CREO

Creo Products Inc.

Engineering Change Order

ECO#: C443

Originator: SMON **Page:** 1

Department: ENG **Date: 8/20/98**

Engineering Changes

Part #	Rev/Status From	To	Description	Product	ECRs	Back Comp?	Reason for chg.	Serv. Class	Prod. Class
50-1454A	N	P	Kit mech autoloader parts creo gry	Ts-auto			1	N/A	3
50-1539A	G	H	Kit mech autoloader parts jv gry	Ts-auto			1	N/A	3
57-5450A	PRE	C	Fab load table support ts-auto	Ts-auto			1	S	1
57-4962B	A	In	Brkt shipping brace ts-auto	Ts-auto			--	--	--
72-0026A	C	D	TRACK AS #7 ON 100 LABEL	Ts-auto			5	N/A	4

Copies To:	Title:	Signature:	Date:	Code Descriptions			
	Design Eng.	Scott Montague	18/August/29	Status	Service	Production	Reason
	Production Eng.			AC - ACTIVE IN - INACTIVE OB - OBSOLETE PR - PREREL.	R-RETROFIT S-NEXT CALL F-NEXT FAIL T-THEIR COST N-NOT UP-GRADABLE NA-NOT APPL.	1-RETROFIT ALL UNITS 2-FINISHED GOODS 3-WIP 4-FUTURE 5-DOCUMENT ONLY	1-DESIGN 2-MANUFACT 3-ASSEMBLY 4-DOCUMENT 5-COST 6-MAINT. 7-RELAIBIL. 8-SOFTWARE 9-OTHER
	Field Service Eng.						
	Project Eng.						
	Project Manager						
	Product Manager						

Details of Problem and the Changes

57-5450A Fab load table support

The load table still has a large amount of flex in it.

To stiffen the assembly up, install these supports between the load table top (shipping bracket pem) and the pan support brackets. Holes may need to be drilled and pem's inserted in the load table on some machines. The shipping brackets are no longer required.

Track this change with #7 on the 100 label

Documentation Changes

Part #	Rev/Status		Documents							
	From	To	Type	Status/Resp.	Type	Status/Resp	Type	Status/Resp	Type	Status/Resp
72-0026A	C	D								
57-5450A	PRE	C	DD	AT/SMON						
57-4962B	A	In	DD							

Status Codes: AT- Udated document is attached RL- Redlined document is attached UP- No document attached, update will follow NC- No changes required to document

Resp.: NAME-four letter Creo employee who is/was responsible for updating the document

Field Service Implementation

Field Upgrade Kit: 05-0063 Description
For units:

Part No.	Description	Qty	Std. Unit Cost	Total Cost
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
57-5450A	FAB LOAD TABLE SUPPORT TS-AUTO	2.00	$15.00	$30.00
				$0.00
52-4441	NUT M6*1.0 MIN PRESS-IN (PEM) SS	2.00		$0.00
52-3254	SCRW M6*10 SOCK-CAP S-PLATED PRE APPL	2.00		$0.00
52-4070	WASH M6 FLT S-PLATED	2.00		$0.00
		2.00		$0.00
				$0.00
				$0.00
				$0.00
				$0.00
	Material Cost:			**30.00**
		Hours	**Rate**	**Total**
	Labour Cost:	$ 0.50	$ 80.00	$ 40.00

Special Tools Required:

Field Upgrade Instructions:

On recent machines the load table supports are simply bolted in place where the shipping brackets were once installed. For earlier machines where the shipping brackets were attached to the load table by the separator cylinder bolt and lock nut, a 11/32 hole must be drilled 60 mm directly above the separator cylinder bolt location and a M6 pem installed. (Be careful of the separator arm cylinders, USE A SCRAP PIECE OF MATERIAL INFRONT OF THE CYLINDER when drilling.)