

Engineering Department

Engineering Change Order (ECO)

ECO #: ECO-52007-001

Effective Date: May 20, 2016

Title: P-Series Skid Manipulator Mount and Hardware Change

Author: KB
Engineering Approval: aeg
Operations Approval: JJV

Date: May 20, 2016
Date: May 22, 2016
Date: May 23, 2016

Summary:

A new float and mounting configuration has been designed to allow the rotating manipulator to be attached to the P-Series BlueView skid. The assembly instructions for the rotating manipulator have been updated to include this new configuration, and new drawings have been created to show the float design and mounting point locations on the P-series skid.

The hardware used to attach the manipulator to the skids in all configurations has been changed from slotted fillister head screws to socket head cap screws to make assembly easier. The BOMs for the manipulator configurations have been updated accordingly.

Parts Affected:

Part Number	Notes	Removed	Added	Modified
52007	Rotating Manipulator to P-Series Sonar Assembly	☐	☒	☐
50074	Rotating Manipulator to Pro 4 Assembly	☐	☐	☒
50222	Rotating Manipulator to V-Series Sonar Assembly	☐	☐	☒
91794A199	18-8 Stainless Steel Fillister Head Slotted Machine Screw 8-32 Thread 1" Length	☒	☐	☐
91794A204	18-8 Stainless Steel Fillister Head Slotted Machine Screw 8-32 Thread 1.75" Length	☒	☐	☐
91794A207	18-8 Stainless Steel Fillister Head Slotted Machine Screw 8-32 Thread 2.5" Length	☒	☐	☐
52003	Socket Head Cap Screw 8-32 Thread 1" Long 18-8 SS	☐	☒	☐
52002	Socket Head Cap Screw 8-32 Thread 1.75" Length 18-8 SS	☐	☒	☐
52004	Socket Head Cap Screw 8-32 Thread 2.5" Length 18-8 SS	☐	☒	☐

Detail:

A new float and mounting configuration has been designed to allow the rotating manipulator to be attached to the P-Series BlueView skid. The assembly instructions for the rotating manipulator have been updated to include this new configuration, and new drawings have been created to show the float design and mounting point locations on the P-series skid.

The hardware used to attach the manipulator to the skids in all configurations has been changed from slotted fillister head screws to socket head cap screws to make assembly easier. The BOMs for the manipulator configurations have been updated accordingly.

Action Item:

Action	Department	Acknowledgement Initials
Update assembly instructions to include P-Series mounting configuration	Engineering	KB
Update SolidWorks assemblies and BOMs	Engineering	KB
Add new part numbers 52002, 52003, 52004, 52006, 52007, and 52016 to Epicor	Engineering	SL
Update BOMs for 50074 and 50222 in Epicor for hardware change	Engineering	SL
Populate BOM in Epicor for new part number 52007	Engineering	SL

Modified / Referenced Documents:

Document	Current Revision
50074 – Rotating Manipulator Assembly Instructions	002
52006 – Rotating Manipulator Float for P-Series Blueview	A
52016 – P-Series Modified Skid for Rotating Manipulator Drawing	A
50074 – Rotating Manipulator to Pro 4 Assembly Drawing	B
50222 - Rotating Manipulator to V-Series Assembly Drawing	B
52007 – Rotating Manipulator to P-Series Blueview Assembly Drawing	A

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