

	Doc or ECO #:	ECO-70893-001	Date:	12/07/2020	Author:	SL
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	aeg	Date:	12/11/2020	Quality Approval:	aeg

P/N #:	70893	Effective Date:	December 11, 2020
Title:	Pro5 Frame Sonar Mount Tilt Upgrade		

1.0 Purpose / Summary

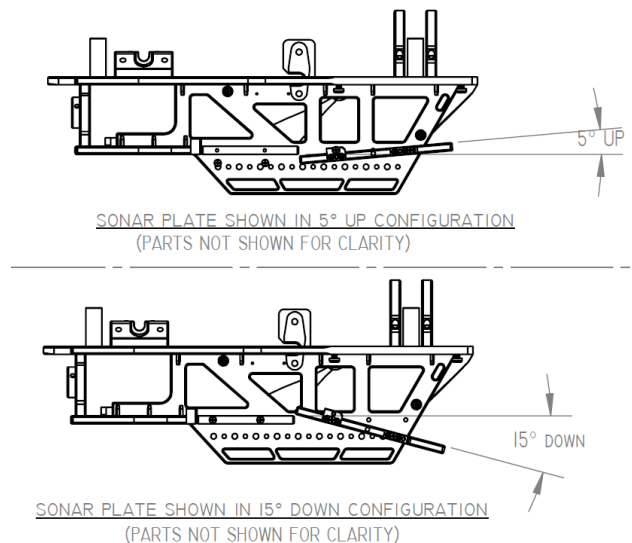
- The purpose of this Engineering Change Order is to increase the feature set of the Mission Specialist Pro 5 Frame by adding a tilt function to the sonar mount plate.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
70893	Top Level Pro 5 Frame	☐	☐	☒	C
70895	Sonar Mount Plate	☐	☐	☒	D
72391	Negative Degree Tilt Plate	☐	☒	☐	A
72392	Positive Degree Tilt Plate	☐	☒	☐	A
72393	Supporting Hardware	☐	☒	☐	A
71843	Supporting Hardware	☐	☒	☐	A
71432	Decreased Quantity from 36 to 30	☐	☐	☒	A

3.0 Detail

- By modifying the Sonar Mount Plate [70895] to add Positive/Negative tile plates [72391 + 72392] (x 2 each) and utilizing the exiting unmodified frame, the sonar can now be angled at a 5 degree positive or 15 degree negative pitch for varying target acquisition requirements.



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- The following hardware changes have been made to the Bill of Materials for the Pro 5 Frame Assembly **[70893]**
 - Removed 6 - Plastite #8 X ¾" 18-8SS **[71432]**
 - Added 8 – Plastite Flat Head #6 X ½" Torx **[72393]**
 - Added 4 – PHPS 8-32 X ¾" 18-8 SS Sealing Screws **[71843]**
- The following parts list can be used to upgrade any existing frame in house or in the field. *Note a T10 Torx screwdriver is required for the replacement and upgrade of the Sonar Mount Plate.
 - 1 – **[70895]** Pro5 ROV Frame Sonar Mount Plate
 - 2 – **[72391]** Sonar Mount Horizontal Nut Plate
 - 2 – **[72392]** Sonar Mount Vertical Nut Plate
 - 8 – **[72393]** Plastite Flat Head #6 X ½" Torx
 - 4 – **[71843]** PHPS 8-32 X ¾" 18-8 SS Sealing Screws

Note work instructions were rev'd to A, from R-#, concurrent with this ECO.

4.0 Disposition of Material

- All Sonar Mount Plates **[70895]** are being reworked to revision D
- All Pro 5 Frame Assemblies **[70893]** should be inspected and upgraded to revision C which include the Sonar Tilt Plates
- Note that pre-production 72391/72392 required rework, which was done.
- Field upgrades kits can go out, there is no singled p/n at the time of publishing.

5.0 Action Items

Action	Department	Acknowledgement Initials
Update BOMs	Engineering	TG
Update Epicor	Engineering	SL
Inspect and upgrade if needed all 70893	Production	KK
Update all stock of 70895 to latest rev D	Purchasing	RM
Work instruction updates	Engineering	SL

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6.0 Modified / Referenced Documents:

Document	Current Revision
WI-70892	A

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