

Engineering Department

Engineering Change Order (ECO)

ECO #: ECO-70159-001

Effective Date: May 31, 2017

Title: M5 Power Module Housing Drawing Update

Author: JK
Engineering Approval: aeg
Operations Approval: aeg

Date: May 31, 2017
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Summary:

On the M5 Power Module Housing prints the as anodized sheet had tolerances that did not allow for the tolerances in the anodizing process. The revised print has these allowances calculated into the new tolerances. Critical to function annotations were added to the print in accordance with our updated quality assurance procedures.

Parts Affected:

Part Number	Notes	Removed	Added	Modified
70159	M5 Power Module Housing	☐	☐	☒

Detail:

Critical Tolerance #1-5 were offset by the nominal Micralox Type III anodizing thickness 2.0 mil or .002 inches. Since the actual anodizing thickness varies from .0018-.0026 inches the tolerances in the as anodized sheet needed additional tolerance range added to prevent passing as machined parts from failing QA inspection after anodizing.

Action Item:

Action	Department	Acknowledgement Initials
Update Drawing for 70159	Engineering	JK
Update part revision in Epicor	Engineering	RN
Notify vendor of change	Purchasing	TB

Modified / Referenced Documents:

Document	Current Revision
70159.pdf	B

-- END OF ORDER --