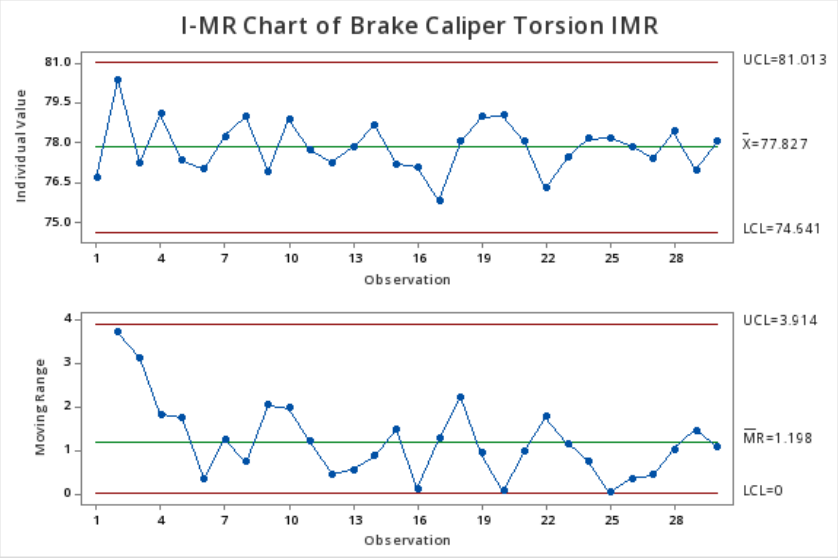
I-MR

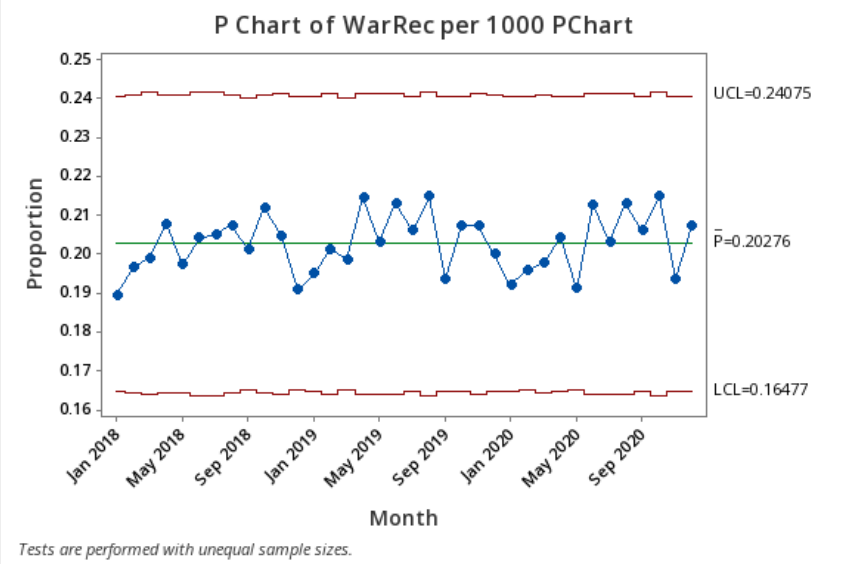
Evaluating the torsion rod resistance of the brake caliper.



- Process is stable
- The torsion reading is centering around 77.8 and ranging between 74.6 and 81

P-chart

Evaluating the proportion of vehicles with warranty or recall claims within 12 months of sale - averaging around 200 per 1000 units, or 20%

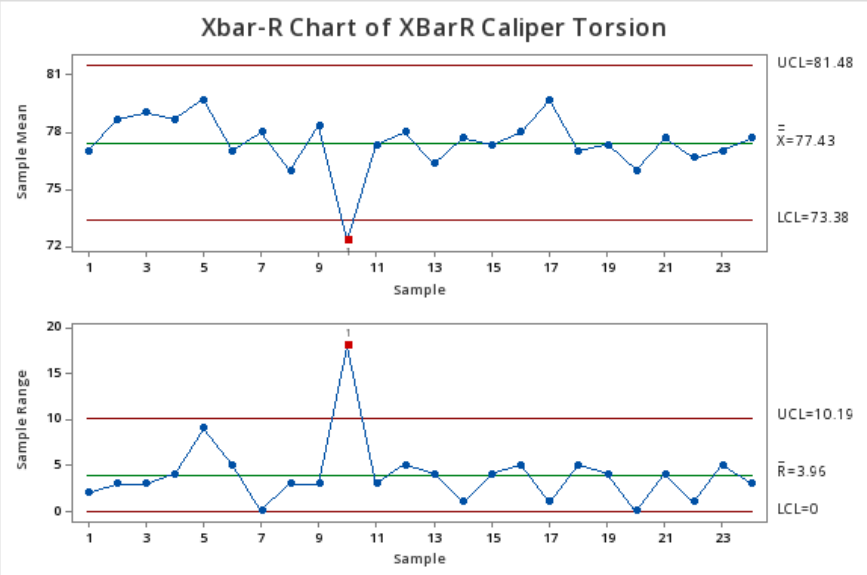


- Process is stable

- The average defect proportion is 20%, with an expected variation between 16.4% and 24%

X-Bar R Chart

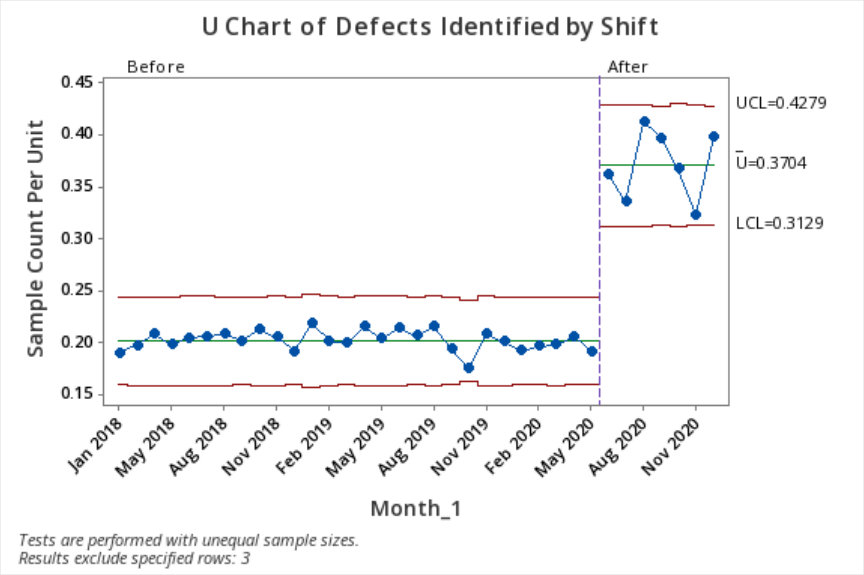
Evaluating the torsion rod resistance of the brake caliper



- Outlier was identified in Subgroup 10
- Subgroup averages typically hover around 77.43, with expected variation between 73.4 and 81.5.
- Investigation is required to understand the anomaly in subgroup 10.

U-Chart

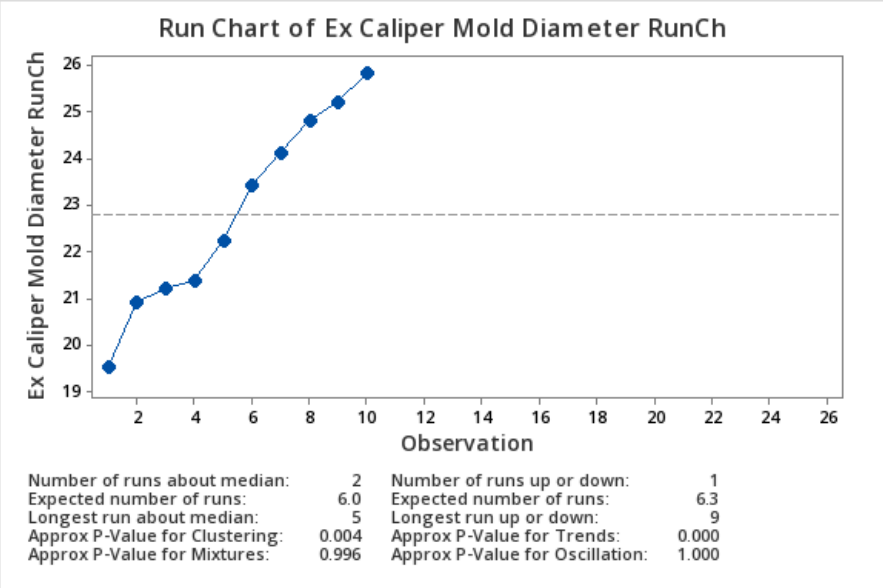
Evaluating the number of defects in airbag testing



- The process remains statistically stable, a noticeable shift occurred following the installation of a new assembler

Run Chart

Monitoring mold diameter variation in brake caliper casting:



- Defects began appearing after the mold diameter increased by 1/4
- The root cause was identified as faulty equipment used for mold de-slagging
- The mold diameter gradually increased over time, negatively impacting the Caliper Torsion Diameter
- The upward trend in mold size was verified