

1) IDENTIFICATION

Request reference :

L - 021

Date :

2022-01-12

Identification / Part description :

1010882

Project :

Samples quantity

10

Expert :

Moisa Alexandru

Appraiser 1 :

Morar Claudiu

Appraiser 2 :

Megyes Robert

Characteristic :

Length

Unit :

mm

S/R Product :

NA

2) CONCLUSION

Criteria	Result	OK	NOK	M.A
Number of categories ≥ 5	7			Validated by:
R&R < 10%	6.45%			
<u>Comments :</u>				

3) METHOD

- Select parts: Chose 10 parts and 2 operators minimum (guideline)
 - Make sure all the measures are done in the way
 - Make sure that you deal with the same measurements for the 10 parts
- Qualification rules :

4) MINITAB : Summary Report

Gage R&R

Variance Components

Source	VarComp	%Contribution
Total Gage R&R	1,667	0,42
Repeatability	1,667	0,42
Reproducibility	0	0,00
Appraiser na	0	0,00
Part-To-Part	398,333	99,58
Total Variation	400,000	100,00

Process tolerance = 4

Historical standard deviation = 2

Total Variance = historical standard deviation squared = 4

Gage Evaluation

Source	StdDev (SD)	Study Var	%Study Var	%Tolerance
Total Gage R&R	12,910	7,746	6,45	19,36
Repeatability	12,910	7,746	6,45	19,36
Reproducibility	0	0	0,00	0,00
Appraiser na	0	0	0,00	0,00
Part-To-Part	199,583	119,750	99,79	299,37
Total Variation	200,000	120,000	100,00	300,00

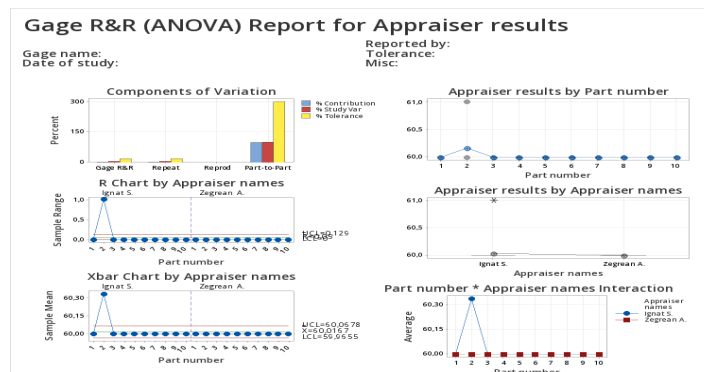
Historical standard deviation is used to calculate some values for StdDev, Study Var, and

%Study Var.

Values for %Process are not displayed because they are identical to values for %Study Var.

Number of Distinct Categories = 21

5) MINITAB : Variation Report



6) APPRAISERS RESULTS



Appraiser 1	Trials number	Part number	Appraiser results	Appraiser 2	Trials number	Part number	Appraiser results
Ignat S.	1	9	60.00	Zegrean A.	1	9	60.00
Ignat S.	1	10	60.00	Zegrean A.	1	5	60.00
Ignat S.	1	1	60.00	Zegrean A.	1	10	60.00
Ignat S.	1	7	60.00	Zegrean A.	1	6	60.00
Ignat S.	1	2	60.00	Zegrean A.	1	7	60.00
Ignat S.	1	4	60.00	Zegrean A.	1	3	60.00
Ignat S.	1	8	61.00	Zegrean A.	1	1	60.00
Ignat S.	1	6	60.00	Zegrean A.	1	8	60.00
Ignat S.	1	5	60.00	Zegrean A.	1	2	60.00
Ignat S.	1	3	60.00	Zegrean A.	1	3	61.00
Ignat S.	2	6	60.00	Zegrean A.	2	9	60.00
Ignat S.	2	4	60.00	Zegrean A.	2	4	60.00
Ignat S.	2	1	60.00	Zegrean A.	2	2	60.00
Ignat S.	2	7	60.00	Zegrean A.	2	1	60.00
Ignat S.	2	5	60.00	Zegrean A.	2	10	60.00
Ignat S.	2	9	60.00	Zegrean A.	2	6	60.00
Ignat S.	2	2	60.00	Zegrean A.	2	7	60.00
Ignat S.	2	3	61.00	Zegrean A.	2	8	60.00
Ignat S.	2	10	60.00	Zegrean A.	2	5	60.00
Ignat S.	2	8	60.00	Zegrean A.	2	8	60.00
Ignat S.	3	6	60.00	Zegrean A.	3	4	60.00
Ignat S.	3	2	60.00	Zegrean A.	3	5	60.00
Ignat S.	3	4	60.00	Zegrean A.	3	1	61.00
Ignat S.	3	3	60.00	Zegrean A.	3	3	60.00
Ignat S.	3	5	60.00	Zegrean A.	3	9	60.00
Ignat S.	3	8	60.00	Zegrean A.	3	10	60.00
Ignat S.	3	10	60.00	Zegrean A.	3	7	60.00
Ignat S.	3	7	60.00	Zegrean A.	3	6	60.00
Ignat S.	3	1	60.00	Zegrean A.	3	2	60.00
Ignat S.	3	9	60.00	Zegrean A.	3	4	60.00

Report date:

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Reported by :

M.A

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