

Process Capability Evaluation

Process Capability Evaluation										
Part Number: 20097832				Supplier : Hansin Precision Engineering				Target	CP : 2.0	
Part Name: ASSY LEFT DOOR				Prepared By : Chu Libo					Cpk : 1.33	
Part Revision: B				Date of Evaluation : 21/May/24					NA	
Specification										
Item No	19	42.1	42.2	49.1	49.2	50.1	50.2	57.1	57.2	63.1
Cavity	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Nominal	0.000	9.000	9.000	306.000	306.000	14.360	14.360	50.000	50.000	9.190
Upper Tol.	0.150	0.100	0.100	0.100	0.100	0.100	0.100	0.050	0.050	0.200
Lower Tol.	0.000	0.100	0.100	0.100	0.100	0.100	0.100	0.050	0.050	0.200
USL	0.150	9.100	9.100	306.100	306.100	14.460	14.460	50.050	50.050	9.390
LSL	0.000	8.900	8.900	305.900	305.900	14.260	14.260	49.950	49.950	8.990
Total Tol	0.150	0.200	0.200	0.200	0.200	0.200	0.200	0.100	0.100	0.400
Process Capability Statistics										
Xbar +3σ	0.058	8.960	8.961	306.028	306.027	14.375	14.374	50.043	50.041	9.147
Xbar	0.029	8.940	8.940	305.991	305.995	14.359	14.360	50.024	50.020	9.110
Xbar -3σ		8.920	8.919	305.954	305.964	14.342	14.345	50.004	49.999	9.073
Std dev	0.010	0.007	0.007	0.012	0.010	0.006	0.005	0.006	0.007	0.012
Zu	4.160	8.036	7.542	2.935	3.341	6.081	7.051	1.362	1.449	7.590
Zl		1.989	1.886	2.460	3.035	5.937	6.995	3.797	3.318	3.237
Cp	2.574	5.012	4.714	2.698	3.188	6.009	7.023	2.579	2.383	5.414
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Cpk	2.574	1.989	1.886	2.460	3.035	5.937	6.995	1.362	1.449	3.237
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Max	0.050	8.950	8.960	306.010	306.010	14.370	14.370	50.030	50.030	9.130
Min	0.010	8.930	8.930	305.960	305.950	14.350	14.350	50.010	50.010	9.090
Variance	0.040	0.020	0.030	0.050	0.060	0.020	0.020	0.020	0.020	0.040
DIMENSIONAL DATA										
Sample	19	42.1	42.2	49.1	49.2	50.1	50.2	57.1	57.2	63.1
1	0.03	8.95	8.94	306.00	306.00	14.37	14.37	50.03	50.02	9.11
2	0.03	8.94	8.94	305.98	305.99	14.36	14.36	50.03	50.01	9.12
3	0.02	8.94	8.94	305.98	306.00	14.36	14.36	50.02	50.02	9.11
4	0.03	8.93	8.93	305.99	305.99	14.36	14.36	50.02	50.01	9.09
5	0.03	8.93	8.93	305.98	306.00	14.37	14.37	50.03	50.02	9.09
6	0.05	8.94	8.94	306.01	306.00	14.36	14.36	50.03	50.03	9.09
7	0.04	8.94	8.94	306.00	305.98	14.36	14.36	50.01	50.03	9.11
8	0.03	8.94	8.94	305.99	306.00	14.36	14.36	50.02	50.02	9.11
9	0.02	8.94	8.95	306.00	306.00	14.36	14.36	50.03	50.03	9.10
10	0.03	8.94	8.94	306.01	305.99	14.35	14.35	50.03	50.03	9.13
11	0.04	8.93	8.96	305.98	306.01	14.36	14.36	50.02	50.03	9.11
12	0.03	8.93	8.93	305.98	305.99	14.36	14.36	50.03	50.02	9.12
13	0.03	8.94	8.94	305.99	305.98	14.35	14.36	50.03	50.02	9.12
14	0.03	8.94	8.93	306.00	306.00	14.36	14.36	50.03	50.02	9.11
15	0.05	8.94	8.94	305.99	305.98	14.36	14.36	50.02	50.03	9.09
16	0.03	8.94	8.95	305.96	306.01	14.35	14.36	50.02	50.01	9.09
17	0.03	8.94	8.94	305.98	306.00	14.36	14.36	50.02	50.02	9.09
18	0.03	8.93	8.94	306.00	305.98	14.35	14.36	50.03	50.01	9.11
19	0.01	8.94	8.94	305.98	305.99	14.36	14.36	50.01	50.02	9.11
20	0.01	8.93	8.93	306.00	306.01	14.36	14.35	50.02	50.03	9.13
21	0.02	8.95	8.94	305.98	306.01	14.36	14.36	50.01	50.01	9.11
22	0.02	8.94	8.94	305.99	305.99	14.36	14.36	50.02	50.01	9.12
23	0.03	8.95	8.94	306.01	306.01	14.35	14.35	50.03	50.01	9.12
24	0.02	8.95	8.95	306.00	305.99	14.36	14.36	50.03	50.02	9.12
25	0.03	8.95	8.94	306.00	305.98	14.36	14.36	50.02	50.01	9.13
26	0.02	8.94	8.93	306.01	305.98	14.36	14.35	50.03	50.01	9.12
27	0.02	8.94	8.94	305.98	305.99	14.36	14.36	50.03	50.02	9.12
28	0.03	8.95	8.96	305.98	305.95	14.36	14.36	50.02	50.01	9.10
29	0.04	8.94	8.94	306.00	306.00	14.36	14.36	50.02	50.02	9.11
30	0.03	8.95	8.95	305.99	305.99	14.36	14.36	50.03	50.02	9.09

Process Capability Evaluation

Process Capability Evaluation									
Part Number:	20097832			Supplier : Hansin Precision Engines		Target	CP : 2.0		
Part Name:	ASSY LEFT DOOR			Prepared By : Chu Libo			Cpk : 1.33		
Part Revision:	B			Date of Evaluation : 21/May/24			NA		
Specification									
Item No	63.2	64	65	67.1	67.2				
Cavity	N/A	N/A	N/A	N/A	N/A				
Nominal	9.190	50.000	9.000	4.000	4.000				
Upper Tol.	0.200	0.050	0.150	0.012	0.012				
Lower Tol.	0.200	0.050	0.150	0.000	0.000				
USL	9.390	50.050	9.150	4.012	4.012				
LSL	8.990	49.950	8.850	4.000	4.000				
Total Tol	0.400	0.100	0.300	0.012	0.012				
Process Capability Statistics									
Xbar +3σ	9.142	50.039	9.033	4.000	4.000				
Xbar	9.102	50.017	8.977	4.000	4.000				
Xbar -3σ	9.061	49.994	8.920	4.000	4.000				
Std dev	0.013	0.008	0.019	0.000	0.000				
Zu	7.166	1.466	3.071	#DIV/0!	#DIV/0!				
Zl	2.775	2.931	2.244	#DIV/0!	#DIV/0!				
Cp	4.971	2.198	2.657	#DIV/0!	#DIV/0!				
	In Control	In Control	In Control	#DIV/0!	#DIV/0!				
Cpk	2.775	1.466	2.244	#DIV/0!	#DIV/0!				
	In Control	In Control	In Control	#DIV/0!	#DIV/0!				
Max	9.140	50.030	9.020	4.000	4.000				
Min	9.080	50.000	8.950	4.000	4.000				
Variance	0.060	0.030	0.070	0.000	0.000				
DIMENSIONAL DATA									
Sample	63.2	64	65	67.1	67.2				
1	9.11	50.02	8.97	4.00	4.00				
2	9.10	50.01	8.95	4.00	4.00				
3	9.10	50.01	9.02	4.00	4.00				
4	9.10	50.02	8.97	4.00	4.00				
5	9.10	50.01	8.96	4.00	4.00				
6	9.10	50.03	8.95	4.00	4.00				
7	9.09	50.02	8.96	4.00	4.00				
8	9.11	50.03	8.96	4.00	4.00				
9	9.08	50.01	8.99	4.00	4.00				
10	9.08	50.02	8.97	4.00	4.00				
11	9.09	50.02	8.98	4.00	4.00				
12	9.10	50.01	9.01	4.00	4.00				
13	9.11	50.01	8.98	4.00	4.00				
14	9.10	50.02	8.97	4.00	4.00				
15	9.09	50.00	8.97	4.00	4.00				
16	9.11	50.03	8.97	4.00	4.00				
17	9.08	50.02	8.98	4.00	4.00				
18	9.10	50.02	8.96	4.00	4.00				
19	9.09	50.02	8.98	4.00	4.00				
20	9.14	50.02	9.01	4.00	4.00				
21	9.10	50.01	8.98	4.00	4.00				
22	9.13	50.02	9.02	4.00	4.00				
23	9.12	50.01	8.99	4.00	4.00				
24	9.11	50.01	8.97	4.00	4.00				
25	9.11	50.01	8.96	4.00	4.00				
26	9.10	50.03	8.96	4.00	4.00				
27	9.10	50.02	8.98	4.00	4.00				
28	9.09	50.02	8.96	4.00	4.00				
29	9.11	50.01	8.98	4.00	4.00				
30	9.10	50.01	8.99	4.00	4.00				