



REPORT 14/076

Date: 08/05/2014  
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*Metallographic Analysis*

Sample # 1440/14	IS1
Tooth flank surface structure:	Martensite + 10% retained austenite (OK)
Tooth base core structure:	Martensite + bainite (OK)



Picture 2: Surface microstructure at tooth flank (X500)



Picture 3: Core microstructure at tooth base (X500)

# Process Capability Study Plan

DCT Shafts

Side 1

EDISON

Part -Nr.: 250.6.5178.35

Supplier: ■■■ GETRAG

Creation Date: 16.09.2014

Part Name: Input Shaft inner

Supplier Plant Name: BARI

Revision Date: 16.09.2014

SCIF #	Identification of Characteristics	Specified Tolerance	$C_m/C_{mk} \geq 1,67$	Study #	Scheduled date	$P_{pk} \geq 1,67$	Study #	Scheduled date	Measurement equipment	Results / Comments
1	Measurement over Balls Profil I	Max. 43,214 Min. 43,164	3.48			2.01			TEST BENCH	
2	Measurement over Balls Profil II	Max. 81,190 Min. 81,084	4.93			2.88			TEST BENCH	
3	Measurement over Balls Profil IIIa	Max. 20,889 Min. 20,830	2.52			2.10			TEST BENCH	
4	Diameter 42,136	-0.016	2.41			1.68			ZEISS 3D	
5	Diameter 22,00	-0.011	4.08			2.78			ZEISS 3D	
6	Diameter 20,00	-0.021	7.03			3.71			ZEISS 3D	
7	Diameter 26,00	±0.007	3.04			1.80			ZEISS 3D	
8	Diameter 34,00	j6	2.22			2.12			ZEISS 3D	
9	Length 83,190	+0,025 -0,025	2.44			1.67			ZEISS 3D	
10										
11										
12										
13										