

**GETRAG**

Production Part Approval

313036

DIMENSIONAL TEST RESULTS

Organization:	GETRAG	Part Number:	250.1.5187.75
Supplier/Vendor Code:	GETRAG Modugno	Part Name:	Ring gear
INSPECTION FACILITY:		Design Record Change Level:	a 35331
NA		Engineering Change Documents:	
Organization Measurement Results (Data)			

Item	Dimension/Specification	Specification / Limits		Test Date	Qty. Tested	1	2	3	4	5	test distruttivo	Ok	Not Ok
1	Bore diameter 116	0,022	0,000		5	116,019	116,021	116,019	116,019	116,019		ok	
2	Bore roughness	0,0063	0,0000		5	0,0015	0,0019	0,0020	0,0025	0,0019		ok	
3	Tip diameter 204,1	0,0	-0,3		5	203,916	203,915	203,836	203,835	203,920		ok	
4	Root diameter 191,6	0,000	-0,450		5	191,465	191,455	191,382	191,379	191,461		ok	
5	Teeth runout	0,032	0,000		5	0,020	0,022	0,019	0,019	0,032		ok	
6	Bore perpendicularity	0,02	0,00		5	0,003	0,001	0,002	0,002	0,002		ok	
7	Teeth roughness	0,004	0,000		5	0,002	0,002	0,002	0,001	0,002		ok	
8	Bore diameter 10,5 (10 fori)	0,2	-0,2		5	ok	ok	ok	ok	ok		ok	
9	Position bore diameter 10,5 (10 fori)	0,2	0,0		5	ok	ok	ok	ok	ok		ok	
10	MDK	203,775	203,709		5	203,744	203,737	203,735	203,733	203,750		ok	
11	M1 HRA 80,5	2,5	0,0		1						81,60	ok	
12	M2 CHD 550 0,5	0,4	0,0		1						0,70	ok	
13	M3 HV10 min 300	-	-		1						349,00	ok	
14	Teeth roughness Rz max	0,0063	--		5	0,0024	0,0023	0,0026	0,0017	0,0024		ok	
15	Microgeometry	--	--		5	ok	ok	ok	ok	ok		ok	
16	Particular Z	--	--		5	ok	ok	ok	ok	ok		ok	
17	Chamfer	--	--		5	ok	ok	ok	ok	ok		ok	
18	Total tickness 27	27,1	26,9		5	27,052	27,063	27,081	27,069	27,063		ok	
19	Technical Cleanliness GN 4240-1	OK	NOK		5	OK	OK	OK	OK	OK		ok	
20	Particular B-B	0,5	0,1		5	0,3	0,3	0,4	0,3	0,3		ok	
21	Chamfer 0,7	1,1	0,3		5	0,760	0,752	0,708	0,712	0,729		ok	
22	Chamfer 1	1,5	0,5		5	0,729	0,724	0,716	0,711	0,711		ok	
23	Roughness Rz 16	0,016	0,000		5	0,0025	0,0025	0,0028	0,0033	0,0025		ok	
24	Planarity 8x0,05	0,05	0,0		5	OK	OK	OK	OK	OK		ok	
25	Chamfer 0,7	1,1	0,3		5	0,709	0,735	0,858	0,846	0,740		ok	
26	Chamfer 1	1,5	0,5		5	0,8	0,8	1,0	1,1	0,8		ok	
27													
28													
29													
30													

March 2006

CFG-1003

SIGNATURE	TITLE	DATE
G. Russo	QPE	25/08/2014