3k083C

Report 72268 - T ███ GETRAG

Change Request ☐	Change Order ☒	Initiator of Change		
Reason for Change		External:	Customer	☐
Part list creation & Drawings distribution.			Supplier	☐
		Internal:		☒

Reference	Issued by:	
German change order: 35928; E-mail of A. Gagliardi (09-12-2014).	*Team:*	B/WLQ1
	Name:	M. Di Pasquale
	Date:	Dec, 4th 2014

Description of Change

Screws with washer discs instead of a retainer plate to fix the hollow shaft ball bearing.

Distribution List	Drawings (DDA)[1]	Change Information		Drawings (DDA)[1]	Change Information
Issuer	☐	☒	B/WLQ1: *Central Quality*	☐	☒
B/ELE1: *Product Engineering*	☐	☒	B/WLQ3: *Customer Service*	☐	☒
B/ELE2/3: *Testing*	☐	☒	B/WLQ2: *Metallurgical Laboratory*	☐	☒
B/WLP: *ME*	☐	☒	B/GPS1: *Production line - Gears*	☐	☐
B/EX: *Program management*	☐	☒	B/GPS2: *Production line - Shafts*	☐	☐
B/BLF: *Finance & Controlling*	☐	☒	B/GPS3: *Housings (1)*	☒	☒
B/EEL: *Logistics*	☐	☒	B/GPS4: *Assembly line*	☐	☒
B/WLQ4: *SQA*	☐	☒		☐	☐
B/WLQ4: *Incoming Inspection*	☐	☒		☐	☐

Getrag Plants

DEU: *Untergruppenbach*	☐	☐	GEC: *Sterling Heights*	☐	☐
DEL: *Ludwigsburg*	☐	☐	GPG: *Charlestone*	☐	☐
DEN: *Neuenstein*	☐	☐	GFT: *Köln*	☐	☐
DER: *Rosenberg*	☐	☐	GFT: *Kechnec*	☐	☐
DEW: *Bad Windsheim*	☐	☐	GTC: *Detroit*	☐	☐
	☐	☐		☐	☐

Customers

C'HANGAN: *Chongqing (CN)*	☐	☐	FORD: *Detroit (US)*	☐	☐
CUMMINS: *Darlington (US)*	☐	☐	LAND ROVER: *Longbridge (UK)*	☐	☐
GME: *Rüsselsheim (DE)*	☐	☐	NAMG: *Longbridge (UK)*	☐	☐
GMB: *Saõ Paolo Brazil (BR)*	☐	☐	RENAULT: *Paris (FR)*	☐	☐
GM-NAO & SATURN: *Detroit (US)*	☐	☐	ROVER: *Longbridge (UK)*	☐	☐
FIAT: *Torino (IT)*	☐	☐		☐	☐
	☐	☐		☐	☐

Remarks BP ☐

(1) This department has to receive the drawings: 2500331322, 2500332110, 2500646201 and 2500666701.

1 Index

2 Info

35928:

- Change of the height of the bearing seat of 14,9±0,04 mm instead 14,75±0,08 mm to increase the robustness.
- 3 screws (900.9.0630.10) and the retainer plate (250.7.4177.01) will be replaced by a screw with added washer (900.9.0270.12).
- This change is only for the K9K application. Other RSA applications will be tracked with the CR35929 and CR35930.
- The following CRs have been implemented also:
  o CR36219: has been implemented. With this change the porosity overview 250.0.9515.00 was updated and described, that PK specifications are to be removed from the single part drawings, which are defined in the overview.
  o CR250/5388: The diameter of the oil drain chamfer is to get a <M> characteristic.
  o CR36123: Machining of the TR1 and TR2 holes where added back to the 3313 drawings as required for the new EU6 variants. Within the change no new chart drawings have been created so a tracking of the parts is not given as this change has an impact on interchangeability. This will be handled now within this change 35928.

E-mail of Gagliardi: requested creation of part list 9009065860KDFO (Spare Parts).

3 Material Master Modification

- In the material master **2500331322** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500331323** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500331332** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500332110** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500332111** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500332112** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500332113** "Clutch Housing" add the Italian part name "Scatola Frizione".

- In the material master **2500646201** "Clutch Housing Chart" add the Italian part name "Chart Scatola Frizione".

- In the material master **2500666701** "Clutch Housing Chart" add the Italian part name "Chart Scatola Frizione".

- In the material master **2500331222** "Clutch Housing Pre Asm" add the Italian part name "Scatola Frizione pre-assemblata".

- In the material master **2500332002** "Clutch Housing Pre Asm" add the Italian part name "Scatola Frizione pre-assemblata".

- In the material master **2500332003** "Clutch Housing Pre Asm" add the Italian part name "Scatola Frizione pre-assemblata".

4   Part List Creation

- Create new part list **2500646201** "Clutch Housing Chart" and **add**:

0010	2500331322	Clutch Housing	1	PZ	Z
0020	2500331323	Clutch Housing	1	PZ	Z
0030	2500331332	Clutch Housing	1	PZ	Z

- Create new part list **2500332110** "Clutch Housing" and **add**:

0010	2500332190	Clutch Housing Raw Part	1	PZ	L

- Create new part list **2500666701** "Clutch Housing Chart" and **add**:

set with attribute "W1"
0010	2500332110	Clutch Housing	1	PZ	X

set with attribute "W0"
0020	2500332111	Clutch Housing	1	PZ	X

set with attribute "W0"
0030	2500332112	Clutch Housing	1	PZ	X

set with attribute "W0"
0040	2500332113	Clutch Housing	1	PZ	X

- Copy part list 2500331220 "Clutch Housing Pre Asm" and rename it as **2500331222** "Clutch Housing Pre Asm".

In the part list **2500331222**:

0010	2500646200	Clutch Housing Chart	1	PZ	L
gets					
0010	2500646201	Clutch Housing Chart	1	PZ	L

delete

0200	2507417701	Holding Plate	1	PZ	L

0210	9009063010	External Six-Lobe Flange Bolt	3	PZ	L
gets					
0210	9009027012	Hexalob. Socket Pan Head Screw w. Washer	3	PZ	L

- Copy part list 2500332000 "Clutch Housing Pre Asm" and rename it as **2500332002** "Clutch Housing Pre Asm".

In the part list **2500332002**:

0010	2500666700	Clutch Housing Chart	1	PZ	L
gets					
0010	2500666701	Clutch Housing Chart	1	PZ	L

delete

0200	2507417701	Holding Plate	1	PZ	L

0210	9009063010	External Six-Lobe Flange Bolt	3	PZ	L
gets					
0210	9009027012	Hexalob. Socket Pan Head Screw w. Washer	3	PZ	L

- Copy part list 2500332001 "Clutch Housing Pre Asm" and rename it as **2500332003** "Clutch Housing Pre Asm".

In the part list **2500332003**:

0010	2500666700	Clutch Housing Chart	1	PZ	L
gets					
0010	2500666701	Clutch Housing Chart	1	PZ	L

delete

0200	2507417701	Holding Plate	1	PZ	L

0210	9009063010	External Six-Lobe Flange Bolt	3	PZ	L
gets					
0210	9009027012	Hexalob. Socket Pan Head Screw w. Washer	3	PZ	L

5   Spare parts

-    Create new part list **9009065860KDFO** "Rotary Shaft Seal" and **add**:

0010   9009065860   Rotary Shaft Seal   ·   1   PZ   L

- The evaluation of impact on RSA Spare Parts will be done later with the implementation Report of the Clutch Housing Pre Asm into the serial TM´s.

6   Drawing Distribution

-    2500331322   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500331323   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500331332   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500332110   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500332111   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500332112   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500332113   Clutch housing (1-5)   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500646201   Clutch housing Chart   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500666701   Clutch housing Chart   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500331222   Clutch Housing Pre Asm   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500332002   Clutch Housing Pre Asm   AE " - " from 28.11.2014
     (Maturity level of specification F approved)
-    2500332003   Clutch Housing Pre Asm   AE " - " from 28.11.2014
     (Maturity level of specification F approved)

7   Instructions

• **The modification must be followed from all affected departments.**
• **Possible IMDS Impact to be evaluated by B/WLQ3.**
• **#MTC891#: THE CHANGE IS READY TO BE IMPLEMENTED. THE CHAMPION HAS TO MAKE SURE THAT ALL CHECK LIST ACTIVITIES ARE COMPLETE BEFORE KICKING OFF THE MODIFICATION. BREAK POINT MUST BE COMMUNICATED TO ELE1.**