IBM
STG - Systems

Document Number	P-04437
Revision Number	3
Category	WW-P&PSG-Packaging
Document Type	Procedure
Date In Production	五月-29-2006
Author(s)	Vincent CJ Chang/Taiwan/IBM
Document Owner	Jeffrey Miller/Raleigh/IBM
Location	Taipei
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.

# Table of Contents

Section 1 - Applicable Systems, MTM Listing

These packaging instructions apply to the following machine types:

Server
8485, 4362, 4362

Section 2 - Unit Packaging

Reference Picture

without keyboard box
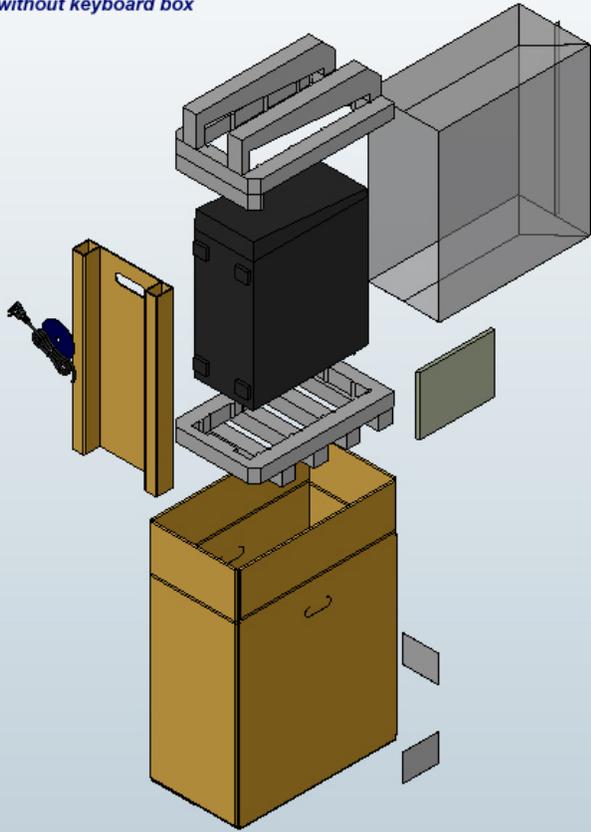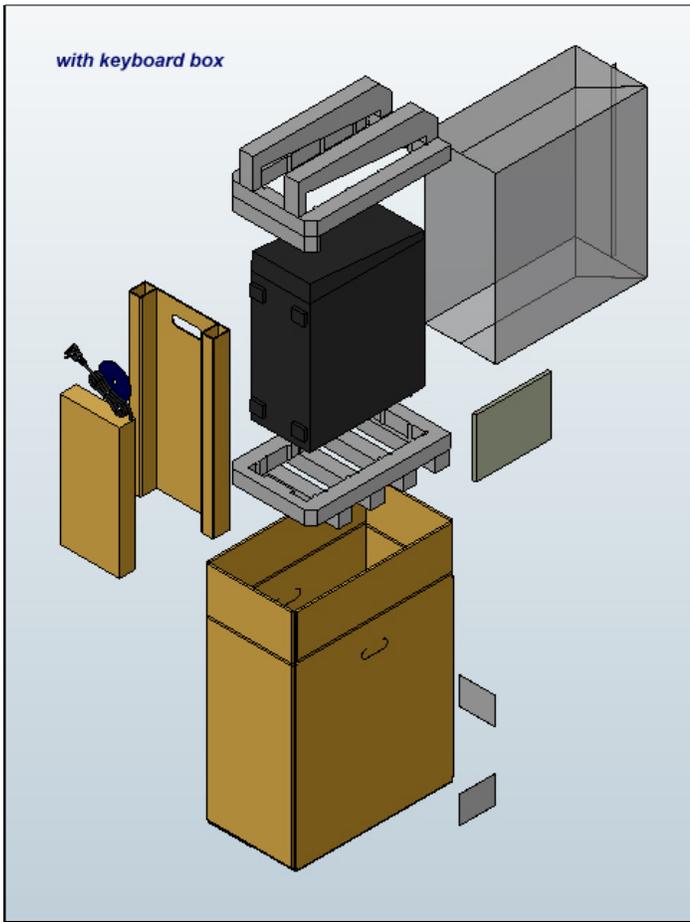
with keyboard box

2.1 - Assemble carton 40K9253 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).
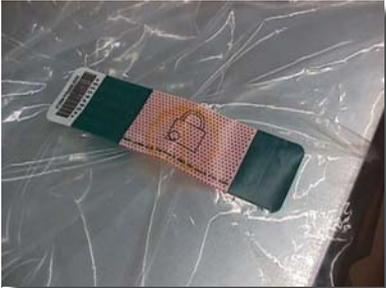
2.5 - Remove labels from the printer and apply one carton label to the long side (length) panel using the tick mark provided. Align the bottom of the carton label with the bottom edge of the tick mark. With the carton on its side and while facing the length panel with label (just applied), apply second 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.

2.6 - Insert rear of system into rear cushion 40K9257 as shown (plastic bag was removed here). The protrusions of cushion should create tight fits with chassis.

2.7 - Lift the cushioned system as shown and place it into bottom of carton.

2.7 - Inspect if the clearance is now on the bottom side of chassis.

2.8 - Place paper documents into the space on one side of carton.

2.9 - Place front cushion 40K9256 on the front side of chassis.

2.10 - Fold cardboard filler 40K9255 and insert it into the space at the bottom of chassis. Note the hand hold is on top.

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

2.12 - Place powercord, mouse, CD etc into compartment of filler.

2.13 - 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			
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 - 39M4449

Part Number	Description	Qty
40K9253	Outer Carton	1
40K9256	Fabricated Front Cushion	1
40K9257	Fabricated Rear Cushion	1
40K9255	Cardboard Filler	1
6165640	Bag (Geo dependant, refer to BOM for detail)	1
33G9780	Label	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.

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
3	Vincent CJ Chang/Taiwan/IBM	五月-29-2006	Removed code name
Previous Versions			
2	Vincent CJ Chang/Taiwan/IBM	五月-26-2006	Corrected typo in Section 2.6.
1	Vincent CJ Chang/Taiwan/IBM	十二月-28-2005	Revised packages for 12 boxes (units) per pallet.
0	Vincent CJ Chang/Taiwan/IBM	八月-03-2005	Initial Version

Long Description

Edits to this Revision

05/29/2006 1:47:35 PM - Vincent CJ Chang/Taiwan/IBM

Approval Information

Reviewers	Vincent CJ Chang/Taiwan/IBM
Approvers	Vincent CJ Chang/Taiwan/IBM
Select if Approvers will be required to re-enter their password prior to approving or rejecting the document.	N
Users	

Editors

People who can change	Jeffrey Miller/Raleigh/IBM Vincent CJ Chang/Taiwan/IBM Paul Cance/Raleigh/IBM
make changes	[QMXADMIN] Mona M Aakre/Rochester/IBM Diane Mitchell/Rochester/IBM Cheryl Wangsness/Rochester/IBM Dale R Mosher/Poughkeepsie/IBM Diane Gonsalves/San Jose/IBM Dale Stuemke/Austin/Contr/IBM Victoria Cyr/Poughkeepsie/IBM Margaret Brinkel/Morrisville/IBM Daniel G Demer/Tucson/IBM Carmen Clark/West Palm Beach/IBM
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		

WW SG Document Library Control / D01DB034 / q_dir\qmx\serv\qrodlc.nsf

End of Document