

| Sběr dat [mm] | | | | | |
|-------------------------|--------|------|------|--------------|--------------|
| Podskupina | Měření | | | Průměr | Rozpětí |
| | 1 | 2 | 3 | | |
| 1 | 7.26 | 7.25 | 7.28 | 7.263 | 0.030 |
| 2 | 7.32 | 7.30 | 7.27 | 7.297 | 0.050 |
| 3 | 7.32 | 7.27 | 7.31 | 7.300 | 0.050 |
| 4 | 7.31 | 7.26 | 7.27 | 7.280 | 0.050 |
| 5 | 7.28 | 7.26 | 7.30 | 7.280 | 0.040 |
| 6 | 7.31 | 7.29 | 7.29 | 7.297 | 0.020 |
| 7 | 7.26 | 7.32 | 7.30 | 7.293 | 0.060 |
| 8 | 7.27 | 7.29 | 7.31 | 7.290 | 0.040 |
| 9 | 7.30 | 7.32 | 7.25 | 7.290 | 0.070 |
| 10 | 7.27 | 7.30 | 7.33 | 7.300 | 0.060 |
| 11 | 7.32 | 7.30 | 7.26 | 7.293 | 0.060 |
| 12 | 7.31 | 7.28 | 7.26 | 7.283 | 0.050 |
| 13 | 7.26 | 7.31 | 7.27 | 7.280 | 0.050 |
| 14 | 7.27 | 7.30 | 7.27 | 7.280 | 0.030 |
| 15 | 7.28 | 7.30 | 7.31 | 7.297 | 0.030 |
| 16 | 7.26 | 7.28 | 7.28 | 7.273 | 0.020 |
| 17 | 7.30 | 7.27 | 7.31 | 7.293 | 0.040 |
| 18 | 7.28 | 7.30 | 7.26 | 7.280 | 0.040 |
| 19 | 7.27 | 7.26 | 7.30 | 7.277 | 0.040 |
| 20 | 7.27 | 7.31 | 7.25 | 7.277 | 0.060 |
| 21 | 7.29 | 7.31 | 7.28 | 7.293 | 0.030 |
| 22 | 7.30 | 7.31 | 7.28 | 7.297 | 0.030 |
| 23 | 7.26 | 7.28 | 7.30 | 7.280 | 0.040 |
| 24 | 7.26 | 7.27 | 7.30 | 7.277 | 0.040 |
| 25 | 7.26 | 7.28 | 7.30 | 7.280 | 0.040 |
| Celkový průměr | | | | 7.286 | |
| Průměrné rozpětí | | | | | 0.043 |

7.300

7.263

| Parametry diagramu [mm] | | | |
|-------------------------|------------------|-------|-------|
| Diagram | Centrální přímka | UCL | LCL |
| Průměr | 7.286 | 7.330 | 7.242 |
| Rozpětí | 0.043 | 0.098 | 0.000 |
| | | | |
| A2 | 1.023 | | |
| D3 | 0 | | |
| D4 | 2.282 | | |
| | | | |
| Způsobilost procesu | | | |
| Střední hodnota | 7.286 | | |
| Rozptyl | 0.025 | | |
| Cp | 2.637 | | |
| Cpu | 2.822 | | |
| Cpl | 2.452 | | |
| Cpk | 2.452 | | |
| | | | |
| USL | 7.5 | | |
| LSL | 7.1 | | |
| d2 | 1.693 | | |

| Podskupina | naměřený | Centrální p | Regulační r | Regulační mez | Podskupina | Průměrné r |
|------------|----------|-------------|-------------|---------------|------------|------------|
| 1 | 7.263 | 7.286 | 7.330 | 7.242 | 1 | 0.030 |
| 2 | 7.297 | 7.286 | 7.330 | 7.242 | 2 | 0.050 |
| 3 | 7.300 | 7.286 | 7.330 | 7.242 | 3 | 0.050 |
| 4 | 7.280 | 7.286 | 7.330 | 7.242 | 4 | 0.050 |
| 5 | 7.280 | 7.286 | 7.330 | 7.242 | 5 | 0.040 |
| 6 | 7.297 | 7.286 | 7.330 | 7.242 | 6 | 0.020 |
| 7 | 7.293 | 7.286 | 7.330 | 7.242 | 7 | 0.060 |
| 8 | 7.290 | 7.286 | 7.330 | 7.242 | 8 | 0.040 |
| 9 | 7.290 | 7.286 | 7.330 | 7.242 | 9 | 0.070 |
| 10 | 7.300 | 7.286 | 7.330 | 7.242 | 10 | 0.060 |
| 11 | 7.293 | 7.286 | 7.330 | 7.242 | 11 | 0.060 |
| 12 | 7.283 | 7.286 | 7.330 | 7.242 | 12 | 0.050 |
| 13 | 7.280 | 7.286 | 7.330 | 7.242 | 13 | 0.050 |
| 14 | 7.280 | 7.286 | 7.330 | 7.242 | 14 | 0.030 |
| 15 | 7.297 | 7.286 | 7.330 | 7.242 | 15 | 0.030 |
| 16 | 7.273 | 7.286 | 7.330 | 7.242 | 16 | 0.020 |
| 17 | 7.293 | 7.286 | 7.330 | 7.242 | 17 | 0.040 |
| 18 | 7.280 | 7.286 | 7.330 | 7.242 | 18 | 0.040 |
| 19 | 7.277 | 7.286 | 7.330 | 7.242 | 19 | 0.040 |
| 20 | 7.277 | 7.286 | 7.330 | 7.242 | 20 | 0.060 |
| 21 | 7.293 | 7.286 | 7.330 | 7.242 | 21 | 0.030 |
| 22 | 7.297 | 7.286 | 7.330 | 7.242 | 22 | 0.030 |
| 23 | 7.280 | 7.286 | 7.330 | 7.242 | 23 | 0.040 |
| 24 | 7.277 | 7.286 | 7.330 | 7.242 | 24 | 0.040 |
| 25 | 7.280 | 7.286 | 7.330 | 7.242 | 25 | 0.040 |

Kontrolní karta

| Charakteristika | Vnější průměr pertlu | |
|----------------------------|----------------------|-------|
| Specifikace | Nominální hodnota | 7.3 |
| | USL | 7.5 |
| | LSL | 7.1 |
| Proces | Průměr | 7.286 |
| | Max | 7.300 |
| | Min | 7.263 |
| Způsobnost | Cp | 2.637 |
| | Cpu | 2.822 |
| | Cpl | 2.452 |
| | Cpk | 2.452 |
| Požadavek na Cpk | 1.33 | |
| Proces je způsobilý | ANO | |

Diagram X bar







