

INSPECTION PROCESS

Origination Date: XXXX

Document Identifier:	Inspection Process
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:

This document describes the inspection process.

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1.0 PURPOSE

This document defines the overall inspection process and includes or makes reference to the procedures necessary for the process.

NOTE: The Production process includes all QC inspections and tests within it. Quality is not a separate process.

2.0 THEORY

Production operations or tasks must be conducted under controlled conditions to ensure product quality. By this we mean:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

3.0 PROBLEM RESOLUTION

All employees are instructed to immediately notify a Responsible Authority (RA) whenever a process or product related problem occurs that cannot be corrected according to [REDACTED]

It is understood that the appropriate responsible authority will occasionally not be available for support; in that event, safely stop the process and contact each of the following personnel in the order listed until [REDACTED]

- [REDACTED] er
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

4.0 PROCEDURE: PRODUCTION DOCUMENTATION

4.1 All revision controlled production documents are available at the point of use and display [REDACTED]

4.2 In addition to this process procedure, additional production documentation may be required for [REDACTED]

4.3 Such documentation includes [REDACTED]

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4.4 Records that are created for temporary retention of miscellaneous information are not [REDACTED]

5.0 PRODUCT IDENTIFICATION

5.1 Product is identified in shop areas by any of the following methods:

[REDACTED]

5.2 Lot traceability or individual serialization of parts is [REDACTED].

5.3 Bad (nonconforming) product that has failed an inspection or test and cannot be reworked to comply with requirements is [REDACTED]. See the **Control of Nonconformances Procedure**.

5.4 Any parts or product not marked with a tag are [REDACTED]

5.5 IDENTIFICATION OF TRANSFER CONTAINERS

5.5.1 Whenever a portion of chemical is transferred from its original container to a smaller temporary container, [REDACTED]

5.5.2 Whenever a portion of chemical is transferred from its original container to a smaller permanent container, [REDACTED]

6.0 PROCEDURE: PRODUCT HANDLING

6.1 Work instructions and/or training will [REDACTED]

6.2 In all cases, Operators are to [REDACTED]

6.3 The Company provides suitable safety and personal protection equipment for handling hazardous or toxic materials. Operators are [REDACTED]

7.0 PROCEDURE: PRESERVATION

7.1 Operators will employ proper handling, packaging (protection) and cleaning of product and constituent parts while [REDACTED].

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7.2 Operators will employ proper use of controlled atmospheres (argon, dry rooms, etc.) to protect the product

7.3 Operators will employ [REDACTED].

7.4 Operators will employ [REDACTED]

7.5 FOD: Foreign Object Damage and Detection: Work instructions and training methods ensure that handling and preservation practices reduce the introduction of foreign objects (FOD) into products.

7.6 Marking and labeling including safety warnings

7.7 Special handling for hazardous materials

8.0 PROCEDURE: CUSTOMER AND GOVERNMENT PROPERTY CONTROL

8.1 Customer and Government Property (C&G Property) means [REDACTED]

This includes:

- 8.1.1 [REDACTED] ment
- 8.1.2 [REDACTED]
- 8.1.3 [REDACTED]
- 8.1.4 [REDACTED]

8.2 All Customer and Government furnished property shall [REDACTED]

8.3 C&G Property shall [REDACTED]

8.4 Sensitive material, as defined by the Customer or Government, shall [REDACTED]

8.5 C&G Property will only be used as [REDACTED]

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8.6 C&G provided equipment shall [REDACTED]

8.7 Quality shall [REDACTED]

8.8 Requirements for the control of C&G property shall [REDACTED]

9.0 PROCEDURE: VALIDATION OF PROCESSES

9.1 Unless otherwise specified by engineering requirements, the form named Design Validation-Verification is used to record results of validation and verification activities.

9.2 Provisions for validation and verification includes:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

10.0 PROCEDURE: INSPECTION AND TEST OF PRODUCT

10.1 Receiving inspection is performed according to the *Receiving Inspection Procedure*.

10.2 First Article Inspection

[REDACTED]

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10.2.7 Any item failing first article inspection must be processed according to the **Control of Nonconforming Product Procedure**.

10.3 In Process Inspections

[Redacted content for 10.3 In Process Inspections]

10.4 Final Inspection

[Redacted content for 10.4 Final Inspection]

11.0 PROCEDURE: SHELF LIFE EXTENSION - Subject to Customer Review and/or Approval

11.1 Items that are subject to expiration may [Redacted]
 [Redacted] for instance:

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11.1.1 [Redacted]

11.1.2 [Redacted]

11.1.3 [Redacted]

11.1.4 [Redacted]

11.2 Chemicals that are purchased [Redacted]

11.3 Raw material components whose shelf life has been extended must [Redacted]

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12.0 PROCESS MAP

Inspection Process

Quality objective: [REDACTED].

Owner: [REDACTED]

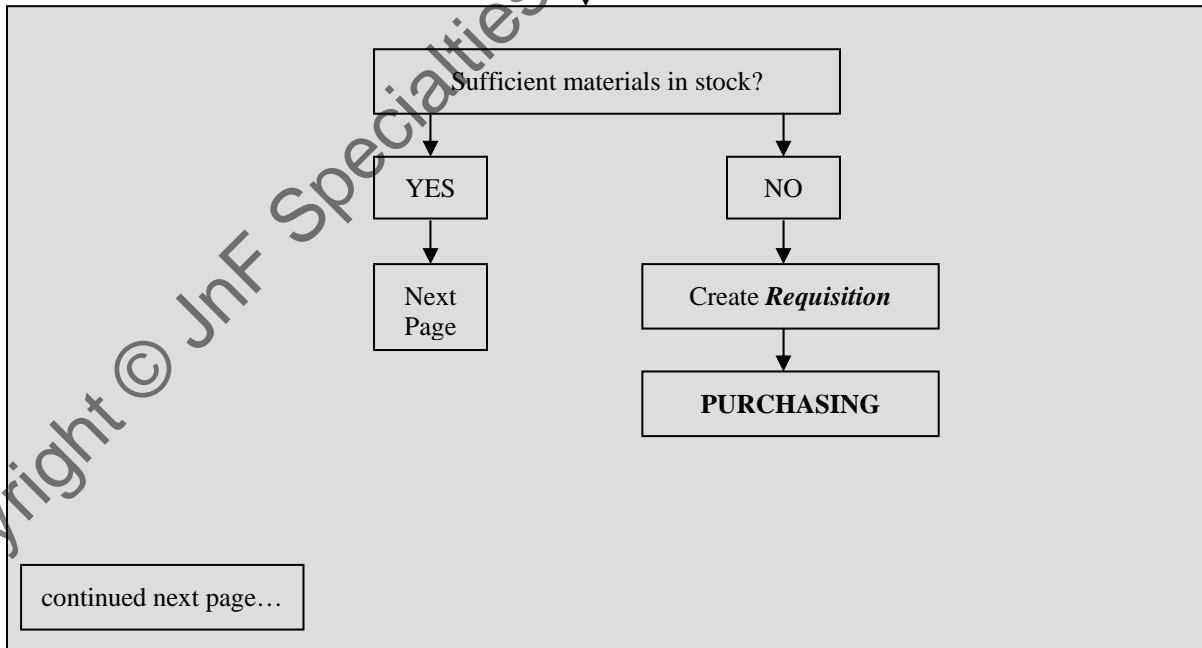
INPUT

- [REDACTED]
- [REDACTED]
- [REDACTED]

Job Sheet provided from Contracts to Responsible Manager.

[REDACTED]

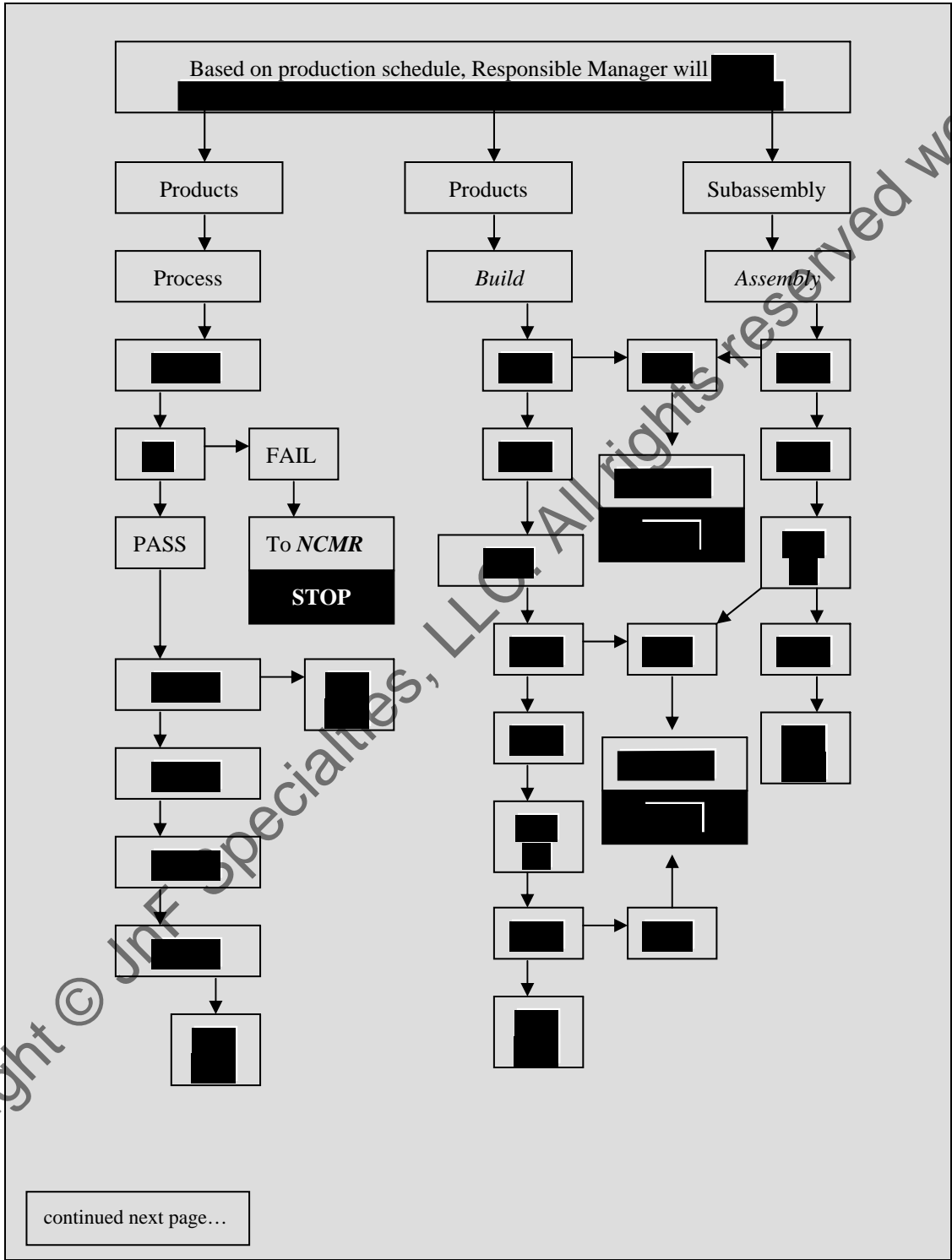
[REDACTED]



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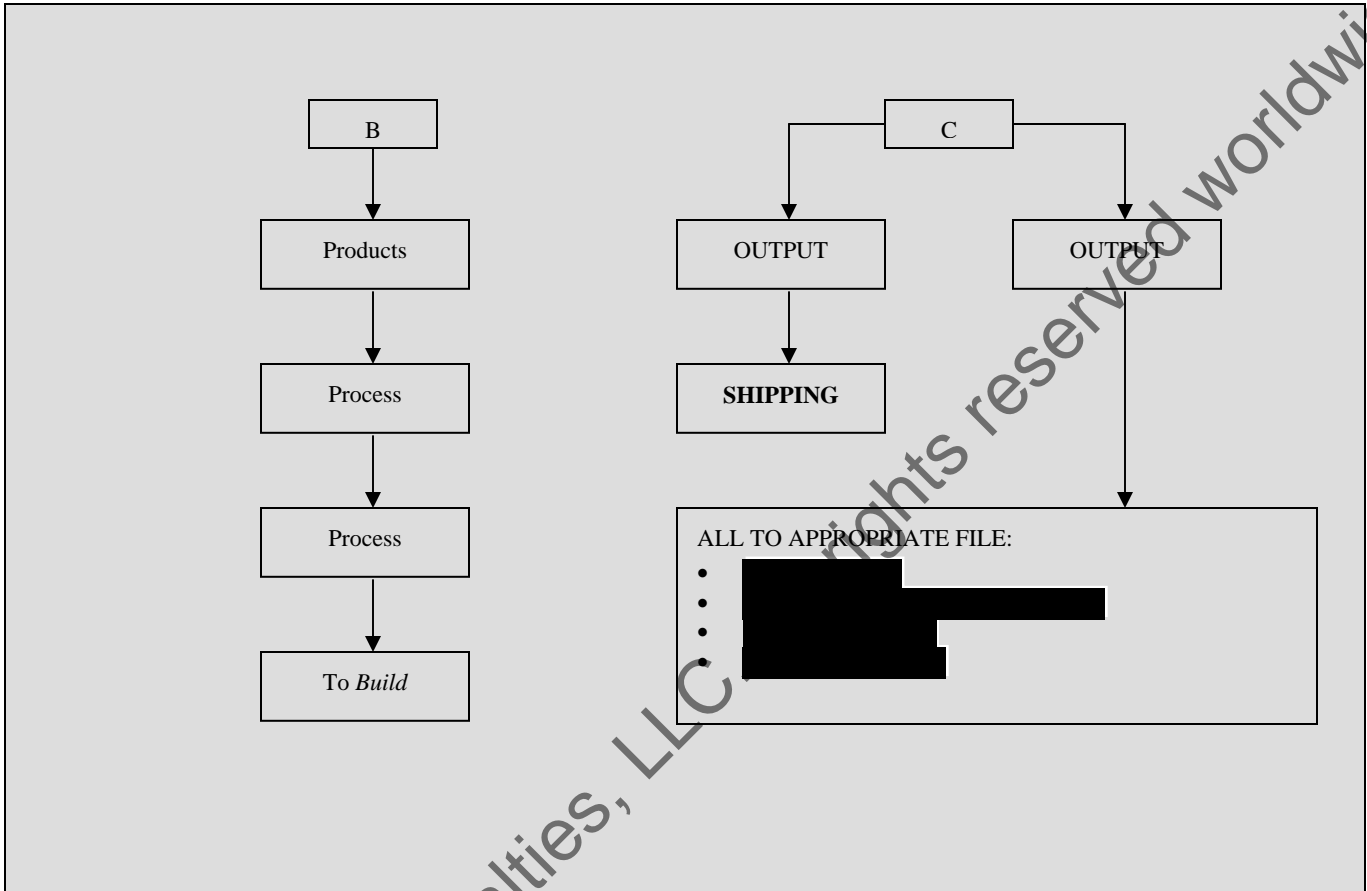
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CONTROL OF NONCONFORMANCES

Origination Date: XXXX

Document Identifier:	Control of Nonconformances
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:

This document describes procedures for control of nonconformances.

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1.0 PURPOSE

This document defines and makes reference to the procedures necessary for the control of nonconforming items.

2.0 THEORY

Items that have failed inspections or tests or that in any way does not meet requirements is considered nonconforming. Such items must be controlled to ensure it is not accidentally delivered or used. The Company's system ensures that nonconforming items are identified when found and segregated, investigated and dispositioned. Corrective and/or preventive actions are taken to ensure nonconformances do not reoccur.

3.0 GENERAL PROCEDURE

3.1 Nonconformances are any deliverable items made by the Company or raw material used by the Company or returned from the Customer that does not meet:

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

3.2 Nonconforming items must be withheld pending disposition by a completed RFS or Bulletin or by direction from Quality. A Calculated Risk Release may [REDACTED]

3.3 All employees are empowered to [REDACTED]

3.4 Upon discovery of nonconforming items, an employee may [REDACTED]

3.5 When an employee cannot bring the item into conformance through immediate rework, the employee shall [REDACTED]

3.6 If an employee or supervisor [REDACTED]

3.7 The employee shall [REDACTED]

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3.8 The employee shall [REDACTED]

3.9 Upon receipt of the RFS, the Quality representative will [REDACTED]

3.10 Quality will then [REDACTED]

3.11 If the nonconforming item is ascertained or estimated to be the fault of a Supplier, Quality may [REDACTED]

3.12 Quality will also [REDACTED]

3.13 The RFS shall [REDACTED]

3.14 The MRB consists of the following managers, at a minimum:

- [REDACTED]
- [REDACTED]
- [REDACTED]

3.14.1 MRB Qualification

A Material Review Board member must:

- 1) [REDACTED]; or
- 2) [REDACTED]

3.15 In the event of a non-unanimous decision, the [REDACTED] shall [REDACTED]

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3.16 The Company shall [REDACTED]

4.0 DISPOSITIONS

4.1 Dispositions are classified as Major, Minor or None.

4.1.1 Major: [REDACTED]

4.1.2 Minor: [REDACTED]

4.1.3 None: [REDACTED]

4.2 MRB dispositions may include, but are not limited to:

4.2.1 Clarification [REDACTED]

4.2.2 Conditional Acceptance [REDACTED]

4.2.3 Non-Deliverable [REDACTED]

4.2.4 Notification
It is possible that a Continuous Improvement Opportunity may not exist for all reported conditions. In this case [REDACTED]

4.2.5 Precautionary [REDACTED]

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4.2.6 Repair (Non-Standard and Standard)

[Redacted]

4.2.7 Request for Waiver/Deviation/Variance

When a supply is considered 'fit-for-use' by the MRB but departs from [Redacted]

4.2.8 Return to Supplier (Receiving Inspection)

[Redacted]

4.2.9 Rework (Non-Standard and Standard)

[Redacted]

4.2.10 Scrap

[Redacted]

5.0 CUSTOMER DISPOSITION AUTHORITY

5.1 Major: [Redacted].

5.2 RTV and Scrap dispositions are not [Redacted].

5.3 Minor: [Redacted]

5.4 Scrap, RTV or Standard Rework dispositions are not [Redacted].

5.5 None: [Redacted].

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6.0 PROCESSING SCRAP

6.1 Nonconforming items dispositioned as scrap are [REDACTED]

6.2 Such scrap is [REDACTED]

6.3 Identifying scrap with markings is unacceptable unless [REDACTED]

6.4 Scrap is controlled internally so as not to be made available for possible theft, which [REDACTED]

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RECEIVING INSPECTION

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Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
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Abstract:

This document describes the receiving inspection process.

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1.0 PURPOSE

This document defines the Receiving process including receiving inspection activities and includes or makes reference to procedures for the various activities within the process.

2.0 THEORY

Receiving is the first line of defense to prevent sub-standard supplies from affecting the Company's process or product quality; however, sampling and 100% incoming inspection is only a part of the collection of applications that are necessary to assure the release of conforming supplies to stock. Receiving inspection cannot provide 100% assurance of product or process quality because the affect that the supplies have on production-level activities cannot be assessed or verified - only by 100% use of supplies will defects be detected in product or process quality.

As a result of teaming and intelligent design, the Company ensures that deliverable supplies meet Customer requirements prior to packaging and shipping.

3.0 PROCEDURE: RECEIVING

- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]
- [REDACTED]

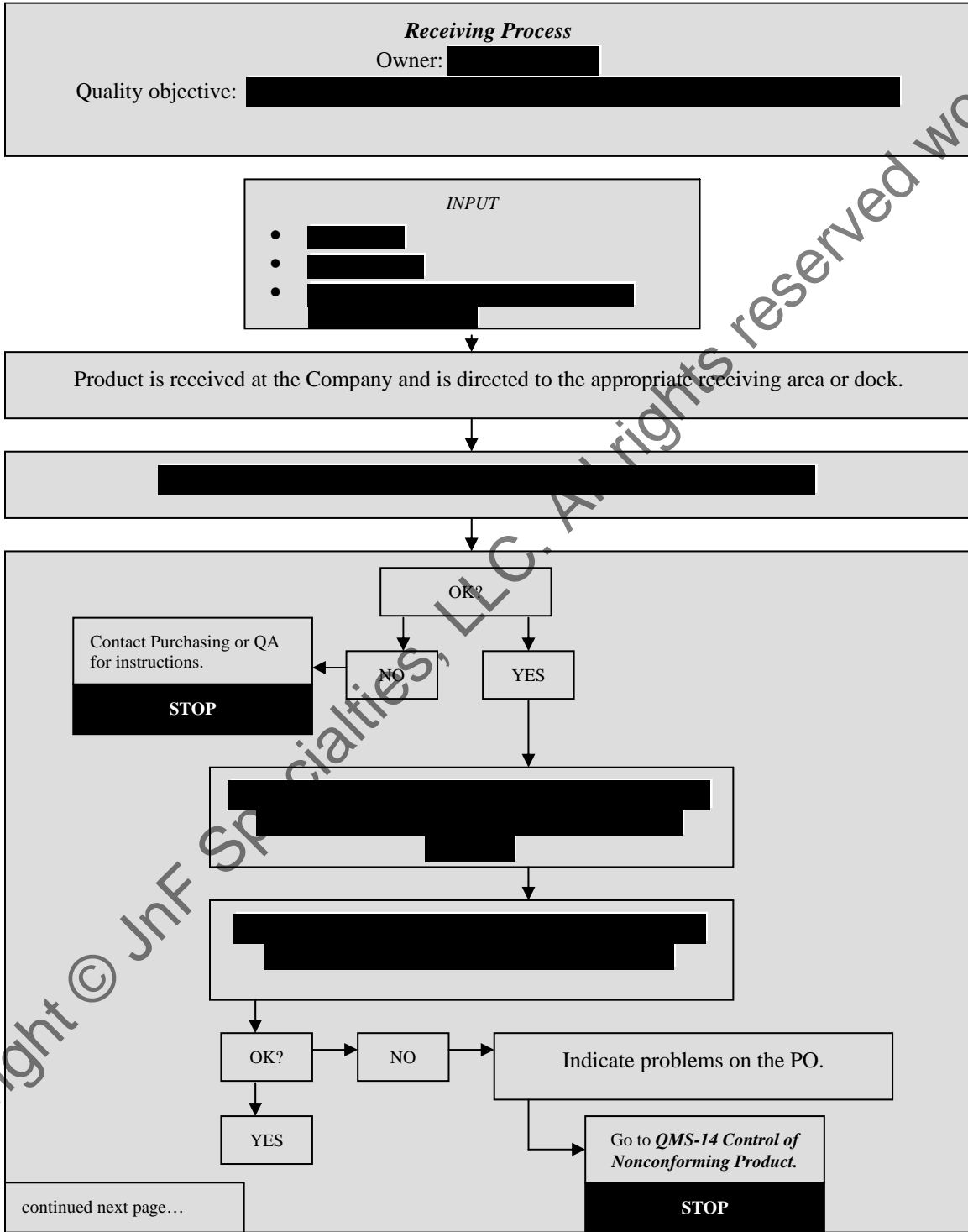
4.0 PROCEDURE: RECEIVING INSPECTION

4.1 The inspector will [REDACTED]

4.2 Inspections are performed according to [REDACTED]

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PROCESS MAP



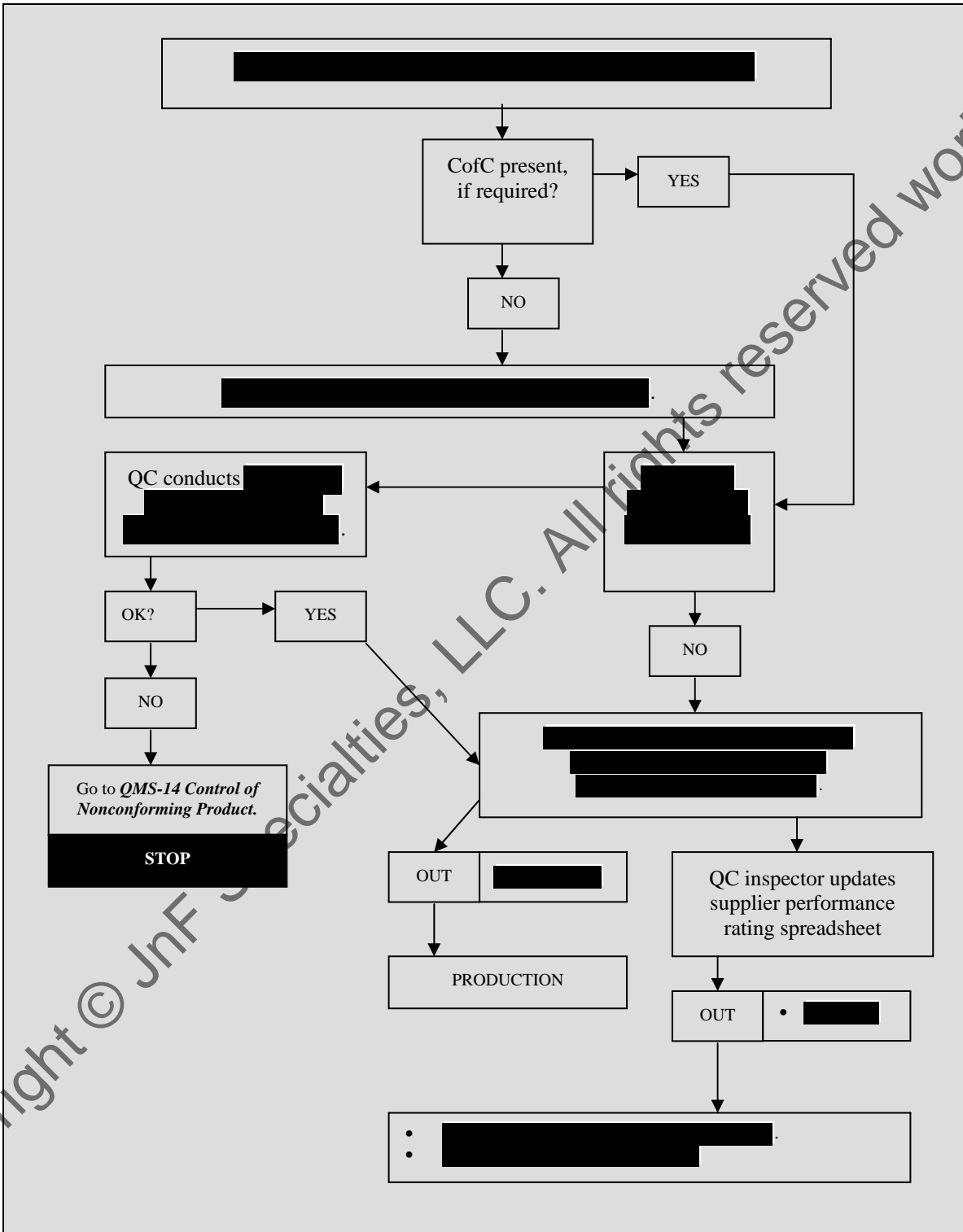
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APPENDIX A - RECEIVING INSPECTION WORK INSTRUCTIONS

Op 1: [Redacted]

Op 2: [Redacted]

Op 3: [Redacted]

Op 4: [Redacted]

Op 5: [Redacted]

Op 6: [Redacted]

Op 7: SAMPLING PLAN: [Redacted]

Op 8: [Redacted] then [Redacted]

Op 9: [Redacted] then [Redacted]

Op 10: [Redacted]

Op 11: When raw material is accepted only by review of Supplier certificate of analysis, review the current Approved Supplier List for item criticality and perform the following activities:

For critical item: [Redacted]

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For non-critical item:

[Redacted]

Op 12:

[Redacted]

Op 13:

[Redacted]

Op 14:

[Redacted]

Op 15:

[Redacted]

Op 16: Complete the inspection record following its format (record applicable M&TE, lot traceability, etc)

Op 17:

Op 18:

[Redacted]

Op 19:

[Redacted]

Op 20:

[Redacted]

[Redacted]

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APPENDIX B - PURCHASE ORDER PROCESSING

Step	IF	THEN
1	Supply is not the Last Item on PO	Produce a copy of the PO - attach packing slip to the copy of PO and forward to Purchasing. Forward [REDACTED]
2	Supply is the last Item on PO	Attach the Supplier's packing slip to the original PO - produce a copy of the PO - forward [REDACTED]
2.1	Supply is the last Item on PO	Optional: [REDACTED]

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VERIFICATION AND VALIDATION

Program Name:		Job Number:	
Part Number:		Rev:	
REA:		Date:	

<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]
<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]
<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]	<input type="checkbox"/> [REDACTED]
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QC Tags (shrink to fit application – send template to printer to make multi-part form)

GOOD MATERIAL TAG			Your Logo		
P/N:		PO #:		Date:	
Dwg #:		Rev:		Lot #:	
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GOOD MATERIAL TAG			Your Logo		
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WITHHOLD TAG

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BAD MATERIAL TAG

Date:		Item Name:	
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P/N:		Rev:		Date:
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Initials:				

Form Rev: Orig

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WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

WITHHOLD TAG		Your Logo	
Date:		Item Name:	
PO #:		Item Part Number:	
Lot #:		Material Report #:	
S/N:		Initials:	
Reason for Withholding:			

Form Rev: Orig

Helpful Hints:

Purchase "presentation" paper in choice of color then print and cut labels as required.

Purchase peel-and-stick labels of the correct size then print as required.

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

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P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

ACCEPTED MATERIAL		Your Logo	
THIS MATERIAL HAS BEEN INSPECTED AND ACCEPTED			
P/N:		Rev:	Date:
PO#:		Lot#:	
MR#:		Qty Ok:	
Initials:			

Form Rev: Orig

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FINAL INSPECTION
PERFORMED BY _____
YOUR LOGO

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY _____
YOUR LOGO

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY _____
YOUR LOGO

Form Rev: Orig

FINAL INSPECTION
PERFORMED BY _____
YOUR LOGO

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FINAL INSPECTION
PERFORMED BY _____
YOUR LOGO

Form Rev: Orig

Helpful Hints:

Purchase "presentation" paper in choice of color then print and cut labels as required.

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CORRECTIVE AND PREVENTIVE ACTION

Origination Date: XXXX

Document Identifier:	Corrective and Preventive Action
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:

This document describes the procedures used to correct and prevent nonconformities.

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Your Logo	Your Company Name	Corrective and Preventive Action
CAGE: xxxxx		Rev: Orig

REVISION LOG

Issue	Date	Comment	Author
0-0			

DOCUMENT CHANGE RECORD

Issue	Item	Reason for Change

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Your Logo	Your Company Name	Corrective and Preventive Action
CAGE: xxxxx		Rev: Orig

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4.0 PROCEDURE: INVESTIGATION & CORRECTIVE ACTION REQUESTS (ICARs) 5

5.0 PROCESS MAP..... 6

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Your Logo	Your Company Name	Corrective and Preventive Action
CAGE: xxxxx		Rev: Orig

1.0 PURPOSE

This document provides details and procedures for the process governing the discovery, reporting, resolution and recording of actions taken to correct or prevent nonconformities.

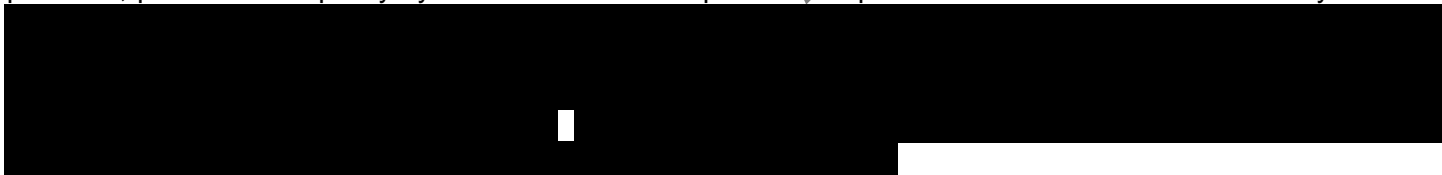
2.0 THEORY

Corrective action is taken to correct nonconformities, which could be product defects found during production, errors found in documents, equipment problems or problems related to how the Company performs functions in its processes. "Corrective action" is simply the "fix" that corrects the problem.

Whenever we take corrective action we also attempt to prevent the problem from recurring, which is known as "preventive action". There are times when preventive action is a standalone activity, specifically when reporting a problem that does not exist at the moment but could exist if something isn't done. Sources for preventive action opportunities include risk management, error proofing, failure mode and effects analysis and reports of product problems by external sources. Having a formal system to record and resolve both existing and potential problems ensures that these problems do not occur or reoccur, thereby improving our products, processes and work environment.

3.0 PROCEDURE: INTERNAL REPORTS

3.1 The Company utilizes a Request for Support (RFS) form to record both nonconformances related to its products, process and quality system as well as compliments or positive feedback. The form and system are



3.2 ALL employees are empowered with the ability to report sources of problems and nonconformances.

3.3 No disciplinary action may be attached to the submission of RFS's.

3.4 The Quality Manager has been assigned the role of [REDACTED].

3.5 For the processing and routing of RFS's see Process Map.

3.6 If the responsible manager determines [REDACTED]

3.7 Actions taken shall [REDACTED]

3.8 The Quality Manager shall [REDACTED]

Your Logo	Your Company Name	Corrective and Preventive Action
CAGE: xxxxx		Rev: Orig

3.9 In addition to corrective action efforts, management shall [REDACTED]

3.10 The management review process shall [REDACTED]

3.11 Where product is suspected of a nonconformance, the Company shall [REDACTED]

4.0 PROCEDURE: INVESTIGATION & CORRECTIVE ACTION REQUESTS (ICAR's)

4.1 Any purchasing agent may [REDACTED]

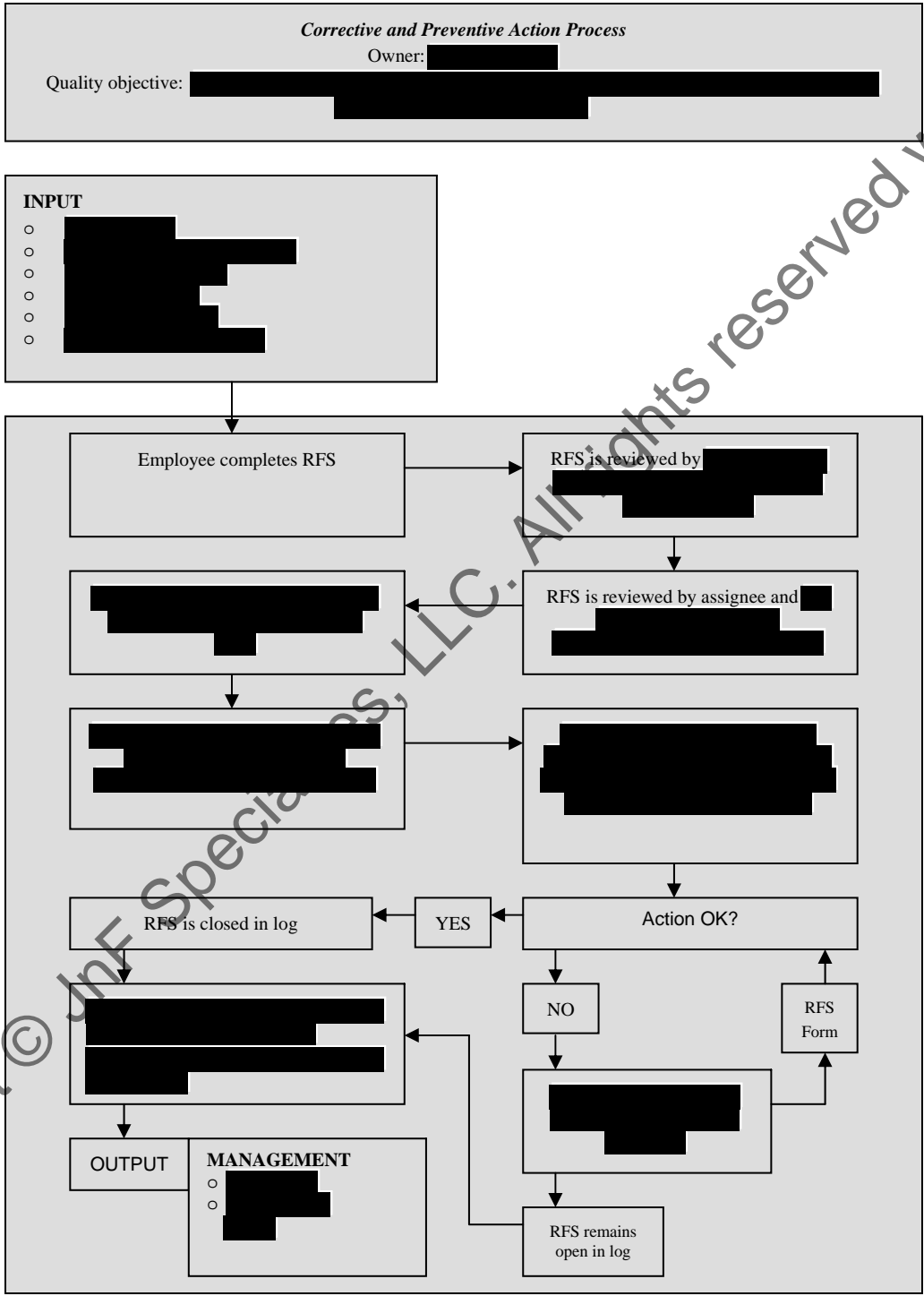
4.2 ICAR's are processed through the same steps as the RFS but are routed to the Supplier for root cause analysis and action planning. ICAR's are logged separately.

4.3 Failure of a Supplier to respond to an ICAR or to respond with an insufficient action plan may [REDACTED]

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5.0 PROCESS MAP



REQUEST FOR CORRECTIVE ACTION

1	RFCA#:	Date:	NCMR#:
2	<input type="checkbox"/> Internal	<input type="checkbox"/> External	
3	To:	Return To: Your Co. Attention: Address:	
4	<div style="background-color: black; width: 100%; height: 10px; margin-bottom: 5px;"></div> <div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> </div> <div style="background-color: black; width: 100%; height: 10px; margin-bottom: 5px;"></div> <div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> </div> <div style="background-color: black; width: 100%; height: 10px; margin-bottom: 5px;"></div> <div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> </div>		
9	<div style="background-color: black; width: 100%; height: 10px; margin-bottom: 5px;"></div> <div style="background-color: black; width: 100%; height: 10px; margin-bottom: 5px;"></div> <div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> </div> <div style="background-color: black; width: 100%; height: 10px; margin-bottom: 5px;"></div> <div style="display: flex; justify-content: space-between;"> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> <div style="width: 30%;"><input type="checkbox"/></div> </div>		

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Your Logo

**INVESTIGATION AND
CORRECTIVE ACTION
REQUEST**

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ICAR Responsible Supplier: _____

Customer: _____ **Part#** _____ **Applicable Customer P.O or Job #** _____

Customer CA or corresponding documentation received? Y N **Number:** _____

[Redacted content]

9. Congratulate the Team!

Your Logo

REQUEST FOR DEVIATION / WAIVER

1. NAME AND ADDRESS

(Your Co)

2. CAGE CODE

3. RDW NO.

4. PURCHASE ORDER NO.

5. DATE

4a. PURCHASE ORDER LINE NO.

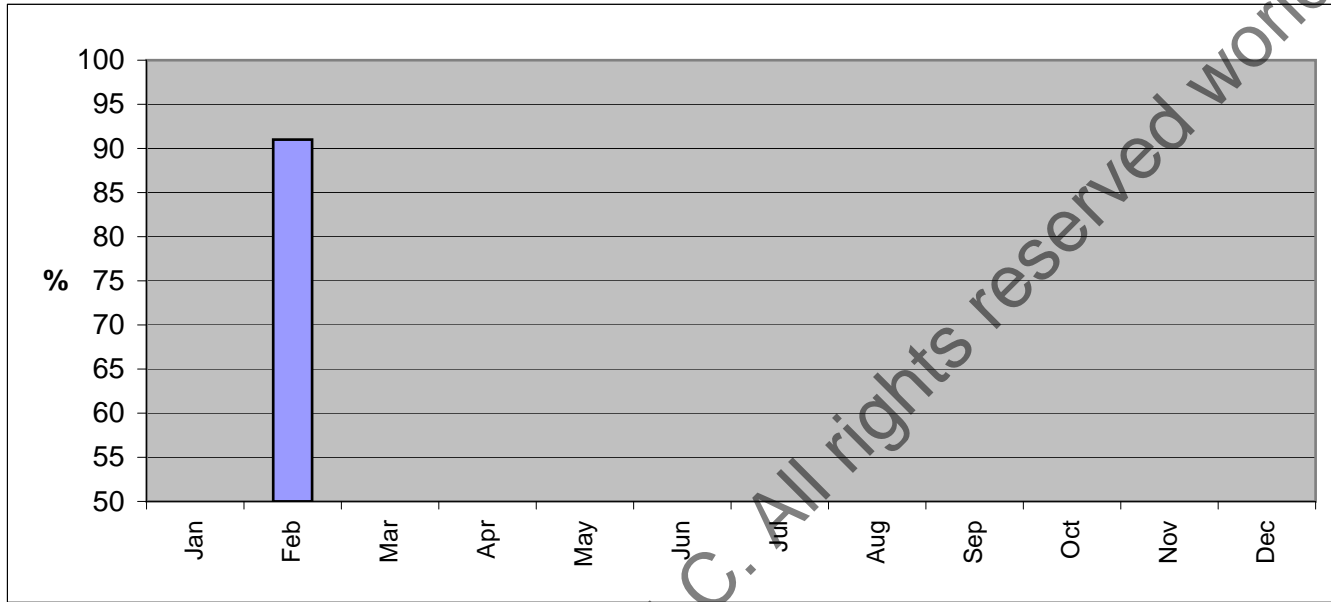
6. DEVIATION WAIVER

7. [REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					

12. [REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					
[REDACTED]					

Form Rev: Orig

Supplier Performance Rating



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Supplier Number: #

Production Quality Performance

Month	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov
Performance Report		91									
PDR Score		1									
PQR Score		.7									
PC Score		1									
RFCA Score		1									

Performance Rating Standards

Gold - 95% to 100%
Silver - 90% to 94%
Bronze - 80% to 89%
Yellow - <80%
Red - <50%

Supplier Name: (name)

Your Company Name

Address

Phone

Fax

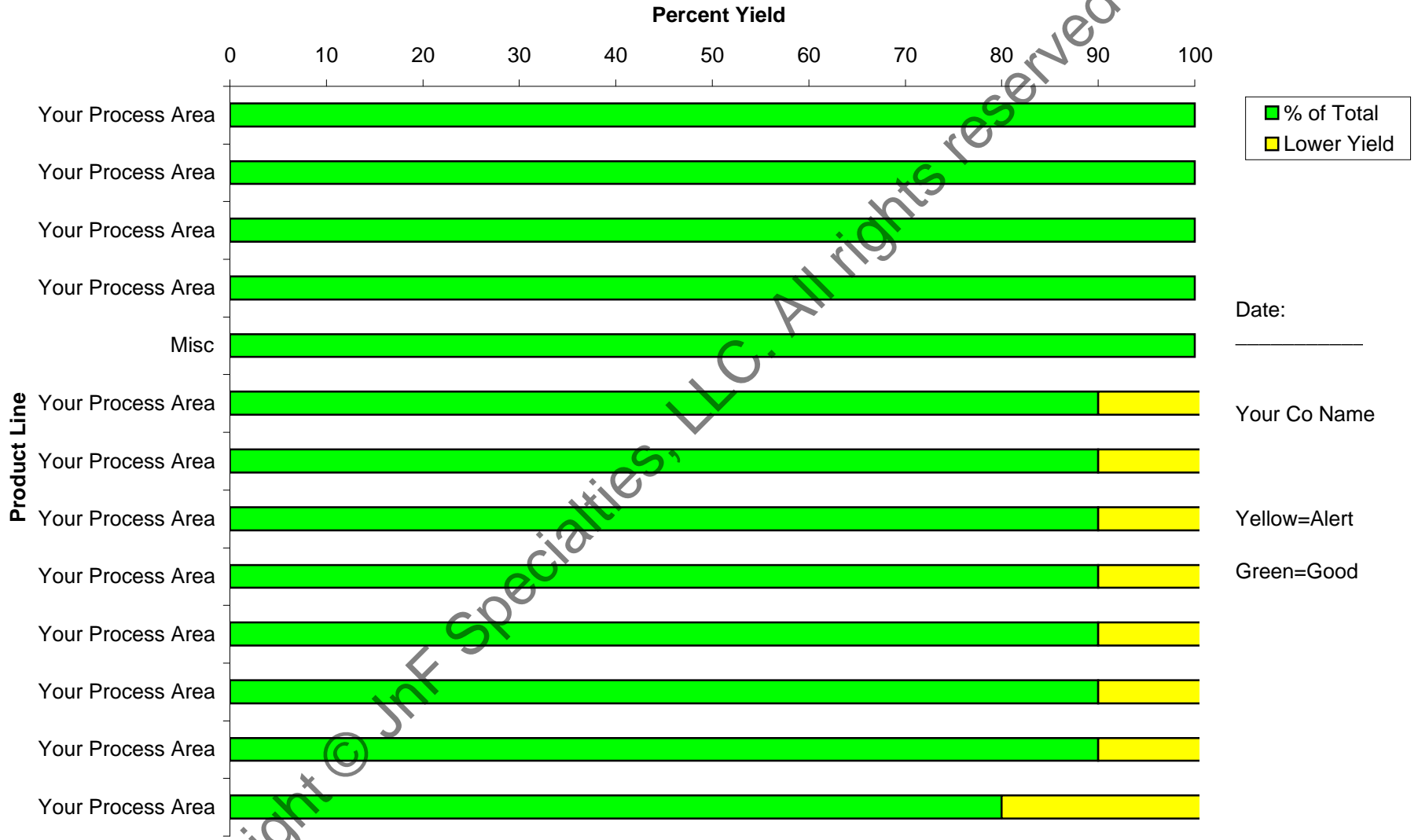
Email

Overall Rating %: 91

Pareto Analysis, (YEAR) Request for Support Trend Chart

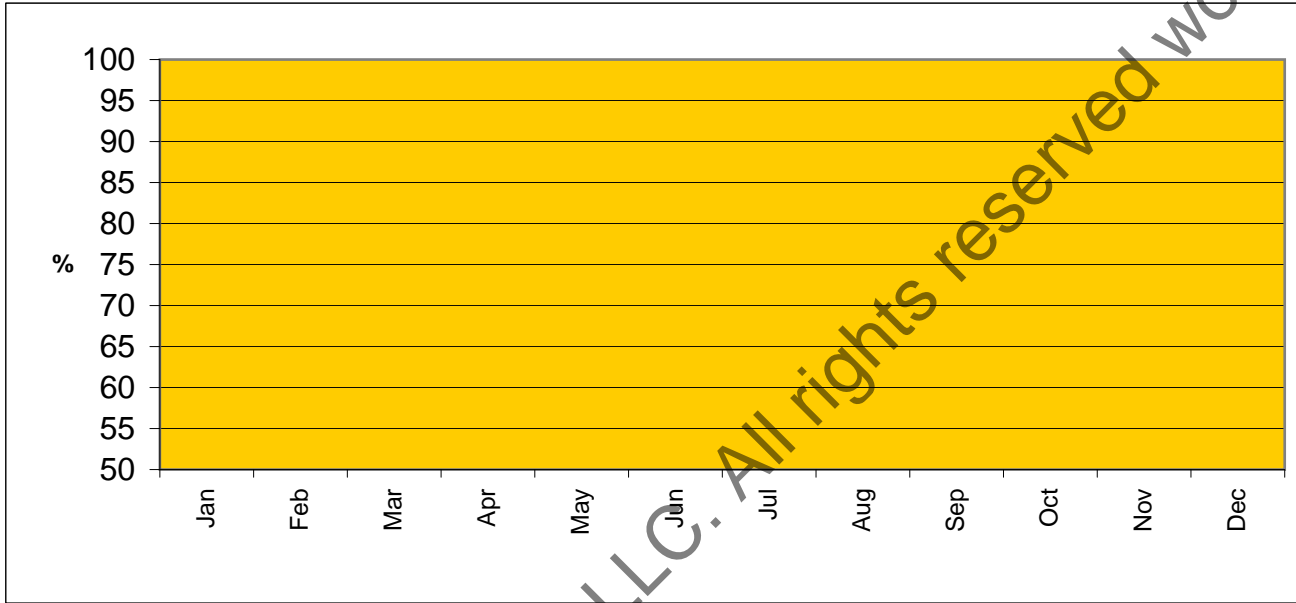


Pareto Analysis, year Product Line Yields



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Product Yield Rating



Product Yield Rating

Month	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	
Average Rating %												
Desired Yield												
Actual Yield												

Form Rev: Orig

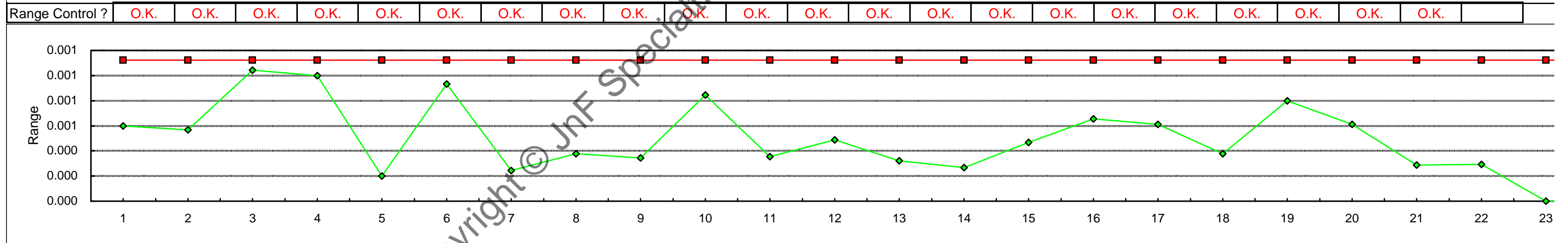
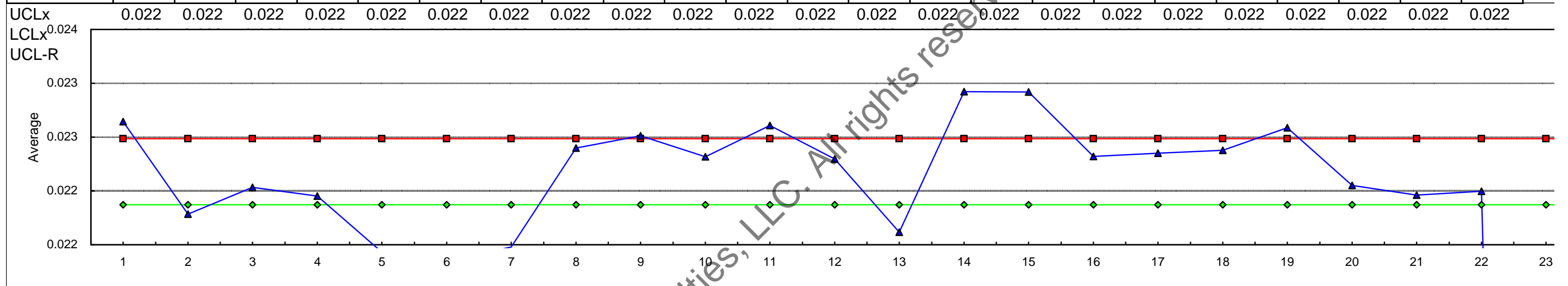
Performance Rating Standards

Gold - 95% to 100%
Silver - 90% to 94%
Bronze - 80% to 89%
Yellow - <80%
Red - <50%

Product Name:
Overall Rating %: #DIV/0!

Your Co Name
 Your Address
 Phone: Your#
 Fax: Your#
 Email: Your email

Sample #	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	19	18	19	20	21	22
Comments:																							
Date:																							
Time:	11:19	11:35	11:51	12:07	12:30	01:30	03:30	06:09	06:58	07:46	08:34	09:22	10:11	10:59	11:47	12:35	01:24	01:24	02:12	04:44	05:33	06:21	
Operator:	YS	YS	YS	YS	RC	RC	RC	IS	IS	RC	DD	DD	IS	IS	RC	DD	YS	DD	DD	IS	IS	IS	
Sample 1	0.0229	0.0215	0.0218	0.0217	0.0214	0.0208	0.0216	0.0225	0.0225	0.0223	0.0226	0.0221	0.0214	0.0230	0.0226	0.0227	0.0222	0.0223	0.0230	0.0221	0.0220	0.0220	
Sample 2	0.0228	0.0220	0.0216	0.0224	0.0213	0.0216	0.0213	0.0223	0.0226	0.0224	0.0227	0.0225	0.0217	0.0228	0.0227	0.0220	0.0226	0.0224	0.0226	0.0219	0.0218	0.0218	
Sample 3	0.0223	0.0217	0.0226	0.0220	0.0215	0.0217	0.0216	0.0222	0.0224	0.0228	0.0224	0.0222	0.0217	0.0229	0.0231	0.0226	0.0221	0.0226	0.0222	0.0219	0.0219	0.0220	
Sample 4	0.0224	0.0218	0.0222	0.0214	0.0215	0.0212	0.0215	0.0224	0.0223	0.0219	0.0227	0.0221	0.0217	0.0229	0.0230	0.0222	0.0222	0.0224	0.0228	0.0219	0.0219	0.0220	
Sample 5	0.0227	0.0219	0.0220	0.0223	0.0215	0.0214	0.0215	0.0225	0.0227	0.0222	0.0226	0.0226	0.0217	0.0230	0.0231	0.0222	0.0227	0.0222	0.0223	0.0225	0.0221	0.0221	
Sum:	0.1132	0.1089	0.1102	0.1098	0.1072	0.1067	0.1074	0.1120	0.1126	0.1116	0.1130	0.1115	0.1081	0.1146	0.1146	0.1116	0.1118	0.1119	0.1129	0.1103	0.1098	0.1100	
Average: (x)	0.0226	0.0218	0.0220	0.0220	0.0214	0.0213	0.0215	0.0224	0.0225	0.0223	0.0226	0.0223	0.0216	0.0229	0.0229	0.0223	0.0224	0.0224	0.0226	0.0221	0.0220	0.0220	
Range - R	0.0006	0.0006	0.0010	0.0010	0.0002	0.0009	0.0002	0.0004	0.0003	0.0008	0.0004	0.0005	0.0003	0.0003	0.0005	0.0007	0.0006	0.0004	0.0008	0.0006	0.0003	0.0003	
Xbar Control ?	?	?	O.K.	O.K.	?	?	?	O.K.	?	O.K.	?	O.K.	?	?	?	O.K.	O.K.	O.K.	?	O.K.	O.K.	O.K.	



The upper and lower control limit calculations are located under the x-bar graph

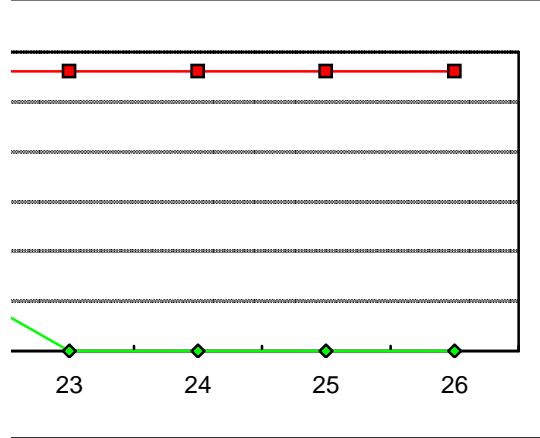
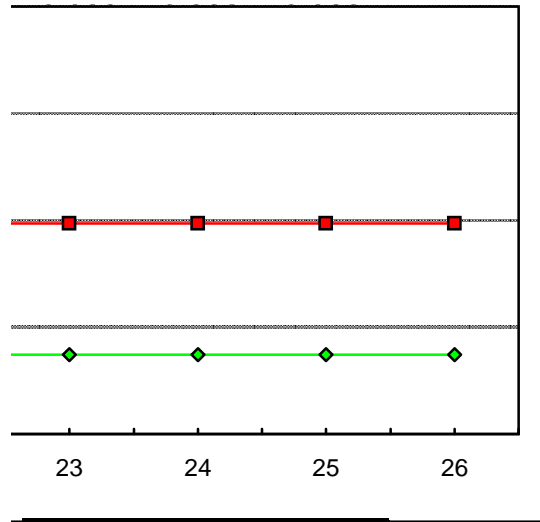
23	24	25

Grand Avg

Std.Dev.
0.0005

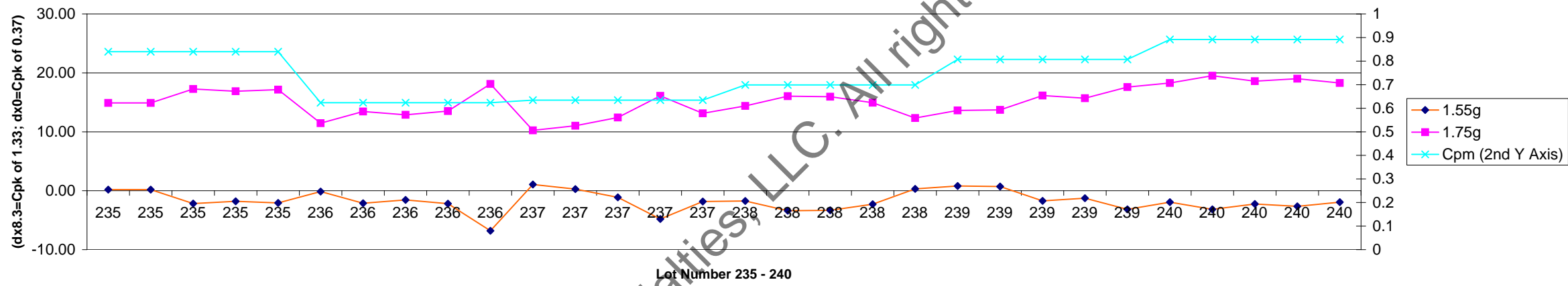
0.0222
0.0005

0.022 0.022 0.022



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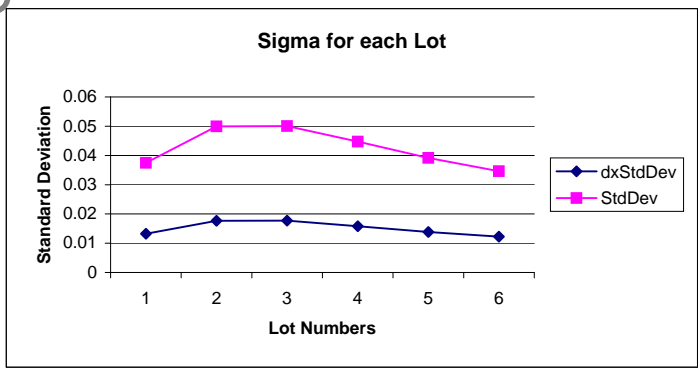
USL, g:	1.75					LSL, g: 1.55					Sample Process										Process Acceptance Chart									
Lot#:	235					236					237					238					239									
Comment:																														
Date:																														
1	1.76	1.75	1.84	1.82	1.77	1.74	1.78	1.76	1.78	1.91	1.75	1.76	1.78	1.78	1.80	1.80	1.84	1.85	1.80	1.77	1.76									
2	1.73	1.73	1.84	1.80	1.84	1.76	1.71	1.79	1.79	1.84	1.75	1.75	1.78	1.79	1.86	1.82	1.71	1.85	1.77	1.77	1.76									
3	1.75	1.74	1.73	1.81	1.76	1.73	1.76	1.76	1.77	1.93	1.68	1.69	1.79	1.88	1.73	1.81	1.85	1.77	1.81	1.80	1.72									
4	1.74	1.66	1.76	1.78	1.75	1.76	1.78	1.80	1.74	1.88	1.67	1.74	1.73	1.85	1.75	1.83	1.77	1.77	1.78	1.76	1.77									
5	1.77	1.81	1.74	1.75	1.75	1.73	1.84	1.81	1.79	1.85	1.78	1.76	1.77	1.88	1.83	1.78	1.85	1.81	1.80	1.67	1.73									
6	1.79	1.77	1.80	1.76	1.77	1.76	1.81	1.71	1.78	1.88	1.79	1.73	1.75	1.81	1.79	1.76	1.79	1.80	1.78	1.66	1.75									
7	1.72	1.76	1.77	1.75	1.83	1.76	1.81	1.78	1.83	1.85	1.70	1.75	1.76	1.83	1.77	1.70	1.84	1.77	1.76	1.78	1.71									
8	1.72	1.76	1.75	1.72	1.75	1.78	1.81	1.81	1.83	1.82	1.73	1.78	1.80	1.86	1.73	1.72	1.78	1.80	1.79	1.75	1.71									
Average:	1.75	1.75	1.78	1.77	1.78	1.75	1.79	1.78	1.79	1.87	1.73	1.75	1.77	1.84	1.78	1.78	1.80	1.80	1.79	1.75	1.74									



81
 .63
 K.
 113
 0716

$$dx = \frac{avg - LSL}{\sigma / \sqrt{n}} > 4\sqrt{n} - 3$$

$$dx = \frac{USL - avg}{\sigma / \sqrt{n}} > 4\sqrt{n} - 3$$



dx provides a means to answer the question:
 Are we making acceptable parts? -- instead of -- Are we in control?

The Cpm capability index depends on both variability and centering.

This is not a control chart

Acceptance is based on the Lower Acceptance Limit

Process Acceptance Chart

239	239	239	239	240	240	240	240	240
1.79	1.72	1.78	1.77	1.80	1.73	1.78	1.80	1.76
1.67	1.74	1.80	1.80	1.80	1.79	1.77	1.84	1.84
1.74	1.80	1.77	1.79	1.76	1.84	1.79	1.79	1.73
1.75	1.81	1.78	1.90	1.78	1.83	1.73	1.80	1.73
1.76	1.80	1.73	1.78	1.76	1.76	1.75	1.78	1.80
1.74	1.77	1.73	1.79	1.78	1.81	1.80	1.73	1.85
1.74	1.75	1.78	1.81	1.72	1.79	1.79	1.76	1.77
1.73	1.80	1.77	1.71	1.79	1.76	1.81	1.76	1.71
1.74	1.77	1.77	1.79	1.77	1.79	1.78	1.78	1.77
0.72	-1.71	-1.26	-3.16	-1.94	-3.17	-2.25	-2.66	-1.94
13.72	16.15	15.70	17.60	18.29	19.52	18.60	19.01	18.29
O.K.	Out	Out	Out	Out	Out	Out	Out	Out
0.1113	0.1113	0.1113	0.1113	0.1113	0.1113	0.1113	0.1113	0.1113
0.80716	0.80716	0.80716	0.80716	0.89172	0.89172	0.89172	0.89172	0.89172

Lot#:	235	236	237	238	239	240
StdDev:	0.01325	0.01766	0.0177	0.01582	0.01385	0.01223
StdDev:	0.03748	0.04995	0.05005	0.04473	0.03918	0.0346
Avg:	1.765	1.79525	1.77275	1.783	1.76275	1.77925

Add to Cart

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