

	Doc or ECO #:	70513-001	Date:	4/28/20	Author:	JK
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	4/28/20	Quality Approval	aeg

P/N #:	70513	Effective Date:	April 28, 2020
Title:	Collet Through Hole Modification		

1.0 Purpose / Summary

Collets can get stuck on M5 Thruster 2.0 5mm Motor Shaft Zirconia [70472], adding a through hole will eliminate the hydraulic mechanism and is provisional for a collet extractor tool.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
70513	Remove .0781 Thru Hole, Add .136 Thru Hole	☐	☐	☒	C

3.0 Detail

Collets can get stuck on M5 Thruster 2.0 5mm Motor Shaft Zirconia [70472] by two mechanisms, mechanical interference between motor shaft chamfer and collet drill point and by hydraulic “lock” where tefgel corrosion inhibitor forms a seal between the motor shaft and the collet forming a vacuum when attempting to remove the collet. The added .136 thru hole will provide a vent eliminating the potential for hydraulic lock and provide access to the motor shaft for an extractor tool.

4.0 Disposition of Material

Use up existing stock of Rev A, then begin using Rev C.

5.0 Action Items

Action	Department	Acknowledgement Initials
Send updated PO and drawings to supplier.	Purchasing	NS
Keep Rev A and Rev C collets separate inventory so all Rev A collets get used first.	Inventory	SL

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6.0 Modified / Referenced Documents:

Document	Current Revision
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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
4/28/20	-	Initial Draft	JK