

Part Name Double Gear 2/Rv		Customer Part Number 250.1.5221.75	
Shown on Drawing No. 250.1.5221.75		Organization Part # _____	
Engineering Change Level - C004731_MIP_2		Dated 20-feb-17	
Additional Engineering Changes _____		Dated _____	
Safety and/or Government Regulation <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	Purchase Order No. _____	Weight (kg) 1.398	
Checking Aid No. _____	Checking Aid Engineering Change Level _____	Dated _____	

ORGANIZATION MANUFACTURING INFORMATION	CUSTOMER SUBMITTAL INFORMATION
GETRAG MODUGNO	
Organization Name & Supplier/Vendor Code VIA DEI CICLAMINI N°4	Customer Name/Division _____
Street Address MODUGNO BARI 70026 ITALY	Buyer/Buyer Code DCT250
City Region Postal Code Country	Application _____

MATERIALS REPORTING

Has customer-required Substances of Concern information been reported? Yes No n/a
Submitted by IMDS or other customer format: _____

Are polymeric parts identified with appropriate ISO marking codes? Yes No n/a

REASON FOR SUBMISSION (Check at least one)

<input checked="" type="checkbox"/> Initial Submission	<input type="checkbox"/> Change to Optional Construction or Material
<input type="checkbox"/> Engineering Change(s)	<input type="checkbox"/> Supplier or Material Source Change
<input type="checkbox"/> Tooling: Transfer, Replacement, Refurbishment, or additional	<input type="checkbox"/> Change in Part Processing
<input type="checkbox"/> Correction of Discrepancy	<input type="checkbox"/> Parts Produced at Additional Location
<input type="checkbox"/> Tooling Inactive > than 1 year	<input type="checkbox"/> Other - please specify below

REQUESTED SUBMISSION LEVEL (Check one)

Level 1 - Warrant only (and for designated appearance items, an Appearance Approval Report) submitted to customer.

Level 2 - Warrant with product samples and limited supporting data submitted to customer.

Level 3 - Warrant with product samples and complete supporting data submitted to customer.

Level 4 - Warrant and other requirements as defined by customer.

Level 5 - Warrant with product samples and complete supporting data reviewed at organization's manufacturing location.

SUBMISSION RESULTS

The results for dimensional measurements material and functional tests appearance criteria statistical process package

These results meet all drawing and specification requirements: Yes NO (If "NO" - Explanation Required)

Mold / Cavity / Production Process _____

DECLARATION

I hereby affirm that the samples represented by this warrant are representative of our parts which were made by a process that meets all Production Part Approval Process Manual 4th Edition Requirements. I further affirm that these samples were produced at the production rate of 1860 / 24 hours. I also certify that documented evidence of such compliance is on file and available for review. I have noted any deviations from this declaration below.

EXPLANATION / COMMENTS: First submission (only differences from 250.1.3692.76)

Is each Customer Tool properly tagged and numbered? Yes No n/a

Organization Authorized Signature Date **28-ago-17**

Print Name **Maselli Vito Carlo** Phone No. **tel 390805858300** Fax No. _____

Title **GPS 1-2 Leader** E-mail **carlo.maselli@magna.com**

FOR CUSTOMER USE ONLY (IF APPLICABLE)

Part Warrant Disposition: Approved Rejected Other

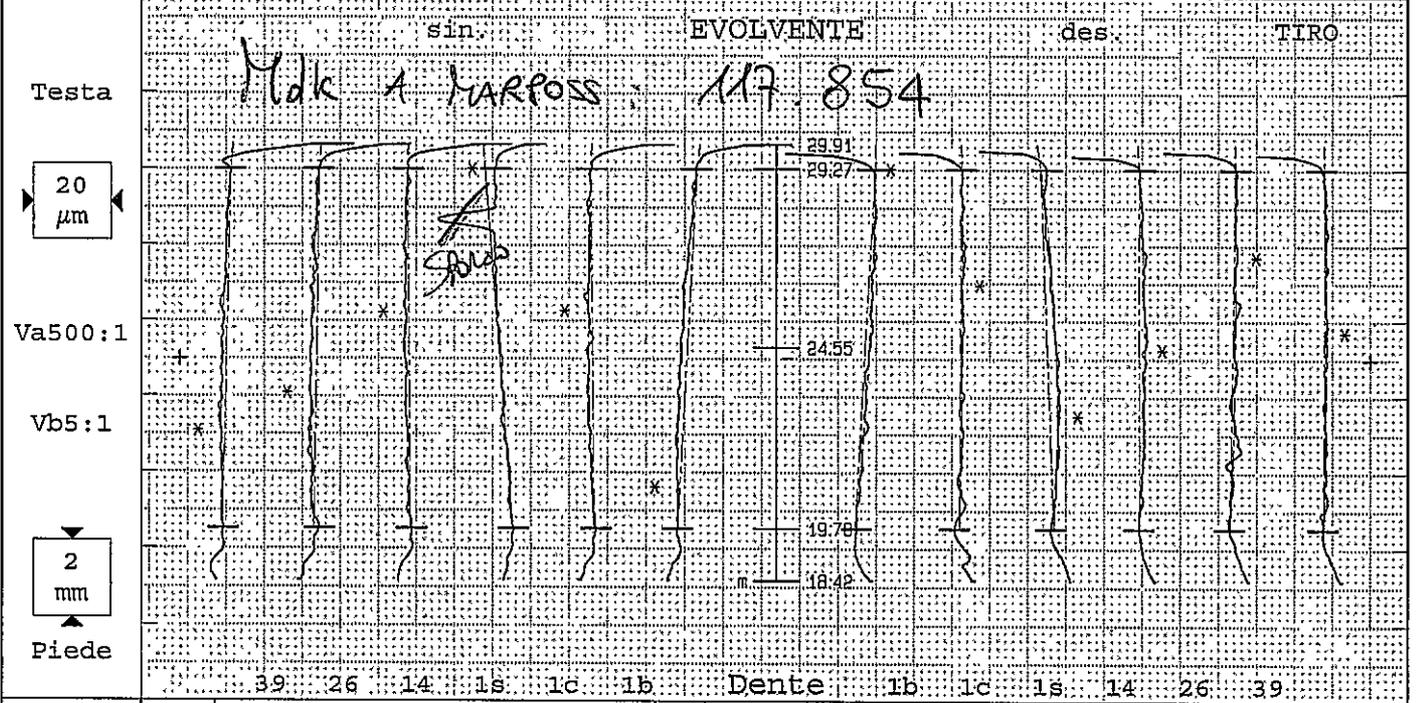
Customer Signature Date **28.08.17**

Print Name _____ Customer Tracking Number (optional) _____

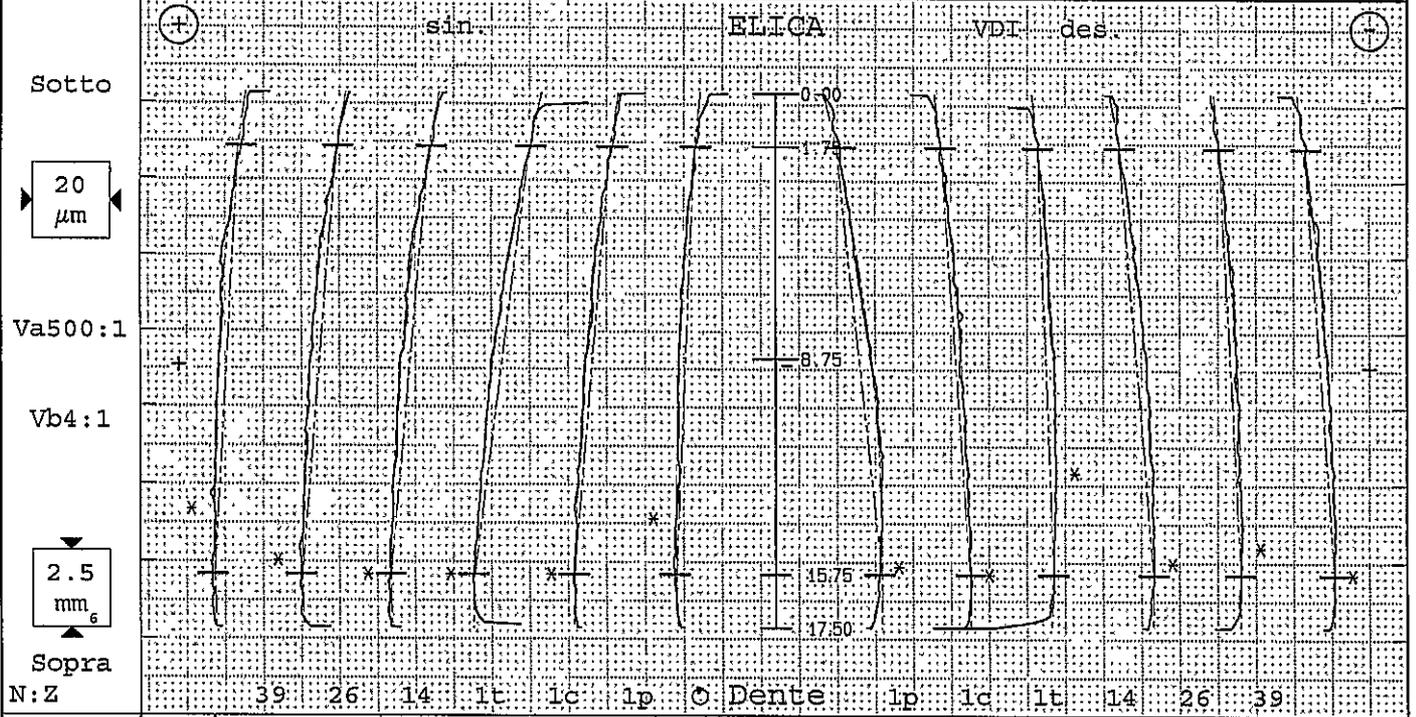
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0412 06 0	P26 B7681	Controllore: turno c	Data: 24.08.2017 08:52
Denominazione: ZR2		Numero denti z: 51	Largh. fasc. dent. b: 17.5mm
Numero disegno.: 250.1.5220.75-IF		Modulo m: 2mm	Tratto evolv. La: 9.49mm
Commessa/serie nr.: 1		Angolo pressione: 20°00'00"	Tratto elica Ls: 14mm
Masch. Nr.: M001	Spindel: Forme	Angolo elica: -22°00'00"	Inizio elab. M1: 19.78mm
Untersuchungszweck: Laufende Messung		Ø Base db: 102.403mm	Palpatore Ø (#2C): 1mm
Werkzeug: Charge:		Ang. Base: -20°36'38"	Fat. scor. pr. x: .888



Tolerance	Medio	Val. misur [µm]					Qual	Tolerance	Val. misur [µm]					Medio	Qual	
fHm	±6	0	Var a 3						±6	Var a 1					1	1
fHa	±7	0	-2	-1	1	7	1	-5	±7	5	1	-3	0	1	0	1
Fa		3	3	3	2	20	3	5		5	3	4	2	4	2	3
ffa	5	2	3	2	2	16	2	1	5	2	3	2	1	4	2	3
Ca	0/3	1	1	1	1	0	1	2	0/3	1	0	2	1	1	1	1
P/T-Ø [mm]		107.658	[107.45/107.75]						118.487	[118.4/118.6]						



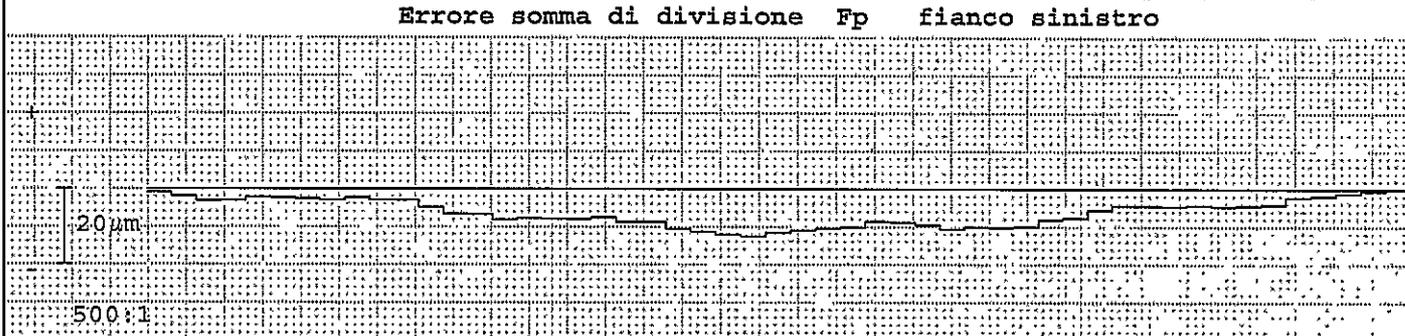
N:Z	39 26 14 1t 1c 1p					Ø	Dente 1p 1c 1t 14 26 39								
fHSm -10±6	-11	Var β 5						10±6	Var β 4					10	
fHs -10±13	-11	-8	-11	-13	-18	-12	-6	10±13	15	10	5	11	7	10	10
Fβ	4	4	3	4	7	3	4		6	3	5	4	4	3	4
ffβ	5	1	2	1	1	1	1	5	2	2	1	1	2	2	2
Cβ	0/3	2	2	2	2	2	2	0/3	3	2	2	2	2	2	2



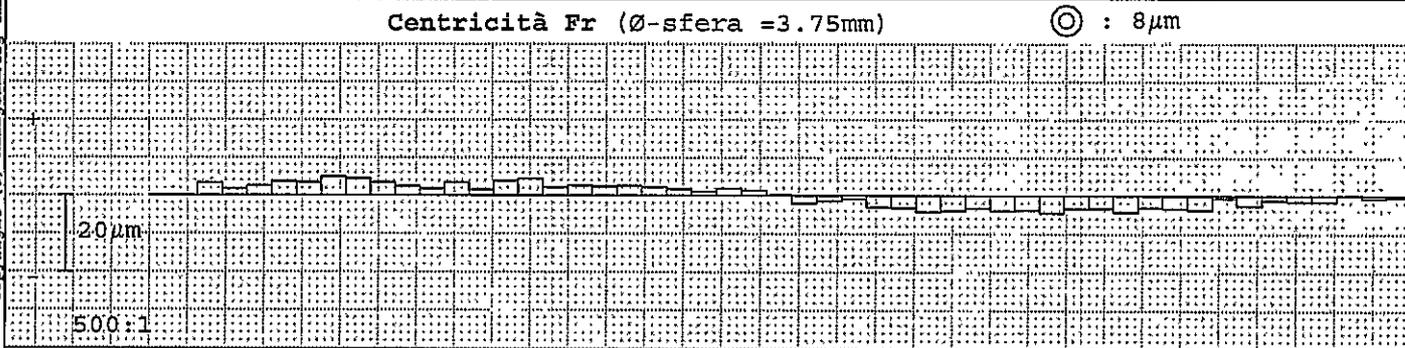
Ruota cilindrica Divisione



Nr. prog.: STI0412 06 0	P26 B7681	Controllore: turno c	Data: 24.08.2017 08:52
Denominazione: ZR2		Numero denti z 51	Angolo pressione 20°00'00"
Numero disegno.: 250.1.5220.75-IF		Modulo m 2mm	Angolo elica -22°00'00"
Commessa/serie nr.: 1		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORM	Werkzeug:	Charge:



Corsa per misura divis. 113.566 z=8.8mm	fianco sinistro				fianco destro / TIRO			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	2		10		3		10	
Gr. salto di passo fu max	2		12		4		12	
Scarto di divisione Rp	4				6			
Err. globale di divisione Fp	13		50		17		50	
Err. cordale di divisione Fpz/8	6				7			



Err. di concentricità Fr	10	32	
Variab. spessore dente Rs			

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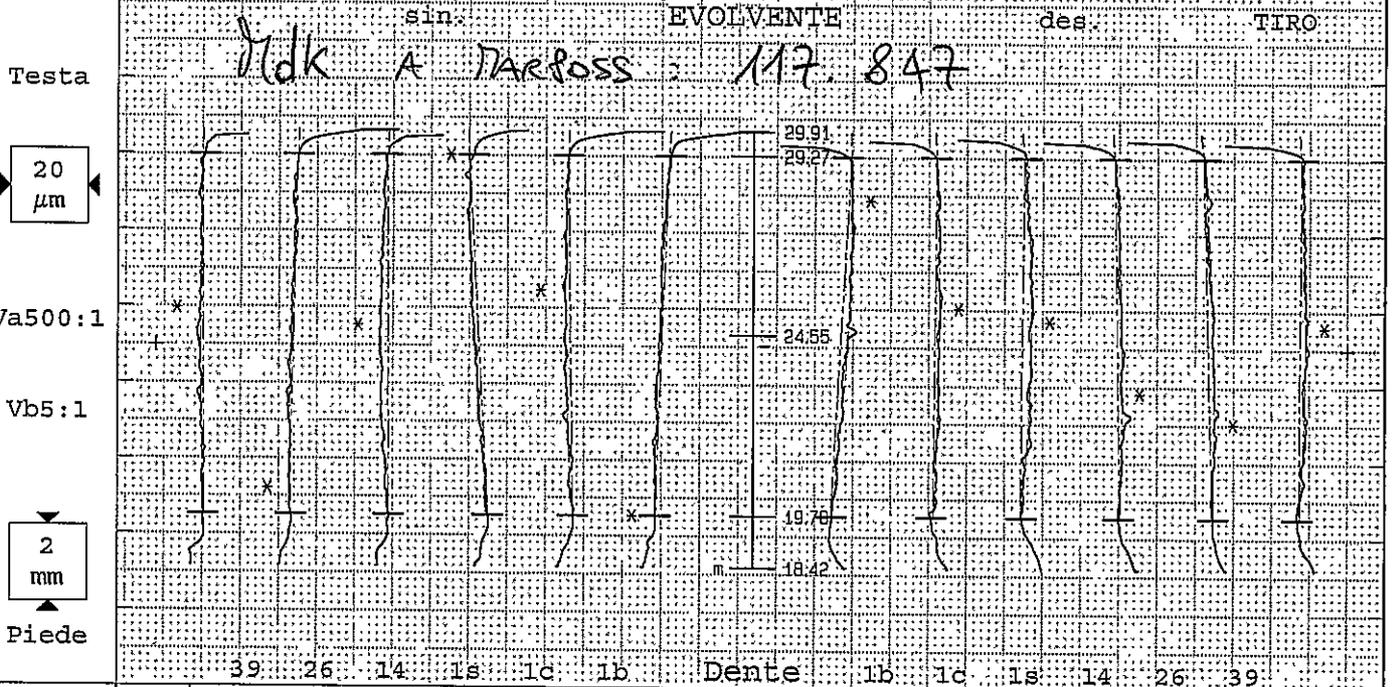


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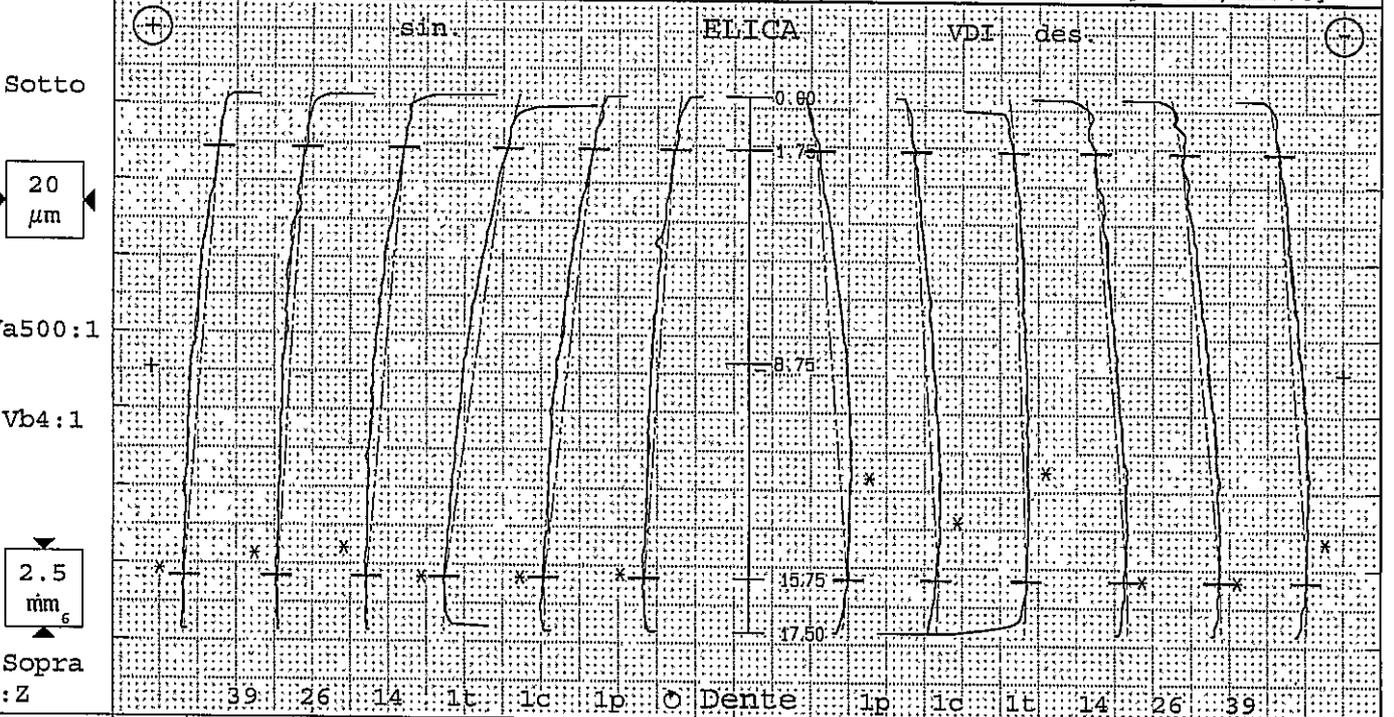
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0412 06 0		P26 B7681		Controllore: turno c		Data: 24.08.2017 08:56					
Denominazione: ZR2		Numero denti z		51		Largh.fasc.dent. b		17.5mm			
Numero disegno.: 250.1.5220.75-IF		Module m		2mm		Tratto evolv. La		9.49mm			
Comessa/serie nr.: 2		Angolo pressione		20°00'00"		Tratto elica Lg		14mm			
Masch.Nr.: M001		Spindel: Form. cilindrica		-22°00'00"		Inizio elab. M1		19.78mm			
Untersuchungszweck: Laufende Messung		Ø Base db		102.403mm		Palpatore Ø		#2C) 1mm			
Werkzeug:		Charge:		Ang. Base		-20°36'38"		Fat.scor.pr. x		.888	



Tolerance	Medio	Val. misur [μ m]						Qual	Tolerance	Val. misur [μ m]						Medio	Qual		
fHm	± 6	0	Var a 3							± 6	Var a 4						-1		
fHa	± 7	0	0	-2	0	5	1	-4		± 7	5	1	1	-1	-3	0	-1		
Fa		3	2	3	3	6	3	5			6	3	3	4	4	3	4		
ffa	5	2	2	2	1	2	2	2		5	3	2	2	3	2	2	2		
Ca	0/3	1	1	1	2	1	1	1		0/3	2	1	2	1	1	1	1		
P/T- ϕ [mm]		107.659	[107.45/107.75]								118.480	[118.4/118.6]							



N:Z	39 26 14 1t 1c 1p						Ø Dente	1p 1c 1t 14 26 39								
fHm -10 \pm 6	-12	Var β 6							10 \pm 6	Var β 4						11
fHB -10 \pm 13	-12	-11	-9	-12	-20	-15	-9	10 \pm 13	10	9	4	11	13	10	11	
FB	4	3	3	4	9	6	3		4	4	5	3	4	3	4	
ffb	5	2	1	2	1	1	2	5	1	2	1	2	1	1	2	
CB	0/3	3	2	2	3	3	2	0/3	4	2	2	2	2	2	2	

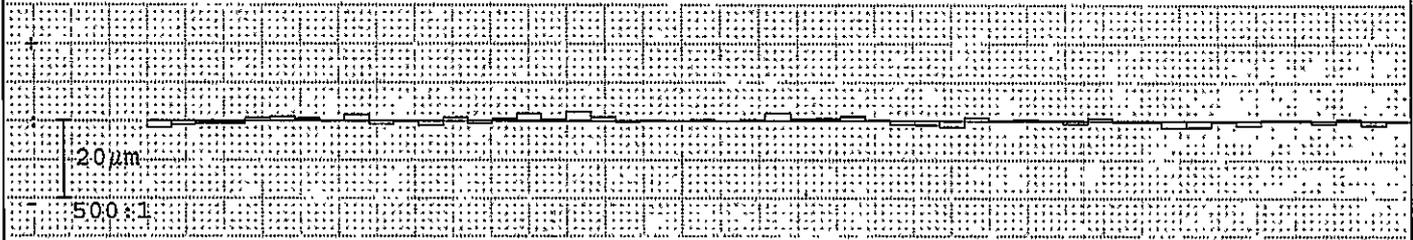


Ruota cilindrica Divisione

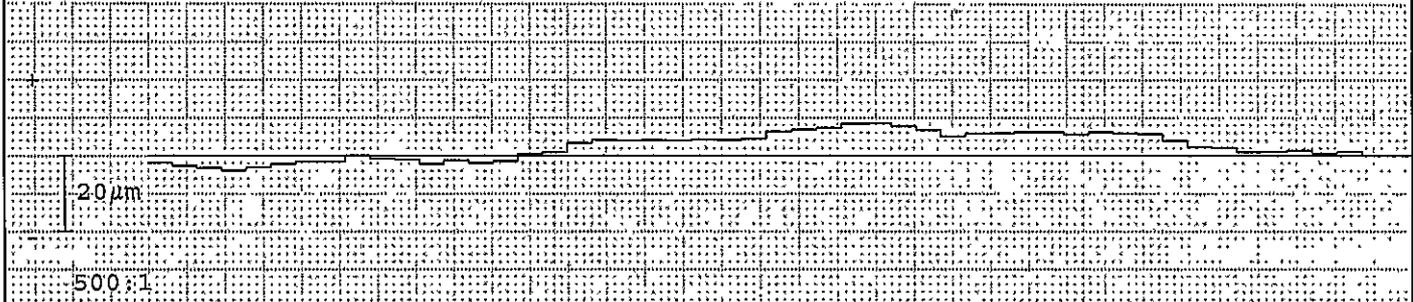


Nr. prog.: STI0412 06 0	P26 B7681	Controllore: turno c	Data: 24.08.2017 08:56
Denominazione: ZR2	Numero denti z: 51	Angolo pressione: 20°00'00"	
Numero disegno.: 250.1.5220.75-IF	Modulo m: 2mm	Angolo elica: -22°00'00"	
Comessa/serie nr.: 2	Untersuchungszweck: Laufende Messung		
Masch.Nr.: M001	Spindel: Formelwerkzeug	Charge:	

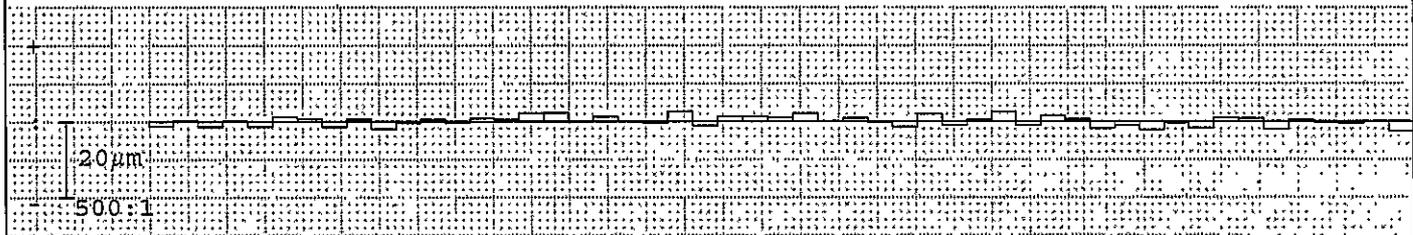
Errori singoli di divisione fp fianco sinistro



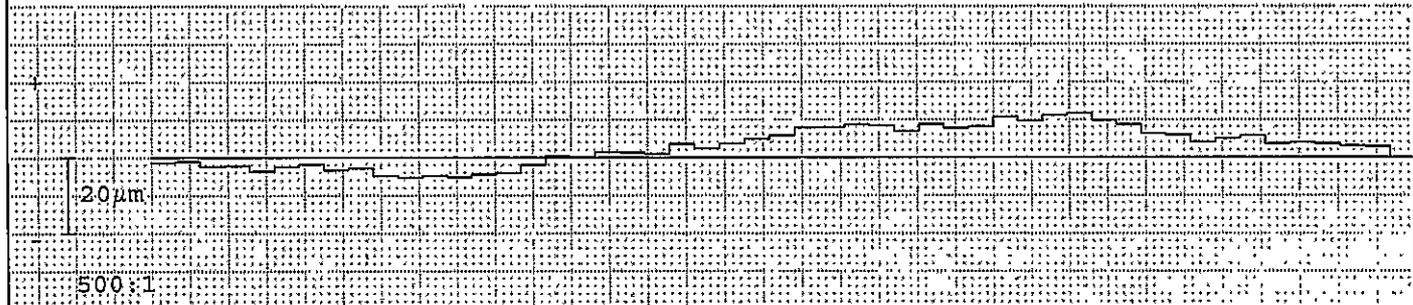
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro

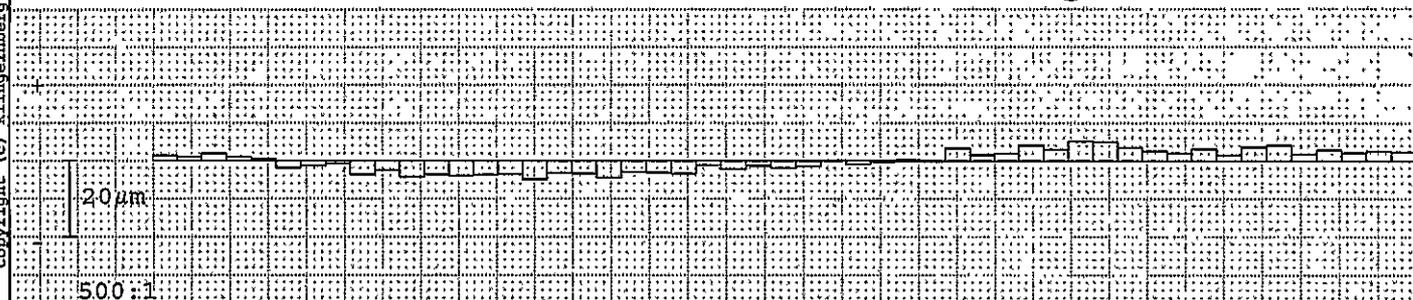


Errore somma di divisione Fp fianco destro



	Corsa per misura divis.: 113.566 z=8.8mm	fianco sinistro				fianco destro / TTRO			
		Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione	fp max	2		10		3		10	
Gr. salto di passo	fu max	2		12		4		12	
Scarto di divisione	Rp	4				6			
Err. globale di divisione	Fp	12		50		17		50	
Err. cordale di divisione	Fpz/8	6				7			

Centricità Fr (Ø-sfera =3.75mm) ⊙ : 7µm



Err. di concentricità	Fr	10	32
Variab. spessore dente	Rs		

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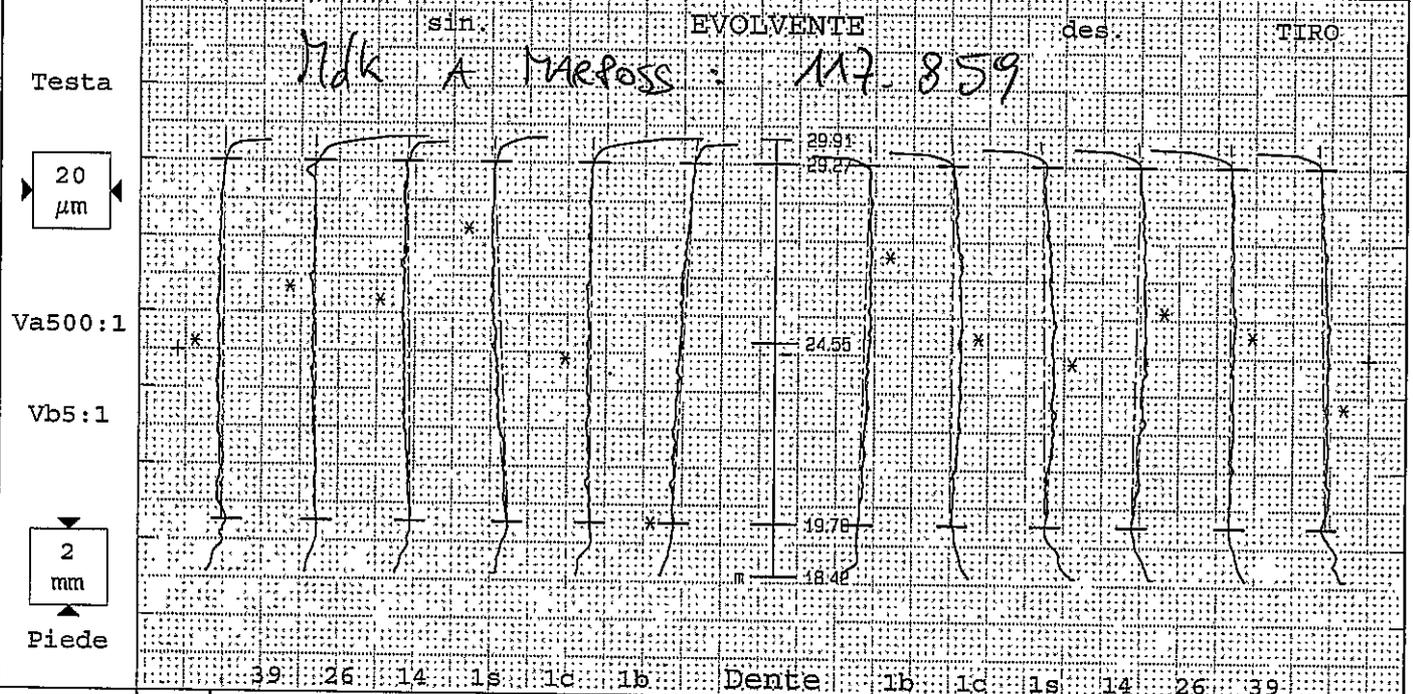


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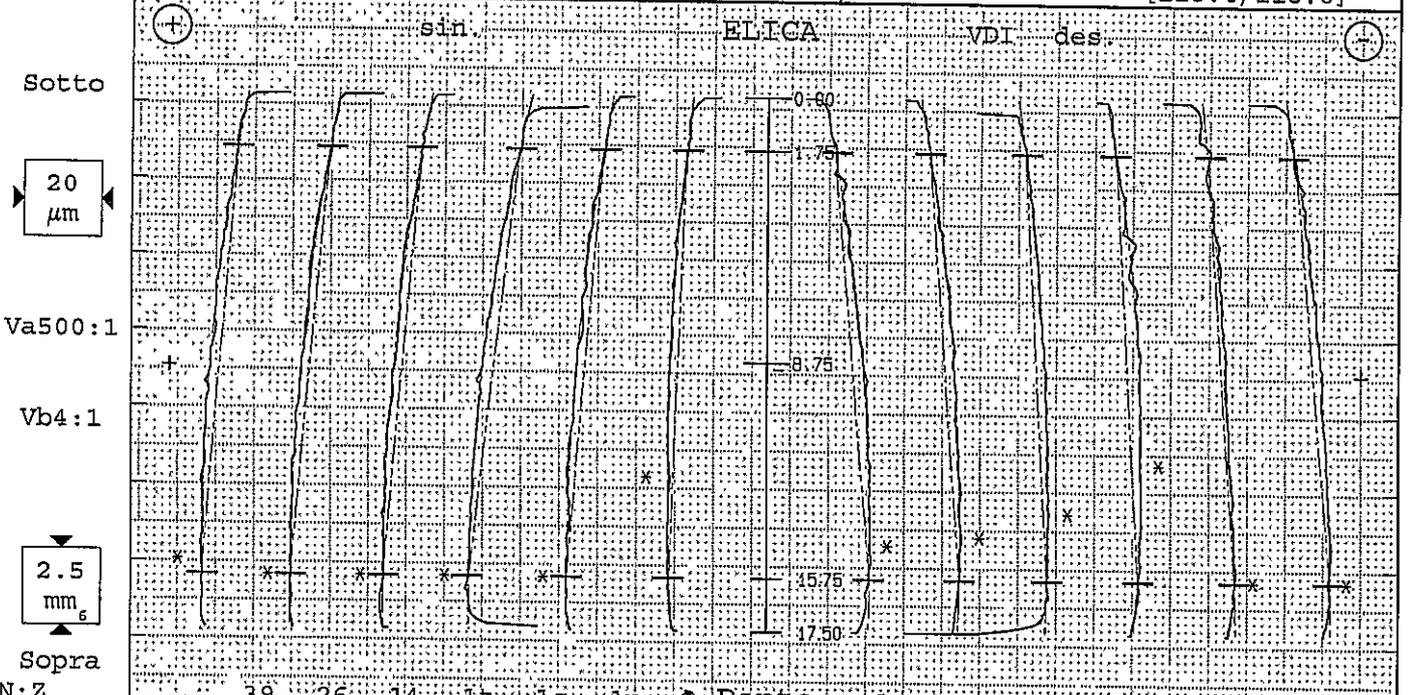
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0412 06 0	P26 B7681	Controllore: turno c	Data: 24.08.2017 09:01
Denominazione: ZR2		Numero denti z 51	Largh.fasc.dent. b 17.5mm
Numero disegno.: 250.1.5220.75-IF		Modulo m 2mm	Tratto evolv. La 9.49mm
Comessa/serie nr.: 3		Angolo pressione 20°00'00"	Tratto elica L6 14mm
Masch.Nr.: M001	Spindel: Form	Angolo elica -22°00'00"	Inizio elab. M1 19.78mm
Untersuchungszweck: Laufende Messung		Ø Base db 102.403mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -20°36'38"	Fat.scor.pr. x .888



Tolerance	Medio	Val. misur [µm]							Qual	Tolerance	Val. misur [µm]							Medio	Qual
fHm ±6	1	Var a 1								±6	Var a 4								0
fHa ±7	1	0	1	1	4	0	-5		±7	2	0	-1	2	0	-2	0			
Fa	3	3	3	3	5	2	6			3	3	4	4	2	3	3			
ffa 5	2	2	3	1	2	2	1		5	2	1	2	2	1	2	2			
Ca 0/3	1	1	1	1	2	1	1		0/3	1	2	2	2	1	1	2			
P/T-ø [mm]	107.658	[107.45/107.75]								118.482	[118.4/118.6]								



N:Z	Var β 1							Qual	Tolerance	Var β 5							Qual	
fHSm -10±6	-13									10±6								
fHS -10±13	-13	-12	-13	-13	-16	-12	-5		10±13	12	10	7	7	9	12	10		
FE	4	4	4	4	7	4	5			5	3	4	5	2	4	4		
ffR 5	1	1	1	1	2	1	1		5	3	1	1	3	2	2	2		
CS 0/3	2	2	2	2	3	2	2		0/3	3	3	2	3	1	2	2		
RA 10+R	11																	

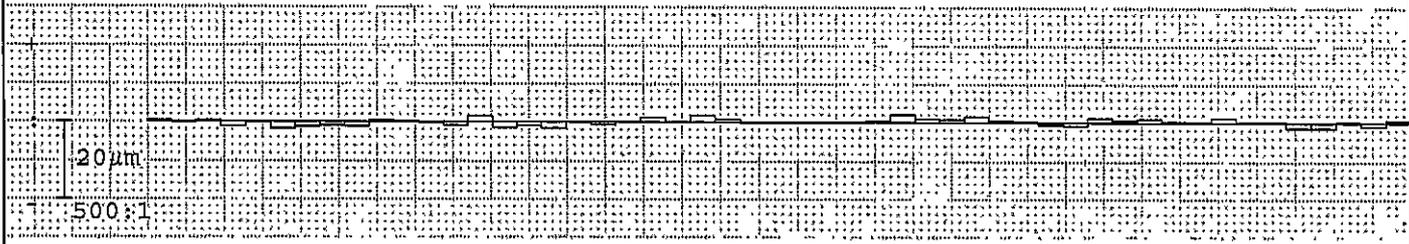


Ruota cilindrica Divisione

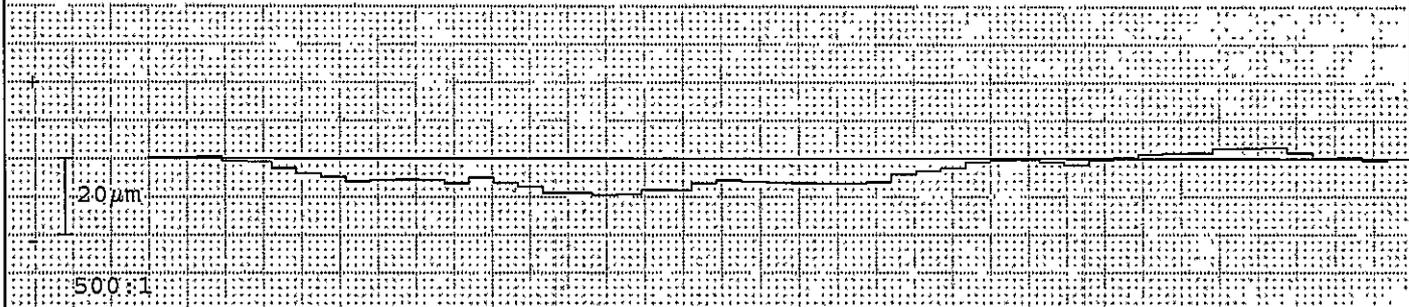


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Denominazione: ZR2		Numero denti z 51	Angolo pressione 20°00'00"
Numero disegno: 250.1.5220.75-IF		Modulo m 2mm	Angolo elica -22°00'00"
Comessa/serie nr.: 3		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: Formelwerkzeug	Charge:	

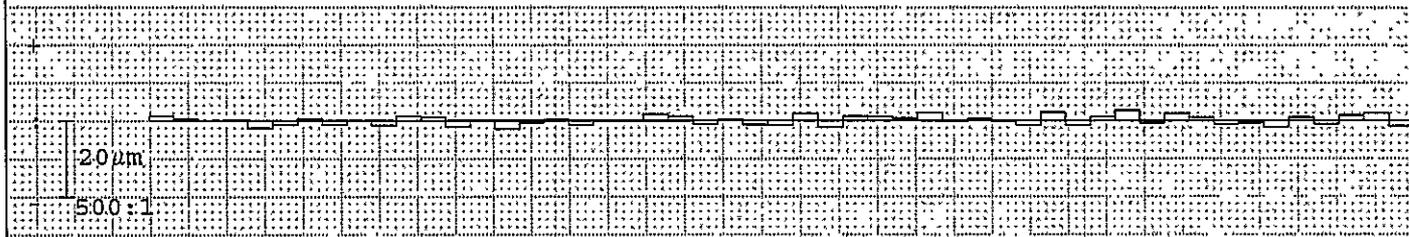
Errori singoli di divisione fp fianco sinistro



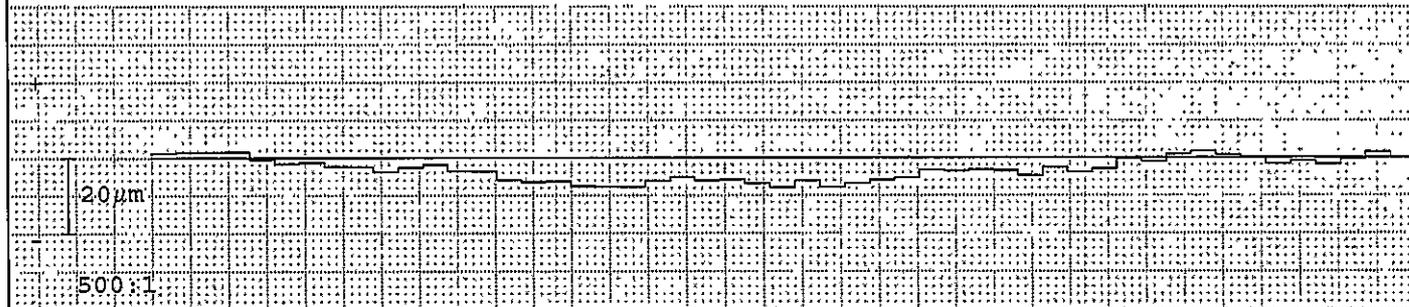
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro

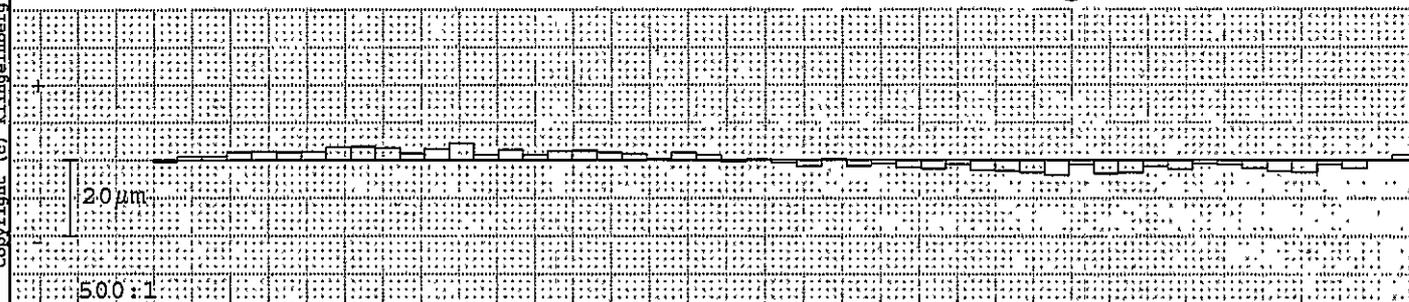


Errore somma di divisione Fp fianco destro



Corsa per misura divis.: 113.566 z=8.8mm	fianco sinistro				fianco destro / TIRO			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	2		10		3		10	
Gr. salto di passo fu max	3		12		4		12	
Scarto di divisione Rp	4				5			
Err. globale di divisione Fp	13		50		10		50	
Err. cordale di divisione Fpz/8	7				6			

Centricità Fr (Ø-sfera =3.75mm) Ⓞ : 6µm



Err. di concentricità Fr	8	32	
Variab. spessore dente Rs			

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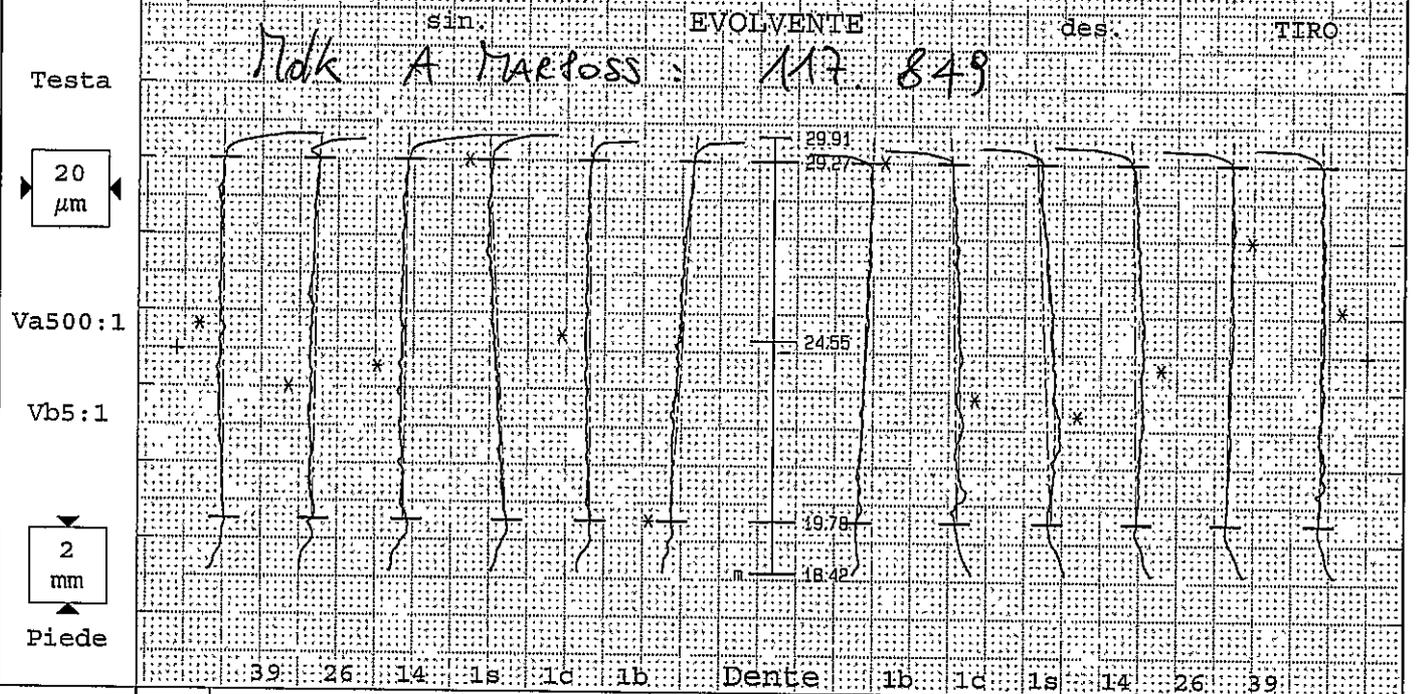


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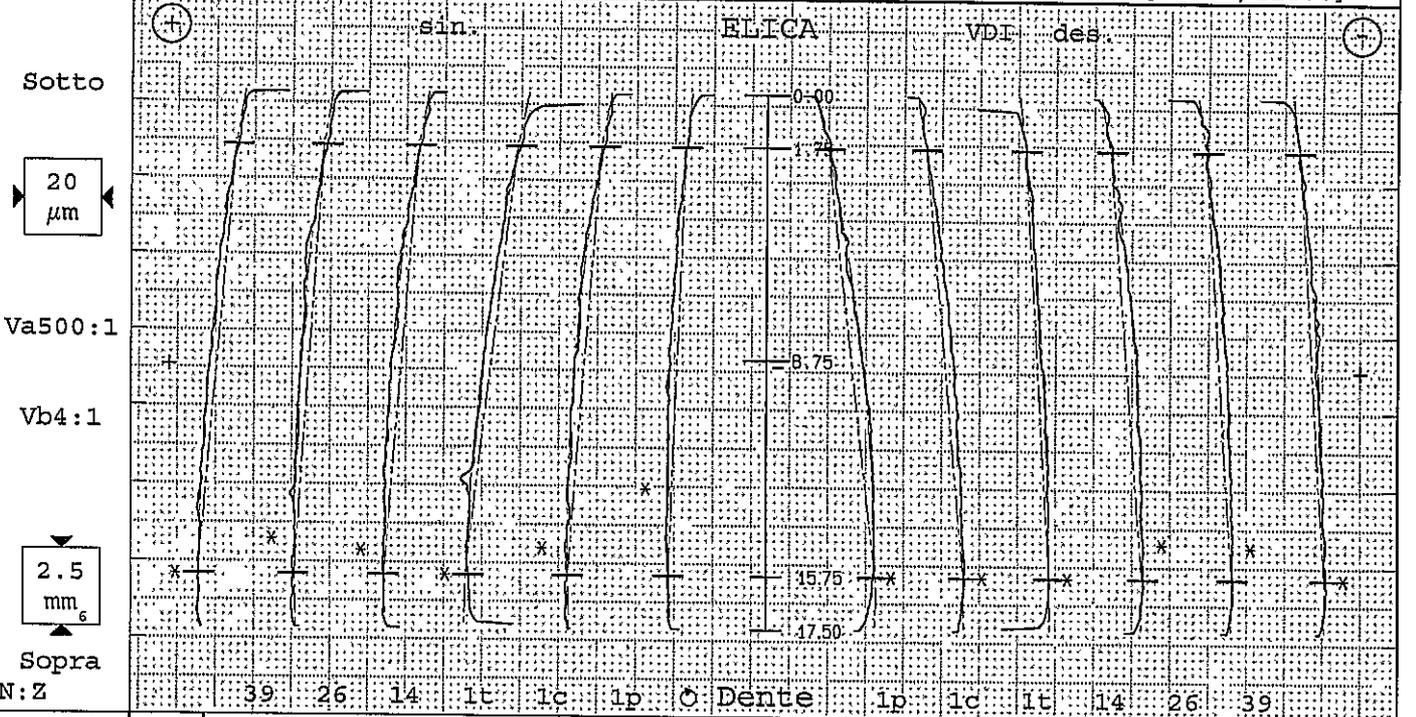
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0412 06 0	P26 B7681	Controllore: turno c	Data: 24.08.2017 09:06
Denominazione: ZR2		Numero denti z 51	Largh.fasc.dent. b 17.5mm
Numero disegno.: 250.1.5220.75-IF		Modulo m 2mm	Tratto evolv. La 9.49mm
Comessa/serie nr.: 4		Angolo pressione 20°00'00"	Tratto elica L& 14mm
Masch.Nr.: M001	Spindel: Forme cilindriche	Angolo elica -22°00'00"	Inizio elab. M1 19.78mm
Untersuchungszweck: Laufende Messung		Ø Base db 102.403mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -20°36'38"	Fat.scor.pr. x .888



Tolerance	Medio	Val. misur [µm]						Qual	Tolerance	Val. misur [µm]						Medio	Qual
fHm ±6	-1	Var a 1							±6	Var a 3						-1	
fHa ±7	-1	0	-1	-1	5	0	-6		±7	4	-2	-4	-1	1	0	-1	
Fa	3	2	3	3	6	2	6			4	4	6	3	2	2	3	
ffa	5	2	3	2	2	1	2		5	3	4	3	1	1	2	2	
Ca 0/3	1	1	1	1	1	1	1		0/3	0	1	2	2	1	1	1	
P/T-Ø (mm)	107.656	[107.45/107.75]							118.481	[118.4/118.6]							



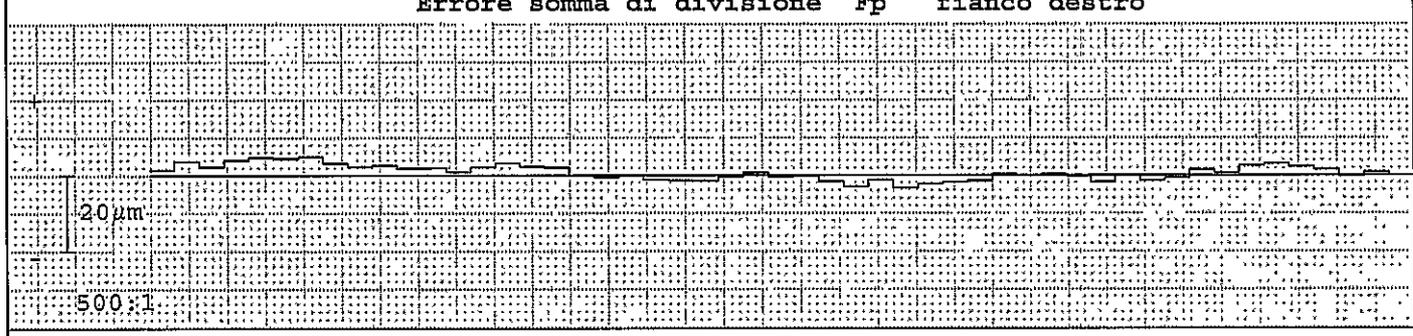
N:Z		Var β 2							Var β 4								
fHβ -10±6	-11	10±6							10								
fHβ -10±13	-11	-12	-10	-11	-17	-11	-5		10±13	16	12	8	11	9	8	10	
Fβ	4	4	4	4	9	4	5			6	4	3	3	3	3	3	
ffβ	5	1	1	2	1	3	1	1		5	2	1	1	2	1	2	2
Cβ	0/3	2	2	2	2	2	2	2		0/3	3	2	1	2	2	2	2
Rβ	10+R	12															



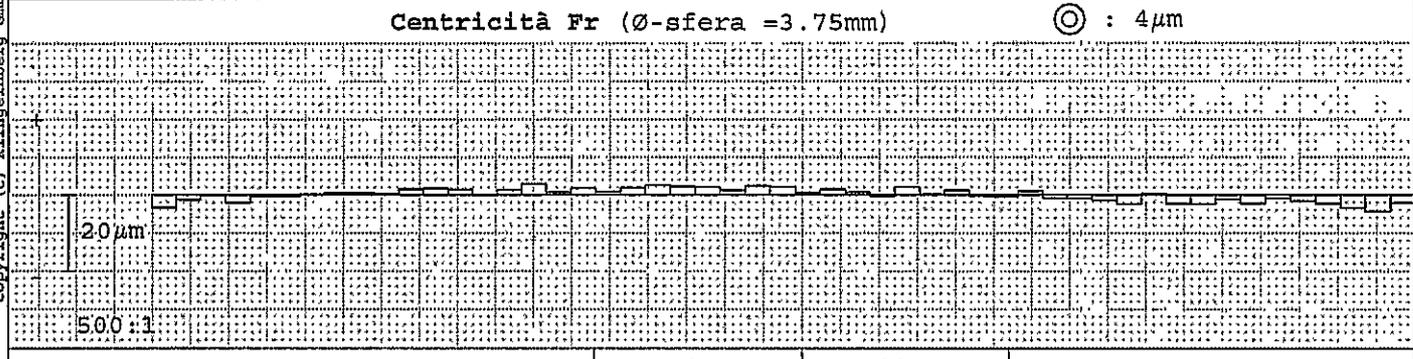
Ruota cilindrica Divisione



Nr. prog.: STI0412 06 0	P26 B7681	Controllatore: turno c	Data: 24.08.2017 09:06
Denominazione: ZR2	Numero denti z: 51	Angolo pressione: 20°00'00"	
Numero disegno.: 250.1.5220.75-IF	Modulo m: 2mm	Angolo elica: -22°00'00"	
Comessa/serie nr.: 4	Untersuchungszweck: Laufende Messung		
Masch.Nr.: M001	Spindel: Form	Charge:	



	fianco sinistro				fianco destro / TIRO			
	Val.misur	Qual.	Val. amm	Qual.	Val.misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	2		10		2		10	
Gr. salto di passo fu max	3		12		4		12	
Scarto di divisione Rp	4				4			
Err. globale di divisione Fp	9		50		8		50	
Err. cordale di divisione Fpz/8	5				5			



Err. di concentricità Fr		7	32
Variaz. spessore dente Rs			

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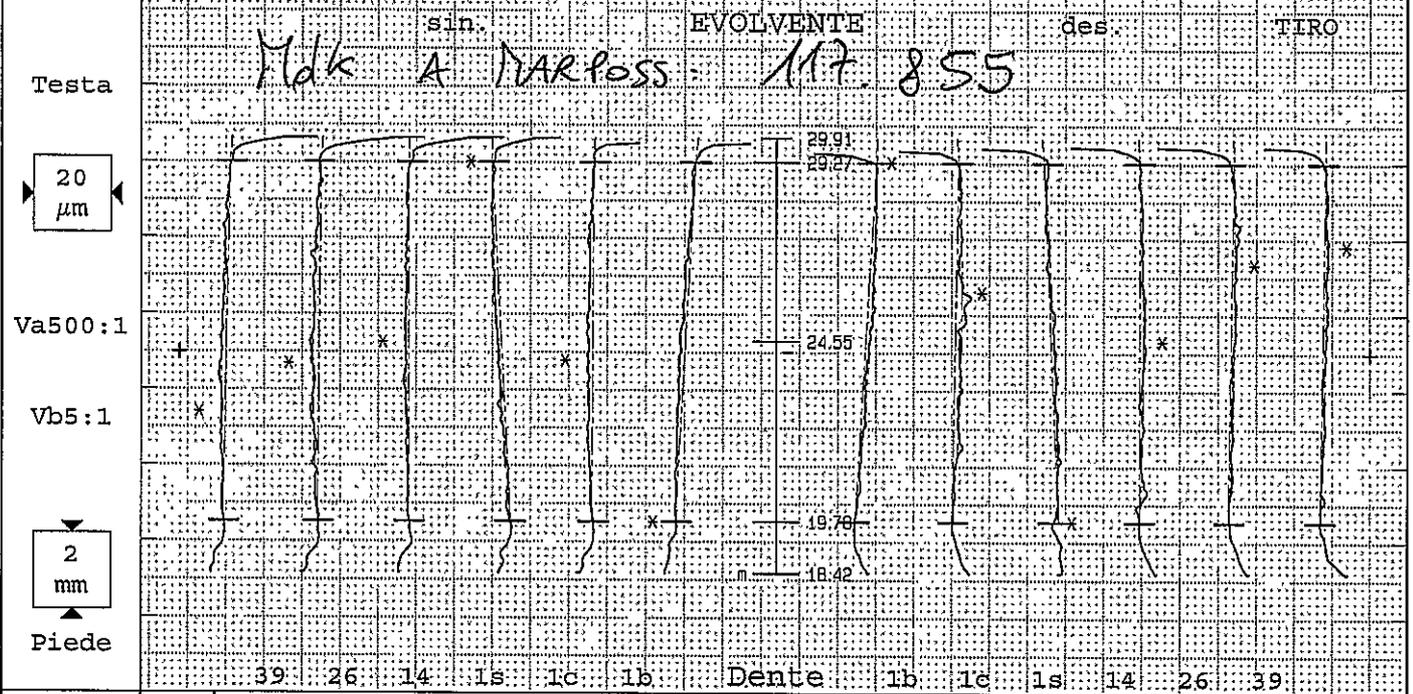


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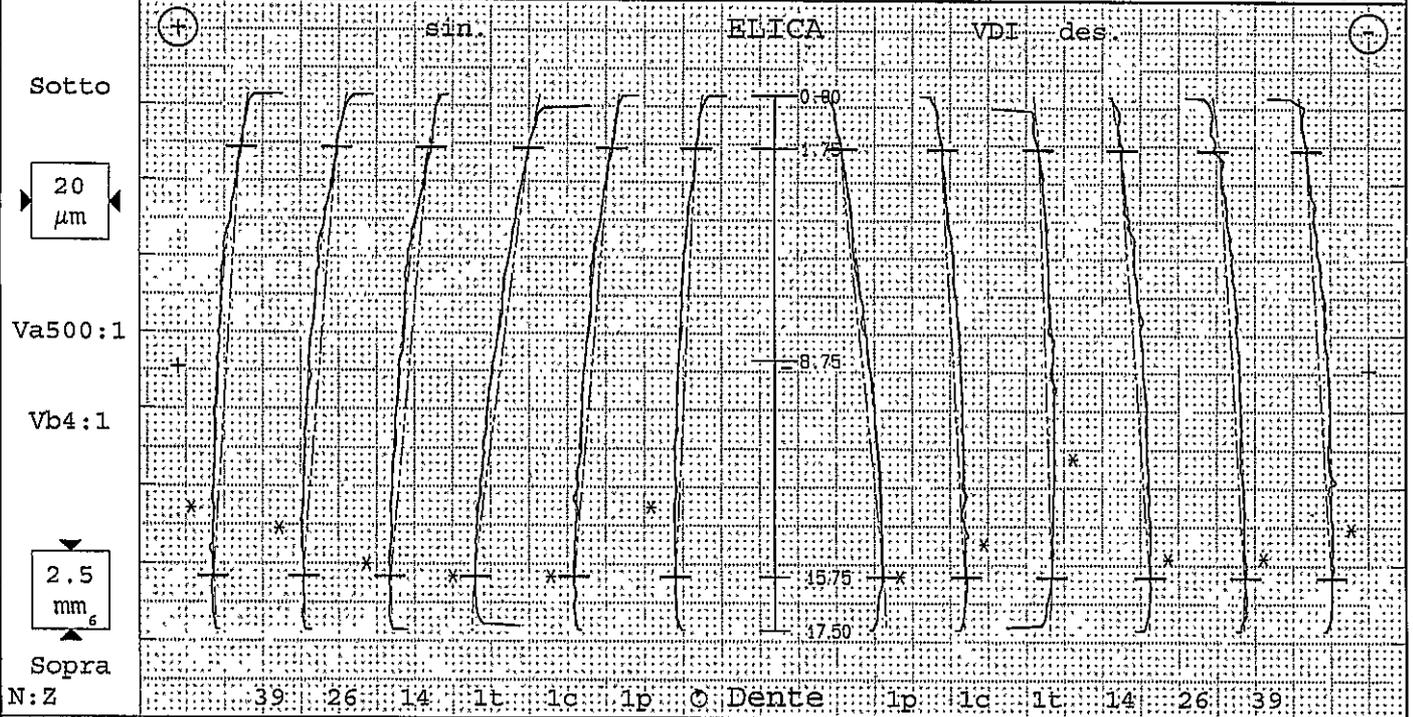
Ruota cilindrica Evolvente/Elica



Nr. prog.: STI0412 06 0	P26 B7681	Controllore: turno C	Data: 24.08.2017 09:10
Denominazione: ZR2		Numero denti z 51	Largh.fasc.dent. b 17.5mm
Numero disegno.: 250.1.5220.75-IF		Modulo m 2mm	Tratto evolv. La 9.49mm
Commessa/serie nr.: 5		Angolo pressione 20°00'00"	Tratto elica Lb 14mm
Masch.Nr.: M001	Spindel: Formaggio	Angolo elica -22°00'00"	Inizio elab. M1 19.78mm
Untersuchungszweck: Laufende Messung		Ø Base db 102.403mm	Palpatore Ø (#2C) 1mm
Werkzeug:	Charge:	Ang. Base -20°36'38"	Fat.scor.pr. x .888



Tolerance	Medio	Val.misur [µm]							Qual	Tolerance	Val.misur [µm]							Medio	Qual
fH _{am} ±6	-1	Var a 2								±6	Var a 2								2
fH _a ±7	-1 -2 -1 0 5 0 -5								±7	6 2 -4 0 2 2 2									
F _a	3 3 3 2 5 2 5									6 5 4 3 3 2 3									
ff _a 5	1 1 2 1 2 1 1								5	2 3 2 3 2 2 3									
C _a 0/3	1 1 2 1 1 1 1								0/3	1 2 1 1 1 1 1									
P/T-Ø [mm]	107.657	[107.45/107.75]								118.481	[118.4/118.6]								



Tolerance	Medio	Var β							Qual	Tolerance	Var β							Medio	Qual
fH _{Sm} -10±6	-11	4								10±6	2								9
fH _S -10±13	-11 -8 -11 -12 -18 -12 -6								10±13	14 8 4 10 8 8 9									
F _β	4 3 4 4 7 3 4									4 3 5 3 3 3 3									
ff _β 5	2 2 2 2 1 1 1								5	1 2 2 2 2 2 2									
C _β 0/3	3 2 3 3 2 2 2								0/3	2 2 2 2 2 2 2									

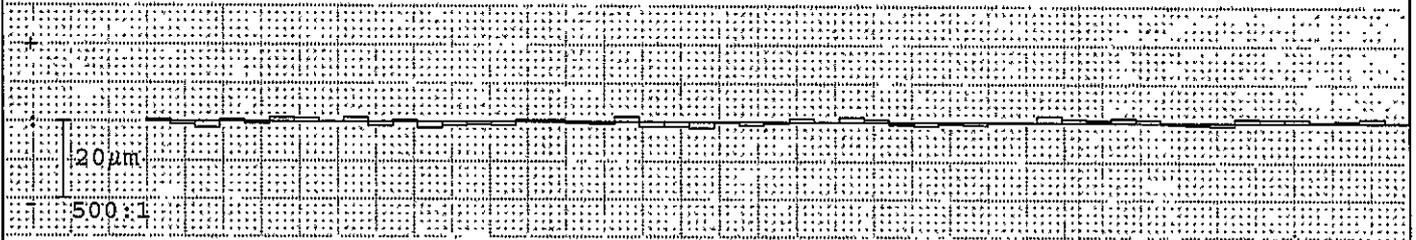


Ruota cilindrica Divisione

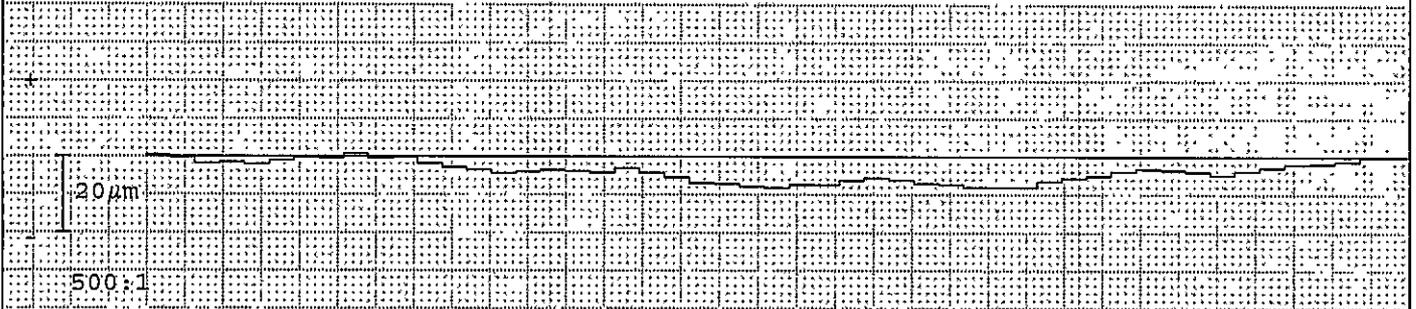


Nr. prog.: STI0412_06 0	P26 B7681	Controllore: turno C	Data: 24.08.2017 09:10
Denominazione: ZR2		Numero denti z 51	Angolo pressione 20°00'00"
Numero disegno.: 250.1.5220.75-IF		Modulo m 2mm	Angolo elica -22°00'00"
Comessa/serie nr.: 5		Untersuchungszweck: Laufende Messung	
Masch.Nr.: M001	Spindel: FORMULAZEDG	Charge:	

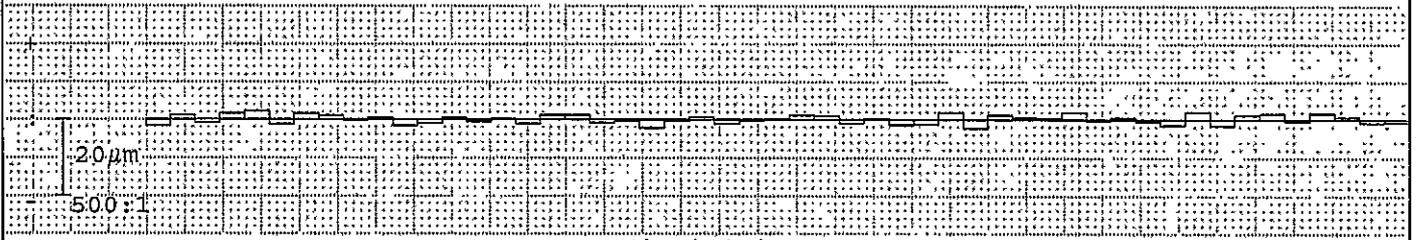
Errori singoli di divisione fp fianco sinistro



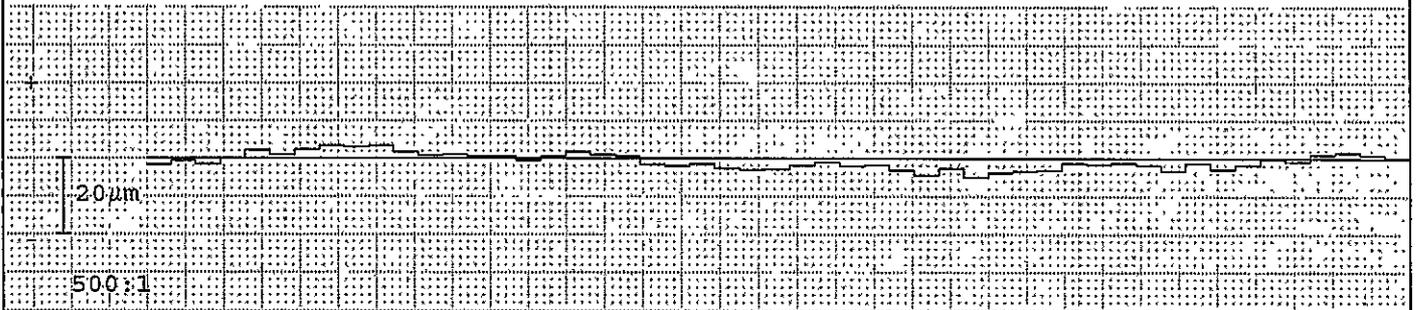
Errore somma di divisione Fp fianco sinistro



Errori singoli di divisione fp fianco destro

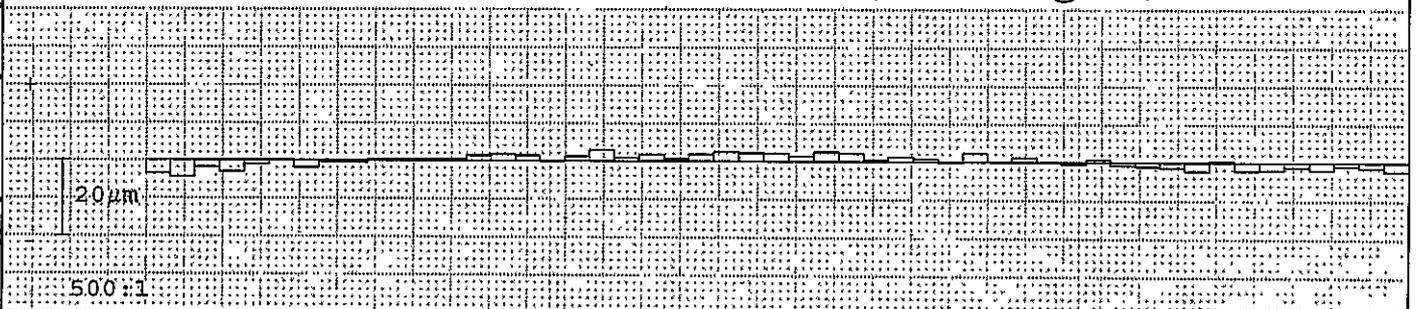


Errore somma di divisione Fp fianco destro



Corsa per misura divis.: 113.566 z=8.8mm	fianco sinistro				fianco destro / TIRO			
	Val. misur	Qual.	Val. amm	Qual.	Val. misur	Qual.	Val. amm	Qual.
Gr. err. singoli divisione fp max	2		10		2		10	
Gr. salto di passo fu max	2		12		4		12	
Scarto di divisione Rp	4				4			
Err. globale di divisione Fp	9		50		8		50	
Err. cordale di divisione Fpz/8	5				4			

Centricità Fr (Ø-sfera =3.75mm) Ⓞ : 4µm



Err. di concentricità Fr	7	32	
Variab. spessore dente Ra			

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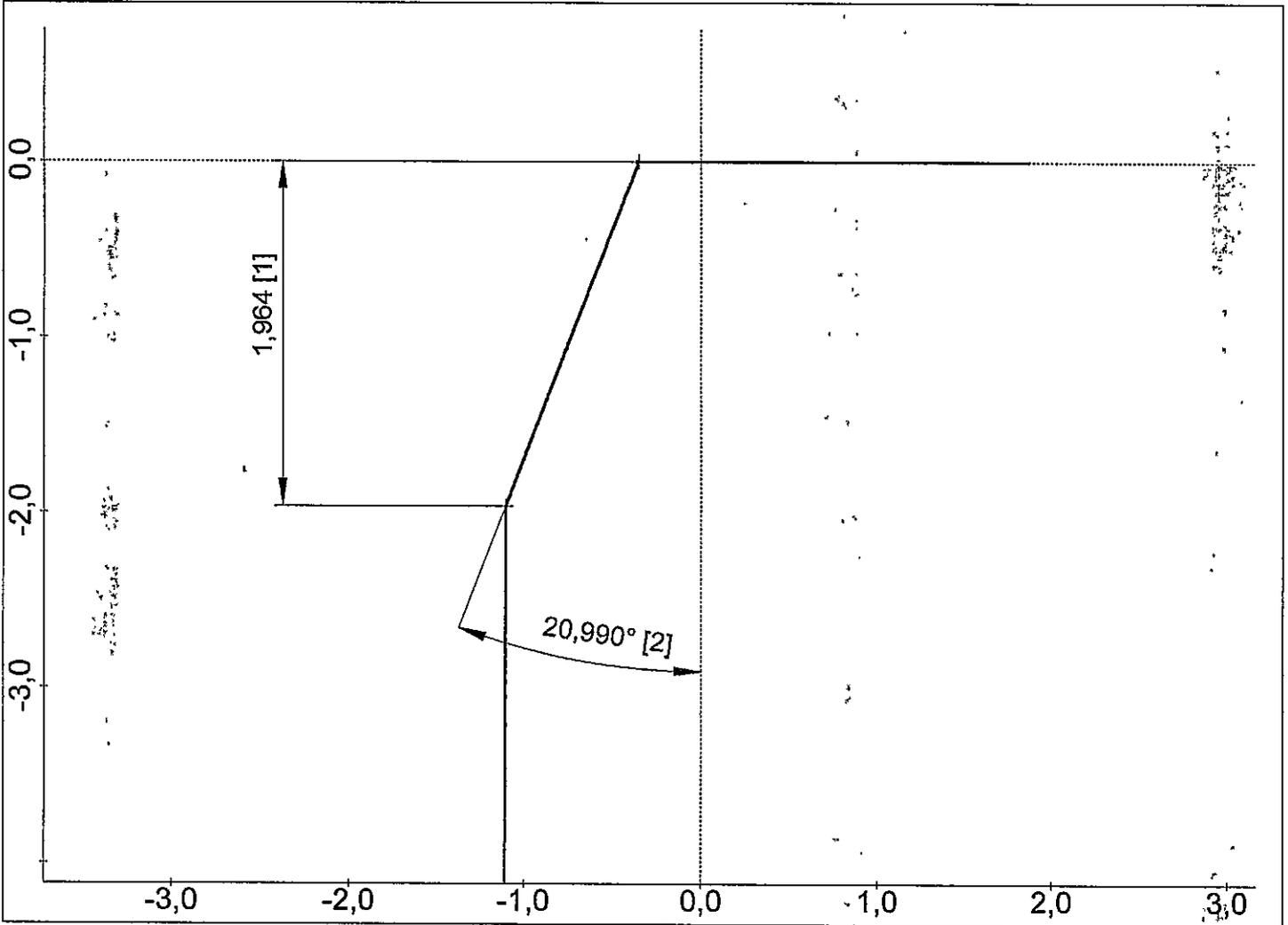




Via dei Ciclamini 4, Modugno (BA)

Oggetto: D2
Numero: 5220
Operatore: TURNO D
Data, ora: 24.08.2017, 09:22
Nota: PART PZ N 1
Tastatore: PCV 350 / 33 mm

Macchina: MOA 416120 002



PERTHOMETER CONCEPT

Area Riservata alla Produzione

Valutazione Profilo

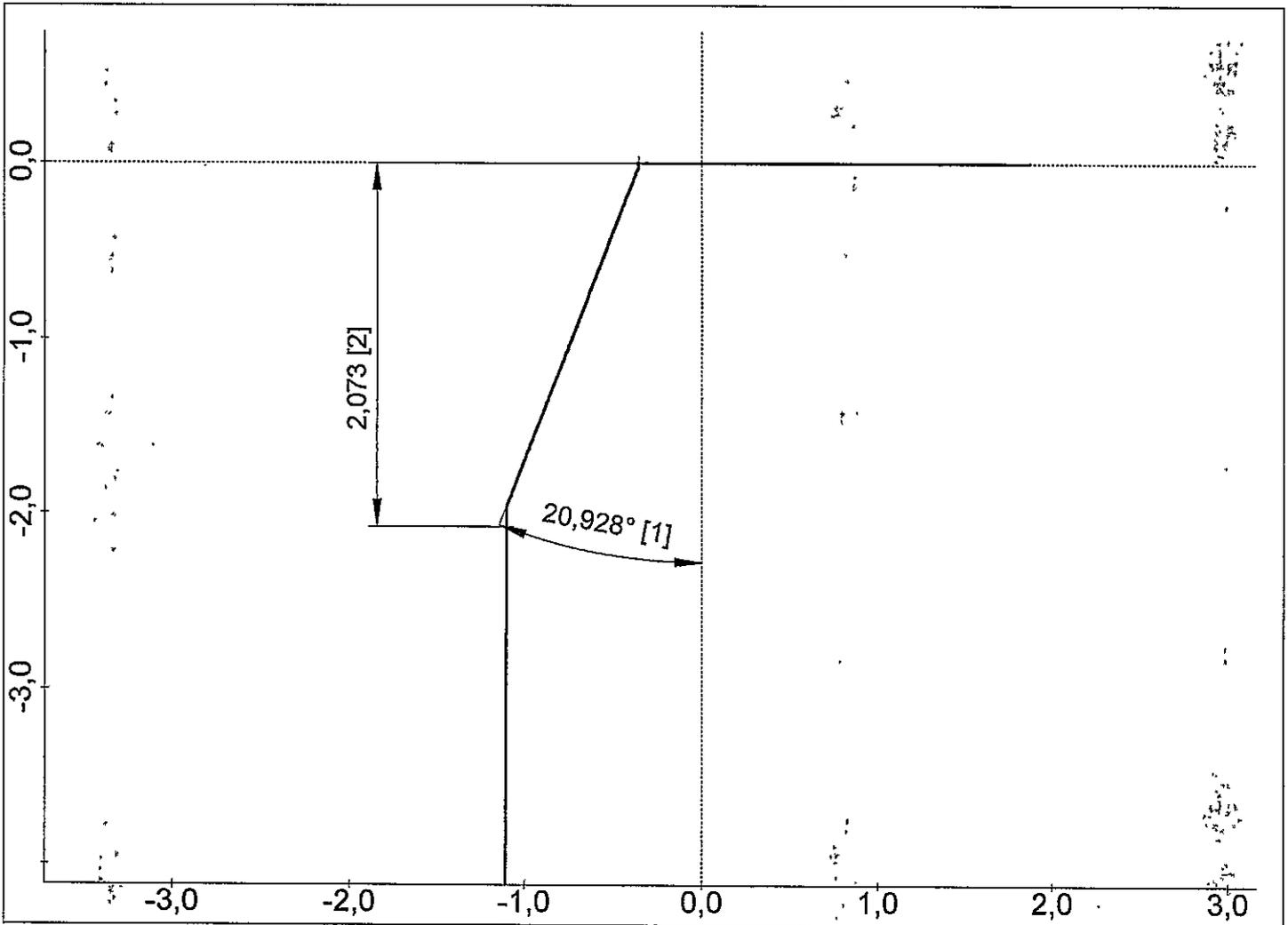
OK

NOK

N°BADGE ODP RICEVENTE

Oggetto: D2
Numero: 5220
Operatore: TURNO D
Data, ora: 24.08.2017, 09:22
Nota: PART PZ N 2
Tastatore: PCV 350 / 33 mm

Macchina: MOA 416120 002



PERTHOMETER CONCEPT

Area Riservata alla Produzione

Valutazione Profilo

OK

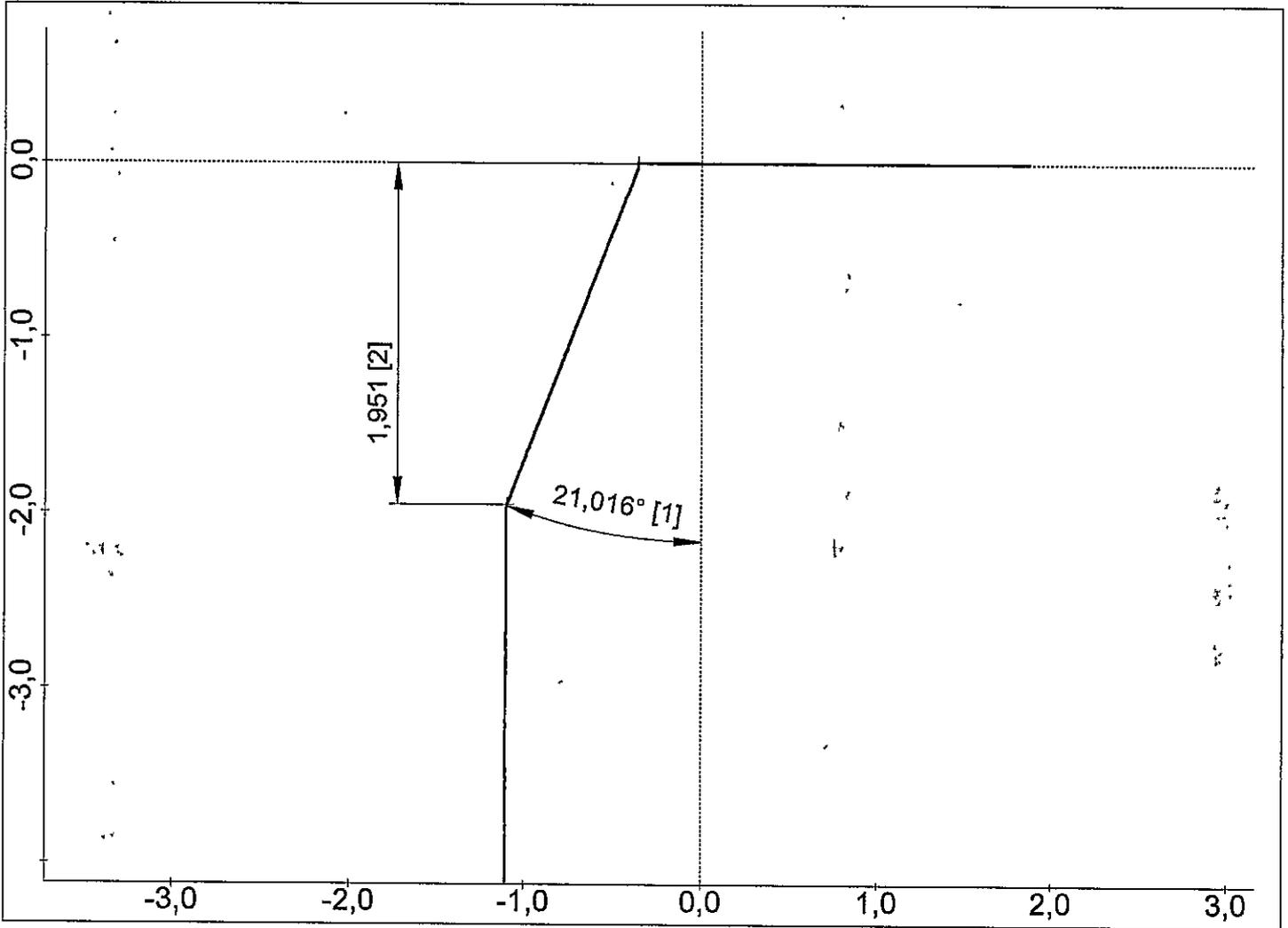
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N°BADGE ODP RICEVENTE



Via dei Ciclamini 4, Modugno (BA)

Oggetto:	D2
Numero:	5220
Operatore:	TURNO D
Data, ora:	24.08.2017, 09:22
Nota:	PART PZ N 3
Tastatore:	PCV 350 / 33 mm
Macchina:	MOA 416120 002



PERTHOMETER CONCEPT

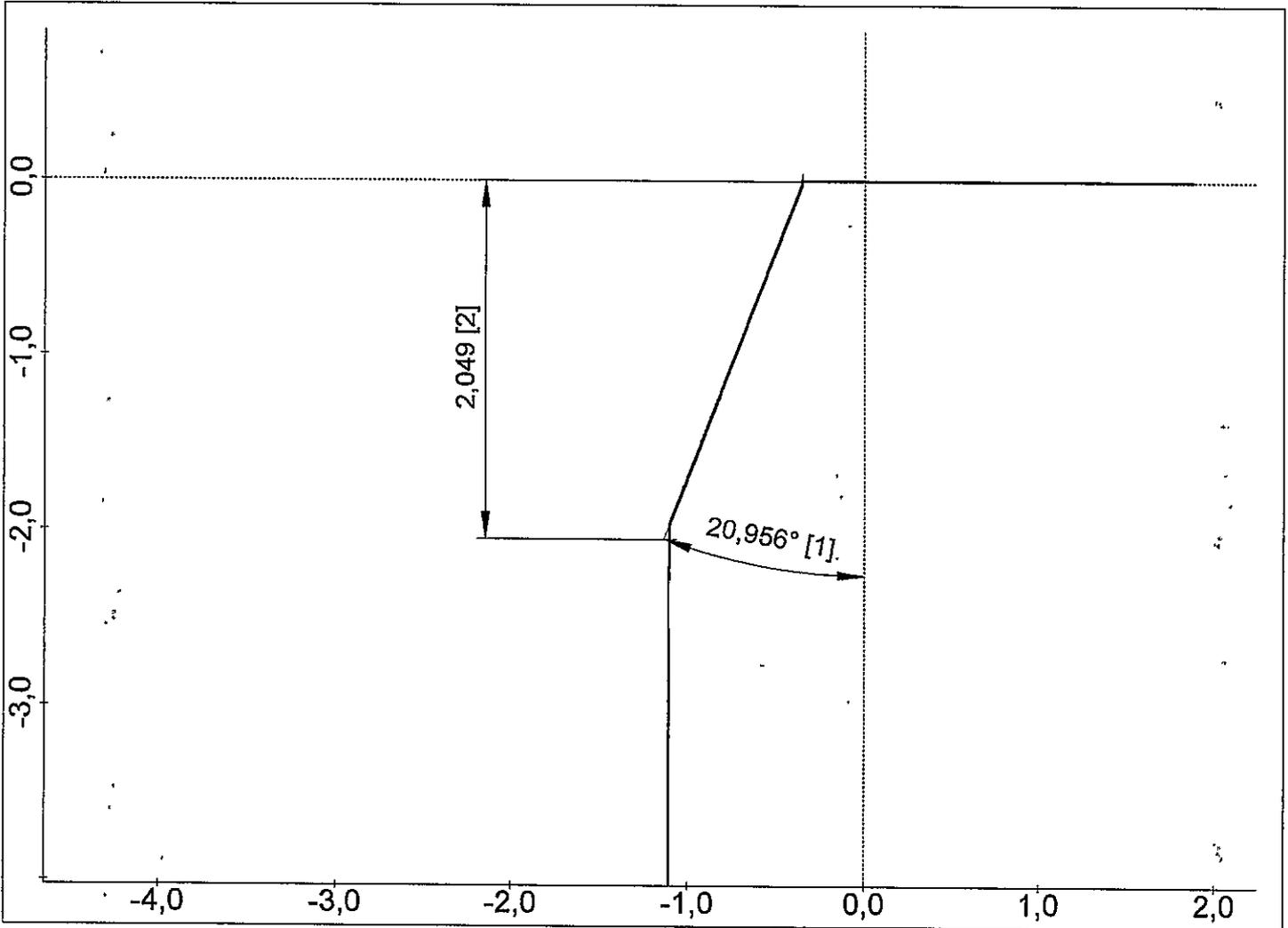
Area Riservata alla Produzione	
Valutazione Profilo	
OK	<input type="checkbox"/>
NOK	<input type="checkbox"/>
N°BADGE ODP RICEVENTE	
<input type="text"/>	



Via dei Ciclamini 4, Modugno (BA)

Oggetto: D2
Numero: 5220
Operatore: TURNO D
Data, ora: 24.08.2017, 09:22
Nota: PART PZ N 4
Tastatore: PCV 350 / 33 mm

Macchina: MOA 416120 002



PERTHOMETER CONCEPT

Area Riservata alla Produzione

Valutazione Profilo

OK

NOK

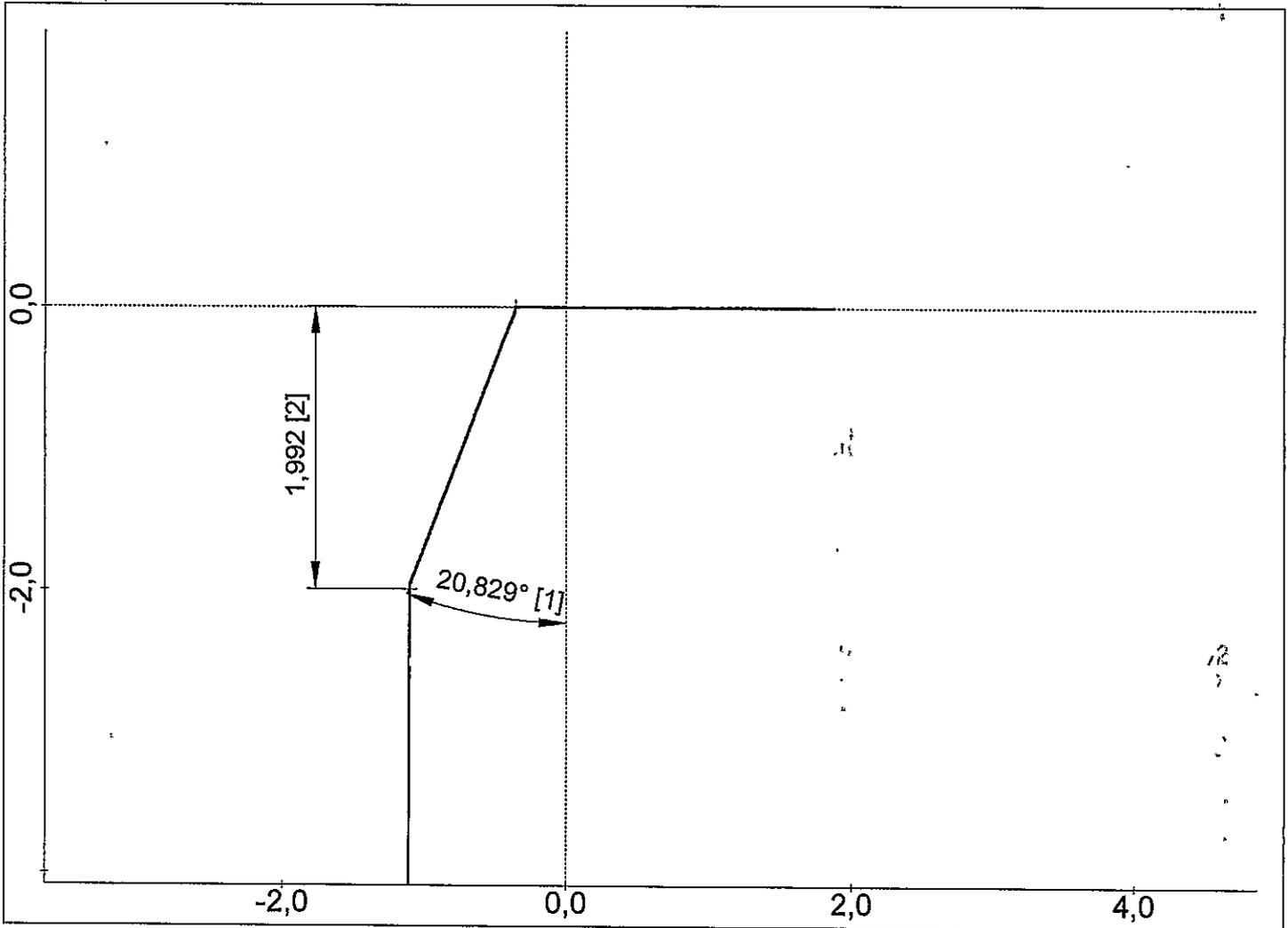
N°BADGE ODP RICEVENTE



Via dei Ciclamini 4, Modugno (BA)

Oggetto: D2
Numero: 5220
Operatore: TURNO D
Data, ora: 24.08.2017, 09:22
Nota: PART PZ N 5
Tastatore: PCV 350 / 33 mm

Macchina: MOA 416120 002



PERTHOMETER CONCEPT

Area Riservata alla Produzione

Valutazione Profilo

OK

NOK

N°BADGE ODP RICEVENTE

New P/N 5221 introduction (FG2 : 5220, Rev Gear: 3693)

PPAP Requirements		Required	Note
1	Design Records	Yes	
2	Authorized Engineering change documents	Yes	see dwg
3	Customer Engineering approval	n.a.	
4	DFMEA	NO	
5	Process flow diagram(s)	NO	
6	PFMEA	Yes	
7	Control plan	Yes	
8	Measurement system analysis studies	NO	
9	Dimensional results	Yes	
10	Records of Material / Performance test results	NO	
11	Initial process studies	NO	
12	Qualified laboratory documentation	NO	
13	Appearance Approval Report (A.A.R.)	n.a.	
14	Sample Production Parts	Yes	
15	Master sample	Yes	
16	Checking aids	n.a.	
17	Customer-Specific Requirements	NO	
18	Part Submission Warrant (PSW)	Yes	

PPAP Docs updated
Yes
Yes
Yes
Yes
Yes
Yes
Yes
Yes

Other requirements		
1	PSW Raw part	NO
2	PSW E.P. part	NO
3	PSW Engagement Rings	NO

