



STG - Systems

Server Packaging Instructions : x345 2U (MT 8670)

No. WW-P-01037 Rev. 7

Status: In Production

Document Number	WW-P-01037
Revision Number	7
Category	ISC-Global Engineering
Document Type	Procedure
Date In Production	May-24-2006
Author(s)	Ivan Liverman/Raleigh/IBM, Jeffrey Miller/Raleigh/IBM
Document Owner	Jeffrey Miller/Raleigh/IBM
Location	Worldwide
Department	GQBA
Last Updated	May-24-2006
Last Modified By	Ivan Liverman/Raleigh/IBM

Procedure Description

Procedure Text

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 assembly without prior written approval from the responsible Packaging Engineer.

Table of Contents

- [Section 1](#) - APPLICABLE SYSTEMS, MTM Table
- [Section 2](#) - IBM UNIT PACKAGING
- [Section 3](#) - MANUFACTURING PALLETIZATION - For IBM and OEM Systems
- [Section 4](#) - **DISTRIBUTION** - For IBM and OEM Systems

Section 1 - Applicable Systems, MTM Listing

Server

8670 - x345 (2U Server) - ALL MODELS

Note: There are separate packaging procedures for OEM systems .

Section 2 - IBM UNIT PACKAGING

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

2.2 - Make sure voltage setting is correct.

2.3 - Set up carton (25P1045) and H-Tape the bottom with IBM Logo Tape (74F5698).
Making sure

that the hand holes on the end of the carton are on the top as shown in the picture below. The second picture highlights in red where tape is to be applied to the carton for H-Taping.





Make sure that the tape extends 3/4s of the way up the side. See picture below.



2.4 - Break apart the bottom cushion set (01R3721) and place the cushions in the carton as shown below. The bottom rear cushion has to be place so it is against the corrugate container.



2.5 - Place the plastic bag (6165640) over the cushion so the machine can be placed in both the bag and cushion.



2.6 - Place the machine inside the bag on the cushions. The second picture does not have a bag on the machine to help clearly show how the machine is to be placed inside the cushions.





2.7 - Insert the Rail Kit Carton (01R3711) on the left side of the unit in between the cushions and corrugate carton. As shown in the picture.



Note: This picture shows how the pack should look at this point.



Note: This is how the corrugate Shipgroup Tube (01R3709) folds up to fit in front of the unit. Make sure that the edge with the cut-out tabs is place up in the pack.



2.8 - Place the Shipgroup Tube (01R3709) in front of the machine with the cut out tabs facing up.

Refer to the picture below for visual add.



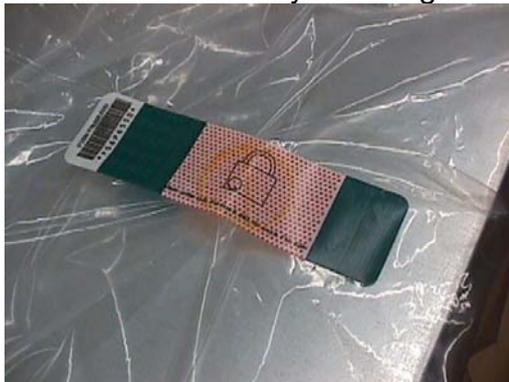
2.9 - Place the Cable Management Arm box (01R3710) in the Shipgroup Tube, as shown below.



Make sure that the Cable Management box is pushed all the way to the bottom.



2.10 - Close and seal the system bag with the tamper evident seal (06P6550).



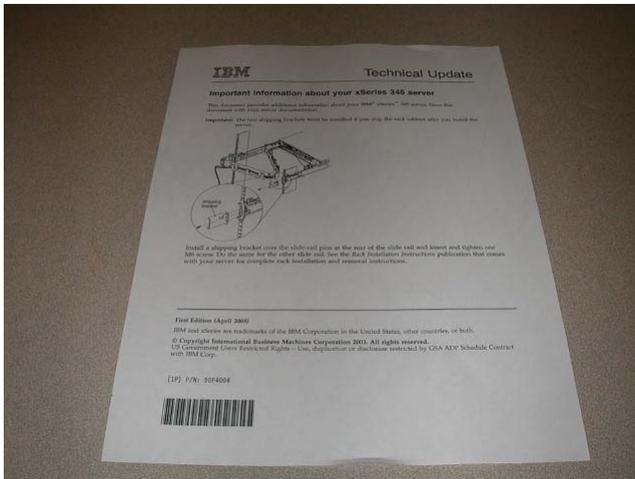
2.11 - Break apart the top cushion set (01R7322) and place them on top of the machine.



2.12 - Bend over the tabs on the Shipgroup Tube which are by the hand holes the carton. The following two pictures clearly show how the two tabs have to bent over.



*****This flyer if required is to be placed inside of the Pud Pack Bag on top.*****



2.13 - The Pub Pack is to be placed on and taped to the top of the chassis. Use (74F5698) IBM

Logo Tape to secure the Pub Pack to the system PolyBag. As you can see, there is plenty of space in between the cushions for the pub pack.



2.14 - The Power Cords are to be placed on top of the Cable Management box in the Shipgroup Tube.



*** If required, insert slide kit brackets into Country Kit (Shipgroup) Accessory Bag.***

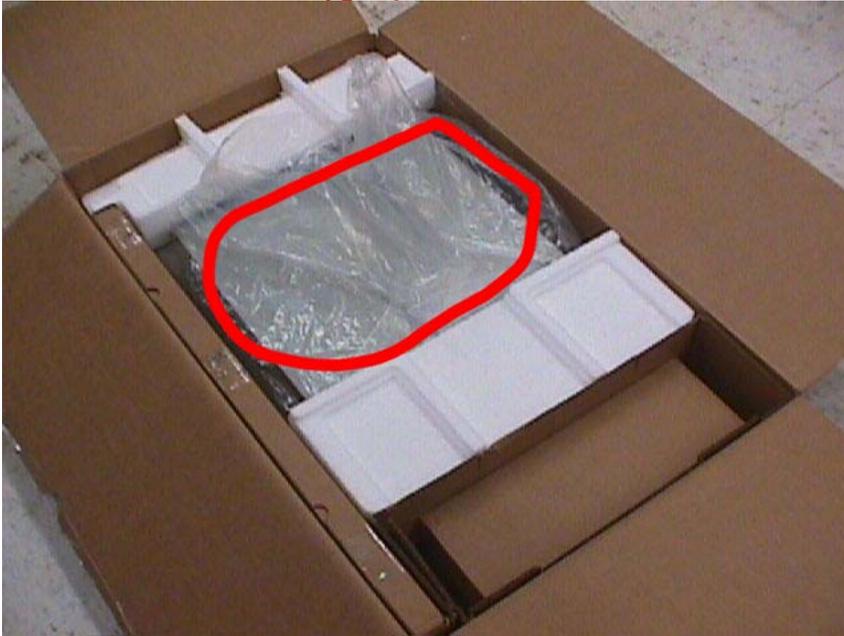


2.15 - The Country Kit (Shipgroup) Accessory Bag is to be placed on top of the Cable Management box in the Shipgroup Tube.





NOTE: Do NOT place extra shipgroup items in voids around the system . Materials placed in these areas will result in damage to the system . IBM WW Packaging Engineering must be contacted if contents do not fit in the shipgroup area .



2.16 - Fold carton flaps down and H-Tape the carton shut using 3" IBM Logo Tape (**74F5698**).

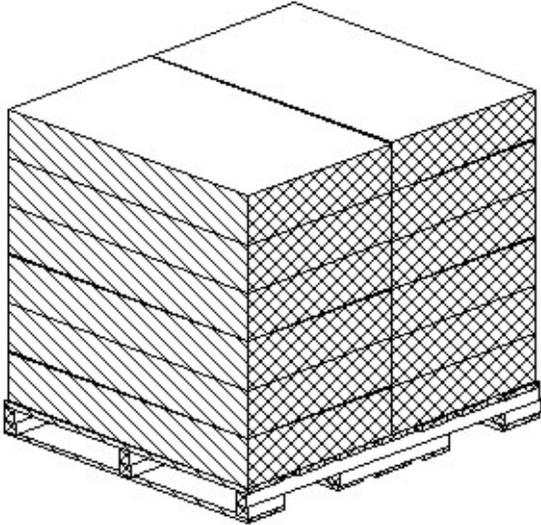
2.17 - Take the two (2) printed carton labels (33G9780) off the printer. Position them on front and left sides of the carton. Use label locating marks for label location placement.

2.18 - Place Intel label (if called out in DFC) on the top of the carton between label location marks.

Section 3 - Manufacturing Palletization

Worldwide Sites

3.1.1 - Place up to 12 systems on a full size pallet P/N 6038887 or P/N 7310275 in even quantities.

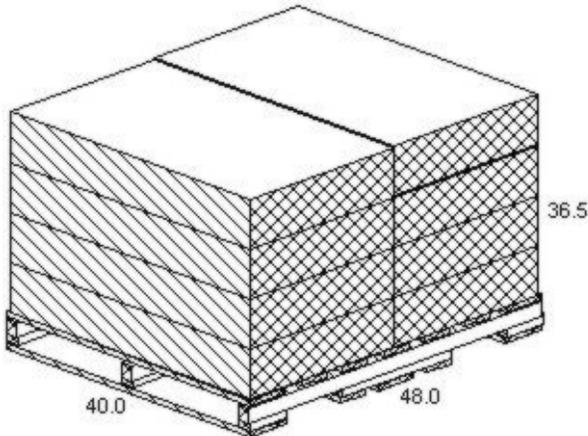


3.1.2 - Secure load to pallet utilizing "Best of Breed" palletization methods. See 92F6168 - "Best of Breed" Pallet Unitization.

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

EMEA Site

3.2.1 - Place up to 8 systems on a full size pallet P/N 6038887 or P/N 7310275 in even quantities.



3.2.2 - Secure load to pallet utilizing "Best of Breed" palletization methods. See 92F6168 - "Best of Breed" Pallet Unitization.

3.2.3 - Place two pallet labels (33G6283) on the front and left sides 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 - Secure load to pallet (or half pallet) utilizing "Best of Breed" palletization methods. See 92F6168 - "Best of Breed" Pallet Unitization. Use pallet configuration table provided below to determine pallet and empty box usage.

Quantity	Half Pallet	Full Pallet	Empty Box w/ label
1-5	X		
6		X	
7		X	1
8		X	
9		X	1
10		X	
11		X	1
12		X	

4.2 - Label load for shipment as necessary.

EMEA Site

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.

4.2.1 - Secure load to pallet (or half pallet) utilizing "Best of Breed" palletization methods. See 92F6168 - "Best of Breed" Pallet Unitization. Use pallet configuration table provided below to determine pallet and empty box usage.

Quantity	Half Pallet	Full Pallet	Empty Box w/ label
1-5	X		
6		X	
7		X	1
8		X	

4.2.2 - Label load for shipment as necessary.

Section 5 - Materials Listing (BOM)

Quantity	P/N	Description
	25P1045	Corrugate Carton - RSC Style

01R3721	Bottom Cushion Set	
01R3722	Top Cushion Set	
01R3709	Corrugate Shipgroup Tube	
01R3710	Cable Management Kit	
01R3711	Rail Kit	
74F5698	3" IBM Logo Tape	A
6165640	System/Machine PolyBag	
06P6550	QC Seal	

[References](#)
[Document Management](#)
[Revision History](#)
[Approval Information](#)
[Editors](#)
[History Log](#)

[© 2006 IBM Corporation, All Rights Reserved Worldwide](#)
[WW SG Document Library Control / D01DB034 / q_dir\qmx\serv\qrodic.nsf](#)

End of Document
