

Change Request <input type="checkbox"/>	Change Order <input checked="" type="checkbox"/>	Initiator of Change	
Reason for Change Drawings distribution		External: Customer <input type="checkbox"/>	Supplier <input type="checkbox"/>
		Internal: <input checked="" type="checkbox"/>	
Reference German change order: C005481_MIP_1		Issued by:	
		Team: BWLQ1 Name: M. Di Pasquale Date: July, 19th 2017	

Description of Change
Only drawing release

Distribution List	Drawings (DDA)	Change Information		Drawings (DDA)	Change Information
Issuer	<input type="checkbox"/>	<input checked="" type="checkbox"/>	BWLQ1: Central Quality	<input type="checkbox"/>	<input checked="" type="checkbox"/>
B/ELE1: Product Engineering	<input type="checkbox"/>	<input checked="" type="checkbox"/>	BWLQ3: Customer Service	<input type="checkbox"/>	<input checked="" type="checkbox"/>
B/ELE2/3: Testing	<input type="checkbox"/>	<input checked="" type="checkbox"/>	BWLQ2: Metallurgical Laboratory	<input type="checkbox"/>	<input checked="" type="checkbox"/>
B/WLP: ME	<input type="checkbox"/>	<input checked="" type="checkbox"/>	B/GPS1: Production line - Gears	<input type="checkbox"/>	<input checked="" type="checkbox"/>
B/EX: Program management	<input type="checkbox"/>	<input checked="" type="checkbox"/>	B/GPS2: Production line - Shafts	<input type="checkbox"/>	<input type="checkbox"/>
B/BLF: Finance & Controlling	<input type="checkbox"/>	<input type="checkbox"/>	B/GPS3: Housings	<input type="checkbox"/>	<input type="checkbox"/>
B/EEL: Logistics	<input type="checkbox"/>	<input type="checkbox"/>	B/GPS4: Assembly line	<input type="checkbox"/>	<input checked="" type="checkbox"/>
B/WLQ4: SQA	<input type="checkbox"/>	<input checked="" type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>
B/WLQ4: Incoming Inspection	<input type="checkbox"/>	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>

Getrag Plants					
DEU: Unterguppenbach	<input type="checkbox"/>	<input type="checkbox"/>	GEC: Sterling Heights	<input type="checkbox"/>	<input type="checkbox"/>
DEL: Ludwigsburg	<input type="checkbox"/>	<input type="checkbox"/>	GPG: Charlestone	<input type="checkbox"/>	<input type="checkbox"/>
DEN: Neuenstein	<input type="checkbox"/>	<input type="checkbox"/>	GFT: Köln	<input type="checkbox"/>	<input type="checkbox"/>
DER: Rosenberg	<input type="checkbox"/>	<input type="checkbox"/>	GFT: Kechnec	<input type="checkbox"/>	<input type="checkbox"/>
DEW: Bad Windsheim	<input type="checkbox"/>	<input type="checkbox"/>	GTC: Detroit	<input type="checkbox"/>	<input type="checkbox"/>
	<input type="checkbox"/>	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>

Customers					
C'HANGAN: Chongqing (CN)	<input type="checkbox"/>	<input type="checkbox"/>	FORD: Detroit (US)	<input type="checkbox"/>	<input type="checkbox"/>
CUMMINS: Darlington (US)	<input type="checkbox"/>	<input type="checkbox"/>	LAND ROVER: Longbridge (UK)	<input type="checkbox"/>	<input type="checkbox"/>
GME: Rüsselsheim (DE)	<input type="checkbox"/>	<input type="checkbox"/>	NAMG: Longbridge (UK)	<input type="checkbox"/>	<input type="checkbox"/>
GMB: São Paulo Brazil (BR)	<input type="checkbox"/>	<input type="checkbox"/>	RENAULT: Paris (FR)	<input type="checkbox"/>	<input type="checkbox"/>
GM-NAO & SATURN: Detroit (US)	<input type="checkbox"/>	<input type="checkbox"/>	ROVER: Longbridge (UK)	<input type="checkbox"/>	<input type="checkbox"/>
FIAT: Torino (IT)	<input type="checkbox"/>	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>
	<input type="checkbox"/>	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>

Remarks	BP <input type="checkbox"/>

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2 Info

Specification of: - Feed rate additional to Rz value for the hard-turned cone surfaces.
This change is only for Bari, affected all gear drawings with hard turned cone and all customer except Ford SG Rev.

3 Spare parts

- No impact on Spare parts -

4 Drawing Distribution

- **2501438175** **SPEED GEAR 1ST CPL.** **AE " b " from 18.05.2017**
(Maturity level of specification F approved)
E/3: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.
- **2501438075** **SPEED GEAR 1ST CPL.** **AE " c " from 18.05.2017**
(Maturity level of specification F approved)
E/3: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.
- **2501437875** **SPEED GEAR 1ST CPL.** **AE " d " from 18.05.2017**
(Maturity level of specification F approved)
E/3: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.
- **2501470375** **SPEED GEAR 1ST CPL.** **AE " c " from 18.05.2017**
(Maturity level of specification F approved)
E/3: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.
- **2501520375** **SPEED GEAR 1ST CPL.** **AE " c " from 18.05.2017**
(Maturity level of specification F approved)

E/3: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501471075** **SPEED GEAR 1ST CPL.** **AE " c " from 18.05.2017**
(Maturity level of specification F approved)
E/3: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501422175** **SPEED GEAR 3RD.** **AE " k " from 23.05.2017**
(Maturity level of specification F approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501422178** **SPEED GEAR 3RD.** **AE " g " from 23.05.2017**
(Maturity level of specification F approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501364175** **SPEED GEAR 3RD.** **AE " j " from 23.05.2017**
(Maturity level of specification F approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501364177** **SPEED GEAR 3RD.** **AE " f " from 23.05.2017**
(Maturity level of specification F approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501516975** **SPEED GEAR 3RD.** **AE " g " from 23.05.2017**
(Maturity level of specification F approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501516976** **SPEED GEAR 3RD.** **AE " e " from 23.05.2017**
(Maturity level of specification F approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501364234** **SPEED GEAR 4TH CPL.** **AE " d " from 23.05.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501364237** **SPEED GEAR 4TH CPL.** **AE " f " from 23.05.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- **2501364238** **SPEED GEAR 4TH CPL.** **AE " f " from 23.05.2017**
(Maturity level of specification F approved)

B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol UPDATED.

- **2501387535** **SPEED GEAR 4TH CPL.** **AE " e " from 23.05.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol UPDATED.

- **2501387536** **SPEED GEAR 4TH CPL.** **AE " d " from 23.05.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol UPDATED.

- **2501422637** **SPEED GEAR 6TH CPL.** **AE " g " from 18.05.2017**
(Maturity level of specification F approved)
F/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- **2501422638** **SPEED GEAR 6TH CPL.** **AE " c " from 18.05.2017**
(Maturity level of specification F approved)
F/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- **2501387735** **SPEED GEAR 6TH CPL.** **AE " e " from 18.05.2017**
(Maturity level of specification F approved)
F/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- **2501387736** **SPEED GEAR 6TH CPL.** **AE " c " from 18.05.2017**
(Maturity level of specification F approved)
F/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- **2501422807** **SPEED GEAR REV CPL.** **AE " b " from 03.07.2017**
(Maturity level of specification 3 approved)
C/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol UPDATED.

- **2501364178** **SPEED GEAR 3RD** **AE " b " from 26.06.2017**
(Maturity level of specification 3 approved)
B/7: Text: "FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol UPDATED.

- **2501439035** **SPEED GEAR 4TH CPL** **AE " a " from 03.07.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- **2501470535** **SPEED GEAR 4TH CPL** **AE " c " from 03.07.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- **2501522835** **SPEED GEAR 4TH CPL** **AE " a " from 03.07.2017**
(Maturity level of specification F approved)
B/5: Text: "FOR INFORMATION: FEED MOTION..." ADDED.

- 2501364808 SPEED GEAR REV CPL AE " b " from 03.07.2017
(Maturity level of specification 3 approved)
C/7: Text:"FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

- 2501364805 SPEED GEAR REV CPL AE " c " from 03.07.2017
(Maturity level of specification F approved)
C/7: Text:"FOR INFORMATION: FEED MOTION..." ADDED; B/4: CHD Symbol
UPDATED.

5 Instructions

- The modification must be followed from all affected departments.
- The old drawing must be replaced.
- GPS1 department has to take a break point, for modification referred to:
 - 2501438175;
 - 2501438075;
 - 2501437875;
 - 2501470375;
 - 2501520375;
 - 2501471075;
 - 2501422175;
 - 2501422178;
 - 2501364175;
 - 2501364177;
 - 2501516975;
 - 2501516976;
 - 2501364234;
 - 2501364237;
 - 2501364238;
 - 2501387535;
 - 2501387536;
 - 2501422637;
 - 2501422638;
 - 2501387735;
 - 2501387736;
 - 2501422807;
 - 2501364178;
 - 2501439035;
 - 2501470535;
 - 2501522835;
 - 2501364808;
 - 2501364805.
- **#MTC C005481#: THE CHANGE IS READY TO BE IMPLEMENTED. THE CHAMPION HAS TO MAKE SURE THAT ALL CHECK LIST ACTIVITIES ARE COMPLETE BEFORE KICKING OFF THE MODIFICATION. BREAK POINT MUST BE COMMUNICATED TO ELE1.**

6 Breakpoint request

Data di comunicazione modifica: DATE OF THE CHANGE ORDER:		Numero di comunicazione modifica: CHANGE ORDER NUMBER:				
Codice pezzo: PART NUMBER:		Denominazione: PART NAME:				
PRODUZIONE PRODUCTION	Codice pezzo: PART NUMBER COMPONENT:					
	Data di produzione: PRODUCTION DATE:					
	Data di uscita: DELIVERY DATE:			Firma: SIGNATURE:		
MONTAGGIO ASSEMBLY	Tipo di cambio: TRANSMISSION VARIANT:					
	Data di montaggio: ASSEMBLY DATE:					
	1° numero cambio: 1ST TRANSMISSION AFFECTED BY THE CHANGE:			Firma: SIGNATURE:		
SPEDIZIONE LOGISTICS	Termine di consegna: DELIVERY DATE:					
	Data di uscita: DELIVERY DATE:			Firma: SIGNATURE:		
Osservazioni: REMARKS:						
Destinatari: DISTRIBUTION LIST:	✓				✓	
Reparto: DEPARTMENT:	GPS1	GPS2	GPS3	GPS4	ELE 1	
Data: DATE:						

FOGLIO PARAMETRI PROCESSO
(PROCESS PARAMETERS SHEET)

Nome Componente: Ruote/Corona 250/300	Codice componente: TUTTI
Macchina:EMAG	Codice macchina: Tutte

Parametri di taglio F ed S

NON VARIABILI fatta eccezione per avanzamenti tornitura cono in funzione della rugosità e nei range di seguito indicati:

DCT 250

Avanzamento cono	Range
Tutte i componenti DCT250	Min 0,07 Max 0,11
Tutte i componenti DCT250 nel caso di Rz < 2.0 µm	Min 0,11 Max 0,12
Solo SRRW – 2501364805	Min 0,05 Max 0,09

Parametri programma MPF DCT 250 / DCT 300

Parametro	descrizione	Range
R801	N.RO PROGRAMMA DI LAVORAZIONE	=1xxx
R804	N.RO PROGRAMMA SGROSSATURA	=9xxx
R805	N.RO PROGRAMMA UTENSILI	=5xxx
R809	N.RO PROGRAMMA CORREZIONI MARPOSS	=6xxx
R704	CONTROLLO PLANARITA'	= 1 (ATTIVO)
R890	CORSA MANDRINO DI SERRAGGIO - SBLOCCATO	VALORE APERTO +1 Min
R891	CORSA MANDRINO DI SERRAGGIO - MAX CON PZ	VALORE PZ SERRATO +5/+10
R892	CORSA MANDRINO DI SERRAGGIO - MIN CON PZ	VALORE PZ SERRATO -5/-10
R893	CORSA MANDRINO DI SERRAGGIO - EXTRACORSA CHIUSO	VALORE CHIUSO -1 Min
R831	POS Z SOPRA PEZZO GREZZO IN FASE DI CARICO	IN FUNZ. DELLA PRESA PZ
R832	POS Z SOPRA PEZZO GREZZO CON PICKUP PREMUTA	IN FUNZ. DELLA PRESA PZ
R833	POSIZ Z DOPO CARICO PEZZO GREZZO	IN FUNZ. DELLA PRESA PZ
R835	POSIZIONE DI ACCOSTAMENTO Z SU PEZZO GREZZO	IN FUNZ. DELLA PRESA PZ
R836	VALORE AVANZAMENTO PER ACCOSTAM. A QUOTA R832	IN FUNZ. DELLA PRESA PZ
R837	POSIZ ASSE C IN FASE DI CARICO	IN FUNZ. DELLA PRESA PZ
R849	VARIAZIONE ANGOLO DOPO TENTATIVO DI PRESA NOK	IN FUNZ. DELLA PRESA PZ
R851	POSIZIONE Z CON PEZZO FINITO SU PICK UP	IN FUNZ. DELLA PRESA PZ
R852	POSIZIONE Z SCARICO PEZZO FINITO SU PICK UP	IN FUNZ. DELLA PRESA PZ

Record Owner: PAPAGNA F.	Date Issued: 31.10.2012	GIS1 Item Number: 28.04 / C+12	Page: 1 / 2
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FOGLIO PARAMETRI PROCESSO
(PROCESS PARAMETERS SHEET)

PARAMETRI UTENSILI

Geometria L1 ed L2 secondo piano utensili con tolleranza +/- 0,5mm per L1 e +/- 10 mm per L2.

Range Usura Utensile L1 e L2 +/-0.5

In caso di variazione tutti i programmi "L5xxx" corrispondenti devono essere aggiornati

STORIA DELLE MODIFICHE:

- Ed. 01 - 5/10/2012 – aggiunti parametri avanzamento cono per nuova variante 2501364804
- Ed. 02 - 17/11/2014 – Inserito formato GIS
- Ed. 03 - 10/01/2017– Introdotti parametri per DCT 300
- Ed. 04 - 30/03/2017– Modificati codici di riferimento SRRW DCT250
- Ed. 05 - 14/09/2017– Modificati parametri avanzamento cono per DCT 250 secondo specifiche espresse su disegno finito e VBZ

Record Owner: PAPAGNA F.	Date Issued: 31.10.2012	GIS1 Item Number: 28.04 / C+12	Page: 2 / 2
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