Effects	S	C	Failure mode	Cause	Preventive action	O	Detection action	D	RPN	R/D

GETRAG

GETRAG S.p.A.

POWERSHIFT

FMEA

Process

Number: 1.1.4

Page: 3 of 91

Type/Model/Fabrication/Lot:	Item code:	Responsible:	Created:
250 RENAULT K9K - K9Kx98 Clutch Housing	2500331320 - 2500331330 - 2500332100 - 2500332110 Revision state:	B/GPS3 Company: GETRAG	10/06/2009
FMEA/system element:	Item code: Revision state:	Responsible: D.Pi[redacted] G.Ci[redacted] N Lo[redacted] Com[redacted] GET[redacted]	Created: 10/06/2009 18/03/2015

Effects	S	C	Failure mode	Cause	Preventive action
System element: Automatic load / unload (KG/GG)					
Function: Felsomat loading operation (GG/KG)					
F1 Assembly area nicks Agg da noi			F Housing damaged	F? The piece fall down in manual loading phase	Initial state: 10/06/2009
> F1 Scrap to assembly leak test Agg da noi					Specific work istruction
> F1 intermittent assembling process					
>> F1 customer satisfaction	6				
> F1 Assembly scrap Agg da noi					
> F1 intermittent assembling process					
>> F1 customer satisfaction	6				
F1 Structural area niks Agg da noi					
> F1 break housing	8				

[redacted]

Annotazione

Categorie: [redacted]

Annotazione (English):

Normale

30/09/2011 8-D-Report-No 100000010839 of 21.12.2010 TM serial:LFJ0790.

Problem description: Place of Defect clutch, Kind of Defect engage problems.

Implemented Permanent Corrective Action(s) : Corrective Action, Control plan updated about for clean and not chips.

23/04/12 Aggiornata voce Wrong tool setup / Wrong pre-setting tool parameters / Wrong pre-setting machine parameters / Tool balancing NOK sulla base di un reclamo FORD dello stesso periodo.

14/08/12 Eliminazione del T2 indice (-) 2500331320 CR250/5007.

31/10/12 3313 Update index (a) CR35591 RR1 - RR2 suspended and change part number from 2500331312 to 2500331320. RR1 - RR2 deleted to PFMEA.

25/01/13 3313 Update index (b) CR250/5390 HP1 - HP2 standardization with code 2500332100. No change needed.

11/04/13 3321 new variant included in PFMEA.

24/05/13 3321 Update index (b) CR250/5454 Conc CA13 - CA23, no change needed.

01/08/13 3321 Update index (d) CR35981 W5 deleted, no change needed.

17/01/14 3313 Update index (c) CR35901 Machining deletion of hole W5, Dimension 78.432 and angle 41.766° deleted, Add group number note. No change needed.

13/03/14 3313 Update index (d) CR36125 Note and chamfer specificatrion added, no change needed.

16/04/14 2500331330 Introduzione del nuovo fornitore Grupe Arché.

20/05/14 3321 Update index (e) CR35899 Note added, CAD-DASET 2014-05-13 was 2012-06-18, no change needed. Aggiunto Ø smusso tappo olio <M>. Thread M =|Ø0.4|G|D|M-K deleted, no change needed.

11/03/15 Added vers. 2500332110 to produce a PTR Lot.

Effects	S	C	Failure mode	Cause	Preventive action	O	Detection action	D	RPN	R/O

GETRAG

GETRAG S.p.A.

POWERSHIFT

FMEA

Number: 1.1.4

Type/Model/Fabrication/Lot:
250 RENAULT K9K - K9Kx98 Clutch Housing

Item code:
25006462xx - 25006667xx

Revision state:

10/06/2009

FMEA/system element:
Summary (KG)

Item code:

Revision state:

10/06/2009
21/11/2017

Effects	S	C	Failure mode	Cause
System element: Automatic load / unload (KG/GG)				
Function: Felsomat loading operation (GG/KG)				
Assembly area nicks Agg da noi			Housing damaged	The piece fall down in manual loading phase
> Scrap to assembly leak test Agg da noi				
> intermittent assembling process				
>> customer satisfaction	6			
> Assembly scrap Agg da noi				
> intermittent assembling process				
>> customer satisfaction	6			
Structural area nks				

S3 in base ad esperienze processo simile

Annotazione

Categorie:

Annotazione (English):

Normale

03/06/15 Added vers. 2500331322 to produce a PTR Lot and SOP.

08/09/15 Added Chart 25006667xx, included for CH 25003321xx two suppliers DGH and FVM

13/01/16 3321.13 part of Chart 25006667xx, update index (b) Report T-72374 Note added, CAD-DASET 2015-12-17 was 2015-03-03, no change needed.

22/02/2016 3321.13 and 3313.30 update index (c) Rerport T-72386, Porosity Spec drawing 2500951501 was 2500951500, no changes needed.

07/03/2016 3321.10 Index (a) and 3313.22 index (a) updated Report T-72360 Note added, CAD-DASET 2016-02-26 was 2012-04-25, Porosity Spec drawing 2500951501 was 2500951500, no changes needed.

11/03/16 Followed the acrivity of revision and update of the Control Plan, the team decided to leave in the PFMEA and control plan only the <M> Ø Chamfer OD and 6 <C> Characteristic, all officially in the drawing.

21/03/16 Ø D72 >Intrernal Assembly Line claim, Pipe Guide not assemblable.

01/07/16 Daewngreding on charcteristics <M> to <Std> in according with GCG_803001 page 6 subtitle "2.7 Finalised Characteristics": "Any "Major Characteristic" not confirmed as "Major" as well as all remaining characteristics which are not Critical or Major are classified as "Standard"/"Minor"".

04/07/16 Update with note: Characteristic <C> on drawing, all effects on the vehicle and measure are attributed to PFMEA assembly in accordind to Norm CGC_803001 Alternative 5.

02/11/17 3321.10 Index (c) updated Report T-72530 Adaptation of all clutch housings, the angle LH1 / LH2 (16.5 ° and 45 °) to the drawing 3313, no changes needed.

02/11/17 3321.10 Index (d) updated Report T-72554 CAD DATA SET 2017-07-04 WAS 2017-02-23, no changes needed.

OK