Process Capability Workshop

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Upper Control Limit = Mean + (3* SD)
Lower Control Limit = Mean - (3 * SD)
Control Width = UCL - LCL
Spec Width = USL - LSL
Cp = Spec Width / Control Width
Cpu = USL - UCL / (3*SD)
Cpl = LSL - LCL / (3*SD)
Cpk = Cpu

The process is not capable

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