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Server Packaging Instructions: **x336** (MT [Subscribe](#)..[Unsubscribe](#) 8837)

STG - Systems

No. **P-04223 Rev. 6** Production Date: .

**05/22/2006**

Owner: **Jeffrey Miller**

**Online Version is the Master**

NOTE: This document is designed to be used online. You are responsible to use only the “Production” version online.

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**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.

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- Information contained in this document is for reference purposes only.
- Packing process may vary slightly in each manufacturing location.
- No deviation is to be made to the overall assembly without prior written approval from the responsible Packaging Engineer.

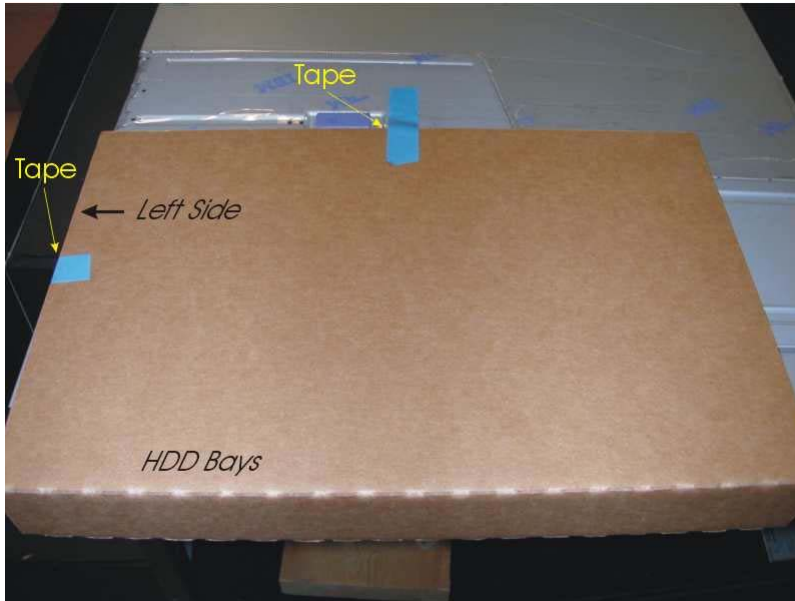
## Table of Contents

- Section 1 - Unit Packaging
- Section 2 - Manufacturing Palletization
- Section 3 - Distribution
- Section 4 - Material Listing (BOM)

## Section 1 - Unit Packaging

1.1 Check all HDD latches and blank drive fillers to ensure that they are closed and latched. **An unlatched HDD may result in damage when the unit is packaged and or shipped.**

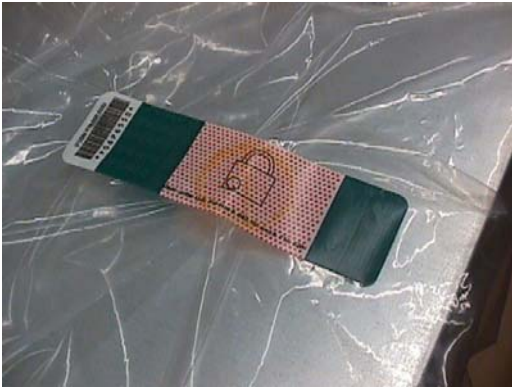
1.2 Place loadspreader 39Y7468 onto front of system on the left side (over the HDD Bays). Tape the loadspreader onto the system with appliance tape 01R3747 (04N8185 is also acceptable). Wrap piece of tape goes around the left side of the system and loadspreader, and place one piece of tape at the top of the loadspreader.



1.3 - Assemble carton 39Y7687 and tape the bottom flaps shut with IBM Logo Tape 74F5698 or 74F5699. **Note: Old version artwork on carton is depicted.**



1.4 - Place bag 32R0130 onto the unit. Seal bag with 06P6550 tamper seal as shown below.



1.5 Break apart cushion 32R0044 and place in bottom of carton as shown below. **DO NOT PLACE SHIPGROUP IN AT THIS TIME. WAIT UNTIL STEP 1.8.**



1.6 - Place the unit into cushions by placing unit into cushion with the front bezel going into cushions first.

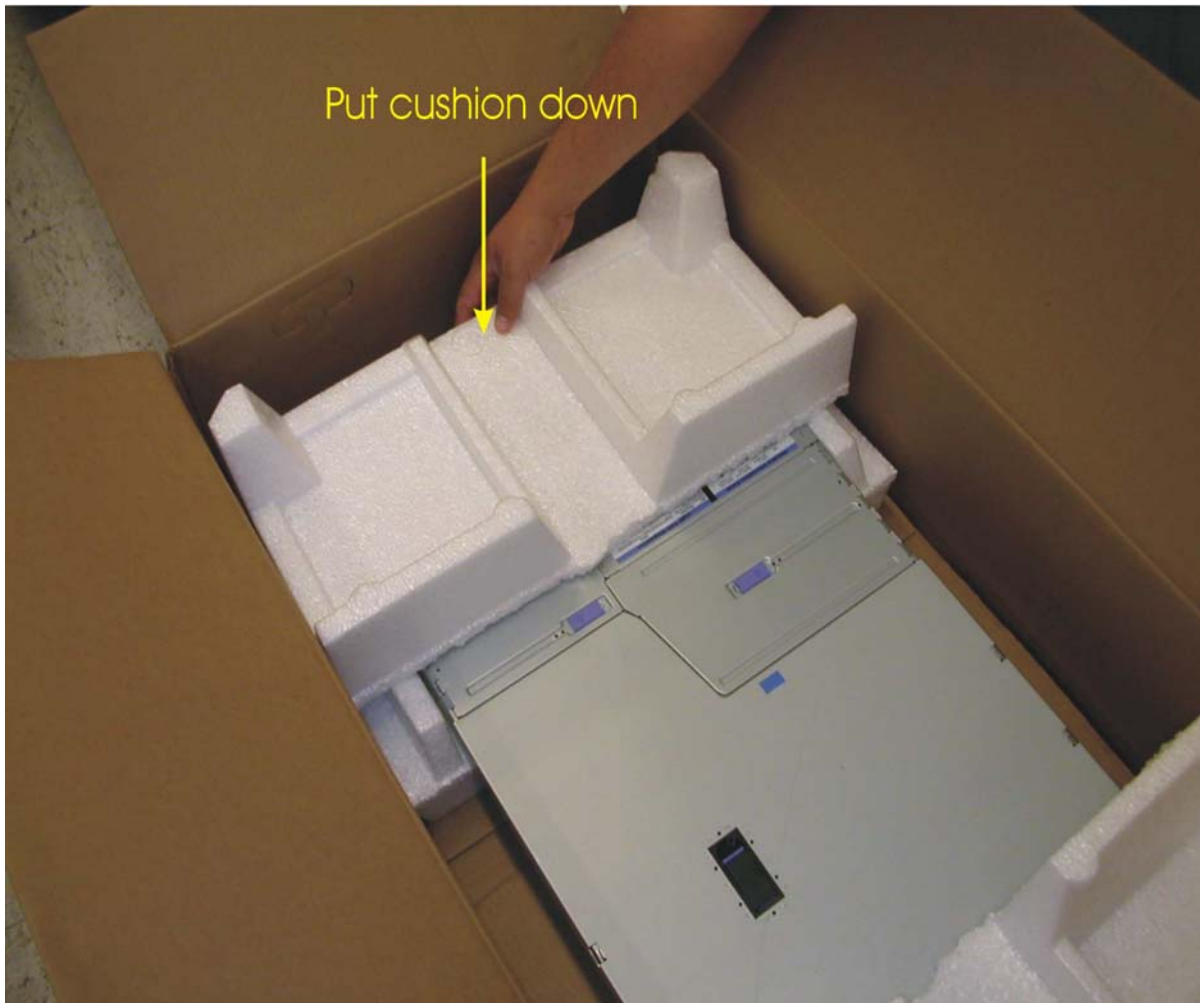
Note: Bag is not depicted in the illustration for better visibility of product orientation.



1.7 - Break apart cushion 32R0045. Place rear part of cushion onto the top rear of the unit as depicted below.



1.8 - Place front top half of cushion down in front of system, and then slide it back into position next to the HDDs. **Take great care not to force cushion downward as damage may occur.**





1.9 - Place shipgroup 39Y7467 into carton next to cushions. Place shipgroup items into shipgroup.

**Note: Front cushions are next to shipgroup divider.**

**NOTE: Do not place shipgroup components in the empty space between the system and carton.**





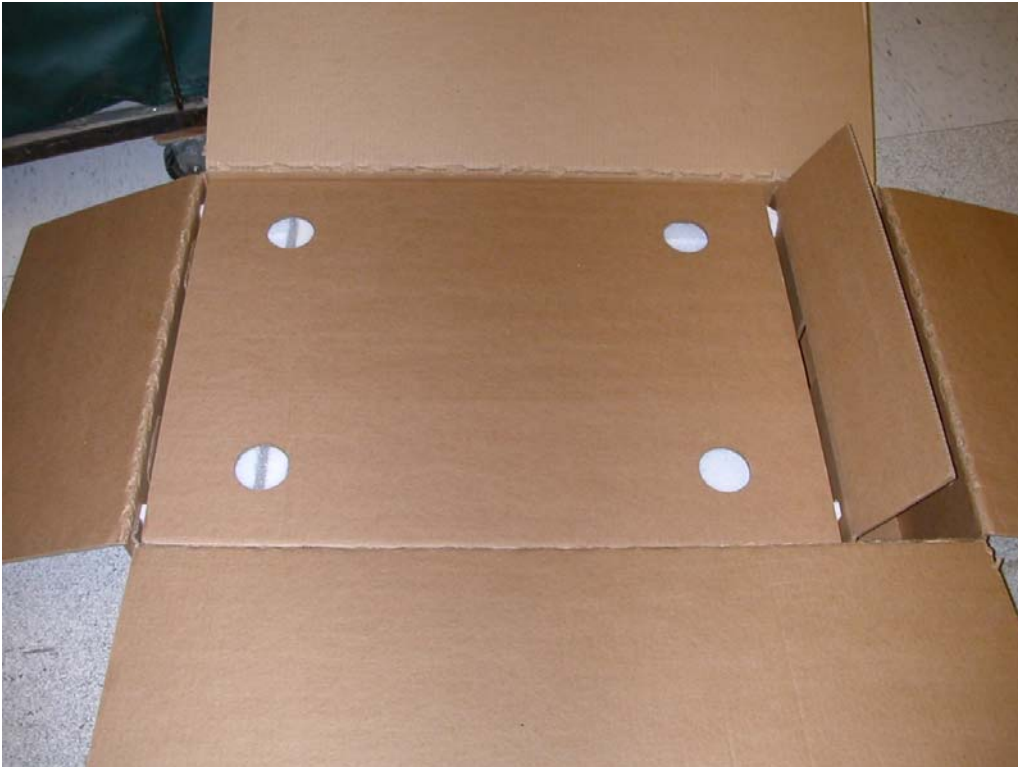
1.10 - Place rail kit on top of system as shown below.

**Note: Actual rail kit length may vary. Use hole in shipgroup for longer rail kits, if necessary.**



1.11 - Place system tray 32R0046 on top of system as shown below.

**Note: The system tray is located over the system, and not the shipgroup tray.**



1.12 - Close flaps and seal carton as shown using IBM logo tape 74F5698 or 74F5699.

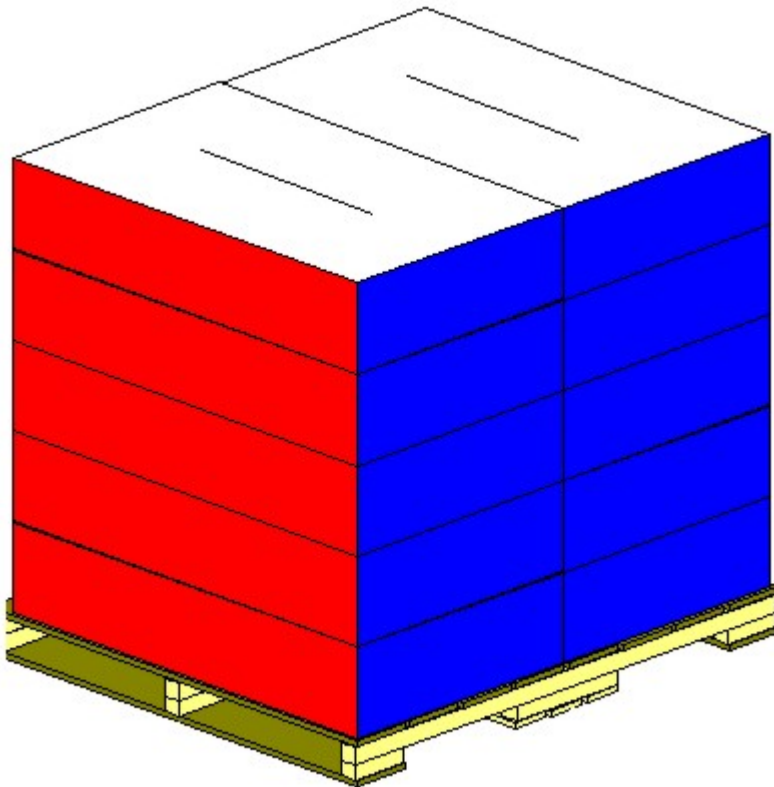


1.13 - Print and place carton labels on label tick marks located on carton.

## **Section 2 - Manufacturing Palletization**

### **2.1 - Worldwide Palletization**

2.1.1 - Place up to 10 systems on a full size pallet (6038887) in even quantities.

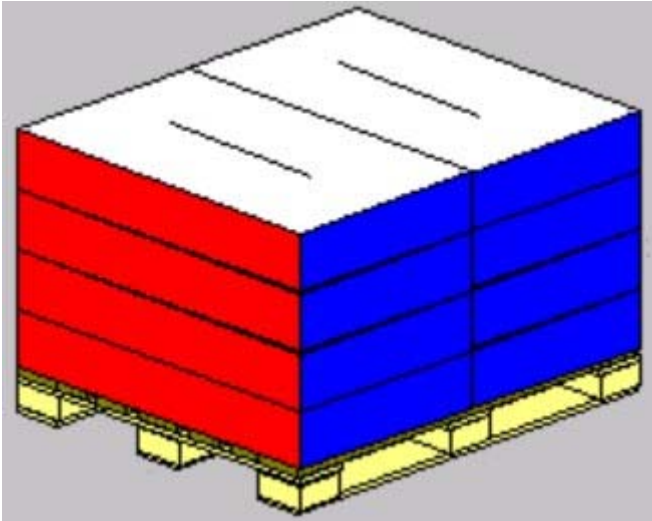


2.1.2 - Secure load to pallet utilizing materials listed on BOM.

2.1.3 - Place two pallet labels (33G6283) on the front and left sides of the pallet load.

## 2.2 - EMEA Palletization

2.2.1 - Place up to 8 systems on a full size pallet (6038887) in even quantities.



2.2.2 - Secure load to pallet utilizing materials listed on BOM.

2.2.3 - Place two pallet labels (33G6283) on the front and left sides of the pallet load.

## Section 3 - Distribution

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

### Worldwide

Quantity	Half Pallet	Full Pallet	Ship Individual (no pallet)	Empty Box w/ Label
1 - 2			X	
3 - 5	X			
6		X		
7		X		1
8		X		
9		X		1
10		X		

### EMEA

Quantity	Half Pallet	Full Pallet	Ship Individual	Empty Box w/ Label

1 - 2			X	
3 - 5	X			
6		X		
7		X		1
8		X		

3.2 - Label load for shipment as necessary.

## Section 4 - Materials Listing (BOM)

### WW Pkg BOM 01R3965

#### WW Common Parts 25P1326

Part Number	Description	QTY
39Y7687	Outer Carton	1
39Y7467	Shipgroup Tray	1
39Y7468	Loadspreader	1
01R3747 or 04N8185	Appliance Tape	as needed
32R0044	Bottom EPP Cushion	1
32R0045	Top EPP Cushion	1
32R0046	System Tray	1
06P6550	Padlock Tamper Seal	1
74F5698 or 74F5699	IBM Logo Tape	as needed

END DOCUMENT

- ▶ General Information
- ▶ Summary of Changes
- ▼ Approval Information

Date Approved	Approved By
05/22/2006	See Library Control database for approval information.

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