

Process Capability Evaluation

Part Number: 20097419				Supplier : Hansin Precison Engineeri				Target	CP : 2.0	
Part Name: COVER, RIGHT TOP				Prepared By : Chu Libo					Cpk : 1.3	
Part Revision: C				Date of Evaluation : 30-May-24						
Specification										
Item No	4	19	20	21	35	36	48	49	52	53
Cavity	1	1	1	1	1	1	1	1	1	1
Nominal	3.000	266.980	3.020	5.000	2.020	3.000	4.200	2.000	0.000	0.000
Upper Tol.	0.200	0.500	0.200	0.100	0.200	0.200	0.100	0.050	0.200	0.800
Lower Tol.	0.200	0.500	0.200	0.100	0.200	0.200	0.100	0.050	0.000	0.000
USL	3.200	267.480	3.220	5.100	2.220	3.200	4.300	2.050	0.200	0.800
LSL	2.800	266.480	2.820	4.900	1.820	2.800	4.100	1.950	0.000	0.000
Total Tol	0.400	1.000	0.400	0.200	0.400	0.400	0.200	0.100	0.200	0.800
Process Capability Statistics										
Xbar +3σ	3.097	267.237	3.139	5.047	2.086	3.097	4.251	2.025	0.130	0.589
Xbar	3.004	267.011	3.039	4.999	2.004	3.009	4.201	2.000	0.084	0.390
Xbar -3σ	2.910	266.785	2.940	4.951	1.922	2.921	4.152	1.975	0.038	0.191
Std dev	0.031	0.075	0.033	0.016	0.027	0.029	0.017	0.008	0.015	0.066
Zu	2.095	2.074	1.819	2.098	2.631	2.174	1.987	2.007	2.540	2.065
Zl	2.173	2.351	2.208	2.056	2.241	2.379	2.041	2.007		
Cp	2.134	2.213	2.014	2.077	2.436	2.277	2.014	2.007	2.190	2.015
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Cpk	2.095	2.074	1.819	2.056	2.241	2.174	1.987	2.007	2.190	2.015
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Max	3.050	267.150	3.090	5.030	2.040	3.060	4.230	2.010	0.110	0.500
Min	2.930	266.860	2.970	4.980	1.960	2.960	4.180	1.990	0.050	0.300
Variance	0.120	0.290	0.120	0.050	0.080	0.100	0.050	0.020	0.060	0.200
DIMENSIONAL DATA										
Sample	4	19	20	21	35	36	48	49	52	53
1	2.99	267.05	3.08	4.98	2.04	3.05	4.22	2.00	0.08	0.40
2	3.02	267.04	3.06	4.99	2.02	3.04	4.21	1.99	0.09	0.50
3	2.98	267.12	3.07	4.98	2.04	3.05	4.22	1.99	0.07	0.45
4	3.01	266.96	3.09	4.99	2.02	3.06	4.18	1.99	0.10	0.40
5	3.04	266.91	2.98	5.01	2.04	3.02	4.19	2.00	0.11	0.35
6	2.99	266.95	3.03	5.00	2.01	3.03	4.18	2.01	0.09	0.40
7	3.02	267.08	3.05	5.02	2.00	2.98	4.19	1.99	0.08	0.50
8	2.97	267.03	3.07	5.02	1.96	2.96	4.21	1.99	0.07	0.30
9	3.01	267.04	3.06	4.98	1.98	2.99	4.21	2.00	0.08	0.35
10	3.02	267.07	3.04	4.98	1.99	2.97	4.19	2.01	0.09	0.30
11	2.95	267.15	3.06	5.00	1.96	2.98	4.18	2.01	0.05	0.35
12	2.93	267.04	3.03	5.01	1.97	3.01	4.20	2.00	0.06	0.40
13	3.02	266.89	2.99	5.02	2.04	3.03	4.20	2.01	0.08	0.50
14	3.03	266.98	2.97	5.03	2.01	3.02	4.22	2.00	0.09	0.45
15	2.97	267.08	3.08	4.98	2.02	3.00	4.18	2.00	0.08	0.30
16	3.04	266.94	3.05	4.99	1.98	3.01	4.19	1.99	0.10	0.35
17	3.02	266.97	3.06	4.98	2.02	3.02	4.23	1.99	0.08	0.40
18	3.05	266.86	3.03	4.99	2.04	3.04	4.21	2.00	0.10	0.50
19	2.98	266.99	3.05	4.98	1.99	2.98	4.23	1.99	0.09	0.45
20	3.03	267.09	3.04	5.00	1.97	2.99	4.19	2.01	0.07	0.30
21	2.98	267.01	2.98	5.02	2.00	2.96	4.19	2.00	0.08	0.35
22	3.03	266.87	3.01	5.01	2.03	2.98	4.20	2.01	0.09	0.40
23	2.98	266.95	3.07	5.00	2.04	3.01	4.23	2.01	0.11	0.30
24	2.97	266.98	3.05	5.01	2.01	3.03	4.18	2.00	0.08	0.35
25	3.03	267.02	3.07	4.99	2.02	3.04	4.19	1.99	0.07	0.40
26	3.04	267.13	3.01	5.02	2.02	3.01	4.18	1.99	0.11	0.45
27	3.02	267.10	3.07	5.00	1.99	3.04	4.21	2.01	0.07	0.30
28	3.04	267.03	3.01	4.99	1.97	3.02	4.22	2.00	0.10	0.35
29	2.96	266.99	3.02	4.98	1.96	2.99	4.21	2.01	0.09	0.40
30	2.99	267.02	3.00	5.02	1.98	2.96	4.20	2.01	0.06	0.45

Process Capability Evaluation

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Part Name: COVER, RIGHT TOP				Prepared By : Chu Libo					Cpk : 1.3	
Part Revision: C				Date of Evaluation : 30-May-24						
Specification										
Item No	55	56	59	62.1	62.2	62.3	62.4	70		
Cavity	1	1	1	1	1	1	1	1		
Nominal	4.200	0.000	37.500	14.000	14.000	14.000	14.000	0.000		
Upper Tol.	0.100	0.200	0.200	0.200	0.200	0.200	0.200	0.200		
Lower Tol.	0.100	0.000	0.400	0.200	0.200	0.200	0.200	0.000		
USL	4.300	0.200	37.700	14.200	14.200	14.200	14.200	0.200	0.000	0.000
LSL	4.100	0.000	37.100	13.800	13.800	13.800	13.800	0.000	0.000	0.000
Total Tol	0.200	0.200	0.600	0.400	0.400	0.400	0.400	0.200	0.000	0.000
Process Capability Statistics										
Xbar +3σ	4.249	0.128	37.501	14.101	14.095	14.103	14.081	0.131	#VALUE!	#VALUE!
Xbar	4.200	0.090	37.399	14.001	14.000	14.007	14.002	0.086		
Xbar -3σ	4.151	0.051	37.297	13.902	13.905	13.911	13.923	0.041	#VALUE!	#VALUE!
Std dev	0.016	0.013	0.034	0.033	0.032	0.032	0.026	0.015		
Zu	2.053	2.890	2.953	1.995	2.101	2.006	2.508	2.538		
Zl	2.039		2.934	2.022	2.101	2.151	2.559			
Cp	2.046	2.619	2.944	2.009	2.101	2.079	2.534	2.220		
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control		
Cpk	2.039	2.619	2.934	1.995	2.101	2.006	2.508	2.220		
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control		
Max	4.230	0.110	37.450	14.070	14.060	14.060	14.040	0.110	0.000	0.000
Min	4.170	0.070	37.350	13.920	13.950	13.950	13.960	0.060	0.000	0.000
Variance	0.060	0.040	0.100	0.150	0.110	0.110	0.080	0.050	0.000	0.000
DIMENSIONAL DATA										
Sample	55	56	59	62.1	62.2	62.3	62.4	70		
1	4.21	0.08	37.36	13.99	13.96	14.03	13.96	0.06		
2	4.22	0.10	37.35	13.97	13.98	14.00	13.99	0.09		
3	4.20	0.08	37.36	13.92	13.99	14.05	13.97	0.09		
4	4.18	0.11	37.40	13.97	13.97	14.03	14.02	0.07		
5	4.17	0.10	37.45	14.02	13.98	14.01	14.00	0.08		
6	4.19	0.07	37.42	14.01	13.99	14.03	14.03	0.07		
7	4.21	0.09	37.39	14.03	14.00	13.99	14.02	0.09		
8	4.20	0.08	37.37	14.04	14.03	13.95	13.98	0.10		
9	4.21	0.10	37.44	14.03	14.06	14.01	13.97	0.11		
10	4.19	0.07	37.45	14.04	14.04	14.05	14.03	0.09		
11	4.18	0.08	37.41	13.98	13.96	13.98	13.97	0.07		
12	4.21	0.10	37.38	13.97	14.02	14.03	14.03	0.09		
13	4.22	0.11	37.35	14.03	14.01	14.06	13.98	0.07		
14	4.23	0.09	37.38	13.99	14.04	14.01	13.99	0.10		
15	4.20	0.08	37.44	13.97	13.98	13.96	14.04	0.08		
16	4.19	0.09	37.41	13.98	13.96	13.99	14.03	0.07		
17	4.19	0.07	37.35	14.04	13.97	14.03	13.97	0.11		
18	4.18	0.08	37.40	14.02	14.01	14.01	13.99	0.09		
19	4.21	0.09	37.45	14.01	14.03	14.05	14.02	0.10		
20	4.23	0.08	37.42	14.03	13.95	13.98	14.01	0.08		
21	4.20	0.10	37.44	14.07	13.97	13.95	14.03	0.06		
22	4.21	0.09	37.36	13.98	14.00	13.97	14.04	0.07		
23	4.17	0.11	37.39	13.96	14.05	13.99	13.97	0.09		
24	4.19	0.09	37.38	13.98	14.03	14.02	13.98	0.11		
25	4.20	0.07	37.42	14.02	14.05	14.05	14.03	0.08		
26	4.18	0.08	37.35	14.03	14.02	14.03	13.98	0.09		
27	4.19	0.10	37.40	14.01	13.99	14.00	13.97	0.11		
28	4.21	0.11	37.39	13.96	13.97	13.96	14.02	0.10		
29	4.20	0.10	37.45	13.97	14.02	13.97	14.03	0.07		
30	4.22	0.09	37.41	14.02	13.97	14.02	14.01	0.08		