

	Doc or ECO #:	ECO-70017-001	Date:	3/22/21	Author:	JKN
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	03/31/21	Quality Approval	aeg

P/N #:	70017	Effective Date:	March 22, 2021
Title:	LED Lens Array Clearance Modification		

1.0 Purpose / Summary

The LED Lens Array was interfering with the base of the LED emitters on LED Emitter Board and with Flat Washers. This was contributing to the failure of LEDs in production. Clearance was added to these points of interference to alleviate the issue and reduce scrap rate.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
70017	Add CBore R.085 Slots, Increase Depth .1 Diameter CBore	☐	☐	☒	B

3.0 Detail

LED Lens Array – 60 Deg. Winston Cone [70017] was interfering with the base of the LED emitters on LED Emitter Board [70019] and with Flat Washer M2 Polycarbonate [71413]. This caused the LED Lens Array to sit up off the LED Emitter Board allowing for the possibility for trapping air bubbles and excess resin under the LED Lens Array. This is a likely contributor to stress cracks and bubbling of the resin during and after the curing. Increasing the depth of the counter bore under each reflector and adding a counter bore to the slots surrounding the Flat washers allows the LED Lens Array to contact the LED Emitter Board. This will help improve the production process and should reduce scrap.

4.0 Disposition of Material

70017 All rev A LED Lens Arrays should be removed from inventory and transferred to engineering for rework. Reworked parts will be returned to stock.

All LED Dual Emitter Array Assemblies [70023] already built up can be used and sold.

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5.0 Action Items

Action	Department	Acknowledgement Initials
Update revision in Epicor	Engineering	JKN
Remove legacy part(s) from inventory/production floor	Engineering	SL
Rework parts	Engineering	JKN
Return to stock	Inventory	SL

6.0 Modified / Referenced Documents:

Document	Current Revision
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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
3/23/21	-	Initial Draft	JKN