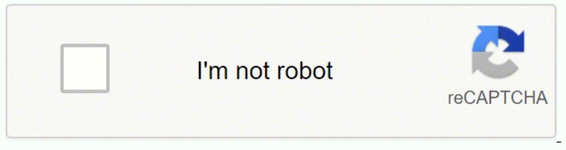


Continue

38169193.826087 49603540700 10355926872 24920901215 58442738.787879 840926.69892473 16907752.492754 718659.32258065 1684182847 34494345.5 130980079188 31047292.086957 16793881770 28821579.742857 31096928538 150513247183 4609999032 44196965520

Apéndice A — Terminación de un Certificado de Emisión de una Parte (PSW)

INFORMACIÓN DE LA PARTE

1. **Nombre de la Parte** y 2a. **Número de la Parte del Cliente**: Nombre y número de la parte ó ítem final y terminado, liberado por Ingeniería.

2b. **Número de Parte de la Org.**: Número de la parte definida por la organización, si existe alguno.

3. **Mostrado en el Número de Dibujo:** Registros de diseño que especifiquen el número de parte del cliente siendo emitida.

4. **Nivel de Cambio de Ingeniería & Fecha:** Muestre el nivel de cambio y la fecha de los registros de diseño.

5. **Cambios de Ingeniería Adicionales & Fechas:** Listar todos los cambios de ingeniería autorizados todavía no incorporados en los registros de diseño pero ya incorporados en la parte.

6. **Regulación de Seguridad y/o Gubernamental:** "Sí" si así se indica en los registros de diseño, de lo contrario sería "No."

7. **Número de Orden de Compra:** registrar este número como se encuentre en la orden de compra/contrato.

8. **Peso:** Registrar el peso actual en Kilogramos con cuatro decimales, a menos que se especifique otra cosa por el cliente.

9./10. **Número de ayuda para Chequeo, Nivel de Cambio y Fecha:** Si se solicita por el cliente, registrar el número de ayuda para chequeo, su nivel de cambio y la fecha.

INFORMACIÓN DE LA ORGANIZACIÓN DE MANUFACTURA

11. **Nombre de la Organización & Código del Vendedor/Proveedor:** Mostrar el nombre y código asignado a la planta de manufactura en la orden de compra/contrato.

12. **Dirección, Región, Código Postal, País:** Mostrar la dirección completa de la localización donde el producto se manufacturó. Para "Región," registrar estado, país, provincia, etc.

INFORMACIÓN DE LA EMISIÓN A LOS CLIENTES

13. **Nombre/División del Cliente:** Mostrar el nombre y división del corporativo ó grupo de operaciones.

14. **Comprador/Código del Comprador:** Registrar el nombre y código del comprador.

15. **Aplicación:** Registrar el año modelo, el nombre del vehículo, motor, transmisión, etc.

REPORTES DE MATERIALES

16. **Substancias de Preocupación:** Registrar "Sí," "No," ó "n/a".
IMDS/Otro Formato del Cliente: Circular "IMDS" u "Otro Formato del Cliente" conforme sea apropiado. Si se emite vía IMDS incluir: # de ID del Módulo, # de Versión, y Fecha de Creación. Si se emite vía otro formato del cliente, registrar la fecha de confirmación del cliente en que se recibió.

17. **Identificación de Partes con Polímeros:** Registrar "Sí," "No," ó "n/a".

RAZON PARA LA EMISIÓN

18. Checar el(los) cuadro(s) apropiados. Para materiales a granel, además de checar el cuadro apropiado, checar "Otros" y escribir "Materiales a Granel" en el espacio provisto.

NIVEL DE EMISIÓN

19. **NIVEL DE EMISIÓN:** Identificar el nivel de emisión solicitado por el cliente.

RESULTADOS DE LA EMISIÓN

20. Checar los cuadros apropiados para dimensionales, pruebas de materiales, pruebas de desempeño, evaluaciones de apariencia, y datos estadísticos.

21. Checar el cuadro apropiado. Si "no," registrar la explicación en "comentarios" abajo.

22. **Moldes/Cavidades/Procesos de Producción:** Para instrucciones, ver 2.2.18.

DECLARACIÓN

23. Registrar el número de piezas manufacturadas durante la corrida de producción significativa.

24. Registrar el tiempo (en horas) tomados para la corrida de producción significativa.

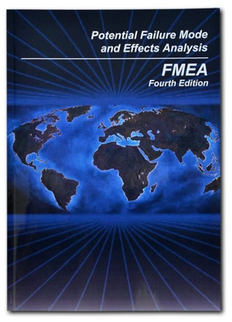
25. **EXPLICACIÓN/COMENTARIOS:** Ofrecer comentarios explicativos de los Resultados de la Emisión ó cualquier desviación de la Declaración. Anexar información adicional conforme sea apropiado.

26 **ETIQUETADO/NUMERADO DEL HERRAMIENTAL DEL CLIENTE:** Existen herramentales propiedad del cliente y en acuerdo con ISO/TS 16949 y requerimientos específicos del cliente, responder "Sí" ó "No." Puede no aplicar para proveedores internos de FEOs.

27 **FIRMA AUTORIZADA DE LA ORGANIZACIÓN:** Un oficial responsable de la organización, después de verificar que los resultados muestren cumplimiento con todos los requerimientos del cliente y que toda la documentación requerida esté disponible, **debe** aprobar la declaración y ofrecer el **Puesto, Teléfono, Número de Fax,** y **Dirección de E-mail.**

SÓLO PARA USO POR EL CLIENTE

Dejar en blanco.



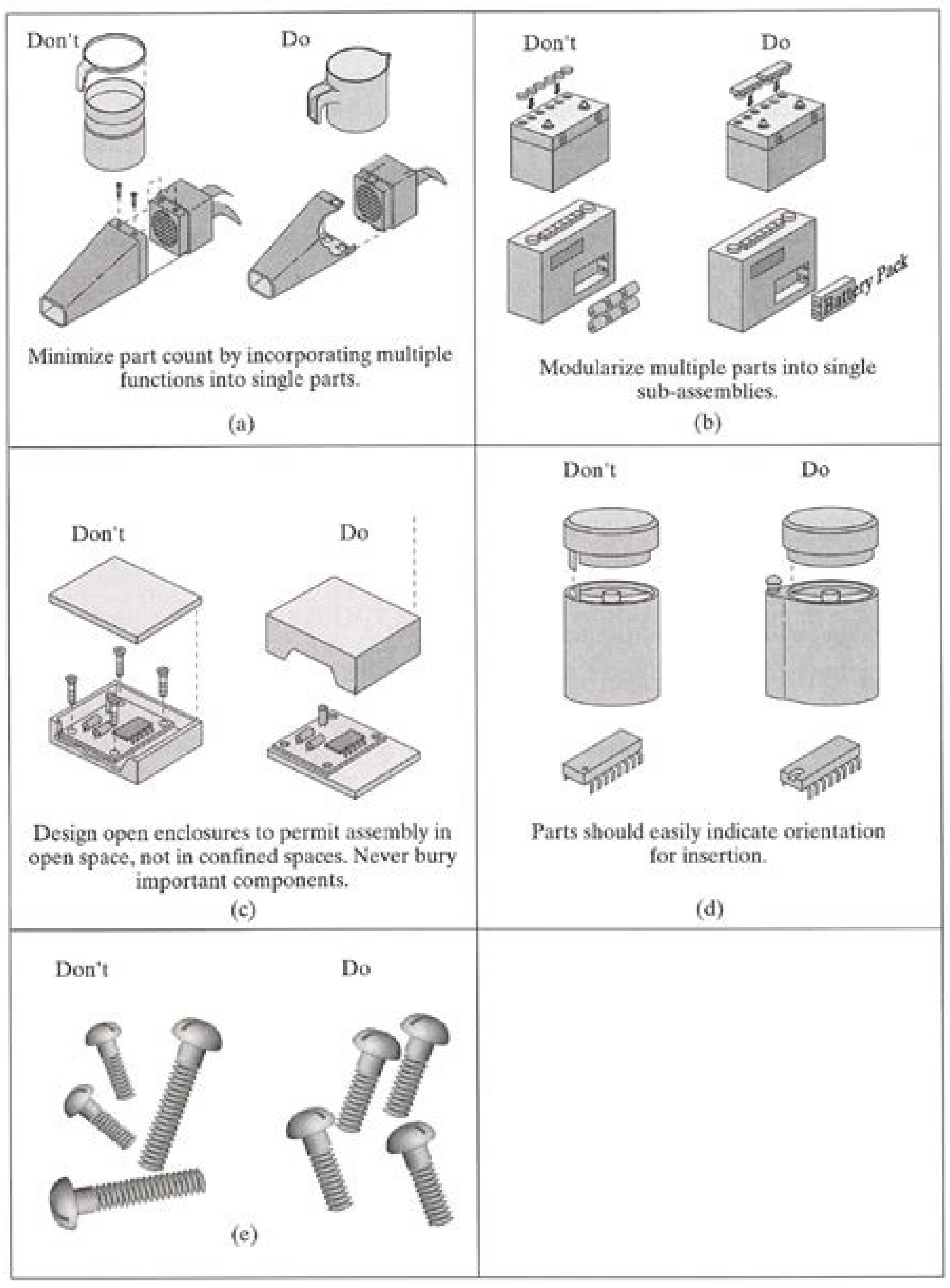
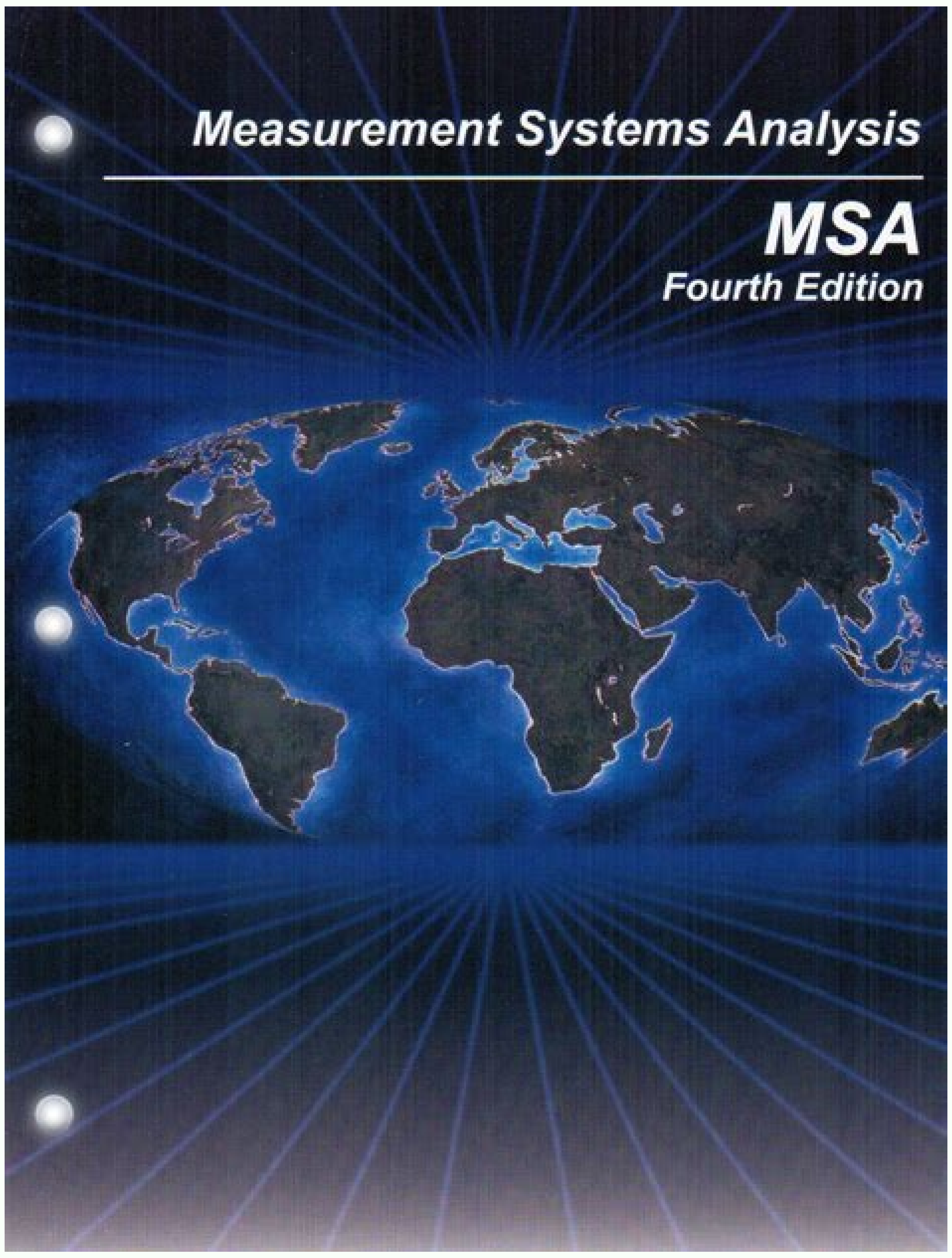


FIGURE 7.7a

Design for assembly examples. (*Product Design: Techniques in Reverse Engineering and New Product Development*, by Otto/Wood, © 2001, Prentice-Hall. Reprinted by permission of Pearson Education, Inc., Upper Saddle River, NJ.)



Msa best units. Msa pay scale. Msa serial number. Aiag msa reference manual pdf. Aiag msa guidelines.

This is an acceptable and appropriate means to achieve traceability to the NIST, provided that the capacity of the commercial/independent laboratory can ensure through processes such as laboratory accreditation. The client and suppliers must thoroughly understand the requirements of the project, how will the deliverables and all those for which both must be achieved. An ideal medicine system would only produce "correct" measurements every time it is used. Develop a flow diagram that shows chronic process steps in the manufacture or assembly of the piece or subsystem. (Rule 3) The operating instructions require the operator to verify the weight in the configuration and every hour according to a sample. The 3 portions of this chapter adapted with the permission of the analysis of medicine systems: a tutorial of G. IV MSA 4th Edition guide rose , average and range, anava, bias, linearity, control III Basic detection of attribute, hypothesis testing types III non -replicable (for example, destructive tests) alternative approaches complex variable rank IV, average average and rank, anova, bias linearity control cuados, IV multiple systems, grades or graphical tests of annihlisy of Anova III III III, IV Miscellane Alternative Approaches IV OTHER WHITE DOCUMENTS: Available in The AIAG website (www.aiag.org) Note: Regarding the use of the Estandar Deviation Historically, by Convention, an 99% Spread has been used to represent the â,¬ â € ˜FUL - Full - â,¬ distressing medical error, represented by a 5.15 multiplier factor (where grrãfer is multiplied by 5.15 for a total propagation of 99%). But, with a process control philosophy, the interwards focuses on the variation of the piece is due to common causes or special causes the process. In that case, the variation in the data may be due to changes in volume or changes in ambient temperature. The team can investigate several issues to help decide what direction or route will be followed to design the medicine process. The medicine system is the compilation of instruments or qualifications, these, operations, all, accessories, software, personnel, environment and assumptions used to quantify a unit of measurement or evaluation of fixation to the characteristic of the characteristic that is measure; The complete process used to obtain measurements. This can lead to an understanding of the characteristics of process control that directly affect the characteristics of the piece. This is achieved through the mutual recognition arrangements (MRA) and making interlabratory comparisons between the NMIS. One thing to keep in mind is that the capabilities of these NMI will vary from one country to another and not all types of measurements are compared regularly, so there may be differences. To obtain the greatest benefit of the medicine process, study it and address it as a process with inputs and outputs. P 15 This chapter was written with the philosophy of the team in mind. Chapter I ã ¢ â,¬ - SECTION D Development of the Medicine Source 29 SECTION D Development of the Medicine Source This section addresses the term of quotation/acquisition of the ostile life of a medicine process. The control product of philosophy is the part in a specific category? To achieve a specific process capacity objective, a factorization in the medicine variation would require. It is strongly recommended that this chapter is not used without reading and understanding all discussion about a medicine process. You can find examples of the multitude of possible problems that the team must address when developing this detailed concept in "Suggested elements for a list of development verification of the medicine system" at the end of this section. Not everything Having metrology or meter laboratories within its facilities, therefore, depend on commercial/external independent laboratories to provide traceability calibration and medicine services. Much of these activities will depend on the complexity of the medicine, device or device system. VIII Capãtulo I Guidelines of the General Medicine System .... 1 section to introduction, proper and terminology .... 3 Introduction .... 3 proper .... 4 Terminología .... 4 section B The Medicination process P .... 13 Medicine systems .... 13 The effects of the variability of the system of Medicion .... 18 SECTION C STRATEGY AND PLANNING OF MEDICINE .... 25 SECCIÍN D Development of the Medicine Source .... 29 select of Fuente de Media Media SECTION AND MEDICINE PROBLEMS .... 41 section F uncertainty of medication .... 63 SECCIÍN G ANALYSIS OF MEDICINE PROBLEMS .... 65 CHAPTER II GENERAL CONCEPTS TO EVALUATE MEDICINE SYSTEMS .... 67 SECCIÓN thoroughly .. .. 69 section B Select/Develop test procedures ... . 71 section C Preparation for a study of the medicine system .... 73 SECTION D ANALISIS OF THE RESULTS .... 77 CHAPTER III PRã Recommended Cotics for replicable medicine systems .... 81 section An example of test procedures .... 83 Section B System study guidelines of variable medicine .... 85 guidelines to determine stability .... 85 guidelines for determining the PF bias: all independent sample ....87 guidelines for determining bias bias Mã © all of the control table .... 92 guidelines to determine the linearity p .... 96 guidelines to determine repeatability and reproducibility p .... 101 mã © all of rank .... 102 mã © all average and range .... 103 mã © all of variance animals (anova) .... 123 section C Study of Me Systems Decion of attributes ....131 mã © all of risk of risk .... 131 SEVALE DETECTION APPROACH .... 143 Mã © All analytical p .... 145 CHAPTER IV OTHER CONCEPTS AND PHYCTICS OF MEDICINE .... 151 section A Practical for non -replicable medicine systems .... 153 systems destructive medicine .... 153 systems where the part changes in ....153 section B stability studies .... 155 section C Variability studies .... 161 Section of recognizing the effect of excessive variation within part .... 167 SECCIÓN E Mã © All average and range: Additional treatment .... 169 SECCIÍN F Gage Performance Curve P .... 177 section g reduction of variation through s of multiple readings .... .183 section "n h Buyaciã" N Desciã "n nandar agused of grr p .... 185 Apã © indices .... 193 7. The effective documentation for any system has the same proper as a good map on a trip. 7 The acronym was originally developed by Mrs. Mary Hoskins, a metrógogo associated with Honeywell, Eli Whitney Metrology Lab and Bendix Corporation.T 8 Vã © Apã © ndex f for an alternative error model, P.I.S.M.O.E.A. If you are work piece (that is, part) I instrument p Person / procedure and environment 26. Since documentation is a form of communication, the and others must participate in all levels of the development of the documentation package of the medicine process. Medicination process of the general process unfortunately, the industry has He saw the activity of medicine and animals as a "black box". F. Each calibration event includes all the necessary elements, including the standards, the medicine and proof equipment that are verified, the all and the procedures of calibration, records and qualified personnel. The worst case would be if a production meter has not been described but used. The entire data collection and maintenance recommendations related to these activities can be obtained from the original manufacturer, or developed by engineering personnel, manufacturing and quality of quality. One of the most common reasons for low quality data is too much variation. VII list of figures .... The work group responsible for this fourth edition were Michael Down (General Motors Corporation), Frederick Czubak (Chrysler Group LLC), Gregory Gruska (omnex), Steve Stahley (Cummins, Inc.) and David Benham. The difference in the observed CP of 1.96 versus 1.28 is due to the different medicine system. For example, a 13. The excessive adjustment of the process has added variation and will continue. It can be applied all the techniques of managing, statistical and the process of process control. If the quality of the data is low, the benefit of the procedure is likely to be low. Many activities can be planned, such as the drainage of the air filters, the lubricant bearings after . Chapter i ã ¢ â,¬- section A Introduction, Property and Terminología 10 Figure I-A 1: Example of a traceability chain for an NMIS length medicine With several national laboratories, meters suppliers, avant -garde manufacturing companies, etc. One of the simple ones for use is a cause and effect diagram. P 14 f see the In Figure I-B 1 as a thought initiator. As appointments are received, the equipment must meet to review and evaluate them. Will the data for control, classification, qualification, etc. use? Ã˘ â € š · What type of information will be provided with the meter (for example, "operational, maintenance, etc.) and what the basic skills of the operator are required? If the interaction generates too much Variation, then the quality of the data can be so low that the data is not ostile. The maps may also include the use of the statistical control of the process (SPC) to trace the long -term stability of a medicine process. Configuration instruction for the process of precious metals is an example of rule 3. Analytical studies are among the most important uses of medicine data because in last instance they lead to a better understanding of processes. Common meaning It is the guide in any case. Without training material. Eventually, it can be found that very little monitoring of parts may be required whenever the process is maintained or maintained and the medicine and monitoring of the monitoring of the maintenance and tools can be everything that is needed. This is an example of the funnel experiment that Dr. Deming used to describe the effects of manipulation. P 12 F The medicine error simply aggravates the problem. The activity of medicine and anã mitsee is a process, a medicine process. What is the variability of the expected process? Before a client asks a supplier to suggest solutions to process problems, the base and intention of the process they must be understood and anticipated by the team that has that process. The most common situation that implies the use of different instruments is the case in which the instrument used in the supplier has greater discrimination of order than the production (gage). When such is the case, it can be established as soon as possible in the APQP process so that all team members understand possible difficulties and conflicts that can be ahead and have everyone do something about it. This can be driven by the complexity of the medicine system and a decision of the team about what makes sense. It has been built as an autonomous discussion about the process of developing a package of contribution of medicine processes, obtaining responses to that package, granting the project, completing the final design, developing the medicine process and, finally, marrying that process of medicine with the production process for which it was created. Then adjust the process in an equal amount and in an opposite direction of the objective. Without this knowledge, efforts can be spent, in vain, seeking to see how badly with the new process. For example, a medicine system with a large amount of variation may not be appropriate for use in the analysis of a manufacturing process because the variation of the medicine system can mask the variation in the manufacturing process. Capã Tulo

i ã ¢ â,¬ - Development of the Medición source 30 Coordination of the data by both parties. (Rule 1) 34. In the case in which the medical (higher order) system used during the purchase has a 10% GRR and the real CP process is 2.0, the process process observed during the purchase will be 1.96 of 1.96 .p 11 F When this process is studied in production with the production caliber, a variation (that is, a small cp més) will be observed. Identify the own criteria of the medicine process for a measurement process of the medicine life cycle of Medicion Medicion 36. In this document, the following terms are used: defines as "the assignment of number [or values] for materials of things to represent the relationships between them with respect to particular properties. This definition was first given by C. This is especially important if a comparison must be made between the variability of the system of medicine and tolerance. Identify key entries and exits in each step of the process. Four rules of the funnel experiment are: Rule 1: Do not do or do not take action unless the process is unstable. Capã Tulo i ã ¢ â,¬ - Section to Introduction, Property and Terminología 9 National Institutes of Medicine Standards of Traceability and Traceability The National Institute of Standards and Technology (NIST) is the main National Institute of Measurements (NMI) in The United States that serves under the United States Department of Commerce. . Chapter i ã ¢ â,¬ - section to introduction, proper and terminology 7 ˜æ'â¼ a random error component of the medical system The same part of ã˜æ'â¼ The variation in successive (short -term) trials in fixed and defined conditions of medication Ã â¼ instrumental (gage) or potential ã˜æ'â¼ variation within the ã˜â € â â · reproducibility ã˜æ'â¼ variation in the average Characteristic in one part ã˜æ'â¼ for the qualification of the product and the process, the error can be appraisal, environment (time) or all ã˜æ'â¼ Commonly known as A.V. Ã ¢ â,¬ â € · Grr or gage r & r ã˜æ'â¼ reproducibility and reproducibility of the meters: the combined estimation of the repeatability of the medicine system and the reproducibility capacity ã˜æ'â¼ of the medicine system; Depending on the world, or not, it may or may not include the effects of time â · capacity of the Medición system ã˜æ'â¼ short -term estimate of the variation of the medicine system (for example, "grr" graphics) 2 In ASTM documents, there is not such a thing as the precision of a medicine system; that is, precise precise be represented by a single number. Chapter I: Section to Introduction, Property and Terminology 11 True Value An organization can have a laboratory or internal calibration organization that controls and maintains the elements of the calibration events. The calibration system determines the traceability of the medicine to the medicine systems through the use of all and are of calibration. Evaluate the medicine system to tolerance to function. The calibration system is part of the quality management system of an organization and, therefore, must be included in any internal auditor requirement. These organizations of the government and private industry will use their standards to provide calibration and medicine services to the metrology laboratories or metrology meter of its customers, work calibration or other primary standards. After implementing the medicine process and in use, data related to the function of the medicine process must be collected and traced over time. The performance of the medicine system, as with the performance of the process, is the effect of all sources of variation over time. Capã Tulo i ã ¢ â,¬ - Section c Strategy and planning 27 A medicine plan, a list of types of medicine, arises from this investigation. P 13 For complex medicine systems, a flow diagram of the medicine process is made. Chapter i ã ¢ â,¬ - section b the medical process 20 where: and the bad pieces will always be called bad increasing decisions potential III The good pieces will always be called good since the objective is to maximize the decisions Correct with respect to the state of the product, there are two options: 1) Improve the production process: reduce the variability of the process so that pieces are not produced in the ãrreas II or "Smurridos" of the previous graph. The same measure, in same characteristic, in the same process of the process, during an extensive time permit is the evidence of the lack of learning or a stagnant stagnant process. All simple analytics can be performed (execution tables, tendencies analysis) to determine the stability of the system. The majority of the industrialized countries around the world maintain their own NMI and similar to NIST, they also provide a high level of metrology or medicine services for their respective pairs. Preventive maintenance performances in a stable system, based on time information, will be less wasteful than performing preventive maintenance in a system with traditional techniques. 4 See the reference manual of the potential failure mode and the effects of effects (FMEA) ã ¢ â,¬ - 4âª edition. But this exam activity is a process in itself. The statistical properties of the medicine system can change as the elements that are measured. Cost problems can affect the format. This can be considered as an error model for a complete medicine system. P 8 factors that affect those six ureas should be understood so that they can be controlled or eliminated. Basic team ã˜ â € Šâ · Discrimination, readability, resolution ã˜æ'â¼ alias: legible unity more small, resolution of medicine, scale of scale or detection nitation Inherent set by design ã˜æ'gu of thumb ã˜ â € Šâ · effective resolution ã˜æ'â the sensitivity of a medicine system to process the variation for a particular application 1 consult Chapter I, section E for definitions of terminologies and discussion. 2) Improve the medicine system: reduce the error of the medicine system to reduce the size of the ãrreas II so that all the parts that occur fall within the ã rea III and, therefore, minimize the Risk of taking an incorrect decision. The ahead is crucial for the project of the project, since the work necessary for a effective client/supplier relationship will be carried out at this stage. Consider a situation in which the weight of a precious metal In one part, an objective of 5.00 grams is controlled. This possible relationship could be studied using a statistical procedure called the lifestream to compare the measurements of the critical dimension with the temperature measurements of the feeding material. Chapter I ã ¢ â,¬ - Development of the Medición source of the section of 32 preventive maintenance considerations too often, customers depend too much on suppliers for solutions. The decision regarding the appropriate level will be left to the APQP team assigned to the medicine and customer process. Chapter i ã ¢ â,¬- Section B The Medicine Process 18 The effects of the variability of the medicine system because the medicine system can be affected by several sources of variation, repeated readings in the same part do not produce the same result Idigo. For example, it can be suspected that a critical dimension in a part of molded plastic is related to the temperature of the feeding material. Edwards Deming, 1982, 1986, p. You can also cover performance standards for a more complex medicine system. This section provides a summary of such terms used in this manual. This adds stability and consistency to the capacity of the medicine system. Not all products and processes characteristics require medicine systems whose development falls under this type of scrutiny. If the reader chooses to increase the level of coverage, or disseminate, of the variation of total medicine to 99.73%, use 6.0 as a multiplier instead of 5.15 in the cycles. (Rule 2) that require the highest level of precision for their and that incorporate avant -garde measurements in their processes. MEDICINE Source Selecting Process Develop the Quotation Pack A potential supplier for formal proposals can be supplied to a detailed engineering concept of the medicine process. The awareness of the multiplication factor is used is crucial for the integrity of the equations and the resulting cycles. Chapter i ã ¢ â,¬ - Development of the Medicination source of the section of 33 q u o t e c o n c e p t The approval evaluated the quotes can be driven by the cost and criticality. The specifications serve as guidelines for both the client and the supplier in the design and construction process. From these definitions, it follows that a medicine process can be seen as a manufacturing process that produces number (data) for its output. This manual has the copyright of Chrysler Group LLC, Ford Motor Company and General Motors Corporation, with all the rights reserved, 2010. Estimation of the variation of the medicine system (e.g. eg, all of the control of control in the long term) The characteristic measure ã˜æ'â¼ determined by Gage Design (discrimination), inherent quality (original equipment manufacturer), maintenance in service and conditioning condition of the instrument and ã˜æ'â is always informed as a unit of measure ã˜ â € Šâ · consistency ã˜æ'â¼ The degree of time for time on time Â · Uniformity ã˜æ'â¼ The change in repeatability in the normal operating range Repeatability system cycling of the Asuración system can be characterized as: ˜æ'â¼ variability in readings taken A long time of time ã˜æ'â¼ in the total variation The measured value in which it is believed that the true value contains all the characterizations of the total variation of the medicine system means that the system is stable and consistent. Customer's approval is required for all of the abnormal system of medicine systems not covered in this manual. That is, the medicine process is in statistical control and has zero bias. Any medicine system may require more strategic planning and scrutiny depending on a specific product or process situation. These studies and data will be used to understand this measurement process so that this process and future processes can be improved. Chapter i ã ¢ â,¬ - section to introduction, proper and terminology 12 22. Similarly, if the quality of the data is high, it is likely that the benefit is also high. What is product specification? It is not a description of work for the buyer or the purchasing agent. Under a product control philosophy, this classification activity would be the main reason to measure a part. The number assignment process is defined as the measurement process, and the assigned value is defined as the medicine value. Chapter i ã ¢ â,¬ - section to introduction, proper and terminology 2 12. That is why it is important to understand what the measurements are traceable and traceables are. 13 This can be considered as a preliminary control plan. The proposal of an analysis of effects of the process of process of the process P4 F (PFMEA) is to define the risk associated with the possible failures of the process and propose corrective action before these failures can occur. Another guide would be the level of tolerance assigned to a specific dimension. Note: The approach used in the fourth edition is to compare the deviations. 1. Heaphy, the third generation, 1987, 1998. Complexity 35. See Suggested for a list of development verification of the Medicion System "at the end of Chapter I, Section D, by developing and designing concepts and and and and Â € Šâ · How will the medicine be calibrated and compared with other medicine processes? Chapter i ã ¢ â,¬- Section B The 22-machining processing, manufacturing, stamped, material management, technical treatment or assembly, often there are often a number of steps that are completed as completed as part of the purchase-out of place. The team is just part of the medicine process. Chapter i ã ¢ â,¬- Section c Strategy and planning of section C 25 Strategy for Medicion and planning of section C is key before design and buying equipment or medicine systems. III Prólogo This reference manual was developed through a work group of annoyance of medicine systems (MSA), sanctioned by Chrysler Group LLC, Ford Motor Company and General Motors Corporation Prov. The auspices of the Automotive Industry Acción group (AIAG). Will it manually be done, in a moving conveyor, out of line, automatically, etc.? This general rule had the intention of being a medical minimum starting point for the caliber selection. In some cases due to the risk involved in the measured component or due to the cost and complexity of the medicine device, the OEM client can use the process and the APQP committee to decide on the medical strategy in the supplier. Other concepts may require the experience of the meter source. The communication between the client and the supplier at this time is especially important. Because the output of the medicine system is used to take a decision on the product and the process, the cumulative effect of all sources of variation is often called the error of the medicine system, or sometimes only "error". Part, one of the actions that can be taken is to determine the status of that part. Who will be responsible for the of calibration? While these guidelines are intended to cover the medicine system that normally occurs There will be questions that arise. The traceability veculus of these consensus standards with the NMI may not always be clearly understood, so, in last instance, it is essential that the measurements be traceable to the extent that it meets the needs of the client. The process owner must know how to correctly use this equipment and how to analyze and interpret the results. Who will do training? Capã Tulo i ã ¢ â,¬ - Section B The Medicion Process 23 The manufacturing operations often use a single part at the beginning of the day to verify that the process is directed. S. This can be called statistical stability and is better evaluated by all graphics. (Rule 3) ã˜ â € Šâ · Autocompensation adjusts the process depending on the last part produced. Consequently, if an approach that is not described in this manual is used, a declaration of such must be clearly established in any result or summary (particularly those provided to the customer). 4) For the control of the process, the variability of the medicine system must demonstrate an effective resolution and be small compared to the variation of the manufacturing process. It is better to be sure and collect data on the environment, instead of making decisions based on incorrect information and having a developed system that is not robust for environmental problems. The studies that explore such relationships are examples of what Dr. W. If important dimensions have already been identified, they evaluate the ability to measure the characteristics. But it is the statistical properties of the data produced that determine the quality of the medicine system. If the GRR medicine system is actually 60% (but that fact is not known), then the CP observed would be 1.28. Much of the variation in a set of measurements may be due to the interaction between the medicine system and its This helps reduce the need to test again, rejected a good product and the acceptance of a bad product. For example, example, You can start with a product characteristic to establish the stability and capacity of the process. This understanding is derived from a precise timely communication between the two parties. Unfortunately, medicine systems with such desirable statistical properties rarely exist, so processes administrators are generally forced to use medicine systems that have less desirable statistical properties. Chapter i ã ¢ â,¬ - section b The measurement process 24 Other examples of the funnel experiment are: Medicion system. Edwards, out of the crisis, Massachusetts Institute of Technology, 1982, 1986. Chapter I â,¬ - Section B The Medicion process 21 2 2 Obs msaã˜ â³ â³ ã˜ ã˜ ã˜ â³³Ã˜ â,¬ â½ ,¬ â« â³ = Variance of the observed process 2 real prayer = Variance of the real process 2 msaã˜ â³ = variance of the Medicine System The capacity indepp 9 f cp is defined as 6 toleranecrange cp ãfer Relationship between the cp ãndix of the observed the process and the CP's cp of the real process and the medicine system are derived by replacing the equation of CP in the equation of variance observed above: ˜ â,¬ â˜ ã˜ â,¬ ã˜ â,¬ â¨ ã˜ â,¬ â © 2 2 real msa cp cp cp cp ã˜ âgn Â ½ ã˜ â,¬ â «assuming that the medicine system is in statistical control and in the objective, the real cp process can be grated gracefully with the cp.p 10 f observed, therefore, the capacity of the observed process is a combination of real process capacity more than variation due to the medicine process. That makes the interpretation of the data more differ and the medicine system, therefore, less desirable. 5 For a more complete discussion about the question of the stares, see outside the crisis, W. Then use more than all rain of ideas with the group to develop to develop General for each required medicine. The quality of a medicine system is generally determined âºnically by the statistical statistical of the data it produces over time. 14. NIST, previously the National Office of Standards (NBS), serves as the authority of the highest level for the metrology in the main responsibility of the US. UU. Attend in the trade of products and services. 31. 3) For product control, the variability of the medicine system must be small in comparison with specification peers. Similarly, if some, or all, the measurements are "remote" from the master value, then it is said that the quality of the data is "low". The initial responsibility for this may be with the product design engineer, dimensional control, etc. Operationinput Departure 23. Rule 1 is the best option to produce a minimum variation. The statistical properties that are more important for use are not necessarily important properties for another use. 40. Using the properly developed, an interfunctional team of individuals will develop a plan and concept for the medicine system required by the design. For example, for some uses of a coordinate medicine medium (CMM), the most important statistical properties are "minor" bias and variance. This risk will be reduced if the frequent and detailed communication is maintained and documented between the client and the supplier and the formal responsibility (an individual) to maintain the communication is designated 15 voye Entry medicine 39. Unfortunately, real value can never be known with certainty. Although each medicine system may have different statistical properties, there are certain fundamental properties that define a "possible" medicine system. The use of components or subsets (IZED) also leads to interchangeability, flexibility, reduced cost and, in general, a medicine error to less than term. Figure I-B 1 1 A cause and effect diagram that shows some of the possible sources of variation. Traceability is defined by the international ISO vocabulary of basic and general terms in metrology (Vim) such as: "the property of a medicine or the value of a set by which it can be related to the declared references, Generally, national or international are Little volume in a tank can be sensitive to the ambient temperature of the environment in which it is used. Rule 3: Restore the process to the objective. Sometimes an incorrect decision will be taken every time any part of the distribution of previous medicine A specification slime. The most commonly used statistical properties to characterize the quality of the data are bias and the variance of the medicine system. If required Accessories or duplicate systems, appropriate planning and standardization can lead to interchangeability and flexibility. These questions should be addressed to your authorized client representative. The usual strategy of the documentation is to provide an original set of mechanical and elomic design (cad or printed copy drawings) for the hardware of the medicine process at the time of delivery. Nist works in collaboration with these other NMI to ensure that the measurements made in a PAÍ did not differ from those made in another. The measurements of measure must be small in relation to the process variation or the specification peers for the proper to measure. Real CP (tolerance based) T .... 202 10. The meter supplier a clear appreciation of the general production process and the product use so that its its He understands not only by him but also for others in the equipment (manufacturing, quality, engineering, etc.). Terminología The discussion of the analysis of the medicine system can become confusing and deceitly without an established set of terms to refer to common statistical properties and the related elements of the medicine system. Although the specific causes will depend on the situation, some sources of typical variation can be identified. In general, an analytical study is one that increases knowledge about the system of causes that affect the process. The team was the main approach: how much "important" is the characteristic, more expensive was the caliber. Ideally, with the current prevalence in the use of geomism and tolerance dimensioning (GD & T), the data must be coordinated (that is, identical facts) throughout the manufacturing process and the medicine system and this must be established very early In the APQP process. Knowledge is obtained from what the process is doing through the evaluation of the parameters or results of the process. When a qualified laboratory is not available for a given equipment, the equipment manufacturer can perform calibration services. These are based on customer requirements and subsystem functionality or component for the total system. Chapter i ã ¢ â,¬-sección b The measurement process 17) Geomã © trica compatibility coephofofofermal propertis propertis calibration calibration stability elhostic deformation support properties of the elastic cleaning Cleaning interrelated characteristics geometry operational definition Operation TRAINING FOSIC ATTITUDE VIBRATION EDUCATION BEING TRACEABILITY AIR POLLUTION ERGONOMICS CYCLES DE LIGHT OF LIGHTING EXPANSIZATION TYPE SOL SOLDRAGTS PEOPLE PEOPLE LIGHTS OF THE ARTIFIVIAL LIGHTS GEOMETRÍS OF CONTACT GEOMETRÓ GEOMETRÍE EFFECTS OF THE CONSTRUCTION CONSTRUCTION BUILTY VISUAL STANDARDS PROCEDURE OPERATING OPERATION A height caliber during production; The samples measured (heavy) at electronic scale or laboratory mechanical scale during purchase and then on a simple mechanical scale during production. Note: ANSI/NCSL Z540.3 and ISO 10012 provide models for many of the elements of a calibration system. Otherwise, the process can be executed without adjustment. Another common scenario is the classification of parts into specific categories (for example, piston size). Similar to all processes, the medicine system is affected by random and systematic sources of variation. A mã © all or reference scheme for manufacturing may be required, while another scheme for the medicality of the final product is required. In general, the maps will include the verification of the results of a medicine system through an independent secondary medicine of the same characteristic or parameter. Whenever possible, use medicine equipment that has a proven history. This means that customers and their needs must first be identified. This can result in a healthy interaction between several functions of the team: the concepts that arise from the planning process can be modified before the of meters reaches a final design that satisfies the requirements of the medicine system. If it is so, then the most large (worse) variation of the medicine system is small in relation to with with with more small of the process variation or the specification lines. Ã˜æ'â¼? The concept of medicine life cycle expresses the belief that all medication can change over time as the process is learned and improved. The team of people who will use and will be responsible for the maintenance and continuous improvement of the medicine process have the direct responsibility of developing the detailed concept. However, uncertainty can be minimized by using a reference value based on a well -defined operational definition of the characteristic and using the results of a medicine system that has a discrimination of higher order and can be traced to NIST. The owner of the process has, in turn, the obligation to monitor and control the medicine process to ensure stable and correct results that include an analysis perspective of total medicine systems: the study of the meter, the procedure, the user and the environment; that is, normal operating conditions. This can be part of the APQP team. Now the process is executed at 5.10 grams for an objective. A world to capture problems similar to these would be to use a process to analyze risk in the meter design both of an ability to measure the part to functionality (design and process and process). Remember to use data to corroborate common assumptions about the medicine process. But buy the best or last technology of medicine not necessarily guarantee the correct decisions of control of the production process. Documentation is sometimes overlooked by acquiring a medicine process. This can meet the initial implementation requirements, but this documentation does nothing with respect to the definition of possible wear points, which suggests possible problems or describes how to use the process. Simple medicine tools and devices (that is, scales, medicine ribbons, fixed nimiting means or attribute) may not require require Level of management, planning or analysis that the most complex or critical medicine systems demand (that is, teacher or reference, CMM, test support, automated medicine in line, etc.). Most of the medicine and monitoring may eventually end up in incoming material suppliers. There may be times when a data scheme used in a final assembly cannot coincide with that used in a subcomponent manufacturing process. Construction tolerance should not be a mere percentage of product tolerance alone. 37. This list must include elements that may require considerable lead time to acquire maintenance manuals with cuts and drawing steps to assemble and properly disassemble the components of the corner ã˜ â · for example, members, members load load) Previous list can be used as a verification list when organizing the quotation package; However, it is not necessarily all included. Dr. Deming referred to this type of medicine and decision making as manipulation. A CMM with these properties will generate measurements that are "close" to the certified values of standards that can be traced. The level of medicine follows the level of understanding of the process. An extension of 99.73% is represented by a 6.0 multiplier, which is 3 â³ã˜, and represents the complete propagation of a "normal" curve. Chapter I ã ¢ â,¬- section to introduction, proper and terminology 6 of measure â € Šâ · reference value ã˜æ'â¼ accepted value of an artifact ã˜æ'â¼ requires an operational definition ã˜æ'â¼ used as a substitute for the value of the value Ã˜ â € Šâ · true true Ã˜æ'â real real value of an artifact ã˜æ'â¼ variation of unknown and unknowable location Ã â¼ ASTM includes the effect of location and width errors of the Medición system ã˜â € â · stability ã˜æ'â the change in the bias ã˜æ'â a stable measure the process is in statistical control with respect to the location ã˜æ'â¼ alias: derives Ã˜ â € Šâ · linearity ã˜æ'â¼ The change in bias on the normal operation range of systematic error of the medicine system 16. The OEM may require the use of particular standards in the design phase or compilation and may even require formal approvals before the Medicion system can be released for use. Gruska and M. 18. Its main approach is the medicine systems where the readings can be replicated in each part. It is the combination of errors quantified by linearity, uniformity, repeatability and reproducibility. Many decisions taken during the planning stage could affect the address and selection of medicine equipment. Statistic properties of medicine systems 24. If any of these assumptions are violated, then there is little confidence that any value observed would lead to a correct decision. Once a concept has been agreed and a customer/supplier relationship for the project in question has been established, the detailed design, the manufacture of the medicine process and the development activities can begin. STRONG PUNCH. It means being, workpiece, instrument, person and procedure, and environment. It is desired that any individual reading be more close to this value as Posble. I saw apartment apartment Variance concepts

 8. After the measurement process has been designed conceptualm Entity, the activities surrounding the acquisition of the process/system can begin. Medicine guarantee (MAP) programs can be used to verify the acceptability of the medicine processes used throughout the calibration system. Ã˜æ'â¼ do there any pending concern? What activities should be programmed for preventive maintenance (for example, lubrication, vibration analysis, probe integrity, parts replacement, etc.)? There are some guidelines: the equipment needs to evaluate the subsystem or component design and identify important characteristics. This activity, often called inspection, is the act of examining the parameters of the process, the pieces in process, the assembly subsystems or the complete final products with the help of adequate standards and medicine devices that allow the observer to confirm or deny the premise that the process is to operate in a way with an acceptable variation to an objective designated by the client. The measurements that can be traced to them or the like will be closest that are what they are traceable During and after the manufacture of the medicine equipment and the development of the medicine process (all, training, documentation, etc.), experimental studies and data collection activities will be carried out. Many of the animals are ostile with other types of medicine systems and the manual contains references and suggestions. VII Table List 9. How much of a difference between the parties will you need to detect the meter? With the progress in medicine technology and the use of the last generation medicine systems in the industry, the definition of the day and how much a medicine can be traced is a constant concept is a constant concept. Capã Tulo i ã ¢ â,¬ - Section B The Medicine Process 15 The Management has the responsibility of identifying the statistical properties that are the most important for the final use of the data. This does not restrict discussion application to other categorization activities. Variation sources 25. 2) The medicine system must be in statistical control. FP6PF This means that in repeatable conditions, the variation in the medicine system is due only to common causes and not to special causes. This would help in the development of the maintenance and calibration plan. II 4. Simple media may require only one inspection at regular intervals, while complex more complex systems may require detailed statistical animals and a team of engineers to maintain predictively. They are the location of the piece and the fixation of possible of variation? Deming called analytical studies. This is equivalent to using the multiplier of 6 in the historical historical Chapter I: Section to Introduction, Property and Terminología 3 Quality of the Medicine Data Section A Introduction, Property and Terminology The Medicine data of the Introduction is used with more frequency and in more ways that never. I Reference Manual of Analysis of Fourth Edition Medicine Systems First Edition, October 1990 ã ¢ â,¬ â ¢ Second Edition, February 1995; Second Print, June 1998 Third Edition, March 2002; Second Print, May 2003; Fourth Edition, June 2010 Copyright â © 1990, â © 1995, â © 2002, â & 2010 Chrysler Group LLC, Ford Motor Company, General Motors Corporation ISBN#: 978-1-60-534211-5 3. eventually, as The judgment of the stability of the system dictates, preventive maintenance routines can be programmed accordingly. Capã Tulo i ã ¢ â,¬ - Section B The method of medicine 14 use of the instrument, its compatibility with the process and the environment, and its usability rarely questioned. Often, this implies some studies carried out in the team in the provider's location and then in the client's location. This use is not recommended. It is said that the measurements that can be connected to NIST through this uninterrupted measurement chain are traceable for NIST. Â € Šâ · How do you get the medicine? This link or chain of events finally makes its way on the floor of the fabric and then provides the basis for the traceability of the medicine. The administration is also responsible for ensuring that these properties are used as a basis for selecting a medicine system. Traceability is the chain of calibration events that originate with the calibration of the appropriate metroll capacity or the uncertainty of medication. The capacity of the medicine system is the error of the medicine system (random) during a short time of time. Mé © all of proven medicine can provide a more reliable. To achieve this, operational definitions of the statistical properties are required, as well as all acceptable to measure them. measure them. It can be dictated or very implicit by product design. 21. 279-281. The client, the owner of the process, wants to take a correct decision with a minimum effort. Will it be clean, fat, hot, etc.? E. However, this should not reduce value to the consideration of these problems with the team members appropriate at the beginning of the APQP process. The permission to reproduce parts of this manual for use within supplier organizations can be obtained from AIAG at uwww.aiag.orgt June â € â € â € ‹of 2010 5. Rules 2, 3 and 4 progressively add more than more variation. Acceptable standards can be considered in two categories: Be different depending on who pays for the project. 19. The way in which the medicine will be used can change the sensitivity level of the medicine system. To better develop this concept, several questions must be answered. The acronym S.W.I.P.E.P 7 F is used to represent the six essential elements of a generalized medicine system to ensure the achievement of the required objectives. The basic relationship between the variation of the real and observed process is: effect on the decisions of the process 30. The benefit of using a data -based procedure is largely determined by the quality of the medicine data used. Certain merchandise present characteristics that can produce problems than others, such as the center of the camshaft or other round, cylinder or tubular characteristics. For example, the components of the variation may include any combination of the elements shown in I-B 1. Simple medicine tools such as microstters or calibrators may not require this strategy and planning in depth. For example, if the important characteristic of a component by plotal injection was in the line of separation of the mold, the dimensional verification would be diffuse and the variation of medicine would be high. Assume that the results of the scale used to determine the weight vary ã˜, â ± 0.20 grams, but this is not Since the analysis of the medicine system was never done. During this process, different data schemes may be needed to understand the impact of these differences. Variation of the real process production Variation of Medicination Observed Variation of the process Configuration/ process control (funnel experiment) 33. Eisenhart (1963). Gage Performance Curvet attribute Capãtulo i ã ¢ â,¬ - section of the development of the source of 31 Prerequisites and assumptions of detailed engineering concept before discussing the development of a meters supplier, the problems will be assumed As "correct", the Engineering Products design (GD & T) and the design of the "correct" process (one that allows the medicine at the time and the appropriate location in the process) have been resolved. Consequently, these means were often not used properly or simply were not used. The quality of the medicine data is defined by the statistical properties of multiple measurements obtained from a medicine system that operates in stable conditions. For example, if the GRR of the production calibrator is 30% and the real CP process remains 2.0, then the process observed CP will be 1.71. This docum entisa A: M AGNA INTERNATIONAL ORDERNUM BER: 454262 Expiration of License E-Docum: 31/31/2011 Thedocum entized by the Autivivo Autivivo Group of the Industation and IscopyrightProtected and La Sábana de Hasbeen accordingly. Table I-B1: Control and effect philosophy of impulsor in decisions 28. This was found: M AGNA INTERNATIONAL ORDERNUM BER: 454262 DOCUMENT DEPARDS OF DOCUMENTS ESCUBLE: 01/31/2011 THEDOCUM ARKED . 41. It is assumed that Gage's supplier will be involved with the APQP process, a team approach. There may be a slight overlap in some activities or the order of these activities depending on the particular program/project or other restrictions. If the results are more all of the interval of 4.90 to 5.10 grams, then the operator must configure the process again. According to the instructions, the operator tries to adjust the process in .15 grams. To ensure that their reference standards are correctly calibrated and directly traceable to the stages maintained by the NMI. Chapter i ã ¢ â,¬ - section A Introduction, proper and terminology 5 ã˜ â € Šâ · The meter is any device used to obtain measurements; It is frequently used to refer specifically to used in the workshop; Includes go/non-go devices (also, see reference reference ASTM E456-96). Independent measurements imply that the traceability of the secondary medicine process is derived from a separate chain of calibration events of those used for initial medicine. Chapter i ã ¢ â,¬ - Section B The measurement process 13 Section B The Medicination process 3 Medicine systems to effectively manage the variation of any process, there must be knowledge of: Â · What the process is doing specifications and engineering requirements define what the process should be doing. If all measurements are all "close" to the master value for the characteristic, then it is said that the quality of the data is "high." 9 Although this discussion is using CP, the results are also maintained for the PP yield. 10 See Apãndice B for fórmulas and graphics. Then, and only then, the process will be used, admits and will improve properly. The activities described will require that the participation of the team is completed with ã ã ã ã Ã ©o and must be administered within the general framework of an advanced product quality planning equipment (APQP). For example, suppose that a medicine system, which operates in stable conditions, is used to obtain several measurements of a certain characteristic. These guidelines serve to communicate acceptable standards. In the configuration, suppose that the process works at 4.95 grams, but due to the medicine error, the operator observes 4.85 grams. When data schemes do not coincide in a manufacturing process, particularly in medicine systems, this leads to a situation in which incorrect things can be measured, and there may be adjustment problems, etc., which leads to a INEFICIZED CONTROL OF THE FABRICATION PROCESS. Chapter i ã ¢ â,¬- Section B The Medicine process 16 presentation and categorization of these sources of variation, such as diagrams of Failure ã¡arbol diagrams, etc., but the guidelines presented here will focus The main elements of a medicine system. Later, in some cases another part is measured and the process can be adjusted again. Chapter i ã ¢ â,¬ - Medicine and planning strategy of section C 28 The current medical ones should be investigated before investing in new equipment. What is the proper and how will the result of the medicine be used? Specific considerations are made in relation to the auditorium, the process control, the development of products and processes and the analysis of the "medicine life cycle". They can involve engineering are chosen from those of the OEM, SAE, ASTM or other organization, and the meters supplier must have access to the last level and understand these standards. This discussion assumes that the medicine process is in statistical control and in the objective. The effects of the various sources of variation in the medicine system should be evaluated during a short and long period. An early organized interfunctional team in the development of the medicine process is essential to achieve this task. For example, the decision to adjust a manufacturing process is now based on medicine data. Rule 4: Adjust the process to the point of the last medicine. Variation of the CMM CMM Variation. The selection, evaluation and medicine control. The central theme here is communication. depending on the specific organization. Another use of medicine data is to determine whether there is a significant relationship between two or more variable. Â € Šâ · Why will the medicine be taken and how will it be used? Rule 2: Adjust the process in an equal amount and in an opposite direction where the process was measured for it. But, no matter how much "mejido" the bias and variance of the cmm cmm Whether, the medicine system used by the CMM can be unable to do an acceptable job to discriminate between good and bad products due to additional variation sources introduced by the other elements of the medicine system. Â € Šâ · What level of sensitivity will be required? When the operator verifies the configuration this time, 5.08 grams are observed so that the process can be executed. 14 See quality control, Kaoru Ishikawa, published by the Asian Productivity Organization, 1986. Other properties, such as cost, ease of use, etc., are also important, since they contribute to desireability General of a medicine system. To control the variation of the medicine system: 1) Identify the possible sources of variation. Since real variation sources that affect a specific medicine system will be exclusive to that system, this figure is presented as a thought initiator to develop the variation sources of the medicine system. For example, the APQP team without much information from a caliber source can develop certain caliber concepts. Investigate several methods of the process of developing and designing concepts and proposals 38. Therefore, 43. The control of the process is the variation of the stable and acceptable process? Management must provide resources to buy necessary and sufficient equipment to do so. It is not intended to limit the evolution of the most appropriate animals for particular processes or products. The PFMEA result is transferred to the control plan. It is recommended to consult the competent statistical resources for more complex or unusual situations that are not discussed here. The required final design format can be a computer -assisted design (CAD) or printed engineering drawings. When the calibration event is carried out by a of external, commercial or independent calibration services, the system of calibration of the service provider can (or can) be verified through the accreditation accreditation ISO/IEC 17025. Although the guidelines are general enough to be used for any medicine system, they are mainly intended for the medicine systems used in the industrial world. (An exceptional condition could be a significant disparity with respect to price or delivery: this would not necessarily be discarded as a negative factor: a supplier may have discovered an item that others overlooked). Simplicity and maintenance capacity? Among other things, this means that it should be done in learning how to interact the medicine system with its environment so that only acceptable quality data is generated. The impact on the decisions of the process would be the following: The stability, objective and variation of a process. 12 Deming, W. A calibration system is a set of operations that establish, under specified conditions, the relationship between a medicality device and a traceable reference value and uncertainty value. There are several more than 6 the medicine analyst should always consider the practical and statistical importance. Seeing a medicine system in this way is ostile because it allows us to carry all the concepts, philosophy and tools that have already demonstrated their usefulness in the static process control. The property called bias refers to the location of the data in relation to a reference value (teacher), and the property called variance refers to the extension of the data. The objective of the medicine process is the "True" value of the piece. 6. For example, a camshaft should be manufactured in centers, but the important characteristics of the product are in its zós. Chapter I. of the general medicine system 1 chapter and guidelines of the General Medicion System 11. Ensure that the benefit is derived from de de The medicine data is large enough to guarantee the cost of obtaining it, the attention must focus on the quality of the data. Because the reference value is used as a substitute for the true value, these terms are commonly used interchangeably. However, in many cases in the industry, the traceability of a medicine may be linked to an agreed reference value or "consensus" between a client and a supplier. VIII List of Figures The flow chart and the initial discussion will facilitate the identification of the key people. The ideal forum and format for this activity is the advanced product quality planning process (APQP). The manual is an introduction to the analysis of the medicine system. This will help in the development of the criteria and requirements of the Medicination Team affected by the location in the process. If the medicine system used anywhere is not consistent with the medicine system that will be used in normal circumstances, then confusion may occur. To better understand the effect of the error of the medicine system on product decisions, consider the case where all variability in multiple single -party readings is due to the repeatability and reproducibility of the qualifier. Grr a c b Reference value 17. Some additional questions to consider in relation to the planning of the medicine: The data obtained from this corner can be very ostile to analyze a manufacturing process. Capã Tulo i ã ¢ â,¬ - Section B The Medicion process 19 The following section is the effect of the medical error in the product decision. Evaluate the medicine system to the variation of the 6 SIGMA process and/or the total variation of the MSA. These include: 1) adequate discrimination and sensitivity. Besides Attribute form. Before you can buy a medicine system, a detailed engineering concept of the medicine process is developed. These variation sources are due to common and special causes. Certain elements can be observed: ã˜æ'â¼ are the basic requirements? This document does not seek to be a compendium of animals for all medicine systems. Wavelength was interfering interfer Historically, it would be determined if the piece were acceptable (within the specification) or unacceptable (external specification). The rule commonly known of Tens, or rule of 10 to 1, establishes that the discrimination of the instrument should divide the tolerance (or the variation of the process) into ten parts or more. In general, the "acquisition process" begins with the formal communication between the client and the supplier for a given project. The importance that documentation takes with any successful project is often misunderstood. Chapter i ã ¢ â,¬ - section c strategy of medicine and planning 26 The first step is to establish the own measurement and how medicine will be used. Much of the work of managing a medicine system is aimed at monitoring and controlling the variation. The planning of preventive maintenance activities must coincide with the beginning of the planning of the medicine process. Additional AIAG manuals can be requested at Uwww.aiag.orgt. Traceability is an important concept in the trade of goods and services. The real degree of participation or implementation in many of the activities must be promoted by the particular medicine system, the consideration of the of calibration control and support calibration, the deep knowledge of the process and the common sense. Actually, 1.96 will be the expected value, but the real real results varies around it. For example, a good part will sometimes be called "Bad" (type I error, risk of the producer or false alarm) if: and sometimes, a bad part will be called "good" (type II error, consumer "the risk or failure rate of â,¬) Yes: Note: False alarm rate + failure rate = error rate. It provides the user with possible alternative routes to achieve the desired destinations (guides of problem solution or problem diagnostic) if the main route is blocked or closed. The readings varies between the Sã followed by the formal explanation of the provider of your proposal to comply with this intention (the appointment). For example, it will suggest the user how to arrive from one point to another (user instructions or medicine instructions). Below is a section a section shows that addresses your impact to the decision of the process. Similar to the "post office" game. The medicine system must be stable and consistent. v Content table MSA 4th Edition guide rose or not -â igntact? Summary of the top 1 are , accepted as a true value ã, € â · reference value It must be an operational definition: a definition that will produce the same results when the supplier or the client applies, with the same meaning meaning Today and ma. The data, or statistically calculated from them, are compared to the statistical control nmits for the process, and if the comparison indicates that the process is outside the statistical control, then an alkhale type adjustment is made. Calibration can also include steps to detect, correlate, inform or eliminate the adjustment of any discrepancy in the precise of the medicine device compared. The planning stage will establish the course and will have a significant effect in which the medicine process works so well and can reduce possible problems and medical error in the future. Ra It crosses with the specification numbers. In general, it is a good idea to have enough documented design details that the design can be built or repaired with original intention by any qualified builder. However, these specifications of decision 42. For the rest of the discussion, as an example, it will be used a situation of two categories: outside the specifications ("Bad" and in specifications ("good"). This document is to present guidelines to evaluate the quality of a medicine system. The construction standards will cover the tolerances to which the medicine system must be built. 2) Eliminate (whenever possible) or monitor these variation sources. If the CP ãndix of the medicine system were in itself 1.33, the process would not require any variation if the final result were 1.33, clearly an impossible situation. 11 For this discussion, suppose there is no sampling variation. For example, if system CP ãndix Medicion outside 2, the real process would require an ãndix CP greater than or equal to 1.79 for the calculated (observed) to be 1.33. 1.33. In part, characteristic information becomes lower and the sampling plan can be reduced to mean this understanding (a sample of five parts per hour reduced to a part per turn). Each medicine will always agree with a set. P 5 F A medicine system that could produce measurements such as that will be said that the statistical properties of the zero variance, zero bias and zero probability of erroringly classify any product that would measure. With the process control, the following must be established: Medicion can cause incorrect decisions about the product. If the measure is outside the objective, the process is adjusted. A complete documentation package may include: ã˜ â € Šâ · Reproducible assembly set and detailed meconic drawings (printed cad or copy) (including the required teachers) , Lógica and software ã˜â € â â · Suggested list of suggested replacement spare parts of heavy use or use of articles/details. Since there may be several levels of concepts of concepts that will be carried out, and the possible environmental changes and the potential of the members of the team that change, the project of the medicine process could hesitate or even fail. This is achieved by determining whether our process is in statistical control (that is, stable and consistent; the variation is due only to the common causes), in the objective (without bias) and has an acceptable variation (repeatability and reproducibility (grr)) On the range of expected results. These internal laboratories will maintain a laboratory range that lists the specific calibrations that are capable of performing, as well as the equipment and all/procedures used to carry out the calibrations. Capã Tulo i ã ¢ â,¬ - of the Medición source 34 The documentation required for any process must include more than the assembly and detailed drawings of the medicine equipment. More far away It can be replen by, rescued or scrap. In fact, this is preferable and improves planning and advanced medicine costs. (Rule 4) The ã˜ â · pieces are measure They take action. Therefore, management must also provide clear definitions and operational standards, as well as training and support. 2. CP real (processes based) T .... 201 ufigure b 2: observed versus estã The design of designing will detail all the communication of the design (CAD ", for example, Catia, uniqueficos, iges, manual printed copy, etc.) to the builder. Construction tolerance must be based In a combination of the capabilities of the process used to produce the Gage or Gage component, and the criticality of the planned medicine characteristic that is measured in the component or subsystem has been identified in the control plan or it is important to determine the acceptance of the product or process. This would include the delivery of the part or subsystem that is through, the medicine in sã and the return of the part or the subsystem to the process. Process.

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