

17710 Receiver
Insert DATA

MF1568

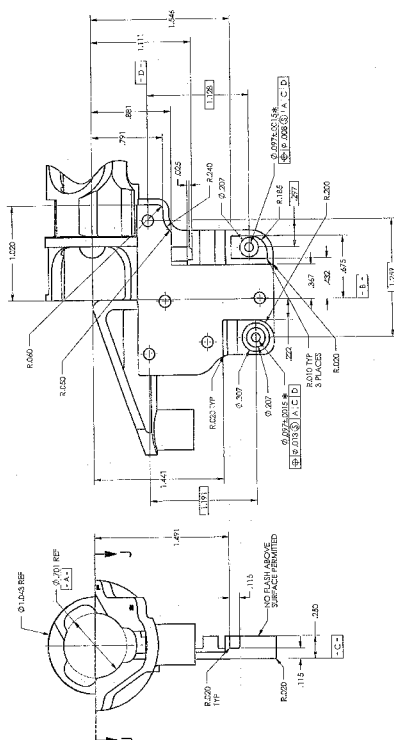
Confidential - Subject to Protective Order
Williams v. Remington

710	3003327	RECEIVER INSIRT	PART NO.	DATE OF SALE	RECEIVED
RECEIVED	INSIRT	TYPE & SIZE	DATE	BY	RECEIVED
INSIRT	1/15/59	JMS 2 1/2" x 9"	JAN 11/7/60		FOR BELL
RECEIVER INSIRT					RECEIVED
2E-300327					RECEIVED

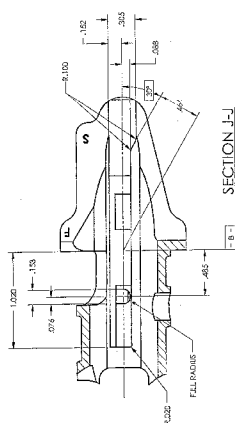
Ramington

[illegible]

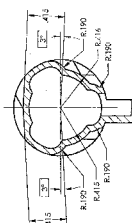
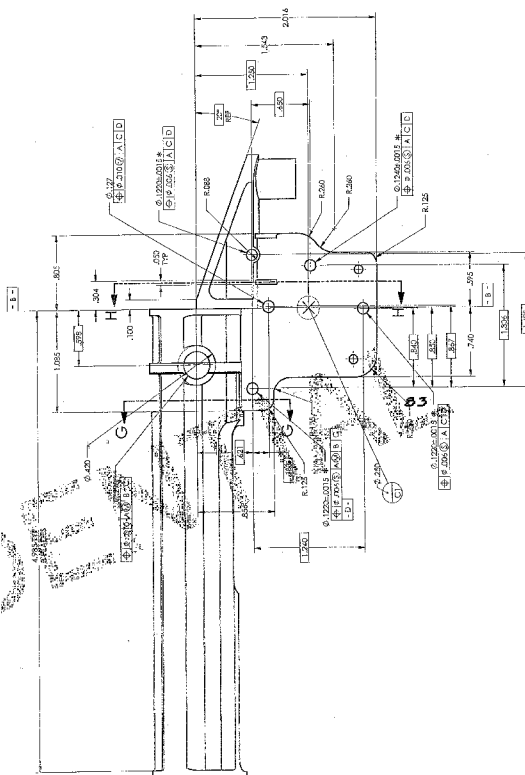
10-4-1 2015



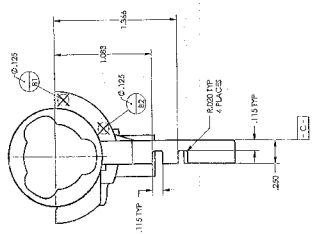
NOTE:¹
* - INDICATES CRITICAL DIMENSION
+ - INDICATES IN PROCESS DIMENSION



SECTION J-J

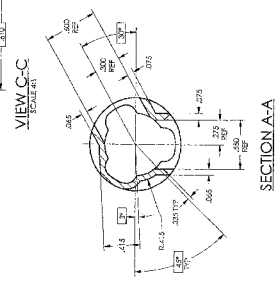


SECTION G-G

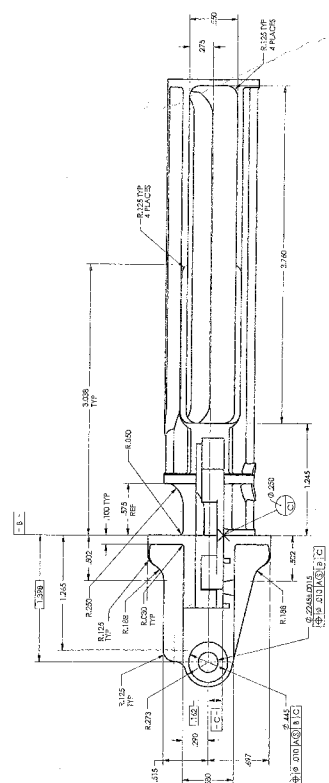


MF1569

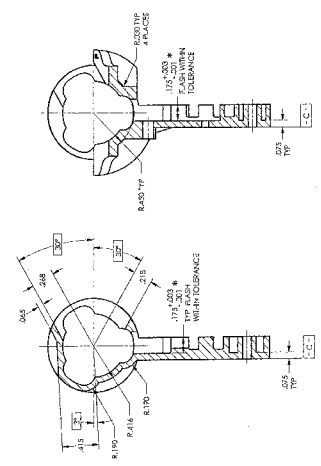
THE DRAWING OR INFORMATION IS
FOR REFERENCE ONLY. FOR THE
LATEST INFORMATION, VISIT
WWW.AERONAUTICS.COM



SECTION A-A



ISOMETRIC VIEWS



SECTION B-B

Design a pinning gage
for critical data

GMT820 - 830 gage

CONFIDENTIAL

MF1571

RECEIVER INSERT\Hanson 600.job: XBar/R 1 - X

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name DATUM D
 Feature number 01180
 NOM 0.8500 UTL 0.8530 LTL 0.8470
 Sample Set Size 3
 # of Sample Sets 33
 Total 99

	Mean Chart	R Chart
Central Line	0.8453	0.0003
UCL	0.8456	0.0008
LCL	0.8450	0.0000

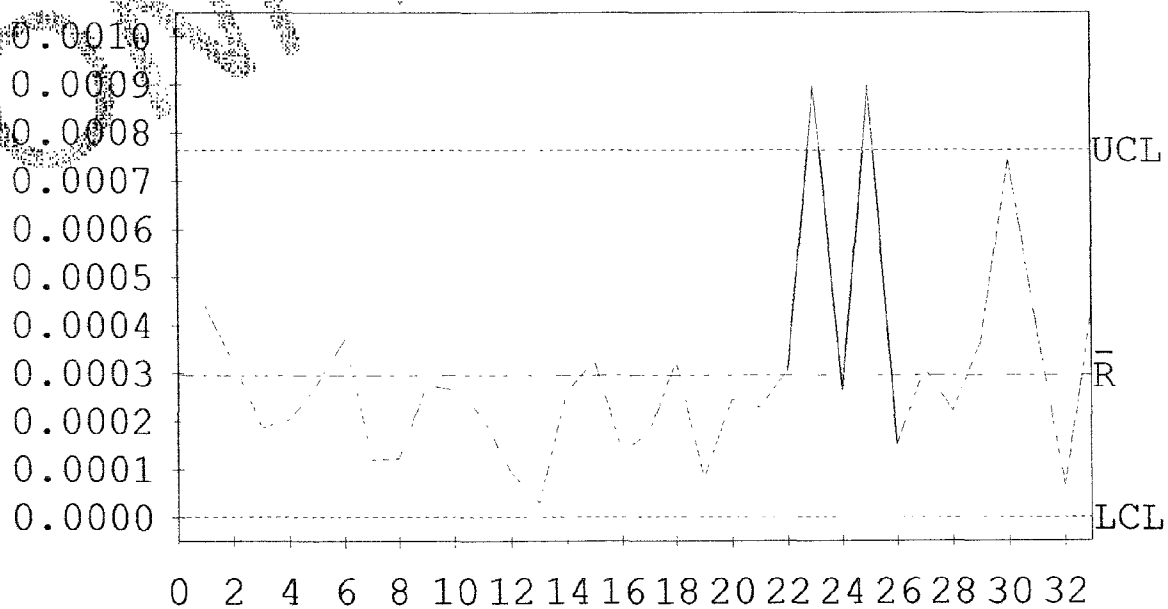
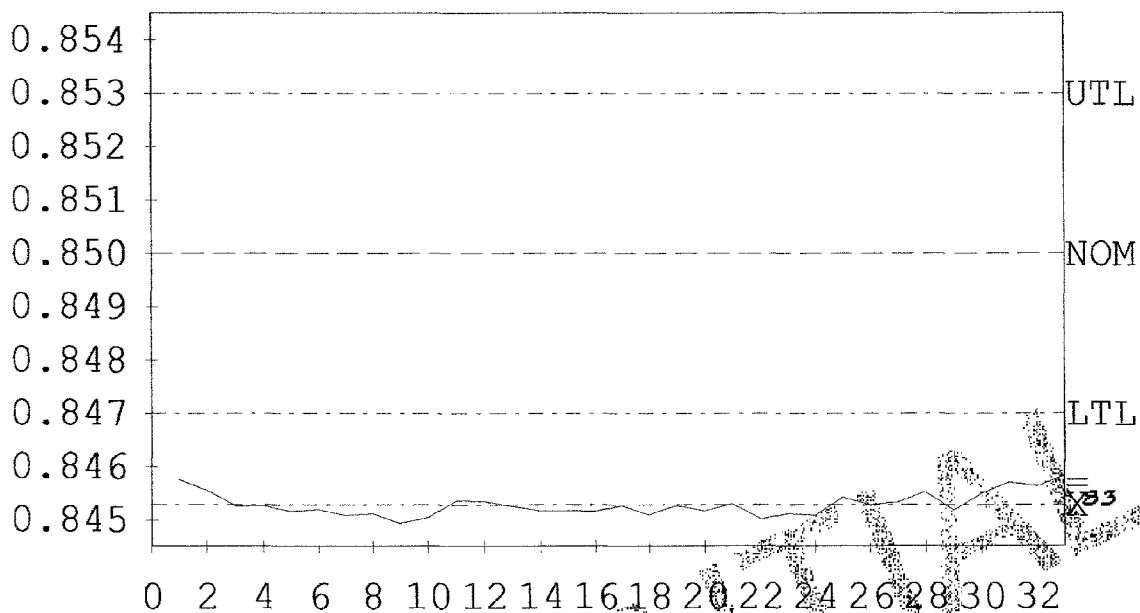
Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 3.76 Cpk -1.47

MF1572

RECEIVER INSERT\Hanson 600.job: XBar/R 1.- X

Cp 3.76 Cpk -1.47



MF1573

RECEIVER INSERT\Hanson 600.job: Histogram 1 - X

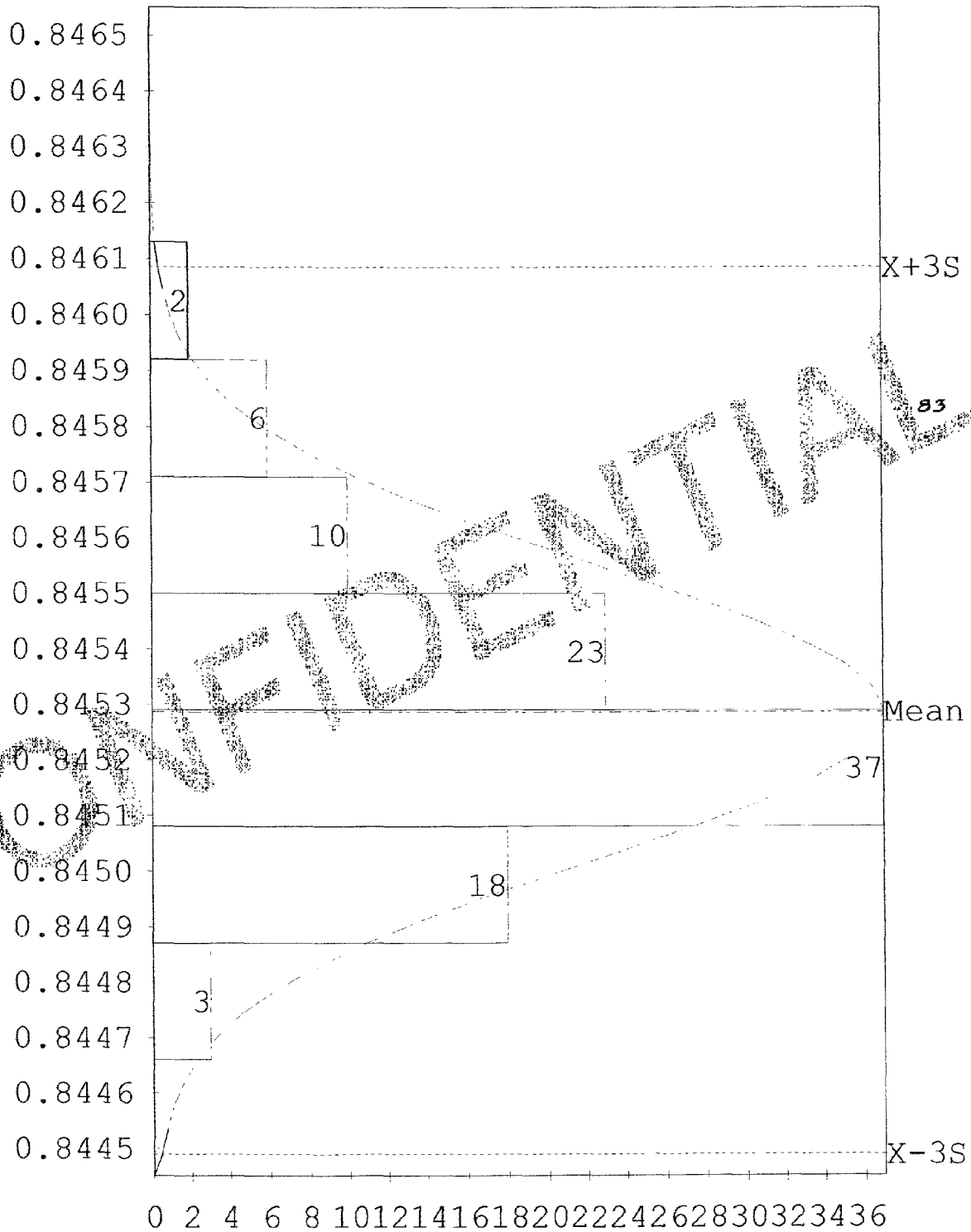
Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	DATUM D		
Feature number	01180		
NOM 0.8500	UTL 0.8530	LTL 0.8470	
Lot Size	99		
Mean	0.8453	Std Dev	0.0003
Mean+3S	0.8461	Mean-3S	0.8445
Skew	0.6665	Kurtosis	-0.0377
Minimum	0.8447	Maximum	0.8460
Range	0.0013	Avg Range	0.0004

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	99	100.0
Defectives Upper	0	0.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	29.01	17.27
QL	-6.44	-3.84
Cp	3.76	Cpk -1.47

MF1574

RECEIVER INSERT\Hanson 600.job: Histogram 1 - X
Cp 3.76 Cpk -1.47



MF1575

RECEIVER INSERT\Hanson 600.job: XBar/R 1 - Y

Part Program RECEIVER INSERT

Description Hanson 600

Feature name DATUM D

Feature number 01180

NOM -0.6210 UTL -0.6180 LTL -0.6240

Sample Set Size 3

of Sample Sets 33

Total 99

Mean Chart

R Chart

Central Line -0.6268

0.0003

UCL -0.6265

0.0007

LCL -0.6271

0.0000

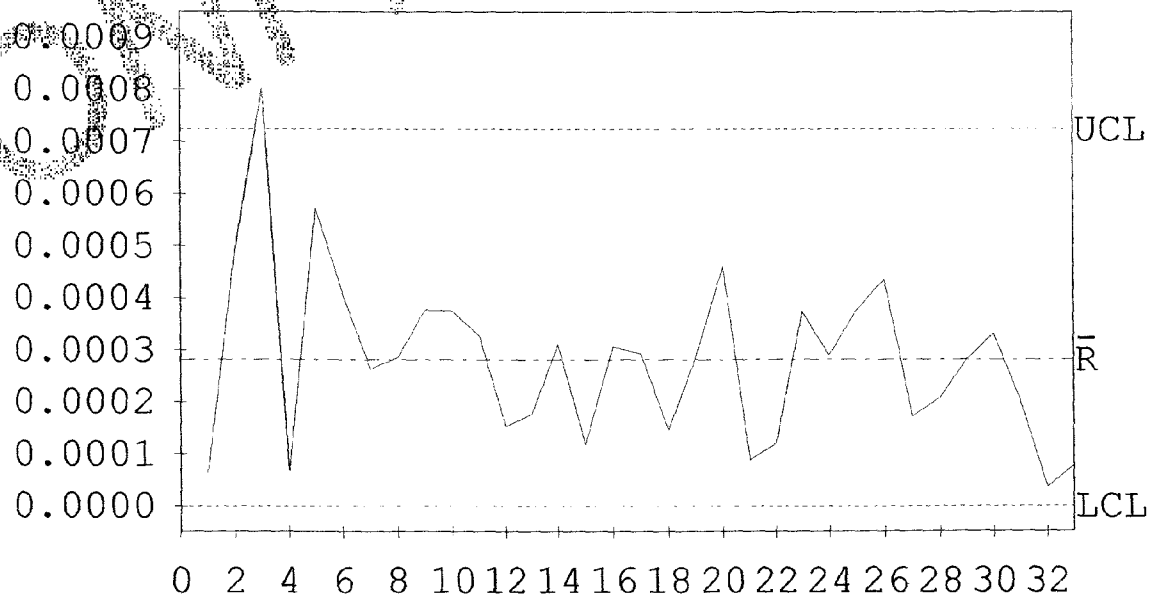
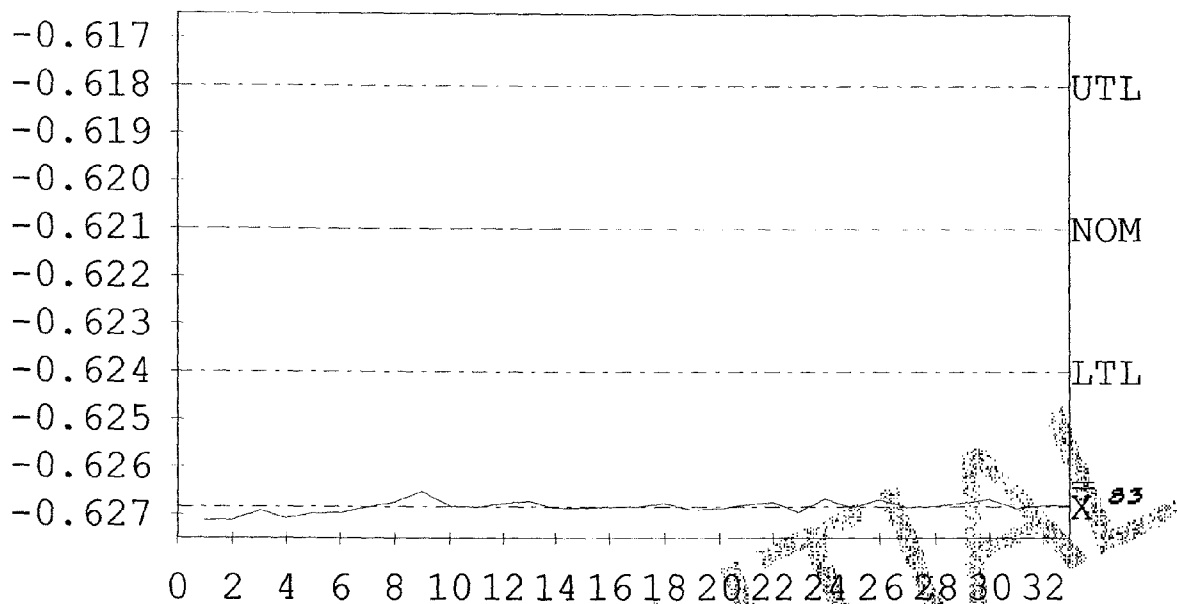
Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 5.40 Cpk -5.05

MF1576

RECEIVER INSERT\Hanson 600.job: XBar/R 1 - Y

Cp 5.40 Cpk -5.05



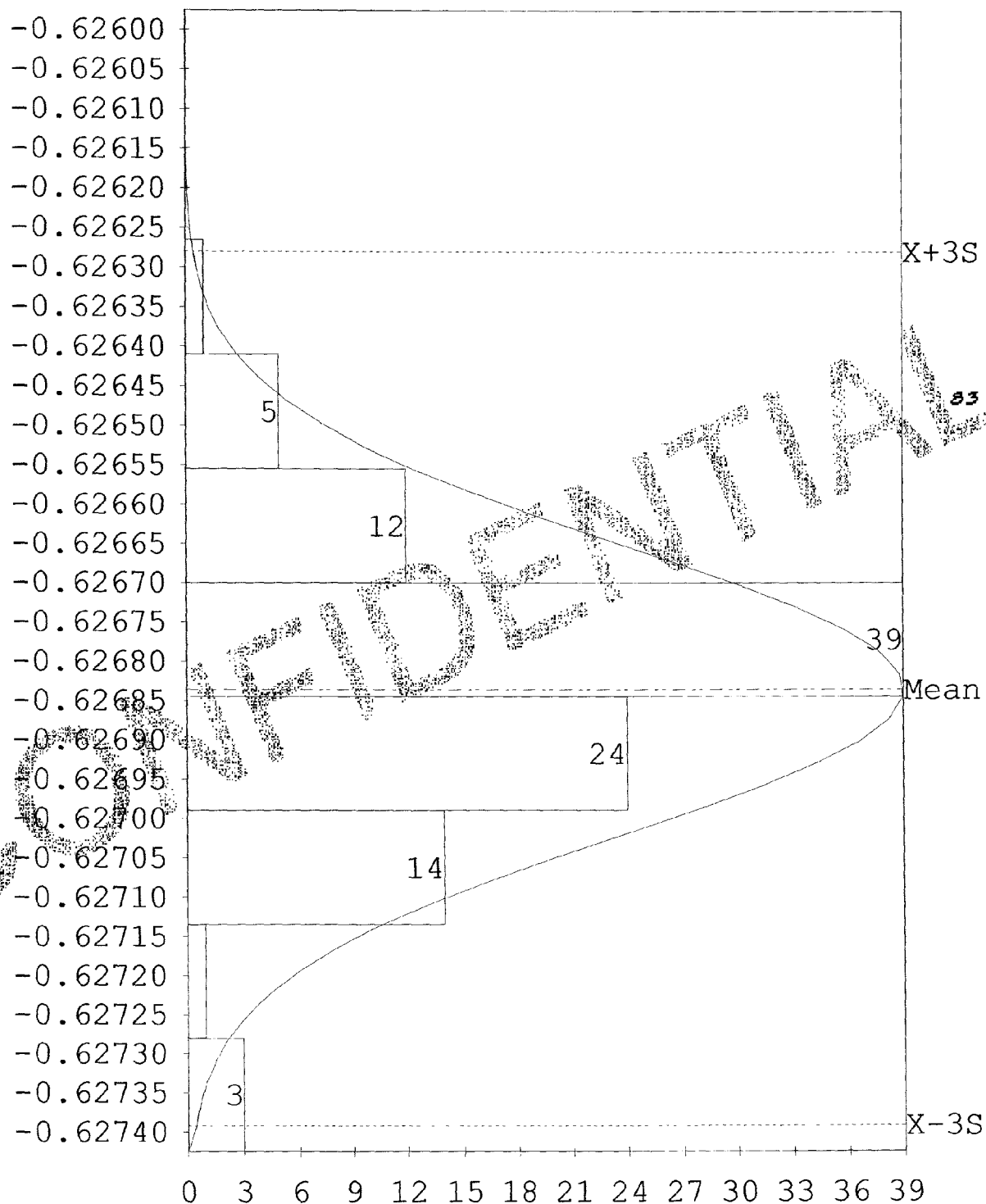
MF1577

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name DATUM D
 Feature number 01180
 NOM -0.6210 UTL -0.6180 LTL -0.6240
 Lot Size 99
 Mean -0.6268 Std Dev 0.0002
 Mean+3S -0.6263 Mean-3S -0.6274
 Skew -0.3129 Kurtosis 0.6807
 Minimum -0.6274 Maximum -0.6264
 Range 0.0010 Avg Range 0.0004

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	99	100.0
Defectives Upper	0	0.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	47.70	22.93
QL	-15.31	-7.36
Cp	5.40	
Cpk	-5.05	

RECEIVER INSERT\Hanson 600.job: Histogram 1 - Y
Cp 5.40 Cpk -5.05



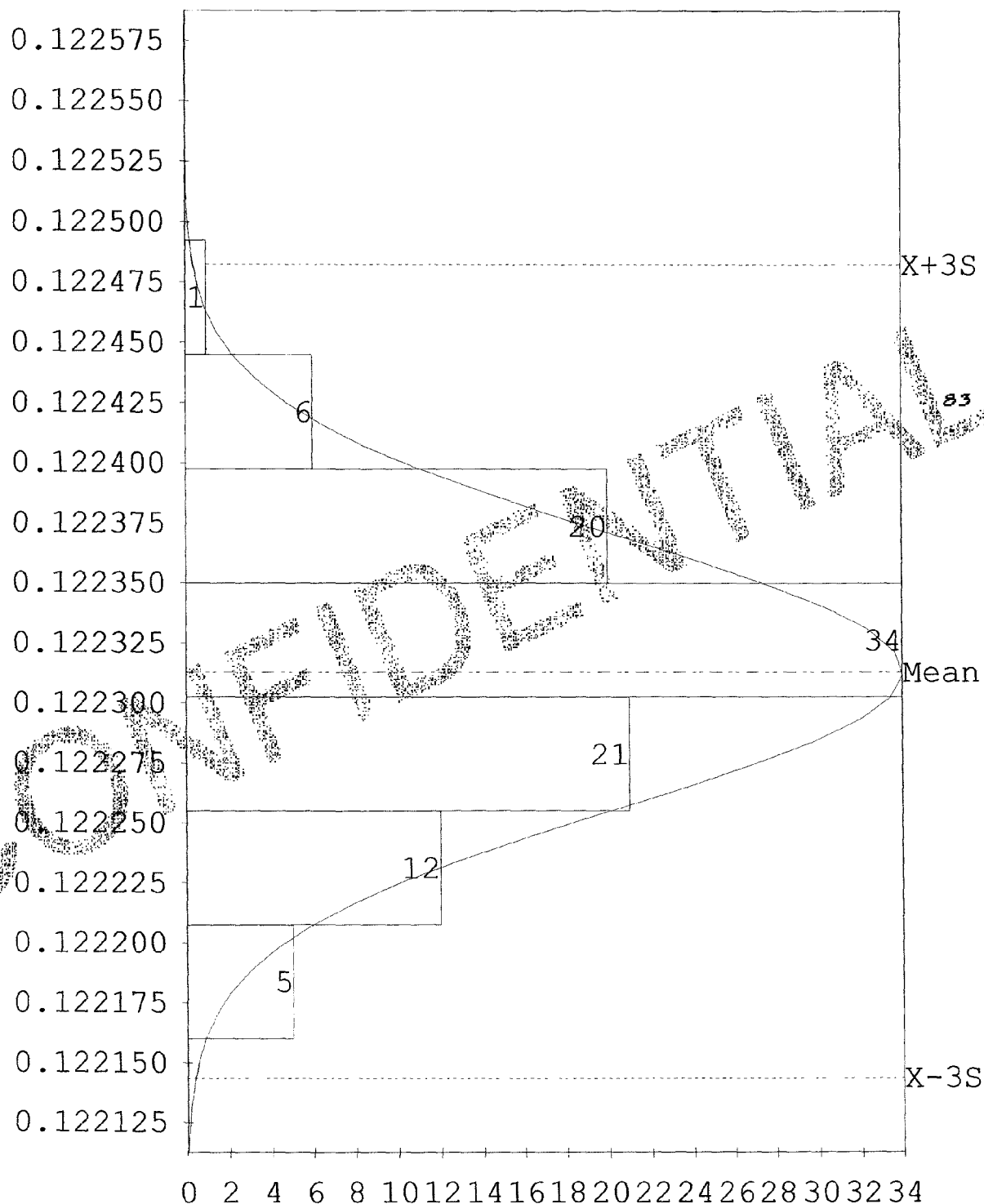
MF1579

Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	DATUM D		
Feature number	01180		
NOM 0.1220	UTL 0.1235	LTL 0.1205	
Lot Size	99		
Mean	0.1223	Std Dev	0.0001
Mean+3S	0.1225	Mean-3S	0.1221
Skew	-0.1060	Kurtosis	-0.0310
Minimum	0.1222	Maximum	0.1225
Range	0.0003	Avg Range	0.0001

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	21.02	11.76
QL	32.11	17.96
Cp	8.86	Cpk 6.68

RECEIVER INSERT\Hanson 600.job: Histogram 1 - DI
Cp 8.86 Cpk 6.68



MF1581

Part Program RECEIVER INSERT
Description Hanson 600
Feature name REAR SEAR
Feature number 01181

NOM -1.4280 UTL -1.4250 LTL -1.4310

Sample Set Size 3

of Sample Sets 33

Total 99

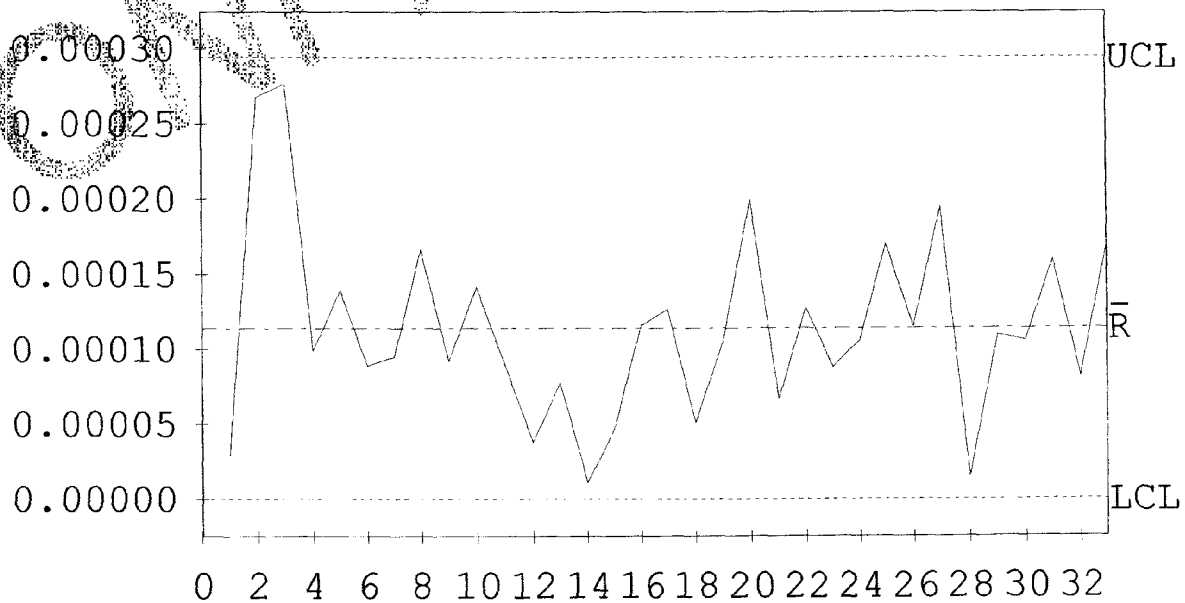
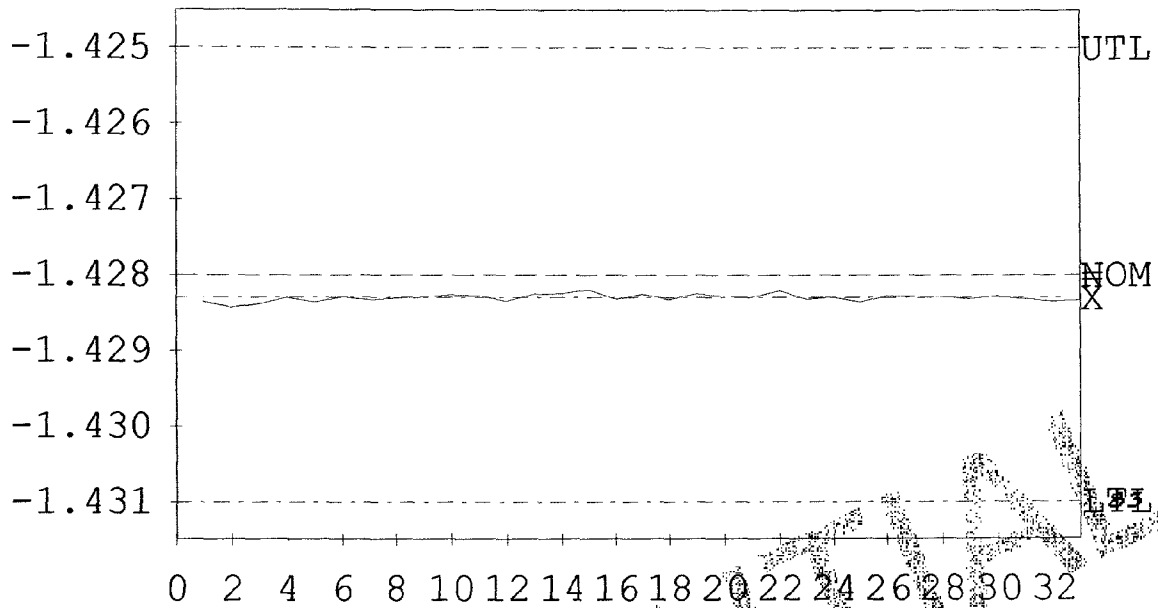
	Mean Chart	R Chart
Central Line	-1.4283	0.0001
UCL	-1.4282	0.0003
LCL	-1.4284	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 13.64 Cpk 12.10

RECEIVER INSERT\Hanson 600.job: XBar/R 2 - X

Cp 13.64 Cpk 12.10



MF1583

RECEIVER INSERT\Hanson 600.job: Histogram 2 - X

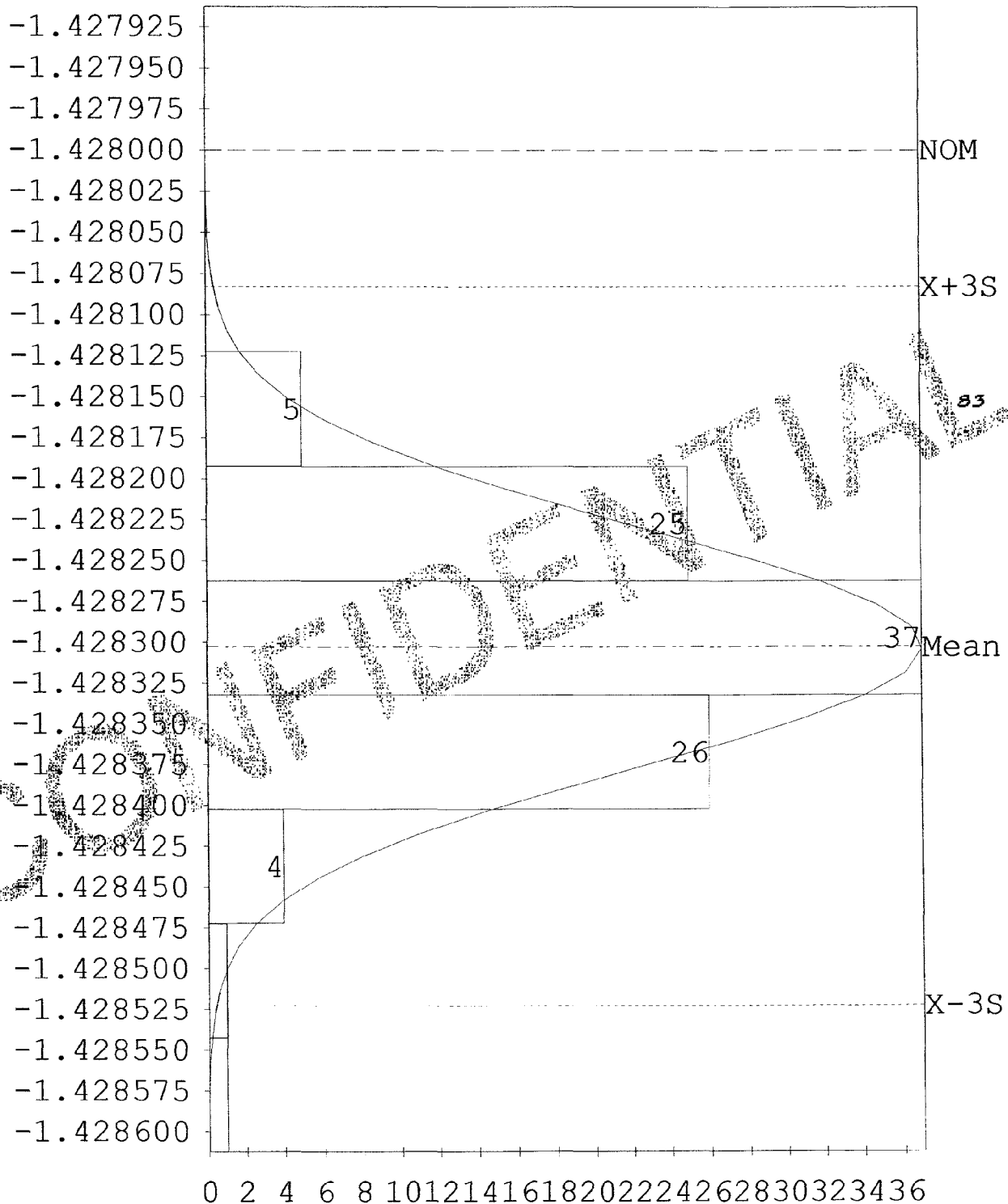
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name REAR SEAR
 Feature number 01181
 NOM -1.4280 UTL -1.4250 LTL -1.4310
 Lot Size 99
 Mean -1.4283 Std Dev 0.0001
 Mean+3S -1.4281 Mean-3S -1.4285
 Skew -0.6460 Kurtosis -253.3824
 Minimum -1.4286 Maximum -1.4282
 Range 0.0004 Avg Range 0.0002

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	45.06	21.26
QL	36.80	17.36
Cp	13.64	Cpk 12.10

MF1584

RECEIVER INSERT\Hanson 600.job: Histogram 2 - X
Cp 13.64 Cpk 12.10



MF1585

Part Program RECEIVER INSERT
Description Hanson 600
Feature name REAR SEAR
Feature number 01181
NOM 0.0000 UTL 0.0030 LTL -0.0030
Sample Set Size 3
of Sample Sets 33
Total 99

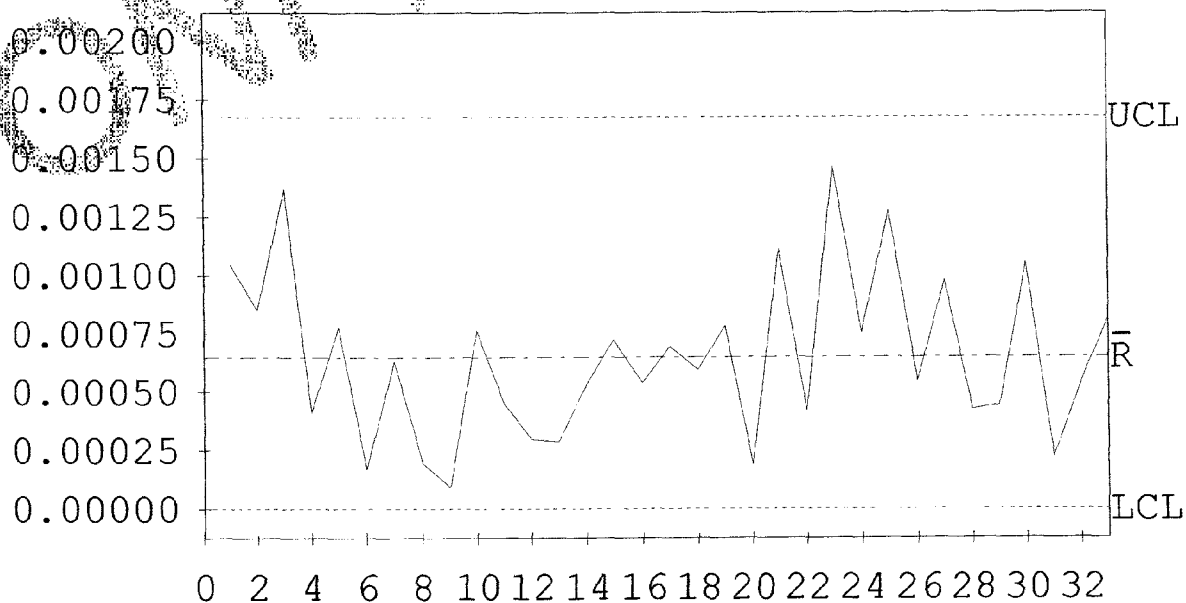
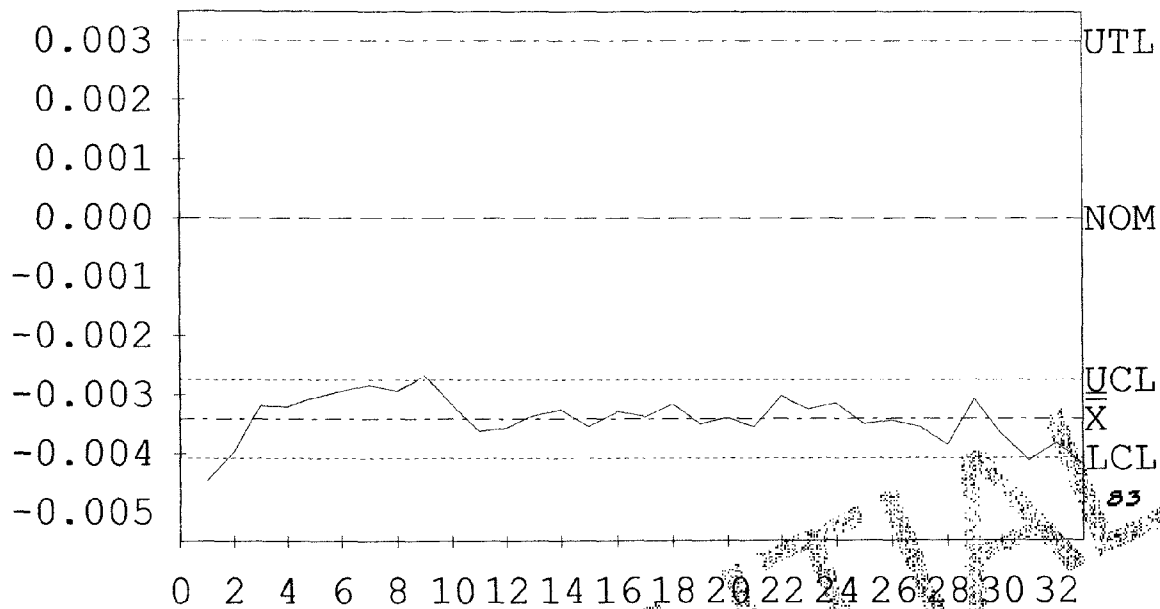
Mean Chart R Chart
Central Line -0.0034 0.0007
UCL -0.0027 0.0017
LCL -0.0041 0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.96 Cpk -0.78

RECEIVER INSERT\Hanson 600.job: XBar/R 2 - Y

Cp 1.96 Cpk -0.78



MF1587

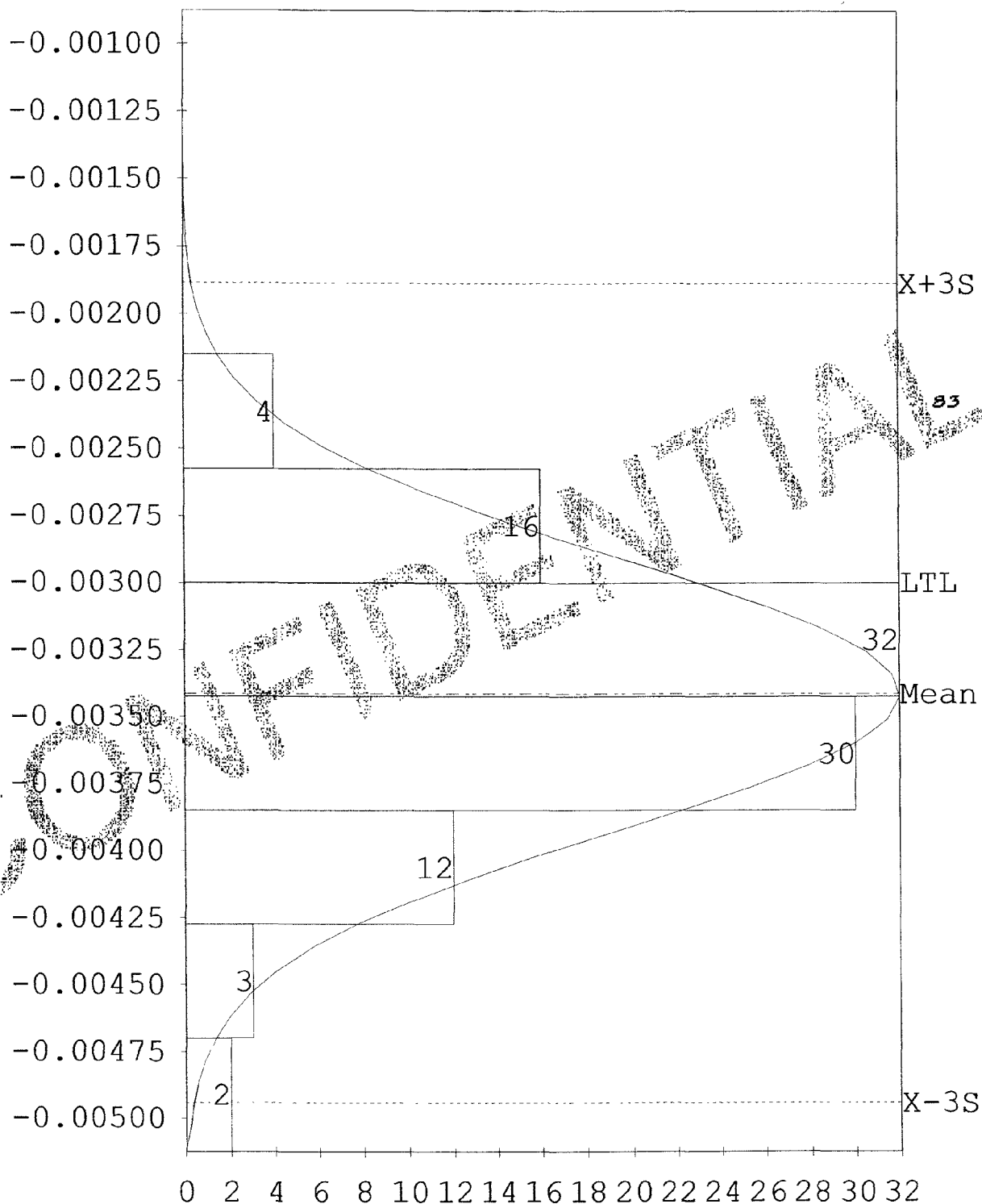
Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	REAR SEAR		
Feature number	01181		
NOM 0.0000	UTL 0.0030	LTL -0.0030	
Lot Size	99		
Mean	-0.0034	Std Dev	0.0005
Mean+3S	-0.0019	Mean-3S	-0.0049
Skew	-0.3895	Kurtosis	-0.0491
Minimum	-0.0049	Maximum	-0.0024
Range	0.0025	Avg Range	0.0009

	Number	Percent
Acceptable Parts	20	20.2
Defectives Lower	79	79.8
Defectives Upper	0	0.0
Defectives Total	79	79.8

	Deviation Method	Range Method
QU	12.59	7.05
QL	-0.81	-0.45
Cp	1.96	Cpk -0.78

MF1588

RECEIVER INSERT\Hanson 600.job: Histogram 2 - Y
Cp 1.96 Cpk -0.78



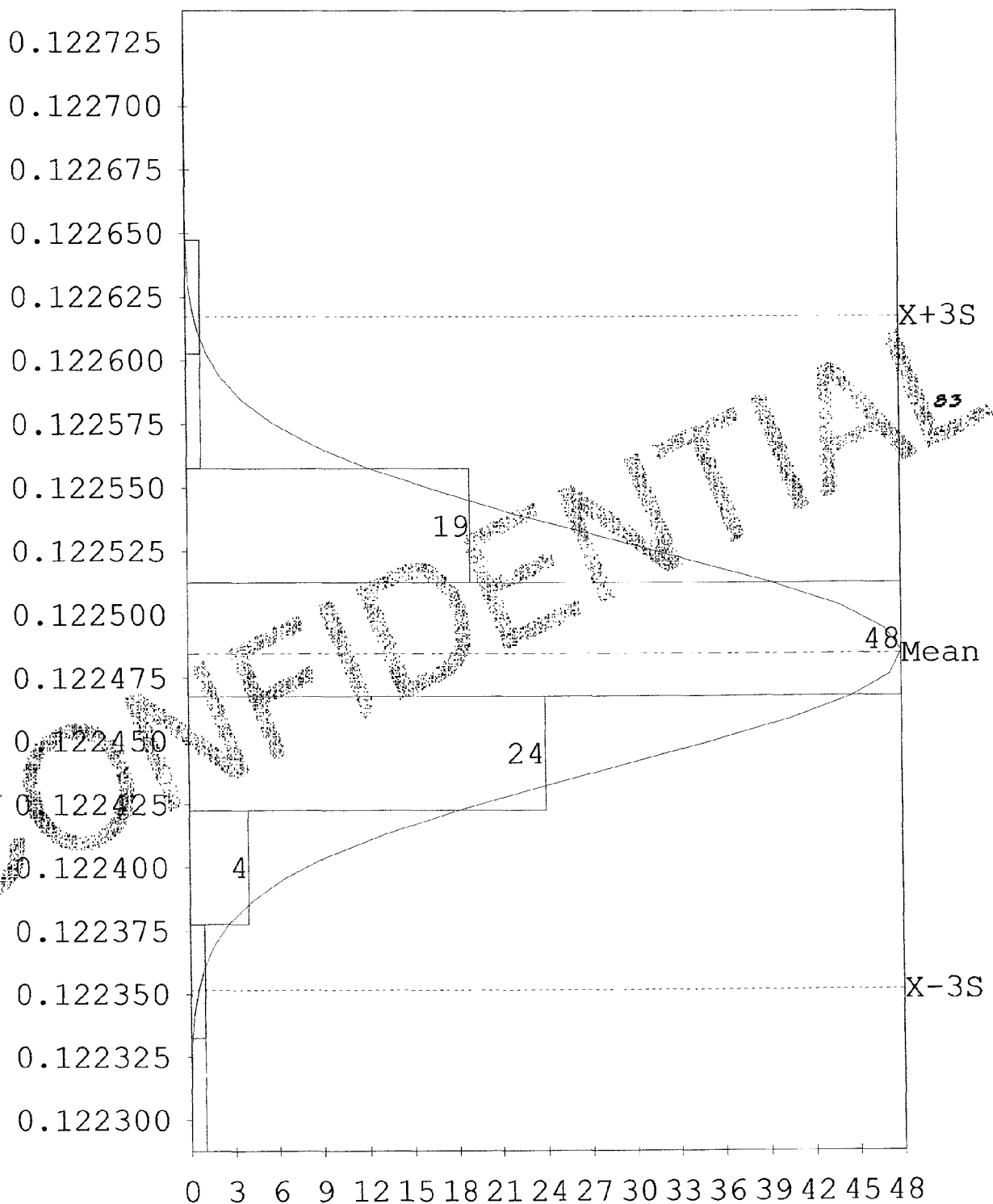
MF1589

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name REAR SEAR
 Feature number 01181
 NOM 0.1220 UTL 0.1235 LTL 0.1205
 Lot Size 99
 Mean 0.1225 Std Dev 0.0000
 Mean+3S 0.1226 Mean-3S 0.1224
 Skew -0.9521 Kurtosis 3.4024
 Minimum 0.1223 Maximum 0.1226
 Range 0.0003 Avg Range 0.0001

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	22.93	11.20
QL	44.81	21.88
Cp	11.29	Cpk 7.71

RECEIVER INSERT\Hanson.600.job: Histogram 2 - DI
Cp 11.29 Cpk 7.71



MF1591

Part Program RECEIVER INSERT
Description Hanson 600
Feature name ENGAGEMENT
Feature number 01182
NOM -0.8670 UTL -0.8620 LTL -0.8720
Sample Set Size 3
of Sample Sets 33
Total 99

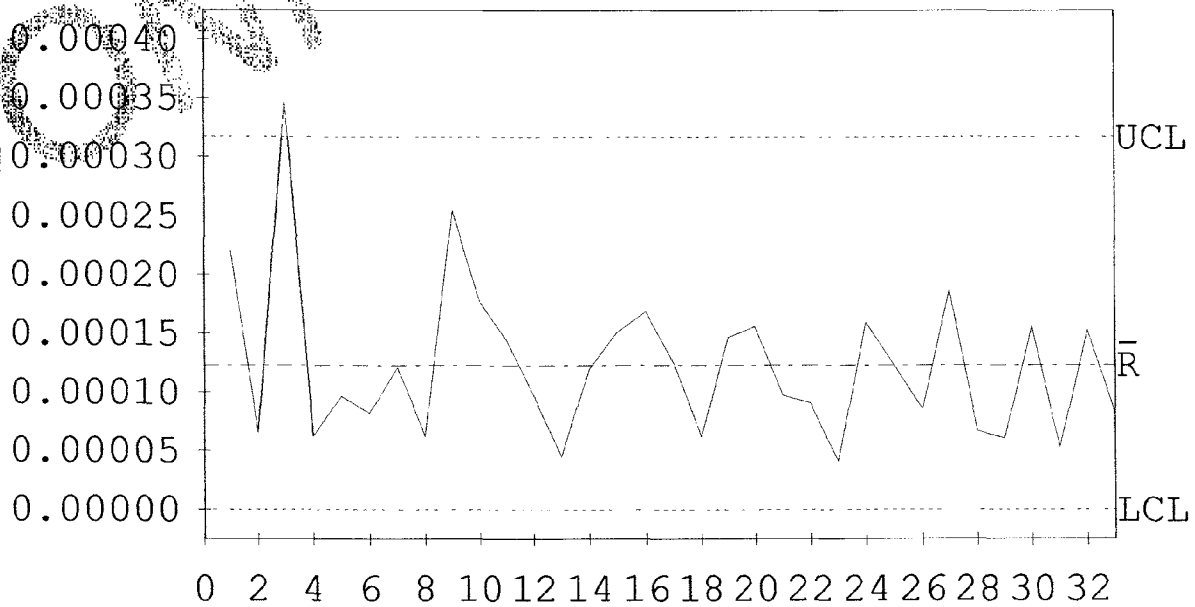
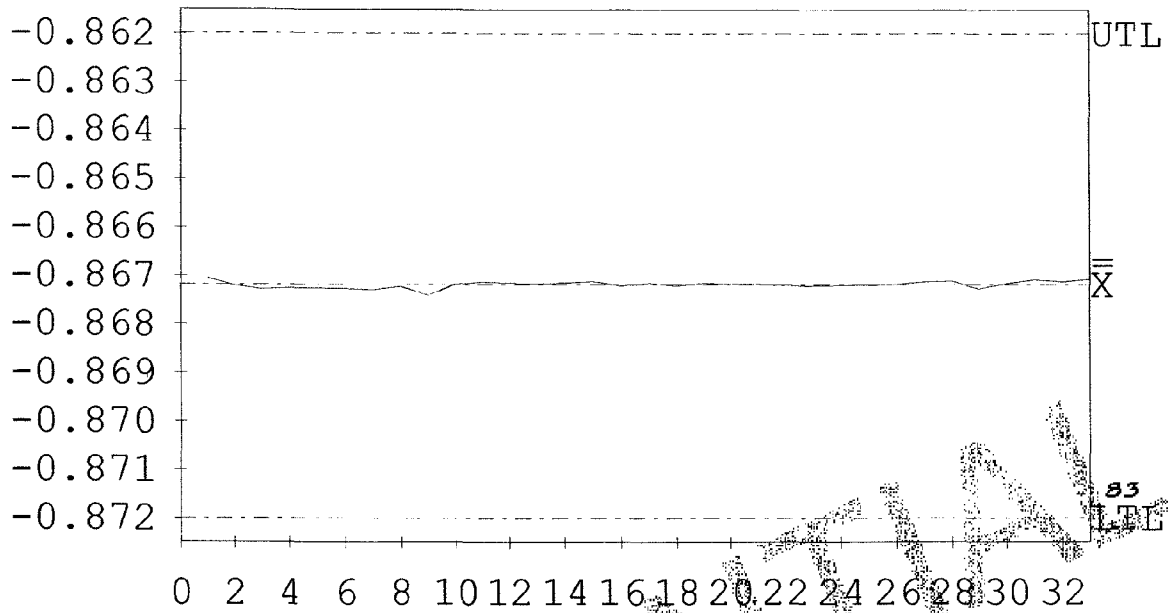
	Mean Chart	R Chart
Central Line	-0.8672	0.0001
UCL	-0.8671	0.0003
LCL	-0.8673	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 18.32 Cpk 18.05

RECEIVER INSERT\Hanson 600.job: XBar/R 3 - X

Cp 18.32 Cpk 18.05



MF1593

RECEIVER INSERT\Hanson 600.job: Histogram 3 - X

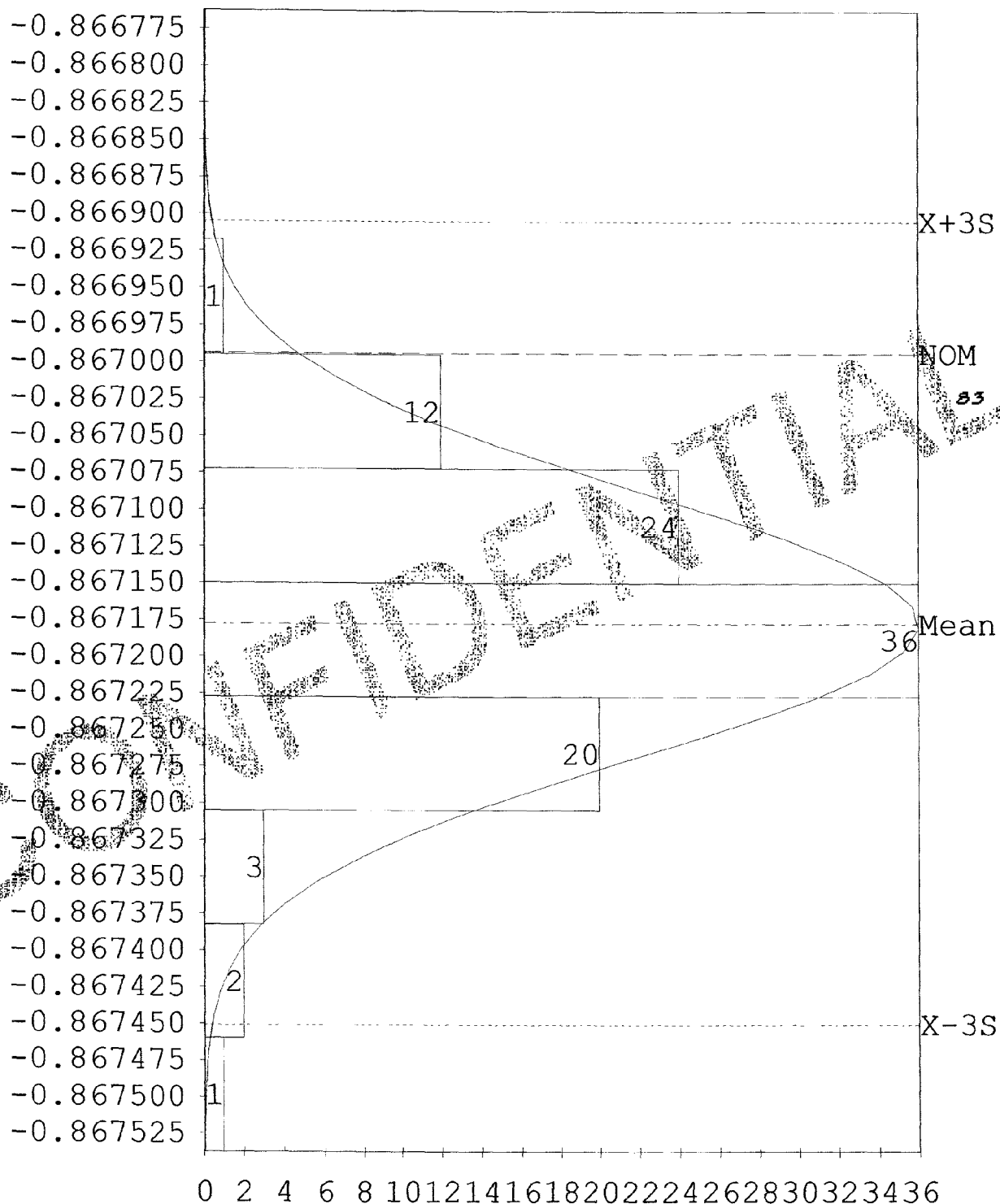
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name ENGAGEMENT
 Feature number 01182
 NOM -0.8670 UTL -0.8620 LTL -0.8720
 Lot Size 99
 Mean -0.8672 Std Dev 0.0001
 Mean+3S -0.8669 Mean-3S -0.8675
 Skew -0.5474 Kurtosis -7.0417
 Minimum -0.8675 Maximum -0.8670
 Range 0.0005 Avg Range 0.0002

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	56.99	30.31
QL	52.95	28.16
Cp	18.32	Cpk 18.05

MF1594

RECEIVER INSERT\Hanson 600.job: Histogram 3 - X
 Cp 18.32 Cpk 18.05



MF1595

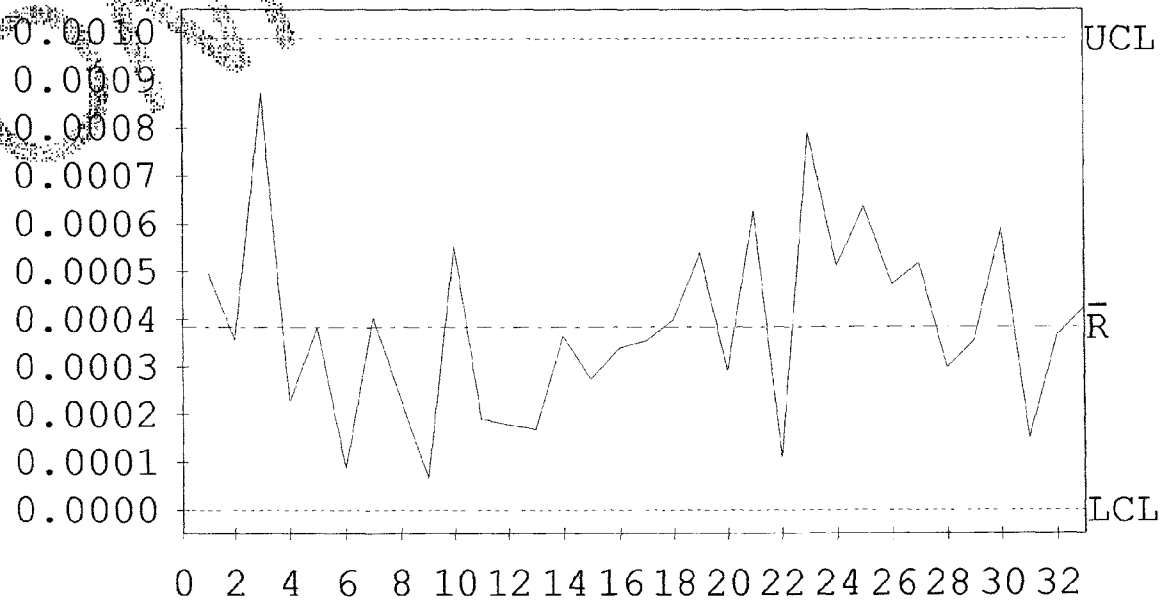
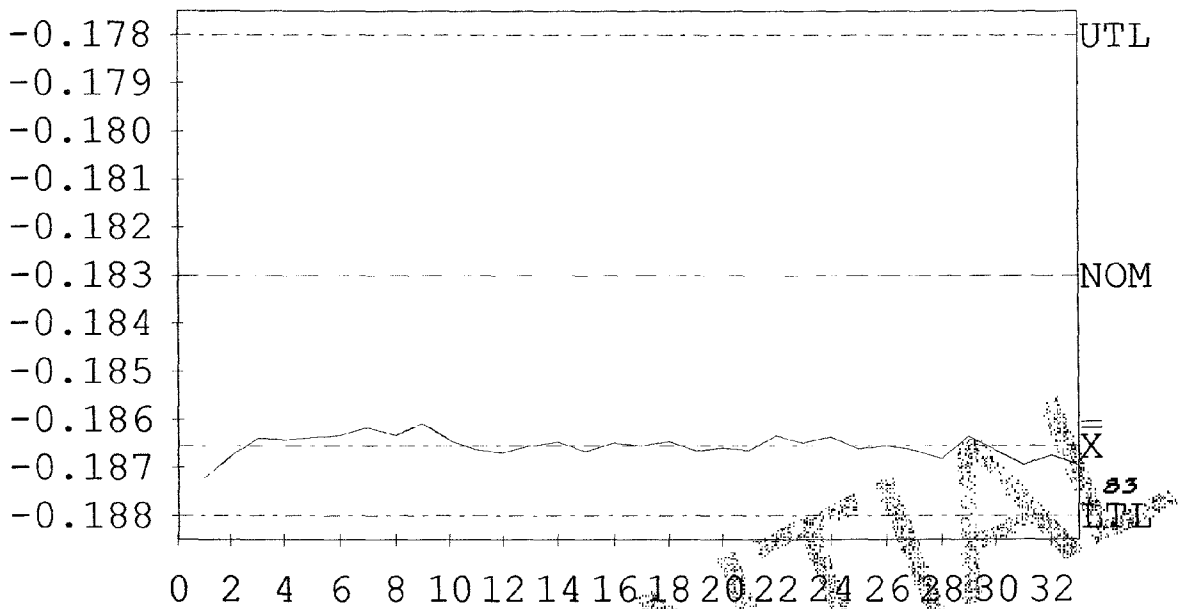
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name ENGAGEMENT
 Feature number 01182
 NOM -0.1830 UTL -0.1780 LTL -0.1880
 Sample Set Size 3
 # of Sample Sets 33
 Total 99

	Mean Chart	R Chart
Central Line	-0.1865	0.0004
UCL	-0.1862	0.0010
LCL	-0.1869	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 5.71 Cpk 1.20

RECEIVER INSERT\Hanson 600.job: XBar/R 3 - Y
Cp 5.71 Cpk 1.20



MF1597

RECEIVER INSERT\Hanson 600.job: Histogram .3 - Y

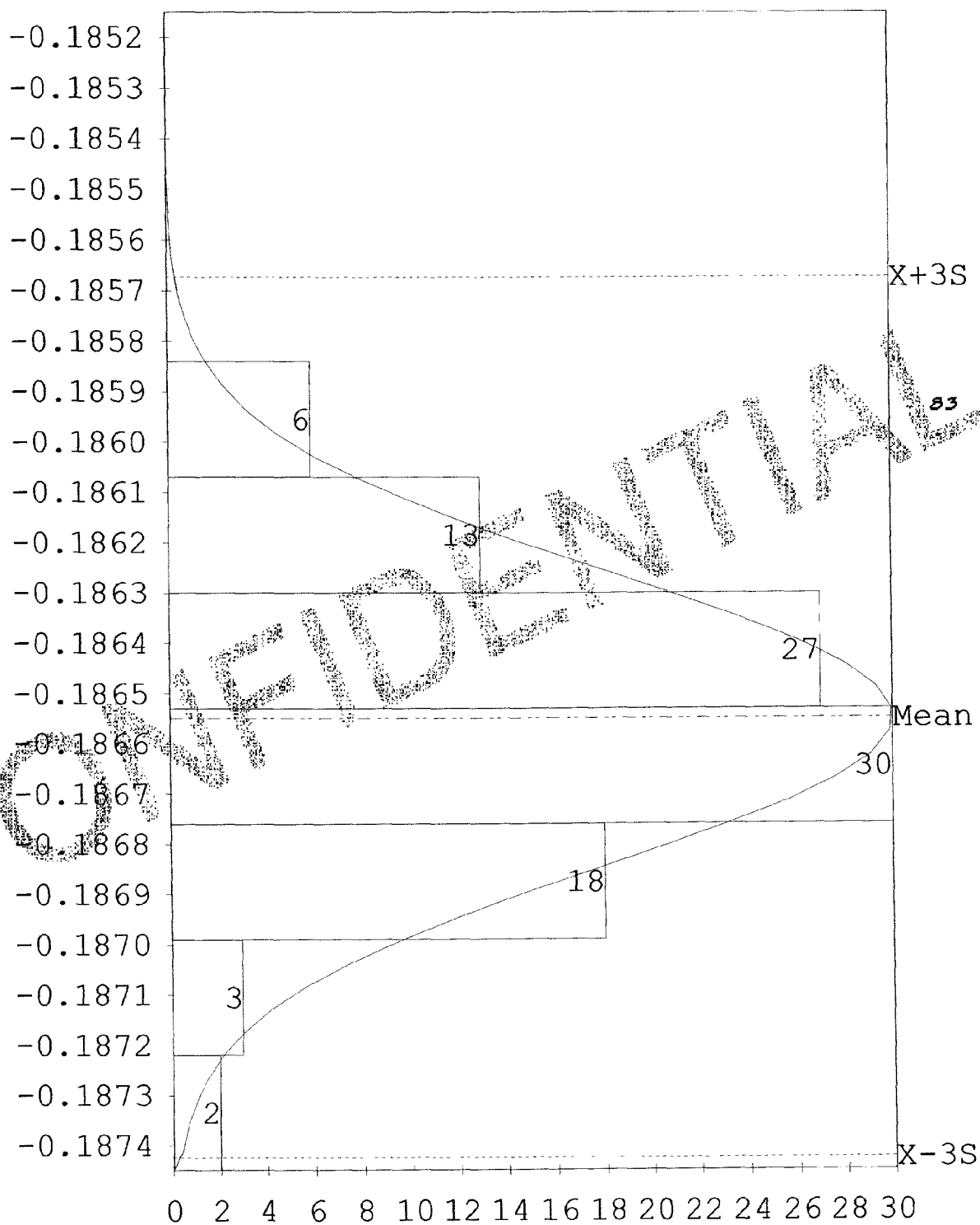
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name ENGAGEMENT
 Feature number 01182
 NOM -0.1830 UTL -0.1780 LTL -0.1880
 Lot Size 99
 Mean -0.1865 Std Dev 0.0003
 Mean+3S -0.1857 Mean-3S -0.1874
 Skew -0.2335 Kurtosis 0.0009
 Minimum -0.1874 Maximum -0.1859
 Range 0.0015 Avg Range 0.0005

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	29.28	15.79
QL	4.97	2.68
Cp	5.71	Cpk 1.20

MF1598

RECEIVER INSERT\Hanson 600.job: Histogram 3 - Y
Cp 5.71 Cpk 1.20



MF1599

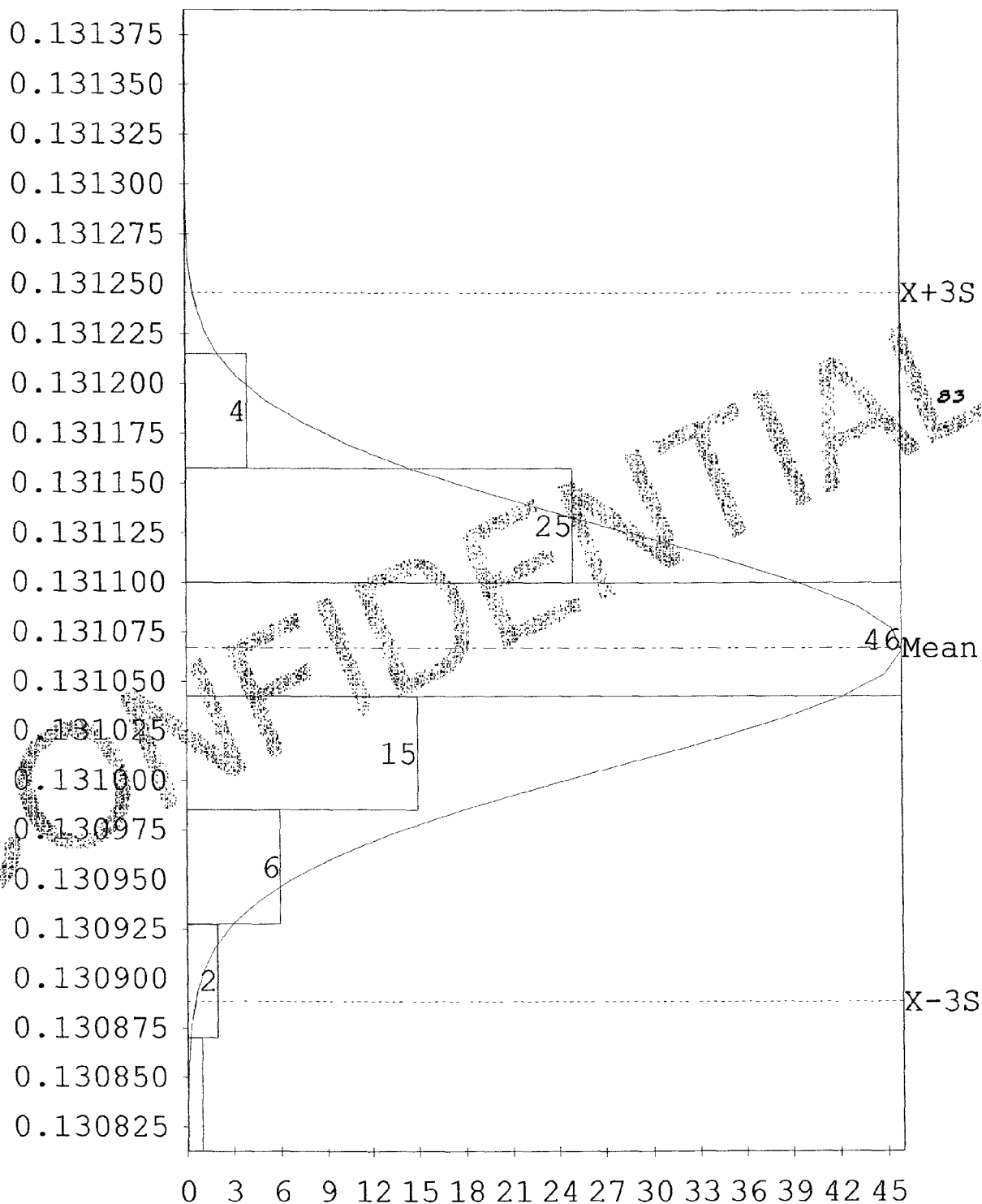
Confidential - Subject to Protective Order
Williams v. Remington

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name ENGAGEMENT
 Feature number 01182
 NOM 0.1270 UTL 0.1320 LTL 0.1220
 Lot Size 99
 Mean 0.1311 Std Dev 0.0001
 Mean+3S 0.1312 Mean-3S 0.1309
 Skew -1.1686 Kurtosis 2.8793
 Minimum 0.1308 Maximum 0.1312
 Range 0.0004 Avg Range 0.0001

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	15.67	7.90
QL	152.26	76.77
Cp	27.99	Cpk 5.06

RECEIVER INSERT\Hanson 600.job: Histogram 3 - DI
Cp 27.99 Cpk 5.06



MF1601

Part Program RECEIVER INSERT
Description Hanson 600
Feature name SAFETY PIVOT

Feature number

NOM -1.3060 UTL -1.3040 LTL -1.3080

Sample Set Size 3

of Sample Sets 33

Total 99

Mean Chart

R Chart

Central Line -1.3071 0.0003

UCL -1.3067 0.0008

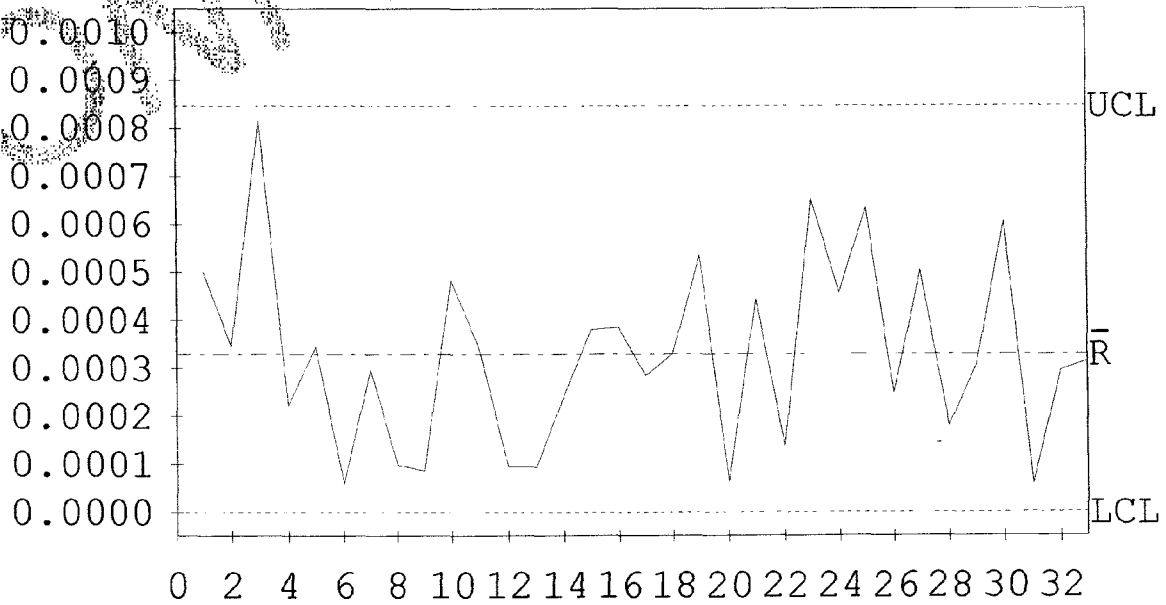
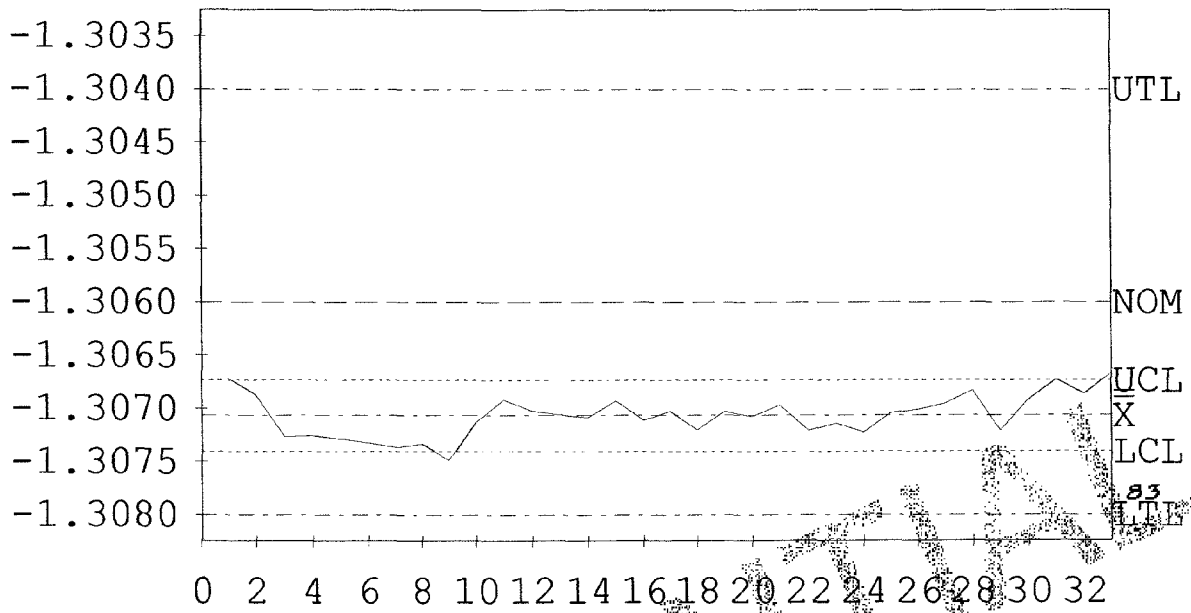
LCL -1.3074 0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 2.62 Cpk 1.75

RECEIVER INSERT\Hanson 600.job: XBar/R .4 - X

Cp 2.62 Cpk 1.75



MF1603

RECEIVER INSERT\Hanson 600.job: Histogram 4 - X

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name SAFETY PIVOT

Feature number

NOM -1.3060 UTL -1.3040 LTL -1.3080

Lot Size 99

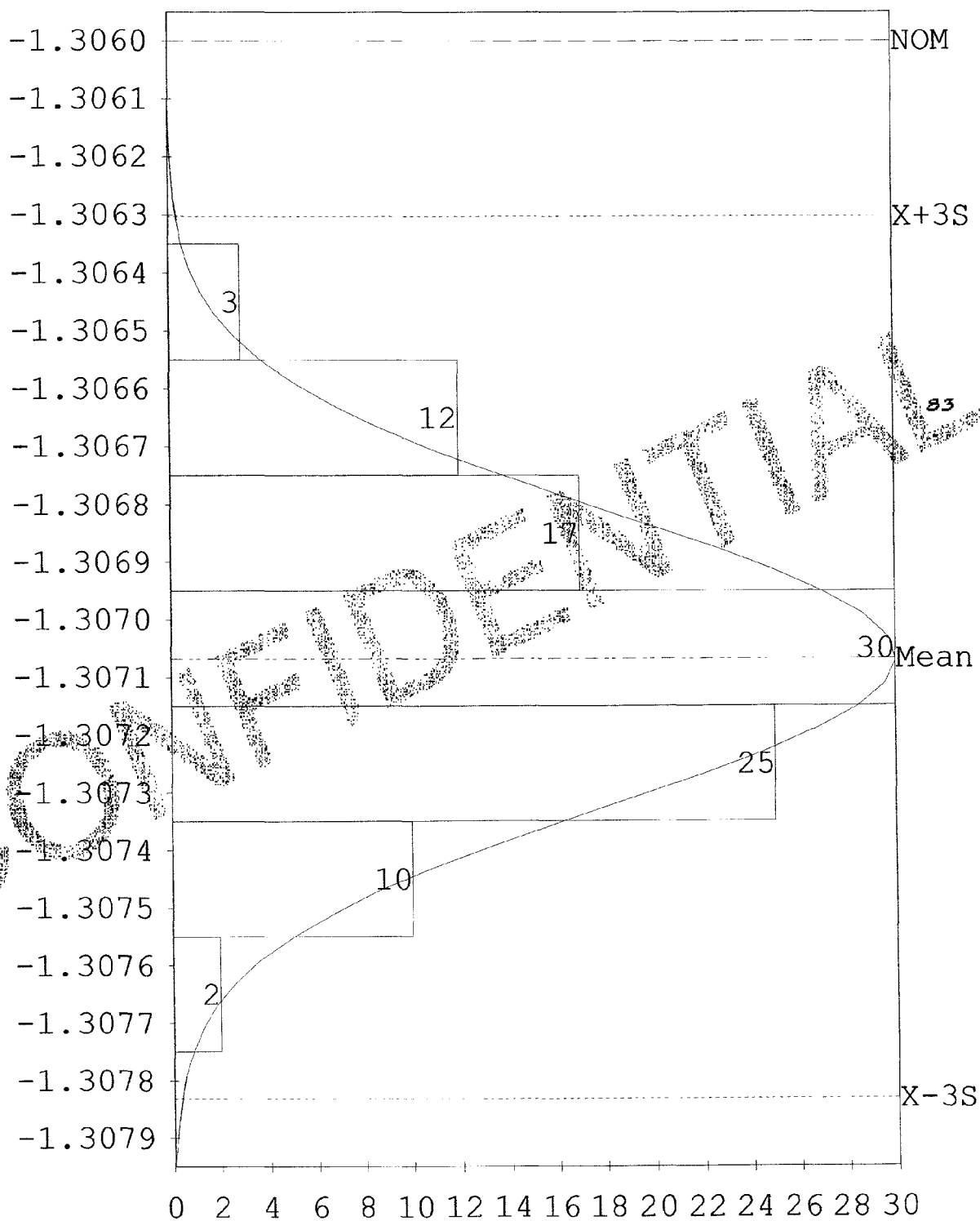
Mean	-1.3071	Std Dev	0.0003
Mean+3S	-1.3063	Mean-3S	-1.3078
Skew	0.0248	Kurtosis	-0.4641
Minimum	-1.3077	Maximum	-1.3065
Range	0.0012	Avg Range	0.0005

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	12.04	6.53
QL	3.66	1.99
Cp	2.62	Cpk 1.75

MF1604

RECEIVER INSERT\Hanson 600.job: Histogram 4 - X
Cp 2.62 Cpk 1.75



MF1605

Part Program RECEIVER INSERT
Description Hanson 600
Feature name SAFETY PIVOT
Feature number

NOM -0.6500 UTL -0.6480 LTL -0.6520

Sample Set Size 3
of Sample Sets 33
Total 99

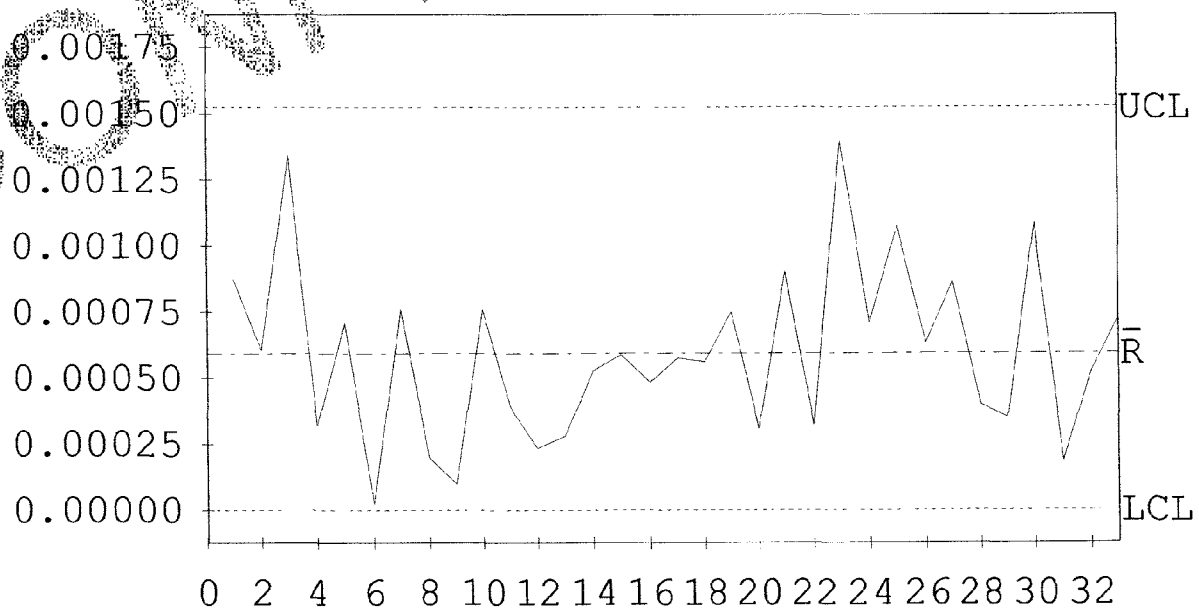
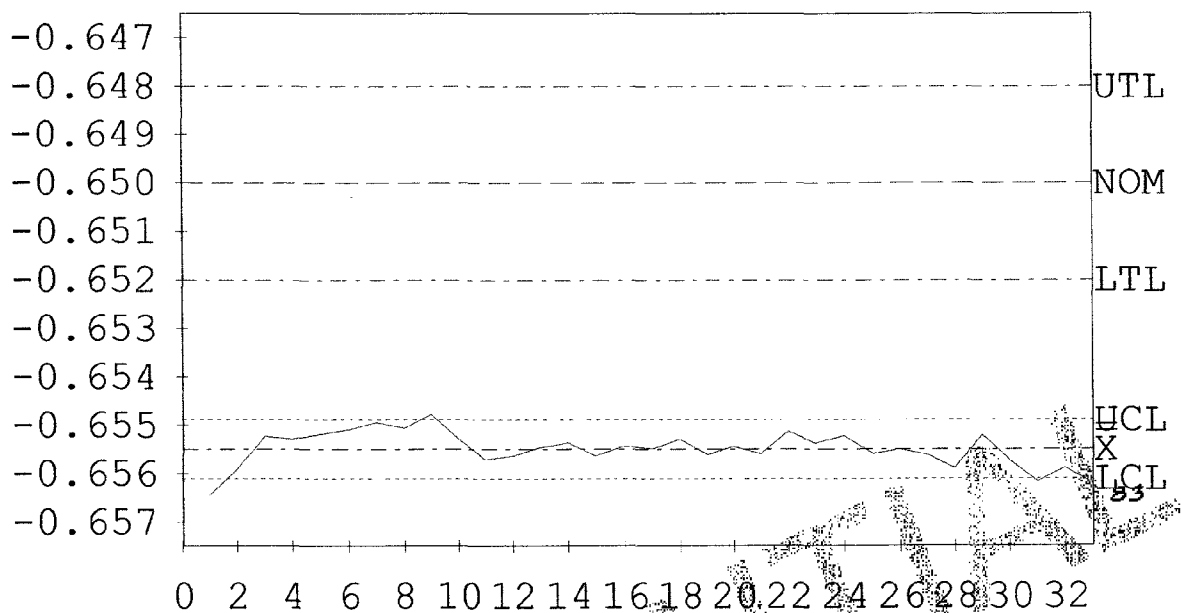
	Mean Chart	R Chart
Central Line	-0.6555	0.0006
UCL	-0.6549	0.0015
LCL	-0.6561	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.44 Cpk -3.03

RECEIVER INSERT\Hanson 600..job: XBar/R 4 - Y

Cp 1.44 Cpk -3.03



MF1607

RECEIVER INSERT\Hanson 600.job: Histogram 4 - Y

Part Program RECEIVER INSERT
Description Hanson 600
Feature name SAFETY PIVOT

Feature number

NOM -0.6500 UTL -0.6480 LTL -0.6520

Lot Size 99

Mean	-0.6555	Std Dev	0.0005
Mean+3S	-0.6541	Mean-3S	-0.6569
Skew	-0.2669	Kurtosis	-0.0818
Minimum	-0.6568	Maximum	-0.6545
Range	0.0023	Avg Range	0.0008

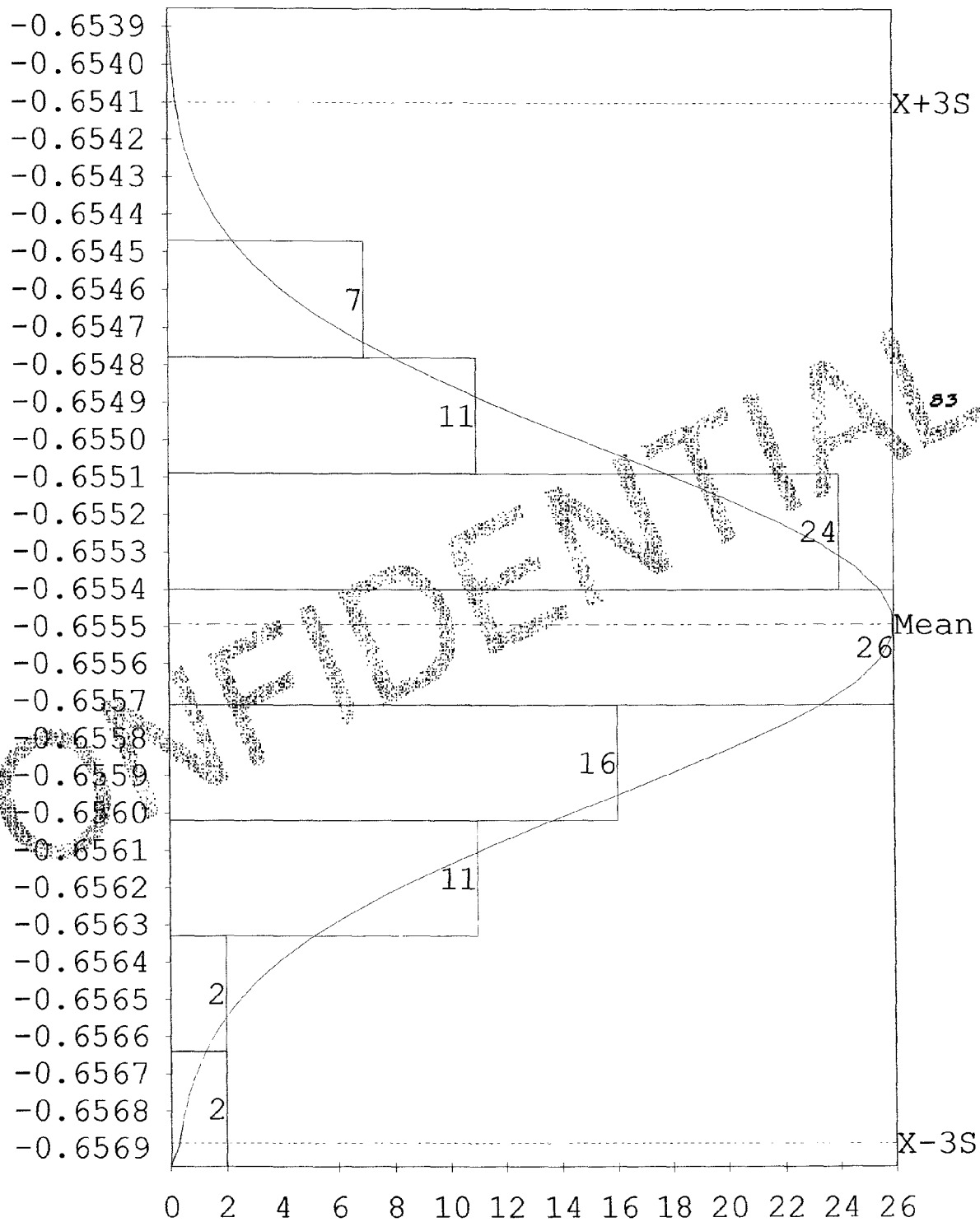
	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	99	100.0
Defectives Upper	0	0.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	16.14	8.94
QL	-7.52	-4.17

Cp 1.44 Cpk -3.03

MF1608

RECEIVER INSERT\Hanson 600.job: Histogram 4 - Y
Cp 1.44 Cpk -3.03



MF1609

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name SAFETY PIVOT

Feature number

NOM 0.1220 UTL 0.1235 LTL 0.1205

Lot Size 99

Mean 0.1238 Std Dev 0.0000

Mean+3S 0.1239 Mean-3S 0.1237

Skew -0.2676 Kurtosis 0.8083

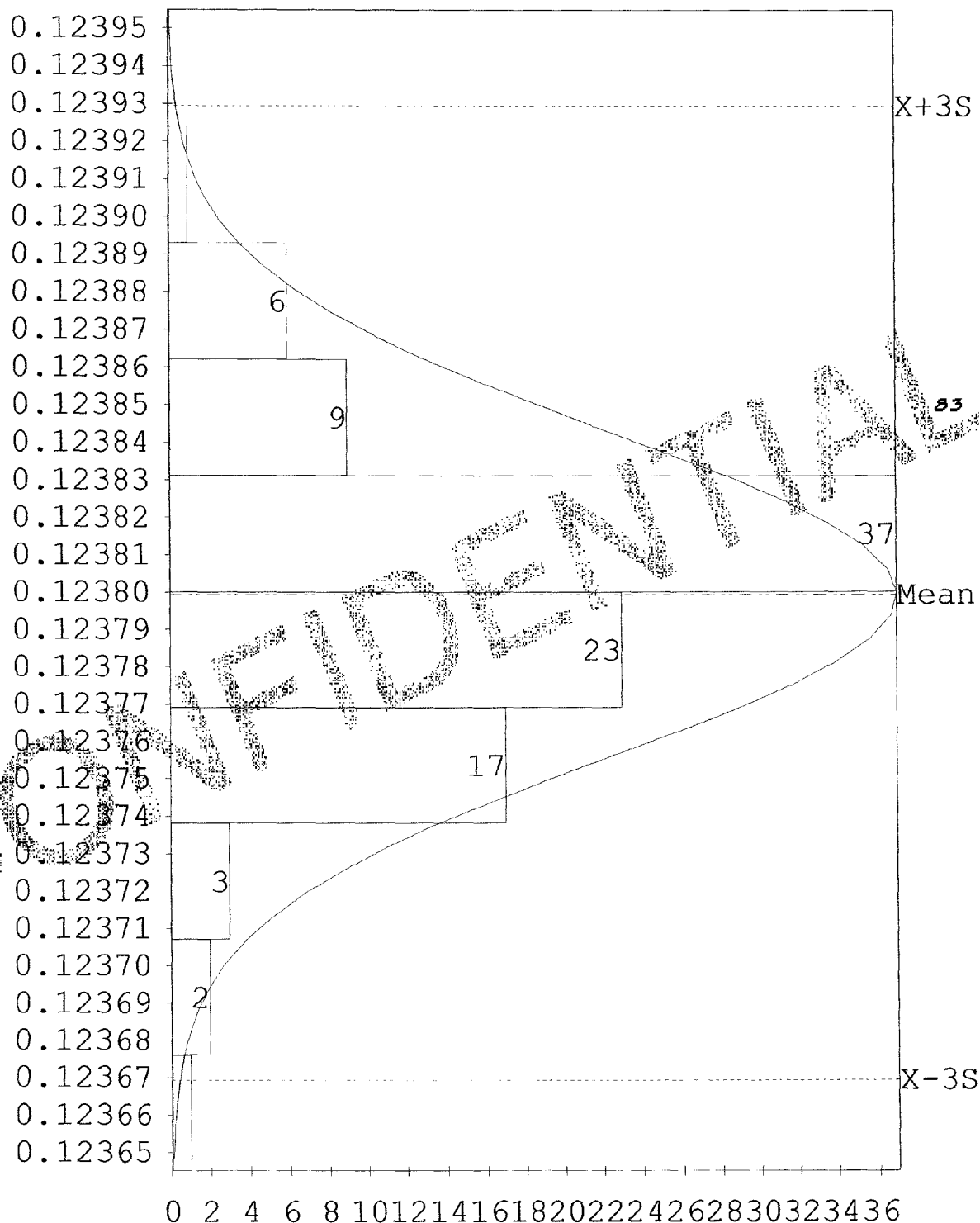
Minimum 0.1236 Maximum 0.1239

Range 0.0002 Avg Range 0.0001

	Number	Percent
Acceptable		
Parts	0	0.0
Defectives		
Lower	0	0.0
Defectives		
Upper	99	100.0
Defectives		
Total	99	100.0

	Deviation	Method	Range	Method
QU	-6.91		-3.13	
QL	76.13		34.54	
Cp	11.54	Cpk	-2.38	

RECEIVER INSERT\Hanson 600.job: Histogram 4 - DI
Cp 11.54 Cpk -2.38



MF1611

Part Program RECEIVER INSERT
Description Hanson 600
Feature name TRIGGER PIVOT
Feature number T

NOM -0.8400 UTL -0.8380 LTL -0.8420

Sample Set Size 3
of Sample Sets 33
Total 99

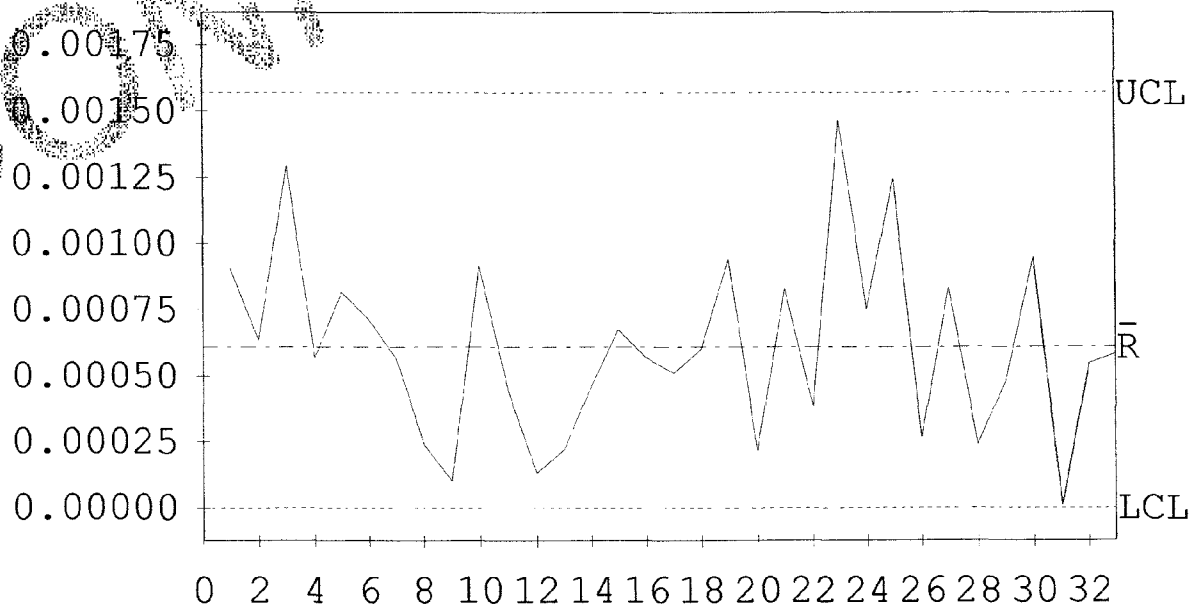
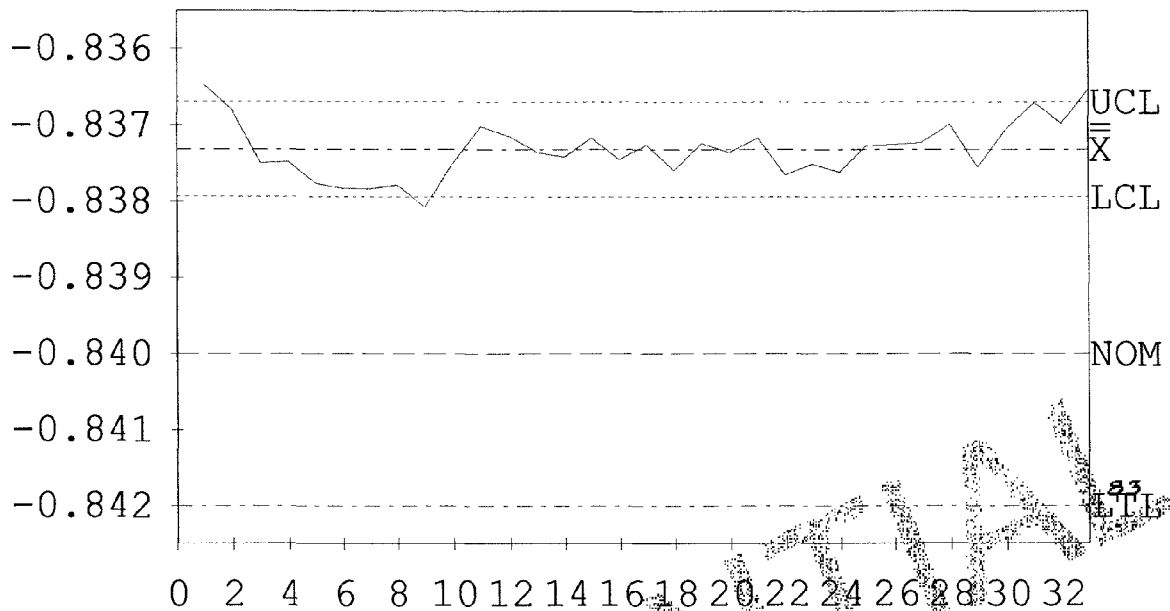
	Mean Chart	R Chart
Central Line	-0.8373	0.0006
UCL	-0.8367	0.0016
LCL	-0.8379	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.40 Cpk -1.04

RECEIVER INSERT\Hanson 600.job: XBar/R . 5 - X

Cp 1.40 Cpk -1.04



MF1613

RECEIVER INSERT\Hanson 600.job: Histogram 5 - X

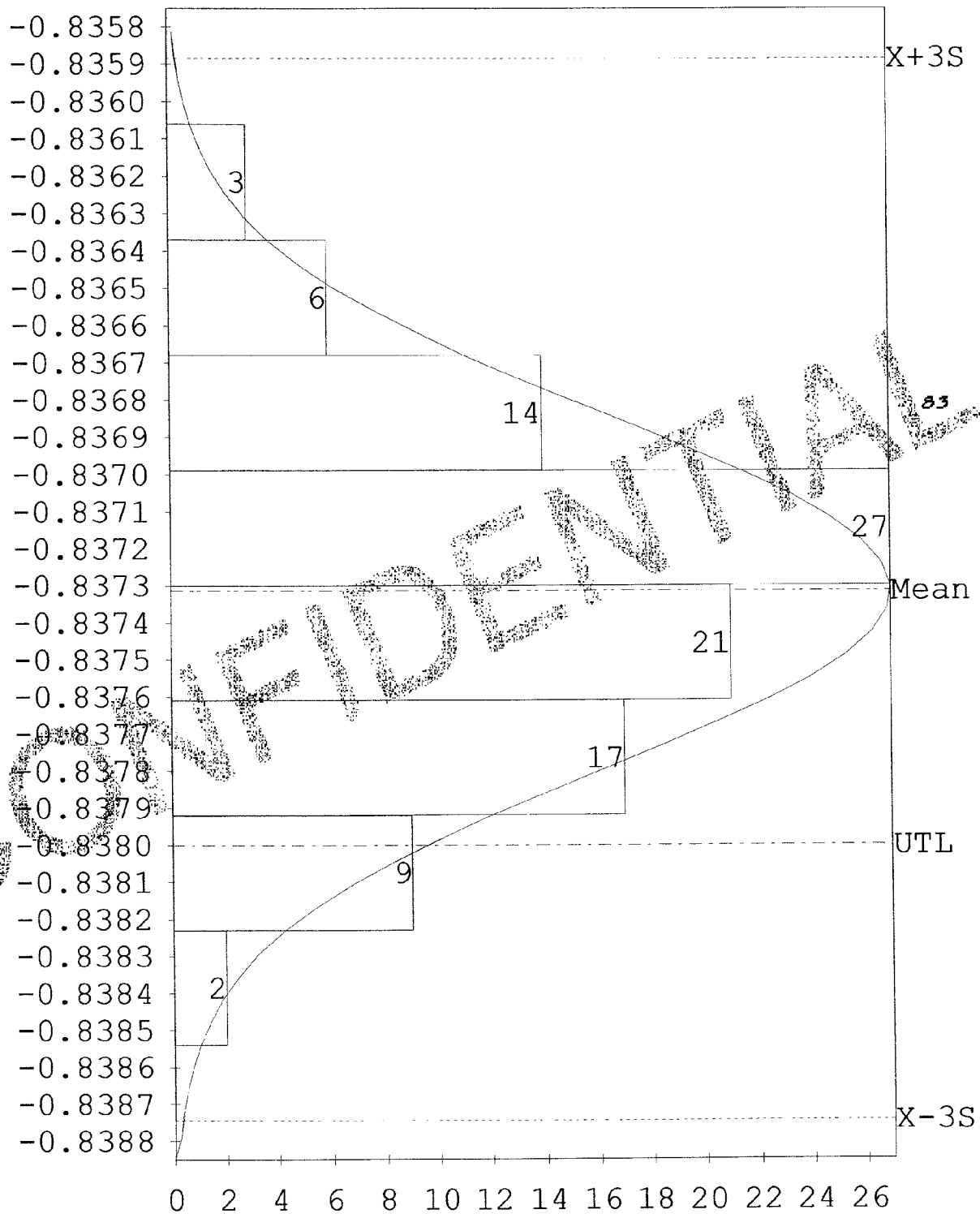
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name TRIGGER PIVOT
 Feature number T
 NOM -0.8400 UTL -0.8380 LTL -0.8420
 Lot Size 99
 Mean -0.8373 Std Dev 0.0005
 Mean+3S -0.8359 Mean-3S -0.8387
 Skew 0.0902 Kurtosis -0.3279
 Minimum -0.8383 Maximum -0.8361
 Range 0.0021 Avg Range 0.0009

	Number	Percent
Acceptable Parts	10	10.1
Defectives Lower	0	0.0
Defectives Upper	89	89.9
Defectives Total	89	89.9

	Deviation Method	Range Method
QU	-1.44	-0.80
QL	9.83	5.48
Cp	1.40	Cpk -1.04

MF1614

RECEIVER INSERT\Hanson 600.job: Histogram 5 - X
Cp 1.40 Cpk -1.04



MF1615

Part Program RECEIVER INSERT
Description Hanson 600
Feature name TRIGGER PIVOT
Feature number T
NOM -1.2400 UTL -1.2380 LTL -1.2420
Sample Set Size 3
of Sample Sets 33
Total 99

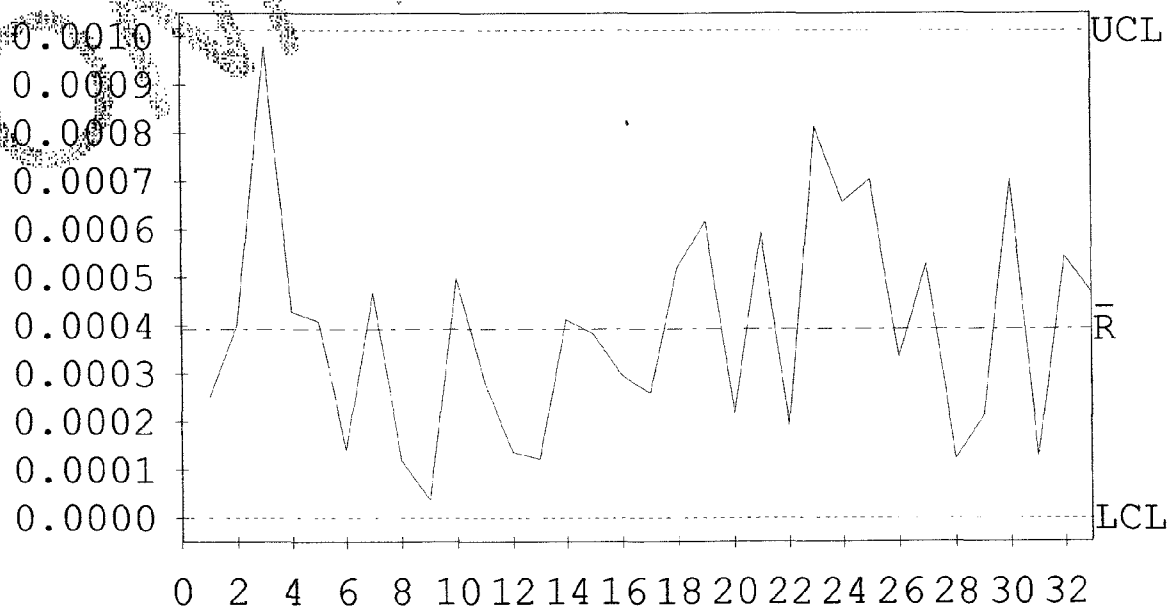
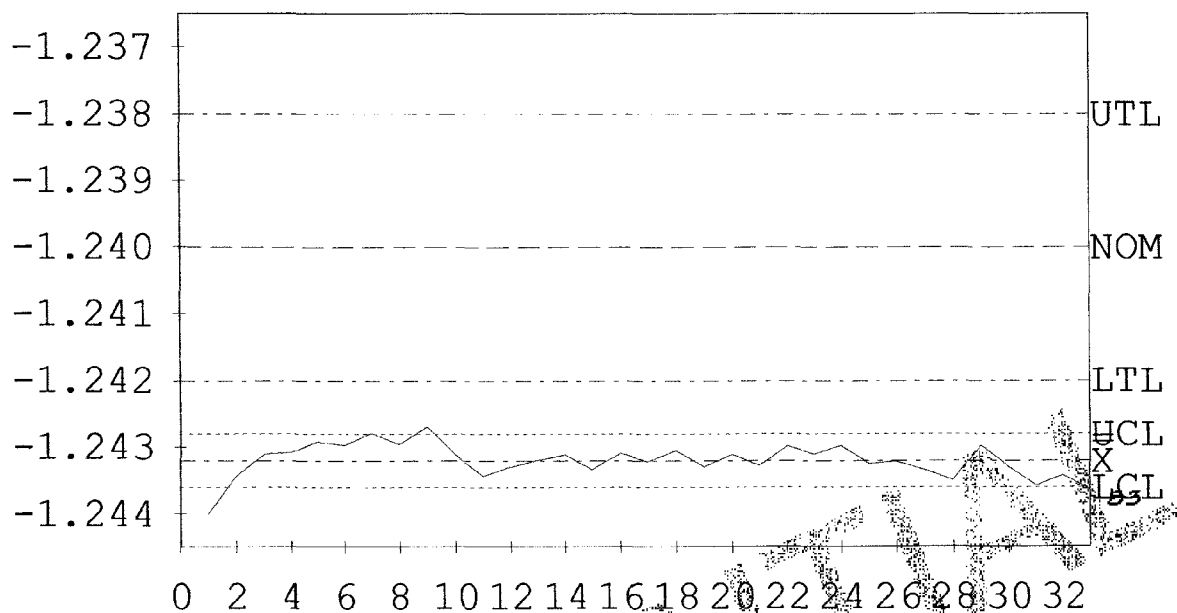
	Mean Chart	R Chart
Central Line	-1.2432	0.0004
UCL	-1.2428	0.0010
LCL	-1.2436	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 2.07 Cpk -1.71

RECEIVER INSERT\Hanson 600.job: XBar/R 5 - Y

Cp 2.07 Cpk -1.71



MF1617

RECEIVER INSERT\Hanson 600.job: Histogram 5 - Y

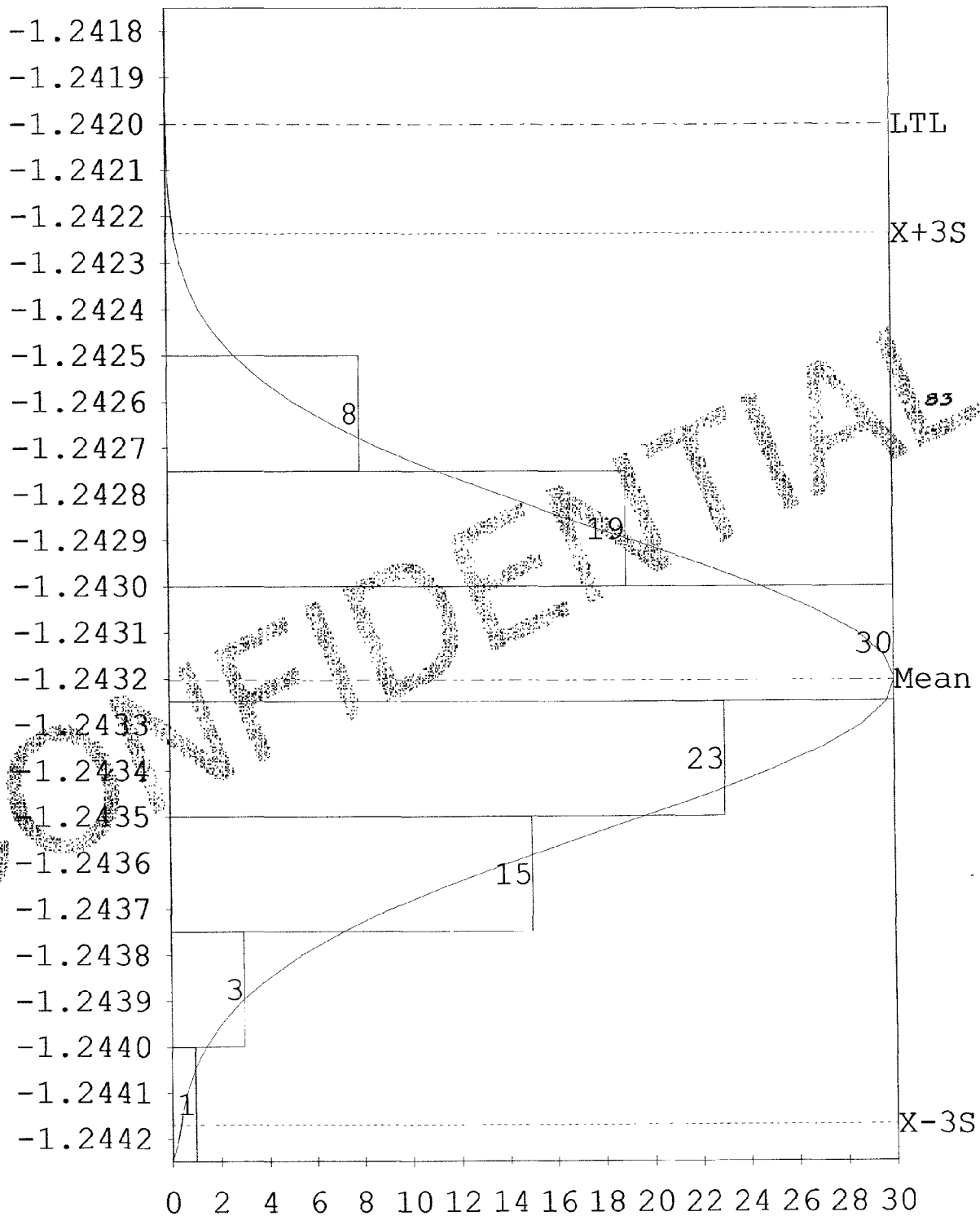
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name TRIGGER PIVOT
 Feature number T
 NOM -1.2400 UTL -1.2380 LTL -1.2420
 Lot Size 99
 Mean -1.2432 Std Dev 0.0003
 Mean+3S -1.2422 Mean-3S -1.2442
 Skew -0.2938 Kurtosis -1.0139
 Minimum -1.2441 Maximum -1.2425
 Range 0.0016 Avg Range 0.0006

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	99	100.0
Defectives Upper	0	0.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	16.15	8.93
QL	-3.73	-2.06
Cp	2.07	Cpk -1.71

MF1618

RECEIVER INSERT\Hanson 600.job: Histogram 5 - Y
Cp 2.07 Cpk -1.71



MF1619

RECEIVER INSERT\Hanson 600.job: Histogram 5 - DI

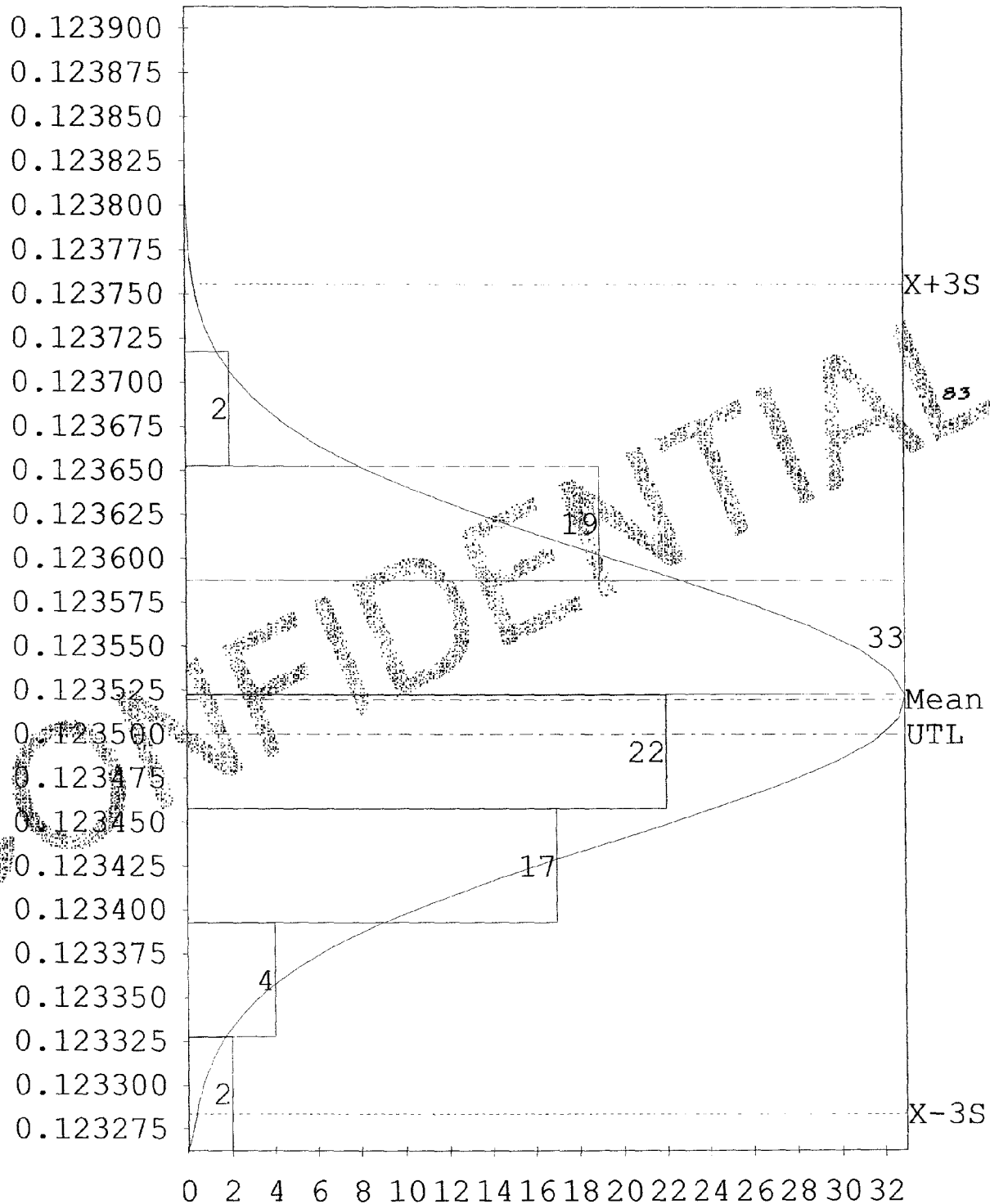
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name TRIGGER PIVOT
 Feature number T
 NOM 0.1220 UTL 0.1235 LTL 0.1205
 Lot Size 99
 Mean 0.1235 Std Dev 0.0001
 Mean+3S 0.1238 Mean-3S 0.1233
 Skew -0.5168 Kurtosis -0.0021
 Minimum 0.1233 Maximum 0.1237
 Range 0.0004 Avg Range 0.0002

	Number	Percent
Acceptable Parts	33	33.3
Defectives Lower	0	0.0
Defectives Upper	66	66.7
Defectives Total	66	66.7

	Deviation Method	Range Method
QU	-0.25	-0.11
QL	38.36	17.03
Cp	6.35	Cpk -0.08

MF1620

RECEIVER INSERT\Hanson 600.job: Histogram 5 - DI
Cp 6.35 Cpk -0.08



MF1621

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Part Program RECEIVER INSERT
Description Hanson 600
Feature name FRONT RIVET
Feature number 01185
NOM -0.2970 UTL -0.2950 LTL -0.2990
Sample Set Size 3
of Sample Sets 33
Total 99

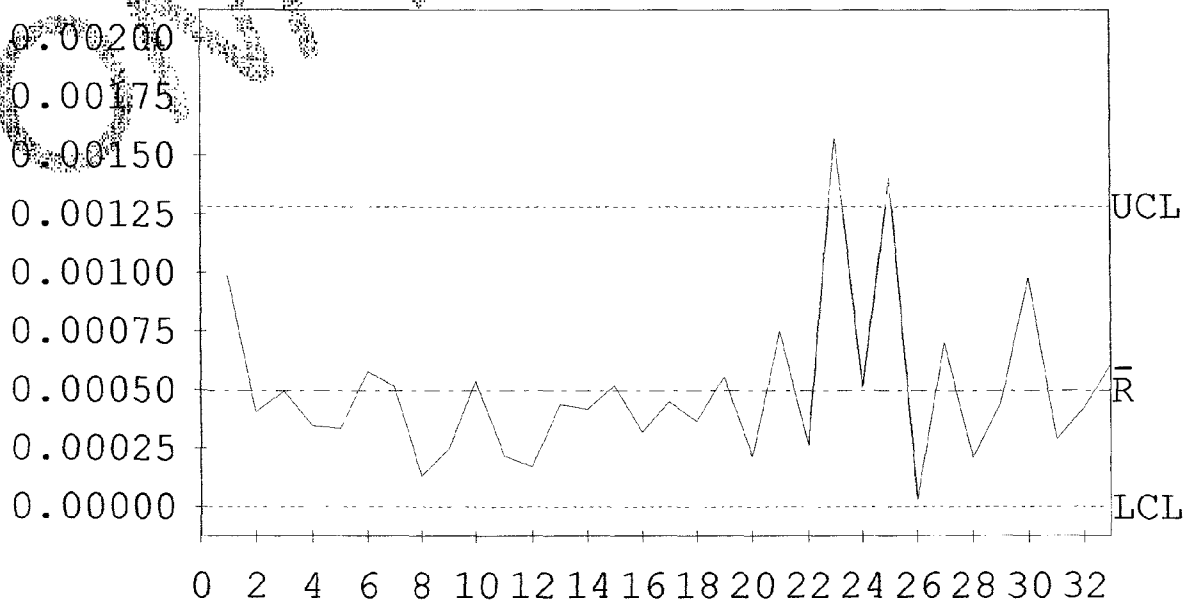
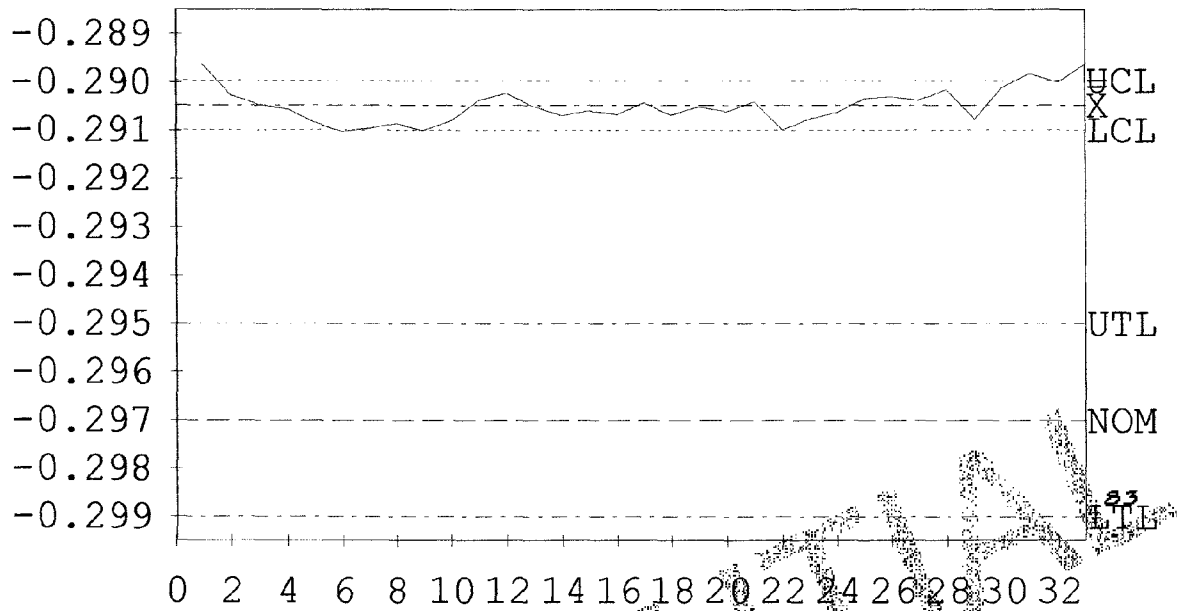
	Mean Chart	R Chart
Central Line	-0.2905	0.0005
UCL	-0.2900	0.0013
LCL	-0.2910	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.50 Cpk -4.04

RECEIVER INSERT\Hanson 600.job: XBar/R . 6 - X

Cp 1.50 Cpk -4.04



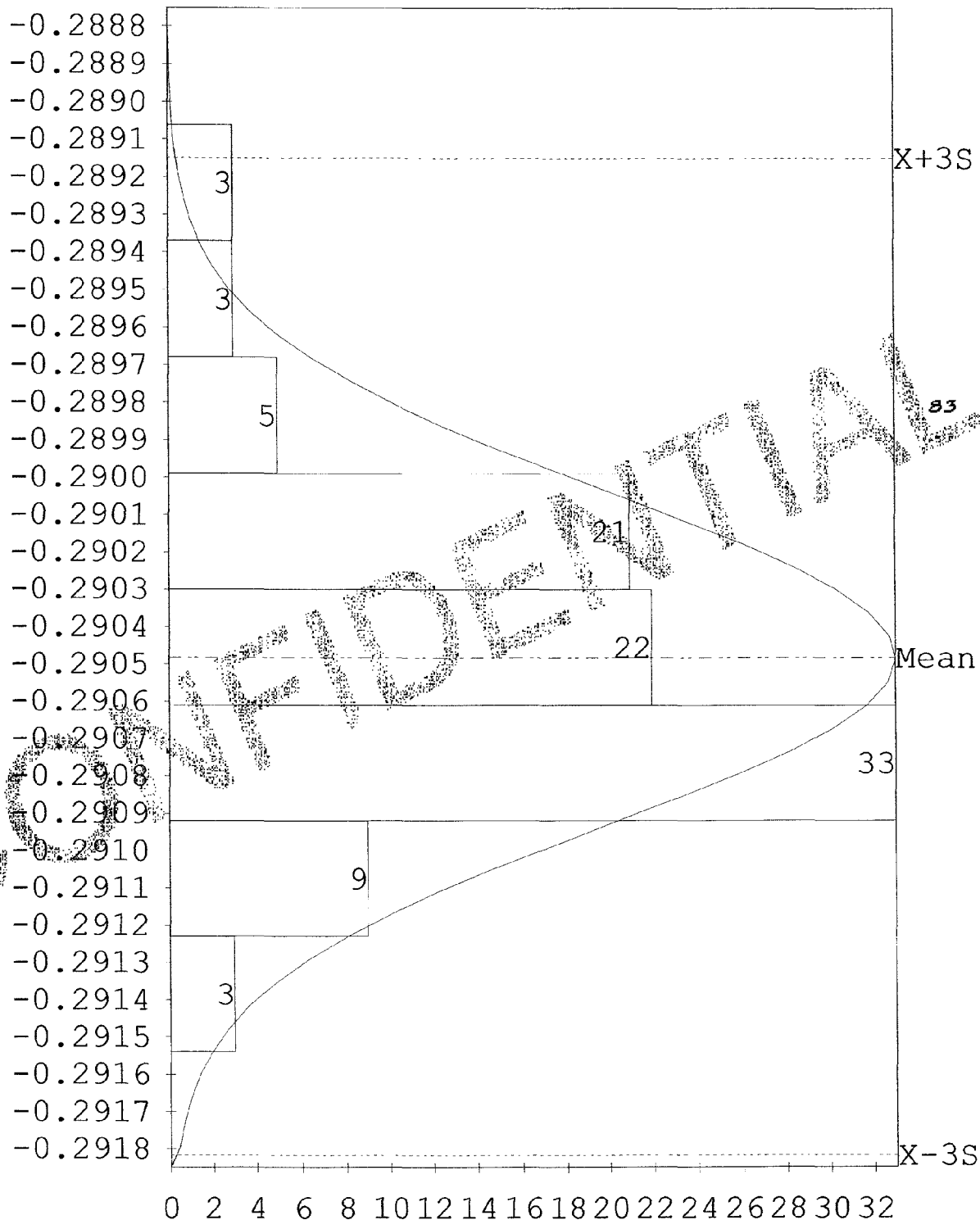
MF1623

Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	FRONT RIVET		
Feature number	01185		
NOM	-0.2970	UTL	-0.2950
		LTL	-0.2990
Lot Size	99		
Mean	-0.2905	Std Dev	0.0004
Mean+3S	-0.2891	Mean-3S	-0.2918
Skew	0.5101	Kurtosis	0.1311
Minimum	-0.2914	Maximum	-0.2893
Range	0.0022	Avg Range	0.0007

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	0	0.0
Defectives Upper	99	100.0
Defectives Total	99	100.0

	Deviation	Method	Range	Method
QU		-10.16		-6.25
QL		19.16		11.78
Cp	1.50	Cpk	-4.04	

RECEIVER INSERT\Hanson 600.job: Histogram 6 - X
Cp 1.50 Cpk -4.04



MF1625

Part Program RECEIVER INSERT
Description Hanson 600
Feature name FRONT RIVET
Feature number 01185
NOM -1.1280 UTL -1.1260 LTL -1.1300
Sample Set Size 3
of Sample Sets 33
Total 99

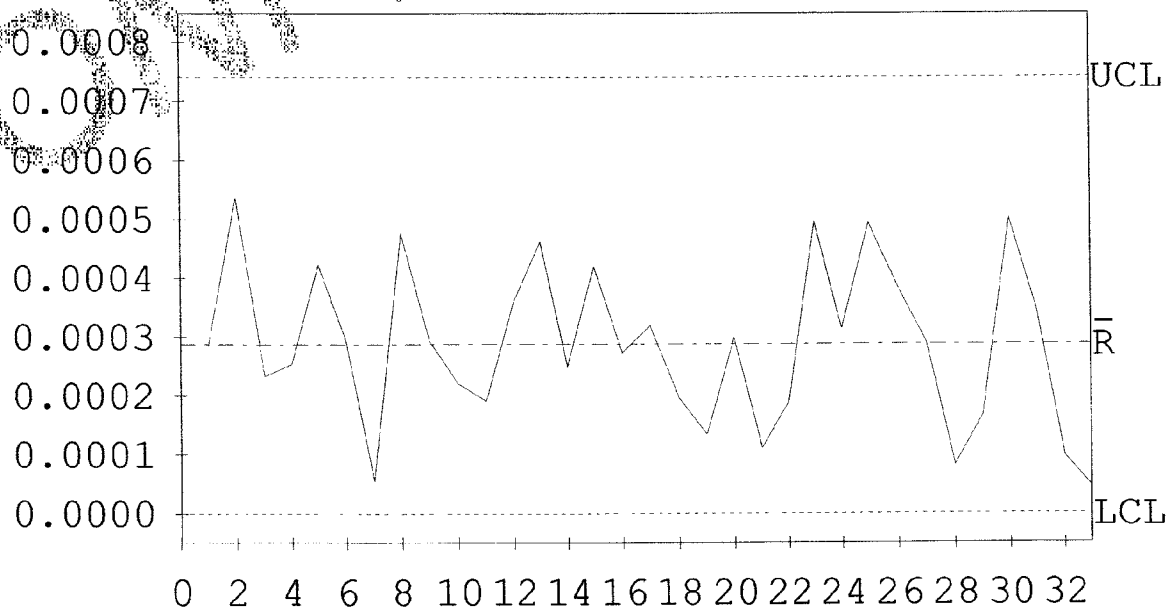
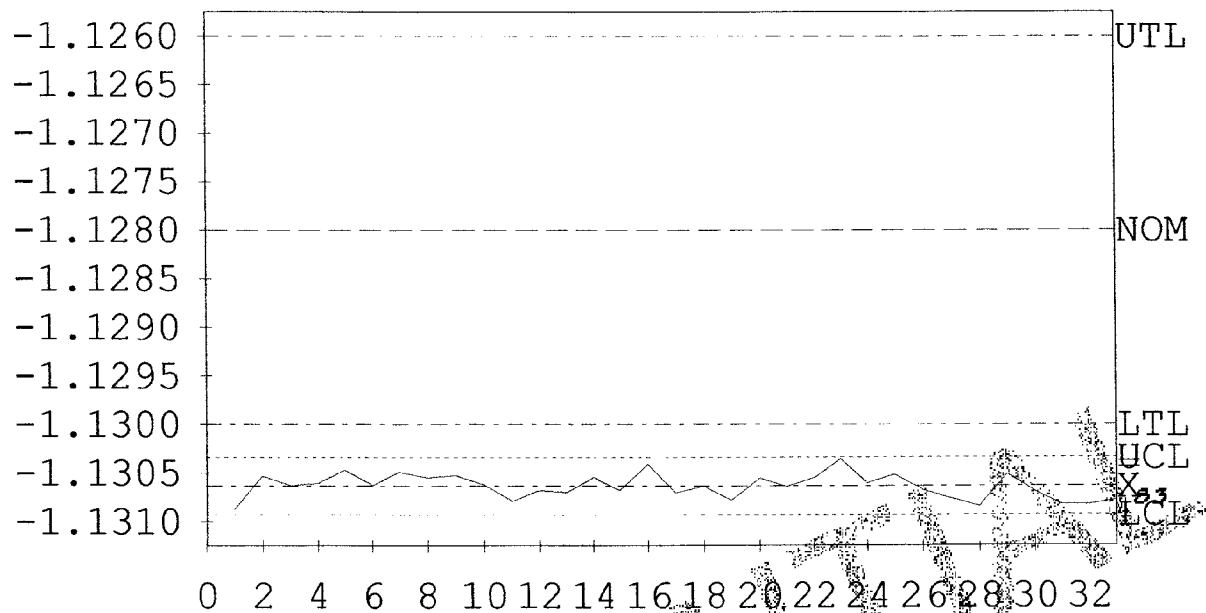
	Mean Chart	R Chart
Central Line	-1.1306	0.0003
UCL	-1.1303	0.0007
LCL	-1.1309	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 3.56 Cpk -1.38

RECEIVER INSERT\Hanson 600.job: XBar/R 6 - Y

Cp 3.56 Cpk -1.38



MF1627

RECEIVER INSERT\Hanson 600.job: Histogram 6 - Y

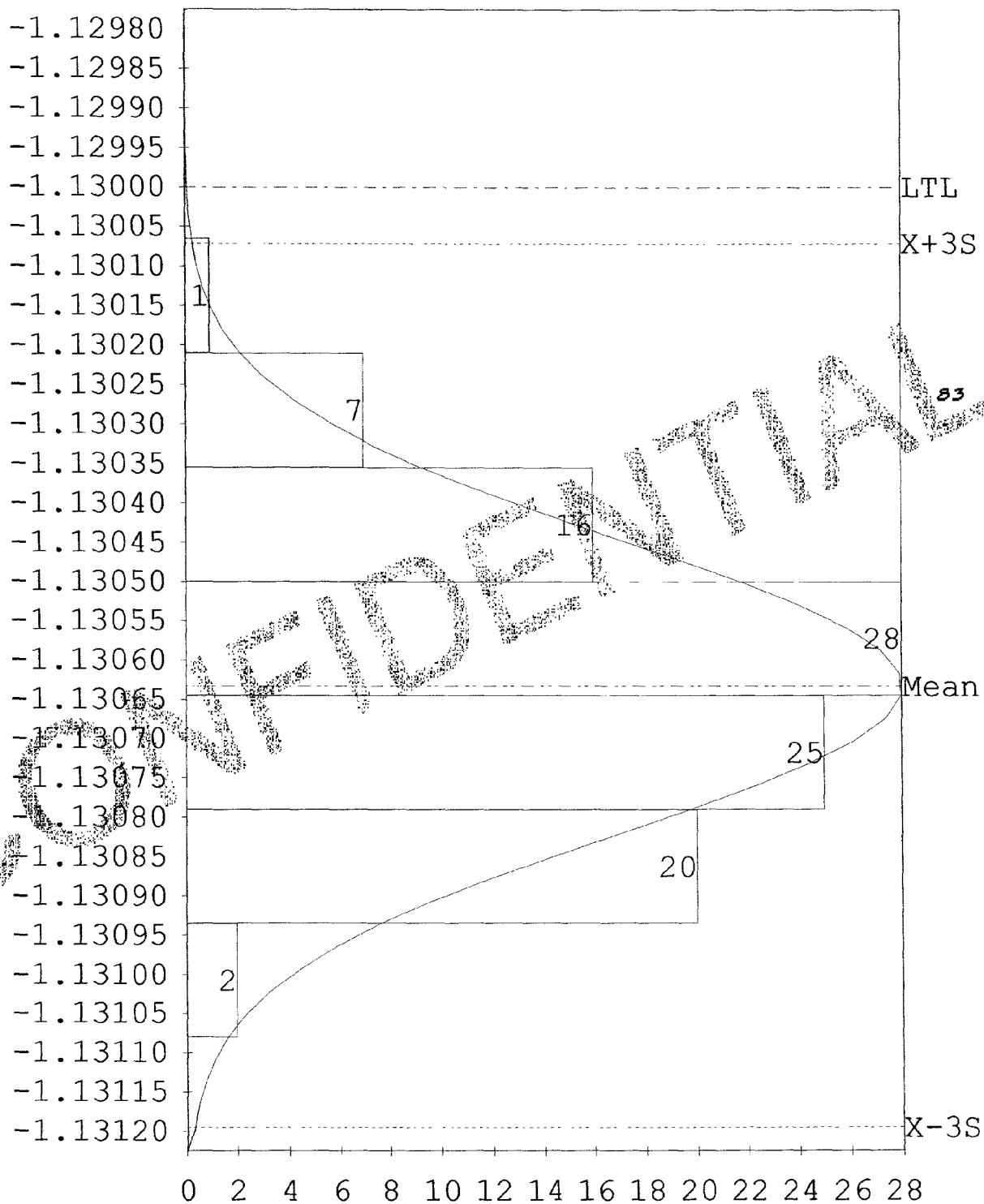
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name FRONT RIVET
 Feature number 01185
 NOM -1.1280 UTL -1.1260 LTL -1.1300
 Lot Size 99
 Mean -1.1306 Std Dev 0.0002
 Mean+3S -1.1301 Mean-3S -1.1312
 Skew 0.2275 Kurtosis -1.0505
 Minimum -1.1310 Maximum -1.1301
 Range 0.0009 Avg Range 0.0004

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	99	100.0
Defectives Upper	0	0.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	24.74	10.96
QL	-3.38	-1.50
Cp	3.56	Cpk -1.38

MF1628

RECEIVER INSERT\Hanson 600.job: Histogram 6 - Y
Cp 3.56 Cpk -1.38



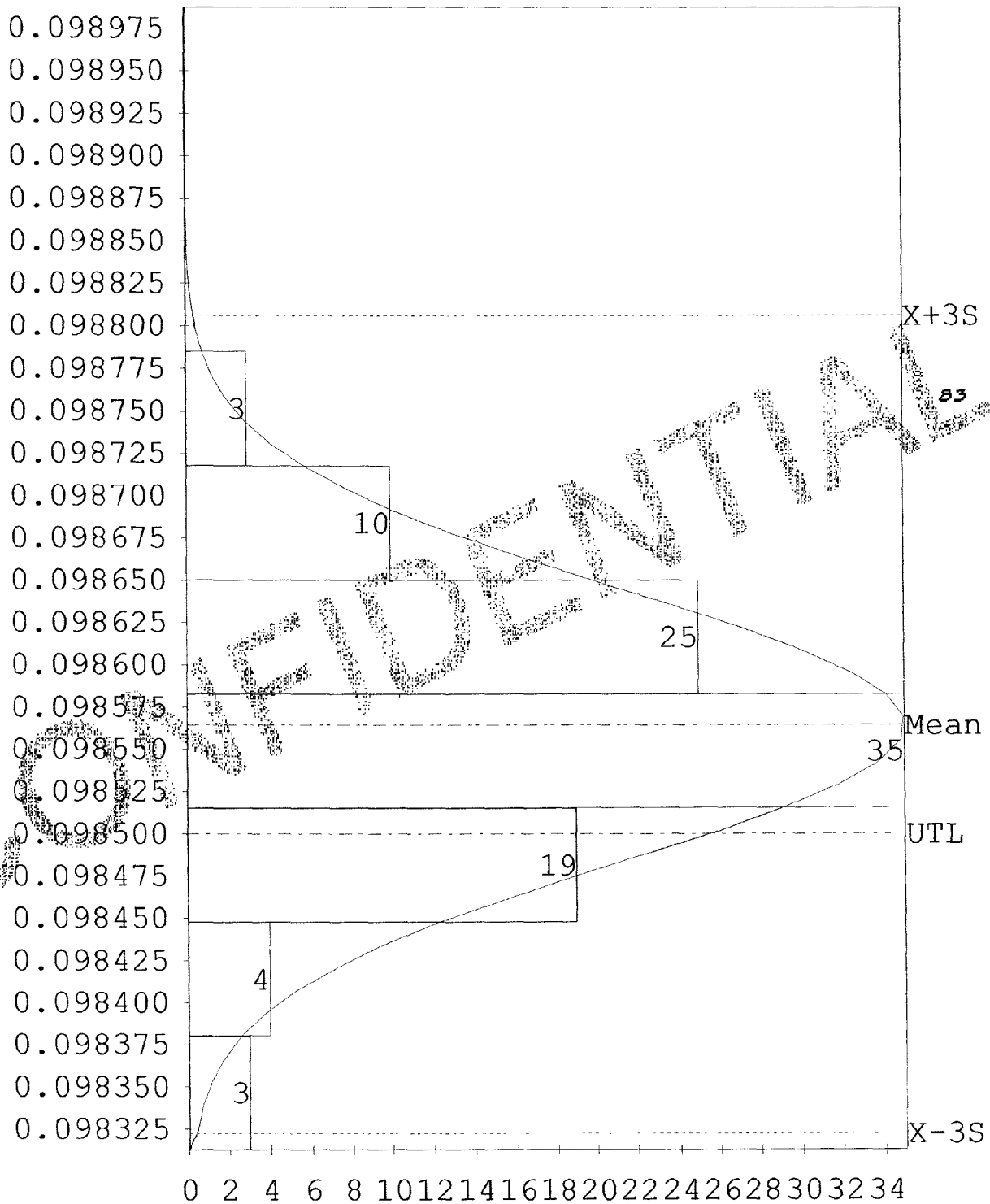
MF1629

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name FRONT RIVET
 Feature number 01185
 NOM 0.0970 UTL 0.0985 LTL 0.0955
 Lot Size 99
 Mean 0.0986 Std Dev 0.0001
 Mean+3S 0.0988 Mean-3S 0.0983
 Skew -0.2754 Kurtosis 0.2645
 Minimum 0.0983 Maximum 0.0987
 Range 0.0004 Avg Range 0.0002

	Number	Percent
Acceptable Parts	17	17.2
Defectives Lower	0	0.0
Defectives Upper	82	82.8
Defectives Total	82	82.8

	Deviation	Method	Range	Method
QU	-0.80		-0.34	
QL	38.01		16.29	
Cp	6.20	Cpk	-0.29	

RECEIVER INSERT\Hanson 600.job: Histogram 6 - DI
Cp 6.20 Cpk -0.29



MF1631

Part Program RECEIVER INSERT

Description Hanson 600

Feature name REAR RIVET

Feature number 01186

NOM -1.2590 UTL -1.2570 LTL -1.2610

Sample Set Size 3

of Sample Sets 33

Total 99

Mean Chart

R Chart

Central Line -1.2547

0.0006

UCL -1.2541

0.0015

LCL -1.2552

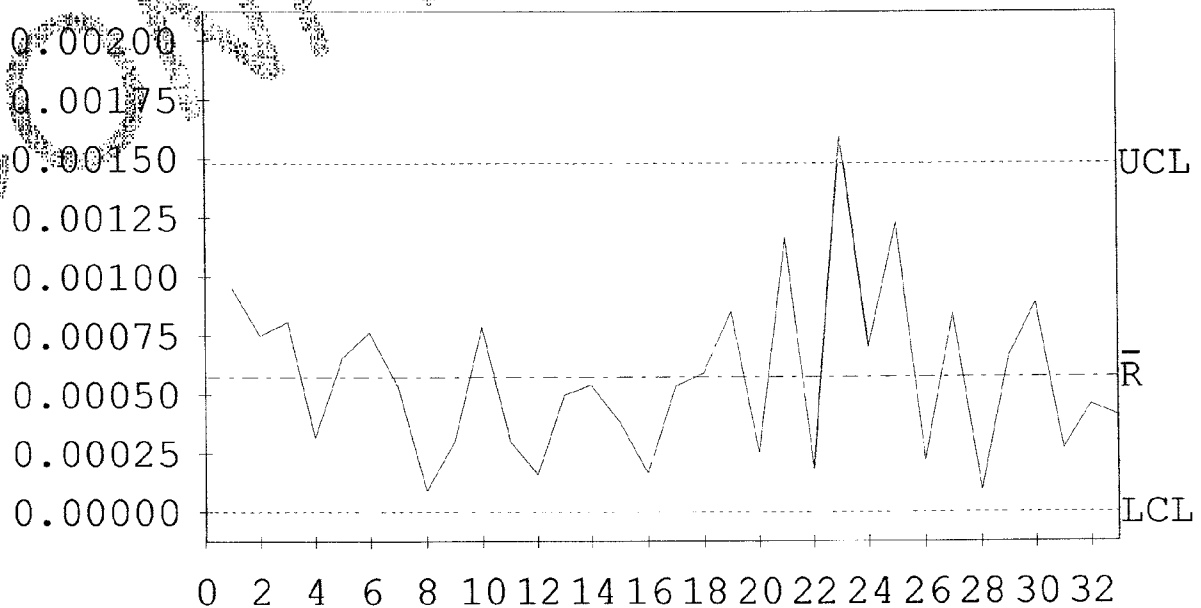
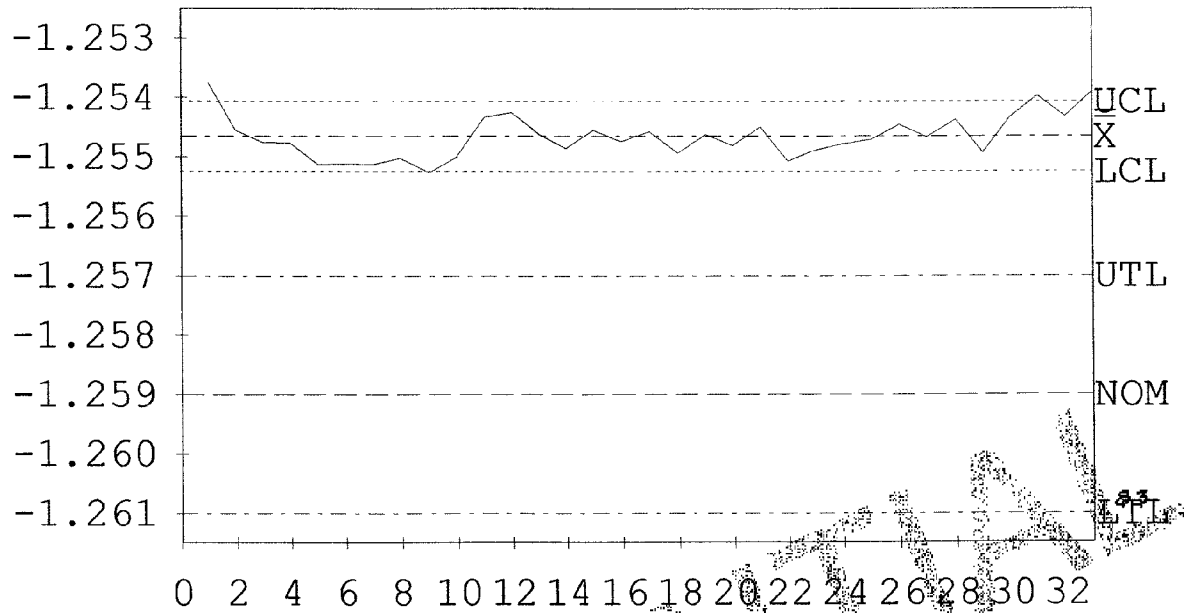
0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.44 Cpk -2.23

RECEIVER INSERT\Hanson 600.job: XBar/R 7 - X

Cp 1.44 Cpk -2.23



MF1633

RECEIVER INSERT\Hanson 600.job: Histogram 7 - X

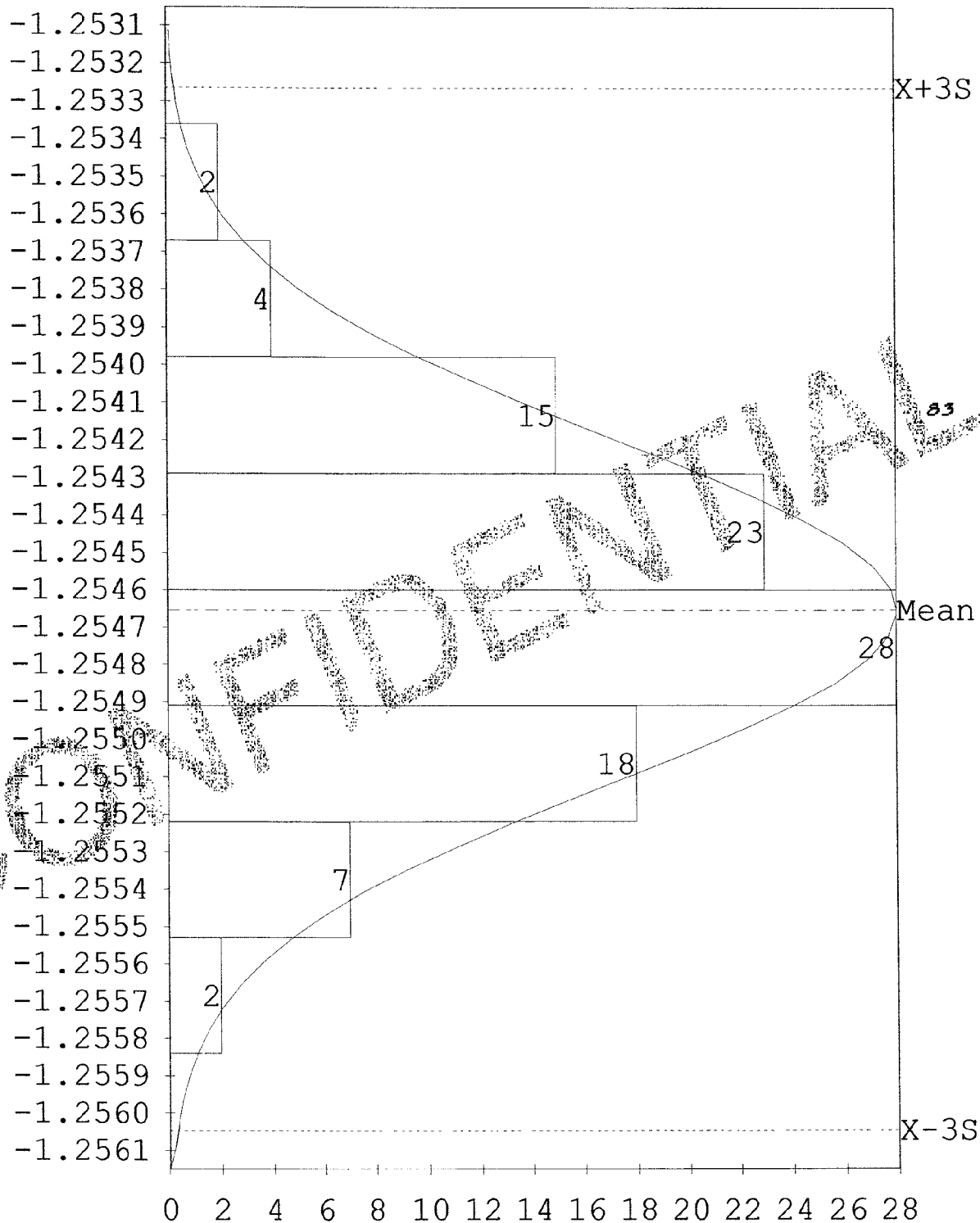
Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	REAR RIVET		
Feature number	01186		
NOM -1.2590	UTL -1.2570	LTL -1.2610	
Lot Size	99		
Mean	-1.2547	Std Dev	0.0005
Mean+3S	-1.2533	Mean-3S	-1.2560
Skew	0.2124	Kurtosis	-0.1536
Minimum	-1.2556	Maximum	-1.2534
Range	0.0022	Avg Range	0.0008

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	0	0.0
Defectives Upper	99	100.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	-5.06	-2.85
QL	13.68	7.72
Cp	1.44	Cpk -2.23

MF1634

RECEIVER INSERT\Hanson 600.job: Histogram 7 - X
Cp 1.44 Cpk -2.23



MF1635

Part Program RECEIVER INSERT

Description Hanson 600

Feature name REAR RIVET

Feature number 01186

NOM -1.1910 UTL -1.1890 LTL -1.1930

Sample Set Size 3

of Sample Sets 33

Total 99

Mean Chart

R Chart

Central Line -1.1925

0.0007

UCL -1.1918

0.0018

LCL -1.1932

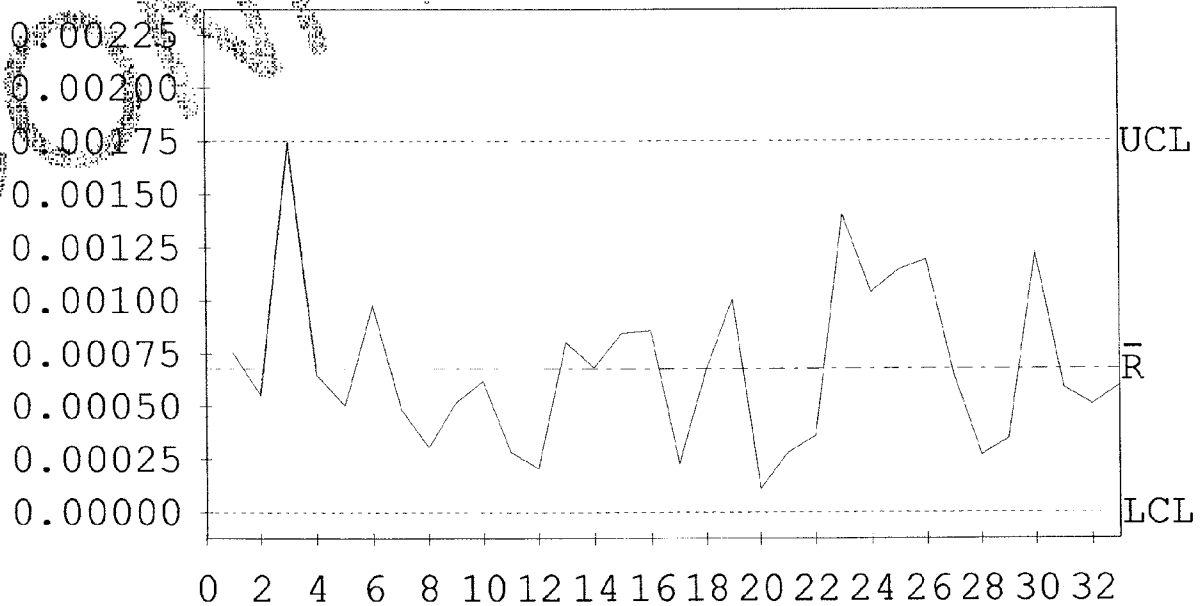
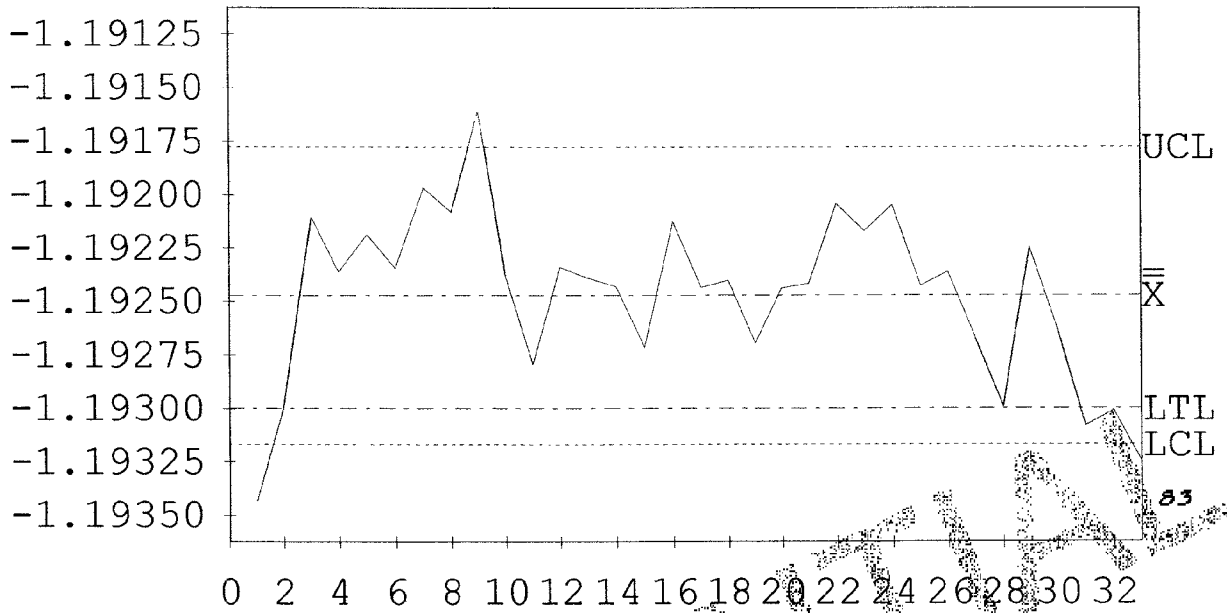
0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.29 Cpk -0.16

RECEIVER INSERT\Hanson 600.job: XBar/R 7 - Y

Cp 1.29 Cpk -0.16



MF1637

RECEIVER INSERT\Hanson 600.job: Histogram 7 - Y

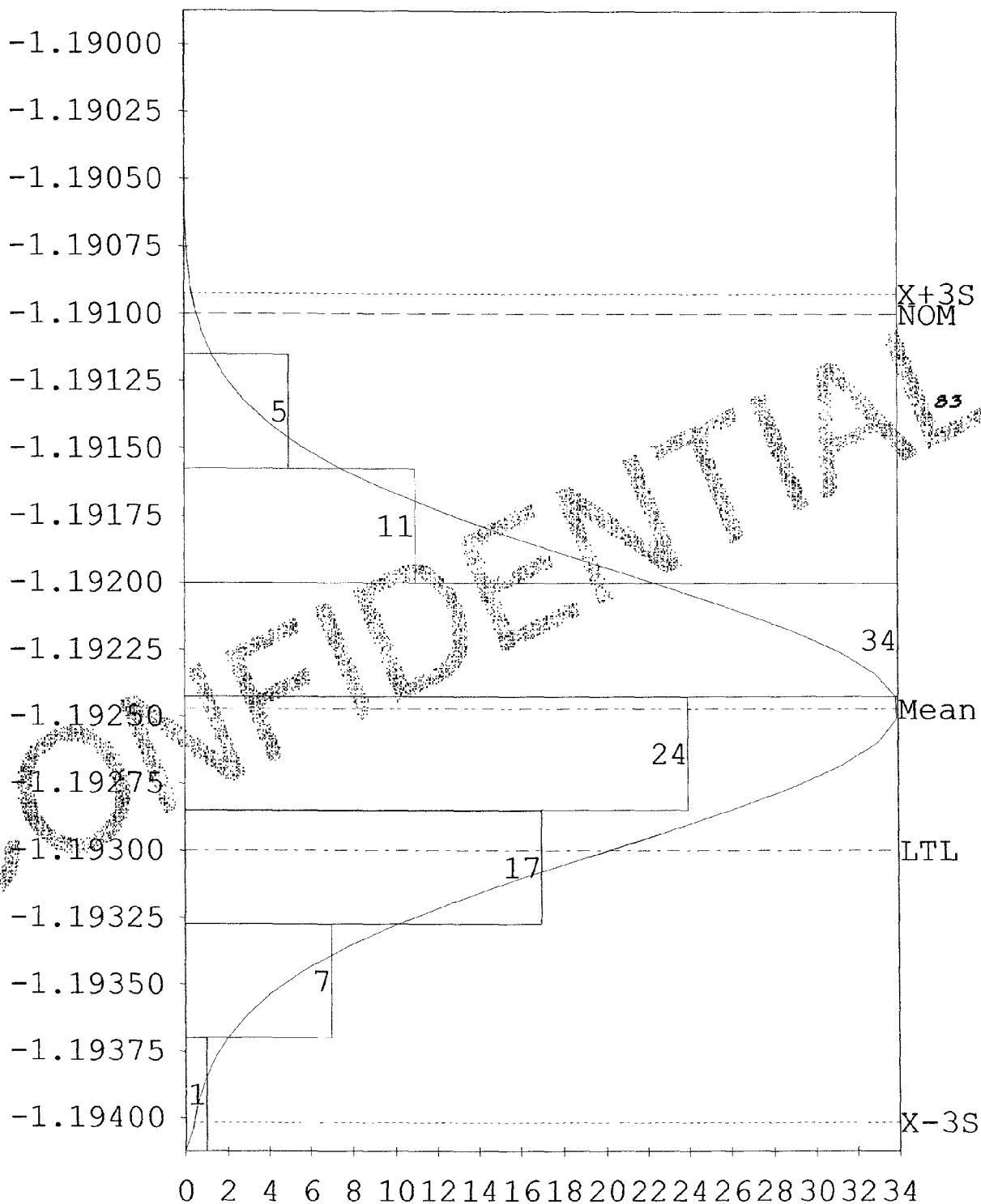
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name REAR RIVET
 Feature number 01186
 NOM -1.1910 UTL -1.1890 LTL -1.1930
 Lot Size 99
 Mean -1.1925 Std Dev 0.0005
 Mean+3S -1.1909 Mean-3S -1.1940
 Skew -0.0937 Kurtosis -0.3918
 Minimum -1.1937 Maximum -1.1913
 Range 0.0025 Avg Range 0.0009

	Number	Percent
Acceptable Parts	83	83.8
Defectives Lower	16	16.2
Defectives Upper	0	0.0
Defectives Total	16	16.2

Deviation Method		Range Method	
QU	6.73		3.67
QL	1.02		0.56
Cp	1.29	Cpk	-0.16

MF1638

RECEIVER INSERT\Hanson 600.job: Histogram 7 - Y
Cp 1.29 Cpk -0.16



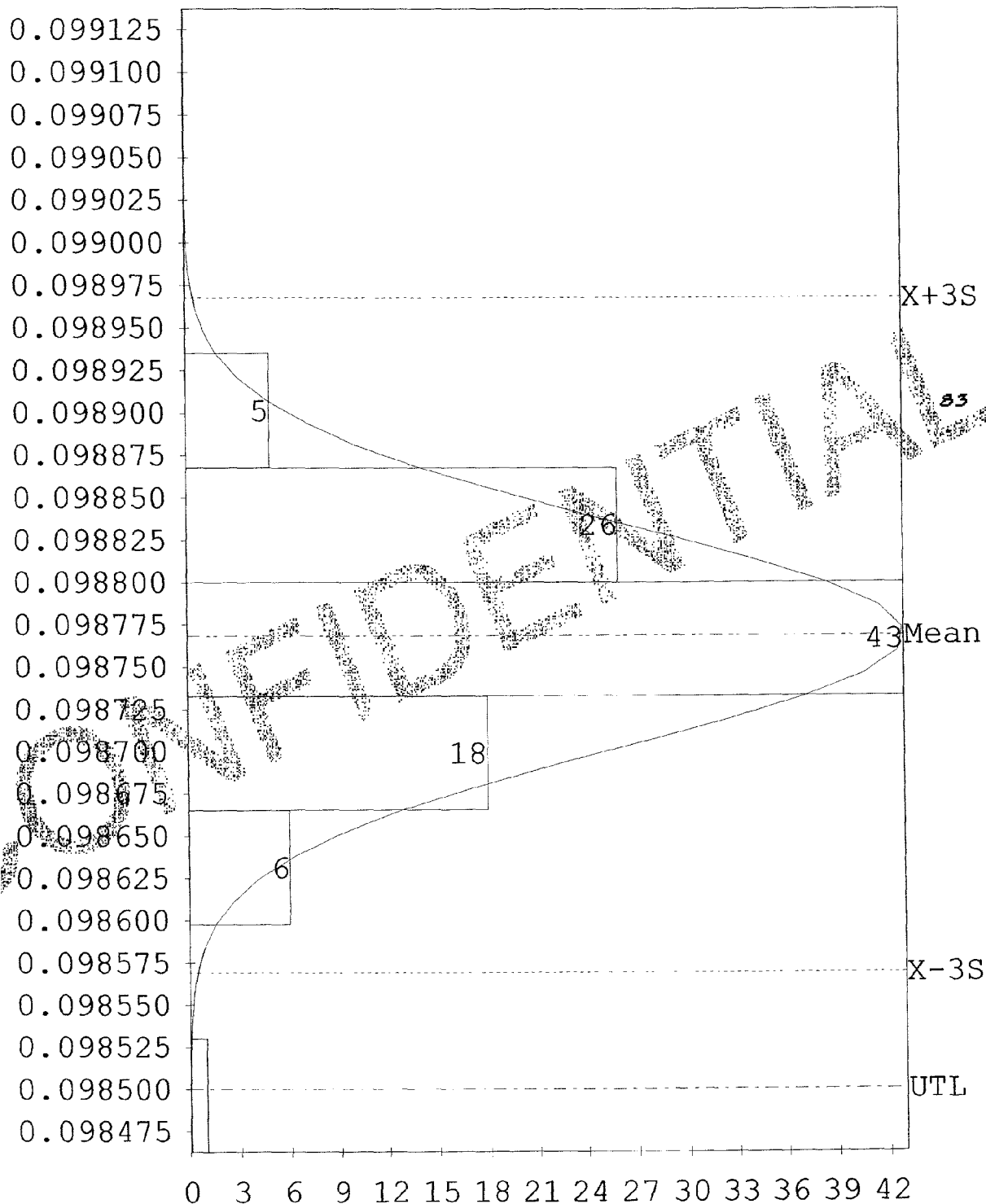
MF1639

Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	REAR RIVET		
Feature number	01186		
NOM 0.0970	UTL 0.0985	LTL 0.0955	
Lot Size	99		
Mean	0.0988	Std Dev	0.0001
Mean+3S	0.0990	Mean-3S	0.0986
Skew	-0.8757	Kurtosis	2.1829
Minimum	0.0985	Maximum	0.0989
Range	0.0004	Avg Range	0.0002

	Number	Percent
Acceptable Parts	1	1.0
Defectives Lower	0	0.0
Defectives Upper	98	99.0
Defectives Total	98	99.0

	Deviation Method	Range Method
QU	-4.04	-1.74
QL	49.18	21.19
Cp	7.52	Cpk -1.33

RECEIVER INSERT\Hanson 600.job: Histogram 7 - DI
Cp 7.52 Cpk -1.33



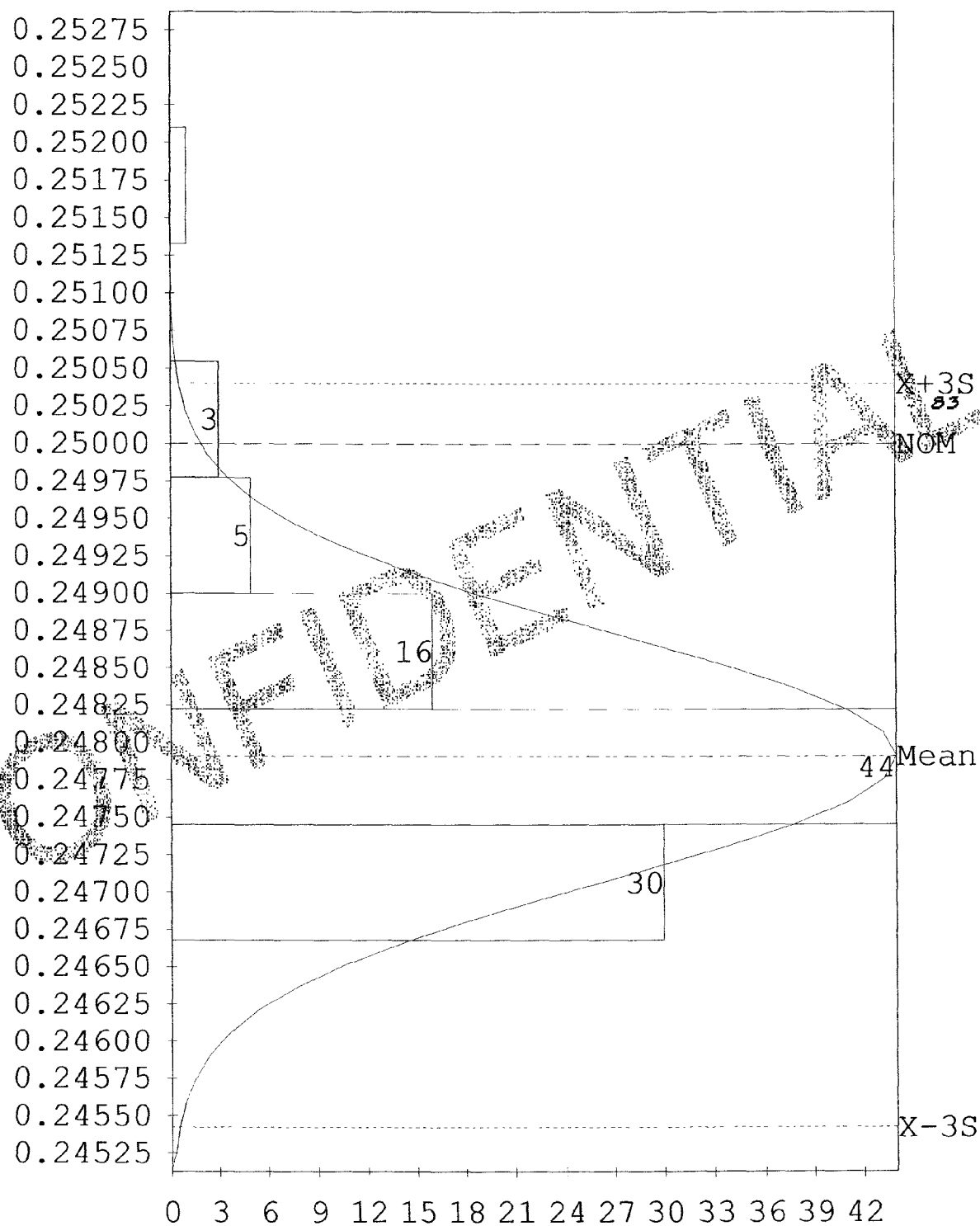
MF1641

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name SIDEPLATE SURF1
 Feature number RF
 NOM 0.2500 UTL 0.2550 LTL 0.2450
 Lot Size 99
 Mean 0.2479 Std Dev 0.0008
 Mean+3S 0.2504 Mean-3S 0.2454
 Skew 2.0283 Kurtosis 5.9689
 Minimum 0.2468 Maximum 0.2521
 Range 0.0053 Avg Range 0.0017

	Number	Percent
Acceptable Parts	99	100.0
Defectives Lower	0	0.0
Defectives Upper	0	0.0
Defectives Total	0	0.0

	Deviation Method	Range Method
QU	8.54	4.15
QL	3.51	1.71
Cp	2.01	Cpk 0.78

RECEIVER INSERT\Hanson 600.job: Histogram 8 - Z
Cp 2.01 Cpk 0.78



MF1643

Part Program RECEIVER INSERT
Description Hanson 600
Feature name SIDEPLATE SURF1
Feature number RF

NOM 0.2500 UTL 0.2550 LTL 0.2450

Sample Set Size 3

of Sample Sets 33

Total 99

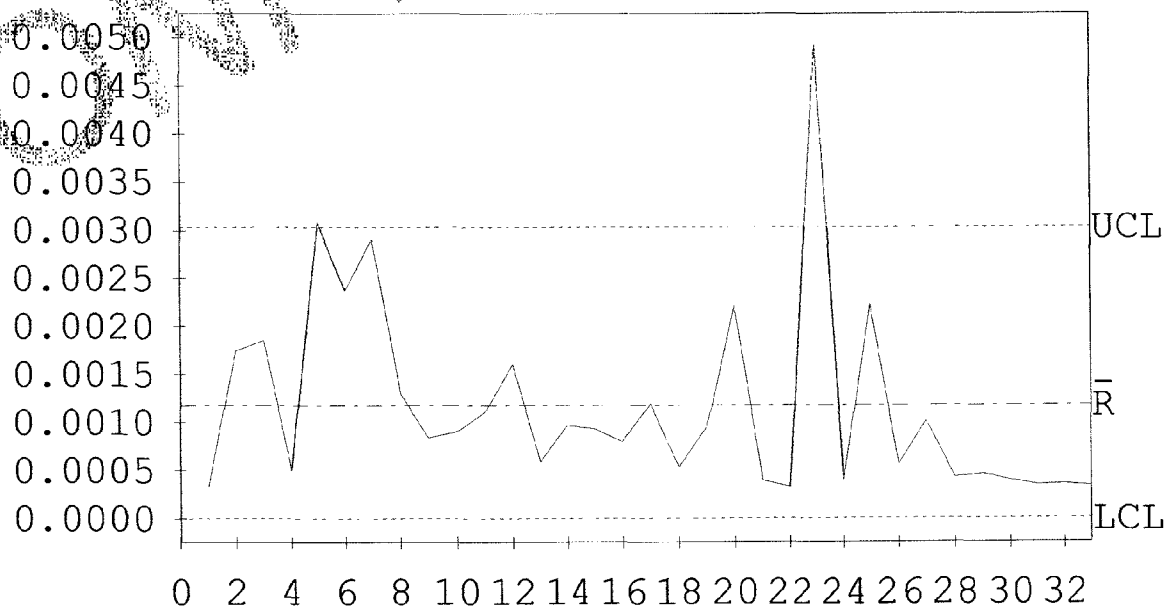
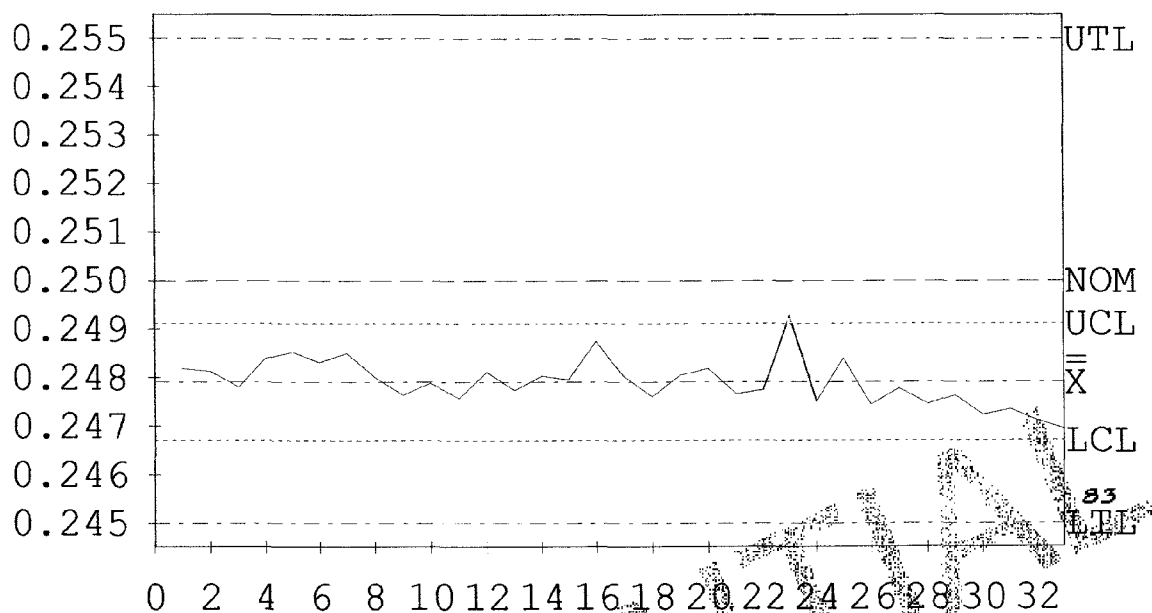
	Mean Chart	R Chart
Central Line	0.2479	0.0012
UCL	0.2491	0.0030
LCL	0.2467	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 2.01 Cpk 0.78

RECEIVER INSERT\Hanson 600.job: XBar/R 8 - Z

Cp 2.01 Cpk 0.78



MF1645

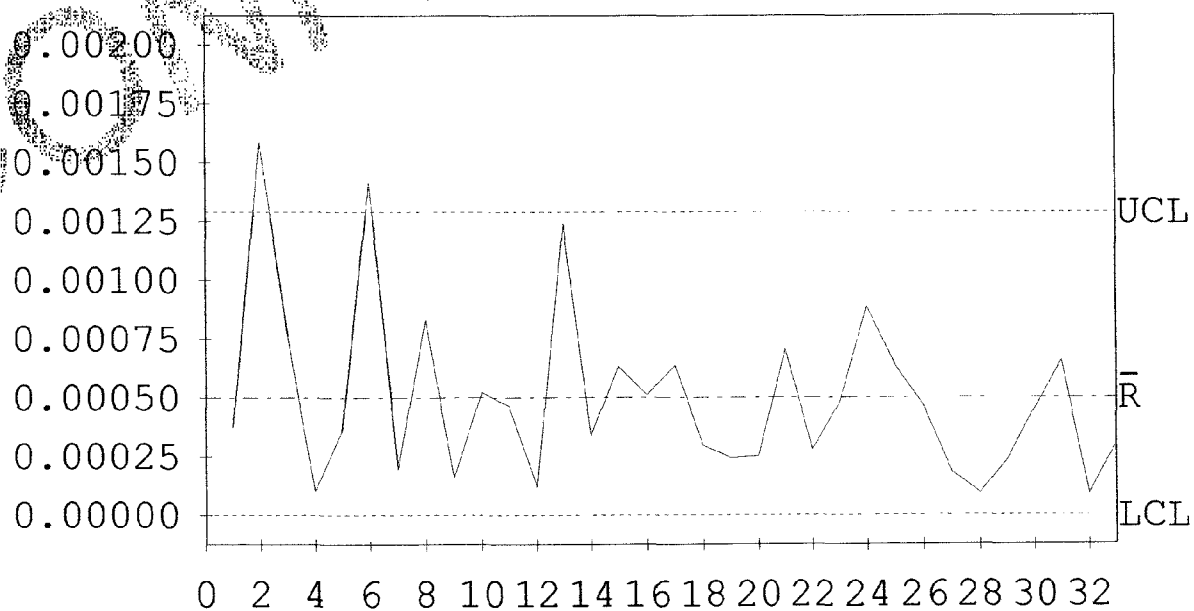
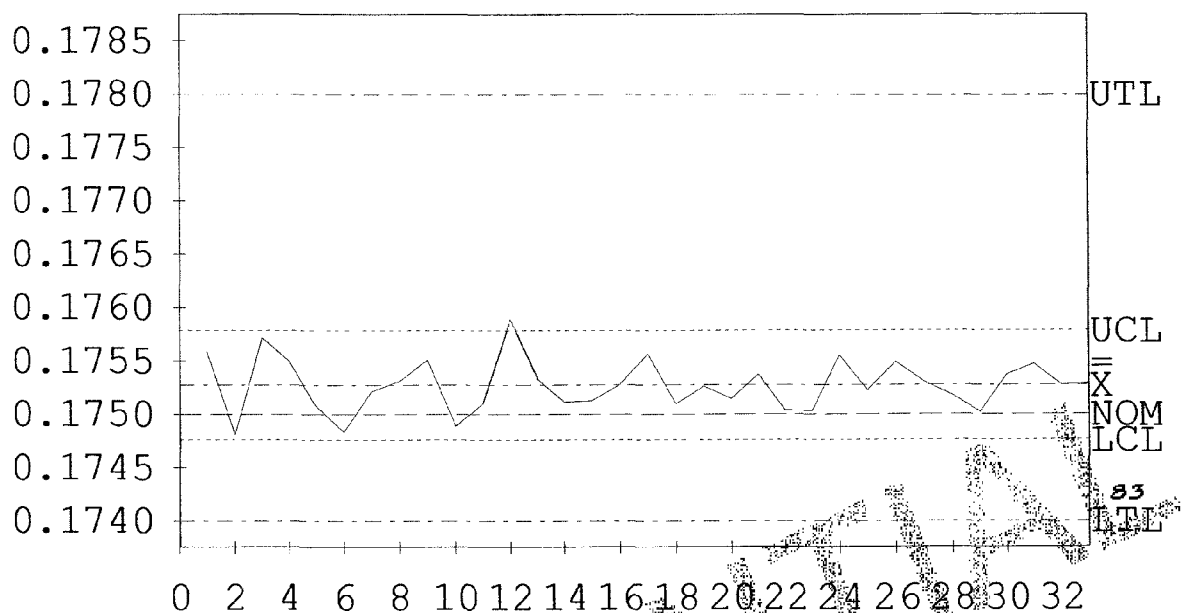
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name SIDEPLATE DEPT
 Feature number PTH
 NOM 0.1750 UTL 0.1780 LTL 0.1740
 Sample Set Size 3
 # of Sample Sets 33
 Total 99

	Mean Chart	R Chart
Central Line	0.1753	0.0005
UCL	0.1758	0.0013
LCL	0.1748	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.83 Cpk 1.18

Cp 1.83 Cpk 1.18



MF1647

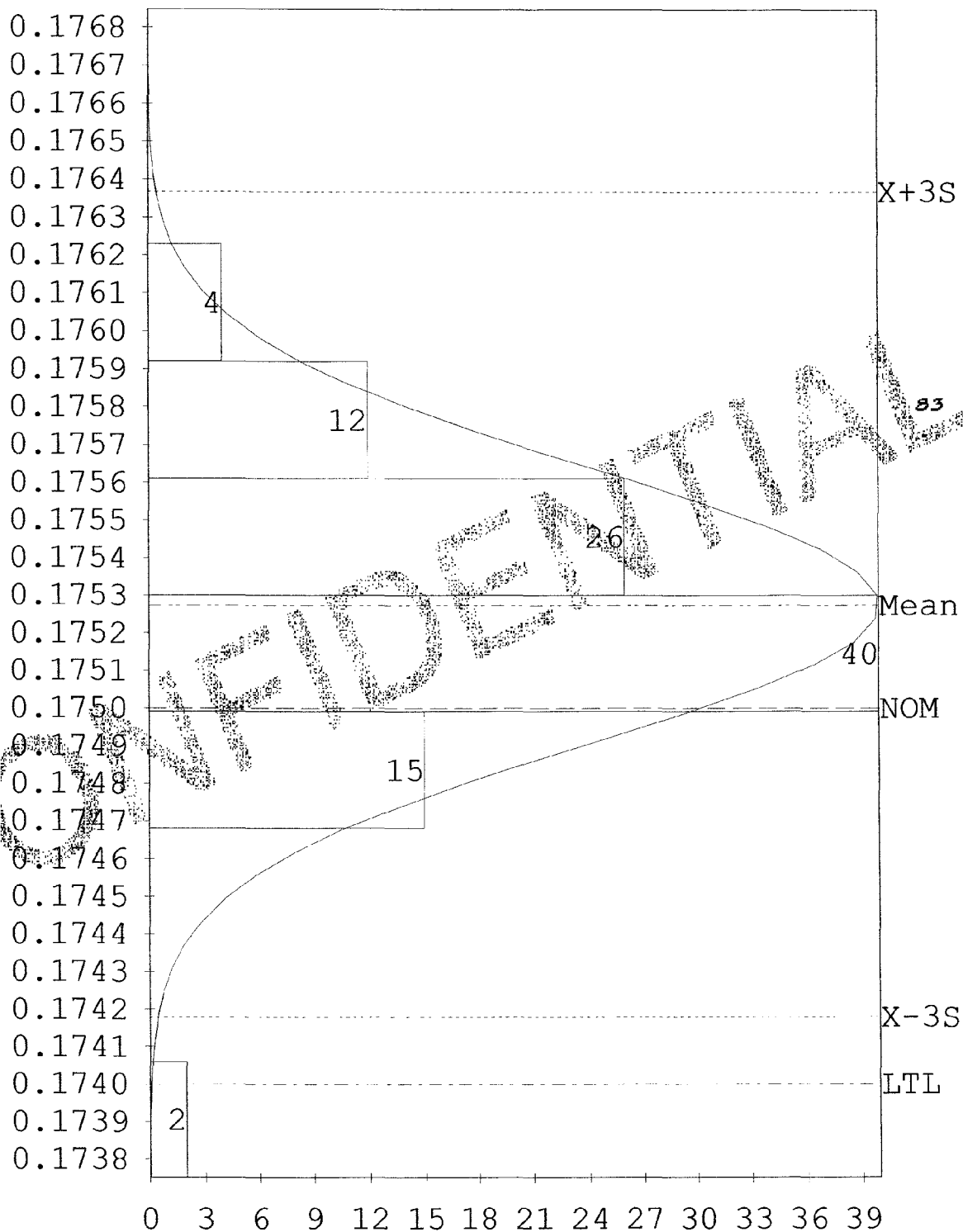
Part Program	RECEIVER INSERT		
Description	Hanson 600		
Feature name	SIDEPLATE DEPTpÝé?¾ë-?q=a?		
Feature number	PTH		
NOM 0.1750	UTL 0.1780	LTL 0.1740	
Lot Size 99			
Mean 0.1753	Std Dev	0.0004	
Mean+3S 0.1764	Mean-3S	0.1742	
Skew -0.6895	Kurtosis	2.7682	
Minimum 0.1739	Maximum	0.1761	
Range 0.0022	Avg Range	0.0009	

	Number	Percent
Acceptable Parts	97	98.0
Defectives Lower	2	2.0
Defectives Upper	0	0.0
Defectives Total	2	2.0

	Deviation Method	Range Method
QU	7.47	3.17
QL	3.49	1.48
Cp 1.83	Cpk 1.18	

MF1648

RECEIVER INSERT\Hanson 600.job: Histogram 9 - DS
Cp 1.83 Cpk 1.18



MF1649

Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name BOTTOM BOSS
 Feature number 01190
 NOM -1.1090 UTL -1.1040 LTL -1.1140
 Sample Set Size 3
 # of Sample Sets 33
 Total 99

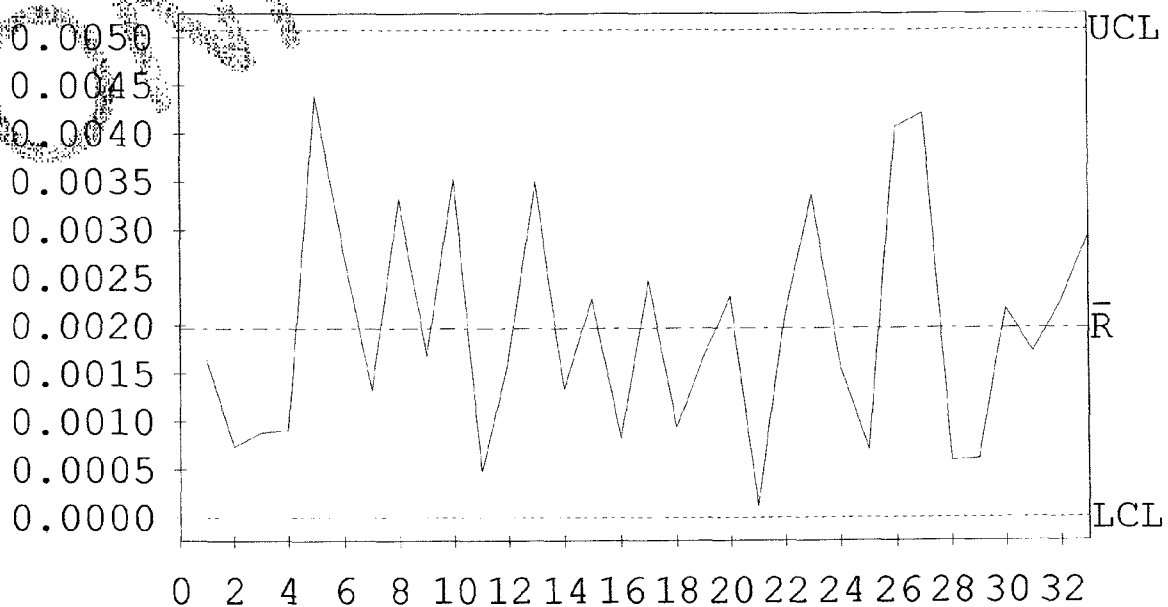
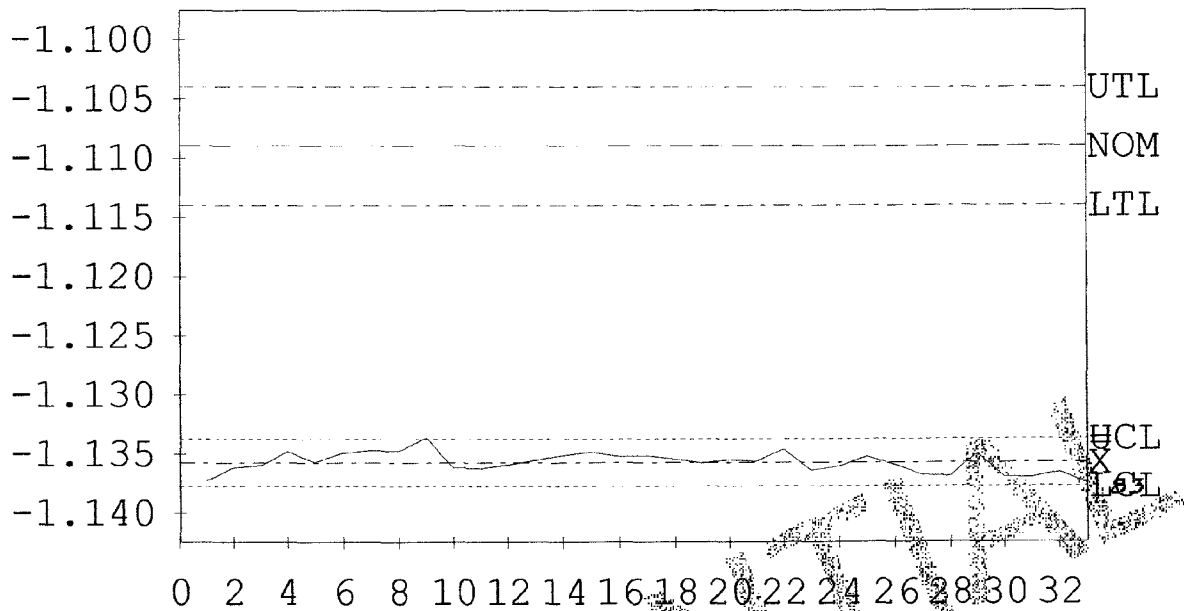
	Mean Chart	R Chart
Central Line	-1.1357	0.0020
UCL	-1.1337	0.0051
LCL	-1.1378	0.0000

Sample	Date/Time	Sample	Date/Time
14	04/04/2000 16:42	15	04/04/2000 16:42
16	04/04/2000 16:42	17	04/04/2000 16:42
18	04/04/2000 16:42	19	04/04/2000 16:42
20	04/04/2000 16:42	21	04/04/2000 16:42
22	04/04/2000 16:42	23	04/04/2000 16:42
24	04/04/2000 16:42	25	04/04/2000 16:42
26	04/04/2000 16:42	27	04/04/2000 16:42
28	04/04/2000 16:42	29	04/04/2000 16:42
30	04/04/2000 16:42	31	04/04/2000 16:42
32	04/04/2000 16:42	33	04/04/2000 16:42

Cp 1.27 Cpk -5.97

RECEIVER INSERT\Hanson 600.job: XBar/R 10 - Y

Cp 1.27 Cpk -5.97



MF1651

RECEIVER INSERT\Hanson 600.job: Histogram 10 - Y

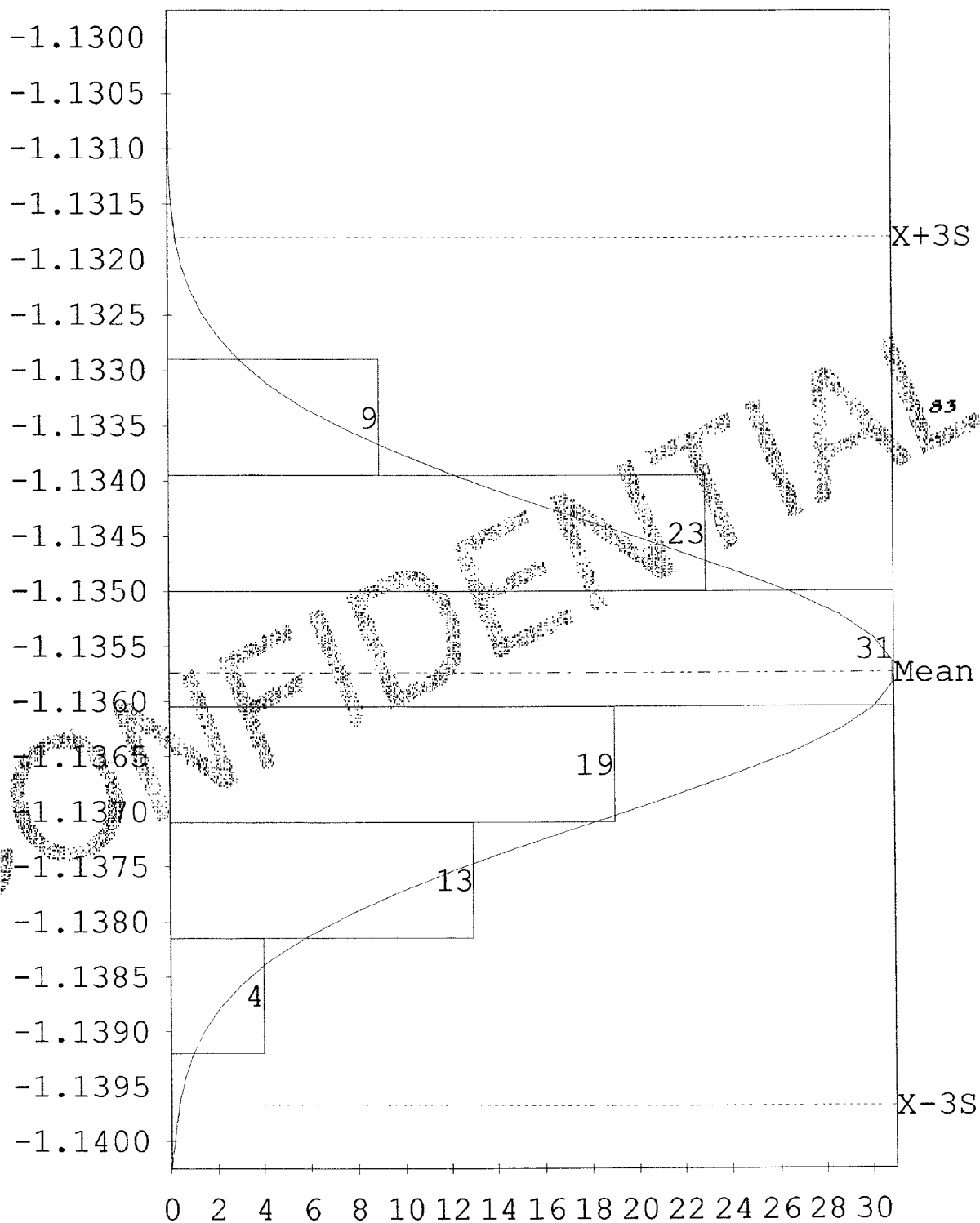
Part Program RECEIVER INSERT
 Description Hanson 600
 Feature name BOTTOM BOSS
 Feature number 01190
 NOM -1.1090 UTL -1.1040 LTL -1.1140
 Lot Size 99
 Mean -1.1357 Std Dev 0.0013
 Mean+3S -1.1318 Mean-3S -1.1397
 Skew -0.2113 Kurtosis -0.5676
 Minimum -1.1389 Maximum -1.1331
 Range 0.0059 Avg Range 0.0028

	Number	Percent
Acceptable Parts	0	0.0
Defectives Lower	99	100.0
Defectives Upper	0	0.0
Defectives Total	99	100.0

	Deviation Method	Range Method
QU	24.16	11.20
QL	-16.55	-7.67
Cp	1.27	Cpk -5.97

MF1652

RECEIVER INSERT\Hanson 600.job: Histogram 10 - Y
Cp 1.27 Cpk -5.97



MF1653