

Process Capability Evaluation

Part Number: 20098635				Supplier : Hansin Precision Engineering				Target	CP : 2.0	
Part Name: FRONT COVER				Prepared By : Chu Libo					Cpk : 1.3	
Part Revision: B				Date of Evaluation : 19-May-24						
Specification										
Item No	30	82.1	82.2	133.1	133.2	133.3	133.4	135	138.1	138.2
Cavity	1	1	1	1	1	1	1	1	1	1
Nominal	24.520	12.020	12.020	84.100	84.100	84.100	84.100	24.520	331.900	331.900
Upper Tol.	0.200	0.200	0.200	0.300	0.300	0.300	0.300	0.200	0.550	0.550
Lower Tol.	0.200	0.200	0.200	0.300	0.300	0.300	0.300	0.200	0.550	0.550
USL	24.720	12.220	12.220	84.400	84.400	84.400	84.400	24.720	332.450	332.450
LSL	24.320	11.820	11.820	83.800	83.800	83.800	83.800	24.320	331.350	331.350
Total Tol	0.400	0.400	0.400	0.600	0.600	0.600	0.600	0.400	1.100	1.100
Process Capability Statistics										
Xbar +3σ	24.636	12.089	12.131	84.009	84.218	84.018	84.015	24.575	332.279	332.325
Xbar	24.560	12.001	12.033	83.946	84.143	83.948	83.949	24.498	332.074	332.099
Xbar -3σ	24.483	11.912	11.935	83.884	84.068	83.878	83.884	24.421	331.869	331.873
Std dev	0.026	0.029	0.033	0.021	0.025	0.023	0.022	0.026	0.068	0.075
Zu	2.088	2.481	1.914	7.285	3.428	6.439	6.890	2.885	1.837	1.555
Zl	3.119	2.043	2.176	2.350	4.585	2.108	2.283	2.305	3.532	3.313
Cp	2.603	2.262	2.045	4.817	4.006	4.273	4.586	2.595	2.684	2.434
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Cpk	2.088	2.043	1.914	2.350	3.428	2.108	2.283	2.305	1.837	1.555
	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control	In Control
Max	24.610	12.060	12.110	83.990	84.190	83.990	83.990	24.540	332.260	332.260
Min	24.510	11.940	11.970	83.910	84.110	83.910	83.910	24.450	331.960	331.940
Variance	0.100	0.120	0.140	0.080	0.080	0.080	0.080	0.090	0.300	0.320
DIMENSIONAL DATA										
Sample	30	82.1	82.2	133.1	133.2	133.3	133.4	135	138.1	138.2
1	24.58	12.06	12.01	83.95	84.11	83.96	83.91	24.50	332.06	331.94
2	24.51	11.99	12.09	83.92	84.15	83.99	83.95	24.45	331.98	332.06
3	24.53	12.06	12.02	83.92	84.13	83.95	83.98	24.51	331.96	331.98
4	24.60	12.00	12.05	83.95	84.15	83.97	83.99	24.50	332.02	332.06
5	24.54	12.02	12.03	83.93	84.12	83.95	83.95	24.50	331.98	332.05
6	24.54	12.01	12.11	83.92	84.13	83.92	83.95	24.48	332.10	332.26
7	24.53	12.01	12.01	83.91	84.19	83.99	83.99	24.52	331.98	332.05
8	24.55	12.00	12.01	83.95	84.13	83.97	83.94	24.54	332.06	331.96
9	24.57	12.03	12.05	83.92	84.13	83.92	83.95	24.53	332.00	332.14
10	24.56	12.04	12.05	83.95	84.15	83.96	83.95	24.54	332.26	332.04
11	24.54	12.01	12.04	83.96	84.13	83.99	83.95	24.52	332.04	332.17
12	24.58	11.98	12.03	83.99	84.16	83.95	83.95	24.51	332.09	332.09
13	24.58	12.01	11.97	83.95	84.15	83.94	83.96	24.52	332.12	332.14
14	24.56	11.99	12.01	83.97	84.13	83.92	83.95	24.50	332.16	332.14
15	24.55	11.95	12.02	83.99	84.11	83.92	83.93	24.48	332.06	332.20
16	24.61	12.01	12.05	83.95	84.12	83.95	83.95	24.50	332.11	332.17
17	24.56	12.00	11.99	83.97	84.15	83.98	83.92	24.51	332.02	332.13
18	24.51	11.99	12.06	83.94	84.12	83.95	83.97	24.50	332.06	332.07
19	24.56	11.99	12.01	83.92	84.13	83.95	83.92	24.54	332.14	332.15
20	24.54	11.97	12.01	83.95	84.11	83.92	83.96	24.48	332.06	332.09
21	24.56	12.00	11.99	83.95	84.11	83.95	83.92	24.49	332.06	332.02
22	24.53	12.06	12.04	83.97	84.18	83.92	83.95	24.52	332.07	332.06
23	24.60	11.94	12.03	83.95	84.15	83.91	83.98	24.48	332.02	332.10
24	24.58	11.99	12.04	83.96	84.19	83.95	83.92	24.50	332.21	332.23
25	24.58	12.00	11.97	83.91	84.18	83.95	83.95	24.49	332.12	332.15
26	24.56	11.98	12.05	83.95	84.15	83.92	83.97	24.48	332.09	332.11
27	24.60	11.96	12.07	83.95	84.17	83.97	83.95	24.45	332.08	332.07
28	24.57	11.97	12.03	83.95	84.15	83.95	83.97	24.46	332.12	332.03
29	24.55	11.99	12.08	83.95	84.13	83.92	83.91	24.48	332.14	332.14
30	24.56	12.01	12.06	83.94	84.19	83.95	83.94	24.45	332.04	332.16

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Part Name: FRONT COVER		Prepared By : Chu Libo			Cpk : 1.3	
Part Revision: B		Date of Evaluation : 19-May-24				
Specification						
Item No	138.3	138.4	138.5	138.6		
Cavity	1	1	1	1		
Nominal	331.900	331.900	331.900	331.900		
Upper Tol.	0.550	0.550	0.550	0.550		
Lower Tol.	0.550	0.550	0.550	0.550		
USL	332.450	332.450	332.450	332.450	0.000	0.000
LSL	331.350	331.350	331.350	331.350	0.000	0.000
Total Tol	1.100	1.100	1.100	1.100	0.000	0.000
Process Capability Statistics						
Xbar +3σ	332.351	332.349	332.302	332.285	#VALUE!	#VALUE!
Xbar	332.119	332.110	332.102	332.014		
Xbar -3σ	331.887	331.870	331.902	331.743	#VALUE!	#VALUE!
Std dev	0.077	0.080	0.067	0.090		
Zu	1.424	1.422	1.741	1.609		
Zl	3.309	3.173	3.756	2.448		
Cp	2.366	2.297	2.749	2.028		
	In Control	In Control	In Control	In Control		
Cpk	1.424	1.422	1.741	1.609		
	In Control	In Control	In Control	In Control		
Max	332.340	332.320	332.290	332.190	0.000	0.000
Min	332.010	332.010	331.980	331.810	0.000	0.000
Variance	0.330	0.310	0.310	0.380	0.000	0.000
DIMENSIONAL DATA						
Sample	138.3	138.4	138.5	138.6		
1	332.01	332.04	331.98	332.05		
2	332.09	332.10	332.10	331.92		
3	332.10	332.06	332.01	331.94		
4	332.05	332.08	332.11	331.90		
5	332.08	332.01	332.11	331.96		
6	332.34	332.11	332.10	332.11		
7	332.02	332.01	332.02	331.97		
8	332.02	332.06	332.05	331.95		
9	332.07	332.16	332.11	332.05		
10	332.11	332.30	332.05	332.15		
11	332.24	332.18	332.19	332.06		
12	332.05	332.05	332.13	332.19		
13	332.27	332.06	332.08	332.11		
14	332.21	332.12	332.11	331.98		
15	332.09	332.06	332.14	332.02		
16	332.11	332.11	332.07	332.08		
17	332.11	332.13	332.15	331.99		
18	332.05	332.11	332.08	331.93		
19	332.12	332.14	332.00	332.02		
20	332.23	332.32	332.29	332.18		
21	332.08	332.06	332.06	331.81		
22	332.14	332.07	332.23	332.03		
23	332.13	332.15	332.12	332.00		
24	332.06	332.28	332.11	332.11		
25	332.17	332.14	332.11	332.05		
26	332.17	332.06	332.11	332.05		
27	332.14	332.14	332.21	331.92		
28	332.14	332.03	332.07	331.89		
29	332.11	332.14	332.09	331.93		
30	332.06	332.01	332.06	332.06		