

310756

Aluminiumtechnologie Schmid GmbH
Dieselstraße 4
D-71404 Kurb

Report Number: DEQ-KJ-11-059

Part Number: 2500354800
Part name: Clutch Housing
Change date: 13.12.2011
Index Nr.: 250/5000 Drawing status: B53
Reason of request: 01.1 Initial Submission

Previous PPAP:
Following PPAP:
Transm Typ: 0
Special request:
Order number: 4500298093
BAW-Nr: B68387 + B68388

Request items	Required score	Achieved score
Degree of performance of design records	100	100
Degree of performance of engineering change documents	0	0
Degree of performance of engineering approval	0	0
Degree of performance of Design FMEA	0	0
Degree of performance of process flow chart	100	100
Degree of performance of process FMEA	100	100
Degree of performance of dimensional results	100	75
Degree of performance of material test results	100	100
Degree of performance of performance test results	0	0
Degree of performance of process capability studies	100	75
Degree of performance of measurement system analysis	100	100
Degree of performance of qualified laboratory documentation	0	0
Degree of performance of control plan	100	100
Degree of performance of Part Submission Warrant (PSW)	100	100
Degree of performance of appearance approval results	0	0
Degree of performance of bulk material requirements	0	0
Degree of performance of sample parts	100	100
Degree of performance of master parts	0	0
Degree of performance of specific inspection and production equipment	0	0
Degree of performance of IMDS registration	100	100
Degree of performance of APQP Status report	100	100
Degree of performance of contracts and standards	100	100
Degree of performance of other requirements	0	0

Achieved score: 1250 Final decision: Frei mit Auflagen / approved with condition

Required score: 1300 Closing date: 27.02.2012

Total degree of performance: 96,2% PPAP presentation date: 23.01.2012

Remarks: raw part no.: 250.0.3548.90
raw part drawing index: d / 23.01.2012
Sample parts will be sent to Bari
dimension deviation:
B 68387- lifetime tool - approved
B 68388- 300 pcs. (PPAP lot) - approved with condition (raw area hole M)
PCS (stock material at flange is 0,36-1.24) will be checked once more at the next batch.
Machining result was OK with condition (B68388)
Leak test result after machining founds porosity at hole V



GETRAG Getriebe- und Zahnradwerke
Herbert-Hagenmayer-Str. 2-4 D-71404 Kurb

27.02.2012 gez. Jakob

Name Buyer: Volk

Name STA

GETRAG Innovation Center
Herbert-Hagenmayer-Str. 2-4
71404 Kurb

Copy to Buyer: DEC1 Hr. Volk

Copy to Team: 250

Copy to Plant: NK / DEQ2

Part Submission Warrant

Part Name Kupplungsgehäuse Cust. Part Number 250.0.3548.90
 Shown on Drawing No. 2500354800 Org. Part Number _____
 Engineering Change Level 250 / 5000 Dated 13. Dez. 11 ✓
 Additional Engineering Changes _____ Dated _____
 Safety and/or Government Regulation Yes No Purchase Order No. _____ Bestellnummer _____ Weight (kg) 9,630
 Checking Aid No. _____ Checking Aid Engineering Change Level _____ Cast-Blank Weight (kg) 9,630

ORGANIZATION MANUFACTURING INFORMATION
Aluminiumtechnologie Schmid GmbH
 Organization Name & Supplier/Vendor Code _____
Föhrenbachstr.7
 Street Address _____
Remshalden B. Württemberg 73630 Germany
 City Region Postal Code Country

CUSTOMER SUBMITTAL INFORMATION

 Customer Name/Division Getrag

 Buyer/Buyer Code Herr Volk

 Application Ford

MATERIALS REPORTING
 Has customer-required Substances of Concern information been reported? Yes No n/a
 Submitted by IMDS or other customer format: 204689819/1

Are putty/mold parts identified with appropriate ISO marking codes? Yes No n/a
REASON FOR SUBMISSION (Check at least one)
 Initial Submission Change to Optional Construction or Material
 Engineering Change(s) Supplier or Material Source Change
 Tooling: Transfer, Replacement, Refurbishment, or additional Change in Part Processing
 Correction of Discrepancy Parts Produced at Additional Location
 Tooling Inactive > than 1 year 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
 Test 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 _____ Mold / Form 1 _____

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 240 / 8 hours.
 I also certify that documented evidence of such compliance is on file and available for review. I have noted any deviations from the declaration below.

EXPLANATION/COMMENTS: _____

Is each Customer Tool properly tagged and numbered? Yes No n/a
 Organization Authorized Signature I.A. Zilligen Date 23. Jan 12
 Print Name Blanca Zilligen Phone No. 07151 / 93299-162 Fax No. 07151 / 93299-160
 Title QS E-mail blanca.zilligen@schmid-at.de

FOR CUSTOMER USE ONLY (IF APPLICABLE)
 Part Warrant Disposition: Approved Rejected Other See PPAP- result sheet
 Customer Signature Jakob Date 27.02.2012
 Print Name Jakob Customer Tracking Number (optional) DEQ-KJ-M-059

SUPPLIER CHANGE / DEVIATION REQUEST

Anderungs- / Bauabweichungsantrag



Change / Deviation No. 68387
 Änderungs- / Bauabweichungsnummer

Issue Date: 01.02.2012
 Ausgestellt am:

STATUS
 02-February-2012
 Not approved

Supplier and part / product information	SUPPLIER NAME Aluminium Technologie Schmid GmbH, D-73630 Remshalden-Grurbach	
	MANUFACTURING SITE CODE	
	PART NAME AND PART NUMBER OF ASSEMBLY AND ITS COMPONENTS Clutch housing 250.0.3548.90 (GE3548-01)	
	AFFECTED GETRAG PRODUCTS or PROGRAMS Ford B-Car, C-Car	
	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: Lifetime tool	
	Site/location change: INDICATE TYPE OF SITE/LOCATION CHANGE <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: DETAIL DF-DF (SHEET 2) DISTANCE 91,5 ± 0,4 IS 90,951 DETAIL DF-DF (SHEET 2) DISTANCE 14,75 +0,1/-0,2 IS 14,137 PURPOSE OF CHANGE:	

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	Yes		
	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	Yes		
	Logistics: Packaging / Shipping	NO		
	Tooling revisions/movement	NO		
	Facility changes	NO		
PPAP Submission Level	1			
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 Zillgen	Title QS	Phone +497151/93299-152	e-mail
Signature	Proposed Implementation date of the change.		Tier 1 approval of sub tier change request

SUPPLIER CHANGE / DEVIATION REQUEST
Änderungs- / Bauabweichungsantrag



Change / Deviation No. 68387
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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	Design and Release Engineer / Manager Component	PD Resident Engineer (Plant)
	Jakob approved 01.02.2012	PRINT NAME SIGNATURE DATE Michael Basslor APPROVED 2012-02-03	PRINT NAME SIGNATURE DATE N. Achille Approved w cond. 2012-02-20 M. Colapietro Approved w cond. 2012-02-23
	Negative cost effect for GETRAG identified? <input type="checkbox"/> YES x NO	Design and Release Manager Component	Plant Quality Manager / Manufacturing Engineering
If YES, rejection recommended <input type="checkbox"/> (please state below)	PRINT NAME SIGNATURE DATE	PRINT NAME SIGNATURE DATE (ME) G.Cuscato Approved 20/02/2012	
Buyer (only for non-design related changes)	Program Engineering Supervisor System	Plant Logistic Manager	
PRINT NAME SIGNATURE DATE	PRINT NAME SIGNATURE DATE	PRINT NAME SIGNATURE DATE	
Additional approval required if Critical Characteristics (C. A. inverted delta (∇)) are affected			
STA/SQA Manager	Chief Program Engineer System	Customer Approval (attached)	
PRINT NAME SIGNATURE DATE	PRINT NAME SIGNATURE DATE	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		Materials Engineer	
PRINT NAME SIGNATURE DATE	PRINT NAME SIGNATURE DATE		
Reason for rejection or qualifying condition(s) of acceptance (for example, recommended GETRAG plant functional trials)			
<p>N.Achille (PD): Approval from Assy line required. It's required a review of the raw part drawing, due to wrong reference in dimension.</p> <p>M. Colapietro: The surface located at the dimension 91.5 from the flange II is used as back-up for the pressing operation of the seal ring. The counter-holder is locked by a wedge which is position controlled by the machine. With this dimensional change, the wedge position can change consequently and could not be detected by the machine. A test with border line parts (10 pcs) is necessary to figure out this potential issue.</p>			

SUPPLIER CHANGE / DEVIATION REQUEST
Änderungs- / Bauabweichungsantrag



Change / Deviation No. 68388
 Änderungs- / Bauabweichungsnummer

Issue Date: 01.02.2012
 Ausgestellt am:

STATUS
 02-February-2012
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Supplier and part / product information	SUPPLIER NAME Aluminum Technologie Schmid GmbH, D-73630 Reinsalden-Grünbach	
	MANUFACTURING SITE CODE	
	PART NAME AND PART NUMBER OF ASSEMBLY AND ITS COMPONENTS Clutch housing 250.0 3548.90 (GE3548-01)	
	AFFECTED GETRAG PRODUCTS or PROGRAMS	
Change Description	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: 300 pcs. (PPAP-batch)	
	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: DETAIL M-M (SHEET 1) POSITION 0,8 IS 0,979 DETAIL T2-T2 (SHEET 1) DISTANCE 62,59 ± 0,3 IS 62,028 DETAIL DF-DF (SHEET 2) STOCK 1,2 ± 0,3 IS 0,36 TO 1,24 DETAIL OD-OD (SHEET 3) POSITION 0,8 IS 0,880	
	AFFECTED GETRAG PLANT(S) BARI	
	PURPOSE OF CHANGE: DEVIATION WILL BE CHANGED AT THE NEXT CASTING BATCH	

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	Yes		
	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	Yes		
	Logistics: Packaging / Shipping	NO		
	Tooling revisions/movement	NO		
	Facility changes	NO		
	PPAP Submission Level	I		
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

SUPPLIER CHANGE / DEVIATION REQUEST
Änderungs- / Bauabweichungsantrag



Change / Deviation No. 68388
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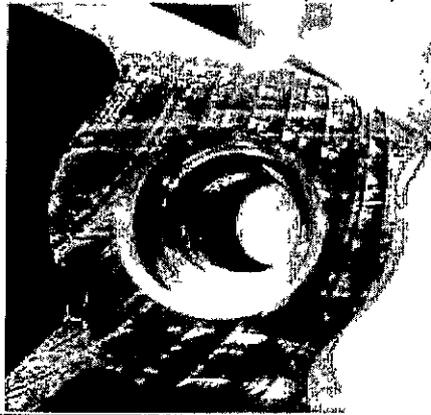
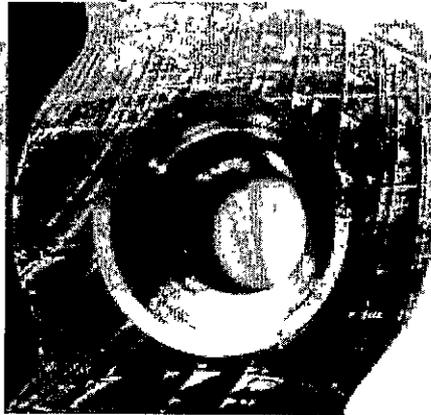
SRGA Form – Approvals

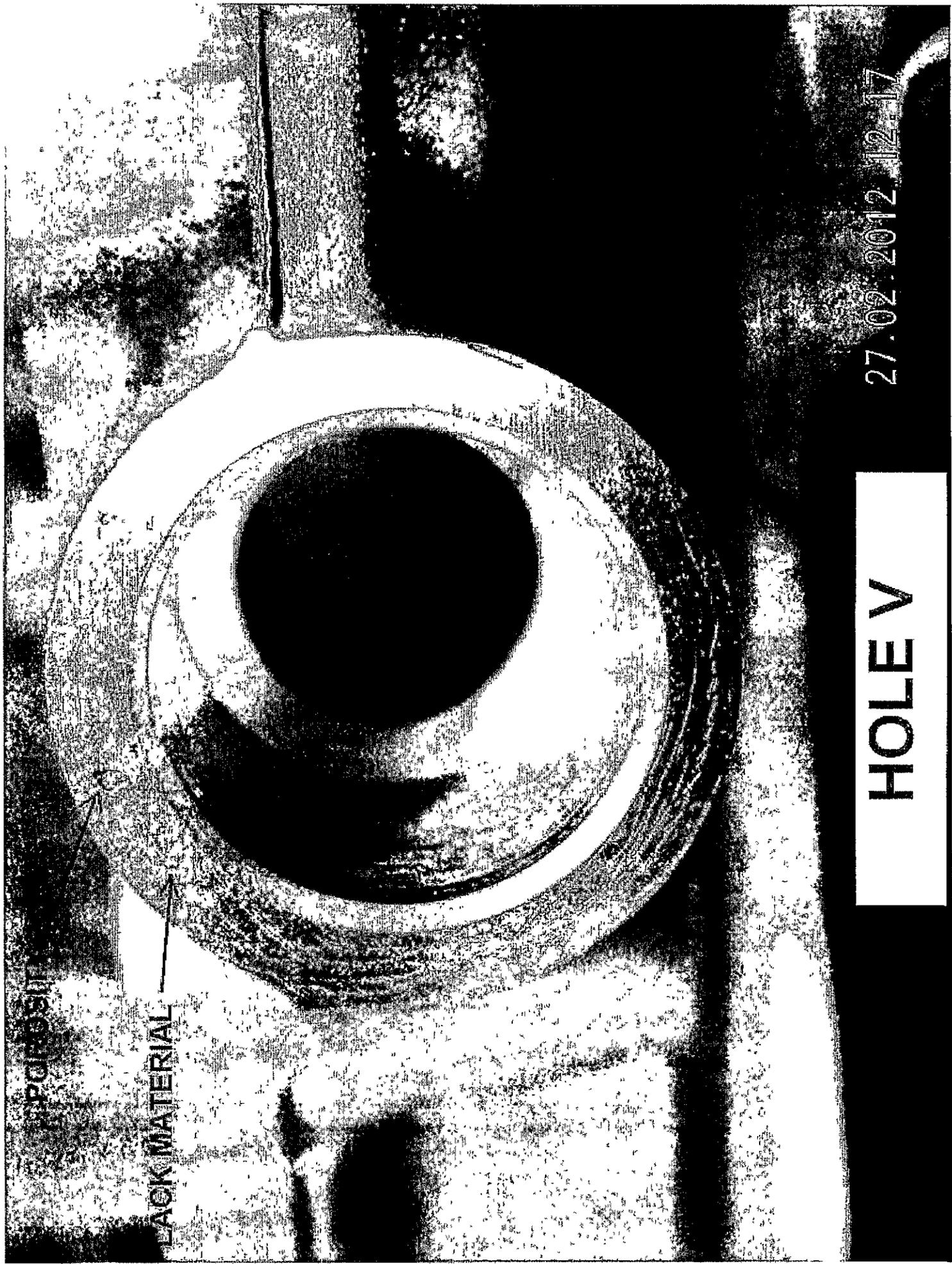
GETRAG approvals for changes affecting production parts (including deviation)					
Parts without Critical Characteristics	Purchasing	Product Development Engineering		Receiving GETRAG Plant	
	STA/SQA Engineer PRINT NAME SIGNATURE DATE Jakob approved 01.02.2012	Design and Release Engineer / Manager Component PRINT NAME SIGNATURE DATE Michael Bassler APPROVED 2012.02.03		PD Resident Engineer (Plant) PRINT NAME SIGNATURE DATE N. Achille Approved w condition 06/02/2012	
	Negativo cost effect for GETRAG identified? <input type="checkbox"/> YES * <input checked="" type="checkbox"/> NO	Design and Release Manager Component PRINT NAME SIGNATURE DATE		Plant Quality Manager / Manufacturing Engineering PRINT NAME SIGNATURE DATE (ME) G. Cuscito Approved w cond. 20/02/2012	
	If YES, rejection recommended <input type="checkbox"/> (please state below)	Program Engineering Supervisor System PRINT NAME SIGNATURE DATE		Plant Logistic Manager PRINT NAME SIGNATURE DATE	
Buyer (only for non-design related changes) 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)**

N. Achille: High risk of non clean up surfaces. Machining line has to confirm the possibility to machine in center of tolerance the alignment references between raw and machined part (i.e. distance 2 ± 0.25 from **CP** to **H**).
 100% visual check required.

G. Cuscito (ME Bari): We report the presence of rough material in hole M as in the photo attached. PD must say if this is ok.



SPURRING

LACK MATERIAL

HOLE V

27.02.2012 12:17