



Hemtack

ENGINEERING CHANGE ORDER

REQUEST DATE	7/7/2022	REQUESTED BY	H. AMEZQUITA	REQUESTED RELEASE DATE	7/14/2022	ECO #	ECO-00069
AFFECTED PRODUCT LINES	ZEBRA STANDARD CASSETTE SHADES						
REASON FOR CHANGE	ALUMINUM COMPONENTS SILVER FINISH CHANGE						
DESCRIPTION OF CHANGE	SILVER COLOR ALUMINUM COMPONENTS FINISH CHANGE FOR A MORE DURABLE SURFACE. AVOID SCRATCHES AND DAMAGE DURING SHIPMENT AND HANDLING.						
COST IMPACT	N/A						
DOCUMENT / PART NUMBER	OLD REV	NEW REV	DOCUMENT/ PART DESCRIPTION	CHANGE DESCRIPTION	FORM, FIT, OR FUNCTION AFFECTED <small>Yes, or No</small>	PART DISPOSITION <small>(USE AS IS) (REWORK) (SCRAP) (OBSOLETE) (RETURN TO VENDOR) (OTHER)</small>	
MPMI1334	-	-	ALUM BOTTOM RAIL V-SHAPED, SILVER 130 IN L	SILVER FINISH CHANGE (SEE PAGES 3 – 18)			
MPMI1355	-	-	ALUM ROLLER COVER ZEBRA STD, SILVER 130 IN L	SILVER FINISH CHANGE (SEE PAGES 3 – 18)			
MPMI1350	-	-	ALUM ROLLER PIPE V SHAPED SILVER 130 IN L	SILVER FINISH CHANGE (SEE PAGES 3 – 18)			
ADDITIONAL INFORMATION	CHANGE EFFECTIVE STARTING FROM PO#1924194 ETD/A: 7/12, 8/5						
AFFECTED DOCUMENTS / PROCESSES (CHECK ALL THAT APPLY)							
BOM / CONFIG	<input type="checkbox"/>	PRODUCT / PART SPEC	<input checked="" type="checkbox"/>	QC CHECKLIST	<input type="checkbox"/>	PART DRAWING	<input type="checkbox"/>
				ASSEMBLY DRAWING	<input type="checkbox"/>	INSTR SHEET	<input type="checkbox"/>
				PROCESS VISUAL AIDS	<input checked="" type="checkbox"/>	WORK INSTRUCTIONS	<input type="checkbox"/>
ECO APPROVALS ROUTING							
APPROVER	APPROVAL REQUIRED	APPROVER NAME	APPROVAL STATUS	APPROVED ON	NOTES		
PHASE II MANAGEMENT (US - DL)	<input checked="" type="checkbox"/>	T. DAVIDSON	APPROVED	07/13/2022			
PHASE II PROD DEV (US - NY)	<input checked="" type="checkbox"/>	L. HUNT	APPROVED	07/13/2022			
MANAGEMENT (MX)	<input checked="" type="checkbox"/>	L. MONTEJO	APPROVED	07/13/2022			
QC / ENG (MX)	<input checked="" type="checkbox"/>	H. AMEZQUITA	APPROVED	07/07/2022			
IT (MX)	<input checked="" type="checkbox"/>	E. CASTELLANOS	APPROVED	07/07/2022			
PRODUCTION (MX)	<input type="checkbox"/>						
MATERIALS (MX)	<input type="checkbox"/>						

ACTIONS REQUIRED

BOM / CONFIG	<input type="checkbox"/>	WILL BE MODIFIED BY IT (MX) / QC / ENG (MX)
PRODUCT / PART SPEC	<input checked="" type="checkbox"/>	WILL BE MODIFIED QC / ENG (MX)
QC CHECKLIST	<input type="checkbox"/>	WILL BE MODIFIED QC / ENG (MX)
PART DRAWING	<input type="checkbox"/>	WILL BE MODIFIED QC / ENG (MX)
ASSEMBLY DRAWING	<input type="checkbox"/>	WILL BE MODIFIED QC / ENG (MX)
INSTR SHEET	<input type="checkbox"/>	WILL BE MODIFIED PHASE II (USA)
PROCESS VISUAL AIDS	<input checked="" type="checkbox"/>	WILL BE MODIFIED QC / ENG (MX)
WORK INSTRUCTIONS	<input type="checkbox"/>	WILL BE MODIFIED QC / ENG (MX)

PICTURES, DRAWINGS, ETC.



Hugo Amezcuita

From: Hugo Amezcuita <hamezcuita@hemtack.com>
Sent: Tuesday, June 21, 2022 1:35 PM
To: 'theresa@phaseii.com'; '陳M.'; 'leehunt666@gmail.com'; 'Lisa Hernandez'; 'Marcos K. Chang'; 'amontejo@hemtack.com'; 'Lulu Montejo'
Subject: RE: KE Silver Cassette

UPDATE:

I am sending two sets of standard cassette Zebra Shades in Silver color with matching silver components for your review and feedback.

Each set includes one shade with our current silver finish and one with the new proposed silver finish (from color sample "A") from KE.

Tracking numbers are:

NYC Samples: 5631 8147 0594

Dallas Samples: 5631 8147 0609

Please review and share your thoughts on this new silver finish.

Thank you,

Hugo A.



From: Hugo Amezcua <hamezcua@hemtack.com>

Sent: Monday, May 2, 2022 10:11 AM

To: 'theresa@phaseii.com' <theresa@phaseii.com>; "'陳M.'" <mkchang3@gmail.com>; 'leehunt666@gmail.com' <leehunt666@gmail.com>; 'Lisa Hernandez' <lhernandez@phaseii.com>; 'Marcos K. Chang' <marcos@phaseii.com>; 'amontejo@hemtack.com' <amontejo@hemtack.com>; 'Lulu Montejo' <lmontejo@hemtack.com>

Subject: RE: KE Silver Cassette

Good morning,

I've attached the Engineering Report regarding color match of the new SILVER paint chip samples from KE.

Overall we agree that color sample "A" is the closest match but we would like to test further to evaluate the convenience of this finish as an alternative to reduce the scratches and damage during transportation and handling.

Thank you,

Hugo A.

From: "陳M." <mkchang3@gmail.com>
Sent: Tuesday, April 12, 2022 4:01 PM
To: Hugo Antonio Amezcua <hamezcua@hemtack.com>
Subject: Fwd: KE Silver Cassette

Begin forwarded message:

From: <vicky@jpaxton.com.tw>
Subject: KE Silver Cassette
Date: April 12, 2022 at 5:59:18 AM EDT
To: "PII / Marcos Chang" <mkchang3@gmail.com>
Cc: "JP / Ariel Hsieh" <ariel@jpaxton.com.tw>, "JP / Ann Wang" <ann@jpaxton.com.tw>, "JP / Aidan Wang" <aidan@jpaxton.com.tw>, "JP / Barry Chen" <barry@jpaxton.com.tw>, "JP / Cindy Brandt" <cindy@jpaxton.com.tw>, "JP / Edward Hong" <edward@jpaxton.com.tw>

Marcos

KE provide Painting silver color swatches A B C for us. (Please refer to attachment)
We think the A color in attachment is closer to the existing anodized silver color.
Please confirm this Color swatches will be sent to NY for Lee or Hemtack for Hugo ?

Best Regards,
Vicky Tseng
J.Paxton Enterprises, Inc.
TEL : + 886 7 2829843 ext. 21
Fax : + 886 7 2829850
Email : vicky@jpaxton.com.tw

From: Edward hong <edward@jpaxton.com.tw>
Sent: Thursday, March 24, 2022 6:03 PM
Subject: 3-24-2022

3. KE Silver Cassette

KE will provide the painting silver for us.
But it can't be exactly same as the anodized silver color but just close.
And the painting color is glossy finish, anodized silver is matte finish.
KE will provide the color swatches by 4/15.



MPMI1355 Current color

SILVER (A)
2022/4/3

MPMI1360 Current Color

Hugo Amezquita

From: Hugo Amezquita <hamezquita@hemtack.com>
Sent: Monday, May 2, 2022 10:11 AM
To: 'theresa@phaseii.com'; "'陳M.'"; 'leehunt666@gmail.com'; 'Lisa Hernandez'; 'Marcos K. Chang'; 'amontejo@hemtack.com'; 'Lulu Montejo'
Subject: RE: KE Silver Cassette
Attachments: ENGREP_062_NEWSILVERCOLOR.pdf

Good morning,

I've attached the Engineering Report regarding color match of the new SILVER paint chip samples from KE. Overall we agree that color sample "A" is the closest match but we would like to test further to evaluate the convenience of this finish as an alternative to reduce the scratches and damage during transportation and handling.

Thank you,

Hugo A.

From: "陳M." <mkchang3@gmail.com>
Sent: Tuesday, April 12, 2022 4:01 PM
To: Hugo Antonio Amezquita <hamezquita@hemtack.com>
Subject: Fwd: KE Silver Cassette

Begin forwarded message:

From: <vicky@jpaxton.com.tw>
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MPMI1355 Current color

MPMI1360 Current Color

SILVER (A)
2022/4/1



ENGINEERING REPORT

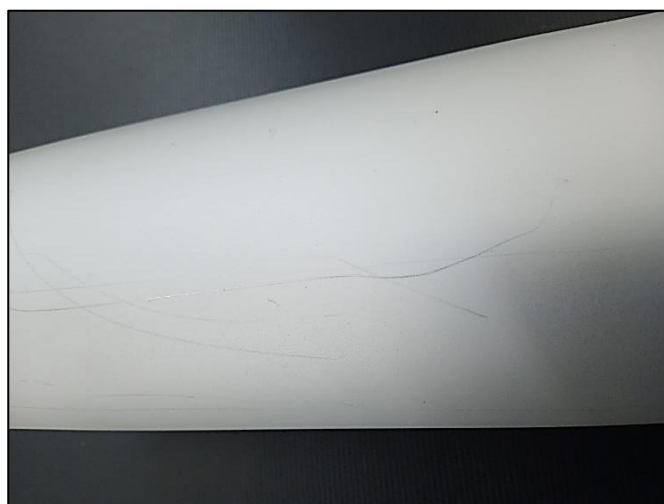
REPORT TITLE:	MPMI1355 ALUM ROLLER COVER ZEBRA SILVER NEW COLOR	REPORT DATE:	05/02/2022
REPORT NUMBER:	ENGREP062	CREATED BY:	Hugo Amezcuita
QA & ENGINEERING APPROVAL	CC:		
Hugo Amezcuita	Theresa Davidson, Lee Hunt, Marcos Chang, Miriam Calderon, Lisa Hernandez, Lourdes Montejo, Alejandro Gonzalez.		

1. Background:

A set of three silver color paint chips were sent for evaluation to select a new finish and color applicable to the following part numbers:

PART NUMBER	DESCRIPTION
MPMI1355	ALUM ROLLER COVER ZEBRA STD, SILVER 130 IN L
MPMI1334	ALUM BOTTOM RAIL V-SHAPED, SILVER 130 IN L
MPMI1350	ALUM ROLLER PIPE V SHAPED SILVER

The finish and color change are considered as an alternative to reduce the amount of scrap related to damaged pieces during transportation and material handling since the current finish and color is too delicate and prone to damage by scratches, stains and dents (picture 1 and 2).



Picture 1. "Scratches" damage by handling.



Picture 2. "Dents" or "Marks" damage by handling.

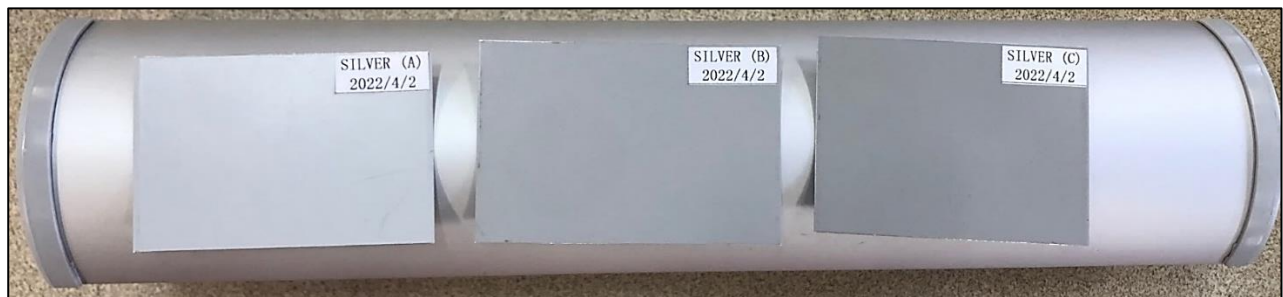
2. Analysis:

Color matching against Silver Standard Zebra Headrail (KE)

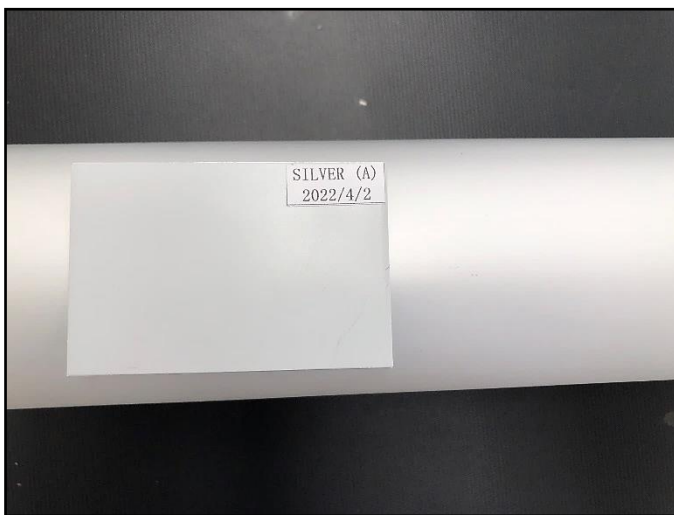
All three paint chip samples were checked for color matching against current silver standard zebra headrail from KE.



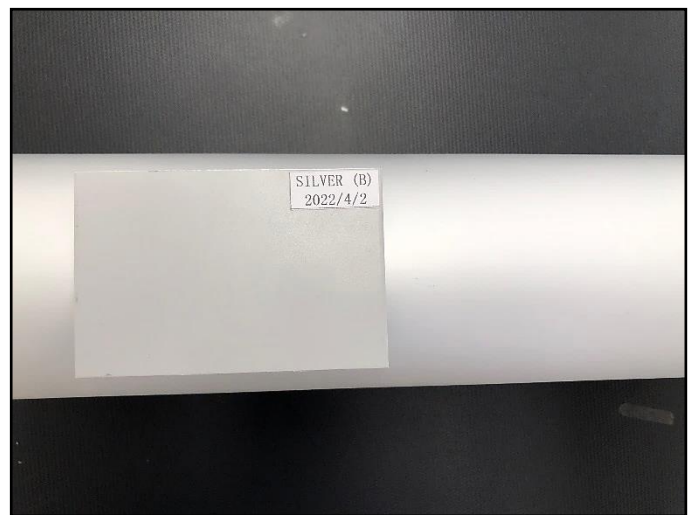
Picture 3. Paint chip "A", "B" and "C" under daylight.



Picture 4. Paint chip "A", "B" and "C" under cool light.



Picture 5. Close up of paint chip "A"



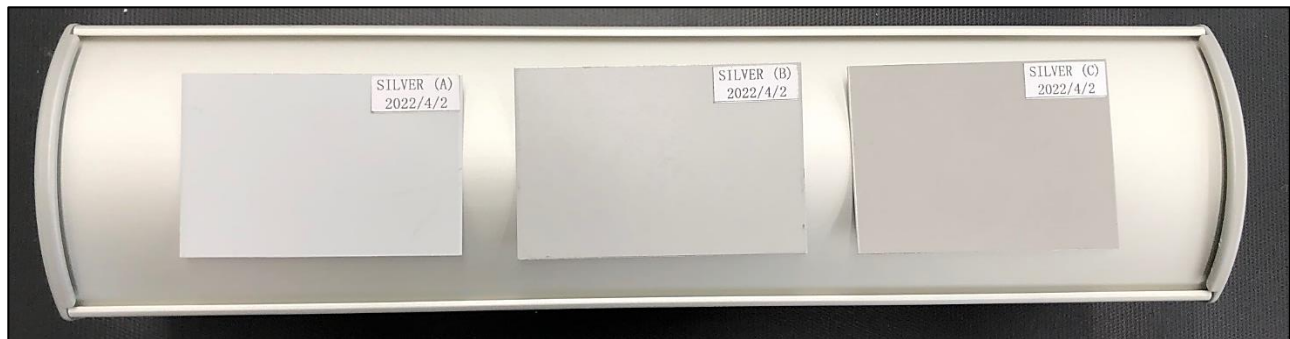
Picture 6. Close up of paint chip "B"



Picture 7. Close up of paint chip "C"

Color matching against Silver Cassette 100 headrail (ROLLEASE)

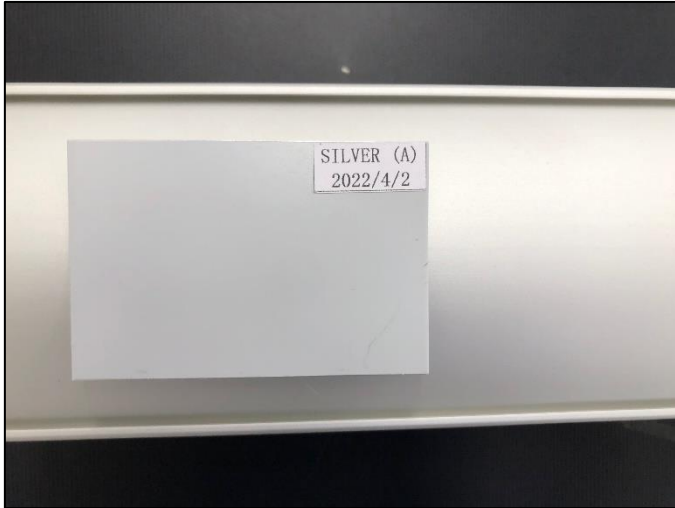
All three paint chip samples were checked for color matching against current silver Cassette 100 headrail from ROLLEASE.



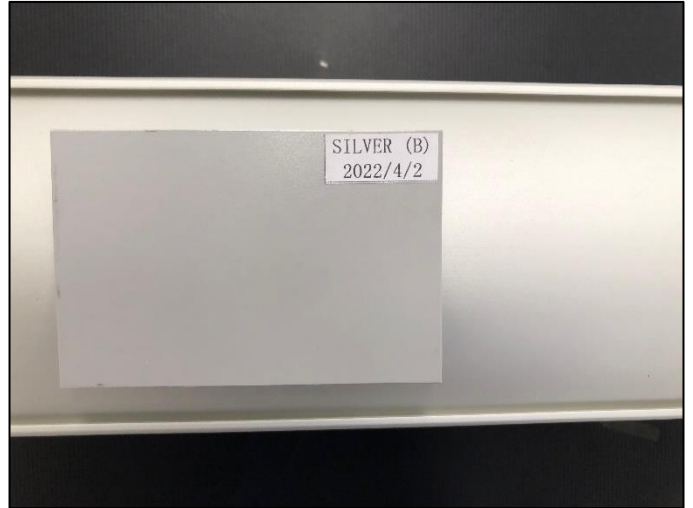
Picture 8. Paint chip "A", "B" and "C" under daylight.



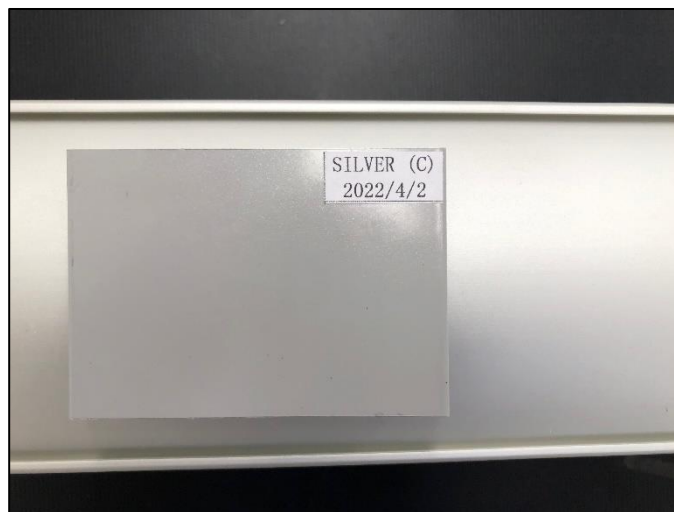
Picture 9. Paint chip "A", "B" and "C" under cool light.



Picture 10. Close up of paint chip "A"

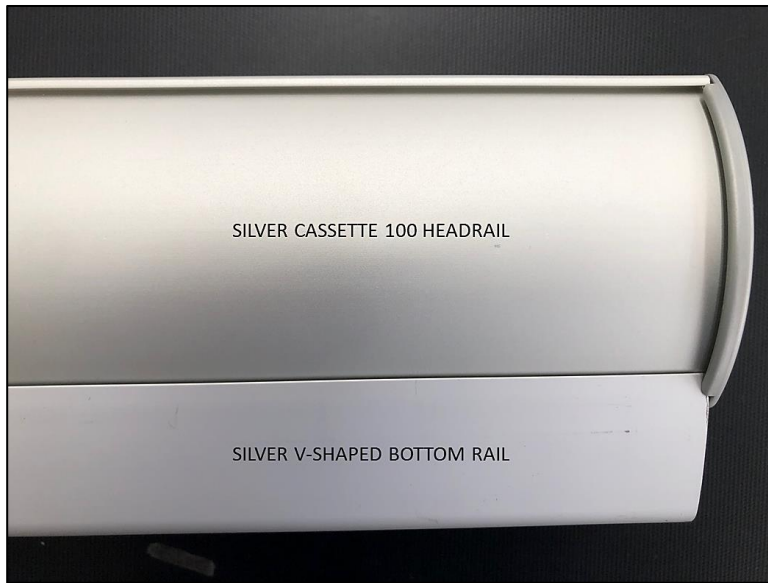


Picture 11. Close up of paint chip "B"



Picture 12. Close up of paint chip "C"

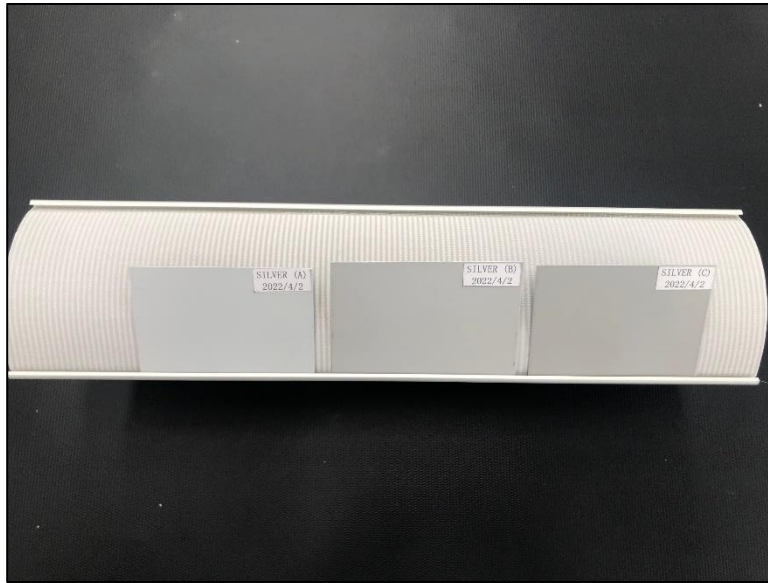
The current silver color for Silver V-Shaped bottom rail is also used in combination with the silver cassette 100 headrail from ROLLEASE. In this case, there is a noticeable difference in color (picture 13). This combination was approved prior to the V-Shaped bottom rail transition since the front face of this type of headrail is always wrapped in fabric for Zebra shade orders. For reference, please see picture 14 and 15.



Picture 13. Silver V-Shaped bottom rail and Silver Cassette 100 headrail comparison.



Picture 14. Silver V-Shaped bottom rail, Silver Cassette 100 headrail and paint color chip samples comparison.

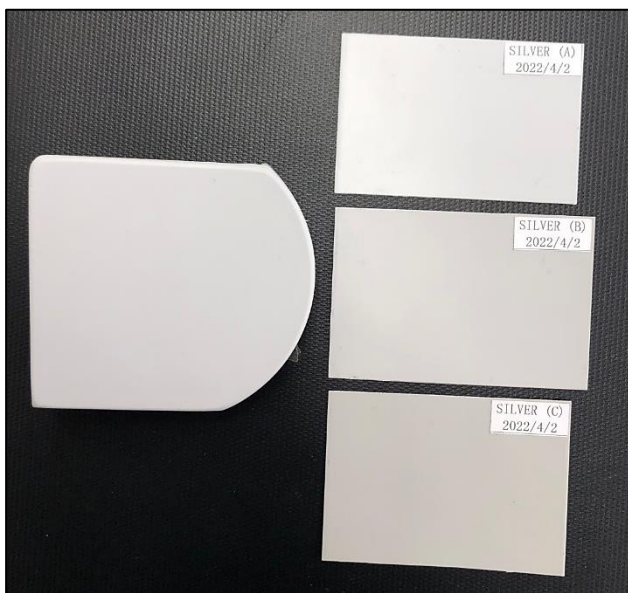


Picture 15. Silver V-Shaped bottom rail, Silver Cassette 100 headrail and paint color chip samples comparison.

Per the current finish and color difference between the components mentioned above, we determined that in this case we can work with the color and finish difference between paint chip sample “A” and current Cassette 100.

Color matching against headrail end caps

No significant issues regarding color compatibility between headrail end caps and paint chip sample “A”.



Picture 16. Paint chip samples “A”, “B” and “C” comparison against standard silver zebra headrail end cap.



Picture 17. Paint chip samples “A”, “B” and “C” comparison against cassette 100 silver headrail end cap.

3. Conclusion:

Per our review, we concluded that paint color chip sample "A" is the closest match to the current silver color for MPMI1355, MPMI1334 and MPMI1350. The sample provided is glossier since it does not have an "anodized" finish.

We also evaluated the resistance to scratches and stains. It does appear to be a more resistant finish and surface and it's also easier to clean. However, we cannot make a complete assessment with the small paint chip sample.

In order to perform further testing that will support our final decision, we strongly suggest that a set of samples with color and finish from paint chip sample "A" is sent to us as follows:

QTY	PART NUMBER	DESCRIPTION	LENGTH
2	MPMI1355	ALUM ROLLER COVER ZEBRA STD, SILVER 130 IN L	60"
2	MPMI1334	ALUM BOTTOM RAIL V-SHAPED, SILVER 130 IN L	60"
2	MPMI1350	ALUM ROLLER PIPE V SHAPED SILVER	60"

These samples will be submitted to our production process from cutting to packaging, before shipping the finished sample units for further review.