

DIMENSIONAL TEST RESULTS

Organization: GETRAG					Part Number: 250.1.3646.37								
Supplier/Vendor Code: GETRAG Modugno					Part Name: SR6								
INSPECTION FACILITY: NA					Design Record Change Level: 35622 16 Gen 2013								
					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 45	45,025	45,009		5	45,023	45,021	45,021	45,021	45,023		ok	
2	Roughness bore	0,003	--		5	0,0025	0,0025	0,0015	0,0025	0,0025		ok	
3	Axial runout on kk	0,100	--		5	0,004	0,009	0,005	0,007	0,004		ok	
4	Radial runout kk	0,100	--		5	0,062	0,054	0,072	0,047	0,031		ok	
5	Roughness on top surface	6,3	--		5	0,003	0,002	0,003	0,003	0,003		ok	
6	Axial runout on top surface	0,03	--		5	0,003	0,008	0,004	0,004	0,003		ok	
7	Total height 36,49	0,03	-0,03		5	36,483	36,484	36,480	36,484	36,484		ok	
8	Axial runout on bottom surface	0,03	--		5	0,007	0,012	0,008	0,010	0,006		ok	
9	Roughness on bottom surface	6,3	--		5	0,002	0,002	0,002	0,002	0,002		ok	
10	kk height 28,69	0,180	-0,080		5	28,808	28,780	28,803	28,791	28,809		ok	
11	Height 24,29	0,04	-0,04		5	24,273	24,283	24,283	24,275	24,284		ok	
12	Bore parallelism	0,007	--		5	0,001	0,001	0,002	0,002	0,001		ok	
13	Bore roundness	0,006	--		5	0,006	0,005	0,005	0,005	0,006		ok	
14	Bore straightness	0,004	--		5	0,001	0,001	0,001	0,001	0,001		ok	
15	Particular Z	--	--		5	ok	ok	ok	ok	ok		ok	
16	Outside diameter 71,6	0,00	-0,16		5	71,5	71,5	71,5	71,5	71,5		ok	
17	Root diameter 61,5	0,00	-0,30		5	61,4	61,4	61,4	61,4	61,4		ok	
18	Roughness tooth	0,004	0,000		5	0,002	0,002	0,002	0,003	0,002		ok	
19	Teeth runout	0,032	--		5	0,021	0,030	0,020	0,019	0,021		ok	
20	MDK	68,579	68,509		5	68,520	68,521	68,533	68,540	68,529		ok	
21	M1 CASE HARDNESS	83,0	80,5		1						82,1	ok	
22	M2 CHD (Eht) 550	0,9	0,5		1						0,74	ok	
23	M3 CHD (Eht) 550	0,3 min	-		1						0,51	ok	
24	M4 inside base of tooth	min 300HV	-		1						393	ok	
25	Weld bead stand off	0,5	--		1						0,12	ok	
26	Particular Y	--	--		5	ok	ok	ok	ok	ok		ok	
27	Microgeometry	--	--		5	ok	ok	ok	ok	ok		ok	
28	Particular X	--	--		5	ok	ok	ok	ok	ok		ok	
29	Diameter 56,4	56,7	56,1		5	56,42	56,41	56,48	56,43	56,45		ok	
30	Cleanliness	ok	nok		5	ok	ok	ok	ok	ok		ok	
31	Angle welding 360°	362°	360°		5	ok	ok	ok	ok	ok		ok	
32	Longitudinal microcracks	0,02	0,00		5	ok	ok	ok	ok	ok		ok	
33	Chamfer	0	-0,200		5	-0,187	-0,195	-0,200	-0,199	-0,194		ok	

March 2006

CFG-1003

SIGNATURE

TITLE

DATE

G. Russo

QPE

22/08/2014

