

**GETRAG**

Production Part Approval

312296

DIMENSIONAL TEST RESULTS

Organization: GETRAG					Part Number: 250.1.5188.76								
Supplier/Vendor Code: GETRAG Modugno					Part Name: SR1								
INSPECTION FACILITY: NA					Design Record Change Level: 35834 04 April 2014								
					Engineering Change Documents:								
					Organization Measurement Results (Data)								
Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	1	2	3	4	5	controllo distruttivo	Ok	Not Ok
1	Bore diameter 42	42,025	42,009		5	42,020	42,020	42,019	42,020	42,017		ok	
2	Height 17,45	17,63	17,37		5	17,582	17,590	17,575	17,592	17,571		ok	
3	Height 19,75	19,79	19,71		5	19,773	19,779	19,771	19,782	19,778		ok	
4	Height 27,15	27,25	27,05		5	27,184	27,190	27,184	27,204	27,179		ok	
5	Axial runout bottom surface	0,03	0,00		5	0,012	0,008	0,002	0,003	0,021		ok	
6	Axial runout top surface	0,03	0,00		5	0,004	0,003	0,004	0,009	0,003		ok	
7	Roughness top surface	6,3	0,00		5	0,930	1,510	0,830	1,640	1,580		ok	
8	Roughness bottom surface	6,3	0,00		5	2,770	2,050	2,500	2,050	1,800		ok	
9	Axial runout on kk	0,1	0,0		5	0,032	0,032	0,019	0,038	0,064		ok	
10	Radial runout on kk	0,100	0,000		5	0,034	0,055	0,069	0,046	0,041		ok	
11	Cone diameter 70,6	70,61	70,59		5	70,606	70,607	70,605	70,608	70,607		ok	
12	Cone angle 7°	7,03°	6,97°		5	7,002	7,011	6,997	7,007	7,003		ok	
13	Cone roundness	4,00	0,00		5	2,13	2,49	2,78	2,77	1,67		ok	
14	Cone radial runout	20,00	0,00		5	2,60	4,38	5,41	3,01	3,57		ok	
15	Cone straightghness	3,0	0,0		5	0,97	1,43	1,17	0,87	0,73		ok	
16	Cone roughness	3,0	1,5		5	2,3	2,7	2,3	2,3	1,6		ok	
17	Cone waviness	0,9	0,0		5	0,4	0,8	0,3	0,7	0,4		ok	
18	Bore roughness	3,0	0,0		5	0,9	1,2	1,0	1,2	1,7		ok	
19	Teeth radial runout	32	0		5	14	12	17	20	28		ok	
20	Roughness teeth	4,0	0,0		5	2,6	1,5	1,8	1,5	1,8		ok	
21	Bore parallelism	7,0	0,0		5	1,6	2,0	2,2	3,9	1,2		ok	
22	Bore roundness	6,0	0,0		5	1,3	2,5	2,6	2,5	1,5		ok	
23	Bore straightghness	4,000	0,000		5	1,0	1,0	1,4	1,4	2,2		ok	
24	Weld bead	0,5 max	-		1						0,2	ok	
25	Profile teeth	-	-		5	ok	ok	ok	ok	ok		ok	
26	Root diameter	117,70	117,25		5	117,551	117,597	117,52	117,544	117,534		ok	
27	Outside diameter	131,0	130,7		5	130,847	130,894	130,831	130,842	130,846		ok	
28	MDK	132,401	132,320		5	132,343	132,333	132,329	132,347	132,343		ok	
29	M1 CASE HARDNESS	83,0	80,5		1						81,20	ok	
30	M2 CHD (Eht) 550	0,9	0,5		1						0,63	ok	
31	M3 CHD (Eht) 550	0,3 min	-		1						0,47	ok	
32	M4 CHD (Eht) 550	0,8	0,4		1						0,54	ok	
33	M5 inside base of tooth	min 300HV	-		1						317	ok	

March 2006

CFG-1003

SIGNATURE

TITLE

DATE

G. Russo

QPE

05/06/2014

DIMENSIONAL TEST RESULTS

Organization: GETRAG Supplier/Vendor Code: GETRAG Modugno INSPECTION FACILITY: NA	Part Number: 250.1.5188.76 Part Name: SR1 Design Record Change Level: 35834 04 April 2014 Engineering Change Documents: Organization Measurement Results (Data)
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Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	1	2	3	4	5	controllo distruttivo	Ok	Not Ok
34	Welding deep 2,5 min	-	2,5		1						3,0	ok	
35	Tickness 28,4	0,030	-0,030		5	28,403	28,406	28,403	28,403	28,397		ok	
36	Cleanliness	ok	nok		5	ok	ok	ok	ok	ok		ok	
37	Ultrasound check	ok	nok		5	ok	ok	ok	ok	ok		ok	
38	Welding offset	0,500	0,000		1						0,000	ok	
39	Particular X	ok	nok		5	ok	ok	ok	ok	ok		ok	
40	Particular W	ok	nok		5	ok	ok	ok	ok	ok		ok	
41	Particular U	ok	nok		5	ok	ok	ok	ok	ok		ok	
41b	Diameter	100,600	100,400		5	100,510	100,500	100,530	100,520	100,520		ok	
42	Particular Y	ok	nok		5	ok	ok	ok	ok	ok		ok	
43	Particular T	ok	nok		5	ok	ok	ok	ok	ok		ok	
44	Particular Z	ok	nok		5	ok	ok	ok	ok	ok		ok	
45	Particular V	ok	nok		5	ok	ok	ok	ok	ok		ok	
45 a	Diameter	110,3	109,7		5	110,010	110,040	110,020	110,010	110,020		ok	
45 b	Diameter	108,3	107,7		5	108,06	108,01	108,08	108,09	108,08		ok	
46	Chamfer	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
47	Chamfer	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
48	Chamfer	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
49	Chamfer	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
50	Axial runout	0,020	0,000		5	0,015	0,023	0,022	0,026	0,018		ok	
51	Radial runout	0,030	0,000		5	0,018	0,018	0,020	0,013	0,020		ok	
52	Radial runout	0,050	0,000		5	0,003	0,004	0,005	0,003	0,004		ok	
53	Rz 16	0,016	0,000		5	0,005	0,004	0,004	0,004	0,004		ok	
54	Rz 25	0,025	0,000		5	0,0070	0,0070	0,0066	0,0070	0,0069		ok	
55	Tickness 4,05	4,15	3,95		5	4,004	4,045	4,007	4,018	4,038		ok	
56	Tickness 4,5	5,000	4,000		5	4,302	4,449	4,489	4,311	4,403		ok	
57	Tickness 6,8	6,95	6,65		5	6,756	6,750	6,780	6,721	6,728		ok	
58	Chamfer 0,5x45°	ok	nok		5	ok	ok	ok	ok	ok		ok	
59	Chamfer1	1,5	0,5		5	0,659	0,612	0,605	0,645	0,601		ok	
60	Chamfer 0,7	1,1	0,3		5	0,552	0,632	0,595	0,605	0,602		ok	

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