


100% Gaging Requirements For Cast and Machined Customer Interface Features

Purpose: To provide direction to our Global Engineering, Commodity Managers, Supplier Development Engineers, and Suppliers concerning the requirement for 100% gaging of customer interface features.

Scope: Applies to ALL suppliers of castings (aluminum and cast iron) that have features that the customer uses to mount or locate our product.

Preface: Remy Inc. has created and is migrating to the use of the symbol  to denote the requirement of 100% gaging by the supplier for customer interface features, and other features Remy deems to be critical to customer satisfaction.

ALL features with this symbol are REQUIRED to have 100% gage inspection, prior to release for use by Remy plants.

This symbol has not yet been migrated to older prints. This directive hereby requires the supplier to plan, budget, and implement this 100% gaging requirement for prints and parts not yet changed.

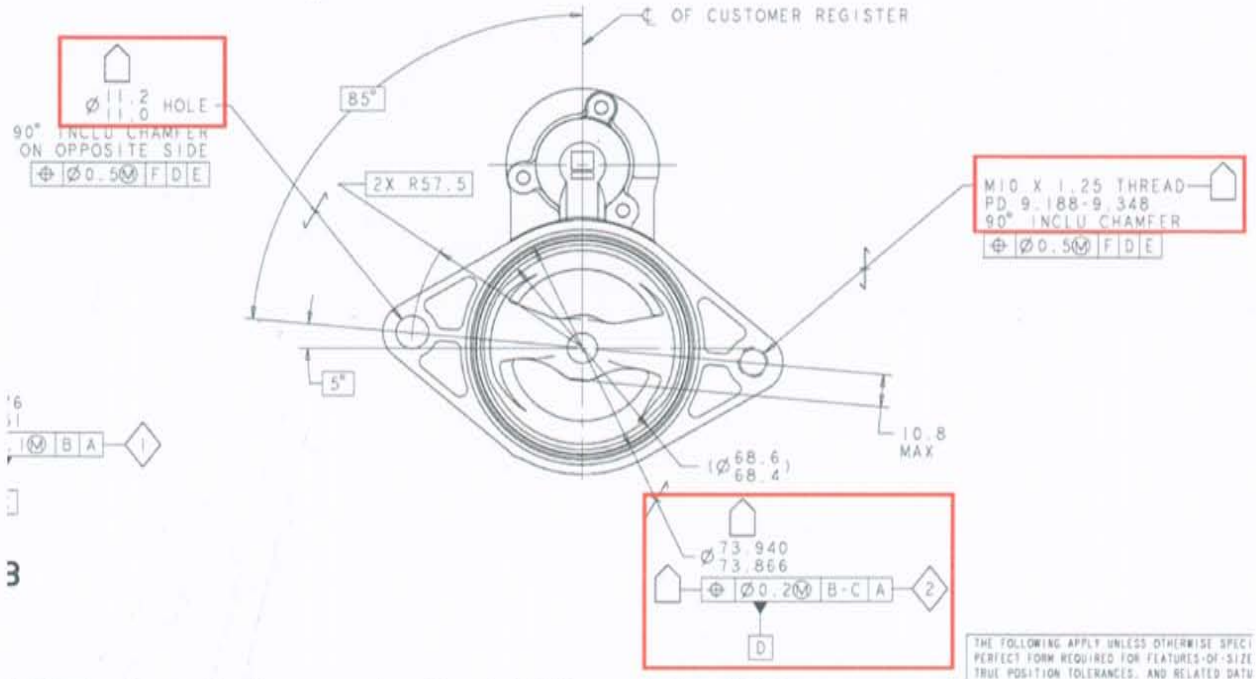
Where Remy has designed specific gages to accomplish the task, the supplier will be provided the design for that gage. It is the supplier's responsibility to manufacture, calibrate, and maintain the gage(s).

Affectivity: **IMMEDIATELY** (06-Jul-2006)

The following are examples of items required to be 100% gaged by the supplier (see pages 2-8).

Example 1: Starting Motor Nose Housing with customer mounting holes and register diameter identified with the 100% gage inspection symbol.

- 11.0-11.2 Diameter Hole (thru)
- M10 X 1.25 Threaded Hole
- 73.866-73.940 Register Diameter
- True Position of Register Diameter

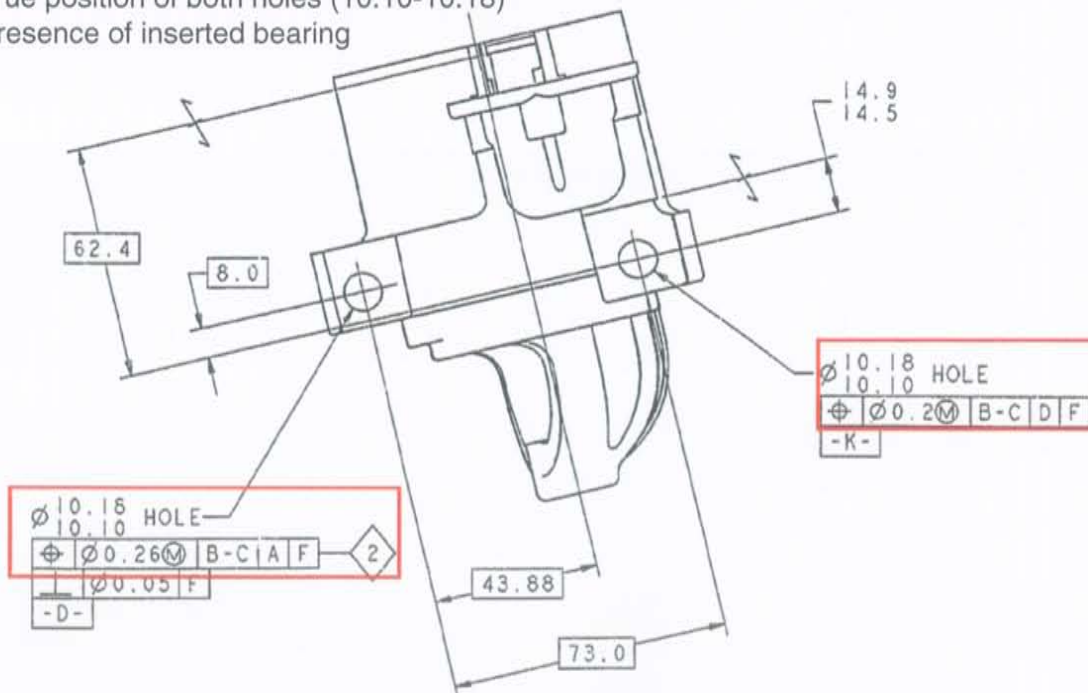


NOTE: Same features apply without 100% symbol or KPC's

Example 2: Starting Motor Nose Housing with pad mounting system and KPC.

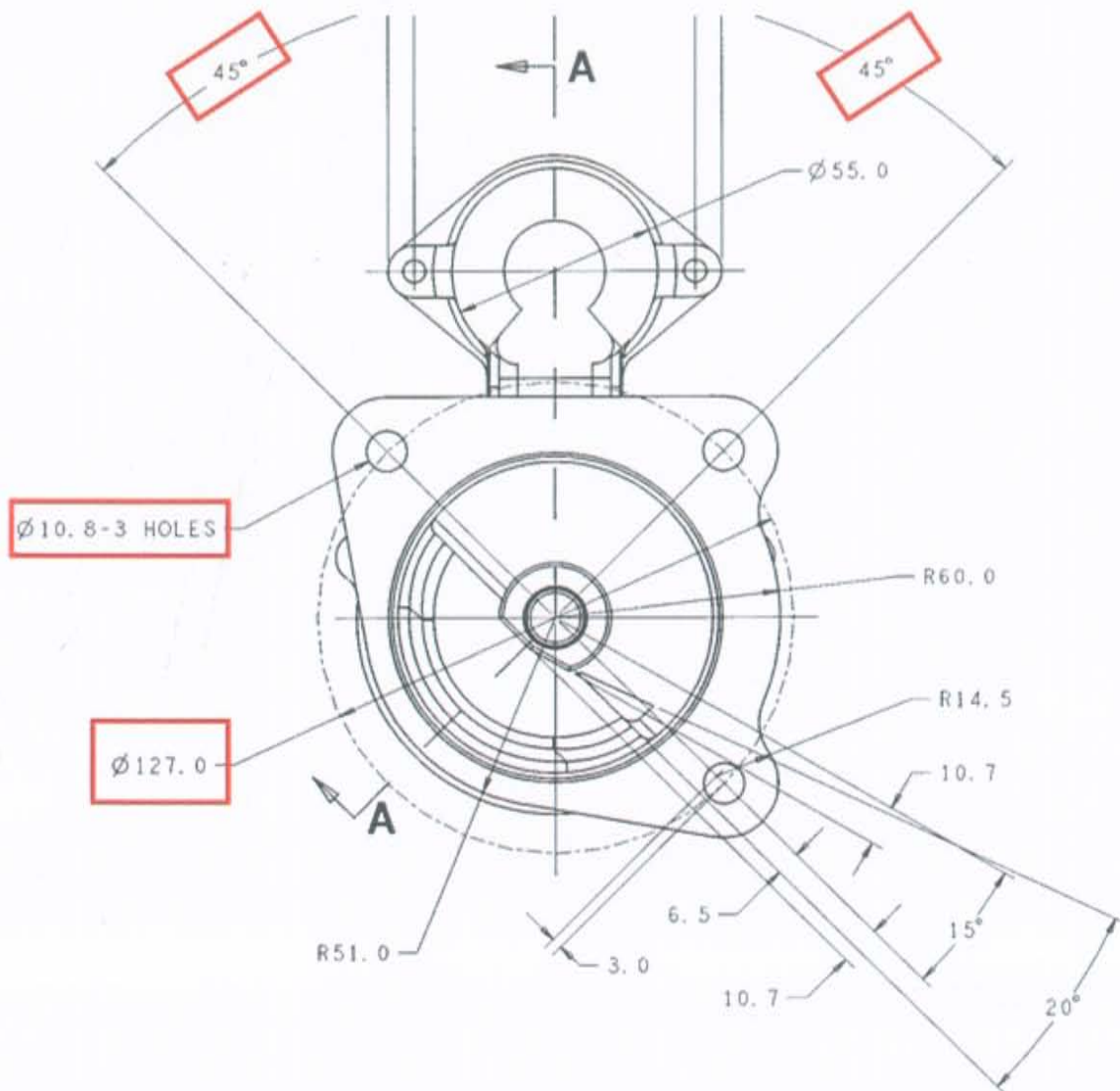
Items requiring 100% gage inspection are:

- 10.10-10.18 Diameter Hole (thru), two (2) places
- True position of both holes (10.10-10.18)
- Presence of inserted bearing



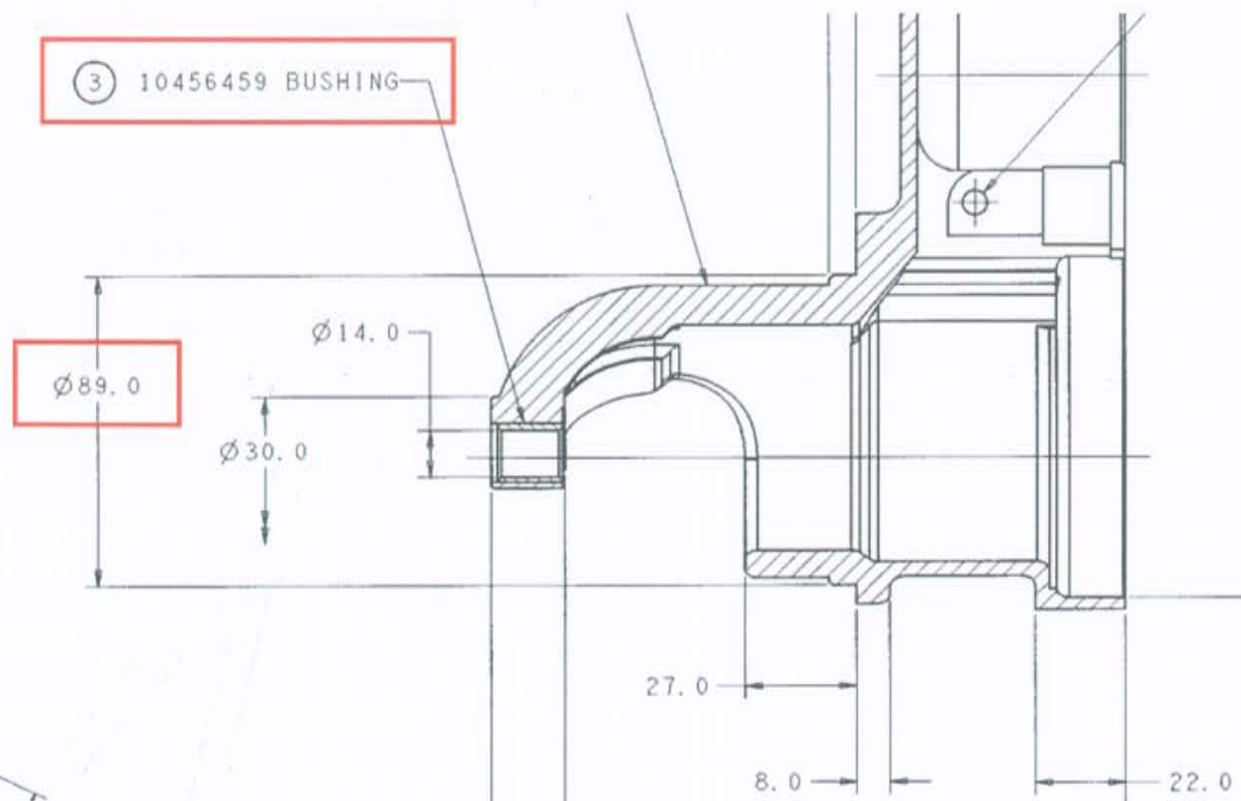
Example 3: Heavy-Duty (HD) Starting Motor Nose Housing without GD&T:

- 10.8 Diameter hole (thru), three (3) places
- Position of holes using Cartesian coordinates
- Register Diameter (see Example 4)
- Presence of bushing, if installed (see Example 4)



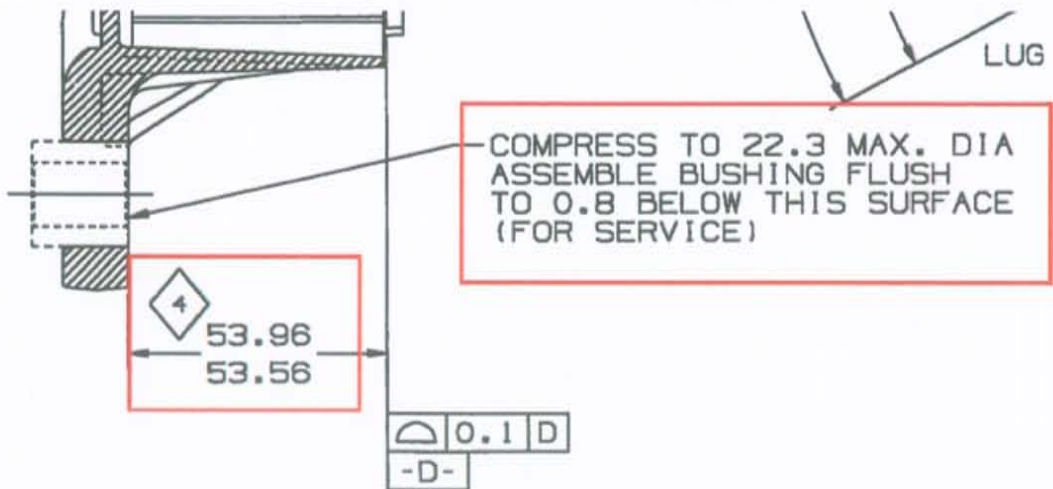
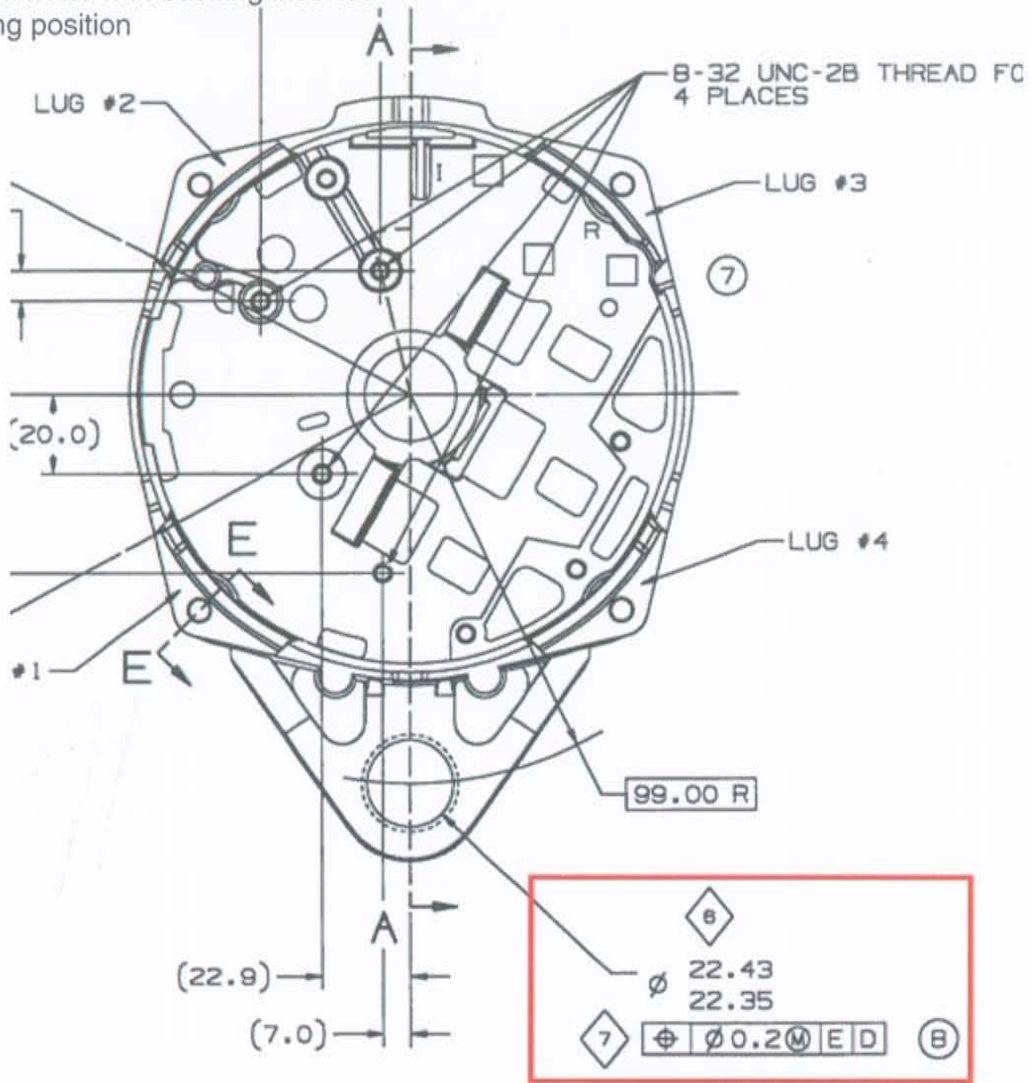
Example 4: Heavy-Duty (HD) Starting Motor Nose Housing without GD&T (continued):

- Register Diameter
- Presence of bushing, if installed



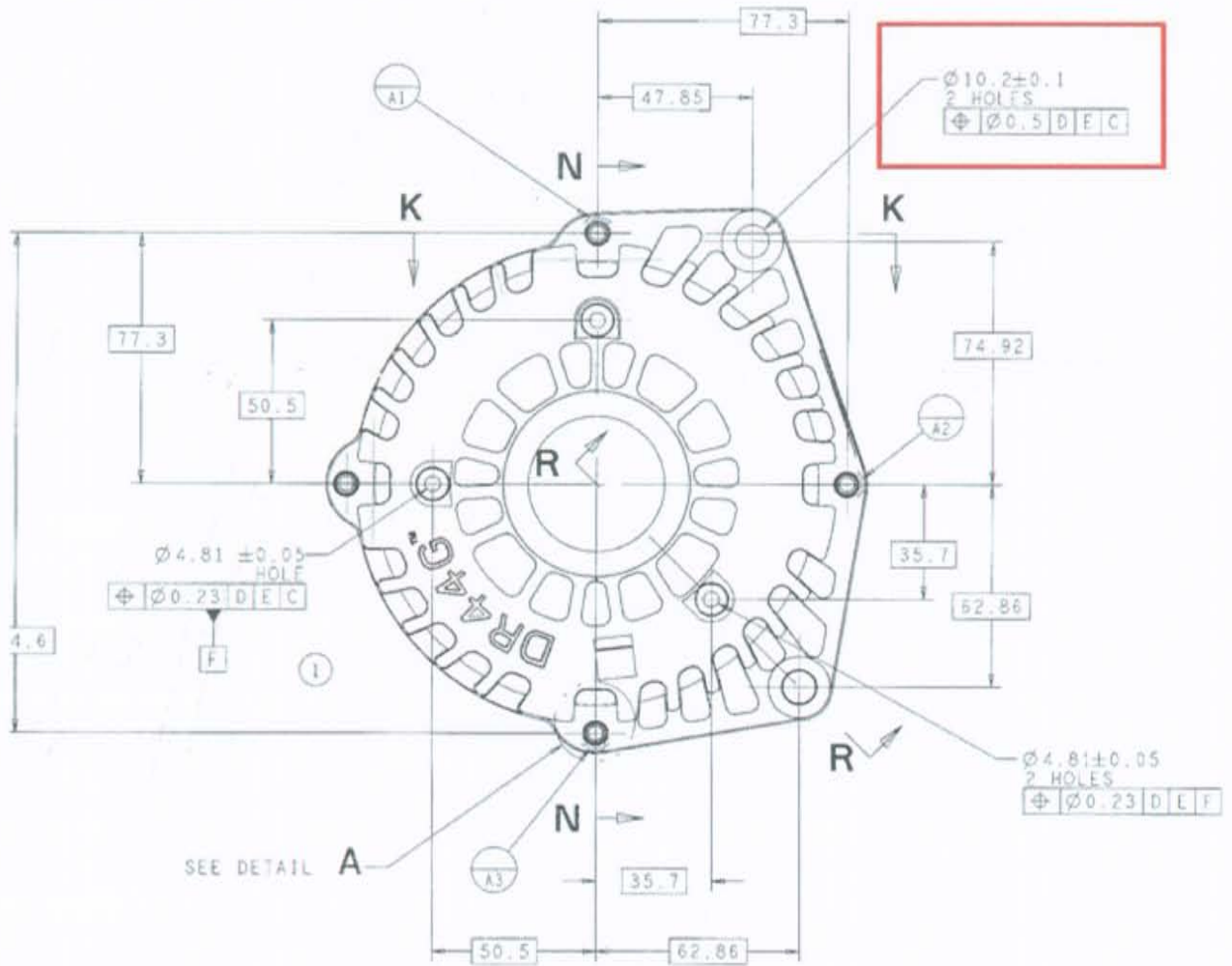
Example 5: Alternator Slip Ring End (SRE) Frame:

- Lug Diameter with bushing inserted
- Bushing position



Example 6: Alternator Drive End (DE) Frame:

- 10.2 Diameter hole (thru), two (2) places
- True Position Holes (10.2), two (2) plcs.



Example 8: Alternator Drive End (DE) Frame with inserted Helicoil (continued):

- Hole Diameter (as-cast)
- True Position of Hole Dia. (as-cast)

