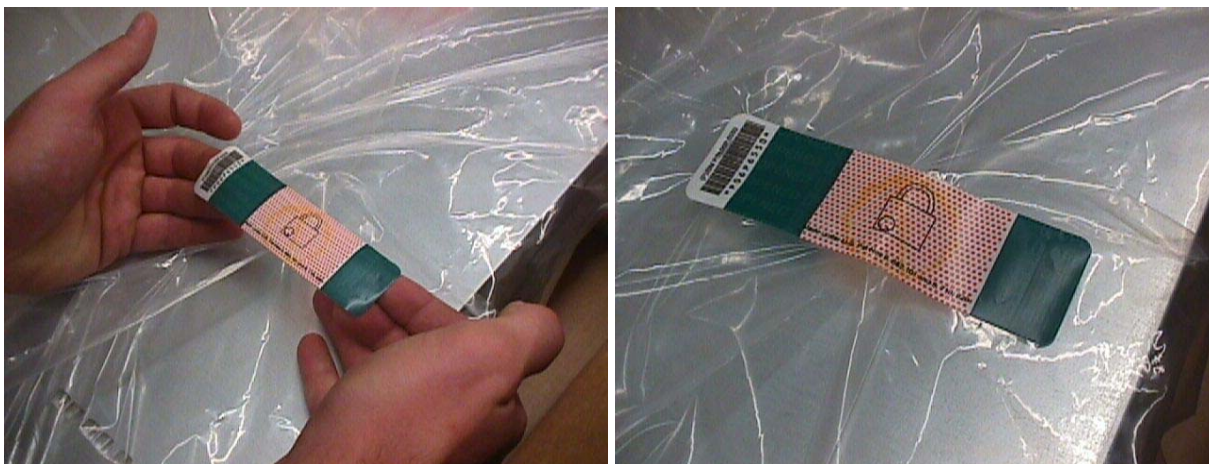
(For optional fabricated cushions use 39Y7478 Front and 39Y7479 rear)



2.8 Place system inside bag (6165640) and place system in bottom cushions. Make sure the system is positioned all the way down and not sitting on the cushion ledge.



2.9 Fold system bag over unit and seal edges of bag closed with Tamper label (06P6550).



2.10 Break apart top cushion set (39Y7768) and place on system as shown below.

(For optional fabricated cushions place top rear cushion (39Y7480) and top front cushion (39Y7481))

onto system).



2.11 Assemble ship group carton (39Y7482) and place ALL shipgroup materials inside (keyboard, mouse, pubs, options etc.). Do not place anything on the top or sides of the system.



2.12 Place ship group at the FRONT of the system as shown.



2.12 Close the top of the carton and seal using printed tape (74F5699 - Automatic taper, 74F5698 - for hand held dispensers).



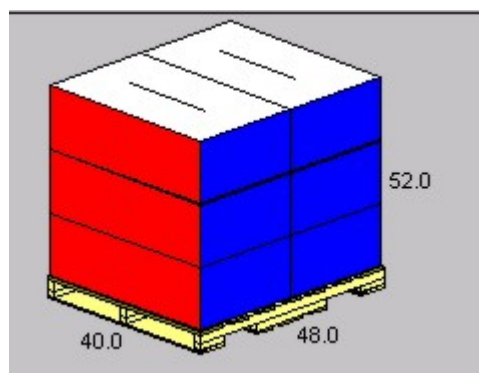
2.13 Check the parts list for additional carton label which are called out. If there is a Processor-related label ("Intel" or "AMD"), place the appropriate label on the top of the carton between the label location marks. If there is no processor-related label on the parts list, leave this area on the carton blank.

**Reference QMX document SG-P-01486 "Special Packaging Labeling Guidelines" which may contain additional labeling requirements.**

## Section 3 - Manufacturing Palletization

### Worldwide Sites

3.1.1 - Place up to 6 systems on a full size pallet (6038887) in even quantities.



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

3.1.3 - Place two pallet labels (33G6283) one on the front and one on the left side of the pallet load.

## Section 4 - Distribution

### Worldwide Sites

NOTE: All units will be received into Distribution as indicated above in Section 2, Manufacturing

Palletization, and are approved to be stacked 4 pallets high.

4.1.1 - Secure load to pallet (or half pallet) utilizing "Best of Breed" Palletization methods. See 92F6168 "Best of Breed" Pallet Unitization or QMX document P-04146.

Use pallet configuration table provided below to determine pallet and empty box usage.

Quantity	Half Pallet	Full Pallet	Ship Individual	Empty Box w/Label
1			X	
2	X			
3	X			
4		X		
5		X		X
6		X		

4.1.2 - Label load for shipment as necessary.

## Section 5 - Materials Listing (BOM)

PKG BOM - 39Y7594, COMMON PARTS BOM - 39Y7783

Part Number	Description	Qty / Unit
39Y7777	Unit Carton	1
39Y7778	Tray	1
39Y7482	Shipgroup	1
39Y7769	Top Cushion (Molded)	1
39Y7768	Bottom Cushion (Molded)	1
39Y7478	Bottom Front Cushion (Fabricated)	1 (optional)
39Y7479	Bottom Rear Cushion (Fabricated)	1 (optional)
39Y7480	Top Front Cushion (Fabricated)	1 (optional)
39Y7481	Top Rear Cushion (Fabricated)	1 (optional)
(Refer to Pkg BOM)	Carton Label	2
06P6550	Padlock Tamper Label	1
74F8851	Tamper Label	2

### ▶ Records and Controlled Documents

### ▶ General Information



- ▶ **Summary of Changes**
- ▶ **Approval Information**

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