

Standard process capability and spot check



valid for initial sample and production

valid for supplier and internal

	Critical Characteristics (CC)		Special Characteristics (SC) and F-Dimensions		Zeppelin test dimension (with capability requirements)		Zeppelin test dimension (without capability requirements)		Other dimension	
	Initial Sample	Production	Initial Sample	Production	Initial Sample	Production	Initial Sample	Production	Initial Sample	Production
Process capability (cmk and cpk)	cmk ≥ 2,00 ^(*1)	cpk ≥ 1,67 ^(*1)	cmk ≥ 1,67 ^(*1)	cpk ≥ 1,33 ^(*1)	cmk ≥ see drawing ^(*2)	cpk ≥ see drawing ^(*2)	-	-	-	-
general	min. 25 parts	min. 2 parts each spot check	min. 25 parts	min. 2 parts each spot check	min. 25 parts	min. 2 parts each spot check	min. 5 parts Inspection decision tolerance limit	min. 2 parts each spot check Inspection decision tolerance limit	min. 3 parts ^{(*3),(4)} Inspection decision tolerance limit	-
Stamping part each cavity										
Moulding part each cavity										
<p>(*1) = For deviating customer requirements from Standard have to be specified in drawing</p> <p>(*2) = If zeppelin test dimension require process capability have to be specified in drawing at test dimension (typical cmk ≥ 1,33 / cpk ≥ 1,0)</p> <p>(*3) = 2 parts each cavity, if tool > 1 cavity! 1 part each cavity, if tool > 7 cavities!</p> <p>(*4) = 1 part each cavity, if measurement and analysis is done by CT-Scan</p> <p>Remark: In general only few test dimensions should be defined.</p>										