

GFM-HAMMER
MARKS

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MACHINE CAPABILITY STUDY PROGRAM SUMMARY

STUDY NO. 492-5
AUDITORS INITIALS JWH

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C.F. CTECKO (6) FILE

MODEL: PART NAME: BARREL
OPER. NUMBER: 100-130
MACHINE NO.: 28341
BUILDING NUMBER: 66
DATE: 10-28-81
COMMENTS: SAMPLED BEHIND OF 100% AFTER
150 To DETERMINE AVERAGE Abnormal Removal.

PAGE	GAGE	DESCRIPTION	DESCRIPTION OF CHARACTERISTIC	DWG.	FIXT	I/O	EXPEC	DIM.	NO	TOL	YIELD	STAT
1	POICE	DIA. INDICATOR	DIA 2.808 FROM BREECH FACE	1.0170	0	OUT	80.	UNC				
2	POICE	DIA. INDICATOR	DIA 2.808 FROM BREECH FACE	1.0074	0	OUT	64.	UNC				
3	POICE	DIA. INDICATOR	DIFFERENCE OF BEFORE AND AFTER	0.0000	0	N/A	N/A	INF				
4			SUMMARY-EXPECTED YIELD - AS RUN				U.					
			SUMMARY-EXPECTED YIELD W/MEAN OF TOLERANCE APPLIED				51.					

APPROVED BY: CONTROL BY: FOREMAN, QUALITY CONTROL												

REVIEWED BY: PRODUCTION SUPERVISOR												

PROCESS ENGINEER												

10-30-81

MACHINE CAPABILITY STUDY

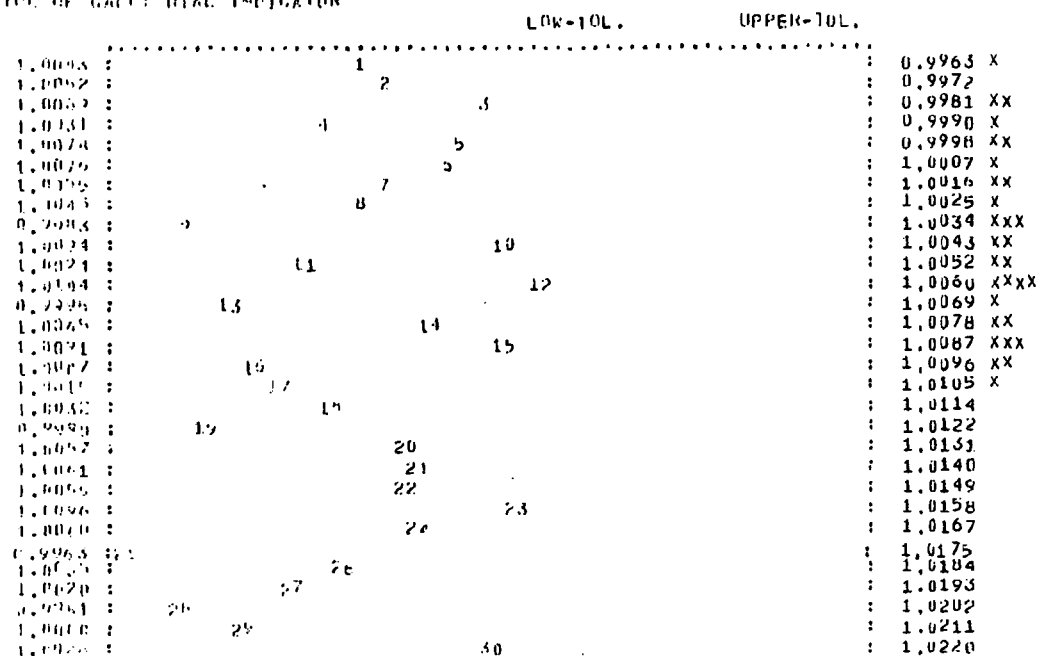
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GAGE: 000011: 00101
CORRECTION: 000011: 00101

MODEL DRAWING DIMENSIONS
MIN: 1.0120 MAX: 1.0220

DESCRIPTION OF CHARACTERISTIC: DIA 2.800 FROM BREECH FACE
TYPE OF GAGE: DIAL INDICATOR



MEAN

MEAN = 1.0040

STANDARD DEVIATION = 0.00331

SIX STANDARD DEVIATIONS = 0.02331

DEFECTIVE YIELD = AS RUN = 2. PERCENT

DEFECTIVE YIELD WITH PLAN OF TOLERANCE APPLIED = 50. PERCENT

STANDARD DEVIATION OF DATA IS NOT CONTROLLABLE TO 3 STANDARD DEVIATIONS *****

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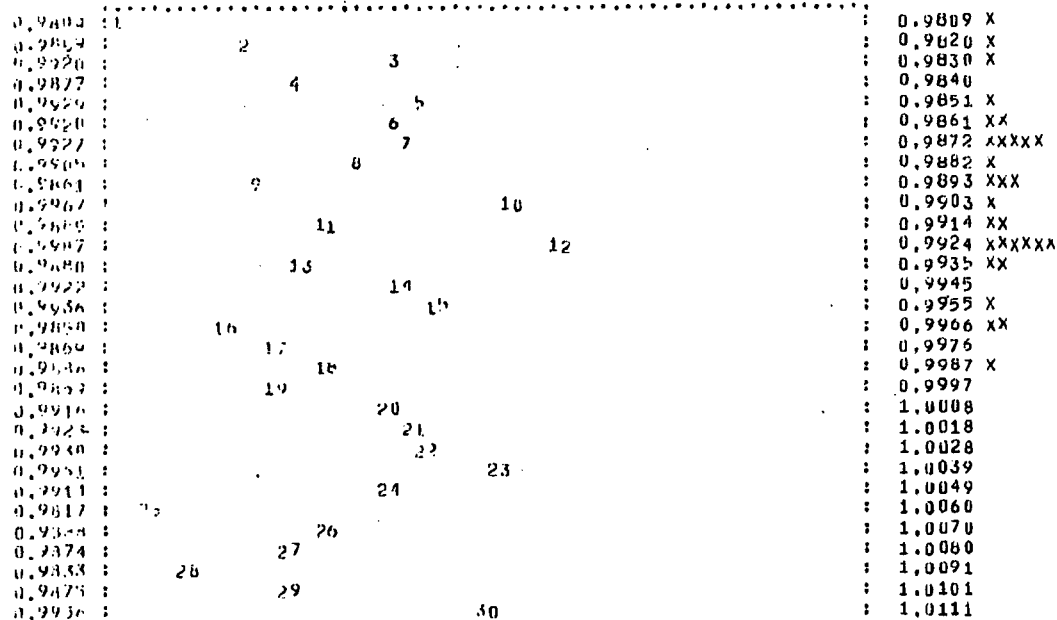
GAGE NUMBER: 03102
COMMENTS: AFTER OP 133

MODEL DRAWING DIMENSIONS
MIN: 1.0034 MAX: 1.0114

DESCRIPTION OF CHARACTERISTIC: DIA 2.000 FROM BREACH FACE
TYPE OF GAGE: DIAL INDICATOR

LOW-TOL. UPPER-TOL.

HISTOGRAM



MEAN

MEAN = 0.99985

ONE STANDARD DEVIATION = 0.00436

SIX STANDARD DEVIATIONS = 0.02614

PERCENT YIELD = AS RUN = 0. PERCENT

PERCENT YIELD = WITH MEAN OF TOLERANCE APPLIED = 64. PERCENT

***** THIS SET OF DATA IS NOT CONSIDERABLE TO 6 STANDARD DEVIATIONS *****

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GAGE DIMENSION: VOICE
COORDINATES:

MODEL DRAWING DIMENSIONS
MIN: 0.0000 MAX: 0.0000

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

0.0234	1	0.0000
0.0193	2	0.0008
0.0162	3	0.0016
0.0154	4	0.0024
0.0149	5	0.0032
0.0155	6	0.0040
0.0120	7	0.0048
0.0140	8	0.0056
0.0122	9	0.0065
0.0127	10	0.0073
0.0135	11	0.0081
0.0117	12	0.0089
0.0115	13 ✓	0.0097
0.0143	14	0.0105
0.0155	15	0.0113 X
0.0157	16	0.0121 XXXX
0.0146	17	0.0129 XXXX
0.0154	18	0.0137 XXXXX
0.0121	19	0.0145 XXXXXXXX
0.0131	20	0.0153 XXXXX
0.0135	21	0.0161
0.0129	22	0.0169 X
0.0135	23	0.0178
0.0146	24	0.0186
0.0140	25	0.0194 X
0.0147	26	0.0202
0.0146	27	0.0210
0.0144	28	0.0218
0.0125	29	0.0226
0.0130	30	0.0234 X

MEAN

MEAN = 0.01449

SIX STANDARD DEVIATION = 0.00234

SIX STANDARD DEVIATIONS = 0.01406

SUMMARY-EXPECTED YIELD - AS RUN
 =====
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 =====
 DESCRIPTION OF CHARACTERISTIC
 FIA 2.008 FROM ERECH FACE
 =====
 FIA 2.808 FROM FINECH FACE
 =====
 TOTAL YIELD
 =====
 EXPECTED YIELD
 =====
 2.
 0.
 0.
 =====
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 =====

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SUMMARY-EXPECTED YIELD - WITH MEAN OF TOLERANCE APPLIED

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DESCRIPTION OF CHARACTERISTIC

11A 2.808 FROM HATCH FACE

11A 2.808 FROM HATCH FACE

TOTAL YIELD

EXPECTED YIELD

80.

64.

51.