

SUPPLIER CHANGE / DEVIATION REQUEST
Änderungs- / Bauabweichungsantrag



310454
GETRAG
SRGA

Change / Deviation No. 70211
 Änderungs- / Bauabweichungsnummer

Issue date: 24-May-2013
 Ausgestellt am:

STATUS
 15-May-2013
 Not Approved

.0088.43Supplier and part / product	SUPPLIER Getrag. S.p.A.		
	MANUFACTURING SITE CODE		
	PART NAME AND PART NUMBER OF ASSEMBLY AND ITS COMPONENTS Clutch Housing 2500332100		
	AFFECTED GETRAG PRODUCTS or PROGRAMS DCT 250 Renault K9K X98		
Change Type	Manufacturing Process Change <input checked="" type="checkbox"/> Heat Treat affected? <input type="checkbox"/> Special Characteristics affected? <input type="checkbox"/> YES <input 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	Quantity: 100 parts	
	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:		AFFECTED GETRAG PLANT(S) Getrag S.p.A.
	1. Position hole T1 required 0.1mm is 0.203 max.		
	2. Parallelism flange D required 0.03mm is 0.071 max.		
	3. Parallelism flange F required 0.03mm is 0.087 max.		
4. Position hole V required 0.3mm is 0.355 max.			
5. Position holes TRS1 – TRS2 required 0.1mm is 0.139 max.			
6. Concentricity Ø 57 CA1-CA2 required 0.1mm is 0.127 max.			
7. Position of raw hole G3 required 0.8mm is 1.141 max (supplier DGH action needed).			
8. Position of Pocket D required 0.1mm is 0.256 max (Ø = 10.022 mm).			
9. Position of CA11, CA12, CA14 threads required 0.3mm is 0.836 max (supplier DGH analysis and action needed).			
10. Position of CA21, CA22, CA24 threads required 0.3mm is 0.609 max (supplier DGH analysis and action needed).			
11. Distance SD2 to H required 6.1mm max is 6.139 max.			
12. Distance TRS1 – TRS2 to P required 39.4 mm min is 39.390 min.			
13. Position of thread W4 required 0.4 mm is 0.892 max (supplier DGH analysis and action needed).			
14. Distance TR1 to D required 143.120 mm max is 143.178 max.			
15. Distance TR2 to D required 154.170 mm min is 154.153 min.			
16. Ø PT0 reproduced with drill tool Ø 10 for cost saving.			
17. Concentricity CA13 – CA23 required 0.2 mm is 0.791 max (supplier DGH analysis and action needed).			
18. Cone Z2 distance to D required min 170.96 mm is 160.428 min.			
19. Distance PT0 to G required max 15.03 mm is 17.27 mm.			
Corrective action:			
1. Set up of the zero points in machine.			
2. Fine tuning of tool set up.			
3. Fine tuning of cut parameters.			
4. Supplier DGH analysis and action needed.			
5. Correction of Nominal Measure on 3D Zeiss Machine.			

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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	<u>no</u>		
	Component tolerance stack-up	<u>no</u>		
	Supplier engineering specification	<u>no</u>		
	Material Specification incl. IMDS update	<u>no</u>		
	Supplier Design FMEA	<u>no</u>		
	Supplier DV Test(s)	<u>no</u>		
	Supplier Software update (incl. interface)	<u>no</u>		
	Process Flow Chart	<u>no</u>		
	Supplier Process FMEA	<u>no</u>		
	Control Plan	<u>no</u>		
	Process Information/Operator Instructions	<u>no</u>		
	Process and/or Gauge Capability	<u>no</u>		
	Sub-Supplier Effect	<u>no</u>		
	Logistics: Packaging / Shipping	<u>no</u>		
	Tooling revisions/movement	<u>no</u>		
	Facility changes	<u>no</u>		
	PPAP Submission Level	<u>no</u>		
Functional Check at GETRAG Plant	<u>no</u>			

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:	Title	Phone	e-mail
Signature	Proposed Implementation date of the change:		Tier 1 approval of sub tier change request

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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		PD Resident Engineer (Plant)	
	PRINT NAME SIGNATURE DATE	PRINT NAME SIGNATURE DATE F. Russo Approved 24.05.13		PRINT NAME SIGNATURE DATE E. Camarda Approved 24.05.13	
Negative cost effect for GETRAG Identified? <input type="checkbox"/> YES <input type="checkbox"/> NO	Design and Release Manager		Plant Quality Manager		
If YES, rejection recommended <input type="checkbox"/> (please state below)	PRINT NAME SIGNATURE DATE		PRINT NAME SIGNATURE DATE P. Lucchese APPROVED 24/05/13 M. Colapietro Approved 27.05.2013 V. Uhr		
Buyer (only for non-design related changes)	Program Engineering Supervisor		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 (V)) are affected					
STA/SQA Manager		Chief Program Engineer		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)



K_TR_321__FASE1

Analisi campionaria (Cm - Cmk)

MACH BAZ-358

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25/08/13

Desc. Car.	Val. Nom.	Sc. Inf.	Sc. Sup.	Indice	Indice	Indice
#BO_PT0__P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 1.69	
#BO_PT0__D / Durchmesser	9.000	0.000	0.300	Cm 5.73	Cmk 2.86	
#BO_TRS1_P / Form-, Lageabweichung	0.000	0.000	0.100	Cm --- 915	Cmk 4.49	
#BO_TRS2_P / Form-, Lageabweichung	0.000	0.000	0.100	Cm --- 915	Cmk 3.53	
#ASOL_P(M) / Form-, Lageabweichung	0.000	0.000	0.100	Cm --- 915	Cmk 2.81	
#GW_CA11_P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 3.31	
#GW_CA12_P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 3.99	
#BO_CA13_P / Form-, Lageabweichung	0.000	0.000	0.100	Cm --- 915	Cmk 3.81	
#GW_CA14_P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 3.50	
#GW_CA21_P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 4.09	
#GW_CA22_P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 3.67	
#BO_CA23_P / Form-, Lageabweichung	0.000	0.000	0.100	Cm --- 915	Cmk 3.61	
#GW_CA24_P / Form-, Lageabweichung	0.000	0.000	0.400	Cm --- 915	Cmk 3.89	
#FL_D1_PAR / Form-, Lageabweichung	0.000	0.000	0.030	Cm --- 915	Cmk 3.62	
#FL_F_PAR / Form-, Lageabweichung	0.000	0.000	0.030	Cm --- 915	Cmk 3.71	



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K_TR_321__FASE1

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MACH BAZ-358

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25/08/13

Desc. Car.	Val. Nom.	Sc. Inf.	Sc. Sup.	Indice	Indice	Indice
#BO_F2_D / Durchmesser	55.000	0.000	0.046	C _m 2.29	C _{mk} 2.16	☺
#BO_T1__P / Form-, Lageabweichung	0.000	0.000	0.100	C _m --- 915	C _{mk} 3.66	☺
#BO_CA1__P / Form-, Lageabweichung	0.000	0.000	0.260	C _m --- 915	C _{mk} 4.33	☺
#BO_CA2__P / Form-, Lageabweichung	0.000	0.000	0.260	C _m --- 915	C _{mk} 3.43	☺
#BO_V__P / Form-, Lageabweichung	0.000	0.000	0.300	C _m --- 915	C _{mk} 3.85	☺
#GW_W4__P / Form-, Lageabweichung	0.000	0.000	0.400	C _m --- 915	C _{mk} 3.52	☺
TRS1/2-Distance	39.500	-0.100	0.100	C _m 2.64	C _{mk} 2.37	☺
TR1-Distance	143.120	-0.100	0.100	C _m 2.32	C _{mk} 2.02	☺
TR2-Distance	154.170	-0.100	0.100	C _m 2.47	C _{mk} 2.17	☺
CONEZ2-Distance	170.960	-0.100	0.100	C _m 2.38	C _{mk} 2.14	☺