

	Doc or ECO #:	ECO-70018-001	Date:	5/17/19	Author:	JK
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	5/20/19	Quality Approval	DO

P/N #:	70018	Effective Date:	May 17, 2019
Title:	LED Dual Emitter Housing Laser Etch		

1.0 Purpose / Summary

Etching is required to achieve the required adhesion between the potting compound and the Micralox anodizing. This ECO details the switch from Sodium Hydroxide chemical etching to laser etching.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
70018	Reformat Anodized Sheet, add Laser Etch Annotations	☐	☐	☒	B

3.0 Detail

Micralox anodizing develops finer cells during the anodizing process, this results in significantly higher corrosion resistance but also makes the surface difficult to bond to. To achieve the necessary bond strength the anodizing was being etch through using Sodium Hydroxide, this process was very difficult to carry out consistently causing a high scrap rate. Laser etching has proven equally effective in test samples to remove the Micralox and leave behind a suitable bonding substrate for the potting compound. The Laser etching process can be performed consistently and turn key through Precision Coating.

4.0 Disposition of Material

70018 All rev B housings should be removed from inventory and transferred to engineering. Housings already built up in assemblies can be used and sold.

5.0 Action Items

Action	Department	Acknowledgement Initials
Update revision in Epicor	Engineering	RN
Remove legacy part(s) from inventory	Inventory Control	SL

	Doc or ECO #:	ECO-70018-001	Date:	5/17/19	Author:	JK
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	5/20/19	Quality Approval	DO

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
5/17/2019	-	Initial Draft	JK