

	Doc or ECO #:	ECO-50074-005	Date:	11/30/18	Author:	SL
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	AEG	Date:	11/30/18	Quality Approval:	DO

P/N #:	50074	Effective Date:	November 30, 2018
Title:	Standard Rotating Manipulator Screw Change		

1.0 Purpose / Summary:

- The mounting holes for on Rotating Manipulator 2.0 changed for the rear ballast and need a change in length to account for that.

2.0 Parts Affected:

Part Number	Notes	Removed	Added	New	Modified
50074	Rotating Manipulator Kit Standard	☐	☐	☐	☒
52370	Button Head Hex Drive M3 x 25mm 18-8 SS	☒	☐	☐	☐
71668	Screw M3 x 10mm Hex Button Head 18-8	☐	☒	☐	☐

3.0 Detail:

- The rear ballast mounting holes for rotating manipulator 1.0 are through-hole allowing for larger length screws (25mm) to fit correctly.
- The rear ballast mounting holes for rotating manipulator 2.0 are depth specific which keeps the current 25mm length screw from being inserted fully.
- To resolve this issue the M3 x 25mm screws are being replaced by M3 x 10mm Screws.
- The new screws will be backwards compatible.

4.0 Disposition of Material:

- Properly dispose of all (52370) M3 x 25mm 18-8 SS Screws.

5.0 Action Items:

Action	Department	Acknowledgement Initials
Update BOM	PE	SL
Update Epicor	Engineering	RN
Begin ordering 71668	Purchasing	NS
- Begin using 71668 - Properly dispose of 52370	Production	KK

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6.0 Modified / Referenced Documents:

Document	Current Revision
Click here to enter text.	Click here to enter text.

7.0 Revision History

Date Revised (mm-dd-yyyy)	Location of Change (section, paragraph no., step no., etc.)	Description of Change Made	Name of Person making the Change
11-30-2018	Initial Release	Initial Release	SL