

## 検査成績書

検査日：2024年5月22日

DATE：22-May-24

M/P/N Product Code No.: N13785-153

メーカー名: ミツビシ精機株式会社

材料コード Material Code No.: -

Supplier: MITSUBISHI CO., LTD.

測定項目 ITEM		1	2		3	5	7	R	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23			
測定器具 Measure		S	S	S	S	S	S	S	S	S	S	M	M	S	S	S	S	S	S	S	S	S	S	S			
基準値 DIMENSION		3.400	1.600	1.600	6.300	9.600	6.500	6.500	21.500	21.600	3.600	0.800	0.600	7.500	6.200	5.700	7.900	3.100	7.700	3.100	10.300	0.000	0.000	0.000			
公差 Tolerance	+	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.100	0.200	0.100	0.060	0.000	0.200	0.050	0.100	0.100	0.100	0.100	0.100	0.200	0.050	0.050	0.050			
	-	-0.100	-0.100	-0.100	-0.100	-0.100	-0.100	-0.100	-0.100	-0.200	-0.100	-0.060	-0.030	-0.200	-0.050	-0.100	-0.100	-0.100	-0.100	-0.100	-0.200	0.000	0.000	0.000			
センター値		3.400	1.600	1.600	6.300	9.600	6.500	6.500	21.500	21.600	3.600	0.800	0.585	7.500	6.200	5.700	7.900	3.100	7.700	3.100	10.300	0.025	0.025	0.025			
1	240301	3.4049	1.6091	1.6103	6.3087	9.6198	6.4774	6.5003	21.4818	24.6192	3.641	0.802	0.581	7.5126	6.2145	5.678	7.9049	3.0999	7.7012	3.1036	10.2677	0.0121	0.0157	0.0161			
2		3.4045	1.6104	1.6118	6.3089	9.6215	6.4761	6.4998	21.4827	24.6273	3.6337	0.802	0.581	7.5299	6.2138	5.6782	7.9025	3.0948	7.7035	3.0996	10.2661	0.0133	0.0114	0.0078			
3		3.405	1.6097	1.6102	6.3091	9.6202	6.476	6.4988	21.4896	24.6314	3.6272	0.802	0.581	7.536	6.2148	5.6798	7.9049	3.1037	7.7053	3.1036	10.2611	0.0117	0.0119	0.0124			
4		3.405	1.608	1.609	6.31	9.6179	6.4791	6.4997	21.48	24.6342	3.6289	0.802	0.581	7.5202	6.2138	5.681	7.9059	3.1004	7.7022	3.1037	10.2575	0.0127	0.0128	0.0116			
5		3.4049	1.6096	1.6081	6.3092	9.5997	6.4753	6.4991	21.4856	24.6262	3.6301	0.803	0.581	7.5241	6.2142	5.6796	7.9056	3.1021	7.7021	3.1113	10.2611	0.0117	0.0127	0.0111			
6	240326	3.4069	1.6132	1.614	6.3088	9.6077	6.4954	6.4742	21.4855	24.6093	3.6083	0.807	0.585	7.5272	6.2159	5.6943	7.8866	3.1211	7.6995	3.111	10.2557	0.0108	0.0123	0.0109			
7		3.407	1.6141	1.6161	6.3089	9.6151	6.4972	6.4771	21.4846	24.609	3.6145	0.807	0.586	7.5282	6.2166	5.696	7.8869	3.1135	7.7012	3.1052	10.2538	0.0082	0.0199	0.0173			
8		3.4061	1.6095	1.6101	6.3091	9.6299	6.4971	6.478	21.488	24.6043	3.6152	0.807	0.586	7.5222	6.2139	5.6949	7.8936	3.0847	7.7014	3.1015	10.2597	0.0117	0.0143	0.0103			
9		3.4058	1.611	1.6118	6.3088	9.605	6.4956	6.4772	21.4866	24.6118	3.6177	0.808	0.586	7.5279	6.2161	5.6964	7.8883	3.102	7.7013	3.1092	10.2579	0.0117	0.012	0.0142			
10		3.4062	1.612	1.612	6.3088	9.6206	6.4957	6.4752	21.4808	24.605	3.611	0.807	0.586	7.5277	6.216	5.6955	7.8861	3.1037	7.7012	3.0974	10.256	0.0091	0.0139	0.0105			
11	240327	3.4057	1.6099	1.6116	6.3097	9.6155	6.482	6.4958	21.4814	24.6121	3.5909	0.809	0.587	7.5184	6.2158	5.6899	7.8949	3.0941	7.7019	3.1034	10.262	0.0118	0.0147	0.011			
12		3.4062	1.6109	1.6116	6.3098	9.6131	6.4821	6.4993	21.4787	24.6052	3.6091	0.809	0.587	7.5145	6.2165	5.6907	7.8961	3.0981	7.7032	3.0997	10.2632	0.0134	0.0105	0.0102			
13		3.4056	1.6119	1.6114	6.3094	9.6246	6.4835	6.4977	21.4753	24.6013	3.6029	0.809	0.586	7.5088	6.2165	5.6881	7.8944	3.0964	7.6988	3.1014	10.2568	0.0116	0.0118	0.0112			
14		3.4066	1.6098	1.6101	6.3102	9.617	6.4799	6.4953	21.4723	24.6011	3.6026	0.809	0.586	7.5183	6.217	5.6903	7.8939	3.1001	7.6999	3.1015	10.2587	0.0132	0.0141	0.0091			
15		3.4062	1.6102	1.6102	6.3088	9.6291	6.4828	6.4976	21.4736	24.6063	3.6092	0.809	0.586	7.5259	6.2156	5.6892	7.8945	3.0981	7.7048	3.1036	10.2633	0.0104	0.0124	0.0093			
16	240328	3.4053	1.6088	1.6099	6.3081	9.5973	6.486	6.4996	21.4772	24.599	3.6207	0.805	0.582	7.5316	6.2165	5.6905	7.9027	3.0979	7.7022	3.1047	10.2666	0.0106	0.0166	0.0183			
17		3.4054	1.6086	1.6106	6.3092	9.6066	6.4853	6.5001	21.4791	24.5849	3.6283	0.805	0.581	7.505	6.2144	5.6881	7.9077	3.0882	7.7033	3.1053	10.2596	0.0126	0.0143	0.0171			
18		3.4049	1.6098	1.6112	6.3093	9.5908	6.484	6.4987	21.479	24.5754	3.6227	0.805	0.582	7.5051	6.2154	5.6911	7.9032	3.0891	7.702	3.1035	10.2581	0.011	0.015	0.0137			
19		3.4053	1.6084	1.6107	6.3092	9.6022	6.4844	6.5002	21.4721	24.5805	3.6234	0.805	0.582	7.5102	6.216	5.6875	7.9069	3.0852	7.7026	3.1035	10.2584	0.0119	0.0174	0.0149			
20		3.4047	1.6094	1.6098	6.3092	9.5982	6.4857	6.4998	21.4785	24.5768	3.6287	0.806	0.582	7.5049	6.2144	5.6897	7.9055	3.0899	7.7032	3.1036	10.2614	0.0082	0.0164	0.0168			
21	240329	3.4049	1.6091	1.6103	6.3087	9.6198	6.4774	6.5003	21.4718	24.6192	3.641	0.802	0.581	7.5126	6.2145	5.678	7.9049	3.0999	7.7012	3.1036	10.2677	0.0121	0.0157	0.0161			
22		3.4045	1.6104	1.6118	6.3089	9.6215	6.4761	6.4998	21.4827	24.6273	3.6337	0.802	0.581	7.5299	6.2138	5.6782	7.9025	3.0948	7.7035	3.0996	10.2661	0.0133	0.0114	0.0078			
23		3.405	1.6097	1.6102	6.3091	9.6202	6.476	6.4988	21.4796	24.6314	3.6272	0.802	0.581	7.536	6.2148	5.6798	7.9049	3.1037	7.7053	3.1036	10.2611	0.0117	0.0119	0.0124			
24		3.405	1.608	1.609	6.31	9.6179	6.4791	6.4997	21.47	24.6342	3.6289	0.802	0.581	7.5202	6.2138	5.681	7.9059	3.1004	7.7022	3.1037	10.2575	0.0127	0.0128	0.0116			
25		3.4049	1.6096	1.6081	6.3092	9.5997	6.4753	6.4991	21.4756	24.6262	3.6301	0.803	0.581	7.5241	6.2142	5.6796	7.9056	3.1021	7.7021	3.1113	10.2611	0.0117	0.0127	0.0111			
26	240401	3.4055	1.6091	1.6106	6.3099	9.5788	6.4771	6.4977	21.5122	24.6266	3.6055	0.804	0.582	7.5274	6.2148	5.6808	7.9079	3.1189	7.7009	3.1013	10.2641	0.0115	0.0124	0.0103			
27		3.4044	1.61	1.611	6.3089	9.5776	6.4784	6.4974	21.5169	24.6271	3.6182	0.804	0.581	7.5355	6.2127	5.6795	7.9075	3.1122	7.6992	3.1016	10.2589	0.0114	0.0139	0.0112			
28		3.4039	1.6085	1.6098	6.3087	9.5763	6.4818	6.499	21.5134	24.6221	3.6233	0.805	0.582	7.5334	6.2143	5.6851	7.9065	3.0924	7.7022	3.1034	10.2587	0.0103	0.0144	0.0182			
29		3.4042	1.6102	1.6107	6.3099	9.5825	6.4742	6.498	21.5184	24.6124	3.6092	0.803	0.581	7.5258	6.2139	5.6797	7.9013	3.1117	7.7008	3.1035	10.2607	0.0085	0.0135	0.0113			
30		3.4056	1.609	1.6085	6.309	9.5811	6.4754	6.4973	21.5169	24.6215	3.6224	0.804	0.582	7.5395	6.2148	5.6814	7.9065	3.0905	7.6995	3.1033	10.2583	0.0107	0.0155	0.0154			
31	240408	3.4033	1.6073	1.6099	6.3086	9.5814	6.4824	6.5002	21.5152	24.6062	3.5792	0.805	0.583	7.5243	6.2119	5.6823	7.8954	3.1018	7.7039	3.1112	10.2682	0.0104	0.0147	0.013			
32		3.4049	1.6109	1.6122	6.3077	9.5929	6.4835	6.5009	21.5185	24.6185	3.5807	0.805	0.583	7.5331	6.2145	5.682	7.8938	3.1134	7.7056	3.1052	10.2627	0.0099	0.0148	0.0113			
33		3.4054	1.6118	1.6104	6.308	9.604	6.4822	6.5019	21.5149	24.6246	3.5853	0.805	0.583	7.5308	6.2139	5.6843	7.8952	3.0963	7.7051	3.1073	10.2691	0.0091	0.0152	0.0104			
34		3.4045	1.6114	1.6095	6.3079	9.5943	6.4841	6.5032	21.515	24.612	3.5851	0.805	0.583	7.5374	6.2125	5.6839	7.8942	3.102	7.7016	3.1051	10.2611	0.0086	0.0174	0.0131			
35		3.4049	1.6115	1.611	6.3089	9.5887	6.485	6.5011	21.5177	24.6065	3.5766	0.804	0.583	7.5261	6.2138	5.6818	7.8969	3.1001	7.7024	3.111	10.2631	0.0093	0.0174	0.0142			
36	240409	3.4058	1.6116	1.611	6.3093	9.5997	6.4856	6.5053	21.4984	24.6547	3.6156	0.806	0.586	7.5318	6.2132	5.684	7.8929	3.1038	7.7018	3.1076	10.2625	0.0112	0.0146	0.012			

37		3.4036	1.6096	1.6108	6.3094	9.5796	6.4853	6.5049	21.5015	24.6382	3.6049	0.805	0.586	7.5123	6.2134	5.6786	7.8912	3.0962	7.7002	3.1033	10.2581	0.013	0.0118	0.009				
38		3.4048	1.6106	1.6106	6.3086	9.5923	6.4858	6.5043	21.5032	24.641	3.6061	0.805	0.585	7.5173	6.2142	5.6819	7.894	3.1043	7.6998	3.103	10.2577	0.0104	0.0128	0.0141				
39		3.4053	1.6093	1.609	6.309	9.6018	6.4854	6.5041	21.5065	24.6444	3.5996	0.805	0.586	7.5277	6.2126	5.6798	7.896	3.1134	7.7011	3.1016	10.2612	0.0109	0.0109	0.0107				
40		3.4048	1.6094	1.6101	6.3089	9.5932	6.4862	6.5045	21.5195	24.6558	3.607	0.805	0.585	7.5124	6.214	5.6803	7.8955	3.1078	7.701	3.1112	10.2581	0.0118	0.0099	0.0101				
41	240418	3.4061	1.6122	1.6141	6.3084	9.5857	6.4829	6.5008	21.4804	24.6066	3.6113	0.805	0.584	7.5298	6.2144	5.6833	7.8893	3.1019	7.6991	3.1094	10.2597	0.0101	0.0127	0.0137				
42		3.4013	1.6106	1.6129	6.3096	9.5836	6.4848	6.5028	21.4926	24.5992	3.5914	0.805	0.582	7.5357	6.2143	5.6856	7.9023	3.1133	7.6956	3.1052	10.2598	0.0096	0.0125	0.0154				
43		3.4054	1.6133	1.6137	6.3079	9.5791	6.4873	6.503	21.4818	24.6074	3.5932	0.805	0.583	7.5203	6.215	5.6848	7.8882	3.1001	7.7021	3.1151	10.2592	0.0082	0.0194	0.0172				
44		3.4061	1.6164	1.6165	6.3084	9.5746	6.4852	6.5033	21.4861	24.6048	3.6019	0.805	0.583	7.5337	6.2154	5.6832	7.8775	3.1038	7.7005	3.1093	10.2564	0.0098	0.0114	0.0099				
45		3.4078	1.617	1.6202	6.3083	9.56	6.4844	6.5022	21.4836	24.5976	3.6012	0.805	0.583	7.526	6.2155	5.6838	7.8801	3.1115	7.7021	3.1055	10.2553	0.0093	0.0127	0.0125				
46	240419	3.405	1.6129	1.6142	6.3095	9.5773	6.4842	6.5034	21.4935	24.6125	3.599	0.805	0.586	7.5412	6.2131	5.6844	7.8859	3.1077	7.6994	3.1074	10.2563	0.0132	0.014	0.0118				
47		3.4051	1.6139	1.6168	6.3083	9.5777	6.4862	6.5043	21.4956	24.6179	3.5948	0.805	0.584	7.5282	6.2142	5.6872	7.8802	3.1039	7.7	3.1092	10.2602	0.009	0.0133	0.0131				
48		3.405	1.6131	1.6152	6.3086	9.5715	6.4839	6.5041	21.4932	24.62	3.6048	0.805	0.585	7.5375	6.2112	5.6856	7.8787	3.1076	7.6999	3.1093	10.2604	0.0097	0.0149	0.0113				
49		3.4059	1.6127	1.6147	6.3081	9.5798	6.4857	6.5026	21.5042	24.6203	3.5951	0.805	0.585	7.5303	6.2139	5.6866	7.8832	3.1058	7.7	3.1062	10.259	0.01	0.0161	0.0111				
50		3.4053	1.6137	1.6154	6.3088	9.5819	6.4834	6.5027	21.4752	24.6057	3.6027	0.805	0.585	7.5433	6.2141	5.6856	7.88	3.1	7.7006	3.1055	10.2618	0.0095	0.0157	0.0142				
51	240516	3.4048	1.6117	1.6114	6.3091	9.6294	6.4936	6.5047	21.4779	24.6215	3.6015	0.808	0.587	7.5283	6.2135	5.6722	7.8931	3.1059	7.7049	3.0991	10.2724	0.0129	0.0125	0.0092				
52		3.405	1.6092	1.6103	6.3104	9.6349	6.4925	6.505	21.4756	24.6194	3.594	0.808	0.588	7.5091	6.2126	5.6744	7.8949	3.0867	7.7045	3.1108	10.2683	0.0141	0.0088	0.0109				
53		3.4055	1.6114	1.6147	6.3098	9.6403	6.4927	6.5052	21.475	24.6146	3.597	0.808	0.588	7.5321	6.2136	5.6737	7.8949	3.104	7.7041	3.1069	10.2712	0.0141	0.0105	0.0086				
54		3.4048	1.6094	1.6123	6.3111	9.641	6.492	6.5044	21.4788	24.6218	3.5923	0.808	0.588	7.5052	6.2145	5.6724	7.9003	3.0869	7.705	3.1016	10.277	0.0137	0.0106	0.0107				
55		3.4058	1.6094	1.6132	6.3111	9.6373	6.4948	6.5045	21.4766	24.6143	3.586	0.808	0.588	7.5223	6.2136	5.6747	7.8974	3.0848	7.7043	3.1035	10.2745	0.0129	0.0214	0.0186				
56																												
57																												
58																												
59																												
60																												
%Tolerance	UPPER	4.9%	10.4%	11.8%	8.9%	21.5%	-22.6%	0.3%	-17.3%	13.7%	41.0%	3.3%	-26.7%	14.9%	29.0%	-21.8%	4.9%	-0.1%	3.5%	3.6%	-16.2%	-46.8%	-37.2%	-35.6%				
	LOWER	4.5%	9.1%	10.3%	8.7%	19.8%	-23.9%	-0.2%	-18.2%	9.6%	33.7%	3.3%	-26.7%	6.3%	27.6%	-22.0%	2.5%	-5.2%	1.2%	-0.4%	-17.0%	-51.6%	-54.4%	-68.8%				
Judgment(50%)		OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	Measure More	Measure More	Measure More				
MAX		3.4078	1.617	1.6202	6.3111	9.641	6.4972	6.5053	21.5195	24.6558	3.641	0.809	0.588	7.5433	6.217	5.6964	7.9079	3.1211	7.7056	3.1151	10.277	0.0141	0.0214	0.0186				
MIN		3.4013	1.6073	1.6081	6.3077	9.56	6.4742	6.4742	21.47	24.5754	3.5766	0.802	0.581	7.5049	6.2112	5.6722	7.8775	3.0847	7.6956	3.0974	10.2538	0.0082	0.0088	0.0078				
R		0.0065	0.0097	0.0121	0.0034	0.081	0.023	0.0311	0.0495	0.0804	0.0644	0.007	0.007	0.0384	0.0058	0.0242	0.0304	0.0364	0.01	0.0177	0.0232	0.0059	0.0126	0.0108				
AVE		3.4052	1.6107	1.6116	6.3091	9.602	6.4842	6.4988	21.4898	24.6155	3.6093	0.8053	0.5838	7.5247	6.2144	5.6838	7.8962	3.101	7.7019	3.1051	10.2617	0.0111	0.0139	0.0125				
σ n-1		0.001	0.002	0.0024	0.0007	0.0204	0.0061	0.0076	0.0158	0.0167	0.0163	0.0021	0.0023	0.01	0.0012	0.006	0.0086	0.0086	0.002	0.0038	0.005	0.0016	0.0025	0.0028				
Cp		33.3333	16.6667	13.8889	47.619	1.634	5.4645	4.386	2.1097	3.992	2.045	9.5238	2.3478	6.6667	13.8889	5.5556	3.876	3.876	16.6667	8.7719	13.3333	8.1042	4.8133	4.4643				
Cpk		31.6	14.8834	12.2778	43.2857	1.6013	4.6011	4.3334	1.8945	3.6826	1.8548	8.6825	2.3478	5.8434	9.8889	4.6556	3.7287	3.8372	16.35	8.3245	10.78	8.1042	4.8133	4.4643				
Spec	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK				
CPK判定	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK				
Measure		測定器具 K:測定顕微鏡 (Microscope) G:ピンゲージ (Pin-Gauge) M:マイクロメータ (Micrometer) P:マイクロプロッタ (Micro Protter) N:ノギス (Vernier Caliper) T:投影機 (Projector)																										
		S:三次元測定機 (CNC Video Measuring Systems) その他【 D:デジマイクロ (DigMicro) B: ( ) C: ( ) 】																										

# 初期流動検査記録

品番: NT3621-P50

No.	検査日	ロットNo.	検査数	不良数	不良率	原因・対策
1	8月22日	230811	40655	95	0.23%	
2	8月23日	230812	40098	104	0.26%	
3	8月23日	230813	41949	150	0.36%	
4	8月24日	230821	50431	214	0.42%	
5	8月24日	230822	59293	125	0.21%	
6	8月25日	230823	33954	56	0.16%	
7	8月28日	230824	58668	191	0.33%	
8	8月30日	230825	76080	237	0.31%	
9						
10						
11						
12						
13						
14						
15						
16						
17						
18						
19						
20						
21						
22						
23						
24						
25						
26						
27						
28						
29						
30						
31						
32						
33						
34						
		TOTAL	401128	1172	0.29%	

KH031-HH-097-1