

Engineering Department

Engineering Change Order (ECO)

ECO #: JHC-ASSM-001

Effective Date: June 16, 2016

Title: Secure the knobs on the Industrial Hand Controller

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Engineering Approval: aeg
Operations Approval: JJV

Date: June 16, 2016
Date: July 27, 2016
Date: July 28, 2016

Summary:

The Industrial Hand Controller has had issues with the potentiometer knobs working loose during operation. This ECO will modify the assembly process to improve the knob attachment to the potentiometer shaft.

Parts Affected:

Part Number	Notes	Removed	Added	New	Modified
JHC-ASSM	Industrial Hand Controller	☐	☐	☐	☒

Detail:

The set screw on the vertical knob in particular loosens over time as you have a set screw with a flat bearing surface resting against a round shaft. There is simply not enough force to keep the knob in place.

To improve the mechanical locking of knob and shaft the vendor is drilling dimples into the shaft prior to installing the knob. Once the knob is installed the vendor will use Loctite on the set screw which fits securely into the dimple.

All potentiometer shafts on the hand controller will get these modifications.

Action Item:

Action	Department	Acknowledgement Initials
Update assembly instructions	Engineering	AEG
Notify vendor of the change via this ECO	Purchasing	NS (nancy)
Develop QC process for incoming inspection of hand controllers	QC	NS (nipha)
Implement change effective on any new hand controllers produced	Purchasing	NS (nancy)
Identify initial S/N that change applies and record	QC	NS (nipha)
Update JHC-ASSM Revision in Epicor	Inventory	SL

Modified / Referenced Documents:

Document	Current Revision
Industrial Handcontroller Potentiometer Modification Instructions	1.0

-- END OF ORDER --