

CTQ Capability – OoC Report

Summary report about capability of important processes and about Out of Control cases occur in these processes.

Every process can be displayed, what is appointed to automatic Out of Control monitoring and alert function by users, also processes of variables and attributes.

Calculation long term **Z** and **PPM** values, P_{pk} / C_{pk} process capability indices, C_{pk}/C_p rate.

Number of Out of Control cases occur in important processes (appointed to automatic OoC monitoring and alert): out of control limits, RUN, TREND, Middle-Third, Near to Limits.

Cumulating **number of defective parts**, calculation **actual PPM** value.

Capability - OoC Report - Six Sigma [Time period: 10-28-2005 - 11-28-2005]														
Group	Number of Subgroups	Zgoal	Zlt	PPMlt	Data out of Spec	PPM Actual	Xbar/Xi Out CL	Chart	Xbar/Xi R	Chart	Xbar/Xi T	Chart	Xbar/Xi M-T	Chart
	100	4.50	5.12	0.2	0	0.0	0	0.00 %	0		0		0	
	20	4.50	5.74	0.0	0	0.0	0	0.00 %	0		0		0	
	130	4.50	4.28	10	0	0.0	0	0.00 %	0		0		0	
	200	4.50	3.84	60	0	0.0	6	3.00 %	0		0		0	
	40	4.50	3.28	511	0	0.0	0	0.00 %	0		0		0	
	100	4.50	4.35	6.9	0	0.0	0	0.00 %	0		0		0	

OoC Report - QS 9000 [Time period: 10-28-2005 - 11-28-2005]					
Subgroup size	Number of Subgroups	Cpk goal	Cpk	Cpk/Cp	Data out of Spe
5	100	1.33	1.38	0.88	5
-	0	1.33	-	-	-
3	150	1.33	1.52	0.99	0
5	104	1.33	1.60	1.00	3
5	100	1.33	1.88	0.84	0
5	20	1.33	(1.97)	(0.95)	0
7	130	1.33	(1.42)	(0.80)	0
5	200	1.33	(1.90)	-	0
5	40	1.33	(1.09)	(0.95)	0

Attribute Report

Display the **capability of attributes** (failure groups).

It is possible to display data of lower levels –failure categories, failures.

Data can be displayed cumulative **by a failure group or by machine**.

Calculation **PPM** values **by failure group**, by **failure category** or by **failure**.

Failures - QS 9000: Part: TEST - M/c Group,Machine,Head,Position: TEST,TEST,-,-						
Failure group	Category	PPM				
A.Adatt 1	#1	1. category	8182			
	#2	2. category	20909			
PPM:			18182			
Z:			2.09			
	#3		-			
	#4		-			
	#5		-			
Failure	#1	#2	#3	#4	#5	PPM
1. fault	X	X				3636
2. fault		X				38182
3. fault	X					12727

Attribute Report - QS 9000 [Time period: 10-28-2005 - 11-28-2005]						
Part	CTQ	M/c Group Machine,Head,Position	PPM	Ppk	pieces	
TEST	A.Adatt 1 [teszt DB1]	TEST	18182	0.70	550	
Product [Test DB#1]		TEST,-,-				

Calculation **Z** and P_{pk} indices and colouring the values.

Calculation **PPM Shift** and colouring the value.

Alert Report

The report contains actual and acknowledged alerts and relevant information.

Can be made by variables and also by attributes. The purpose is the support of process improvement.

Process Settings

Display **process parameters and settings** in tabular form: tolerance limit, capability study, distribution type, distribution parameters, fitting test, control chart settings, Out of Control settings ...

It is possible to query separate **settings of automatic OoC monitoring and alert function**.

Data of **processes of variables and attributes** can be queried, too.

This report allows of **simply and quick overview** the processes located in the SPC database.

Selected Process - Process Settings						
S.size	Chart	Mode	Par.s	Lenght	X-Xi LCL	X-Xi UCL
5	Átvételi	Monit.	Xa/s	100	Calc.	Calc.
1	Átvételi	Monit.	Xa/s	25	Calc.	Calc.
Machine	Head/Pos.	F.category	Failure	S.care		
TEST	-/-					
TEST	-/-	1. category				
TEST	-/-	2. category				
TEST	-/-		1. fault	Used		
TEST	-/-		2. fault	N/U		
TEST	-/-		3. fault	N/U		