

1) IDENTIFICATION

Request reference :

L - 021

Date :

2022-01-17

Identification / Part description :

1010883

Project :

Samples quantity

10

Expert :

Moisa Alexandru

Characteristic :

Length

Appraiser 1 :

Ignat S.

Unit :

mm

Appraiser 2 :

Zegrean A.

S/R Product :

NA

2) CONCLUSION

Criteria	Result	OK	NOK	M.A
Number of categories ≥ 5	20			Validated by:
R&R < 10%	6.80%			
<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	1,156	0,46
Repeatability	1,156	0,46
Reproducibility	0	0,00
Appraiser na	0	0,00
Part-To-Part	248,844	99,54
Total Variation	250,000	100,00

Process tolerance = 10

Historical standard deviation = 5

Total Variance = historical standard deviation squared = 25

Gage Evaluation

Source	StdDev (SD)	Study Var	%Study Var	%Tolerance
Total Gage R&R	34,007	20,404	6,80	20,40
Repeatability	34,007	20,404	6,80	20,40
Reproducibility	0	0	0,00	0,00
Appraiser na	0	0	0,00	0,00
Part-To-Part	498,842	299,305	99,77	299,31
Total Variation	500,000	300,000	100,00	300,00

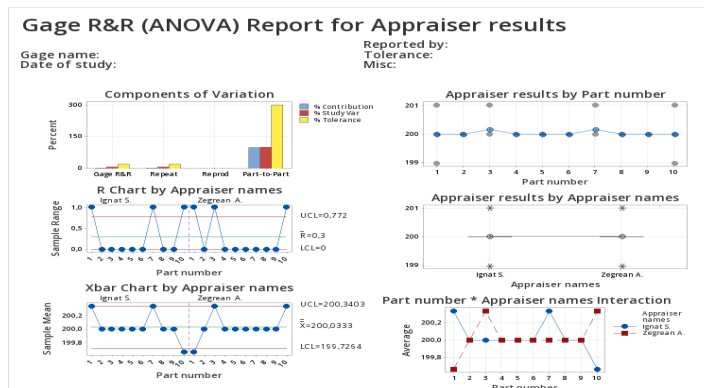
Historical standard deviation is used to calculate some values for StdDev, Study Var, and

%Study Var.

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

Number of Distinct Categories = 20

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	200.00	Zegrean A.	1	9	200.00
Ignat S.	1	10	200.00	Zegrean A.	1	5	200.00
Ignat S.	1	1	200.00	Zegrean A.	1	10	200.00
Ignat S.	1	7	200.00	Zegrean A.	1	6	200.00
Ignat S.	1	2	200.00	Zegrean A.	1	7	200.00
Ignat S.	1	4	200.00	Zegrean A.	1	3	200.00
Ignat S.	1	8	200.00	Zegrean A.	1	1	201.00
Ignat S.	1	6	201.00	Zegrean A.	1	8	200.00
Ignat S.	1	5	200.00	Zegrean A.	1	2	200.00
Ignat S.	1	3	200.00	Zegrean A.	1	3	202.00
Ignat S.	2	6	200.00	Zegrean A.	2	9	200.00
Ignat S.	2	4	200.00	Zegrean A.	2	4	200.00
Ignat S.	2	1	200.00	Zegrean A.	2	2	200.00
Ignat S.	2	7	200.00	Zegrean A.	2	1	200.00
Ignat S.	2	5	200.00	Zegrean A.	2	10	201.00
Ignat S.	2	9	200.00	Zegrean A.	2	6	200.00
Ignat S.	2	2	200.00	Zegrean A.	2	7	200.00
Ignat S.	2	3	200.00	Zegrean A.	2	8	200.00
Ignat S.	2	10	200.00	Zegrean A.	2	5	200.00
Ignat S.	2	8	199.00	Zegrean A.	2	8	200.00
Ignat S.	3	6	200.00	Zegrean A.	3	4	200.00
Ignat S.	3	2	200.00	Zegrean A.	3	5	200.00
Ignat S.	3	4	200.00	Zegrean A.	3	1	200.00
Ignat S.	3	3	200.00	Zegrean A.	3	3	200.00
Ignat S.	3	5	200.00	Zegrean A.	3	9	200.00
Ignat S.	3	8	200.00	Zegrean A.	3	10	199.00
Ignat S.	3	10	200.00	Zegrean A.	3	7	200.00
Ignat S.	3	7	200.00	Zegrean A.	3	6	200.00
Ignat S.	3	1	200.00	Zegrean A.	3	2	200.00
Ignat S.	3	9	200.00	Zegrean A.	3	4	200.00

Report date:

2022-01-17

Reported by :

M.A

Project :

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Page 2/2