

312660

**Process Capability Study Plan**  
DCT Shafts

Part -Nr.: 250.6.4307.35      Supplier: ■■■ GETRAG      Creation Date: 16.09.2014  
 Part Name: Output Shaft 1      Supplier Plant Name: BARI      Revision Date: 14.11.2014

SCIF #	Identification of Characteristics	Specified Tolerance	C <sub>m</sub> /C <sub>mk</sub> ≥ 1,67	Study #	Scheduled date	P <sub>pk</sub> ≥ 1,67	Study #	Scheduled date	Measurement equipment	Results / Comments
1	Measurement over Balls Profil I	Max. 61,153 Min. 61,087	2.45			2.03			TEST BENCH	
2	Measurement over Balls Profil II	Max. 42,148 Min. 42,088	6.82			4.22			TEST BENCH	
3	Measurement over Balls Profil III	Max. 46,231 Min. 46,167	6.12			5.12			TEST BENCH	
4	Length 164,05	+0,025 -0,025	2.21			1.90			EXAMECA	
5	Length 22,26	+0,025 -0,025	4.01			3.88			EXAMECA	
6	Length 226,09	+0,300 -0,300	2.23			1.68			EXAMECA	
7	Length 17,35	+0,300 -0,300	2.49			2.20			EXAMECA	
8	Diameter 35,50	+0,028 +0,012	1.68			1.67			EXAMECA	
9	Diameter 35,50	h6	2.01			1.77			EXAMECA	
10	Diameter 37,00	h6	2.41			1.73			EXAMECA	
11	Diameter 25,00	m6	2.48			2.12			EXAMECA	
12	Diameter 40,00	h6	2.62			2.40			EXAMECA	
13	Diameter 40,00	h6	3.30			2.37			EXAMECA	
14										
15										

