

	Doc or ECO #:	ECO-70023-003	Date:	06/19/19	Author:	SL
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	7/17/19	Quality Approval	DO

P/N #:	70023	Effective Date:	June 19, 2019
Title:	MSS LED Array Screw Length Increase		

1.0 Purpose / Summary

The LED Array screws typically run short, and when used in conjunction with their corresponding washer, the screws do not have enough length to contact the LED Housing.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
70023	High level assembly	☐	☐	☒	C
70265	Screw Length too short	☒	☐	☐	A
70554	Unprogrammed Computer	☐	☒	☐	A

3.0 Detail

- Removed QTY:8 **70265 - Type 18-8 Stainless Steel Socket Head Cap Screw M2 Thread, 3mm Length, 0.4mm Pitch**
- Added QTY:8 **70554 - M2 x 4mm Socket Head Cap Screw, S/S, 0.4mm Pitch**
- Bill Of Materials have been updated to reflect the changes
- Work Instructions have been updated to reflect the changes
- General Assembly has been updated to reflect changes
- Potting volume was corrected on 70023 general assembly (351ml to 35ml)

4.0 Disposition of Material

- Remove 70265 from LED assembly kits, and return to bulk storage

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5.0 Action Items

Action	Department	Acknowledgement Initials
Update Epicor to latest BOM	Engineering	RN
Update BOM & Work Instructions	Engineering	SL
Update General Assembly Drawing	Engineering	JK
Remove 70265 from LED Assembly Kits	Production	KK

6.0 Modified / Referenced Documents:

Document	Current Revision
WI-70023	B
BOM-70023	
70023.pdf (general assembly)	C

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
06-19-2019	Initial Release	Initial Release	SL