Engineering Change Order

ECO#: C604

Creo Products Inc.

Originator: Calvin C **Page:** 1

Department: ENG **Date: 11/25/98**

Engineering Changes

Part #	Rev/Status From	To	Description	Product	ECRs	Back Comp?	Reason for chg.	Serv. Class	Prod. Class
50-1690A	pr	A	Assy,mech,plate push,ts-a	ts-auto		y	1	n/a	4
57-5794A	pr	A	Plate push bracket, autoloader ts	ts-auto		y	1	n/a	4
57-5795A	pr	A	Main bracket, plate push, autoloader ts	ts-auto		y	1	n/a	4
57-5793A	pr	A	Support bar, plate push, autoloader ts	ts-auto		y	1	n/a	4
50-1452A	H	J	Assy,mech,load Table.ts-a	Ts-auto		Y	1	N/a	4
57-5139A	C	INAC	Brkt,Load Table Guard,TS-A						
72-0026A	H	J	Doc,spec,eco/100-label x-ref,ts-al	Ts-auto		Y	4	N/a	5
05-0073			Kit, Upgrade, ECO C604, Plate Push, TS-A						

Copies To:	Title:	Signature:	Date:	Code Descriptions			
	Design Eng.	Calvin Cummings	98/Nov/1	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

Plate pusher assembly has been added to the trendsetter autoloader to ensure the unload table cups contact the plate. This is number 13 on the Autoloader 100 label.

Add the following parts to this assembly (50-1690A)

Qty 1	55-0279 Cyl 9/16 x ½, sg ac, sg rd, pvt mnt
Qty 1	55-0064 Rod end, fem, stud, 10-32 unf, nyloy, s–plated
Qty 1	55-0213 Brkt, pivot, 9/16 dia cyl, pin, s ,ctp
Qty 2	54-3221 Bush, snap-in, 5/16 x 3/8 x .140, type 7 nyl
Qty 4	52-4371 Scrw, 10-24 x ½", sock-cap, s-blk
Qty 4	52-4310 Nut, 10-24, nylock, s-plt
Qty 5	52-3248 Wash, m5, heavy
Qty 1	52-3191 Wash, m6, heavy, sp
Qty 1	52-3090 Wash, m8, ft, ss
Qty 3	52-3177 Nut, m5, nylock, s-plated
Qty 1	52-3318 Bolt,shldr, 5/16" x 2", ¼" thread
Qty 3	55-0134 Ftg, luer, male, 2.25mm id tube, nylon, white
Qty 2	55-0135 Ftg, luer, fem, 2.25mm id tube, nylon, white
Qty 1	55-0623 Regulator, air, #10-32, ts-auto
Qty 2	55-0226 Ftg, air, 10-32, 5/32 tube, barb
Qty 3m	56-1037 Tube, air, 4 od (5/32"), black, polyurethane
Qty 1	57-5794A Plate push bracket, autoloader ts
Qty 1	57-5795A Main bracket, plate push, autoloader ts
Qty 1	57-5793A Support bar, plate push, autoloader ts
Qty 1	55-0071 Elbow,air,male,10-32 unf,5/32" tube, ext hx

Change the following assemblies;

50-1452A Assy,mech, load table

- Item 0780 Change 52-3253 scrw, m4 x 8 to qty 12
- Item 0790 Change 52-4054 wash, m4 to qty 12

Documentation Changes

Part #	Rev/Status		Documents							
	From	To	Type	Status/Resp.	Type	Status/Resp	Type	Status/Resp	Type	Status/Resp
50-1690A	Pre	A	AD	UP/CALC						
50-1452A	H	J	AD	UP/CALC						
57-5794A	Pre	A	DD	UP/CALC						
57-5795A	Pre	A	DD	UP/CALC						
57-5793A	Pre	A	DD	UP/CALC						
72-0026A	H	J	SP	AT/PAUM						

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- Description KIT,UPGRADE,EC0 C604,PLATE PUSH,TS-A
For units:

Part No.	Description	Qty	Std. Unit Cost	Total Cost
50-1690A	ASSY,MECH,PLATE PUSHER,TS-A	1.00	$130.00	$130.00
52-4054	WASH,M4,FLT,S-PLATED	8.00	$0.03	$0.24
52-3253	SCRW,M4*8,SOCK-CAP,S-PLATED,PRE-APPLIED	8.00	$0.15	$1.20
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
				$0.00
	Material Cost:			**131.44**
		Hours	**Rate**	**Total**
	Labour Cost:	$ 2.00	$ 80.00	$ 160.00

Special Tools Required:

Field Upgrade Intructions:

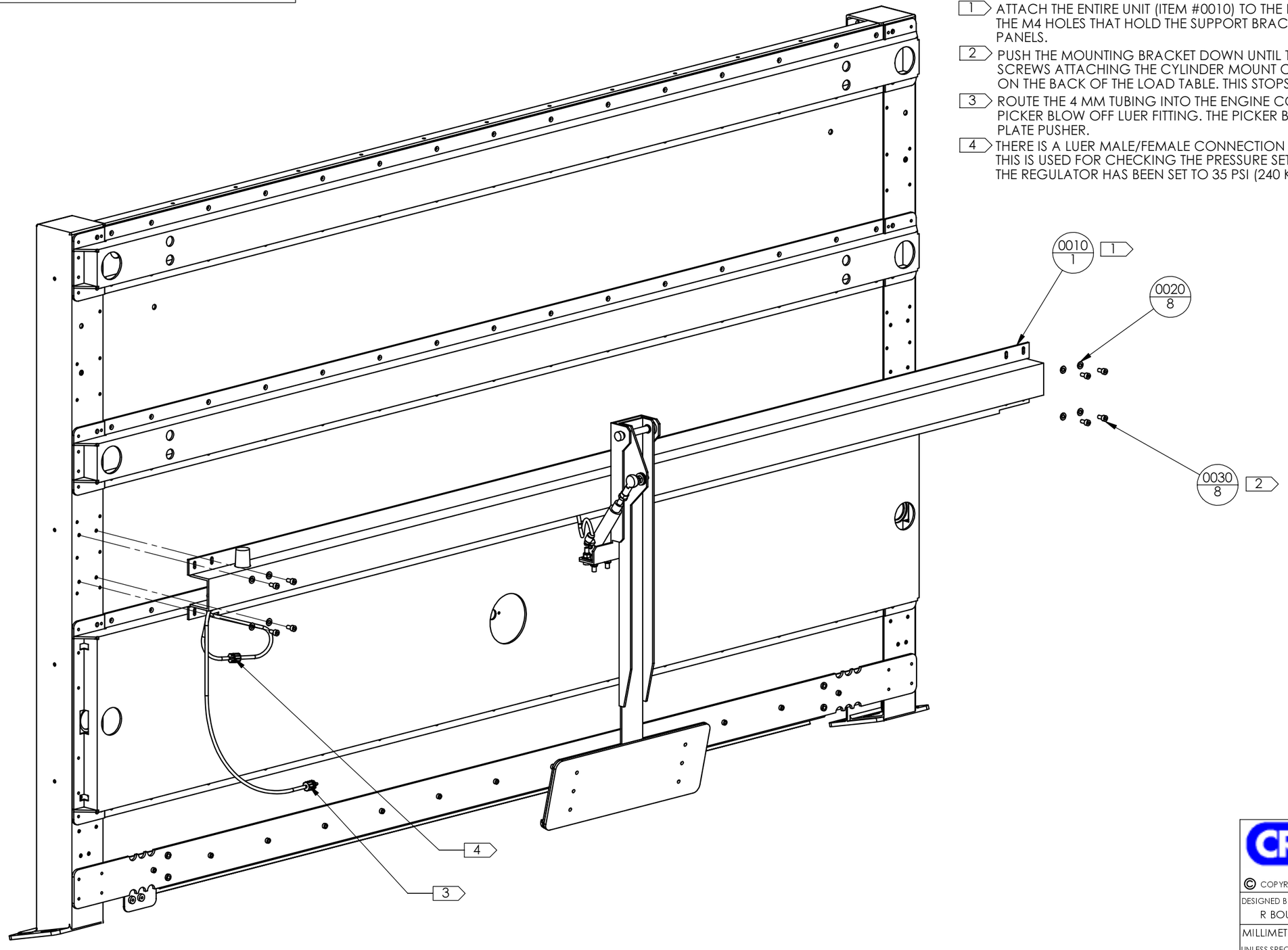
REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY

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NOTES:

IMPORTANT NOTE: THE MINIMUM MPE CODE REQUIRED FOR THE PLATE PUSHER IS 1.10

1. ATTACH THE ENTIRE UNIT (ITEM #0010) TO THE BACK OF THE LOAD TABLE USING THE M4 HOLES THAT HOLD THE SUPPORT BRACKETS FOR THE PLASTIC SIDE SAFETY PANELS.
2. PUSH THE MOUNTING BRACKET DOWN UNTIL THE HEADS OF THE SOCKET HEAD SCREWS ATTACHING THE CYLINDER MOUNT CONTACT THE TOP OF THE STIFFENER ON THE BACK OF THE LOAD TABLE. THIS STOPS THE UNIT FROM TWISTING.
3. ROUTE THE 4 MM TUBING INTO THE ENGINE COMPARTMENT AND CONNECT IT TO THE PICKER BLOW OFF LUER FITTING. THE PICKER BLOW FUNCTION IS NOW USED FOR THE PLATE PUSHER.
4. THERE IS A LUER MALE/FEMALE CONNECTION AT THE END OF THE UNIT. THIS IS USED FOR CHECKING THE PRESSURE SETTING OF THE REGULATOR. THE REGULATOR HAS BEEN SET TO 35 PSI (240 KPa).



KIT,UPGRADE,
PLATE PUSHER
TS-AUTO

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DESIGNED BY	DRAWN BY			
R BOUCHAL	R BOUCHAL			
MILLIMETERS UNLESS SPECIFIED	DATE: 1999:APR:22	SIZE B	SCALE 1:5	
PART NO.	REV	DOC	SHEET	OF
05-0073	–	AD	1	1