

	Doc or ECO #:	70189-002	Date:	6/11/18	Author:	JK
	Rev. #:	001				
Engineering Change Order (ECO)	Engineering Approval:	AEG	Date:	6/11/18	Quality Approval	DO

P/N #:	70189	Effective Date:	June 11, 2018
Title:	Communication Housing Fillet Update		

1.0 Purpose / Summary

M5 Comms Module Housing [70189] is becoming chipped on the corners during shipping and handling to the factory. Fillets were added to the corners to alleviate this issue.

2.0 Parts Affected

Part Number	Notes	Removed	Added	New	Modified
70189	Add R .031 Fillets	☐	☐	☐	☒

3.0 Detail

M5 Comms Module Housing [70189] has sharp (.005 fillets or chamfer max) external edges. The 2.0 mil micralox anodizing builds on the surface such that sharp edges, anything less than approximately R.015 in. is weak and prone to chipping. R .031 in. fillets were added to all external corners.

4.0 Disposition of Material

Use current stock which passes QA

5.0 Action Items

Action	Department	Acknowledgement Initials
Initiate sample production run	Purchasing	TB
Perform FAI	Engineering	JK
QA acknowledge change and track defect rate	QA	DO

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6.0 Modified / Referenced Documents:

Document	Current Revision
70189.pdf	C
70189_C.step	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
6/11/2018	-	Initial Release	JK