GETRAG

Production Part Approval
DIMENSIONAL TEST RESULTS

309266

Organization:	GETRAG	Part Number:	250.0.3313.22
Supplier/Vendor Code:	GETRAG Modugno	Part Name:	CLUTCH HOUSING
INSPECTION FACILITY: NA		Design Record Change Level:	Index "-"
		Engineering Change Documents:	

						Organization Measurement Results (Data)					Ok	Not Ok
Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	1	2	3				
1	Altezza foro D Ø62	14.940	14.860		3	14.894	14.883	14.897			ok	

March 2006 CFG-1003

SIGNATURE	TITLE
P.Lucchese	QPE

GETRAG

Production Part Approval

DIMENSIONAL TEST RESULTS

Organization:	GETRAG	Part Number:	250.0.3313.20
Supplier/Vendor Code:	GETRAG Modugno	Part Name:	CLUTCH HOUSING
INSPECTION FACILITY: NA		Design Record Change Level:	Final Index 'e'
		Engineering Change Documents:	

Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	Organization Measurement Results (Data) PSW1	PSW2	PSW3			Ok	Not Ok
1	Thread TR1 position	0	0.4		3	0.058	0.067	0.067	-	-	ok	
2	Thread TR2 position	0	0.4		3	0.116	0.120	0.120	-	-	ok	
3	Flange TR1 height	142.900	143.100		3	142.900	142.903	142.907	-	-	ok	
4	Flange TR2 height	154.160	154.360		3	154.313	154.310	154.317	-	-	ok	
5	Threads check with Gage Go/Ngo	OK	NOK		3	OK	OK	OK	-	-	ok	

SIGNATURE	TITLE
P.Lucchese	QPE

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DIMENSIONAL TEST RESULTS

Organization:	GETRAG	Part Number:	250.0.3313.20
Supplier/Vendor Code:	GETRAG Modugno	Part Name:	CLUTCH HOUSING
INSPECTION FACILITY:		Design Record Change Level:	Final Index 'c'
NA		Engineering Change Documents:	

Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	Organization Measurement Results (Data) PSW1	PSW2	PSW3			Ok	Not Ok
1	Roughness PT2 Rz	0	16		3	15.891	15.887	15.884	-	-	ok	
2	Champfer Hole V	1.1	1.9		3	OK	OK	OK	-	-	ok	

SIGNATURE	TITLE
P.Lucchese	QPE

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DIMENSIONAL TEST RESULTS

Organization:	GETRAG	Part Number:	250.0.3313.20
Supplier/Vendor Code:	GETRAG Modugno	Part Name:	CLUTCH HOUSING
INSPECTION FACILITY:		Design Record Change Level:	Final Index 'b'
NA		Engineering Change Documents:	

Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	Organization Measurement Results (Data)					Ok	Not Ok
						PSW1	PSW2	PSW3				
1	Thread deep min 25	-	25.000		3	25.200	25.300	25.200	-	-	ok	
2	Distance flange HP1 - HP2 to flange G	129.600	130.000		3	129.810	129.816	129.813	-	-	ok	

March 2006 CFG-1003

SIGNATURE	TITLE
P.Lucchese	QPE

Pz. 1

PROTOCOLLO DI MISURA ZEISS UMESS

Scatola Frizione | CICLO CNC

DISEGNO No.	Indice	PROV.MAC	ZEISS	TIPO MISURA
K_TR_313___FASE1	h	Bz -	Cx ZEISS 1	TEST

OPERATORE	DATA	NUMERO PART.	PROGRAMMA	PALETTE	TIME
Partipilo	10. 6.2015	TEST D2Y			15:46: 9

TEMP. PEZZO 25.94

IND	NOMI / IDF	SY	VAL ATT	VAL NOM	TOL.S	TOL.I	DEV	MAG
	#FL_D2___Y	Y	14.894	14.900	0.040	-0.040	-0.006	-

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PROTOCOLLO STAMPATO DA NEW-GSSTAT IL 10/06/15 15.58.32
****

Pz. 6^a

PROTOCOLLO DI MISURA ZEISS UMESS

Scatola Frizione | CICLO CNC

DISEGNO No.	Indice	PROV.MAC	ZEISS	TIPO MISURA
K_TR_313___FASE1	h	Bz -	Cx ZEISS 1	TEST

OPERATORE	DATA	NUMERO PART.	PROGRAMMA	PALETTE	TIME
Partipilo	10. 6.2015	PZ2 TEST D2Y			15:52:35

TEMP. PEZZO 25.69

IND	NOMI / IDF	SY	VAL ATT	VAL NOM	TOL.S	TOL.I	DEV	MAG
	#FL_D2___Y	Y	14.883	14.900	0.040	-0.040	-0.017	--

****
PROTOCOLLO STAMPATO DA NEW-GSSTAT IL 10/06/15 16.00.04
****

Pz. 3 e 4

PROTOCOLLO DI MISURA ZEISS UMESS

Scatola Frizione			CICLO CNC			
DISEGNO No. K_TR_313___FASE1	Indice h	PROV.MAC Bz -	ZEISS Cx ZEISS 1	TIPO MISURA TEST		
OPERATORE Partipilo	DATA 10. 6.2015	NUMERO PART. PZ3 TEST D2Y	PROGRAMMA	PALETTE	TIME 16: 1:14	

TEMP. PEZZO 25.68

IND	NOMI / IDF	SY	VAL ATT	VAL NOM	TOL.S	TOL.I	DEV	MAG
	#FL_D2___Y	Y	14.897	14.900	0.040	-0.040	-0.003	-

PROTOCOLLO STAMPATO DA NEW-GSSTAT IL 10/06/15 16.08.15

PROTOCOLLO DI MISURA ZEISS UMESS

Scatola Frizione				CICLO CNC		
DISEGNO No.	Indice	PROV.MAC	ZEISS		TIPO MISURA	
K_TR_313___FASE2	h	Bz361-538	Cx ZEISS 1		PRIMO PEZZO	
OPERATORE	DATA	NUMERO PART.	PROGRAMMA		PALETTE	TIME
Santorsola	20. 3.2015	1			M 1	17:35: 4

TEMP. PEZZO 21.94

IND	NOMI / IDF	SY	VAL ATT	VAL NOM	TOL.S	TOL.I	DEV	MAG
	#GW_TR1__X	X	-247.715	-247.694	0.200	-0.200	-0.021	-
	#GW_TR1__Y	Y	16.020	16.000	0.200	-0.200	0.020	+
	#GW_TR1__P	td	0.058	0.400				+
	#FL_TR1__Z	Z	-142.900	143.000	0.100	-0.100	-0.100	----
	#GW_TR2__X	X	-147.752	-147.694	0.200	-0.200	-0.058	--
	#GW_TR2__Y	Y	15.994	16.000	0.200	-0.200	-0.006	-
	#GW_TR2__P	td	0.116	0.400				++
	#FL_TR2__Z	Z	-154.313	154.260	0.100	-0.100	0.053	+++

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PROTOCOLLO STAMPATO DA NEW-GSSTAT IL 23/03/2015 12:00:53
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PROTOCOLLO DI MISURA ZEISS UMESS

Scatola Frizione | CICLO CNC

DISEGNO No.	Indice	PROV.MAC	ZEISS	TIPO MISURA
K_TR_313___FASE2	h	Bz361-538	Cx ZEISS 1	PRIMO PEZZO

OPERATORE	DATA	NUMERO PART.	PROGRAMMA	PALETTE	TIME
Santorsola	20. 3.2015	2		M 1	17:45:35

TEMP. PEZZO - 21.94

IND	NOMI / IDF	SY	VAL ATT	VAL NOM	TOL.S	TOL.I	DEV	MAG
	#GW_TR1__X	X	-247.707	-247.694	0.200	-0.200	-0.013	-
	#GW_TR1__Y	Y	16.013	16.000	0.200	-0.200	0.013	+
	#GW_TR1__P	td	0.067	0.400				+
	#FL_TR1__Z	Z	-142.903	143.000	0.100	-0.100	-0.097	----
	#GW_TR2__X	X	-147.747	-147.694	0.200	-0.200	-0.053	-
	#GW_TR2__Y	Y	15.987	16.000	0.200	-0.200	-0.013	-
	#GW_TR2__P	td	0.120	0.400				++
	#FL_TR2__Z	Z	-154.310	154.260	0.100	-0.100	0.050	++

****
PROTOCOLLO STAMPATO DA NEW-GSSTAT IL 23/03/2015 12:02:45
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PROTOCOLLO DI MISURA ZEISS UMESS

Scatola Frizione				CICLO CNC	
DISEGNO No.	Indice	PROV.MAC	ZEISS	TIPO MISURA	
K_TR_313___FASE2	h	Bz361-538	Cx ZEISS 1	PRIMO PEZZO	

OPERATORE	DATA	NUMERO PART.	PROGRAMMA	PALETTE	TIME
Santorsola	20. 3.2015	3			17:53:14

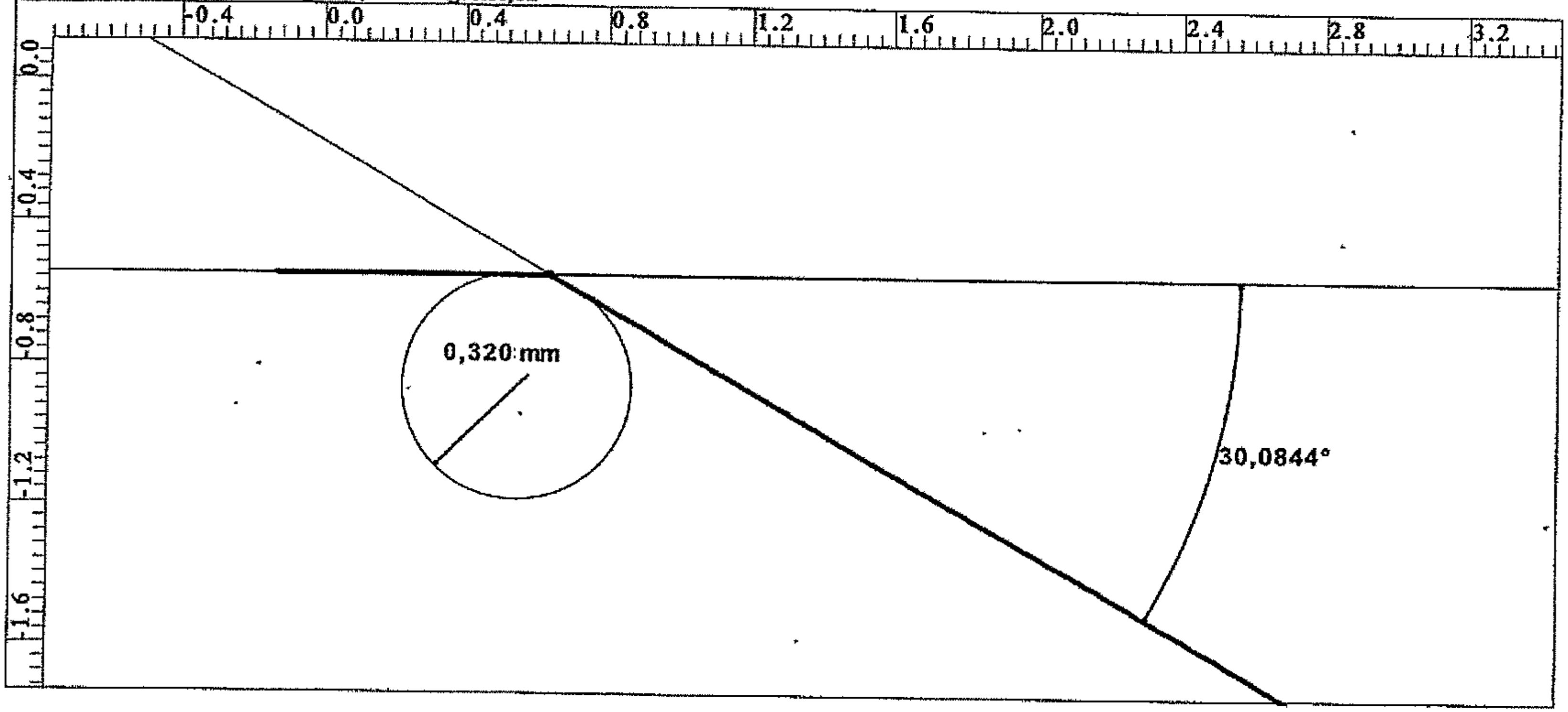
TEMP. PEZZO 22.91

IND	NOMI / IDF	SY	VAL ATT	VAL NOM	TOL.S	TOL.I	DEV	MAG
	#GW_TR1__X	X	-247.707	-247.694	0.200	-0.200	-0.013	-
	#GW_TR1__Y	Y	16.027	16.000	0.200	-0.200	0.027	+
	#GW_TR1__P	td	0.067	0.400				+
	#FL_TR1__Z	Z	-142.907	143.000	0.100	-0.100	-0.093	----
	#GW_TR2__X	X	-147.747	-147.694	0.200	-0.200	-0.053	-
	#GW_TR2__Y	Y	16.000	16.000	0.200	-0.200	0.000	+-
	#GW_TR2__P	td	0.120	0.400				++
	#FL_TR2__Z	Z	-154.317	154.260	0.100	-0.100	0.057	+++

PROTOCOLLO STAMPATO DA NEW-GSSTAT IL 23/03/2015 12:12:01

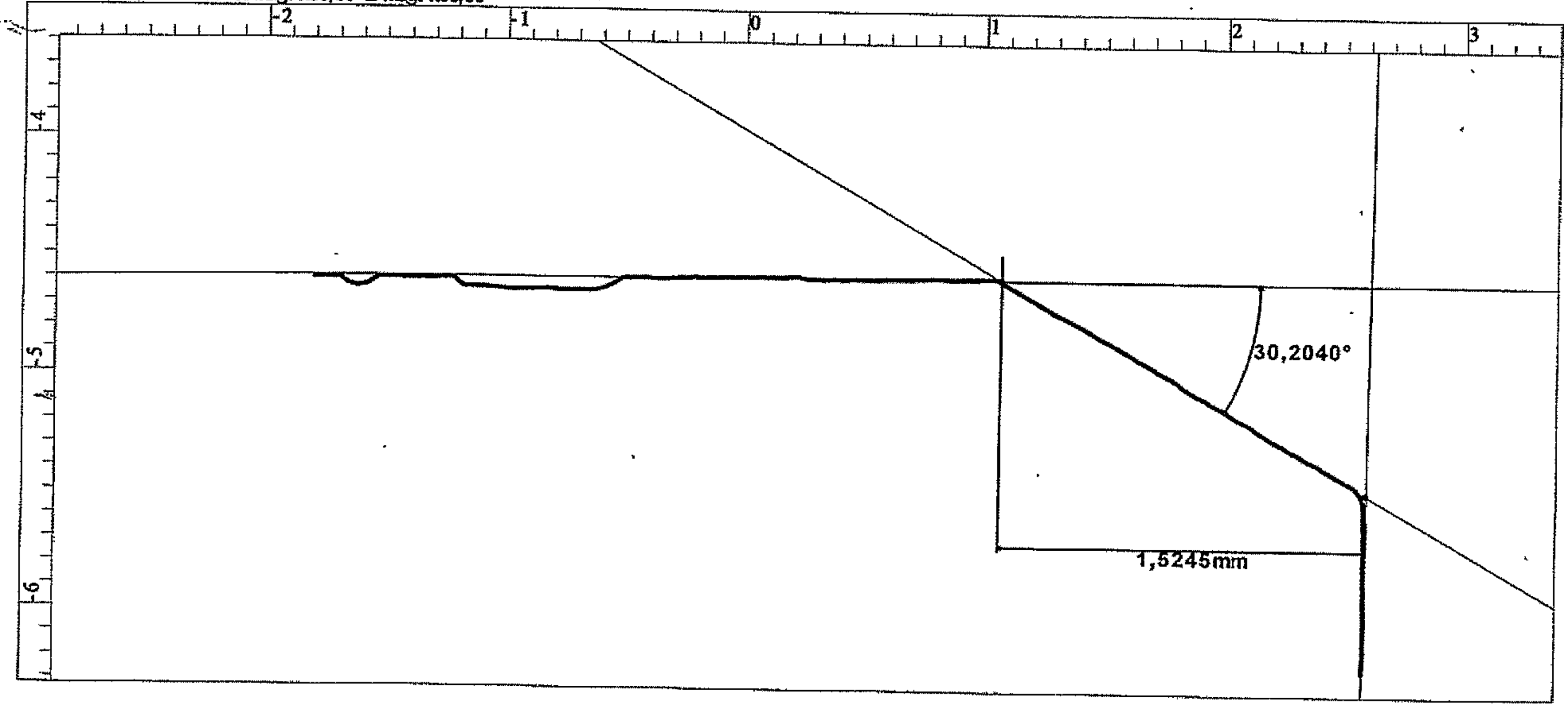
ANGOLO SMUSSO FORO F
VERIFICA STATO 16/01/14

Meas Result Geo Data   X Mag: x50,32 Z Mag: x50,32



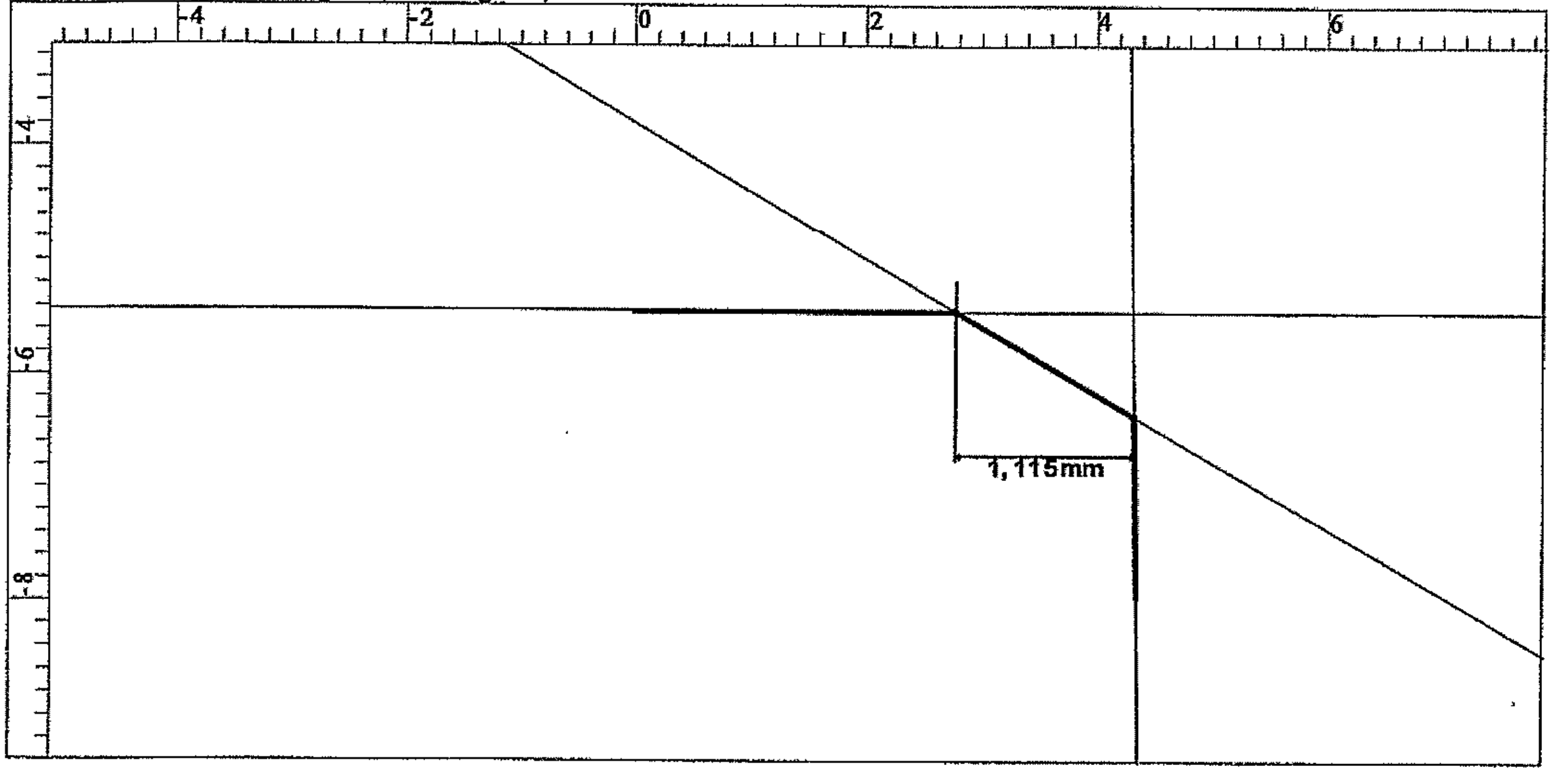
ANGOLO SMUSSO FORO V
VERIFICA STATO
16/01/14

Meas Result Geo Data X Mag: x38,66 Z Mag: x38,66



SMUSSO GTS
VERIFICA STATO
15 / 01 / 2014

Meas Result Geo Data   X Mag: x14,99 Z Mag: x14,99



SMUSSO CA15
VERIFICA STATO
15 / 01 / 2014

Meas Result Geo Data   X Mag: x14,97 Z Mag: x14,97