

	Doc or ECO #:	MNP-009 - 001	Date:	5/14/20	Author:	JK
	Rev. #:	A				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	5/22/20	Quality Approval	aeg

P/N #:	MNP-009	Effective Date:	May 22, 2020
Title:	Updated Tolerancing for Manipulator Part Actuator		

1.0 Purpose / Summary

Manipulator Part Actuator [MNP-009] had three dimensions which could cause interference with mating parts if manufactured near the extremes of the print tolerance range. Updating these tolerances eliminates the risk of a part machined and inspected to print from causing interference.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
MNP-009	Update Uncoated Tolerance, Add Reference Dimensions Coated Sheet	☐	☐	☒	B

3.0 Detail

The .375- and .490-inch ears on Manipulator Part Actuator [MNP-009] once anodized and Cerakote would interfere with the .380- and .500-inch slots in the Manipulator Pivot Fork [MNP-010]. Similarly, the .385-inch slot in Manipulator Part Actuator [MNP-009] once anodized and Cerakote would interfere with Manipulator Part Arm 1 [MNP-007] and Manipulator Part Arm 2 [MNP-008]. The tolerances were adjusted on Manipulator Part Actuator [MNP-009] to eliminate all four interference events. Reference dimensions were added to the coating sheet of Manipulator Part Actuator [MNP-009] to improve coating thickness clarity.

4.0 Disposition of Material

Manipulator Part Actuator [MNP-009] outside of the acceptance range specified in Rev B must be scrapped

5.0 Action Items

Action	Department	Acknowledgement Initials
Coordinate with ESI to carry out disposition of material	Purchasing	NS
Carry out disposition of material on VideoRay premise	Inventory Control	SL

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6.0 Modified / Referenced Documents:

Document	Current Revision
Click here to enter text.	Click here to enter text.

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
5/14/20	-	Initial Draft	JK