

	Doc or ECO #:	70044-001	Date:	12/18/2017	Author:	JK
	Rev. #:	003				
Engineering Change Order (ECO) Camera Assembly Update	Engineering Approval:	aeg	Date:	12/18/2017	Quality Approval	DO

P/N #:	70044	Effective Date:	December 18, 2017
Title:	Camera Assembly Update		

1.0 Purpose / Summary

The MSS HD camera (70044) was experience field failures due to the heat sink shearing off its mounting screws.

A wider field of view, and greater tilt extents were also required.

This ECO corrects those 2 issues.

2.0 Parts Affected

Part Number	Notes	Removed	Added	New	Modified
70606	Update BOM	☐	☐	☐	☒
70607	Add Mount Screw Isolation Features, Cap Isolation Slot	☐	☐	☐	☒
70608	Update BOM	☐	☐	☐	☒
70609	Decrease Height, Update Dimension Orientation	☐	☐	☐	☒
70619	Add R.394 Cutout, Add .118x60 Chamfer	☐	☐	☐	☒
70620	Add R.394 Cutout, Add .118x60 Chamfer	☐	☐	☐	☒
70985	Added to Assembly	☐	☒	☒	☐
70983	Added to Assembly	☐	☒	☒	☐
70634	Remove from Assembly	☒	☐	☐	☐

3.0 Detail

The plastic screws holding the SensoRay board to the Camera Encoder Board Heat Sink were breaking, the Camera Encoder Board Heat Sink was modified to allow the use of stainless steel screws by isolating the SensoRay mounting screws from the heat sink.

A spring and spacer were added to the HD Camera Internal Electronics Assembly – MK2 to improve its retention in the MSS HD Camera 2km Housing.

	Doc or ECO #:	70044-001	Date:	12/18/2017	Author:	JK
	Rev. #:	003				
Engineering Change Order (ECO) Camera Assembly Update	Engineering Approval:	aeg	Date:	12/18/2017	Quality Approval	DO

A cutout and chamfer was added to the Internal Assembly Front Plates to increase the travel of the lens adapter and to prevent the lens from resting against the Internal Assembly Front Plates when tilted to upper and lower extents.

The lens was also changed from iPro Wide Angle Lens to iPro Fisheye Lens Series 2.

The Production Instructions were updated to include the aforementioned modifications in addition to general clarifications and added production test tools.

4.0 Disposition of Material

Part Number:

70044 All assemblies must be reworked to Rev B of the Production Instructions

70607 All Rev A parts must be removed from inventory and disposed of.

70609 All Rev A parts must be reworked to meet Rev B print.

70619 All Rev A parts must be reworked to meet Rev B print.

70620 All Rev A parts must be reworked to meet Rev B print.

70634 (Ipro 0.65X Wide Angle Lens) all material should be moved to engineering inventory.

5.0 Action Items

Action	Department	Acknowledgement Initials
Rework Full Assembly	Production	KK, KM
Rework Parts	Purchasing	TB
Update BOM In Epicor	Engineering	RN
Remove Legacy Parts from Inventory	Inventory Control	SL

	Doc or ECO #:	70044-001	Date:	12/18/2017	Author:	JK
	Rev. #:	003				
Engineering Change Order (ECO) Camera Assembly Update	Engineering Approval:	aeg	Date:	12/18/2017	Quality Approval	DO

6.0 Modified / Referenced Documents:

Document	Current Revision
70044-BOM	Rev B
70044-Production_Instructions	Rev B

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
12/18/2017	-	Initial Release	JK
12/19/2017	5.0	Add action item for Inventory Control	JK
12/21/2017	4.0	Added item for disposition of 70634	aeg