

Test 1 FORD

Nominal 20,0000 Tol Sup 0,040
Unité mm Tol Inf -0,040

Nb Echantillon : 100 Taille Echantillon 5 Nb Pieces : 500
Moyenne des moyennes 20,0046 Moyenne carte 2 : 0,0083 Sygma estimé 0,0089

CARTES DE CONTROLE

Hors Tolerance

Hors Limite

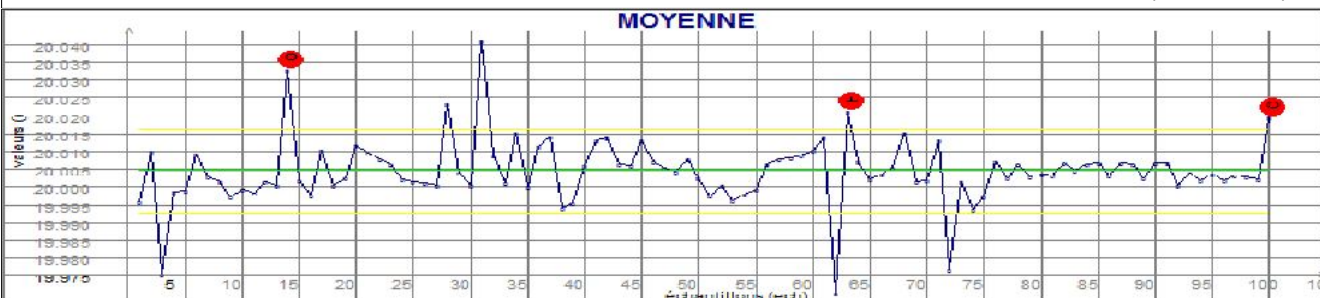


Hors Contrôle

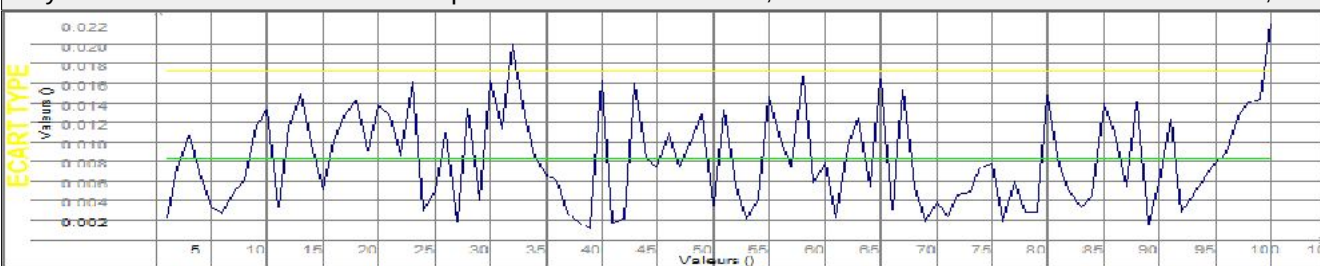
20



100 Echantillon Du 26/07/2002 12:15: au 26/07/2002 12:15: Max / min 20,06 19,96



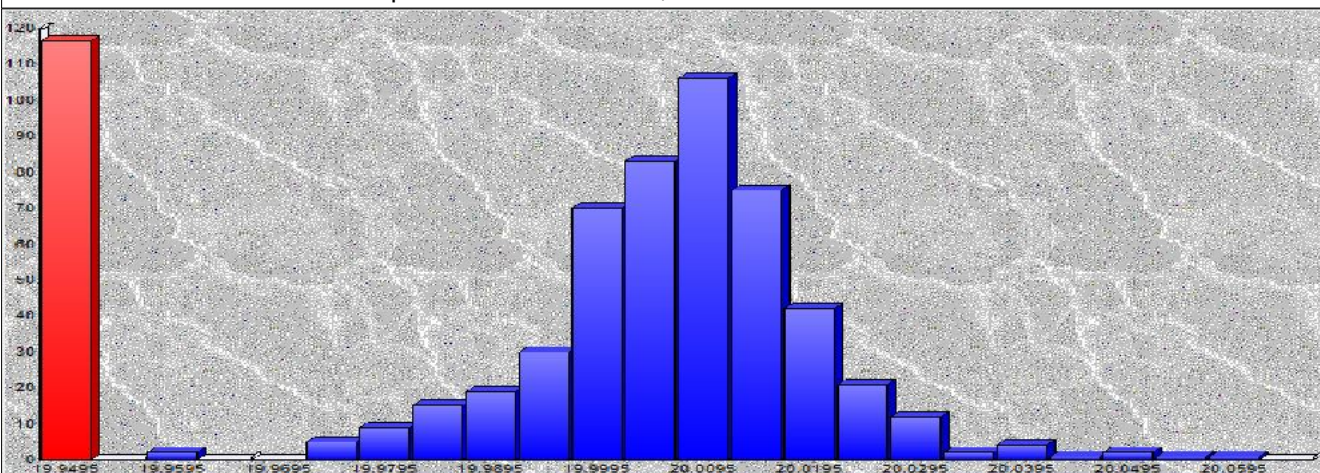
Moyenne = 20,0046 Limite Supérieures de contr 20,016 Limite Inférieure de controle 19,993



Moyenne = 0,0083 Limite Supérieures de contr 0,0173 Limite Inférieure de control 0,0000

HISTOGRAMME

Intervale de classe = 0,0050 Nominal 20,0000
Tol Inf -0,040 Tol Sup 0,040 % Hors tolerance : 1,40 %
Sygma estimé 0,009 Hors 3 sygma = 4,60 %
Cp = 1,07 Cpk = 0,46



Test 1 FORD

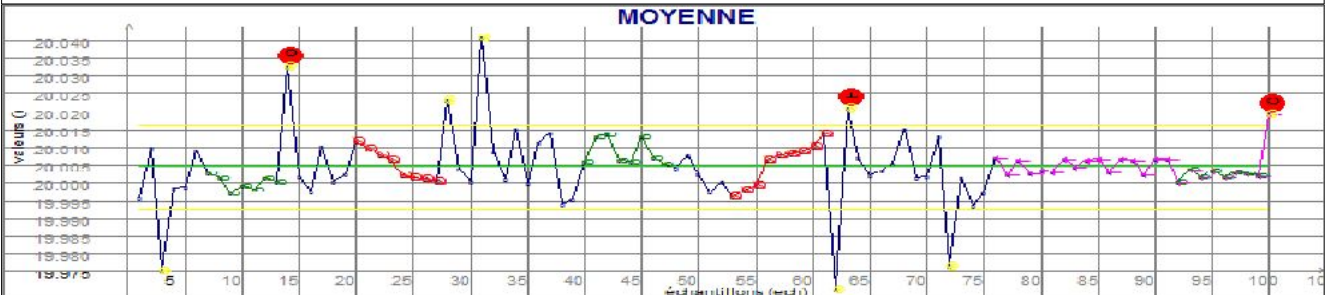
Nominal 20,0000 Tol Sup 0,040
Unité mm Tol Inf -0,040

Nb Echantillon : 100 Taille Echantillon 5 Nb Pieces : 500
Moyenne des moyennes 20,0046 Moyenne carte 2 : 0,0083 Sygma estimé 0,0089

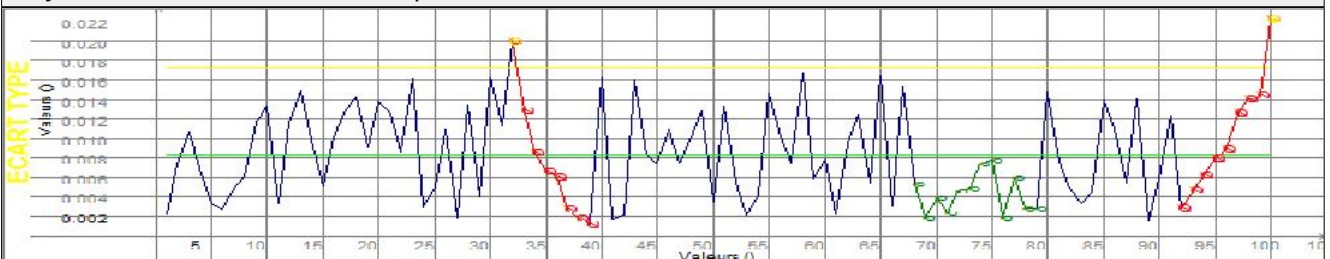
CARTES des TESTS HORS CONTROLE

Hors Tolerance	Hors Limite		Hors Contrôle	
			20	

100 Echantillon Du 26/07/2002 12:15: au 26/07/2002 12:15: Max / min 20,06 19,96



Moyenne = 20,0046 Limite Supérieures de controle 20,016 Limite Inférieure de controle 19,993



Moyenne = 0,0083 Limite Supérieures de control 0,0173 Limite Inférieure de control 0,0000

LISTE DES SITUATIONS HORS CONTROLE

Carte	de	à	N tes	Commentaire
1	63		1	Violation LIMITE de SURVEILLANCE : (20.0214 > 20.0164)
	28		1	Violation LIMITE de SURVEILLANCE : (20.0234 > 20.0164)
	31		1	Violation LIMITE de SURVEILLANCE : (20.0408 > 20.0164)
	62		1	Violation LIMITE de SURVEILLANCE : (19.9704 < 19.9928)
	72		1	Violation LIMITE de SURVEILLANCE : (19.9768 < 19.9928)
	100		1	Violation LIMITE de SURVEILLANCE : (20.0196 > 20.0164)
	3		1	Violation LIMITE de SURVEILLANCE : (19.9754 < 19.9928)
	14		1	Violation LIMITE de SURVEILLANCE : (20.0328 > 20.0164)
	92	99	2	SUITE DE POINTS DU MEME COTE DE LA CIBLE (<)
	40	47	2	SUITE DE POINTS DU MEME COTE DE LA CIBLE (>)
	7	13	2	SUITE DE POINTS DU MEME COTE DE LA CIBLE (<)
	53	61	3	POINTS CONSECUTIFS MONTANTS (/)
	20	27	3	POINTS CONSECUTIFS DESCENDANTS (\)
	93	100	8	SUITE DE POINTS DANS LE TIERS CENTRAL
	76	92	8	SUITE DE POINTS DANS LE TIERS CENTRAL
2	32		1	Violation LIMITE de SURVEILLANCE : (0.0200 > 0.0173)
	100		1	Violation LIMITE de SURVEILLANCE : (0.0223 > 0.0173)
	68	79	2	SUITE DE POINTS DU MEME COTE DE LA CIBLE (<)
	92	100	3	POINTS CONSECUTIFS MONTANTS (/)
	32	39	3	POINTS CONSECUTIFS DESCENDANTS (\)

Test 1 FORD												
Nominal	20,0000	Tol Sup	0,040									
Unité	mm	Tol Inf	-0,040									
Nb Echantillon : 100		Taille Echantillon		5		Nb Pieces		:		500		
Moyenne des moyennes		20,0046		Moyenne carte 2		:		0,0083		Sygma estimé 0,0089		
LISTE DES ECHANTILLONS												
DATE	HEURE	Mesures										COD
26/07/2002	12:15:17	19,993	19,995	19,997	19,995	19,999						
	12:15:17	20,006	20,010	20,010	20,022	20,002						
	12:15:17	19,958	19,982	19,973	19,985	19,979						
	12:15:17	19,996	20,006	19,988	20,002	20,001						
	12:15:17	19,995	19,998	20,002	20,003	19,998						
	12:15:17	20,009	20,006	20,012	20,007	20,012						
	12:15:17	20,001	20,006	20,006	19,995	20,006						
	12:15:17	20,004	20,002	20,006	19,991	20,005						
	12:15:17	19,986	19,984	20,010	20,001	20,005						
	12:15:18	19,991	20,011	20,006	19,980	20,009						
	12:15:18	19,996	19,996	20,001	20,003	19,996						
	12:15:18	20,002	20,018	20,006	19,987	19,995						
	12:15:18	20,019	19,981	20,005	19,990	20,007						
	12:15:18	20,046	20,039	20,028	20,030	20,021						O
	12:15:18	19,996	20,003	20,005	19,997	20,008						
	12:15:18	20,008	19,985	20,005	19,989	20,002						
	12:15:18	20,005	20,018	20,007	19,994	20,028						
	12:15:18	20,010	20,013	19,977	19,999	20,004						
	12:15:19	19,998	19,995	20,013	19,995	20,012						
	12:15:19	20,011	20,026	20,017	19,989	20,015						
	12:15:19	20,019	20,004	20,026	20,004	19,995						
	12:15:19	20,018	20,013	19,998	20,000	20,011						
	12:15:19	20,018	20,005	20,024	19,982	20,003						
	12:15:19	20,000	20,007	20,003	20,001	20,000						
	12:15:19	19,996	20,004	20,009	20,000	19,999						
	12:15:19	19,999	20,007	19,993	20,017	19,990						
	12:15:19	20,000	20,001	20,003	19,998	20,001						
	12:15:20	20,039	20,006	20,019	20,018	20,035						
	12:15:20	19,998	20,005	20,007	20,002	20,008						
	12:15:20	20,013	19,983	19,987	20,021	19,999						
	12:15:20	20,025	20,035	20,055	20,043	20,046						
	12:15:20	20,025	20,023	19,985	19,989	20,022						
	12:15:20	19,999	20,009	19,982	20,000	20,016						
	12:15:20	20,018	20,020	20,002	20,012	20,024						
	12:15:20	19,993	20,007	20,007	19,997	19,996						
	12:15:20	20,015	20,012	20,005	20,019	20,006						
	12:15:21	20,017	20,013	20,017	20,011	20,013						
	12:15:21	19,995	19,993	19,993	19,993	19,997						
	12:15:21	19,997	19,994	19,996	19,995	19,996						
	12:15:21	20,009	20,016	19,979	20,021	20,006						
	12:15:21	20,015	20,011	20,013	20,012	20,015						
	12:15:21	20,016	20,011	20,013	20,016	20,013						
	12:15:21	20,017	20,012	20,022	20,000	19,982						
	12:15:21	20,000	19,998	20,007	20,007	20,019						
	12:15:21	20,020	20,015	20,018	20,012	20,001						
	12:15:22	20,014	19,998	19,994	20,020	20,010						

DATE	HEURE	Mesures										CODE
	12:15:22	20,010	19,998	19,998	20,015	20,006						
	12:15:22	20,000	20,011	19,988	20,012	20,010						
	12:15:22	20,009	20,012	20,019	19,986	20,014						
	12:15:22	20,002	20,003	20,006	19,997	20,005						
	12:15:22	19,997	19,977	20,011	19,996	20,008						
	12:15:22	20,008	19,996	19,999	20,004	19,995						
	12:15:22	19,995	19,995	20,000	19,995	19,996						
	12:15:22	19,998	19,997	19,992	20,002	20,002						
	12:15:23	20,007	19,978	20,009	19,991	20,013						
	12:15:23	20,010	19,993	20,005	20,004	20,021						
	12:15:23	19,995	20,012	20,008	20,014	20,010						
	12:15:23	19,998	20,025	19,990	20,027	20,001						
	12:15:23	20,003	20,012	20,002	20,013	20,014						
	12:15:23	20,005	20,007	20,003	20,015	20,022						
	12:15:23	20,014	20,011	20,015	20,017	20,013						
	12:15:23	19,976	19,970	19,971	19,955	19,980						
	12:15:23	20,020	20,034	20,001	20,026	20,026						H
	12:15:24	20,001	20,007	20,016	20,006	20,006						
	12:15:24	20,020	19,987	20,014	20,007	19,983						
	12:15:24	20,001	20,000	20,005	20,006	20,007						
	12:15:24	20,024	20,002	19,989	19,994	20,019						
	12:15:24	20,021	20,011	20,009	20,020	20,016						
	12:15:24	20,003	19,999	20,000	20,002	20,003						
	12:15:24	19,997	20,005	20,003	19,999	20,006						
	12:15:24	20,012	20,011	20,016	20,015	20,011						
	12:15:24	19,976	19,982	19,981	19,971	19,974						
	12:15:24	20,000	20,007	19,996	19,998	20,006						
	12:15:25	20,003	19,999	19,988	19,985	19,994						
	12:15:25	19,992	20,001	19,990	20,009	19,994						
	12:15:25	20,008	20,005	20,010	20,007	20,006						
	12:15:25	20,005	19,993	20,006	20,001	20,008						
	12:15:25	20,006	20,003	20,005	20,009	20,010						
	12:15:25	20,006	20,001	19,999	20,005	20,003						
	12:15:25	20,015	20,009	20,011	19,978	20,006						
	12:15:25	20,010	19,992	20,008	20,007	19,999						
	12:15:25	20,008	20,009	20,000	20,013	20,005						
	12:15:26	20,004	20,002	20,008	20,008	20,001						
	12:15:26	20,000	20,011	20,010	20,008	20,004						
	12:15:26	20,011	19,983	20,020	20,010	20,010						
	12:15:26	20,012	19,984	20,005	20,008	20,007						
	12:15:26	20,007	20,008	19,998	20,013	20,009						
	12:15:26	20,013	20,013	20,008	20,017	19,982						
	12:15:26	20,000	20,002	20,004	20,004	20,003						
	12:15:26	19,999	20,006	20,004	20,011	20,014						
	12:15:26	19,988	20,002	20,015	20,011	20,019						
	12:15:27	20,002	19,999	20,002	20,003	19,996						
	12:15:27	19,996	20,008	20,004	20,006	20,006						
	12:15:27	20,003	20,005	20,005	19,991	20,006						
	12:15:27	19,997	20,002	19,996	20,013	20,011						
	12:15:27	19,992	20,005	19,993	20,012	20,007						
	12:15:27	20,018	19,994	20,008	20,010	19,987						
	12:15:27	20,011	19,979	20,005	20,005	20,015						
	12:15:27	19,988	20,025	19,999	19,993	20,006						
	12:15:28	19,990	20,051	20,010	20,022	20,025					-15,00	C

