

	Doc or ECO #:	ECO-MNP-010-018-001	Date:	12/16/2021	Author:	JV
	Rev. #:	001				
Engineering Change Order (ECO)	Engineering Approval:	Aeg	Date:	12/16/2021	Quality Approval	aeg

P/N #:	MNP-010 & MNP-018	Effective Date:	December 15, 2021
Title:	Updated Manip Tolerances		

1.0 Purpose / Summary

Tolerances were adjusted within MNP-010 and MNP-018 to allow for a proper mate. Prior to this ECO, these parts had overlapping tolerances, which causes us to have batches of passing parts that would not mate.

2.0 Parts Affected

Part Number	Notes	Removed	Added	Modified	REV
MNP-010	No mechanical changes, drawing tolerance update only	☐	☐	☒	E
MNP-018	No mechanical changes, drawing tolerance update only	☐	☐	☒	C

3.0 Detail

Prior to adjustment, the measurements were as follows:

The bore of MNP-018 was .563 +/- .005, meaning .558 - .568 was within tolerance.

The boss of MNP-010 was .559 +/- .005, meaning .554-.564 was within tolerance.

This creates an overlap of acceptable tolerances causing acceptable parts of each to not accurately mate.

The tolerance of each was adjusted so that in the extremes of each there remains .002" of clearance.

4.0 Disposition of Material

Once the new batch of MNP-010 Rev E arrives and is tested, the remainder of MNP-010 Rev D will be removed from inventory.

MNP-018 rev B should be used entirely before using Rev C.

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5.0 Action Items

Action	Department	Acknowledgement Initials
Order new revs of MNP-010 & MNP-018	Purchasing	RM
EPICOR UPDATE	ENGR	JV

6.0 Modified / Referenced Documents:

Document	Current Revision
n/a	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
12/16/2021		initial	JV