

Príloha 7 – Experiment 2 – Vyhodnotenie spôsobilosti procesu merania

Namerané hodnoty

Operátor	Díl	001_A_DRW_ PAR_001.P008	002_A_DRW_ DIS_001.M.P0 10_CALC.B004	003_A_DRW_ POS_001.K005	004_A_DRW_ POS_001.K006	005_A_DRW_ POS_001.K009	006_A_DRW_ POS_001.K014	
Opakování 1								
1	A	1	0.07613	-0.09431	0.05222	0.09642	0.07544	0.09038
		2	0.03622	0.01222	0.07122	0.06321	0.15621	0.06725
		3	0.02114	0.0571	0.06322	0.07832	0.15102	0.08233
2	B	1	0.07342	-0.08321	0.06021	0.09821	0.06802	0.09212
		2	0.04025	0.0142	0.07002	0.06712	0.15722	0.06414
		3	0.02217	0.05921	0.06521	0.07231	0.15033	0.08433
3	C	1	0.06821	-0.08231	0.06131	0.09512	0.0743	0.09401
		2	0.03271	0.01323	0.07433	0.0611	0.1523	0.06417
		3	0.02311	0.05788	0.06421	0.07422	0.15021	0.08531
Opakování 2								
1	A	1	0.07531	-0.08322	0.05613	0.09621	0.07611	0.09101
		2	0.03821	0.01814	0.07214	0.06445	0.16241	0.06843
		3	0.02211	0.05512	0.06512	0.07521	0.1841	0.08421
2	B	1	0.07157	-0.08453	0.05742	0.09891	0.07021	0.09321
		2	0.04141	0.01762	0.07322	0.06533	0.1602	0.06572
		3	0.03001	0.05841	0.06441	0.07345	0.1487	0.0833
3	C	1	0.06531	-0.08441	0.05882	0.09341	0.0732	0.09221
		2	0.03692	0.01442	0.07421	0.06043	0.1575	0.06366
		3	0.02453	0.05612	0.06432	0.07326	0.1477	0.08424
Opakování 3								
1	A	1	0.06422	-0.08212	0.05771	0.09592	0.07841	0.10089
		2	0.03704	0.01421	0.07321	0.06381	0.15544	0.0702
		3	0.0481	-0.004	0.06405	0.0925	0.15331	0.08125
2	B	1	0.07311	-0.08533	0.05632	0.09911	0.06931	0.09335
		2	0.04251	0.01663	0.07115	0.06852	0.1643	0.06455
		3	0.02483	0.05661	0.06532	0.07562	0.1443	0.08432
3	C	1	0.07031	-0.08321	0.06026	0.09221	0.0741	0.09231
		2	0.03491	0.01632	0.07143	0.06372	0.15741	0.06221
		3	0.02751	0.06032	0.06441	0.07434	0.1492	0.08621

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Opakování 4								
1	A	1	0.07421	-0.08241	0.05323	0.09411	0.07723	0.09125
		2	0.03925	0.01641	0.07204	0.06603	0.16132	0.06844
		3	0.02362	0.06002	0.06721	0.0801	0.14701	0.08421
2	B	1	0.07341	-0.0771	0.05722	0.09813	0.07211	0.09312
		2	0.04081	0.01441	0.07534	0.0644	0.1614	0.06311
		3	0.02771	0.06113	0.06542	0.0768	0.1432	0.08531
3	C	1	0.07001	-0.08533	0.05921	0.09323	0.0753	0.09222
		2	0.03682	0.01723	0.07331	0.06134	0.15521	0.06401
		3	0.0291	0.05912	0.06211	0.07561	0.1483	0.08632

Vyhodnotenie experimentu

Znaky

Hledat

Název ↑	Kód	Q _{MS}	Q _{MP}	U _{MS}	U _{MP}	%GRR	ndc
// 001_A_DRW_PAR_001.P008	001	14.418	20.199	0.00721	0.0101	30.299	6
∩ 002_A_DRW_DIS_001.M.P010_CALC.B004	002	14.651	14.746	0.0366	0.0369	12.941	9
⊕ 003_A_DRW_POS_001.K005	003	8.435	9.002	0.0105	0.0113	5.078	5
⊕ 004_A_DRW_POS_001.K006	004	8.905	10.618	0.0111	0.0133	9.491	5
⊕ 005_A_DRW_POS_001.K009	005	10.903	11.67	0.0136	0.0146	16.489	9
⊕ 006_A_DRW_POS_001.K014	006	12.647	13.24	0.0158	0.0166	6.222	7

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Znak 001

Celkové výsledky MP:

ISO22514-7 / VDA5

u_{MP} : 0.00505

$\%Q_{MP}$: 20.199

Odlehle hodnoty: 1

U_{MP} : 0.0101

C_{MP} : 0.99

AIAG MSA4

$\%AV$: 7.519

$\%PV$: 137.96

$\%GRR$: 30.299

AV : 0.00125

PV : 0.023

GRR : 0.00505

$\%EVO$: 29.351

$\%IA$: 0

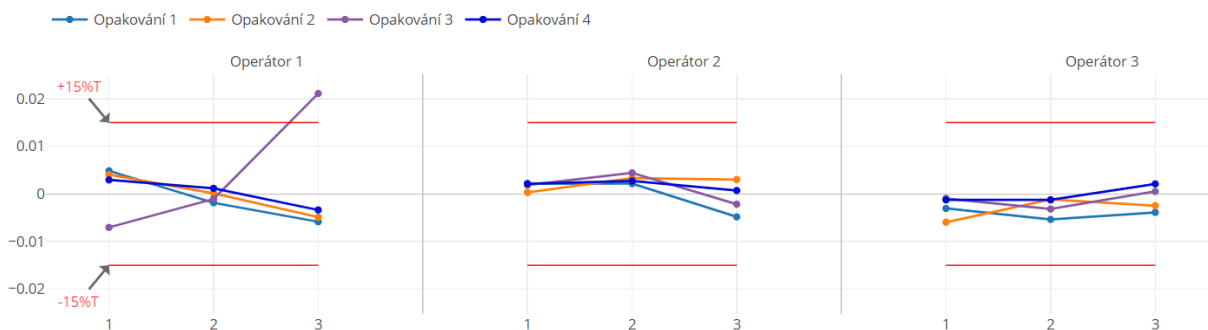
ndc : 6

EVO : 0.00489

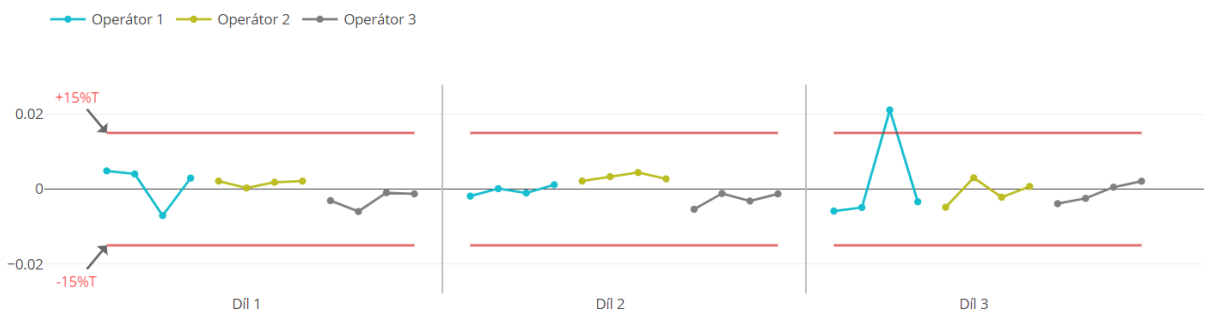
IA : 0

MP grafy:

Experiment typ 2 (podle opakování)



Experiment typ 2 (podle úrovně)



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Znak 002

Celkové výsledky MP:

ISO22514-7 / VDA5

u_{MP} : 0.0184

$\%Q_{MP}$: 14.746

Odlehle hodnoty: 3

U_{MP} : 0.0369

C_{MP} : 1.356

AIAG MSA4

$\%AV$: 2.508

$\%PV$: 84.881

$\%GRR$: 12.941

AV : 0.00209

PV : 0.0707

GRR : 0.0108

$\%EVO$: 12.695

$\%IA$: 0

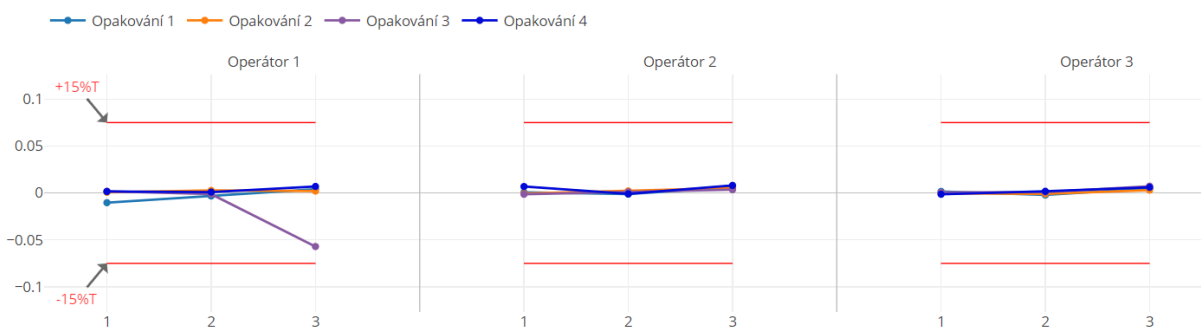
ndc : 9

EVO : 0.0106

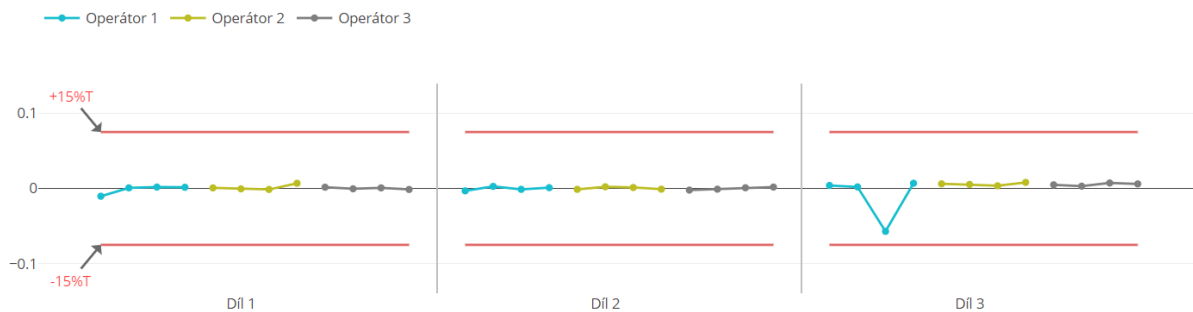
IA : 0

MP grafy:

Experiment typ 2 (podle opakování)



Experiment typ 2 (podle úrovně)



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Znak 003

Celkové výsledky MP:

ISO22514-7 / VDA5

u_{MP} : 0.00563

$\%Q_{MP}$: 9.002

Odlehle hodnoty: 2

U_{MP} : 0.0113

C_{MP} : 2.222

AIAG MSA4

$\%AV$: 3.334

$\%PV$: 18.032

$\%GRR$: 5.078

AV : 0.00139

PV : 0.00751

GRR : 0.00212

$\%EVO$: 3.83

$\%IA$: 3.334

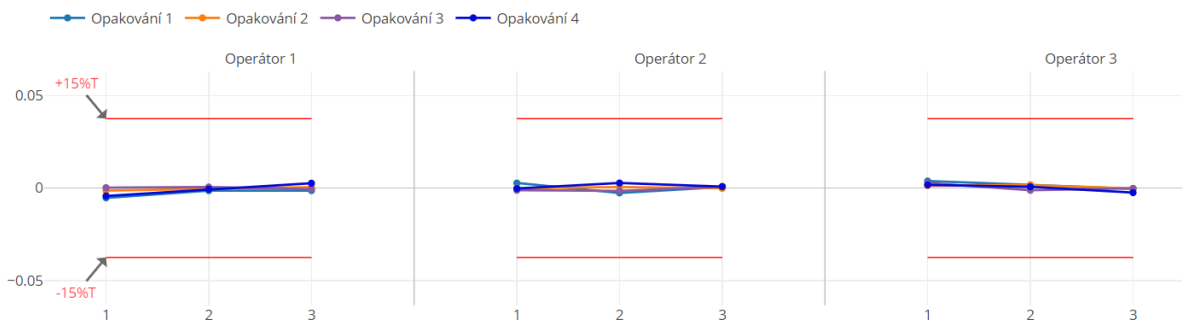
ndc : 5

EVO : 0.0016

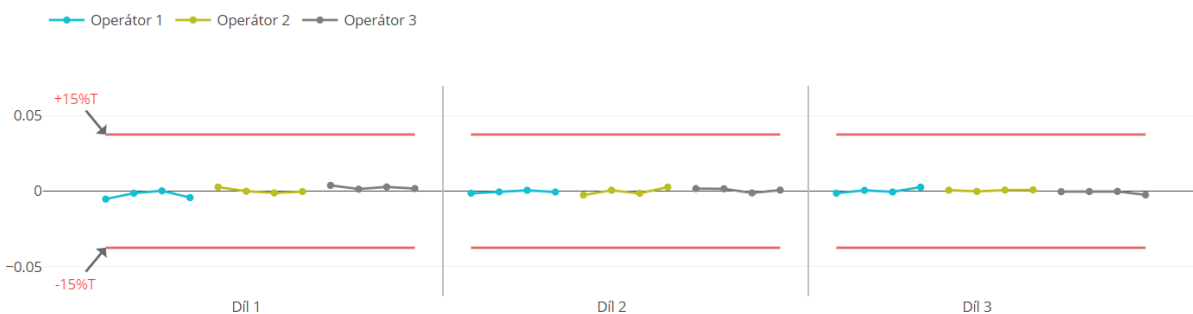
IA : 0.00139

MP grafy:

Experiment typ 2 (podle opakování)



Experiment typ 2 (podle úrovně)



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Znak 004

Celkové výsledky MP:

ISO22514-7 / VDA5

u_{MP} : 0.00664

$\%Q_{MP}$: 10.618

Odlehle hodnoty: 1

U_{MP} : 0.0133

C_{MP} : 1.884

AIAG MSA4

$\%AV$: 6.616

$\%PV$: 38.224

$\%GRR$: 9.491

AV : 0.00276

PV : 0.0159

GRR : 0.00395

$\%EVO$: 6.805

$\%IA$: 5.61

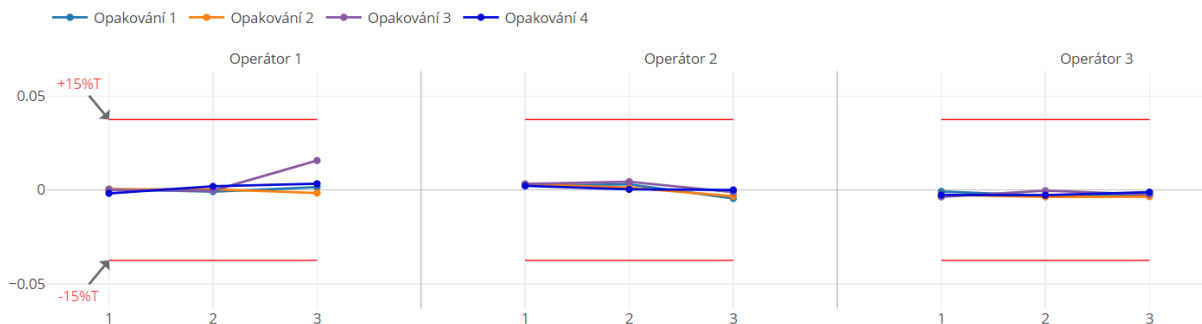
ndc : 5

EVO : 0.00284

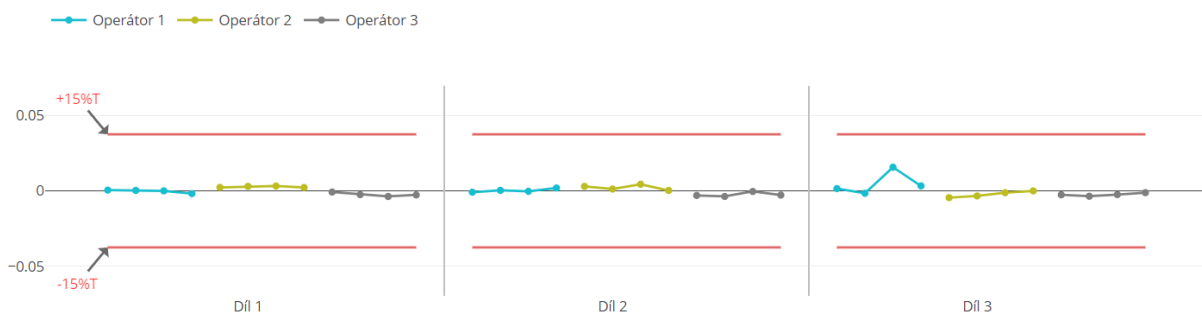
IA : 0.00234

MP grafy:

Experiment typ 2 (podle opakování)



Experiment typ 2 (podle úrovně)



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Znak 005

Celkové výsledky MP:

ISO22514-7 / VDA5

U_{MP} : 0.00729

$\%Q_{MP}$: 11.67

Odlehle hodnoty: 1

U_{MP} : 0.0146

C_{MP} : 1.714

AIAG MSA4

$\%AV$: 6.241

$\%PV$: 112.854

$\%GRR$: 16.489

AV : 0.0026

PV : 0.047

GRR : 0.00687

$\%EVO$: 15.262

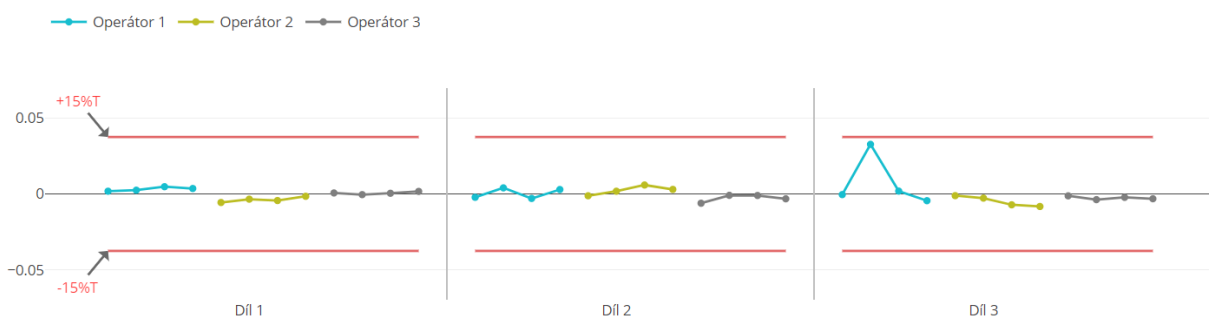
$\%IA$: 0

ndc : 9

EVO : 0.00636

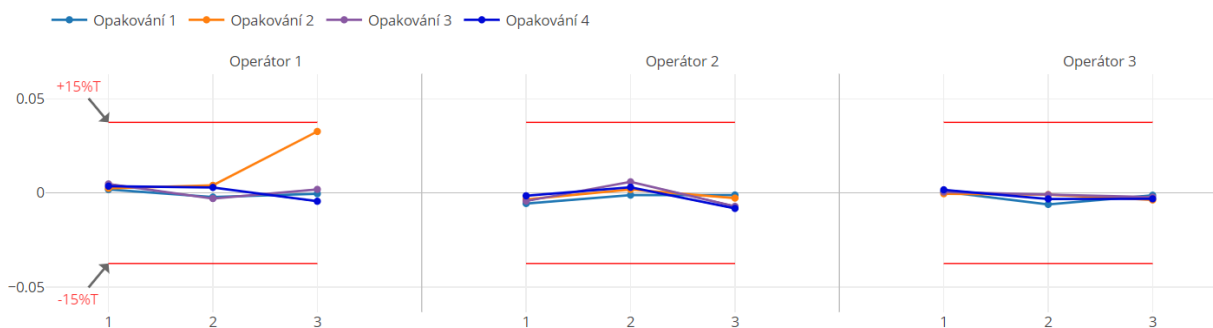
IA : 0

Experiment typ 2 (podle úrovně)



MP grafy:

Experiment typ 2 (podle opakování)



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Znak 006

Celkové výsledky MP:

ISO22514-7 / VDA5

U_{MP} : 0.00828

$\%Q_{MP}$: 13.24

Odlehle hodnoty: 2

U_{MP} : 0.0166

C_{MP} : 1.511

AIAG MSA4

$\%AV$: 4.157

$\%PV$: 33.634

$\%GRR$: 6.222

AV : 0.00173

PV : 0.014

GRR : 0.00259

$\%EVO$: 4.629

$\%IA$: 4.157

ndc : 7

EVO : 0.00193

IA : 0.00173

1 2 3

1 2 3

1 2 3

Experiment typ 2 (podle úrovne)

