

## 塑胶产品生产能力CPK分析报告

目前塑胶产品问题凸显，多次生产批量不合格产品，塑胶壳体尺寸方面的稳定性较差，例如中兴N0.2壳体，目前库存140K超宽产品。

为了充分了解注塑部的生产能力，针对现每一个在生产的机台做出能力值分析，以便于找出产生问题的真正原因，制定合理的标准参数、作业方式。

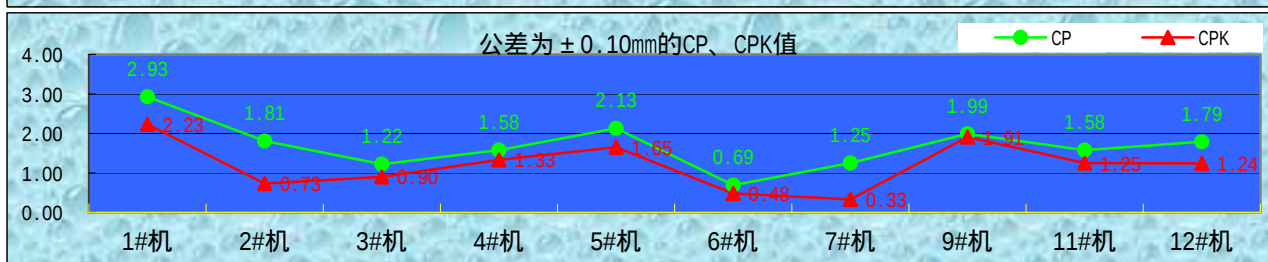
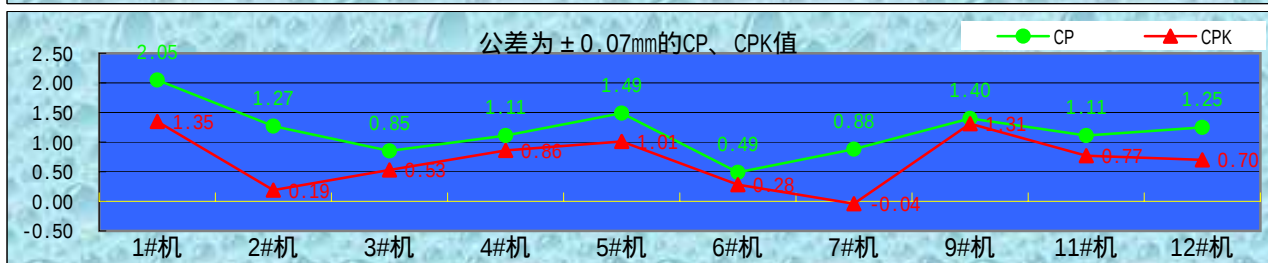
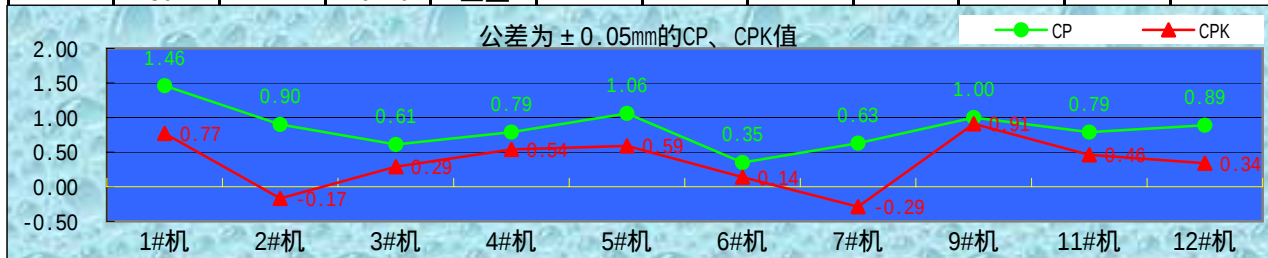
实验方法：采取单机台某时间段连续生产的产品各200PCS，由同一检验员用同一把卡尺，以相同的测量方法测量产品长度尺寸并作记录。根据记录值作直方图及正态分布曲线，计算出每台注塑机当前的设备能力及生产能力。

以下数据请塑胶产品行业专家们参考，并制定相应的措施。

试验结果见下表：

注塑产品设备能力（CP）及制程能力（CPK）统计表

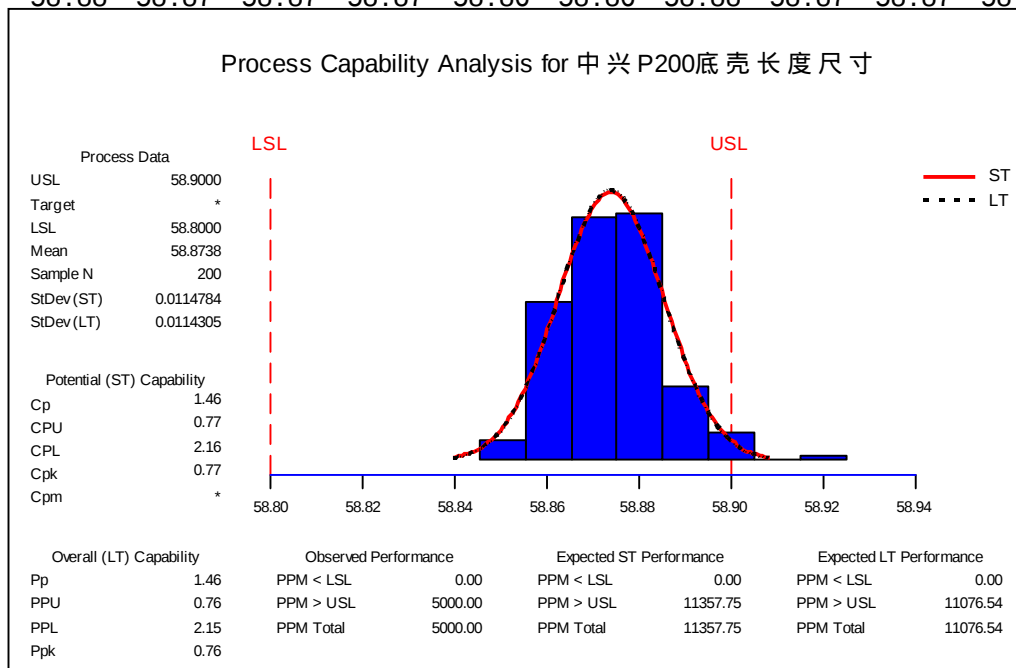
|      | 机台参数    | 生产日期  | 生产时间段       | 生产型号    | 公差为 $\pm 0.05\text{mm}$ |       | 公差为 $\pm 0.05\text{mm}$ |       | 公差为 $\pm 0.05\text{mm}$ |      | 备注 |
|------|---------|-------|-------------|---------|-------------------------|-------|-------------------------|-------|-------------------------|------|----|
|      |         |       |             |         | CP                      | CPK   | CP                      | CPK   | CP                      | CPK  |    |
| 1#机  | 亿利达120T | 8月14日 | 18:35~20:35 | P200底壳  | 1.46                    | 0.77  | 2.05                    | 1.35  | 2.93                    | 2.23 |    |
| 2#机  | 亿利达120T | 8月14日 | 18:48~20:20 | CL108框架 | 0.90                    | -0.17 | 1.27                    | 0.19  | 1.81                    | 0.73 |    |
| 3#机  | 亿利达120T | 8月14日 | 18:48~20:30 | C300框架  | 0.61                    | 0.29  | 0.85                    | 0.53  | 1.22                    | 0.90 |    |
| 4#机  | 住友130T  | 8月14日 | 18:40~20:00 | 夏新N0.8  | 0.79                    | 0.54  | 1.11                    | 0.86  | 1.58                    | 1.33 |    |
| 5#机  | 柳州150T  | 8月15日 | 9:40~10:40  | C2205上盖 | 1.06                    | 0.59  | 1.49                    | 1.01  | 2.13                    | 1.65 |    |
| 6#机  | 柳州150T  | 8月15日 | 1:40~2:50   | 侨兴288框架 | 0.35                    | 0.14  | 0.49                    | 0.28  | 0.69                    | 0.48 |    |
| 7#机  | 柳州110T  | 8月15日 | 4:00~5:10   | C2201框架 | 0.63                    | -0.29 | 0.88                    | -0.04 | 1.25                    | 0.33 |    |
| 9#机  | 柳州110T  | 8月15日 | 2:00~4:00   | 国虹A06框架 | 1.00                    | 0.91  | 1.40                    | 1.31  | 1.99                    | 1.91 |    |
| 11#机 | 柳州80T   | 8月15日 | 18:10~19:08 | A10-C框架 | 0.79                    | 0.46  | 1.11                    | 0.77  | 1.58                    | 1.25 |    |
| 12#机 | 柳州80T   | 8月15日 | 18:07~19:10 | C170上盖  | 0.89                    | 0.34  | 1.25                    | 0.70  | 1.79                    | 1.24 |    |



## 中兴P200底壳长度尺寸CPK分析 (公差0.1)

日期：2006.08.14 生产时间段：18:35-20:35  
品名：中兴P200底壳 机台号：1# 机台参数：亿利达120T  
样本数：200 不良数：1 不良率：0.50%  
尺寸上限：58.90 尺寸下限：58.80  
最大值：58.92 最小值：58.85  
平均值：58.874 标准差：0.0114  
Cp：1.46 U\_Cpk：0.77 L\_Cpk：2.16 Cpk：0.77

|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 58.86 | 58.87 | 58.88 | 58.87 | 58.88 | 58.87 | 58.88 | 58.86 | 58.88 | 58.87 |
| 2  | 58.87 | 58.89 | 58.89 | 58.87 | 58.88 | 58.88 | 58.88 | 58.86 | 58.87 | 58.87 |
| 3  | 58.86 | 58.88 | 58.88 | 58.86 | 58.88 | 58.88 | 58.86 | 58.89 | 58.88 | 58.88 |
| 4  | 58.86 | 58.88 | 58.87 | 58.86 | 58.89 | 58.88 | 58.87 | 58.87 | 58.88 | 58.86 |
| 5  | 58.88 | 58.89 | 58.88 | 58.86 | 58.87 | 58.87 | 58.87 | 58.88 | 58.88 | 58.87 |
| 6  | 58.89 | 58.85 | 58.87 | 58.86 | 58.87 | 58.87 | 58.89 | 58.87 | 58.86 | 58.87 |
| 7  | 58.92 | 58.88 | 58.86 | 58.88 | 58.88 | 58.88 | 58.90 | 58.86 | 58.86 | 58.86 |
| 8  | 58.87 | 58.90 | 58.86 | 58.88 | 58.88 | 58.87 | 58.87 | 58.88 | 58.87 | 58.86 |
| 9  | 58.87 | 58.88 | 58.87 | 58.88 | 58.88 | 58.87 | 58.86 | 58.88 | 58.87 | 58.86 |
| 10 | 58.86 | 58.87 | 58.87 | 58.88 | 58.87 | 58.88 | 58.87 | 58.87 | 58.87 | 58.85 |
| 11 | 58.85 | 58.86 | 58.87 | 58.89 | 58.88 | 58.87 | 58.87 | 58.87 | 58.86 | 58.88 |
| 12 | 58.87 | 58.89 | 58.90 | 58.90 | 58.89 | 58.87 | 58.87 | 58.87 | 58.88 | 58.88 |
| 13 | 58.87 | 58.88 | 58.88 | 58.90 | 58.90 | 58.87 | 58.88 | 58.88 | 58.86 | 58.86 |
| 14 | 58.88 | 58.87 | 58.87 | 58.89 | 58.86 | 58.88 | 58.86 | 58.87 | 58.89 | 58.87 |
| 15 | 58.88 | 58.87 | 58.86 | 58.89 | 58.88 | 58.88 | 58.86 | 58.88 | 58.89 | 58.88 |
| 16 | 58.87 | 58.88 | 58.87 | 58.90 | 58.88 | 58.86 | 58.85 | 58.86 | 58.88 | 58.86 |
| 17 | 58.87 | 58.88 | 58.88 | 58.87 | 58.89 | 58.87 | 58.86 | 58.89 | 58.86 | 58.89 |
| 18 | 58.88 | 58.86 | 58.87 | 58.89 | 58.88 | 58.89 | 58.88 | 58.87 | 58.86 | 58.88 |
| 19 | 58.87 | 58.86 | 58.86 | 58.88 | 58.88 | 58.88 | 58.86 | 58.88 | 58.85 | 58.88 |
| 20 | 58.88 | 58.87 | 58.87 | 58.87 | 58.86 | 58.86 | 58.88 | 58.87 | 58.87 | 58.87 |

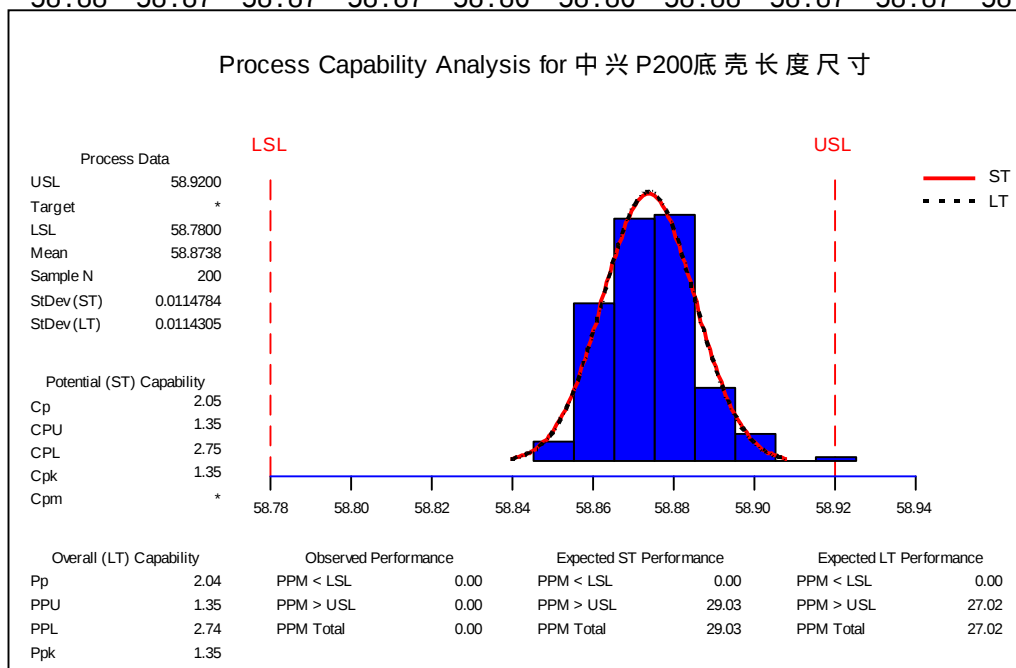




### 中兴P200底壳长度尺寸CPK分析 (公差0.14)

日期: 2006.08.14      生产时间段: 18:35-20:35  
品名: 中兴P200底壳      机台号: 1#      机台参数: 亿利达120T  
样本数: 200      不良数: 0      不良率: 0.00%  
尺寸上限: 58.92      尺寸下限: 58.78  
最大值: 58.92      最小值: 58.85  
平均值: 58.874      标准差: 0.0114  
Cp: 2.05      U\_Cpk: 1.35      L\_Cpk: 2.75      Cpk: 1.35

|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 58.86 | 58.87 | 58.88 | 58.87 | 58.88 | 58.87 | 58.88 | 58.86 | 58.88 | 58.87 |
| 2  | 58.87 | 58.89 | 58.89 | 58.87 | 58.88 | 58.88 | 58.88 | 58.86 | 58.87 | 58.87 |
| 3  | 58.86 | 58.88 | 58.88 | 58.86 | 58.88 | 58.88 | 58.86 | 58.89 | 58.88 | 58.88 |
| 4  | 58.86 | 58.88 | 58.87 | 58.86 | 58.89 | 58.88 | 58.87 | 58.87 | 58.88 | 58.86 |
| 5  | 58.88 | 58.89 | 58.88 | 58.86 | 58.87 | 58.87 | 58.87 | 58.88 | 58.88 | 58.87 |
| 6  | 58.89 | 58.85 | 58.87 | 58.86 | 58.87 | 58.87 | 58.89 | 58.87 | 58.86 | 58.87 |
| 7  | 58.92 | 58.88 | 58.86 | 58.88 | 58.88 | 58.88 | 58.90 | 58.86 | 58.86 | 58.86 |
| 8  | 58.87 | 58.90 | 58.86 | 58.88 | 58.88 | 58.87 | 58.87 | 58.88 | 58.87 | 58.86 |
| 9  | 58.87 | 58.88 | 58.87 | 58.88 | 58.88 | 58.87 | 58.86 | 58.88 | 58.87 | 58.86 |
| 10 | 58.86 | 58.87 | 58.87 | 58.88 | 58.87 | 58.88 | 58.87 | 58.87 | 58.87 | 58.85 |
| 11 | 58.85 | 58.86 | 58.87 | 58.89 | 58.88 | 58.87 | 58.87 | 58.87 | 58.86 | 58.88 |
| 12 | 58.87 | 58.89 | 58.90 | 58.90 | 58.89 | 58.87 | 58.87 | 58.87 | 58.88 | 58.88 |
| 13 | 58.87 | 58.88 | 58.88 | 58.90 | 58.90 | 58.87 | 58.88 | 58.88 | 58.86 | 58.86 |
| 14 | 58.88 | 58.87 | 58.87 | 58.89 | 58.86 | 58.88 | 58.86 | 58.87 | 58.89 | 58.87 |
| 15 | 58.88 | 58.87 | 58.86 | 58.89 | 58.88 | 58.88 | 58.86 | 58.88 | 58.89 | 58.88 |
| 16 | 58.87 | 58.88 | 58.87 | 58.90 | 58.88 | 58.86 | 58.85 | 58.86 | 58.88 | 58.86 |
| 17 | 58.87 | 58.88 | 58.88 | 58.87 | 58.89 | 58.87 | 58.86 | 58.89 | 58.86 | 58.89 |
| 18 | 58.88 | 58.86 | 58.87 | 58.89 | 58.88 | 58.89 | 58.88 | 58.87 | 58.86 | 58.88 |
| 19 | 58.87 | 58.86 | 58.86 | 58.88 | 58.88 | 58.88 | 58.86 | 58.88 | 58.85 | 58.88 |
| 20 | 58.88 | 58.87 | 58.87 | 58.87 | 58.86 | 58.86 | 58.88 | 58.87 | 58.87 | 58.87 |

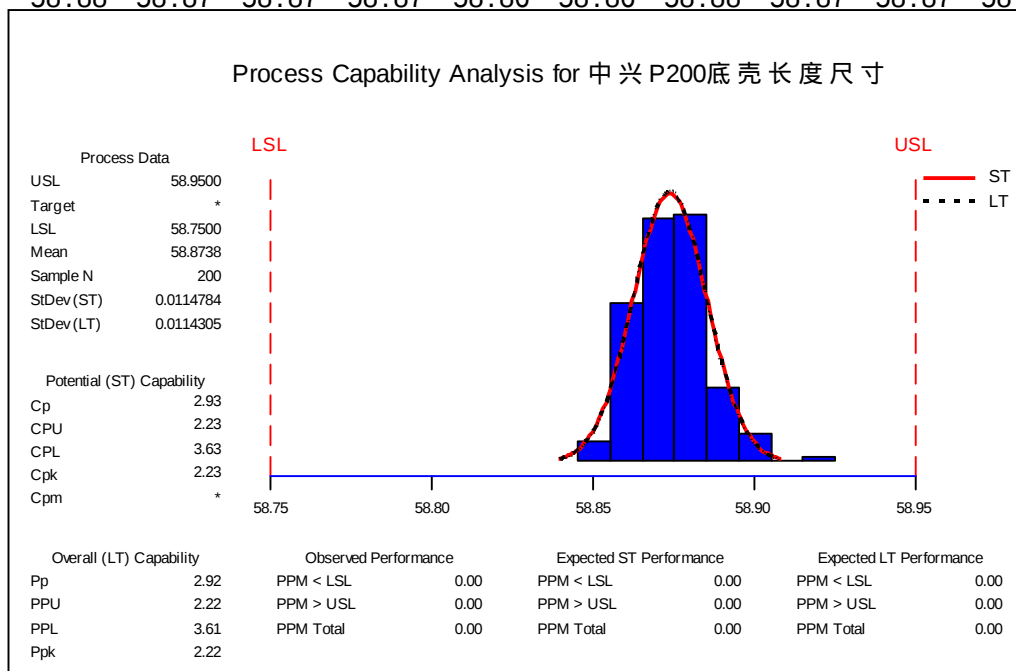




## 中兴P200底壳长度尺寸CPK分析 (公差0.2)

日期: 2006.08.14      生产时间段: 18:35-20:35  
品名: 中兴P200底壳      机台号: 1#      机台参数: 亿利达120T  
样本数: 200      不良数: 0      不良率: 0.00%  
尺寸上限: 58.95      尺寸下限: 58.75  
最大值: 58.92      最小值: 58.85  
平均值: 58.874      标准差: 0.0114  
Cp: 2.93      U\_Cpk: 2.23      L\_Cpk: 3.63      Cpk: 2.23

|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 58.86 | 58.87 | 58.88 | 58.87 | 58.88 | 58.87 | 58.88 | 58.86 | 58.88 | 58.87 |
| 2  | 58.87 | 58.89 | 58.89 | 58.87 | 58.88 | 58.88 | 58.88 | 58.86 | 58.87 | 58.87 |
| 3  | 58.86 | 58.88 | 58.88 | 58.86 | 58.88 | 58.88 | 58.86 | 58.89 | 58.88 | 58.88 |
| 4  | 58.86 | 58.88 | 58.87 | 58.86 | 58.89 | 58.88 | 58.87 | 58.87 | 58.88 | 58.86 |
| 5  | 58.88 | 58.89 | 58.88 | 58.86 | 58.87 | 58.87 | 58.87 | 58.88 | 58.88 | 58.87 |
| 6  | 58.89 | 58.85 | 58.87 | 58.86 | 58.87 | 58.87 | 58.89 | 58.87 | 58.86 | 58.87 |
| 7  | 58.92 | 58.88 | 58.86 | 58.88 | 58.88 | 58.88 | 58.90 | 58.86 | 58.86 | 58.86 |
| 8  | 58.87 | 58.90 | 58.86 | 58.88 | 58.88 | 58.87 | 58.87 | 58.88 | 58.87 | 58.86 |
| 9  | 58.87 | 58.88 | 58.87 | 58.88 | 58.88 | 58.87 | 58.86 | 58.88 | 58.87 | 58.86 |
| 10 | 58.86 | 58.87 | 58.87 | 58.88 | 58.87 | 58.88 | 58.87 | 58.87 | 58.87 | 58.85 |
| 11 | 58.85 | 58.86 | 58.87 | 58.89 | 58.88 | 58.87 | 58.87 | 58.87 | 58.86 | 58.88 |
| 12 | 58.87 | 58.89 | 58.90 | 58.90 | 58.89 | 58.87 | 58.87 | 58.87 | 58.88 | 58.88 |
| 13 | 58.87 | 58.88 | 58.88 | 58.90 | 58.90 | 58.87 | 58.88 | 58.88 | 58.86 | 58.86 |
| 14 | 58.88 | 58.87 | 58.87 | 58.89 | 58.86 | 58.88 | 58.86 | 58.87 | 58.89 | 58.87 |
| 15 | 58.88 | 58.87 | 58.86 | 58.89 | 58.88 | 58.88 | 58.86 | 58.88 | 58.89 | 58.88 |
| 16 | 58.87 | 58.88 | 58.87 | 58.90 | 58.88 | 58.86 | 58.85 | 58.86 | 58.88 | 58.86 |
| 17 | 58.87 | 58.88 | 58.88 | 58.87 | 58.89 | 58.87 | 58.86 | 58.89 | 58.86 | 58.89 |
| 18 | 58.88 | 58.86 | 58.87 | 58.89 | 58.88 | 58.89 | 58.88 | 58.87 | 58.86 | 58.88 |
| 19 | 58.87 | 58.86 | 58.86 | 58.88 | 58.88 | 58.88 | 58.86 | 58.88 | 58.85 | 58.88 |
| 20 | 58.88 | 58.87 | 58.87 | 58.87 | 58.86 | 58.86 | 58.88 | 58.87 | 58.87 | 58.87 |

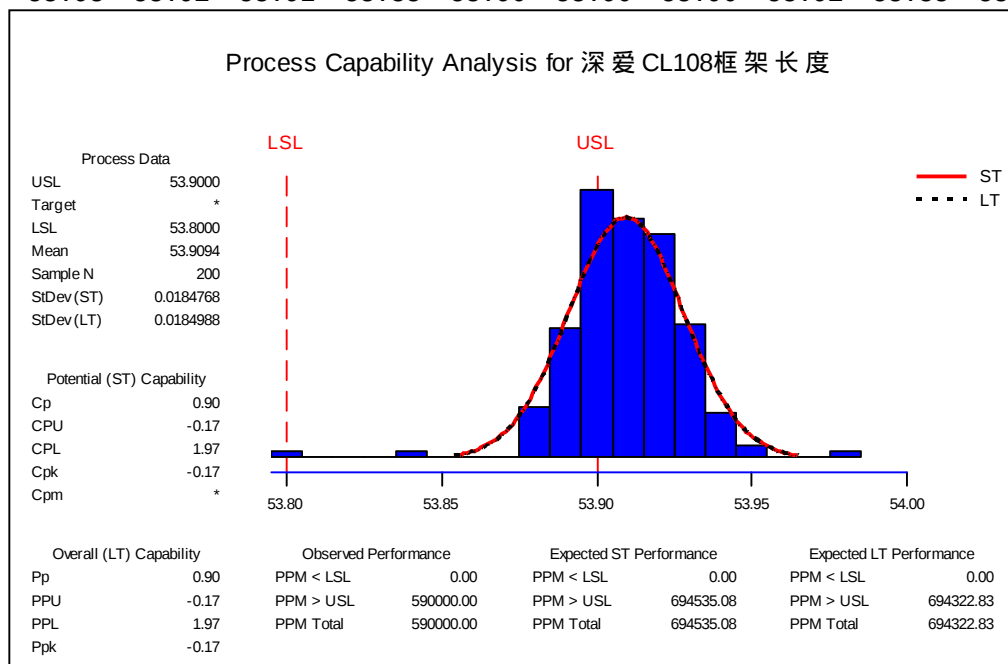




## 深爱CL108框架长度尺寸CPK分析 (公差0.1)

日期: 2006.08.14      生产时间段: 18:48-20:20  
品名: CL108      机台号: 2#      机台参数: 亿利达120T  
样本数: 200      不良数: 118      不良率: 59.00%  
尺寸上限: 53.90      尺寸下限: 53.80  
最大值: 53.98      最小值: 53.80  
平均值: 53.909      标准差: 0.0184  
Cp: 0.90      U\_Cpk: -0.17      L\_Cpk: 1.98      Cpk: -0.17

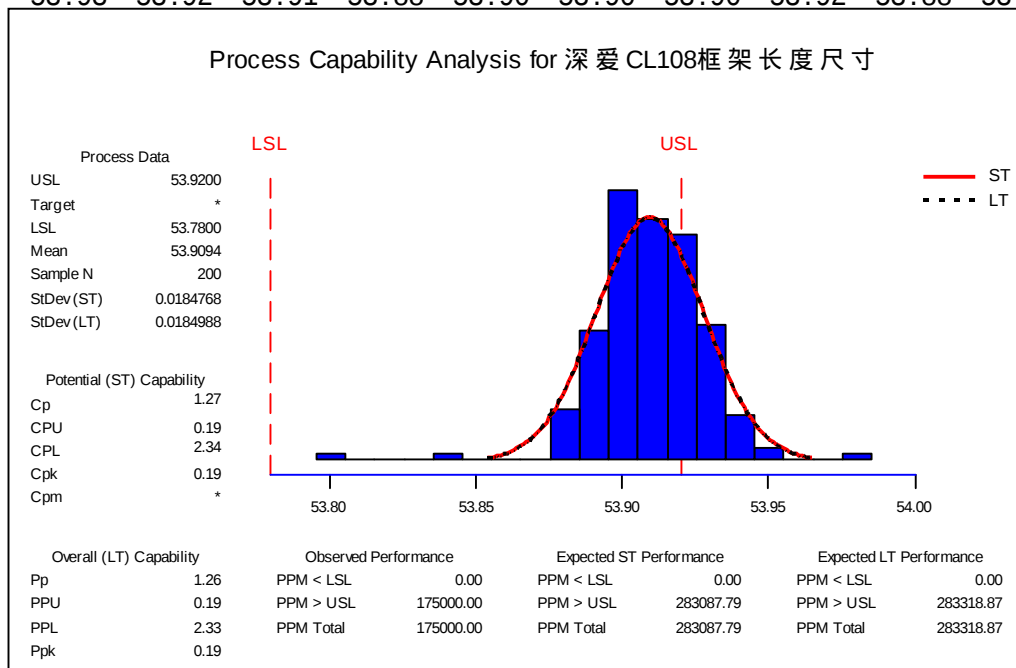
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 53.90 | 53.89 | 53.91 | 53.91 | 53.88 | 53.92 | 53.88 | 53.90 | 53.91 | 53.90 |
| 2  | 53.92 | 53.88 | 53.91 | 53.95 | 53.90 | 53.90 | 53.92 | 53.93 | 53.90 | 53.89 |
| 3  | 53.89 | 53.89 | 53.89 | 53.94 | 53.91 | 53.92 | 53.92 | 53.90 | 53.92 | 53.91 |
| 4  | 53.88 | 53.90 | 53.93 | 53.90 | 53.91 | 53.91 | 53.91 | 53.90 | 53.94 | 53.89 |
| 5  | 53.91 | 53.89 | 53.91 | 53.89 | 53.91 | 53.92 | 53.92 | 53.90 | 53.90 | 53.93 |
| 6  | 53.91 | 53.91 | 53.89 | 53.90 | 53.90 | 53.93 | 53.91 | 53.91 | 53.92 | 53.91 |
| 7  | 53.92 | 53.93 | 53.90 | 53.91 | 53.93 | 53.89 | 53.92 | 53.90 | 53.90 | 53.91 |
| 8  | 53.91 | 53.91 | 53.91 | 53.89 | 53.92 | 53.94 | 53.91 | 53.90 | 53.93 | 53.91 |
| 9  | 53.90 | 53.90 | 53.90 | 53.88 | 53.93 | 53.90 | 53.92 | 53.91 | 53.92 | 53.89 |
| 10 | 53.92 | 53.92 | 53.91 | 53.93 | 53.92 | 53.92 | 53.91 | 53.91 | 53.89 | 53.92 |
| 11 | 53.90 | 53.89 | 53.90 | 53.91 | 53.93 | 53.91 | 53.92 | 53.91 | 53.91 | 53.91 |
| 12 | 53.90 | 53.90 | 53.92 | 53.91 | 53.92 | 53.92 | 53.90 | 53.92 | 53.90 | 53.90 |
| 13 | 53.92 | 53.89 | 53.90 | 53.90 | 53.94 | 53.90 | 53.89 | 53.94 | 53.92 | 53.90 |
| 14 | 53.93 | 53.92 | 53.91 | 53.91 | 53.93 | 53.94 | 53.92 | 53.90 | 53.92 | 53.92 |
| 15 | 53.89 | 53.90 | 53.89 | 53.91 | 53.92 | 53.90 | 53.91 | 53.93 | 53.89 | 53.80 |
| 16 | 53.95 | 53.93 | 53.88 | 53.92 | 53.91 | 53.89 | 53.88 | 53.90 | 53.91 | 53.90 |
| 17 | 53.89 | 53.90 | 53.94 | 53.93 | 53.93 | 53.92 | 53.93 | 53.90 | 53.94 | 53.89 |
| 18 | 53.93 | 53.89 | 53.92 | 53.92 | 53.92 | 53.91 | 53.93 | 53.93 | 53.93 | 53.90 |
| 19 | 53.91 | 53.90 | 53.98 | 53.90 | 53.90 | 53.84 | 53.90 | 53.93 | 53.92 | 53.93 |
| 20 | 53.93 | 53.92 | 53.91 | 53.88 | 53.90 | 53.90 | 53.90 | 53.92 | 53.88 | 53.92 |



## 深爱CL108框架长度尺寸CPK分析 (公差0.14)

日期: 2006.08.14      生产时间段: 18:48-20:20  
品名: CL108      机台号: 2#      机台参数: 亿利达120T  
样本数: 200      不良数: 35      不良率: 17.50%  
尺寸上限: 53.92      尺寸下限: 53.78  
最大值: 53.98      最小值: 53.80  
平均值: 53.909      标准差: 0.0184  
Cp: 1.27      U\_Cpk: 0.19      L\_Cpk: 2.34      Cpk: 0.19

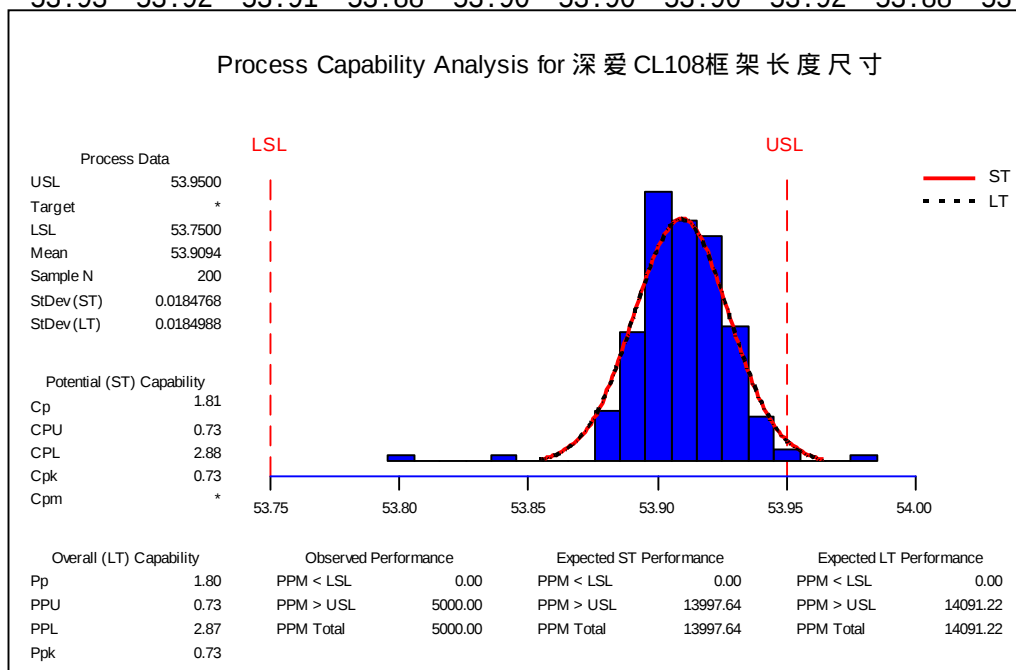
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 53.90 | 53.89 | 53.91 | 53.91 | 53.88 | 53.92 | 53.88 | 53.90 | 53.91 | 53.90 |
| 2  | 53.92 | 53.88 | 53.91 | 53.95 | 53.90 | 53.90 | 53.92 | 53.93 | 53.90 | 53.89 |
| 3  | 53.89 | 53.89 | 53.89 | 53.94 | 53.91 | 53.92 | 53.92 | 53.90 | 53.92 | 53.91 |
| 4  | 53.88 | 53.90 | 53.93 | 53.90 | 53.91 | 53.91 | 53.91 | 53.90 | 53.94 | 53.89 |
| 5  | 53.91 | 53.89 | 53.91 | 53.89 | 53.91 | 53.92 | 53.92 | 53.90 | 53.90 | 53.93 |
| 6  | 53.91 | 53.91 | 53.89 | 53.90 | 53.90 | 53.93 | 53.91 | 53.91 | 53.92 | 53.91 |
| 7  | 53.92 | 53.93 | 53.90 | 53.91 | 53.93 | 53.89 | 53.92 | 53.90 | 53.90 | 53.91 |
| 8  | 53.91 | 53.91 | 53.91 | 53.89 | 53.92 | 53.94 | 53.91 | 53.90 | 53.93 | 53.91 |
| 9  | 53.90 | 53.90 | 53.90 | 53.88 | 53.93 | 53.90 | 53.92 | 53.91 | 53.92 | 53.89 |
| 10 | 53.92 | 53.92 | 53.91 | 53.93 | 53.92 | 53.92 | 53.91 | 53.91 | 53.89 | 53.92 |
| 11 | 53.90 | 53.89 | 53.90 | 53.91 | 53.93 | 53.91 | 53.92 | 53.91 | 53.91 | 53.91 |
| 12 | 53.90 | 53.90 | 53.92 | 53.91 | 53.92 | 53.92 | 53.90 | 53.92 | 53.90 | 53.90 |
| 13 | 53.92 | 53.89 | 53.90 | 53.90 | 53.94 | 53.90 | 53.89 | 53.94 | 53.92 | 53.90 |
| 14 | 53.93 | 53.92 | 53.91 | 53.91 | 53.93 | 53.94 | 53.92 | 53.90 | 53.92 | 53.92 |
| 15 | 53.89 | 53.90 | 53.89 | 53.91 | 53.92 | 53.90 | 53.91 | 53.93 | 53.89 | 53.80 |
| 16 | 53.95 | 53.93 | 53.88 | 53.92 | 53.91 | 53.89 | 53.88 | 53.90 | 53.91 | 53.90 |
| 17 | 53.89 | 53.90 | 53.94 | 53.93 | 53.93 | 53.92 | 53.93 | 53.90 | 53.94 | 53.89 |
| 18 | 53.93 | 53.89 | 53.92 | 53.92 | 53.92 | 53.91 | 53.93 | 53.93 | 53.93 | 53.90 |
| 19 | 53.91 | 53.90 | 53.98 | 53.90 | 53.90 | 53.84 | 53.90 | 53.93 | 53.92 | 53.93 |
| 20 | 53.93 | 53.92 | 53.91 | 53.88 | 53.90 | 53.90 | 53.90 | 53.92 | 53.88 | 53.92 |



## 深爱CL108框架长度尺寸CPK分析 (公差0.2)

日期：2006.08.14      生产时间段：18：48-20：20  
品名：CL108      机台号：2#      机台参数：亿利达120T  
样本数：200      不良数：1      不良率：0.50%  
尺寸上限：53.95      尺寸下限：53.75  
最大值：53.98      最小值：53.80  
平均值：53.909      标准差：0.0184  
Cp：1.81      U\_Cpk：0.73      L\_Cpk：2.88      Cpk：0.73

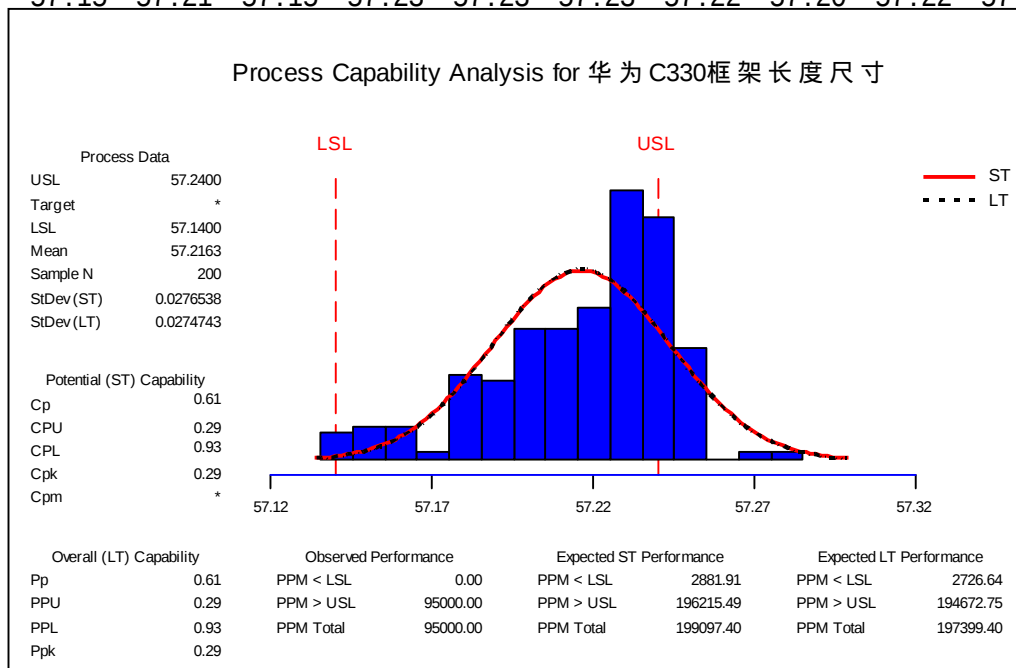
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 53.90 | 53.89 | 53.91 | 53.91 | 53.88 | 53.92 | 53.88 | 53.90 | 53.91 | 53.90 |
| 2  | 53.92 | 53.88 | 53.91 | 53.95 | 53.90 | 53.90 | 53.92 | 53.93 | 53.90 | 53.89 |
| 3  | 53.89 | 53.89 | 53.89 | 53.94 | 53.91 | 53.92 | 53.92 | 53.90 | 53.92 | 53.91 |
| 4  | 53.88 | 53.90 | 53.93 | 53.90 | 53.91 | 53.91 | 53.91 | 53.90 | 53.94 | 53.89 |
| 5  | 53.91 | 53.89 | 53.91 | 53.89 | 53.91 | 53.92 | 53.92 | 53.90 | 53.90 | 53.93 |
| 6  | 53.91 | 53.91 | 53.89 | 53.90 | 53.90 | 53.93 | 53.91 | 53.91 | 53.92 | 53.91 |
| 7  | 53.92 | 53.93 | 53.90 | 53.91 | 53.93 | 53.89 | 53.92 | 53.90 | 53.90 | 53.91 |
| 8  | 53.91 | 53.91 | 53.91 | 53.89 | 53.92 | 53.94 | 53.91 | 53.90 | 53.93 | 53.91 |
| 9  | 53.90 | 53.90 | 53.90 | 53.88 | 53.93 | 53.90 | 53.92 | 53.91 | 53.92 | 53.89 |
| 10 | 53.92 | 53.92 | 53.91 | 53.93 | 53.92 | 53.92 | 53.91 | 53.91 | 53.89 | 53.92 |
| 11 | 53.90 | 53.89 | 53.90 | 53.91 | 53.93 | 53.91 | 53.92 | 53.91 | 53.91 | 53.91 |
| 12 | 53.90 | 53.90 | 53.92 | 53.91 | 53.92 | 53.92 | 53.90 | 53.92 | 53.90 | 53.90 |
| 13 | 53.92 | 53.89 | 53.90 | 53.90 | 53.94 | 53.90 | 53.89 | 53.94 | 53.92 | 53.90 |
| 14 | 53.93 | 53.92 | 53.91 | 53.91 | 53.93 | 53.94 | 53.92 | 53.90 | 53.92 | 53.92 |
| 15 | 53.89 | 53.90 | 53.89 | 53.91 | 53.92 | 53.90 | 53.91 | 53.93 | 53.89 | 53.80 |
| 16 | 53.95 | 53.93 | 53.88 | 53.92 | 53.91 | 53.89 | 53.88 | 53.90 | 53.91 | 53.90 |
| 17 | 53.89 | 53.90 | 53.94 | 53.93 | 53.93 | 53.92 | 53.93 | 53.90 | 53.94 | 53.89 |
| 18 | 53.93 | 53.89 | 53.92 | 53.92 | 53.92 | 53.91 | 53.93 | 53.93 | 53.93 | 53.90 |
| 19 | 53.91 | 53.90 | 53.98 | 53.90 | 53.90 | 53.84 | 53.90 | 53.93 | 53.92 | 53.93 |
| 20 | 53.93 | 53.92 | 53.91 | 53.88 | 53.90 | 53.90 | 53.90 | 53.92 | 53.88 | 53.92 |



## 华为C330框架长度尺寸CPK分析 (公差0.1)

日期: 2006.08.14 生产时间段: 18:48-20:30  
品名: 华为C330框架 机台号: 3# 机台参数: 亿利达120T  
样本数: 200 不良数: 19 不良率: 9.50%  
尺寸上限: 57.24 尺寸下限: 57.14  
最大值: 57.28 最小值: 57.14  
平均值: 57.216 标准差: 0.0274  
Cp: 0.61 U\_Cpk: 0.29 L\_Cpk: 0.93 Cpk: 0.29

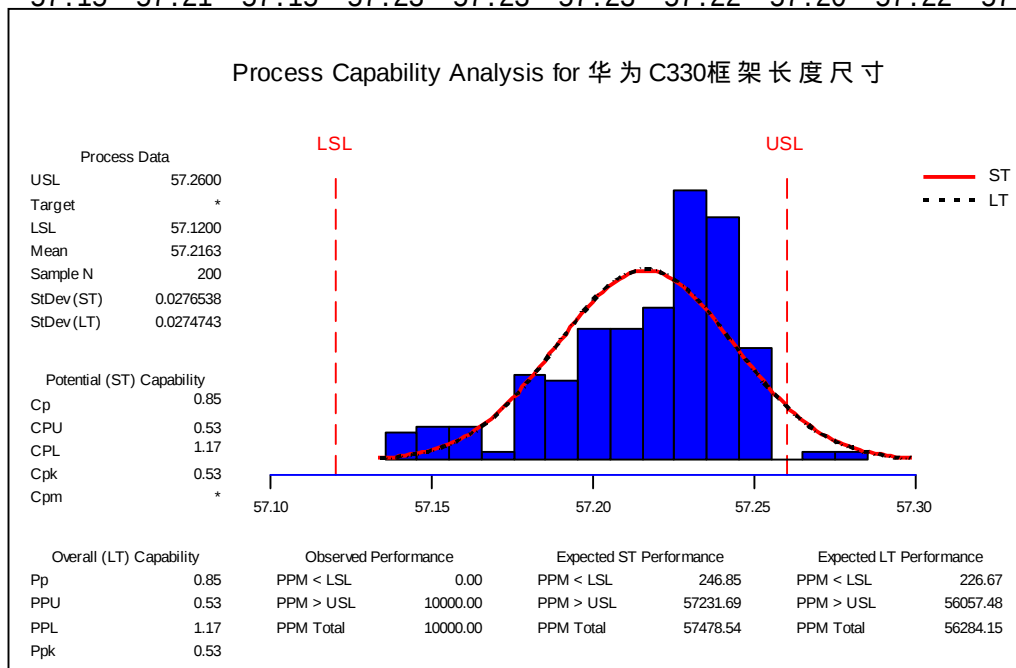
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 57.25 | 57.19 | 57.17 | 57.19 | 57.20 | 57.16 | 57.25 | 57.22 | 57.24 | 57.18 |
| 2  | 57.27 | 57.22 | 57.21 | 57.24 | 57.23 | 57.18 | 57.18 | 57.23 | 57.24 | 57.23 |
| 3  | 57.28 | 57.23 | 57.19 | 57.23 | 57.24 | 57.14 | 57.25 | 57.24 | 57.21 | 57.19 |
| 4  | 57.20 | 57.24 | 57.19 | 57.23 | 57.22 | 57.23 | 57.24 | 57.23 | 57.25 | 57.18 |
| 5  | 57.23 | 57.25 | 57.24 | 57.22 | 57.23 | 57.24 | 57.20 | 57.21 | 57.23 | 57.24 |
| 6  | 57.22 | 57.24 | 57.24 | 57.18 | 57.15 | 57.21 | 57.15 | 57.22 | 57.21 | 57.25 |
| 7  | 57.21 | 57.22 | 57.24 | 57.24 | 57.21 | 57.24 | 57.25 | 57.25 | 57.20 | 57.24 |
| 8  | 57.16 | 57.22 | 57.24 | 57.19 | 57.22 | 57.24 | 57.20 | 57.20 | 57.21 | 57.25 |
| 9  | 57.25 | 57.21 | 57.20 | 57.24 | 57.23 | 57.22 | 57.22 | 57.21 | 57.18 | 57.16 |
| 10 | 57.23 | 57.23 | 57.22 | 57.18 | 57.23 | 57.23 | 57.24 | 57.24 | 57.24 | 57.24 |
| 11 | 57.22 | 57.23 | 57.19 | 57.23 | 57.23 | 57.21 | 57.25 | 57.21 | 57.23 | 57.19 |
| 12 | 57.18 | 57.21 | 57.24 | 57.24 | 57.23 | 57.23 | 57.20 | 57.23 | 57.20 | 57.16 |
| 13 | 57.24 | 57.23 | 57.16 | 57.24 | 57.14 | 57.20 | 57.24 | 57.21 | 57.25 | 57.25 |
| 14 | 57.23 | 57.21 | 57.20 | 57.22 | 57.18 | 57.23 | 57.20 | 57.20 | 57.24 | 57.21 |
| 15 | 57.22 | 57.24 | 57.23 | 57.15 | 57.24 | 57.20 | 57.23 | 57.18 | 57.25 | 57.23 |
| 16 | 57.22 | 57.22 | 57.25 | 57.24 | 57.22 | 57.24 | 57.24 | 57.20 | 57.23 | 57.19 |
| 17 | 57.18 | 57.24 | 57.18 | 57.18 | 57.24 | 57.21 | 57.23 | 57.20 | 57.21 | 57.14 |
| 18 | 57.23 | 57.24 | 57.23 | 57.20 | 57.22 | 57.19 | 57.25 | 57.14 | 57.23 | 57.23 |
| 19 | 57.19 | 57.20 | 57.20 | 57.21 | 57.22 | 57.19 | 57.25 | 57.22 | 57.23 | 57.23 |
| 20 | 57.15 | 57.21 | 57.15 | 57.23 | 57.23 | 57.23 | 57.22 | 57.20 | 57.22 | 57.23 |



## 华为C330框架长度尺寸CPK分析（公差0.14）

日期：2006.08.14 生产时间段：18：48-20：30  
品名：华为C330框架 机台号：3# 机台参数：亿利达120T  
样本数：200 不良数：2 不良率：1.00%  
尺寸上限：57.26 尺寸下限：57.12  
最大值：57.28 最小值：57.14  
平均值：57.216 标准差：0.0274  
Cp：0.85 U\_Cpk：0.53 L\_Cpk：1.17 Cpk：0.53

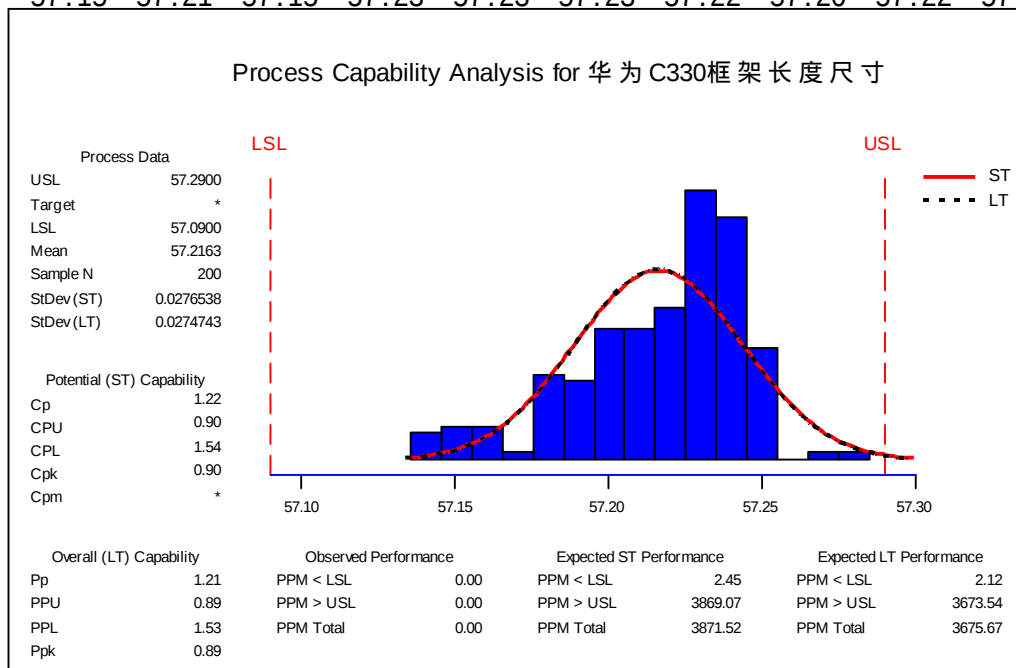
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 57.25 | 57.19 | 57.17 | 57.19 | 57.20 | 57.16 | 57.25 | 57.22 | 57.24 | 57.18 |
| 2  | 57.27 | 57.22 | 57.21 | 57.24 | 57.23 | 57.18 | 57.18 | 57.23 | 57.24 | 57.23 |
| 3  | 57.28 | 57.23 | 57.19 | 57.23 | 57.24 | 57.14 | 57.25 | 57.24 | 57.21 | 57.19 |
| 4  | 57.20 | 57.24 | 57.19 | 57.23 | 57.22 | 57.23 | 57.24 | 57.23 | 57.25 | 57.18 |
| 5  | 57.23 | 57.25 | 57.24 | 57.22 | 57.23 | 57.24 | 57.20 | 57.21 | 57.23 | 57.24 |
| 6  | 57.22 | 57.24 | 57.24 | 57.18 | 57.15 | 57.21 | 57.15 | 57.22 | 57.21 | 57.25 |
| 7  | 57.21 | 57.22 | 57.24 | 57.24 | 57.21 | 57.24 | 57.25 | 57.25 | 57.20 | 57.24 |
| 8  | 57.16 | 57.22 | 57.24 | 57.19 | 57.22 | 57.24 | 57.20 | 57.20 | 57.21 | 57.25 |
| 9  | 57.25 | 57.21 | 57.20 | 57.24 | 57.23 | 57.22 | 57.22 | 57.21 | 57.18 | 57.16 |
| 10 | 57.23 | 57.23 | 57.22 | 57.18 | 57.23 | 57.23 | 57.24 | 57.24 | 57.24 | 57.24 |
| 11 | 57.22 | 57.23 | 57.19 | 57.23 | 57.23 | 57.21 | 57.25 | 57.21 | 57.23 | 57.19 |
| 12 | 57.18 | 57.21 | 57.24 | 57.24 | 57.23 | 57.23 | 57.20 | 57.23 | 57.20 | 57.16 |
| 13 | 57.24 | 57.23 | 57.16 | 57.24 | 57.14 | 57.20 | 57.24 | 57.21 | 57.25 | 57.25 |
| 14 | 57.23 | 57.21 | 57.20 | 57.22 | 57.18 | 57.23 | 57.20 | 57.20 | 57.24 | 57.21 |
| 15 | 57.22 | 57.24 | 57.23 | 57.15 | 57.24 | 57.20 | 57.23 | 57.18 | 57.25 | 57.23 |
| 16 | 57.22 | 57.22 | 57.25 | 57.24 | 57.22 | 57.24 | 57.24 | 57.20 | 57.23 | 57.19 |
| 17 | 57.18 | 57.24 | 57.18 | 57.18 | 57.24 | 57.21 | 57.23 | 57.20 | 57.21 | 57.14 |
| 18 | 57.23 | 57.24 | 57.23 | 57.20 | 57.22 | 57.19 | 57.25 | 57.14 | 57.23 | 57.23 |
| 19 | 57.19 | 57.20 | 57.20 | 57.21 | 57.22 | 57.19 | 57.25 | 57.22 | 57.23 | 57.23 |
| 20 | 57.15 | 57.21 | 57.15 | 57.23 | 57.23 | 57.23 | 57.22 | 57.20 | 57.22 | 57.23 |



## 华为C330框架长度尺寸CPK分析 (公差0.2)

日期: 2006.08.14 生产时间段: 18:48-20:30  
品名: 华为C330框架 机台号: 3# 机台参数: 亿利达120T  
样本数: 200 不良数: 0 不良率: 0.00%  
尺寸上限: 57.29 尺寸下限: 57.09  
最大值: 57.28 最小值: 57.14  
平均值: 57.216 标准差: 0.0274  
Cp: 1.22 U\_Cpk: 0.90 L\_Cpk: 1.54 Cpk: 0.90

|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 57.25 | 57.19 | 57.17 | 57.19 | 57.20 | 57.16 | 57.25 | 57.22 | 57.24 | 57.18 |
| 2  | 57.27 | 57.22 | 57.21 | 57.24 | 57.23 | 57.18 | 57.18 | 57.23 | 57.24 | 57.23 |
| 3  | 57.28 | 57.23 | 57.19 | 57.23 | 57.24 | 57.14 | 57.25 | 57.24 | 57.21 | 57.19 |
| 4  | 57.20 | 57.24 | 57.19 | 57.23 | 57.22 | 57.23 | 57.24 | 57.23 | 57.25 | 57.18 |
| 5  | 57.23 | 57.25 | 57.24 | 57.22 | 57.23 | 57.24 | 57.20 | 57.21 | 57.23 | 57.24 |
| 6  | 57.22 | 57.24 | 57.24 | 57.18 | 57.15 | 57.21 | 57.15 | 57.22 | 57.21 | 57.25 |
| 7  | 57.21 | 57.22 | 57.24 | 57.24 | 57.21 | 57.24 | 57.25 | 57.25 | 57.20 | 57.24 |
| 8  | 57.16 | 57.22 | 57.24 | 57.19 | 57.22 | 57.24 | 57.20 | 57.20 | 57.21 | 57.25 |
| 9  | 57.25 | 57.21 | 57.20 | 57.24 | 57.23 | 57.22 | 57.22 | 57.21 | 57.18 | 57.16 |
| 10 | 57.23 | 57.23 | 57.22 | 57.18 | 57.23 | 57.23 | 57.24 | 57.24 | 57.24 | 57.24 |
| 11 | 57.22 | 57.23 | 57.19 | 57.23 | 57.23 | 57.21 | 57.25 | 57.21 | 57.23 | 57.19 |
| 12 | 57.18 | 57.21 | 57.24 | 57.24 | 57.23 | 57.23 | 57.20 | 57.23 | 57.20 | 57.16 |
| 13 | 57.24 | 57.23 | 57.16 | 57.24 | 57.14 | 57.20 | 57.24 | 57.21 | 57.25 | 57.25 |
| 14 | 57.23 | 57.21 | 57.20 | 57.22 | 57.18 | 57.23 | 57.20 | 57.20 | 57.24 | 57.21 |
| 15 | 57.22 | 57.24 | 57.23 | 57.15 | 57.24 | 57.20 | 57.23 | 57.18 | 57.25 | 57.23 |
| 16 | 57.22 | 57.22 | 57.25 | 57.24 | 57.22 | 57.24 | 57.24 | 57.20 | 57.23 | 57.19 |
| 17 | 57.18 | 57.24 | 57.18 | 57.18 | 57.24 | 57.21 | 57.23 | 57.20 | 57.21 | 57.14 |
| 18 | 57.23 | 57.24 | 57.23 | 57.20 | 57.22 | 57.19 | 57.25 | 57.14 | 57.23 | 57.23 |
| 19 | 57.19 | 57.20 | 57.20 | 57.21 | 57.22 | 57.19 | 57.25 | 57.22 | 57.23 | 57.23 |
| 20 | 57.15 | 57.21 | 57.15 | 57.23 | 57.23 | 57.23 | 57.22 | 57.20 | 57.22 | 57.23 |



## 夏新NO.8框架长度尺寸CPK分析 (公差0.1)

日期: 2006.08.14 生产时间段: 18:40-20:00

品名: 夏新NO.8

机台号: 4#

机台参数: 住友130T

样本数: 200

不良数: 3

不良率: 1.50%

尺寸上限: 38.45

尺寸下限: 38.35

最大值: 38.45

最小值: 38.33

平均值: 38.384

标准差: 0.0211

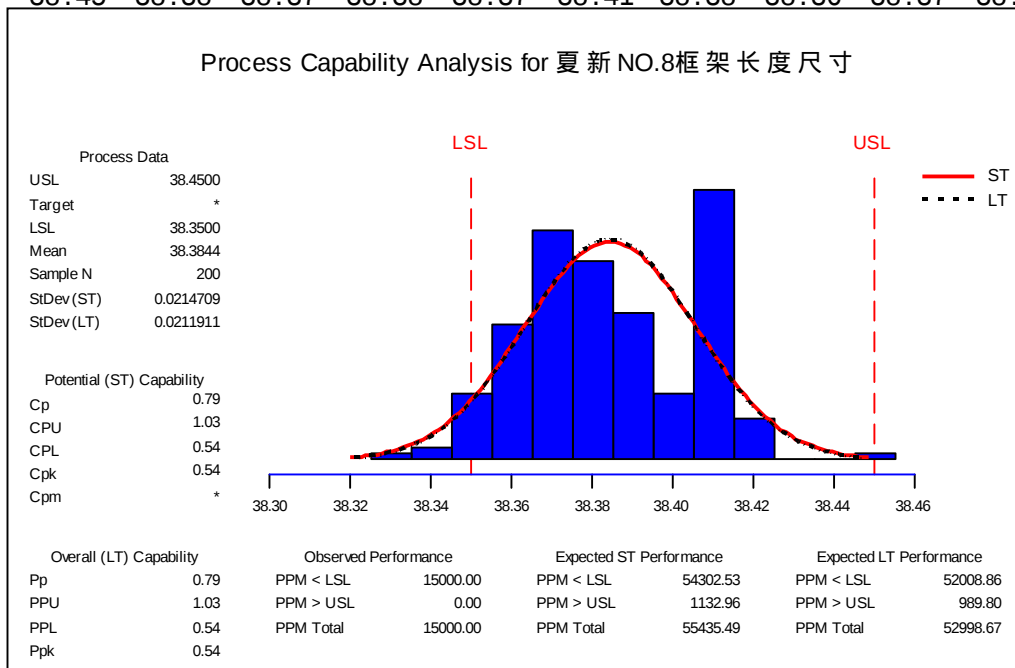
Cp: 0.79

U\_Cpk: 1.03

L\_Cpk: 0.54

Cpk: 0.54

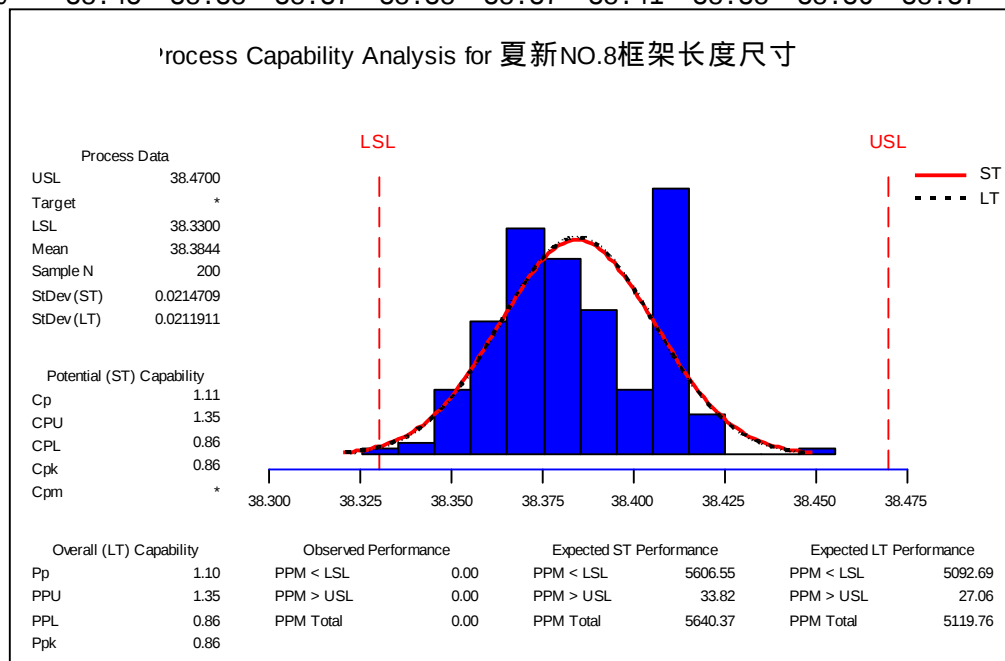
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 38.36 | 38.36 | 38.41 | 38.37 | 38.39 | 38.39 | 38.41 | 38.38 | 38.41 | 38.42 |
| 2  | 38.33 | 38.37 | 38.36 | 38.35 | 38.36 | 38.39 | 38.41 | 38.39 | 38.39 | 38.41 |
| 3  | 38.35 | 38.38 | 38.37 | 38.37 | 38.39 | 38.39 | 38.37 | 38.37 | 38.41 | 38.37 |
| 4  | 38.36 | 38.41 | 38.37 | 38.38 | 38.41 | 38.40 | 38.37 | 38.40 | 38.39 | 38.38 |
| 5  | 38.37 | 38.40 | 38.36 | 38.39 | 38.42 | 38.36 | 38.41 | 38.40 | 38.41 | 38.41 |
| 6  | 38.35 | 38.42 | 38.35 | 38.37 | 38.36 | 38.37 | 38.41 | 38.38 | 38.41 | 38.41 |
| 7  | 38.36 | 38.41 | 38.35 | 38.40 | 38.35 | 38.39 | 38.38 | 38.40 | 38.41 | 38.38 |
| 8  | 38.36 | 38.39 | 38.38 | 38.39 | 38.37 | 38.37 | 38.37 | 38.41 | 38.39 | 38.41 |
| 9  | 38.36 | 38.38 | 38.34 | 38.38 | 38.39 | 38.37 | 38.40 | 38.41 | 38.41 | 38.41 |
| 10 | 38.35 | 38.39 | 38.37 | 38.41 | 38.38 | 38.38 | 38.39 | 38.41 | 38.38 | 38.41 |
| 11 | 38.38 | 38.37 | 38.37 | 38.41 | 38.38 | 38.41 | 38.37 | 38.36 | 38.41 | 38.38 |
| 12 | 38.36 | 38.37 | 38.37 | 38.41 | 38.36 | 38.37 | 38.41 | 38.42 | 38.38 | 38.42 |
| 13 | 38.37 | 38.39 | 38.37 | 38.37 | 38.35 | 38.38 | 38.38 | 38.38 | 38.39 | 38.41 |
| 14 | 38.38 | 38.37 | 38.38 | 38.35 | 38.35 | 38.38 | 38.38 | 38.41 | 38.42 | 38.38 |
| 15 | 38.39 | 38.36 | 38.40 | 38.37 | 38.36 | 38.41 | 38.38 | 38.39 | 38.39 | 38.39 |
| 16 | 38.41 | 38.41 | 38.41 | 38.36 | 38.36 | 38.41 | 38.41 | 38.41 | 38.41 | 38.40 |
| 17 | 38.40 | 38.39 | 38.35 | 38.36 | 38.41 | 38.38 | 38.41 | 38.37 | 38.41 | 38.37 |
| 18 | 38.40 | 38.41 | 38.37 | 38.37 | 38.37 | 38.39 | 38.41 | 38.37 | 38.42 | 38.37 |
| 19 | 38.36 | 38.39 | 38.36 | 38.38 | 38.36 | 38.38 | 38.38 | 38.41 | 38.34 | 38.38 |
| 20 | 38.45 | 38.38 | 38.37 | 38.38 | 38.37 | 38.41 | 38.38 | 38.36 | 38.37 | 38.37 |



## 夏新NO.8框架长度尺寸CPK分析 (公差0.14)

日期：2006.08.14 生产时间段：18:40-20:00  
品名：夏新NO.8 机台号：4# 机台参数：住友130T  
样本数：200 不良数：0 不良率：0.00%  
尺寸上限：38.47 尺寸下限：38.33  
最大值：38.45 最小值：38.33  
平均值：38.384 标准差：0.0211  
Cp：1.11 U\_Cpk：1.35 L\_Cpk：0.86 Cpk：0.86

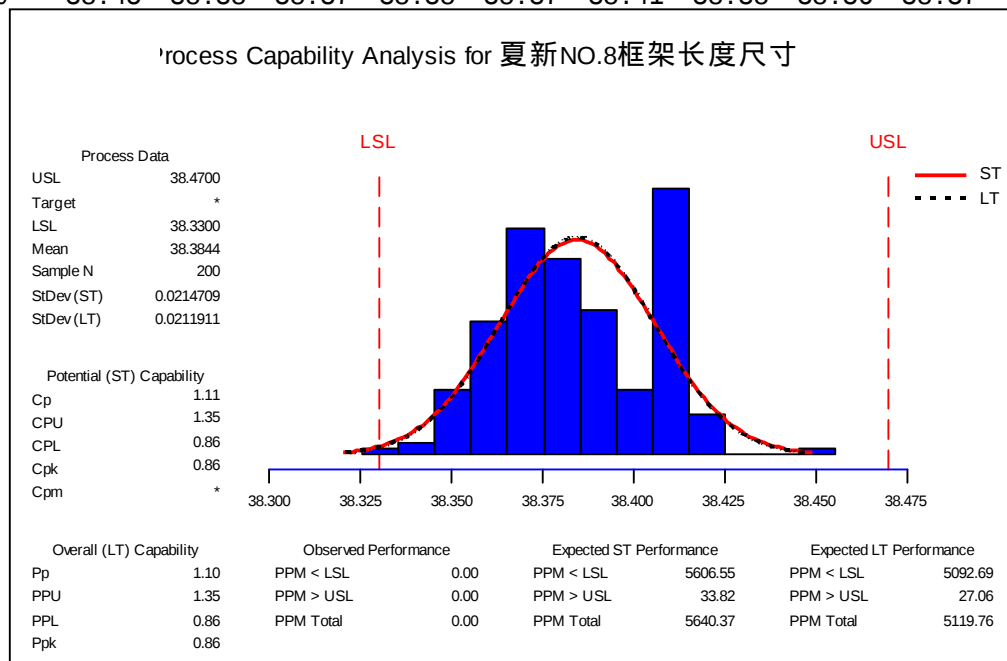
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 38.36 | 38.36 | 38.41 | 38.37 | 38.39 | 38.39 | 38.41 | 38.38 | 38.41 | 38.42 |
| 2  | 38.33 | 38.37 | 38.36 | 38.35 | 38.36 | 38.39 | 38.41 | 38.39 | 38.39 | 38.41 |
| 3  | 38.35 | 38.38 | 38.37 | 38.37 | 38.39 | 38.39 | 38.37 | 38.37 | 38.41 | 38.37 |
| 4  | 38.36 | 38.41 | 38.37 | 38.38 | 38.41 | 38.40 | 38.37 | 38.40 | 38.39 | 38.38 |
| 5  | 38.37 | 38.40 | 38.36 | 38.39 | 38.42 | 38.36 | 38.41 | 38.40 | 38.41 | 38.41 |
| 6  | 38.35 | 38.42 | 38.35 | 38.37 | 38.36 | 38.37 | 38.41 | 38.38 | 38.41 | 38.41 |
| 7  | 38.36 | 38.41 | 38.35 | 38.40 | 38.35 | 38.39 | 38.38 | 38.40 | 38.41 | 38.38 |
| 8  | 38.36 | 38.39 | 38.38 | 38.39 | 38.37 | 38.37 | 38.37 | 38.41 | 38.39 | 38.41 |
| 9  | 38.36 | 38.38 | 38.34 | 38.38 | 38.39 | 38.37 | 38.40 | 38.41 | 38.41 | 38.41 |
| 10 | 38.35 | 38.39 | 38.37 | 38.41 | 38.38 | 38.38 | 38.39 | 38.41 | 38.38 | 38.41 |
| 11 | 38.38 | 38.37 | 38.37 | 38.41 | 38.38 | 38.41 | 38.37 | 38.36 | 38.41 | 38.38 |
| 12 | 38.36 | 38.37 | 38.37 | 38.41 | 38.36 | 38.37 | 38.41 | 38.42 | 38.38 | 38.42 |
| 13 | 38.37 | 38.39 | 38.37 | 38.37 | 38.35 | 38.38 | 38.38 | 38.38 | 38.39 | 38.41 |
| 14 | 38.38 | 38.37 | 38.38 | 38.35 | 38.35 | 38.38 | 38.38 | 38.41 | 38.42 | 38.38 |
| 15 | 38.39 | 38.36 | 38.40 | 38.37 | 38.36 | 38.41 | 38.38 | 38.39 | 38.39 | 38.39 |
| 16 | 38.41 | 38.41 | 38.41 | 38.36 | 38.36 | 38.41 | 38.41 | 38.41 | 38.41 | 38.40 |
| 17 | 38.40 | 38.39 | 38.35 | 38.36 | 38.41 | 38.38 | 38.41 | 38.37 | 38.41 | 38.37 |
| 18 | 38.40 | 38.41 | 38.37 | 38.37 | 38.37 | 38.39 | 38.41 | 38.37 | 38.42 | 38.37 |
| 19 | 38.36 | 38.39 | 38.36 | 38.38 | 38.36 | 38.38 | 38.38 | 38.41 | 38.34 | 38.38 |
| 20 | 38.45 | 38.38 | 38.37 | 38.38 | 38.37 | 38.41 | 38.38 | 38.36 | 38.37 | 38.37 |



## 夏新NO.8框架长度尺寸CPK分析 (公差0.14)

日期：2006.08.14      生产时间段：18:40-20:00  
品名：夏新NO.8      机台号：4#      机台参数：住友130T  
样本数：200      不良数：0      不良率：0.00%  
尺寸上限：38.47      尺寸下限：38.33  
最大值：38.45      最小值：38.33  
平均值：38.384      标准差：0.0211  
Cp：1.11      U\_Cpk：1.35      L\_Cpk：0.86      Cpk：0.86

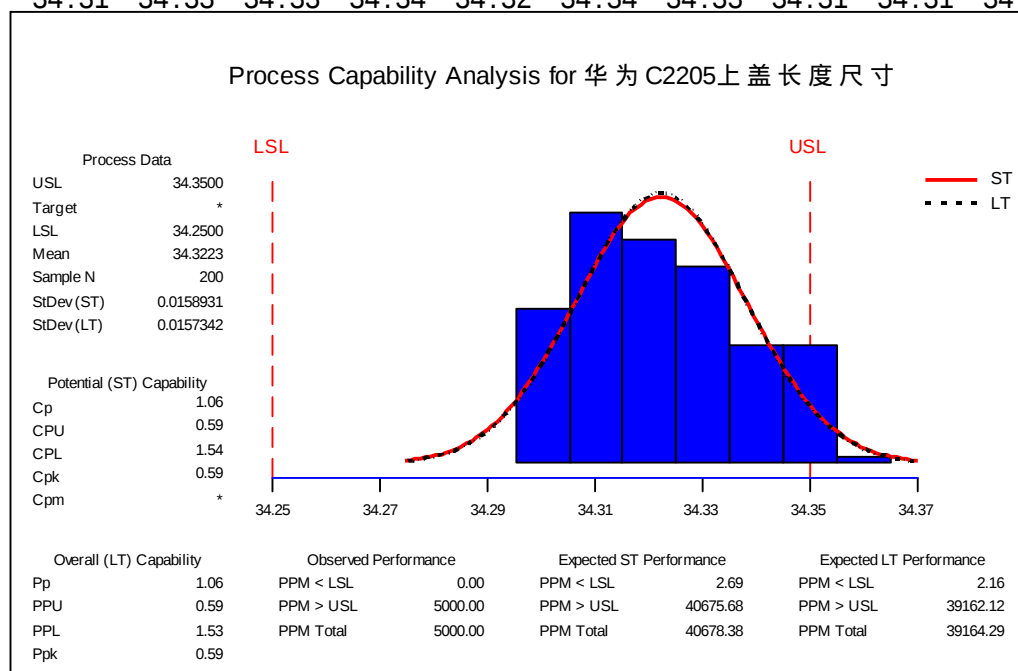
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 38.36 | 38.36 | 38.41 | 38.37 | 38.39 | 38.39 | 38.41 | 38.38 | 38.41 | 38.42 |
| 2  | 38.33 | 38.37 | 38.36 | 38.35 | 38.36 | 38.39 | 38.41 | 38.39 | 38.39 | 38.41 |
| 3  | 38.35 | 38.38 | 38.37 | 38.37 | 38.39 | 38.39 | 38.37 | 38.37 | 38.41 | 38.37 |
| 4  | 38.36 | 38.41 | 38.37 | 38.38 | 38.41 | 38.40 | 38.37 | 38.40 | 38.39 | 38.38 |
| 5  | 38.37 | 38.40 | 38.36 | 38.39 | 38.42 | 38.36 | 38.41 | 38.40 | 38.41 | 38.41 |
| 6  | 38.35 | 38.42 | 38.35 | 38.37 | 38.36 | 38.37 | 38.41 | 38.38 | 38.41 | 38.41 |
| 7  | 38.36 | 38.41 | 38.35 | 38.40 | 38.35 | 38.39 | 38.38 | 38.40 | 38.41 | 38.38 |
| 8  | 38.36 | 38.39 | 38.38 | 38.39 | 38.37 | 38.37 | 38.37 | 38.41 | 38.39 | 38.41 |
| 9  | 38.36 | 38.38 | 38.34 | 38.38 | 38.39 | 38.37 | 38.40 | 38.41 | 38.41 | 38.41 |
| 10 | 38.35 | 38.39 | 38.37 | 38.41 | 38.38 | 38.38 | 38.39 | 38.41 | 38.38 | 38.41 |
| 11 | 38.38 | 38.37 | 38.37 | 38.41 | 38.38 | 38.41 | 38.37 | 38.36 | 38.41 | 38.38 |
| 12 | 38.36 | 38.37 | 38.37 | 38.41 | 38.36 | 38.37 | 38.41 | 38.42 | 38.38 | 38.42 |
| 13 | 38.37 | 38.39 | 38.37 | 38.37 | 38.35 | 38.38 | 38.38 | 38.38 | 38.39 | 38.41 |
| 14 | 38.38 | 38.37 | 38.38 | 38.35 | 38.35 | 38.38 | 38.38 | 38.41 | 38.42 | 38.38 |
| 15 | 38.39 | 38.36 | 38.40 | 38.37 | 38.36 | 38.41 | 38.38 | 38.39 | 38.39 | 38.39 |
| 16 | 38.41 | 38.41 | 38.41 | 38.36 | 38.36 | 38.41 | 38.41 | 38.41 | 38.41 | 38.40 |
| 17 | 38.40 | 38.39 | 38.35 | 38.36 | 38.41 | 38.38 | 38.41 | 38.37 | 38.41 | 38.37 |
| 18 | 38.40 | 38.41 | 38.37 | 38.37 | 38.37 | 38.39 | 38.41 | 38.37 | 38.42 | 38.37 |
| 19 | 38.36 | 38.39 | 38.36 | 38.38 | 38.36 | 38.38 | 38.38 | 38.41 | 38.34 | 38.38 |
| 20 | 38.45 | 38.38 | 38.37 | 38.38 | 38.37 | 38.41 | 38.38 | 38.36 | 38.37 | 38.37 |



## 华为C2205上盖长度尺寸CPK分析 (公差0.1)

日期：2006.08.15 生产时间段：09:40-10:40  
品名：华为C2205上盖 机台号：5# 机台参数：柳州150T  
样本数：200 不良数：1 不良率：0.50%  
尺寸上限：34.35 尺寸下限：34.25  
最大值：34.36 最小值：34.30  
平均值：34.322 标准差：0.0157  
Cp：1.06 U\_Cpk：0.59 L\_Cpk：1.54 Cpk：0.59

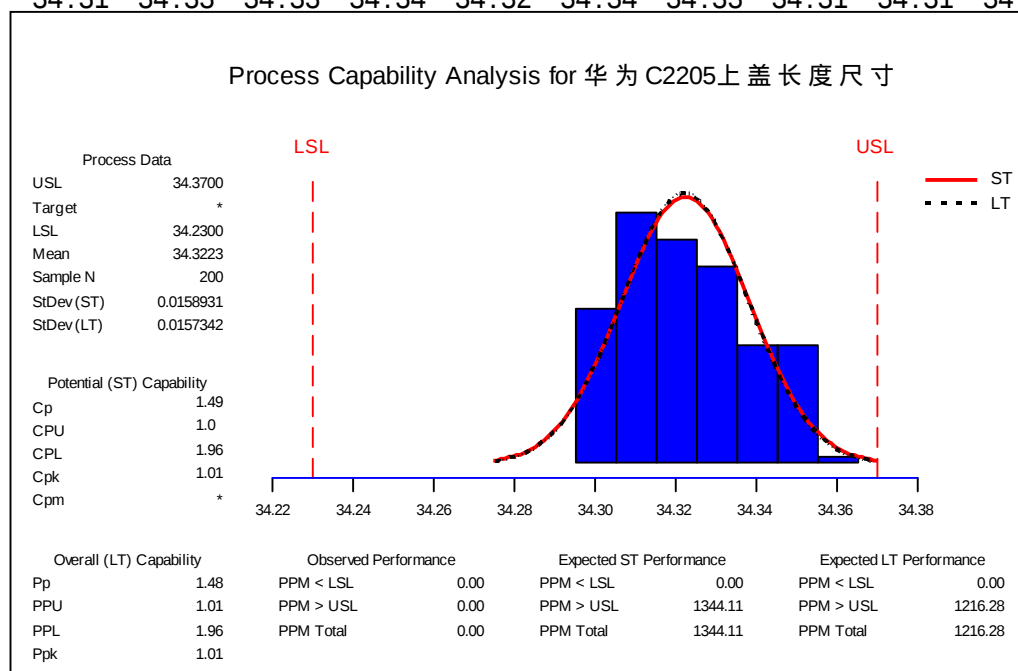
|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 34.32 | 34.32 | 34.33 | 34.31 | 34.32 | 34.33 | 34.33 | 34.34 | 34.32 | 34.31 |
| 2  | 34.31 | 34.30 | 34.30 | 34.32 | 34.34 | 34.30 | 34.31 | 34.30 | 34.30 | 34.33 |
| 3  | 34.34 | 34.33 | 34.32 | 34.35 | 34.32 | 34.31 | 34.32 | 34.31 | 34.31 | 34.33 |
| 4  | 34.33 | 34.31 | 34.32 | 34.32 | 34.31 | 34.31 | 34.33 | 34.33 | 34.31 | 34.33 |
| 5  | 34.35 | 34.32 | 34.34 | 34.32 | 34.32 | 34.32 | 34.34 | 34.31 | 34.34 | 34.30 |
| 6  | 34.33 | 34.31 | 34.32 | 34.33 | 34.30 | 34.30 | 34.34 | 34.33 | 34.31 | 34.34 |
| 7  | 34.30 | 34.35 | 34.30 | 34.31 | 34.30 | 34.33 | 34.32 | 34.31 | 34.35 | 34.35 |
| 8  | 34.33 | 34.31 | 34.30 | 34.30 | 34.35 | 34.32 | 34.35 | 34.32 | 34.33 | 34.33 |
| 9  | 34.34 | 34.32 | 34.32 | 34.33 | 34.32 | 34.31 | 34.35 | 34.31 | 34.35 | 34.35 |
| 10 | 34.32 | 34.31 | 34.34 | 34.33 | 34.31 | 34.32 | 34.30 | 34.31 | 34.31 | 34.34 |
| 11 | 34.31 | 34.31 | 34.33 | 34.30 | 34.32 | 34.34 | 34.33 | 34.30 | 34.32 | 34.32 |
| 12 | 34.32 | 34.30 | 34.34 | 34.34 | 34.35 | 34.35 | 34.34 | 34.32 | 34.31 | 34.30 |
| 13 | 34.30 | 34.31 | 34.32 | 34.34 | 34.35 | 34.31 | 34.31 | 34.31 | 34.32 | 34.34 |
| 14 | 34.32 | 34.33 | 34.33 | 34.30 | 34.32 | 34.31 | 34.35 | 34.33 | 34.34 | 34.33 |
| 15 | 34.30 | 34.31 | 34.30 | 34.31 | 34.33 | 34.35 | 34.31 | 34.33 | 34.34 | 34.31 |
| 16 | 34.32 | 34.31 | 34.30 | 34.35 | 34.35 | 34.32 | 34.32 | 34.34 | 34.35 | 34.33 |
| 17 | 34.30 | 34.35 | 34.35 | 34.30 | 34.32 | 34.31 | 34.31 | 34.31 | 34.30 | 34.35 |
| 18 | 34.31 | 34.33 | 34.31 | 34.32 | 34.30 | 34.32 | 34.32 | 34.32 | 34.31 | 34.33 |
| 19 | 34.33 | 34.31 | 34.30 | 34.32 | 34.30 | 34.33 | 34.31 | 34.33 | 34.36 | 34.35 |
| 20 | 34.31 | 34.33 | 34.33 | 34.34 | 34.32 | 34.34 | 34.33 | 34.31 | 34.31 | 34.33 |



## 华为C2205上盖长度尺寸CPK分析 (公差0.14)

日期: 2006.08.15 生产时间段: 09:40-10:40  
品名: 华为C2205上盖 机台号: 5# 机台参数: 柳州150T  
样本数: 200 不良数: 0 不良率: 0.00%  
尺寸上限: 34.37 尺寸下限: 34.23  
最大值: 34.36 最小值: 34.30  
平均值: 34.322 标准差: 0.0157  
Cp: 1.49 U\_Cpk: 1.01 L\_Cpk: 1.96 Cpk: 1.01

|    | 1     | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 9     | 10    |
|----|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| 1  | 34.32 | 34.32 | 34.33 | 34.31 | 34.32 | 34.33 | 34.33 | 34.34 | 34.32 | 34.31 |
| 2  | 34.31 | 34.30 | 34.30 | 34.32 | 34.34 | 34.30 | 34.31 | 34.30 | 34.30 | 34.33 |
| 3  | 34.34 | 34.33 | 34.32 | 34.35 | 34.32 | 34.31 | 34.32 | 34.31 | 34.31 | 34.33 |
| 4  | 34.33 | 34.31 | 34.32 | 34.32 | 34.31 | 34.31 | 34.33 | 34.33 | 34.31 | 34.33 |
| 5  | 34.35 | 34.32 | 34.34 | 34.32 | 34.32 | 34.32 | 34.34 | 34.31 | 34.34 | 34.30 |
| 6  | 34.33 | 34.31 | 34.32 | 34.33 | 34.30 | 34.30 | 34.34 | 34.33 | 34.31 | 34.34 |
| 7  | 34.30 | 34.35 | 34.30 | 34.31 | 34.30 | 34.33 | 34.32 | 34.31 | 34.35 | 34.35 |
| 8  | 34.33 | 34.31 | 34.30 | 34.30 | 34.35 | 34.32 | 34.35 | 34.32 | 34.33 | 34.33 |
| 9  | 34.34 | 34.32 | 34.32 | 34.33 | 34.32 | 34.31 | 34.35 | 34.31 | 34.35 | 34.35 |
| 10 | 34.32 | 34.31 | 34.34 | 34.33 | 34.31 | 34.32 | 34.30 | 34.31 | 34.31 | 34.34 |
| 11 | 34.31 | 34.31 | 34.33 | 34.30 | 34.32 | 34.34 | 34.33 | 34.30 | 34.32 | 34.32 |
| 12 | 34.32 | 34.30 | 34.34 | 34.34 | 34.35 | 34.35 | 34.34 | 34.32 | 34.31 | 34.30 |
| 13 | 34.30 | 34.31 | 34.32 | 34.34 | 34.35 | 34.31 | 34.31 | 34.31 | 34.32 | 34.34 |
| 14 | 34.32 | 34.33 | 34.33 | 34.30 | 34.32 | 34.31 | 34.35 | 34.33 | 34.34 | 34.33 |
| 15 | 34.30 | 34.31 | 34.30 | 34.31 | 34.33 | 34.35 | 34.31 | 34.33 | 34.34 | 34.31 |
| 16 | 34.32 | 34.31 | 34.30 | 34.35 | 34.35 | 34.32 | 34.32 | 34.34 | 34.35 | 34.33 |
| 17 | 34.30 | 34.35 | 34.35 | 34.30 | 34.32 | 34.31 | 34.31 | 34.31 | 34.30 | 34.35 |
| 18 | 34.31 | 34.33 | 34.31 | 34.32 | 34.30 | 34.32 | 34.32 | 34.32 | 34.31 | 34.33 |
| 19 | 34.33 | 34.31 | 34.30 | 34.32 | 34.30 | 34.33 | 34.31 | 34.33 | 34.36 | 34.35 |
| 20 | 34.31 | 34.33 | 34.33 | 34.34 | 34.32 | 34.34 | 34.33 | 34.31 | 34.31 | 34.33 |



以上内容仅为本文档的试下载部分，为可阅读页数的一半内容。如要下载或阅读全文，请访问：<https://d.book118.com/275310333311011141>