

DISTRIBUTION LIST:

MACHINE CAPABILITY STUDY PROGRAM SUMMARY

STUDY NO. 510-S
AUDITORS INITIALS JBN

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Remington's Chart

MODEL: 700

PART NAME: BARREL

PART NUMBER: 26289

OPER. DESCRIPTION: POLISH BREECH END TO BLEND

OPER. NUMBER: 100-130

MACH: PRODUCTION

MACH. NO.: 28341

CYCLE TIME: .48

DEPARTMENT NUMBER: 58

BUILDING NUMBER: 66

DATE: 2-22-82

COMMENTS: MEASURED BEFORE OP. 100 AFTER OP. 130 TO
DETERMINE AVERAGE MATERIAL REMOVAL.
(FIRST 12 PCS. EVERY 4TH PASS-LAST 18PCS. EVERY 3RD PASS.)

PAGE GAGE NO.	GAGE DESCRIPTION	DESCRIPTION OF CHARACTERISTIC	DWG. DIM.	FIXT NO	I/O	EXPEC TOL	YIELD	STAT
1 Polich	DIAL INDICATOR	DIA 2.808 FROM BREECH FACE	1.0170	0	OUT	55.	UNC	
2 Polich	DIAL INDICATOR	DIA 2.808 FROM BREECH FACE	1.0074	0	OUT	56.	UNC	
3 Polich	DIAL INDICATOR	DIFFERENCE OF BEFORE AND AFTER	0.0000	0	N/A	N/A	INF	
4		SUMMARY-EXPECTED YIELD - AS RUN					0.	
5		SUMMARY-EXPECTED YIELD W/MEAN OF TOLERANCE APPLIED					55.	

APPROVED AS CONTROLLABLE BY:

-----FOREMAN, QUALITY CONTROL

REVIEWED BY:

-----PRODUCTION SUPERVISOR

-----PROCESS ENGINEER

Serviced wheel

3-10-82

MACHINE CAPABILITY STUDY

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STUDY NO. 510-S

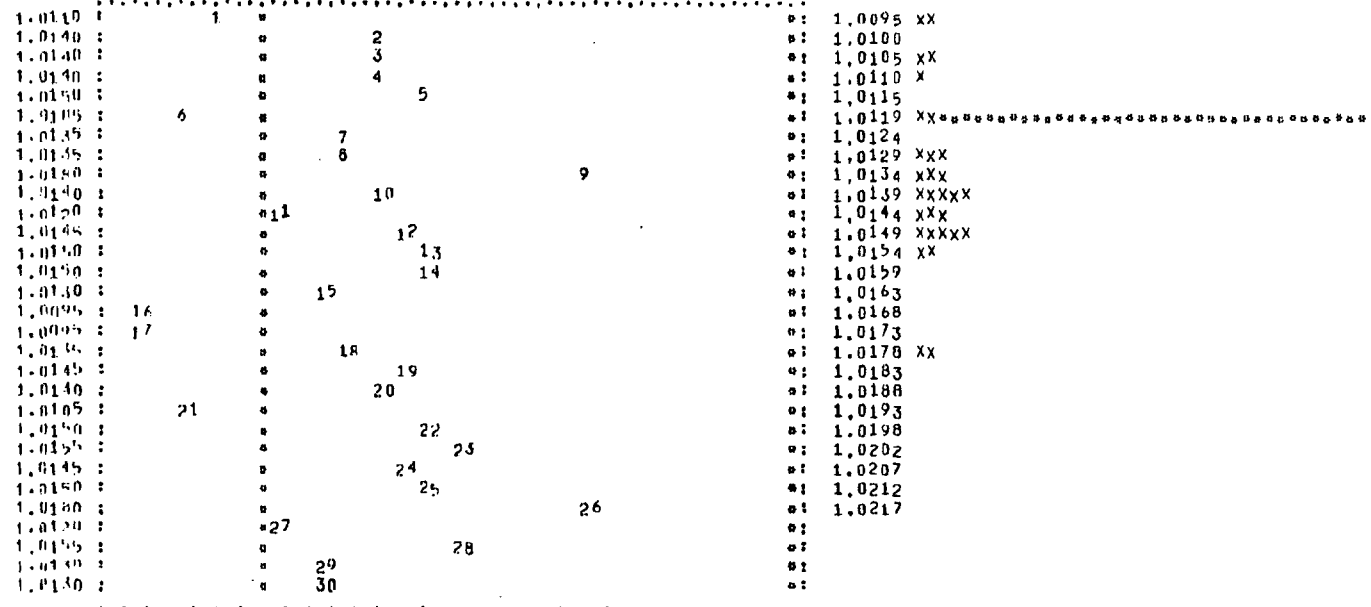
GAGE NUMBER: 601CE
COMMENTS:

MODEL DRAWING DIMENSIONS
MIN: 1.0120 MAX: 1.0220

DESCRIPTION OF CHARACTERISTIC: DIA 2.800 FROM BREECH FACE
TYPE OF GAGE: DIAL INDICATOR
LOW-TOL.

UPPER-TOL.

HISTOGRAM



MEAN

MEAN = 1.01367

ONE STANDARD DEVIATION = 0.00207

SIX STANDARD DEVIATIONS = 0.01244

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

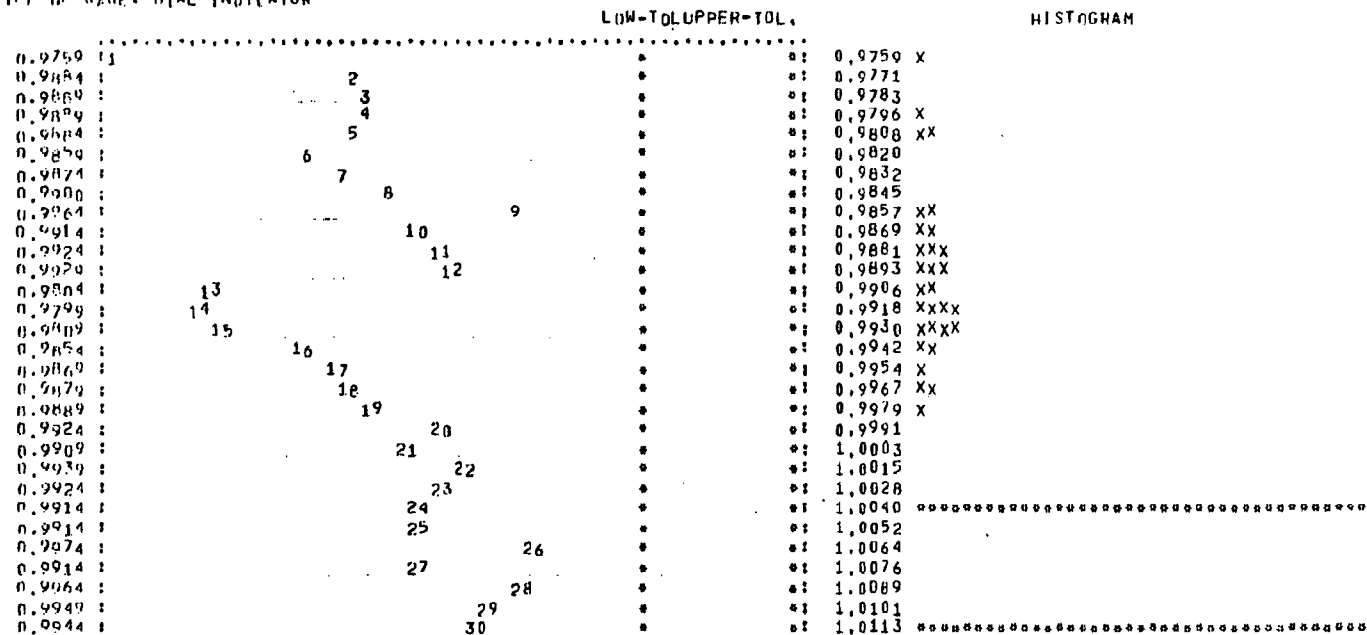
GAGE NUMBER: POICE
CORRECTION:

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STUDY NO. 510-S

DESCRIPTION OF CHARACTERISTIC: DIA 2.808 FROM RREECH FACE.
TYPE OF GAGE: DIAL INDICATOR

MODEL DRAWING DIMENSIONS
MIN: 1.0034 MAX: 1.0114



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 *****

GAGE NUMBER: POICE
 COMMENTS: FOR INFORMATION ONLY

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STUDY NO. 510-S

MODEL DRAWING DIMENSIONS
 MIN: 0.0000 MAX: 0.0000

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

0.0345	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
0.0235	8	0.0084
0.0220	9	0.0097
0.0225	10	0.0109
0.0200	11	0.0121
0.0215	12	0.0133
0.0345	13	0.0145
0.0350	14	0.0157
0.0320	15	0.0169
0.0240	16	0.0181 X
0.0230	17	0.0193 XXX
0.0260	18	0.0205 XXXX
0.0255	19	0.0217 XXX
0.0215	20	0.0229 XXXXX
0.0195	21	0.0241 XX
0.0210	22	0.0253 XXXX
0.0235	23	0.0266 XXX
0.0230	24	0.0278
0.0235	25	0.0290
0.0205	26	0.0302
0.0205	27	0.0314
0.0190	28	0.0326 X
0.0185	29	0.0338
0.0190	30	0.0350 XXX

MEAN

MEAN = 0.02422

ONE STANDARD DEVIATION = 0.00454

SIX STANDARD DEVIATIONS = 0.02724

SUMMARY-EXPECTED YIELD - AS RUN

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STUDY NO. 510-S

***** DESCRIPTION OF CHARACTERISTIC *****	***** EXPECTED YIELD *****
DIA 2.808 FROM BREACH FACE	79.
DIA 2.808 FROM BREACH FACE,	0.
TOTAL YIELD	0.

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SUMMARY-EXPECTED YIELD - WITH MEAN OF TOLERANCE APPLIED

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DESCRIPTION OF CHARACTERISTIC

EXPECTED YIELD

DIA 2.808 FROM BREECH FACE

98,

DIA 2.808 FROM BREECH FACE.

56,

TOTAL YIELD

55,

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