Creo Products Inc.	Engineering Change Order		ECO#: C986
	Originator: C.Townsend		Page: 1
	Department: Engineering	Date: 1999:June:23	

Engineering Changes

Part # (incl version)	Rev/Status From	To	Description	Prod line(s)	Related ECR's	Backwards compatible?	Srvc class	Prod class	Reason
11-0520B	X	Y	Wired frame, TSV	TSV	C191 C248	Y	N/A	3	3
05-0109	A	B	Kit, EMI relocation upgrade	TSV		Y	N/A	5	3
57-5742A	C	D	Omron Sw brkt, Fanbox	TSV	C247	Y	N/A	3/4	1
57-1481C	B	C	Panel rear, mainframe	TSV	C247	Y	N/A	3/4	1
57-5528A	A	B	Fab, AC inlet cover	TSV	C248	Y	N/A	3/4	3
72-3091A	A	B	Doc, EMI Filter Relocation	TSV			N/A	5	4

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Add the following people to this ECO's distribution list:	Print or type name:	Date:
Production Engineer	D.Huber	1999:Jul:01

Status	Service class	Production class	Reason for change
IN Inactive OB Obsolete PR Pre-release	R Retrofit S Next Call F Next Fail T Their Cost N Not Up-Gradable N/A Not Applicable	1 Retrofit all units 2 Finished goods 3 WIP 4 Future 5 Documentation	1 Design 2 Manufacturing 3 Assembly 4 Documentation 5 Cost 6 Maintenance 7 Reliability 8 Software 9 Other

Details of Problem and the Changes

EMI filter mounting:

1) AC inlet cover currently mounted with four studs. In the case of a field relocation of the EMI filter, service engineers can only install a pair of screws close to the edge of the base-frame. This is due to limited space between bottom skin and floor when machine is resting on mounting feet. Two fasteners installed nearest edge of base-frame rail will provide safe and secure mounting of the cover and a pair of self-tapping screws installed from the top is preferred over individual screws mounted from underneath the floor. This ECO reduces mounting of cover to two points and introduces the use of self-tapping screws. BOM's for wired frame and relocation kit and procedure (72-3091A) changed to suit. Redundant mounting tabs on AC inlet cover removed.
2) Standard M4 nuts without lock washers were used to mount the EMI filter. These nuts could loosen over time so this ECO changes hardware to M4 self locking nuts with flat washers. BOM for wired frame modified.

Mounting the cover by only two studs instead of four (Item #1) and using self-locking nuts (Item #2) were implemented into production starting with TSV machine B227.

Omron Key and bracket mounting:

1) Slots for mounting Omron keys to 57-1481C need to be relocated and made larger to accommodate large assembly tolerances between hood and frame. See redline changes on 57-1481C. Production currently re-drilling holes to mount keys.
2) Slot in 57-5742A also to be made longer for taking up greater assembly tolerances between frame and panels. See redline.

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Documentation Changes

Part #	Rev/Status		Documents							
	From	To	Type	Status/Resp	Type	Status/Resp	Type	Status/Resp	Type	Status/Resp
11-0520B	X	Y	AD	RL/C.Townsend						
57-5742A	C	D	DD	Rl/C.Townsend						
57-1481C	B	C	DD	RL/C.Townsend						
57-5528A	A	B	DD	RL/C.Townsend						
05-0109	A	B		RL						
72-3091A	A	B	DOC	RL/C.Townsend						

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Document Status Codes AT – Updated document is attached RL – Redlined document is attached
UP – No document attached, update will follow NC – No changes required to document
Responsibility Name of Creo employee who is responsible for updating the document

Production Implementation

Part #	Qty in Stock	Action	Qty in Process	Job # / PO #	Action	Comments
57-1481C		Continue reworking existing panels.		45019961 45021934	Version B Version C	Wesgar and Anita informed of desired changes Jun 23/99 . Wesgar will advise us when changes can be implemented.
57-5742A		Use bracket as is.		45021945		Tara and Anita informed of desired changes on Jun 23/99. Tara will advise us when changes can be implemented.
57-5528A		Use cover as is.		45022440		Wesgar and Anita informed of desired changes Jun 24/99 . Wesgar will advise us when changes can be implemented.

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Service Logistics Implementation

Part #	Qty in Stock	Action	Qty in Process	Job # / PO #	Action	Comments

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Actions

Owner	Action
C.Townsend	Provide H&S copy for: 57-1481C-C, 57-5742A-D, 57-5528AB and 72-3091A.
R.Hori	Update BOM for 11-0520B-Y AND 05-0109B.
K.Lavernge	Archive H&S copy as it becomes available.
D.Huber/R.Hori	Update pre-released FLEXO BOM for wired frame (11-0567A) to match 11-0520B.
A.Radman	Note changes to rev levels of parts on order – co-ordinate with vendors.
J.Kilbblewhite	Publish links related to ECO and latest revision of 72-3091A on product support page.

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