

Document Number	P-04439
Revision Number	1
Category	WW-P&PSG-Packaging
Document Type	Procedure
Date In Production	五月-29-2006
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Document Owner	Jeffrey Miller/Raleigh/IBM
Location	RTP
Department	GQBA
Last Updated	五月-29-2006
Last Modified By	Vincent CJ Chang/Taiwan/IBM

Procedure Description

Procedure Text

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

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 assembly without prior written approval from the responsible Packaging Engineer.

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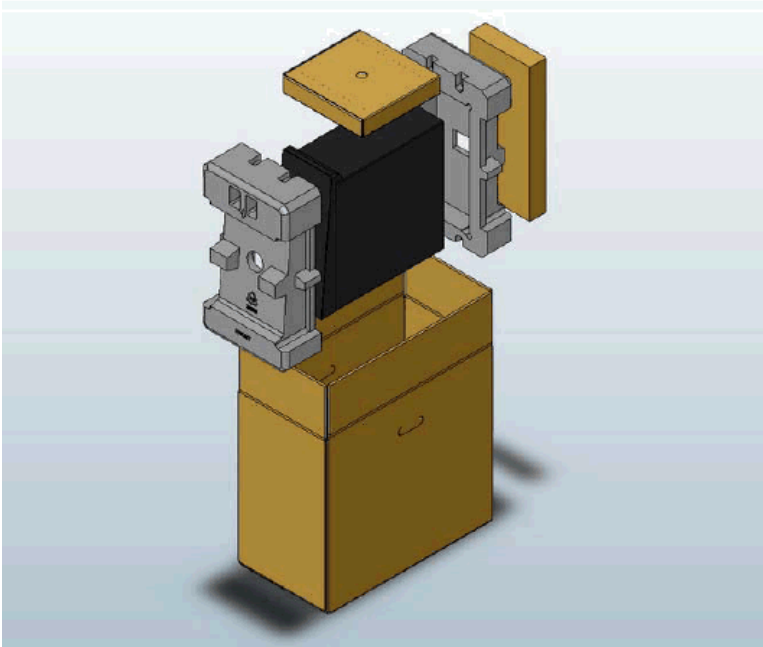
Section 1 - Applicable Systems, MTM Listing

These packaging instructions apply to the following machine types :

PWS
6218, 9229, 9230

Section 2 - Unit Packaging

Reference Picture



Please note that some part numbers will reference a USI part number as well as an IBM part number . Use of either part number is acceptable, however, IBM will only be able to release IBM part numbers on BOMs .

2.1 - If not already done, erect the shipping carton 25R7528 and seal bottom flaps.

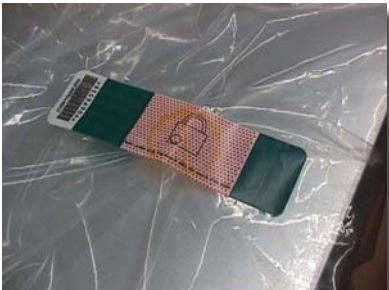
2.2 - Call machine to the packaging station. Verify the feet of unit are secure, verify unit is cosmetically clean and cover is correctly installed . Rotate machine and inspect all sides.

2.3 - Place bag 00K7781, or 8119429, or 9000315 over the unit. (see illustration below).

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

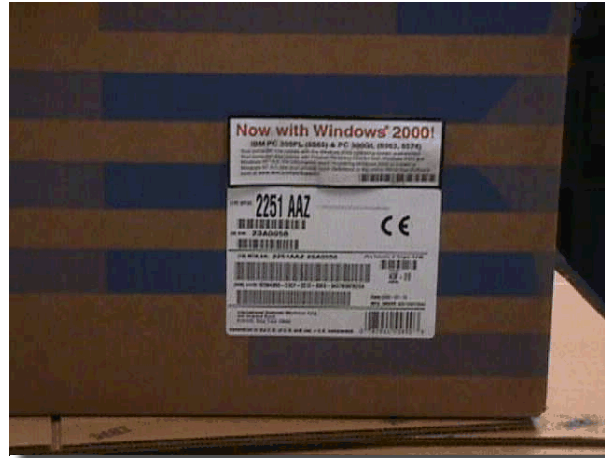


2.4 - Fold bag over, and seal bag closed with 06P6550 padlock label. (illustrated below).



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.



2.6 - Place Front cushion 39M6393 (optional: fabricated cushion - 25R7525) on front of system.

2.7 - Place Rear cushion 39M6394 (optional: fabricated cushion - 25R7526) on rear of system.

Note: Fabricated cushions should only be used in the event that molded cushions are unavailable . If fabricated cushions need to be used, notify IBM Packaging Engineering immediately .

2.8 - Place cushioned system into bottom of carton with the top of the system facing upwards .



2.9 - Place keyboard carton between the end of the carton and the rear of the system unit . If no keyboard is called out, use empty carton 25P1068.

Note: A keyboard or filler must be used and placed next to the rear of the system . If keyboard is placed in a different location, or if a filler box is not used, the system will be damaged during shipment .



2.10 - Add accessories to shipgroup carton 25R7527.



2.11 - Place shipgroup tray on top of unit as depicted below.

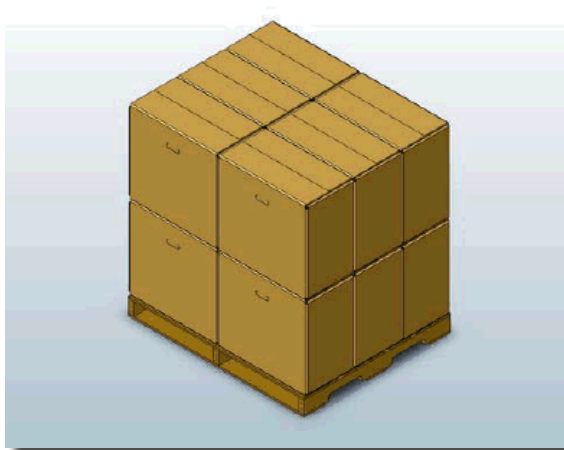


2.12 - Close and seal carton with IBM logo tape 74F5698 or 74F5699.

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			1
4		x		2
5		x		1
6		x		
7 - 8		x	1 - 2	
9	x	x		
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 - 25R7524

Part Number	Description	Qty
25R7528	Outer Carton	1
39M6393 (USI P/N: 59-315533-00)	Molded Front Cushion	1
39M6394 (USI P/N: 59-315534-00)	Molded Rear Cushion	1
25R7527	Shipgroup Carton	1
00K7781 8119429 9000315	Bag (Geo dependant, refer to BOM for detail)	1
33G9780	Label	2
06P6550*	Padlock Label	1
74F5698 or 74F5699	IBM Logo Tape	as needed
25R7525	Fabricated Front Cushion	as needed (1)
25R7526	Fabricated Rear Cushion	as needed (1)

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

References

Document Type	Document Number	Document Name

Document Management

Effective Date	五月-29-2006	Review Interval (Maximum Review Interval = 12 months)	12 months
Next Review Date	五月-29-2007	Retention Period	24 months

Revision History

This Version	Created by	Date	Short Description
1	Vincent CJ Chang/Taiwan/IBM	五月-29-2006	Removed code name
Previous Versions			
0	Vincent CJ Chang/Taiwan/IBM	八月-12-2005	Initial Version

Long Description

Edits to this Revision

05/29/2006 2:56:22 PM - Vincent CJ Chang/Taiwan/IBM
05/29/2006 2:43:41 PM - Vincent CJ Chang/Taiwan/IBM

Approval Information

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Access restricted to

History Log

Date Created	五月-29-2006	Vincent CJ Chang/Taiwan/IBM
Date Draft Complete		
Date Review Complete	五月-29-2006	Vincent CJ Chang/Taiwan/IBM
Date Approved	五月-29-2006	Automatic System
Date Distributed	五月-29-2006	
Date Obsolete Requested		
Date Obsolete		
Date Withdrawn		

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