

	Doc or ECO #:	ECO-72267-001	Date:	10/28/2019	Author:	JV
	Rev. #:	001				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	10/31/2019	Quality Approval	DO

P/N #:	72267	Effective Date:	October 31, 2019
Title:	Tether WI update to include adhesion Test		

1.0 Purpose / Summary

Periodically during tether termination, we have witnessed adhesion issues to the tether jacket. Better data tracking and a tether adhesion test have been added to highlight outliers and eventually narrow down the variable causing adhesion issues.

The work instructions have been updated to feature these changes.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
72267	Tether adhesion test mold assembly	☐	☒	☐	A

3.0 Detail

Tether work instructions have been merged to the new 2019 WI template. Various formatting and updates were done to make the instructions clearer and more concise.

Data tracking throughout the termination process has been implemented, along with an Adhesion test to help check the adhesion of resin to the tether jacket without ruining the actual tethers.

In summary, every time a batch of urethane is mixed, a tether adhesion test will be performed. Regardless if one tether end is to be potted, or six tether ends to be potted. This adhesion test allows us to check the bonding of the tether batch, without damaging tethers.

Along with the data tracking, this allows us to mark potting batches that show differences than the rest. After some time, the hope is that we can look at the tether tracking sheet and see a correlation between faulty bonded tethers. We hope this will allow us to narrow down the root cause of adhesion failure.

4.0 Disposition of Material

N/A

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5.0 Action Items

Action	Department	Acknowledgement Initials
Ensure use of work instructions	QC	DO
Use new tether QC sheet, update record sheets.	QC	DO
Maintain tracking log with Supplier	QC	DO

6.0 Modified / Referenced Documents:

Document	Current Revision
Tether 2.0 WI	006
Tether QC Check Sheet / QC-020	F

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
10/28/2019		Initial Submission	JV