

STUDY NO. 510-S
AUDITORS INITIALS JBM

MACHINE CAPABILITY STUDY PROGRAM SUMMARY

DISTRIBUTION LIST:

S.J. HILL J.A. HARTER
R.L. STAFFORD K.L. TAYLOR
C.F. CIECKO K.W. AUGUSTINE
W.R. GLOBIS FILE

Serviced Wheel

PART NUMBER: 26289
OPER. NUMBER: 100-130
CYCLE TIME: 1.18
DATE: 2-22-82

PART NAME: BARREL
MACH. NO.: 28341
BUILDING NUMBER: 66

Remington

MODEL: 700
OPER. DESCRIPTION: ENGLISH BREECH END TO BLEND

MACHINE: PRODUCTION
DEPARTMENT NUMBER: 58

COMMENTS: MEASURED BEFORE OP. 100 AFTER OP 130 TO
DETERMINE AVERAGE MATERIAL REMOVAL.
(FIRST 12 PCS. EVERY 4TH PASS-LAST 10PCS. EVERY 3RD PASS.)

PAGE GAGE NO. GAGE DESCRIPTION
1 Dial Indicator
2 Dial Indicator
3 Dial Indicator
4

DESCRIPTION OF CHARACTERISTIC
DIA 2.808 FROM BREECH FACE
DIA 2.808 FROM BREECH FACE
DIFFERENCE OF BEFORE AND AFTER
SUMMARY-EXPECTED YIELD - AS RUN
SUMMARY-EXPECTED YIELD W/MEAN OF TOLERANCE APPLIED

DWG. FIXT 1/10 EXPEC
DIM. NO TOL YIELD STAT
1.0170 0 DUT 95. UNC
1.0074 0 DUT 56. UNC
0.0000 0 N/A N/A INF 3-10-82

APPROVED AS CONTROLLABLE BY:

-----FOREMAN, QUALITY CONTROL

REVIEWED BY: -----PRODUCTION SUPERVISOR

-----PROCESS ENGINEER

MACHINE CAPABILITY STUDY

STUDY NO. 51U-S

PAGE 1

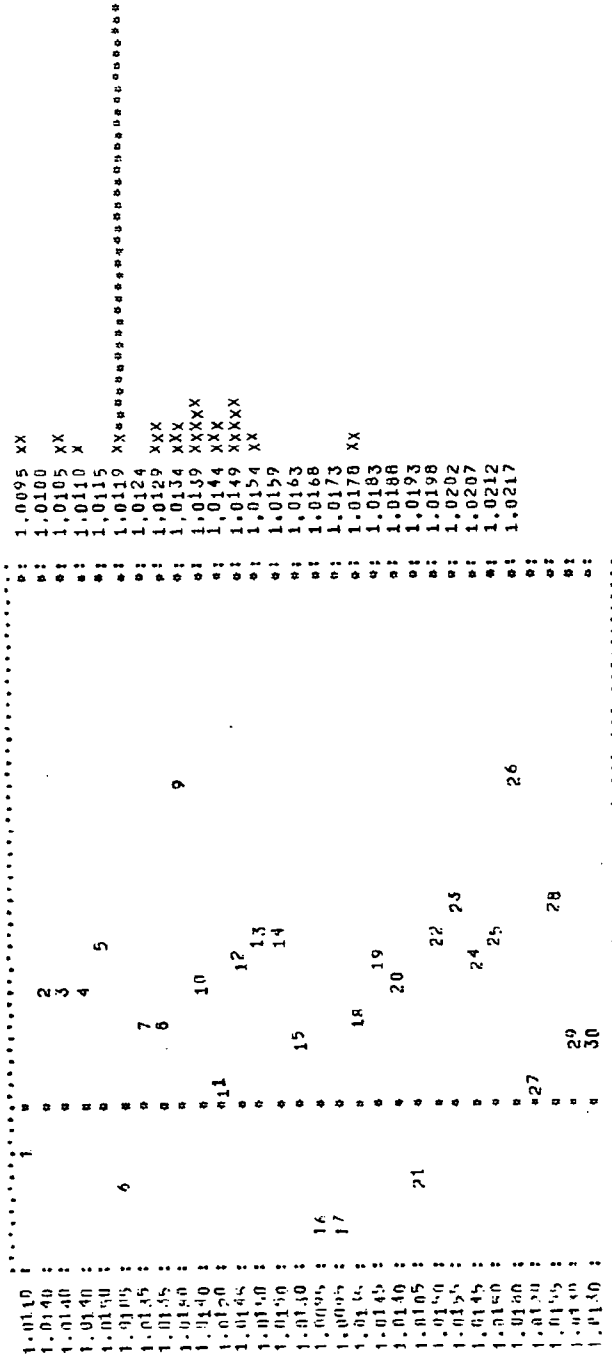
CALL NUMBER: 601CE
COMPANY:

MODEL DRAWING DIMENSIONS
MIN: 1.0120 MAX: 1.0220

DESCRIPTION OF CHARACTERISTIC: DIA 2.808 FROM HRFEECH FACE
TYPE OF GAUGE: 1/16" INDICATOR
LOH-TOL.

HISTOGRAM

UPPER-TOL.



MEAN

MEAN = 1.01367

CRP STANDARD DEVIATION = 0.00207

SIX STANDARD DEVIATIONS = 0.01244

EXPECTED YIELD - AS RUP = 79. PERCENT
EXPECTED YIELD - WITH HEAD OF TOLERANCE APPLIED = 98. PERCENT
***** THIS SET OF DATA IS NOT CONTROLLABLE TO 6 STANDARD DEVIATIONS *****

STUDY NO. 510-S

PAGE 2

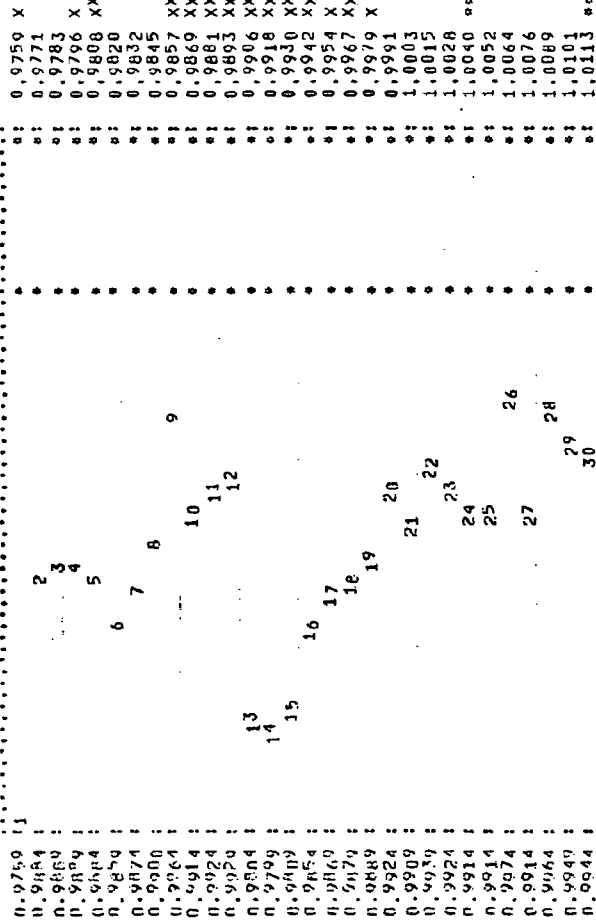
GAGE NUMBER: POICE
COMPONENT:

MODEL DRAWING DIMENSIONS
MIN: 1.0034 MAX: 1.0114

DESCRIPTION OF CHARACTERISTIC DIA 2.808 FROM RHEECH FACE.
TYP OF GAGE: DIAL INDICATOR

HISTOGRAM

LOW-TOLUPPER-TOL



MEAN

MEAN = 0.98947

ONE STANDARD DEVIATION = 0.00513

SIX STANDARD DEVIATIONS = 0.03080

EXPECTED YIELD - AS RUN = 0. PERCENT
EXPECTED YIELD - WITH MEAN OF TOLERANCE APPLIED = 50. PERCENT
***** THIS SET OF DATA IS NOT CONTROLLABLE TO 6 STANDARD DEVIATIONS *****

STUDY NO. 510-S

PAGE 3

GAGE NUMBER: POICE
COMMENTS: FOR INFORMATION ONLY

MODEL DRAWING DIMENSIONS
MIN: 0.0000 MAX: 0.0000

DESCRIPTION OF CHARACTERISTIC: DIFFERENCE OF BEFORE AND AFTER
TYPE OF GAGE: DIAL INDICATOR

0.0145	1	0.0000
0.0255	2	0.0012
0.0250	3	0.0024
0.0255	4	0.0036
0.0265	5	0.0048
0.0245	6	0.0060
0.0260	7	0.0072
0.0255	8	0.0084
0.0220	9	0.0097
0.0225	10	0.0109
0.0200	11	0.0121
0.0215	12	0.0133
0.0145	13	0.0145
0.0300	14	0.0157
0.0320	15	0.0169
0.0240	16	0.0181
0.0350	17	0.0193
0.0260	18	0.0205
0.0235	19	0.0217
0.0215	20	0.0229
0.0195	21	0.0241
0.0210	22	0.0253
0.0255	23	0.0266
0.0230	24	0.0278
0.0255	25	0.0290
0.0205	26	0.0302
0.0190	27	0.0314
0.0145	28	0.0326
0.0190	29	0.0338
0.0190	30	0.0350

MEAN

MEAN = 0.02422

ONE STANDARD DEVIATION = 0.00454

SIX STANDARD DEVIATIONS = 0.02724

SUMMARY-EXPECTED YIELD - AS RUN		STUDY NO. 510-S

PAGE 4		
DESCRIPTION OF CHARACTERISTIC	EXPECTED YIELD	
*****	*****	
DIA 2.008 FROM BRTECH FACE	79.	
DIA 2.008 FROM BRTECH FACE	0.	
TOTAL YIELD	0.	

SUMMARY-EXPECTED YIELD - WITH MEAN OF TOLERANCE APPLIED

 STUDY NO, 510-S

 DESCRIPTION OF CHARACTERISTIC PAGE 5 EXPECTED YIELD

 DIA 2.808 FROM DEPTH FACE ***** 98,

 DIA 2.808 FROM DEPTH FACE ***** 56,

 TOTAL YIELD ***** 55,
