

Process Capability Evaluation										
Part Number: 20097833				Supplier : Hansin Precision Engineering				Target	CP : 2.0	
Part Name: ASSY RIGHT DOOR				Prepared By : Chu Libo					Cpk : 1.33	
Part Revision: B				Date of Evaluation : 21/May/24					NA	
Specification										
Item No	14.1	14.2	15.1	15.2	16	17.1	17.2	24.1	24.2	24.3
Cavity	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Nominal	50.000	50.000	14.360	14.360	28.720	306.000	306.000	9.000	9.000	9.000
Upper Tol.	0.050	0.050	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.100
Lower Tol.	0.050	0.050	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.100
USL	50.050	50.050	14.460	14.460	28.820	306.100	306.100	9.100	9.100	9.100
LSL	49.950	49.950	14.260	14.260	28.620	305.900	305.900	8.900	8.900	8.900
Total Tol	0.100	0.100	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.200
Process Capability Statistics										
Xbar +3σ	50.040	50.038	14.373	14.370	28.739	305.999	306.003	8.982	8.974	8.971
Xbar	50.019	50.023	14.358	14.358	28.724	305.981	305.983	8.957	8.954	8.950
Xbar -3σ	49.998	50.009	14.343	14.346	28.709	305.963	305.964	8.931	8.933	8.930
Std dev	0.007	0.005	0.005	0.004	0.005	0.006	0.006	0.008	0.007	0.007
Zu	1.451	1.854	7.021	8.357	6.327	6.442	6.018	5.675	7.180	7.343
Zl	3.230	5.098	6.746	8.029	6.900	4.385	4.299	2.244	2.633	2.470
Cp	2.341	3.476	6.884	8.193	6.614	5.414	5.158	3.959	4.907	4.907
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Cpk	1.451	1.854	6.746	8.029	6.327	4.385	4.299	2.244	2.633	2.470
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Max	50.030	50.030	14.360	14.360	28.730	305.990	305.990	8.970	8.970	8.960
Min	50.000	50.020	14.340	14.350	28.720	305.970	305.970	8.940	8.940	8.940
Variance	0.030	0.010	0.020	0.010	0.010	0.020	0.020	0.030	0.030	0.020
DIMENSIONAL DATA										
Sample	14.1	14.2	15.1	15.2	16	17.1	17.2	24.1	24.2	24.3
1	50.00	50.02	14.36	14.36	28.72	305.98	305.98	8.97	8.95	8.95
2	50.02	50.02	14.36	14.36	28.73	305.98	305.98	8.96	8.94	8.94
3	50.01	50.03	14.36	14.36	28.72	305.97	305.99	8.95	8.95	8.95
4	50.02	50.03	14.36	14.35	28.72	305.98	305.98	8.95	8.95	8.95
5	50.01	50.03	14.36	14.36	28.73	305.98	305.99	8.96	8.95	8.95
6	50.02	50.03	14.35	14.35	28.72	305.98	305.98	8.96	8.94	8.94
7	50.02	50.02	14.36	14.36	28.73	305.97	305.98	8.95	8.95	8.95
8	50.01	50.02	14.36	14.36	28.73	305.98	305.99	8.95	8.94	8.95
9	50.02	50.02	14.36	14.36	28.73	305.98	305.99	8.95	8.96	8.96
10	50.01	50.02	14.36	14.36	28.72	305.99	305.99	8.94	8.96	8.96
11	50.02	50.02	14.36	14.36	28.72	305.98	305.99	8.95	8.95	8.95
12	50.01	50.02	14.36	14.36	28.72	305.98	305.99	8.94	8.96	8.96
13	50.03	50.02	14.36	14.35	28.73	305.99	305.97	8.96	8.95	8.95
14	50.02	50.03	14.36	14.36	28.72	305.99	305.98	8.96	8.95	8.94
15	50.02	50.02	14.36	14.36	28.73	305.99	305.98	8.95	8.95	8.95
16	50.02	50.02	14.34	14.36	28.72	305.99	305.97	8.96	8.96	8.94
17	50.01	50.02	14.36	14.36	28.73	305.99	305.98	8.95	8.96	8.94
18	50.02	50.02	14.35	14.36	28.72	305.97	305.98	8.95	8.96	8.95
19	50.02	50.02	14.36	14.36	28.73	305.99	305.99	8.96	8.96	8.95
20	50.02	50.02	14.36	14.36	28.73	305.97	305.98	8.97	8.97	8.96
21	50.02	50.02	14.36	14.36	28.73	305.99	305.98	8.97	8.96	8.95
22	50.02	50.03	14.36	14.36	28.72	305.98	305.99	8.96	8.95	8.95
23	50.03	50.02	14.36	14.36	28.72	305.98	305.99	8.96	8.96	8.95
24	50.02	50.03	14.36	14.35	28.72	305.98	305.99	8.96	8.95	8.95
25	50.03	50.02	14.36	14.36	28.73	305.97	305.99	8.94	8.96	8.96
26	50.03	50.02	14.36	14.36	28.72	305.99	305.99	8.96	8.96	8.95
27	50.02	50.03	14.35	14.35	28.73	305.99	305.97	8.97	8.95	8.95
28	50.02	50.03	14.36	14.36	28.72	305.97	305.99	8.96	8.95	8.96
29	50.03	50.02	14.36	14.36	28.72	305.98	305.97	8.96	8.96	8.95
30	50.02	50.03	14.35	14.35	28.72	305.97	305.98	8.97	8.95	8.95

Process Capability Evaluation										
Part Number: 20097833			Supplier : Hansin Precision Engineering					Target	CP : 2.0	
Part Name: ASSY RIGHT DOOR			Prepared By : Chu Libo						Cpk : 1.33	
Part Revision: B			Date of Evaluation : 21/May/24						NA	
Specification										
Item No	52	53	66.1	66.2	67	68	70.1	70.2		
Cavity	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A		
Nominal	0.000	1.500	9.190	9.190	9.000	50.000	4.000	4.000		
Upper Tol.	0.150	0.080	0.200	0.200	0.150	0.050	0.012	0.012		
Lower Tol.	0.000	0.080	0.200	0.200	0.150	0.050	0.000	0.000		
USL	0.150	1.580	9.390	9.390	9.150	50.050	4.012	4.012		
LSL	0.000	1.420	8.990	8.990	8.850	49.950	4.000	4.000		
Total Tol	0.150	0.160	0.400	0.400	0.300	0.100	0.012	0.012		
Process Capability Statistics										
Xbar +3σ	0.073	1.527	9.150	9.156	9.024	50.040	4.000	4.000		
Xbar	0.036	1.504	9.102	9.103	8.978	50.018	4.000	4.000		
Xbar -3σ		1.481	9.053	9.050	8.932	49.996	4.000	4.000		
Std dev	0.012	0.008	0.016	0.018	0.015	0.007	0.000	0.000		
Zu	3.044	3.327	5.930	5.421	3.722	1.481	#DIV/0!	#DIV/0!		
Zl		3.646	2.297	2.135	2.770	3.099	#DIV/0!	#DIV/0!		
Cp	2.002	3.486	4.114	3.778	3.246	2.290	#DIV/0!	#DIV/0!		
	In Control	In Control	In Control	In Control	In Control	In Control	#DIV/0!	#DIV/0!		
Cpk	2.002	3.327	2.297	2.135	2.770	1.481	#DIV/0!	#DIV/0!		
	In Control	In Control	In Control	In Control	In Control	In Control	#DIV/0!	#DIV/0!		
Max	0.080	1.520	9.130	9.150	9.010	50.030	4.000	4.000		
Min	0.020	1.490	9.070	9.070	8.950	49.990	4.000	4.000		
Variance	0.060	0.030	0.060	0.080	0.060	0.040	0.000	0.000		
DIMENSIONAL DATA										
Sample	52	53	66.1	66.2	67	68	70.1	70.2		
1	0.03	1.52	9.12	9.12	8.98	50.01	4.00	4.00		
2	0.06	1.51	9.13	9.15	8.97	50.03	4.00	4.00		
3	0.05	1.52	9.10	9.09	8.98	50.02	4.00	4.00		
4	0.03	1.50	9.09	9.10	8.99	50.02	4.00	4.00		
5	0.08	1.52	9.12	9.10	8.99	50.02	4.00	4.00		
6	0.04	1.50	9.11	9.13	9.00	50.02	4.00	4.00		
7	0.03	1.50	9.09	9.12	9.01	50.02	4.00	4.00		
8	0.03	1.50	9.10	9.12	8.98	50.02	4.00	4.00		
9	0.05	1.50	9.10	9.12	8.97	50.02	4.00	4.00		
10	0.05	1.50	9.13	9.09	8.98	50.02	4.00	4.00		
11	0.04	1.50	9.12	9.07	9.00	50.02	4.00	4.00		
12	0.03	1.50	9.12	9.11	8.97	50.02	4.00	4.00		
13	0.04	1.49	9.12	9.08	8.97	50.01	4.00	4.00		
14	0.04	1.50	9.09	9.08	8.96	50.02	4.00	4.00		
15	0.02	1.50	9.07	9.08	8.98	50.01	4.00	4.00		
16	0.03	1.50	9.11	9.07	8.95	50.01	4.00	4.00		
17	0.02	1.50	9.08	9.10	8.98	50.02	4.00	4.00		
18	0.03	1.50	9.08	9.11	8.98	50.02	4.00	4.00		
19	0.03	1.49	9.08	9.09	8.99	49.99	4.00	4.00		
20	0.02	1.50	9.07	9.10	9.00	50.02	4.00	4.00		
21	0.03	1.50	9.10	9.11	8.98	50.02	4.00	4.00		
22	0.03	1.51	9.10	9.11	8.96	50.02	4.00	4.00		
23	0.04	1.51	9.11	9.11	8.96	50.02	4.00	4.00		
24	0.03	1.50	9.10	9.09	8.95	50.02	4.00	4.00		
25	0.03	1.50	9.10	9.11	8.96	50.01	4.00	4.00		
26	0.04	1.51	9.09	9.11	8.99	50.02	4.00	4.00		
27	0.03	1.51	9.11	9.10	8.99	50.02	4.00	4.00		
28	0.03	1.50	9.11	9.11	8.96	50.02	4.00	4.00		
29	0.03	1.51	9.10	9.10	8.97	50.03	4.00	4.00		
30	0.04	1.51	9.10	9.11	8.99	50.01	4.00	4.00		