

310757

SUPPLIER CHANGE / DEVIATION REQUEST
Änderungs- / Bauabweichungsantrag

Change / Deviation No. 68511
Änderungs- / Bauabweichungsnummer
Issue Date: 01-March-2012
Ausgestellt am:
STATUS
02-March-2012
Not approved

Supplier and part / product information	SUPPLIER NAME Getrag S.p.A. GPS3 Housings	
	MANUFACTURING SITE CODE	
	PART NAME AND PART NUMBER OF ASSEMBLY AND ITS COMPONENTS Clutch housing 250.0.3548.00	
	AFFECTED GETRAG PRODUCTS or PROGRAMS Ford C-Car	
Change Type	Manufacturing Process Change <input type="checkbox"/> Heat Treat affected? <input type="checkbox"/> Special Characteristics affected? <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	
	Product Design Change: Supplier-initiated design change <input type="checkbox"/>	Material Changed? <input type="checkbox"/>
	DEVIATION Request to ship non-conforming parts to GETRAG <input checked="" type="checkbox"/>	Quantity: Open to October 2012
	Site/location change: INDICATE TYPE OF SITE/LOCATION CHANGE	New Site: Name, Location, Code
	<input type="checkbox"/> SITE CHANGE OF TIER 1 OR OF GETRAG-DIRECTED SUB SUPPLIER <input type="checkbox"/> SITE CHANGE OF SHIP POINT <input type="checkbox"/> SITE CHANGE OF NON GETRAG-DIRECTED SUB SUPPLIERS	
	SUB-SUPPLIER or GETRAG-DIRECTED SUB SUPPLIER Change Request? <input type="checkbox"/> YES <input type="checkbox"/> NO	
	DESCRIPTION OF CHANGE / DEVIATION:	
	(VALID TO 5 PCS SAMPLE MASTER) POSITION BORES G8 (SHEET 5 K/11) 0,8 IS MAX 1,072 (S) DIAMETER BORES G8 (SHEET 5 K/11) 11 +0.5 IS MAX 11.880 (S) DIAMETER BORES CB1-CB2 (SHEET 4 K/7) 9 +0.3 IS MIN 8.990 (O) SLOT WITH BORE D 72.1 (SHEET 5 J/4) 10 +/- 0.1 IS MAX 10.200 (O) POSITION SLOT BORE D 72.1 (SHEET 5 J/4) 0.1 IS 0.16 (O) ROUGHNESS BORE F 55H8 (SHEET 2 H/3) 10/16 IS MIN 7.885 (O) CONCENTRICITY BORE CA2_D3 (SHEET 4 K/9) 0.1 IS MAX 0.135 (O) PARALLELISM OF FLANGE D1 (SHEET 2 J/7) 0.03 IS MAX 0.06 (O)	
	(VALID TO 40 PCS CAPABILITY PRODUCTION) POSITION BORES G8 (SHEET 5 K/11) 0,8 IS MAX 0,91 (S) DIAMETER BORES G8 (SHEET 5 K/11) 11 +0.5 IS MAX 11.880 (S) ROUGHNESS BORE F 55H8 (SHEET 2 H/3) 10/16 IS MIN 7.885 (O) CONCENTRICITY BORE CA2_D3 (SHEET 4 K/9) 0.1 IS MAX 0.135 (O) PARALLELISM OF FLANGE D1 (SHEET 2 J/7) 0.03 IS MAX 0.06 (O) FLANGE F PARALLELISM (SHEET 2 H/3) 0.030 IS 0.037 (O)	
	AFFECTED GETRAG PLANT(S) BARI	
PS: SEE ACTION PLAN ATTACHED		
PURPOSE OF CHANGE: APPROVE OF FIRST BATCH PRODUCT, NECESSARY TO START QUICKLY (05/03/2012) WITH FORD PRODUCTION.		
CORRECTIVE ACTIONS: (S) SUPPLIER ACTIONS – FOLLOWED BY GETRAG STA. (O) SETUP AND FINE TUNING. ACTION PLAN TO ISSUE BY PLANNER L.LANDRISCINA.		

GCG_F11_2209_00 2008-01

 Owner / Originator:
 V. Boerkewitz
 Department:
 Q&EM, Cologne

 Date Issued:
 21.05.2007
 Date Revised:
 03.01.2008

 Security Class:
 Proprietary
 Reference:
 GCG_025001

 Retention:
 28.03/12

SUPPLIER CHANGE / DEVIATION REQUEST

Anderungs- / Bauabweichungsantrag



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Supplier: Complete the following Change Implementation Plan

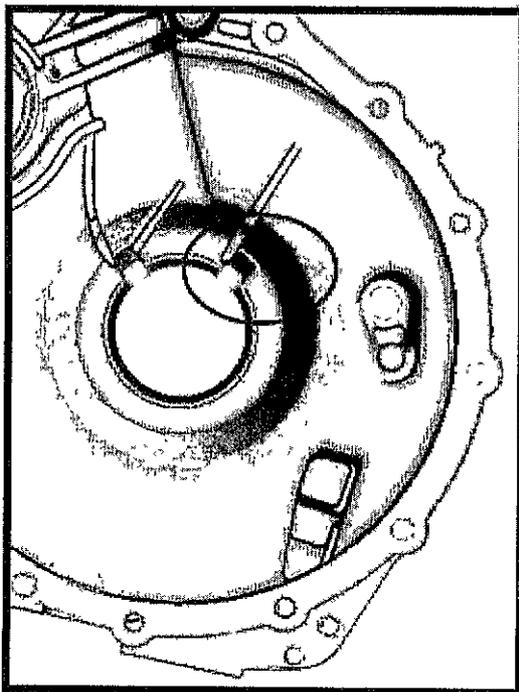
	YES/NO	Required Date	Responsible	Comments
Change Implementation Plan, applicable to all changes, directed by GETRAG STA / PD Engineering	Supplier Layout/Detail/Assy. Drawings	NO		
	Component tolerance stack-up	NO		
	Supplier engineering specification	NO		
	Material Specification incl. IMDS update	NO		
	Supplier Design FMEA	NO		
	Supplier DV Test(s)	NO		
	Supplier Software update (incl. interface)	NO		
	Process Flow Chart	NO		
	Supplier Process FMEA	NO		
	Control Plan	NO		
	Process Information/Operator Instructions	NO		
	Process and/or Gauge Capability	NO		
	Sub-Supplier Effect	NO		
	Logistics: Packaging / Shipping	NO		
	Tooling revisions/movement	NO		
	Facility changes	NO		
	PPAP Submission Level	3		
Functional Check at GETRAG Plant	NO			

All items listed above must be reviewed when developing the change implementation plan. I affirm that the above and any attached information fully describe the proposed change. No changes will be implemented without GETRAG Approval.

Name: Bianca Zilligen	Title QS	Phone +497151/93299-152	e-mail
Signature	Proposed Implementation date of the change:		Tier 1 approval of sub tier change request

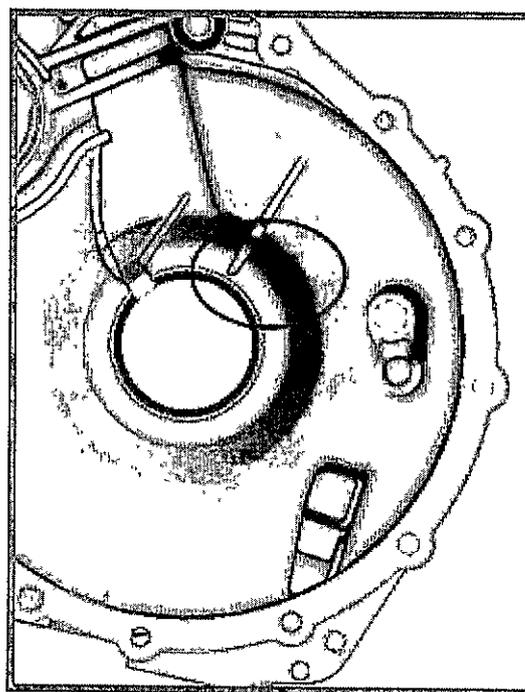
250.0.3548.00

Wrong first off tool parts. Please make sour to destroy all this parts.



250.0.3548.00

Correct current design with closed oil groove



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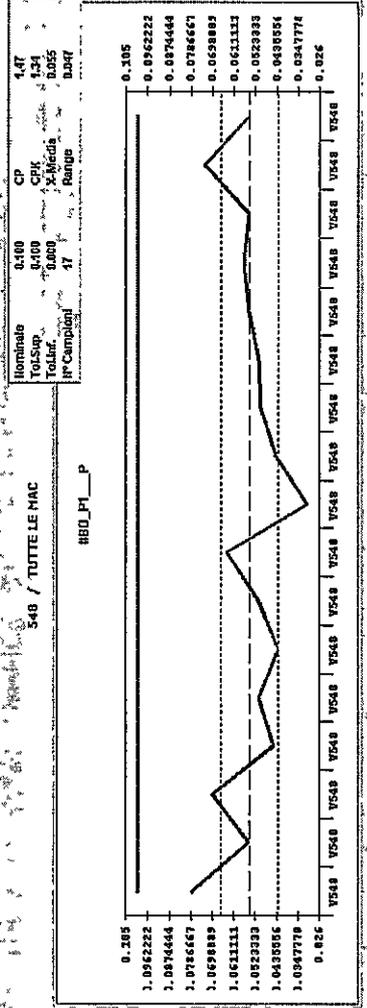
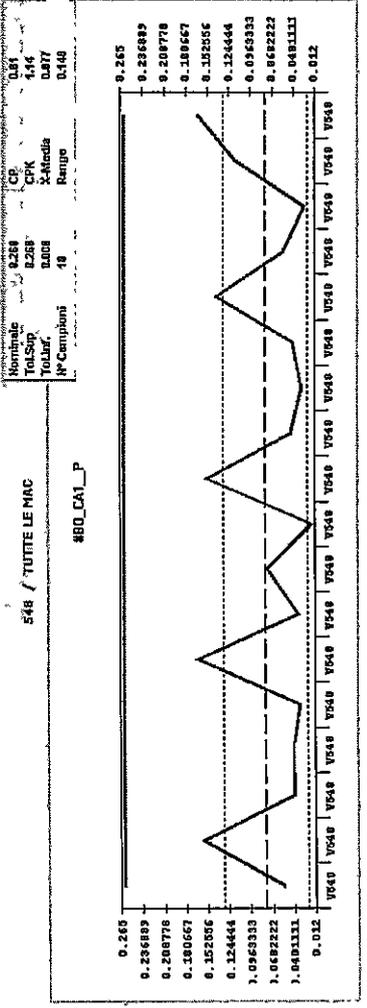
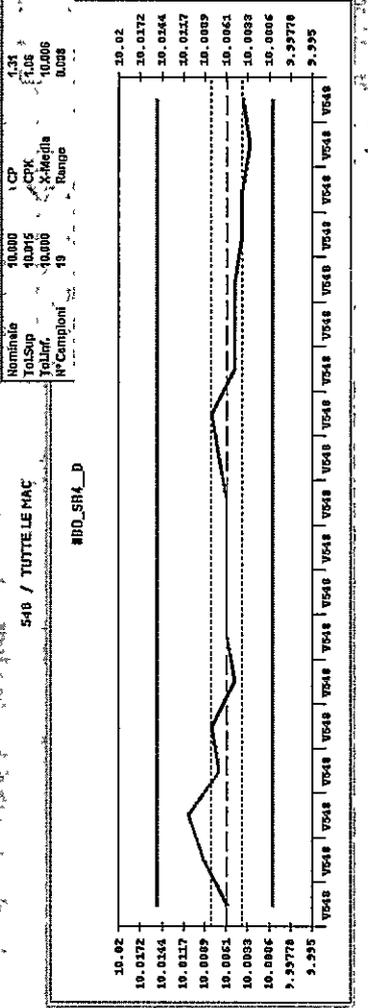
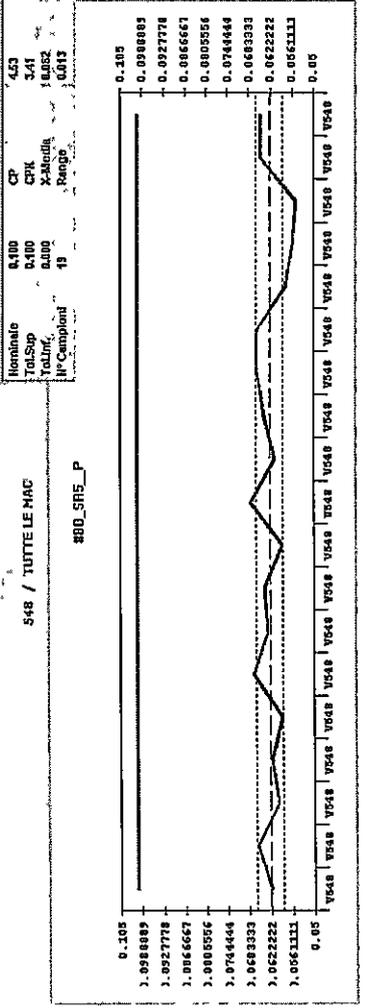
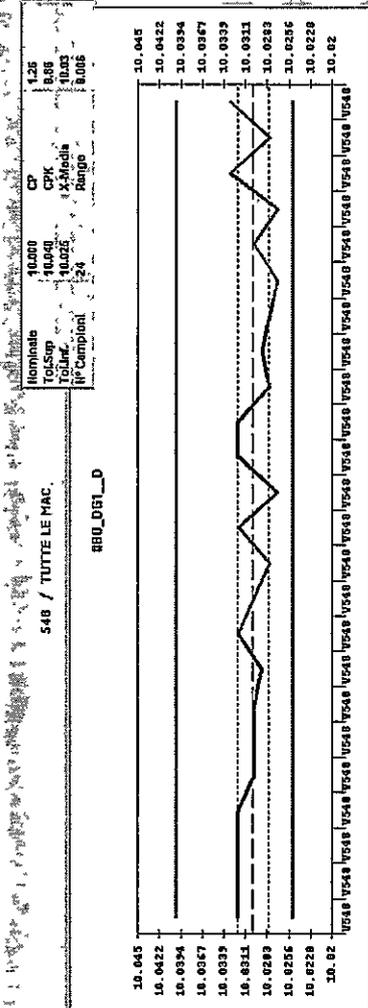
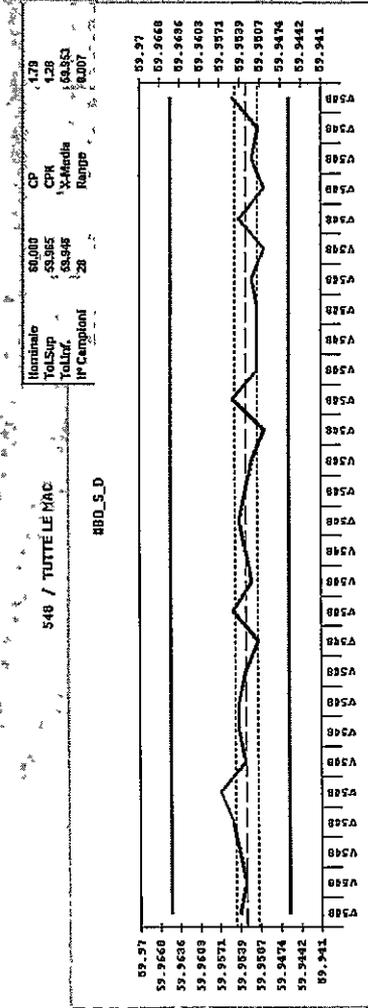
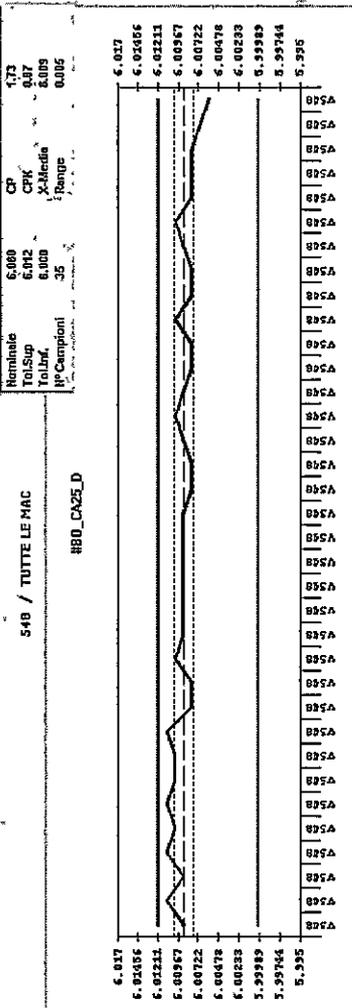
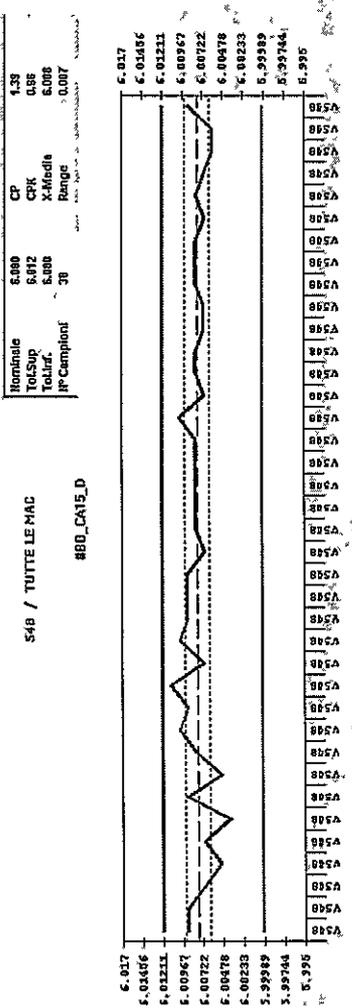
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SRGA Form – Approvals

GETRAG approvals for changes affecting production parts (including deviation)				
Parts without Critical Characteristics	Purchasing	Product Development Engineering	Receiving GETRAG Plant	
	STA/SQA Engineer PRINT NAME SIGNATURE DATE S. Picerno Approved 05.05.12	Design and Release Engineer / Manager Component PRINT NAME SIGNATURE DATE M. Bassler APPROVED 2012-03-02 With comment	PD Resident Engineer (Plant) PRINT NAME SIGNATURE DATE N. Achille APPROVED 02/03/2012	
	Negative cost effect for GETRAG identified? <input type="checkbox"/> YES x NO If YES, rejection recommended <input type="checkbox"/> (please state below)	Design and Release Manager Component PRINT NAME SIGNATURE DATE	Plant Quality Manager / Manufacturing Engineering PRINT NAME SIGNATURE DATE (B/GPS3) V. Pennacchia Approved 01/03/2012 V. Uhr M. Colapietro Approved 04/05/2012	
	Buyer (only for non-design related changes) PRINT NAME SIGNATURE DATE	Program Engineering Supervisor System PRINT NAME SIGNATURE DATE	Plant Logistic Manager PRINT NAME SIGNATURE DATE	
Additional approval required if Critical Characteristics (C, A, inverted delta (V)) are affected				
STA/SQA Manager PRINT NAME SIGNATURE DATE	Chief Program Engineer System PRINT NAME SIGNATURE DATE	Customer Approval (attached) COMPANY NAME: REPRESENTATIVE NAME: APPROVAL DATE:		
Additional GETRAG approvals as needed for changes affecting material				
For changes affecting heat treat		For material changes		
Heat Treat Process Specialist PRINT NAME SIGNATURE DATE	Materials Engineer PRINT NAME SIGNATURE DATE			

Reason for rejection or qualifying condition(s) of acceptance (for example, recommended GETRAG plant functional trials)
<p><u>Note</u></p> <p>B/GPS3 V. Pennacchia: APPROVE NECESSARY TO START quickly (05/03/2012) WITH FORD PRODUCTION.</p> <p>M. Bassler: Please check that no first off tool parts are used for assembling.</p>



Nome responsabile		Luigi.Landriscina		Foglio 1																
Reparto		WLP_		di 3																
Attività		Piano d'azione n° WLP_12.12												Collaboratori						
Pos.	Rientro Capability PPAP Ford 3548	anno 2012												Stato	Emissione	Aggiornamento	Foglio 1			
		Planificazione: mensile																		
		3	4	5	6	7	8	9	10	11	12	1	2	3	4	5	6			
1	Azioni correttive sulle coordinate programma #BO_T1_P - #BO_DG3_P - #BO_TRS1_P #BO_CA1_P - #BO_P1_P - #BO_CA1_P - #BO_SR5_P	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	L.Landriscina	L.Landriscina	ODP
2	Azioni correttive sugli utensili #BO_CA15_D - #BO_CA25_D - #BO_S_D - #BO_DG1_D - #BO_SR4_D #BO_DG2_D - #BO_SR5_D	●	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	L.Landriscina	M.Cannone	
3	Pulizia con mandrino e controllo metodo di misura #FL_D1_PAR - #FL_F_PAR	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	L.Landriscina	L.Landriscina	ODP
4	Pulizia con utensile e controllo metodo di misura #FL_D1_PAR - #FL_F_PAR	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	L.Landriscina	L.Landriscina	ODP
5	Analisi	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	L.Landriscina	L.Landriscina	ODP G.Sette
Legenda		○ pianificato ⊗ negativo ⊕ Stabilite le responsabilità e le scadenze ● positivo ⊖ Provvedimenti attuati, andamento documentato ● Controllo dell'efficacia del provvedimento ● Provvedimenti standardizzati ed informazioni												Percentuale di completamento: #RIFI		Data di chiusura prevista: #RIFI				

Area Interessata: GPS3

Settore:

Stato piano: in corso

Incr. Pz/h: