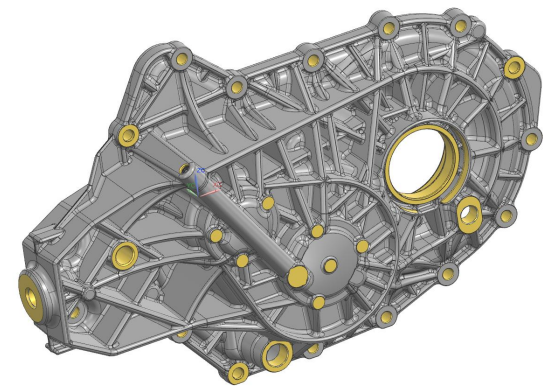


HEV120 – Transmission Cover

Böttcher, EM-EA/EHW2, 30.07.26



01

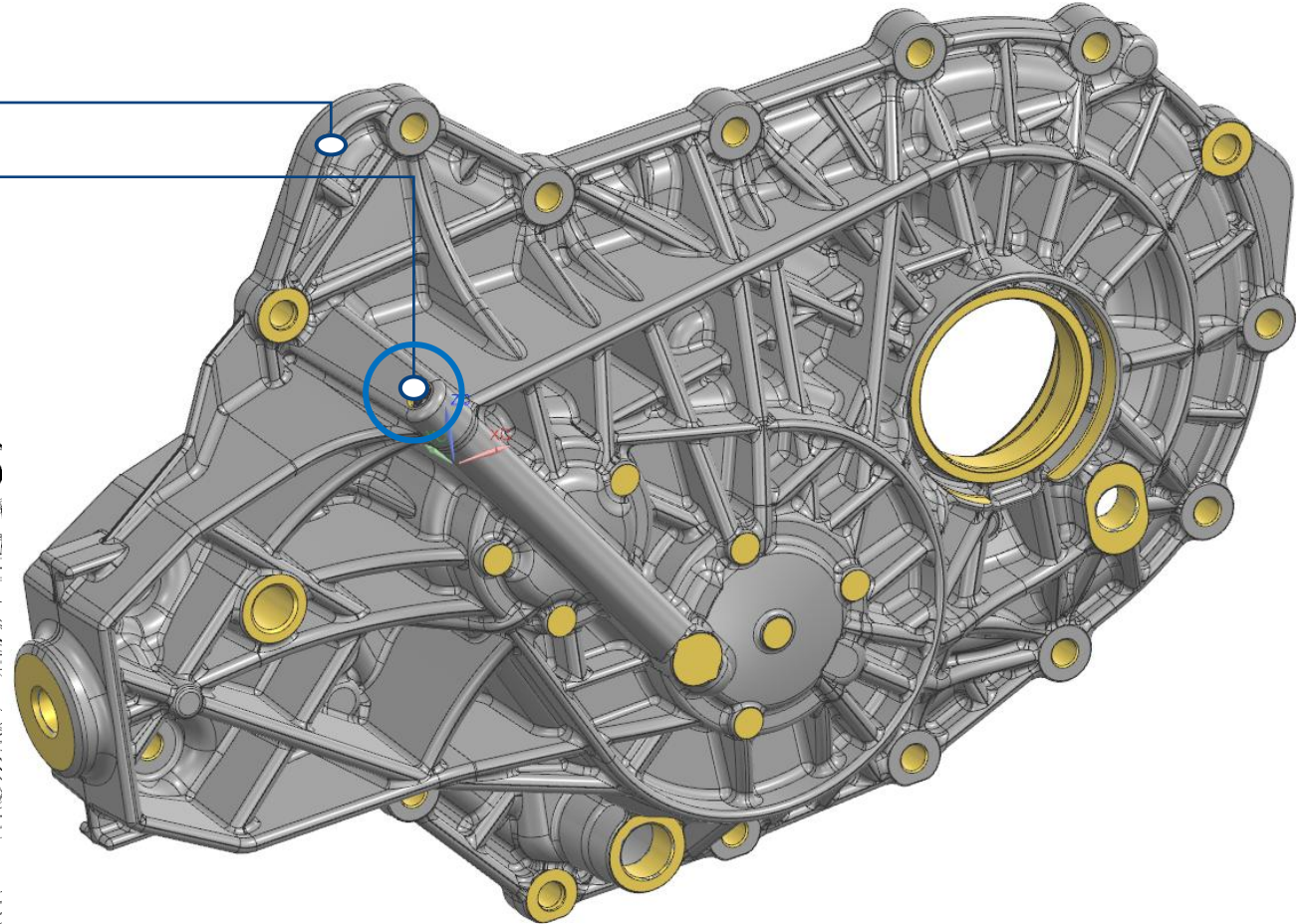
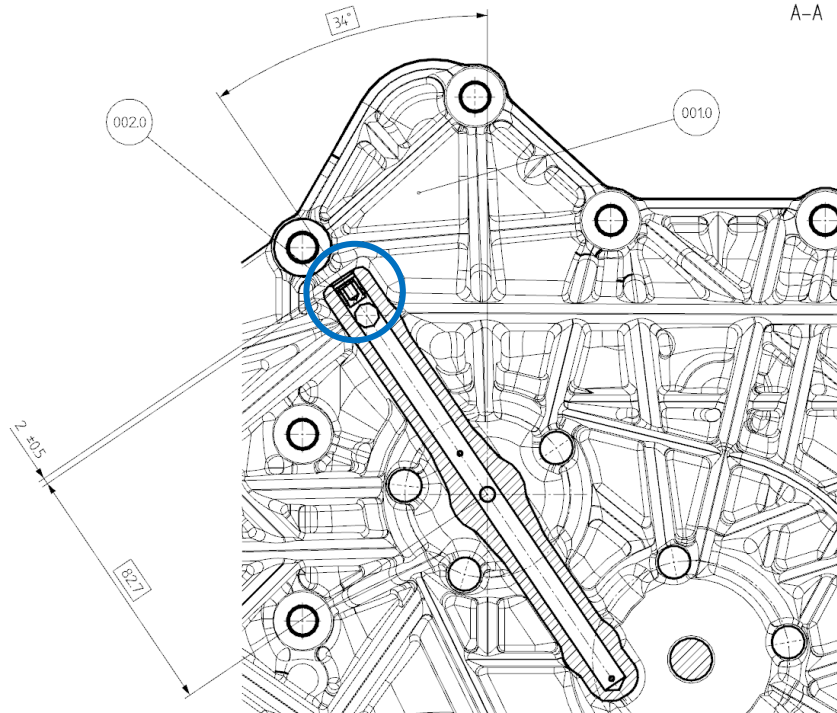
TRC Sub-Assembly

HEV120 – TR Cover Sub-Assembly

Status B2 Sample – Overview

1. Gear Cover Machined

2. Oil Channel Plug



Tightness and Cleanliness requirements see DRW and BOM!

HEV120 – TR Cover Sub-Assembly

Status B2 Sample – Overview

LPNT	StM	Plnt	StP	Usg.	Alt	STB	Partnumber-Index	Short txt	UM	PT	Base/Ref	Draw	F	Drawing	F				
0890	20			3	1	20	F03Z.400.	Gear Cover; Sub-Assembly	PC					F03Z400					
AF	Trm	cd	PI	VF	WT	PC	RP	Chan.no	N	Chan.no	N	Chan.no	N	Chan.no	N				
	118524		BG		Z														
SP	SP	f.	SP	to	Net		Unit												
Z							KG												
Released with: F03ZE000								Currently: 4,3kg											
Type short desc Sub-Assembly																			
Basic text: 12.05.26:DRW and MOD exchanged against Rev 02																			
Pos.F	ASM	Qty	UM	PT	Number-Ind	Short txt			PC	StP	VF	SP	PI	StM	Chan.no	Chge date	NC	O/R/C	
001.0		1,000	PC		F03Z.400.	Gear Cover; MACHINED			XX					TS 20				R	
002.0		1,000	PC		F03Z.400.5MN-01	Plug; 8 mm			XX					TS 20				R	
985.9					F03Z4006DG-01	GEAR COVER SUB ASSEMBLY					DRW	000	02	20					
985.A					F03Z4006DG-01	GEAR COVER SUB ASSEMBLY					MOD	000	02	20					
994.4					F03ZY0008A	test specification inspection dimensions					PRV	000	02	40					
994.7					F03ZY0007N	External Technical Cleanliness					PRV	000	01	40					
994.8					F03ZY000WE	TecSa Specification Appendix - Gearbox					PRV	000	03	40					
994.9					F03ZY0007Z	DMC 22x22 (Module: 300)					PRV	000	02	40					
substitute material:						Invalid from:			00.00.0000	Reason/Comment:									
END	*	END	*	END	*	END	*	END	*	END	*	END	*	END	*	END	*	END	*
Entry parameters: [- - - - - - - - - - 0/99]																			
System Client			Plnt	Department.			Prints and copies are not						printed by			print date			
P79			011	PS-EM Eng			EADI, IMG, SMG, CVsubject of change service						EM-EA/EHW2-Boettcher			30.07.2026 / 12:24			

02

TRC MACH

HEV120 – TR Cover Machined

Status B2 Sample

3x ScREW domes:
Plant Assembly support

3x Clamping flaps

6x Bearing Press Support

Stamped Screw holes

Oil Channel:
1x EIS Oil Plug d8 mm

Customer Interface: Anti Sway
Point

Customer Interface: RWDR
Sealing surface

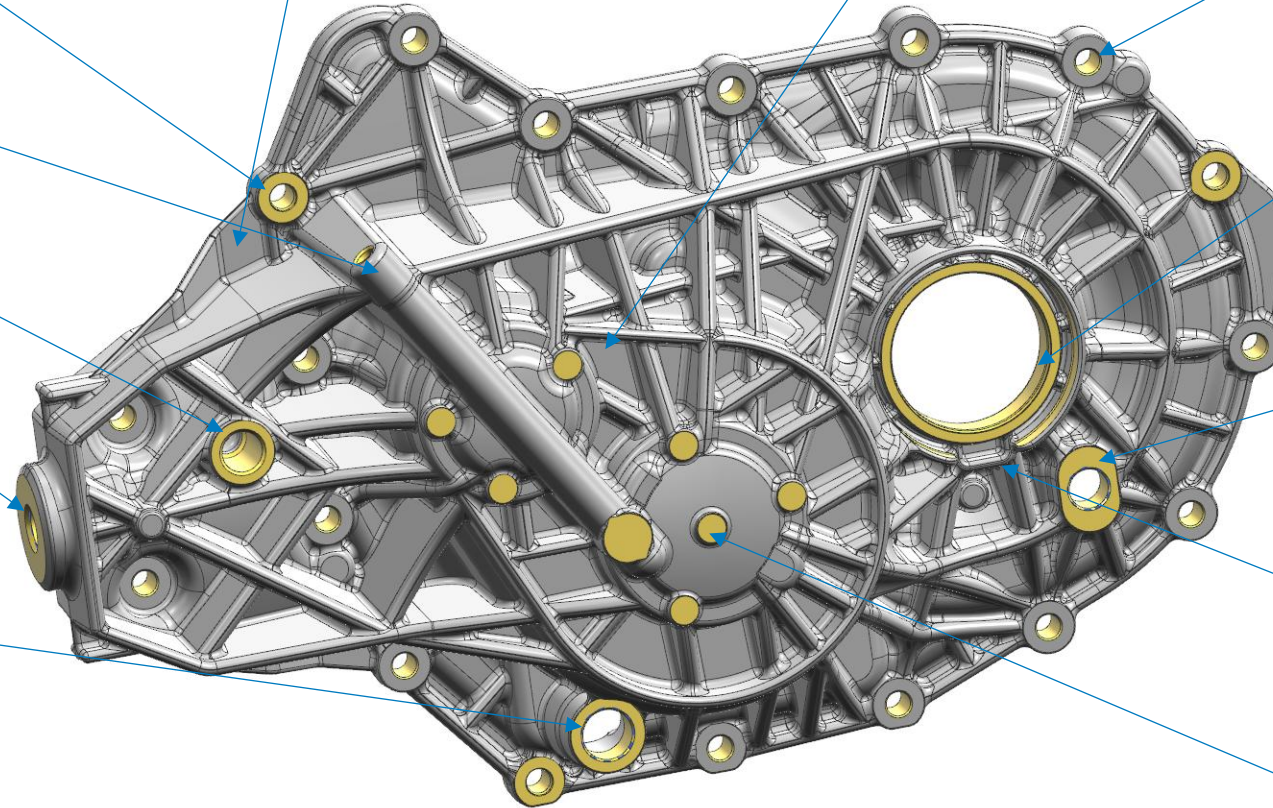
Customer Interface: Vehicle
Mounting with T-stopper

Oil Fill
Sealing surface

Oil Drain
Sealing surface

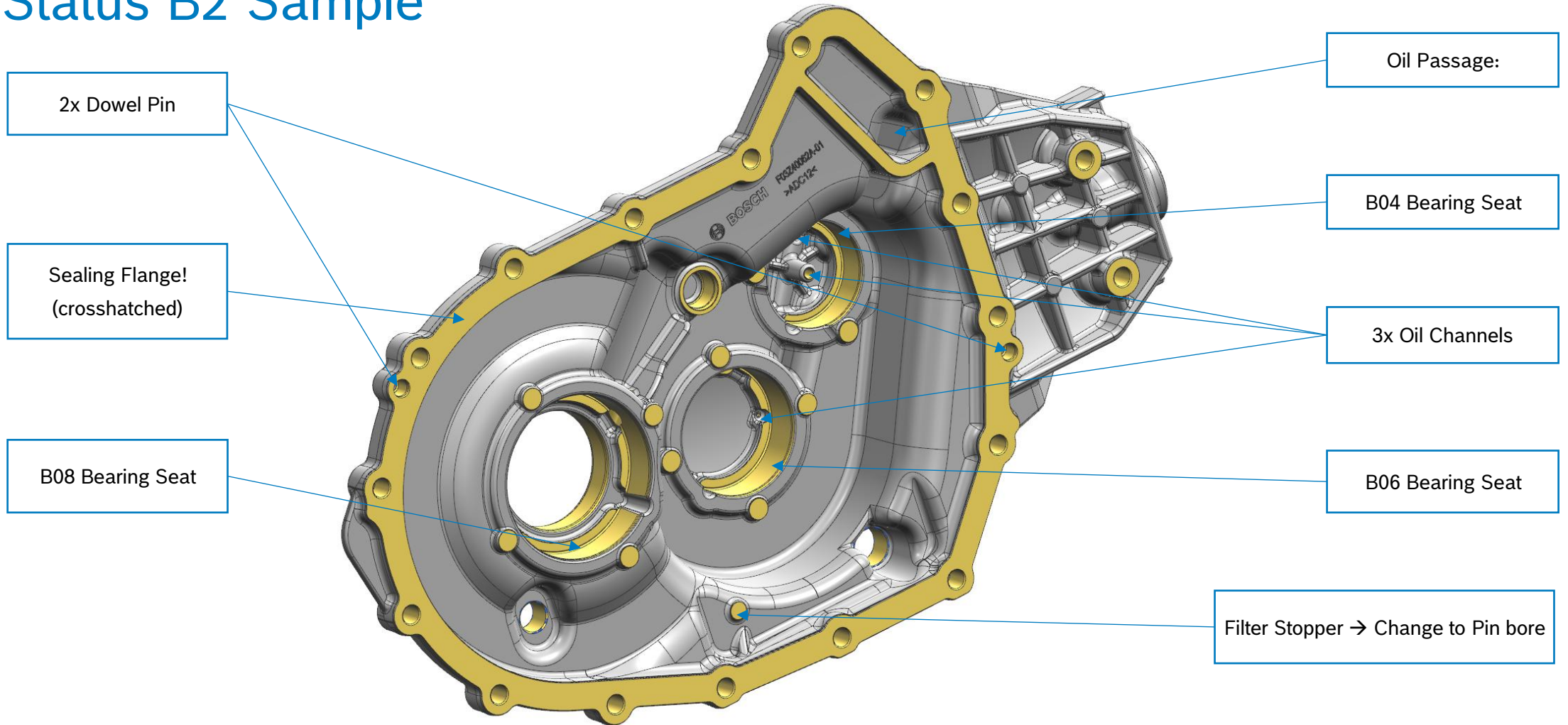
Half Shaft Removal (Service)

NVH mesurement point



HEV120 – TR Cover Machined

Status B2 Sample



HEV120 – TR Cover Sub-Assembly

Status B2 Sample – BOM Overview

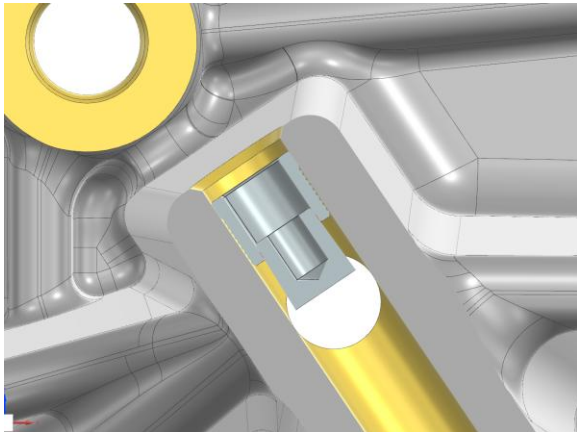
LPNT	StM	Plnt	StP	Usg.Alt	STB	Partnumber-Index	Short txt	UM	PT	Base/Ref	Draw	F	Drawing	F		
089M	20			3	1	20 F03Z.400. [REDACTED]	Gear Cover; MACHINED	PC					F03Z400 [REDACTED]			
AF	Trm	cd	PI	VF	WT	PC	RP	Chan.no	N	Chan.no	N	Chan.no	N	Chan.no		
	118524	TS		Z												
SP	SP	f.	SP	to			Unit									
							KG									
Released with: F03ZE00 [REDACTED]																
Type short desc MACHINED																
Basic text: 12.05.26:DRW and MOD exchanged against Rev 02																
Test internal threads die-casted parts F03ZY004MN added																
Pos.F	ASM	Qty	UM	PT	Number-Ind	Short txt			PC	StP	VF	SP	PI	StM	Chan.no	Chge date NC O/R/C
001.0			KG		5346.022.100	Al. Pressure Die Casting; [REDACTED]			XX		Z	TS		40		
935.0					4497600502	ISO 14405-1:2025-08-01					BST	000	03	40		
935.1					4497601746	DIN EN ISO 21920-1					BST	000	01	40		
935.2					4497601324	ISO 10135					BST	000	02	40		
935.3					4497600307	VDA 260:2022-11-01					BST	000	06	40		
935.4					4497600337	DIN 1451-4					BST	000	01	40		
940.0					4497016706	N41A A3: 2015-12-03					BST	000	03	40		
940.1					4497005948	N41A A4/1					BST	000	05	40		
940.2					4497005963	N41A B1:2020-03-09					BST	000	04	40		
940.3					4497005957	N41A B01:2020-03-06					BST	000	06	40		
940.4					4497005960	N41A B04:2020-03-10					BST	000	06	40		
940.5					4497026614	N41A B07:2020-03-10					BST	000	04	40		
940.6					4497041957	N28 AC0909 S002					BST	000	01	40		
985.9					F03Z4005DG-01	GEAR COVER MACHINED					DRW	000	02	20		
985.A					F03Z4005DG-01	GEAR COVER MACHINED					MOD	000	02	20		
989.0					F03ZY004MN	Test internal threads die-casted parts					BV	000	01	20		
990.1					F03ZY000A4	TEST SPECIFICATION LEAKAGE TEST					PRV	000	01	40		
994.4					F03ZY0008A	test specification inspection dimensions					PRV	000	02	40		
994.5					F03ZY002EZ	Grub peel off test					PRV	000	02	40		
994.6					4497041157	N42AP 605:2020-07-02					BST	000	01	40		
994.7					F03ZY0007N	External Technical Cleanliness					PRV	000	01	40		
994.8					F03ZY000WE	TecSa Specification Appendix - Gearbox					PRV	000	03	40		
substitute material: Invalid from: 00.00.0000 Reason/Comment:																
END * END * END * END * END * END * END * END * END * END * END * END * Entry parameters: [- - - - - 1/99]																
System Client Plnt Departmt. Prints and copies are not printed by print date																
P79		011		PS-EM Eng EADI, IMG, SMG, CVsubject of change service			EM-EA/EHW2-Boettcher			30.07.2026 / 12:24						

03

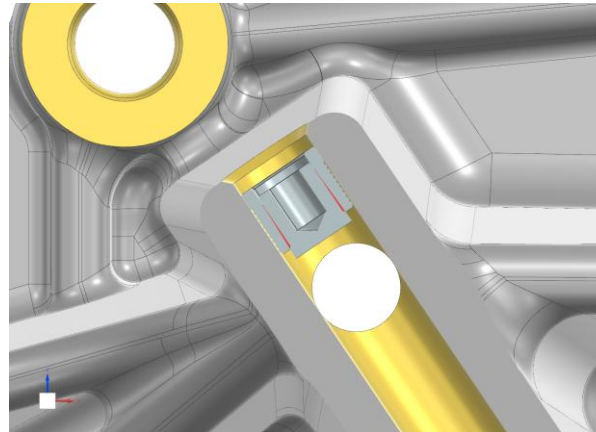
Oil Plug

HEV120 – Oil Plug Status B2 Sample

Positioned



Mounted

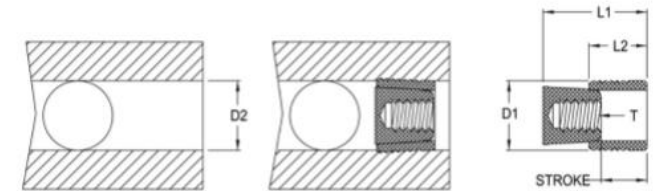


EIS LRST Metric Series PULLPLUGS™

Patent: 10,040,182

Sleeve and Pin Materials: See Below

Max. Operating: 60 Bar (900 psi)



(Dimensions in mm unless otherwise specified)						
D1	L1	D2 +0.1/-0.0	L2 REF	STROKE	T	EIS P/N
5,0	7,5	5,0	4,5	3,0 +0.00/-1,0	4-40UNC	EIS- □ LRST ○ -050
6,0	8,5	6,0	5,0	3,5 +0.00/-1,0	3.0 X 0.5	EIS- □ LRST ○ -060
7,0	9,5	7,0	5,5	4,0 +0.00/-1,0	6-32UNC	EIS- □ LRST ○ -070
8,0	11,5	8,0	6,5	5,0 +0.00/-1,0	4.0 X 0.7	EIS- □ LRST ○ -080
9,0	11,5	9,0	6,5	5,0 +0.00/-2,0	4.0 X 0.7	EIS- □ LRST ○ -090
10,0	11,5	10,0	6,5	5,0 +0.00/-2,0	5.0 X 0.8	EIS- □ LRST ○ -100
12,0	13,2	12,0	7,5	5,7 +0.00/-2,0	5.0 X 0.8	EIS- □ LRST ○ -120
14,0	13,9	14,0	8,0	5,9 +0.00/-2,0	6.0 X 1.0	EIS- □ LRST ○ -140
16,0	18,2	16,0	10,5	7,7 +0.00/-2,5	8.0 X 1.25	EIS- □ LRST ○ -160
18,0	20,2	18,0	12,0	8,2 +0.00/-2,5	8.0 X 1.25	EIS- □ LRST ○ -180
20,0	21,2	20,0	12,5	8,7 +0.00/-2,5	10.0 X 1.5	EIS- □ LRST ○ -200
22,0	22,2	22,0	13,0	9,2 +0.00/-2,5	10.0 X 1.5	EIS- □ LRST ○ -220

□ Plug Material:
 1 = Case Hardening Steel, Black Oxide Finish
 3 = 303 Stainless Steel
 5 = 6061

○ Pin Material:
 4 = 416SS
 7 = 17-4PH
 5 = 7075 T6

Example: EIS-SLRST5-100 (6061 aluminum plug with 7075 T6 aluminum pin)

Engineered Inserts & Systems, Inc.

Certified IATF 16949: 2016 RoHS Compliant

Phone: 203-301-3334

Fax: 203-301-3335

Web: eisinserts.com

HEV120 – Oil Plug

Status B2 Sample



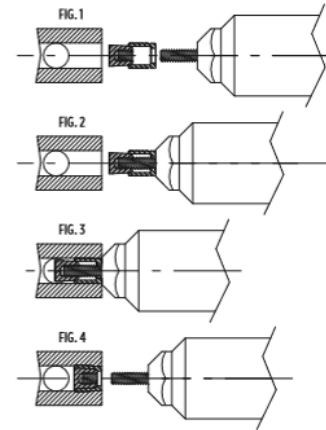
Installation Instructions for
EIS-RST, RSO & LRST Sealing
and Orifice Plugs "patent pending"

Hole Preparation

- Use the catalogue sheet for the product you are installing to determine the correct drilled hole (**D3**) size and tolerance.
- Hole roundness must be held to within 0.05mm.
- Bore roughness must be between R_z (RMS) 10 - 30 μm especially for hard materials.
- Avoid spiral or longitudinal grooves as these may affect plug performance.
- Be sure each bore is clean and free from any and all cutting oils, chips, etc.

Installation Procedure

- Always work in a clean work area.
- EIS RST or RSO Series Sealing Plugs are designed to be used as received. Do not clean or lubricate the plug or the pin. (**Fig. 1**)
- Push the threaded arbor against the EIS Pullplug "patent pending". The arbor will automatically thread into the sealing plug. (**Fig. 2**)
- Insert the plug into the hole. Be sure the nose piece is pushed against the workpiece and is perpendicular. (**Fig. 3**)
- Activate the tool to expand the plug. The threaded arbor will pull the pin to a preset depth and then automatically unscrew itself from the pin (**Fig. 4**)
- Be sure to purchase the correct installation tool for each plug size selected.



Removal

- Using a punch, drive the expansion pin out of the plug.
- Drill out the plug and remove the expansion pin.
- Drill the hole for the next larger size EIS RST or RSO Series Pullplug.
- Be sure to remove all chips, plug remnants and any grease or oil from the hole.
- Install a new EIS RST or RSO Series Pullplug.

Engineered Inserts & Systems, Inc.

Certified ISO/TS 16949-2009

RoHS Compliant

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HEV120 – Oil Plug

Status B2 Sample – BOM Overview

LPNT	StM	Plnt	StP	Usg.Alt	STB	Partnumber-Index	Short txt	UM	PT	Base/Ref	Draw	F	Drawing	F
089M	20			3	1	20 F03Z.400.5MN-01	Plug; 8 mm	PC					F03Z4005MN-01	
AF	Trm cd	PI	VF	WT	PC	RP	Chan.no	N	Chan.no	N	Chan.no	N	Chan.no	N
	108162	TS	Z										F03ZE006AM01	
SP	SP f.	SP to				Unit							07.04.2026	
						KG								
Released with: F03ZE006AM01														
Type short desc 8 mm														
Pos.F	ASM	Qty	UM	PT	Number-Ind	Short txt	PC	StP	VF	SP	PI	StM	Chan.no	Chge date NC O/R/C
001.0						EIS-5LRST5-080								
985.9					F03Z4005MN-01	PLUG								
985.A					F03Z4005MN-01	PLUG								
994.4					F03ZY0008A	test specification inspection dimensions								
994.7					F03ZY0007N	External Technical Cleanliness								
substitute material: Invalid from: 00.00.0000 Reason/Comment:														
END	*	END	*	END	*	END	*	END	*	END	*	END	*	Entry parameters: [- - - - - 1/99]
System Client	Plnt	Departmt.	Prints and copies are not					printed by	print date					
P79	011	PS-EM Eng	EADI, IMG, SMG, CV	subject of change service				EM-EA/EHW2-Boettcher	30.07.2026 / 12:33					