

313045



**GETRAG**

Production Part Approval

**DIMENSIONAL TEST RESULTS**

Organization:	<b>GETRAG</b>	Part Number:	<b>250.1.5186.75</b>
Supplier/Vendor Code:	<b>GETRAG Modugno</b>	Part Name:	<b>Ring gear</b>
INSPECTION FACILITY:	<b>NA</b>	Design Record Change Level:	<b>a 35331</b>
		Engineering Change Documents:	
Organization Measurement Results (Data)			

Item	Dimension/Specification	Specification / Limits	Test Date	Qty. Tested	1	2	3	4	5	test distruttivo	Ok	Not Ok
1	Bore diameter 116	0,022 0,000		5	116,019	116,021	116,019	116,019	116,019		ok	
2	Bore roughness	0,0063 0,0000		5	0,0015	0,0019	0,0020	0,0025	0,0019		ok	
3	Tip diameter 202,9	202,9 202,6		5	202,643	202,644	202,644	202,644	202,644		ok	
4	Root diameter 189,1	189,100 188,650		5	188,835	188,834	188,832	188,834	188,834		ok	
5	Teeth runout	0,032 0,000		5	0,021	0,020	0,020	0,020	0,020		ok	
6	Bore perpendicularity	0,02 0,00		5	0,003	0,003	0,002	0,002	0,002		ok	
7	Teeth roughness	0,004 0,000		5	0,001	0,002	0,002	0,002	0,002		ok	
8	Bore diameter 10,5 (10 fori)	0,2 -0,2		5	ok	ok	ok	ok	ok		ok	
9	Position bore diameter 10,5 (10 fori)	0,2 0,0		5	ok	ok	ok	ok	ok		ok	
10	MDK	201,370 201,302		5	201,314	201,322	201,328	201,338	201,321		ok	
11	M1 HRA 80,5	2,5 0,0		1						81,40	ok	
12	M2 CHD 550 0,5	0,4 0,0		1						0,75	ok	
13	M3 HV10 min 300	-- --		1						393,00	ok	
14	Teeth roughness Rz max	0,0063 --		5	0,0019	0,0031	0,0033	0,0027	0,0025		ok	
15	Microgeometry	-- --		5	ok	ok	ok	ok	ok		ok	
16	Particular Z	-- --		5	ok	ok	ok	ok	ok		ok	
17	Chamfer	-- --		5	ok	ok	ok	ok	ok		ok	
18	Total tickness 27	27,1 26,9		5	27,052	27,063	27,081	27,069	27,063		ok	
19	Technical Cleanliness GN 4240-1	OK NOK		5	OK	OK	OK	OK	OK		ok	
20	Particular B-B	0,5 0,1		5	0,3	0,3	0,4	0,3	0,3		ok	
21	Chamfer 0,7	1,1 0,3		5	0,760	0,752	0,708	0,712	0,729		ok	
22	Chamfer 1	1,5 0,5		5	0,729	0,724	0,716	0,711	0,711		ok	
23	Roughness Rz 16	0,016 0,000		5	0,0025	0,0025	0,0028	0,0033	0,0025		ok	
24	Parallelism 8x0,05	0,05 0,0		5	OK	OK	OK	OK	OK		ok	
25	Chamfer 0,7	1,1 0,3		5	0,709	0,735	0,858	0,846	0,740		ok	
26	Chamfer 1	1,5 0,5		5	0,8	0,8	1,0	1,1	0,8		ok	
	Different parameters by RG 250 1 5187 75											
	Parameters not changed but belong at Teeth											
	As RG 250 1 5187 75											

March 2008

CFG-1003

SIGNATURE	TITLE	DATE
G. Russo	QPE	29/08/2014