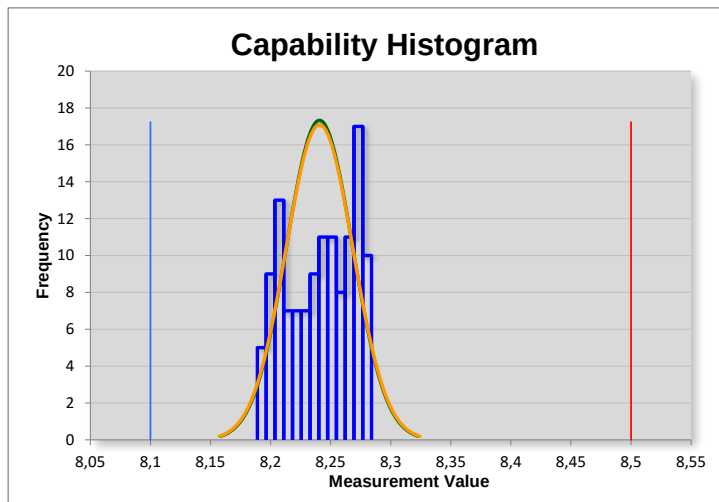




Process Capability Study

According to AIAG - Statistical Process Control 2nd Edition

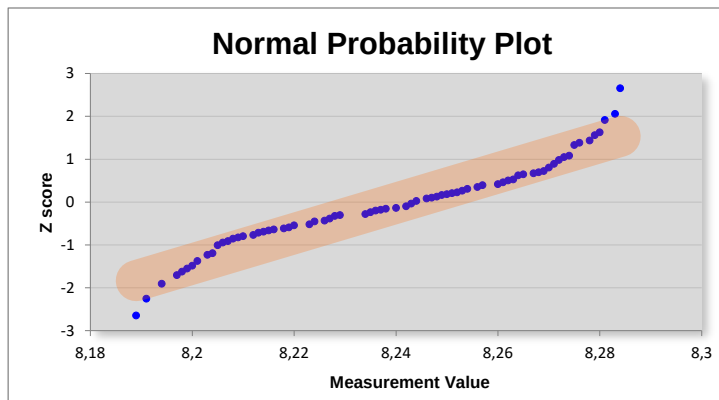
Part Number S002816B	Drawing Number GU5T - 14603 - HB	
Part Name Grom - Wir		
Dimension Design Tolerance	lower 8,10 upper 8,50	Quality Engineer Sandra Correia Operator Tiago Marques
Box-Cox Data Transformation	lambda no 0	Subgroups 25 Samples 5 Sample Size 125 Date Performed 19-05-2021



Specification Limits		
lower	nominal	upper
8,100	8,300	8,500

Actual Data		
min	mean	max
8,189	8,241	8,284

Process Capability		
within	stdDev	0,0275
actual	Cpk	1,708
potential	Cp	2,427
overall	stdDev	0,028
actual	Ppk	1,684
potential	Pp	2,394



skewness	-0,191
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Control Limits	Process Control	
	UCL	8,278
	Xbar	8,241
	LCL	8,204
	Process Stability	
	UCL	0,135
	Rbar	0,064
	LCL	0,000

Subgroup	Sample					Xbar	R
	1	2	3	4	5		
1	8,252	8,257	8,201	8,256	8,280	8,249	0,079
2	8,235	8,204	8,284	8,227	8,261	8,242	0,080
3	8,242	8,278	8,226	8,189	8,216	8,230	0,089
4	8,194	8,271	8,228	8,218	8,250	8,232	0,077
5	8,234	8,212	8,253	8,274	8,274	8,249	0,062
6	8,208	8,243	8,275	8,244	8,248	8,244	0,067
7	8,219	8,236	8,264	8,270	8,260	8,250	0,051
8	8,210	8,207	8,223	8,219	8,224	8,217	0,017
9	8,269	8,201	8,243	8,265	8,280	8,252	0,079
10	8,237	8,199	8,249	8,212	8,205	8,220	0,050
11	8,240	8,254	8,205	8,270	8,229	8,240	0,065
12	8,204	8,226	8,251	8,283	8,198	8,232	0,085
13	8,209	8,280	8,201	8,263	8,200	8,231	0,080
14	8,272	8,274	8,213	8,263	8,234	8,251	0,061
15	8,254	8,263	8,214	8,273	8,206	8,242	0,067
16	8,248	8,204	8,274	8,243	8,278	8,249	0,074
17	8,242	8,272	8,244	8,267	8,204	8,246	0,068
18	8,268	8,283	8,279	8,274	8,274	8,276	0,015
19	8,261	8,223	8,220	8,244	8,262	8,242	0,042
20	8,260	8,281	8,194	8,204	8,235	8,235	0,087
21	8,271	8,247	8,271	8,191	8,269	8,250	0,080
22	8,238	8,227	8,269	8,215	8,253	8,240	0,054
23	8,242	8,276	8,263	8,270	8,203	8,251	0,073
24	8,227	8,223	8,197	8,207	8,200	8,211	0,030
25	8,240	8,191	8,256	8,252	8,246	8,237	0,065

