ENGINEERING CHANGE ORDER

Hemtack

REQUEST DATE	5/28/2024	REQUESTED BY	H. AMEZQUITA	REQUESTED RELEASE DATE	5/31/2024	ECO #	ECO-00139
AFFECTED PRODUCT LINES	CHAIN OPERATED PRODUCTS						
REASON FOR CHANGE	NEW SCREW FOR TENSION DEVICE INSTALLATION KIT						
DESCRIPTION OF CHANGE	RELEASE NEW PART NUMBER FOR SCREW REQUIRED FOR COULISSE TENSION DEVICE INSTALLATION						
COST IMPACT	N/A						

DOCUMENT / PART NUMBER	OLD REV	NEW REV	DOCUMENT/ PART DESCRIPTION	CHANGE DESCRIPTION	FORM, FIT, OR FUNCTION AFFECTED Yes, or No	PART DISPOSITION (USE AS IS) (REWORK) (SCRAP) (OBSOLETE) (RETURN TO VENDOR) (OTHER)
MPMI1590	-	-	SCREW, PHILLIPS #8 PN TYPE A T/S 15TPI, STEEL	**NEW PART NUMBER RELEASE** **COMPONENT:** SAME AS PART NUMBER **COLOR:** N/A **STOCK CLASS:** ROLLER PARTS **PU:** EA **RU:** EA **RF:** 1 **CRITICAL:** NO **CO:** TBD	NO	N/A

ADDITIONAL INFORMATION	

AFFECTED DOCUMENTS / PROCESSES (CHECK ALL THAT APPLY)

BOM / CONFIG	☐	PRODUCT / PART SPEC	☒	QC CHECKLIST	☐	PART DRAWING	☐	ASSEMBLY DRAWING	☐	INSTR SHEET	☐	PROCESS VISUAL AIDS	☐	WORK INSTRUCTIONS	☐

ECO APPROVALS ROUTING

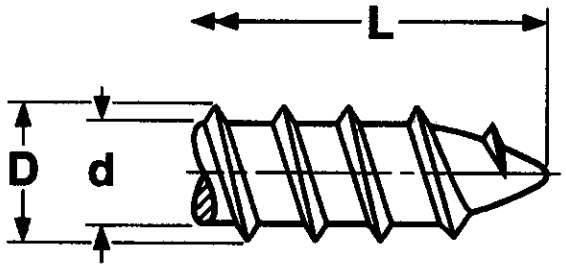
APPROVER	APPROVAL REQUIRED	APPROVER NAME	APPROVAL STATUS	APPROVED ON	NOTES
PHASE II MANAGEMENT (US - DL)	☒	T. DAVIDSON	APPROVED	05/28/2024	
PHASE II PROD DEV (US - NY)	☒	L. HUNT	APPROVED	05/28/2024	
MANAGEMENT (MX)	☒	L. MONTEJO	APPROVED	06/06/2024	
QC / ENG (MX)	☒	H. AMEZQUITA	APPROVED	05/28/2024	
IT (MX)	☒	E. CASTELLANOS	APPROVED	05/28/2024	

PRODUCTION (MX)	☐				
MATERIALS (MX)	☐				

ACTIONS REQUIRED		
BOM / CONFIG	☐	WILL BE MODIFIED BY IT (MX)
PRODUCT / PART SPEC	☒	WILL BE MODIFIED QC / ENG (MX)
QC CHECKLIST	☐	WILL BE MODIFIED QC / ENG (MX)
PART DRAWING	☐	WILL BE MODIFIED QC / ENG (MX)
ASSEMBLY DRAWING	☐	WILL BE MODIFIED QC / ENG (MX)
INSTR SHEET	☐	WILL BE MODIFIED PHASE II (USA)
PROCESS VISUAL AIDS	☐	WILL BE MODIFIED QC / ENG (MX)
WORK INSTRUCTIONS	☐	WILL BE MODIFIED QC / ENG (MX)

PICTURES, DRAWINGS, ETC.

Type-A *Thread Forming* Self-Tapping Screws



Threads For Self-Tapping Screws Type A

ANSI B18.6.4

Nominal Size or Basic Screw Diameter		Threads Per Inch	D		d		L		Minimum Torsional Strength, lb.-in. (STEEL SCREWS ONLY)
			Major Diameter		Minor Diameter		These Lengths or Shorter Have AB Threads		
			Max	Min	Max	Min	90° Heads	Csk Heads	
6	0.1380	18	.141	.136	.102	.096	1/4	5/16	24
7	0.1510	16	.158	.152	.114	.108	5/16	3/8	30
8	0.1640	15	.168	.162	.123	.116	3/8	7/16	39
10	0.1900	12	.194	.188	.133	.126	3/8	1/2	48
12	0.2160	11	.221	.215	.162	.155	7/16	9/16	83
14	0.2420	10	.254	.248	.185	.178	1/2	5/8	125
20	0.3200	9	.333	.327	.234	.226	11/16	13/16	250
24	0.3720	9	.390	.383	.291	.282	3/4	1	492
Tolerance on Length				Up to 1" Incl.: ±0.03			Over 1": ±0.05		

Description	A thread forming tapping screw with wider spaced threads than a Type-AB and a gimlet point.
Applications/ Advantages	For self starting in thin (.015-.050 thick) metal or resin-filled plywood. 18-8 Stainless steel tapping screws may be used in applications which require general atmospheric corrosion resistance. Fastening stainless steel parts to aluminum or steel can cause a type of corrosion known as a galvanic couple in some environments.
Material	**Steel:** AISI 1016 - 1024 or equivalent steel. **Stainless:** Austenitic 18-8 stainless steel
Heat Treatment (Steel only)	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.
Surface Hardness	**Steel:** Rockwell C45 minimum
Case Depth (Steel only)	No. 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" and larger: .005 - .011
Core Hardness (after tempering)	**Steel:** Rockwell C28 - 38
Plating	See Appendix-A for information on plating of steel screws.