

DIMENSIONAL TEST RESULTS

Organization: GETRAG					Part Number: 250.1.3654.36								
Supplier/Vendor Code: GETRAG Modugno					Part Name: Zr 5								
INSPECTION FACILITY: NA					Design Record Change Level: Index (d) 07/12/2011								
					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	Diameter 42 H6	42,016	42,000		5	42,007	42,008	42,006	42,006	42,008		ok	
2	Radial runout Fr 32	0,032	0,000		5	0,026	0,018	0,019	0,018	0,018		ok	
3	Axial runout 0,03 sup.	0,030	0,000		5	0,011	0,005	0,005	0,028	0,010		ok	
4	Rz 6.3 Bore	0,0063	0,0000		5	0,0014	0,0013	0,0014	0,0012	0,0012		ok	
5	Rz tooth	0,004	0,000		5	0,002	0,001	0,002	0,002	0,002		ok	
5	Rmax 8 Tooth	0,008	0,000		5	0,002	0,002	0,002	0,002	0,002		ok	
6	M1 Case Hardness 80.5 +2.5 HRA	83,0	80,5		1						81,20	ok	
7	M2 Tooth Flank 0.5+0.4	0,9	0,5		1						0,79	ok	
8	M3 Bore 0.3 min	0,3 min	-		1						0,73	ok	
9	M4 Inside base of Tooth min 300 HV10	min 300HV10	-		1						OK	ok	
10	Measurement over balls Mdk	87,742	87,665		5	87,693	87,706	87,695	87,696	87,703		ok	
11	Tooth Profile	-	-		5	ok	ok	ok	ok	ok		ok	
12	X Profile	-	-		5	ok	ok	ok	ok	ok		ok	
13	Axial runout 0,04 infer.	0,040	0,000		5	0,012	0,004	0,005	0,027	0,009		ok	
14	Total height 14,700	14,750	14,650		5	14,692	14,692	14,687	14,686	14,687		ok	
15	Rz big surface	0,025	0,00		5	0,001	0,001	0,001	0,001	0,002		ok	
16	Rz little surface	0,025	0,000		5	0,002	0,002	0,002	0,002	0,002		ok	
17	Tooth Chamfer top left	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
18	Tooth Chamfer bottom left	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
19	Tooth Chamfer top right	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
20	Tooth Chamfer bottom right	0,3	-0,5		5	ok	ok	ok	ok	ok		ok	
21	Root diameter	79,50	79,05		5	79,288	79,274	79,293	79,285	79,269		ok	
22	Top diameter	90	89,84		5	89,902	89,879	89,912	89,903	89,893		ok	
23	Chamfer 0,73	1	0,63		5	0,823	0,826	0,805	0,801	0,800		ok	
24	Chamfer 0,7	1,2	0,2		5	0,73	0,8	0,83	0,75	0,80		ok	
25	Thickness 12,95	13,05	12,85		5	12,958	12,980	12,966	12,970	12,969		ok	
26	Chamfer 0,7	1,2	0,2		5	0,83	0,80	0,76	0,72	0,81		ok	
27	Chamfer 0,7	1,5	0,5		5	1,07	0,96	0,96	0,92	1,03		ok	
28	Chamfer 1	1,5	0,5		5	0,79	0,90	1,15	0,8	0,8		ok	
29	Ray 2	3	1,0		5	2,090	1,920	2,084	1,926	2,086		ok	
30	Diameter 55	55,5	54,5		5	55,139	55,042	55,190	55,092	55,110		ok	
31	Diameter 50	50,5	50		5	49,80	49,80	49,90	49,80	49,90		ok	

March 2006

CFG-1003

SIGNATURE

G. Russo

TITLE

QPE

DATE

23/05/2014

-10 PPAP

