

BC Framing CMM BENCHMARK

Feb-2019

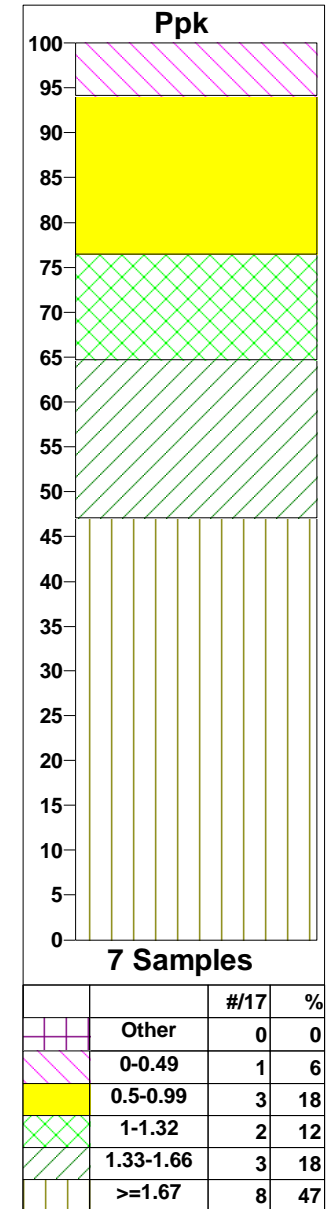
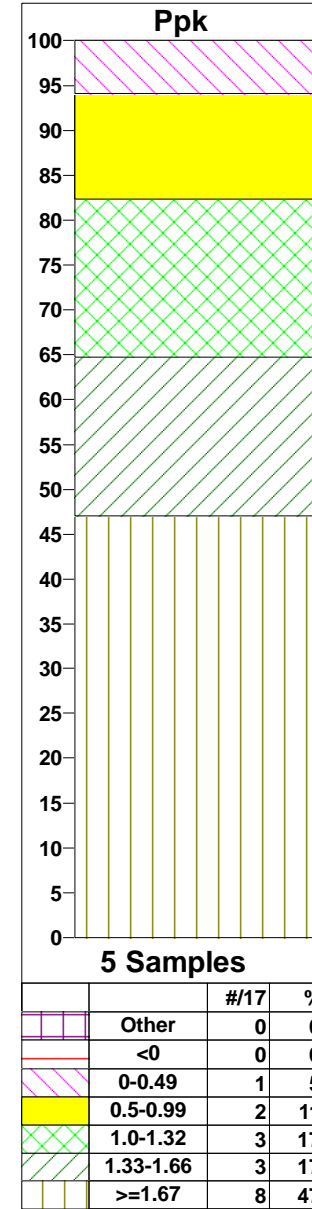
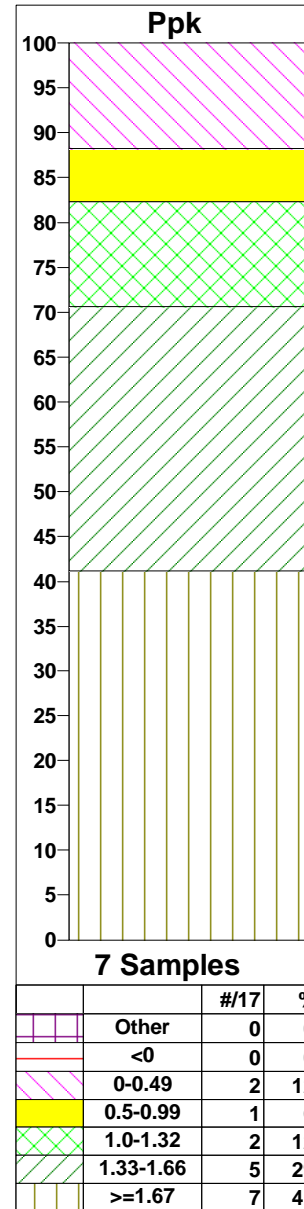
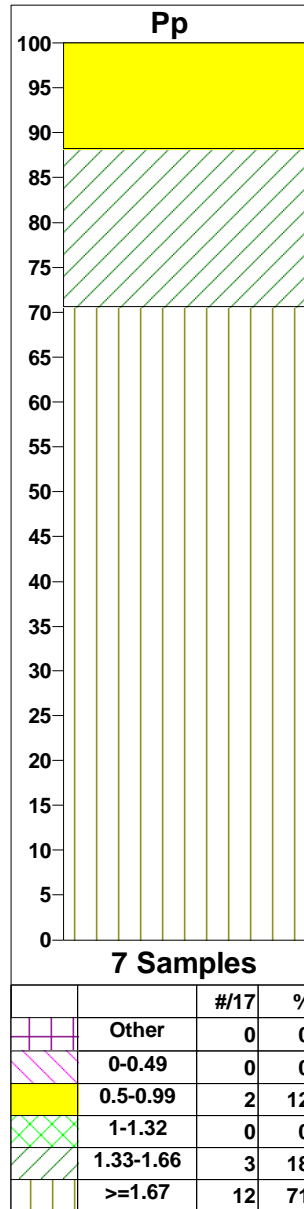
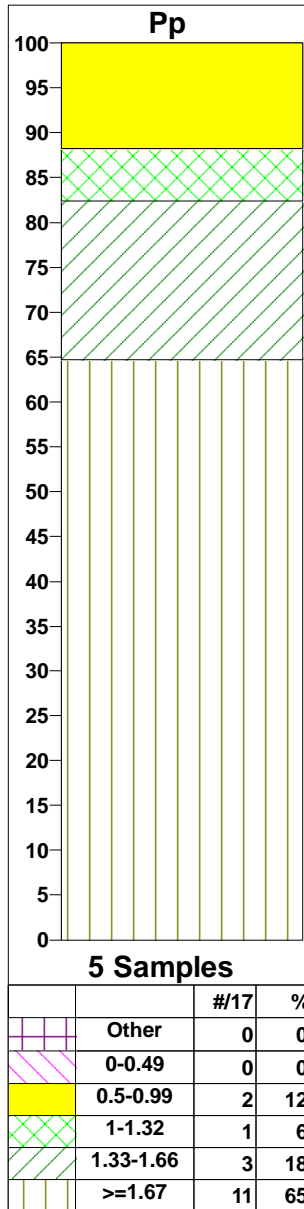
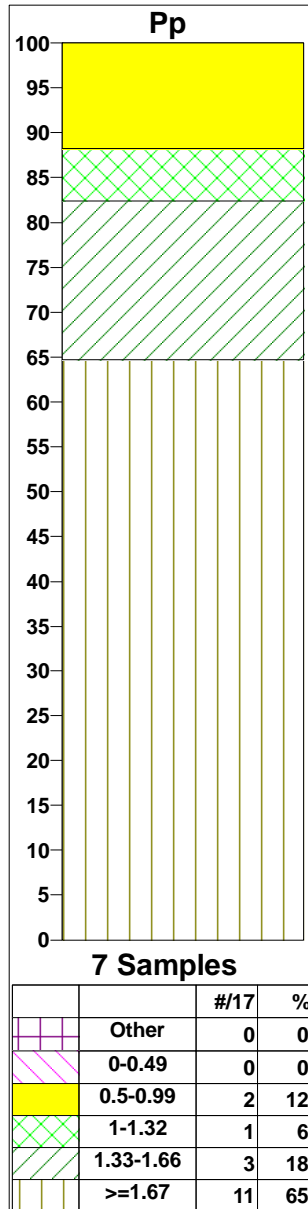
Mar-2019

Apr-2019

Feb-2019

Mar-2019

Apr-2019



FRAMING ASY EB3B-6X70_-A_41-01
BODY CHARACTERISTIC POINTS
U375 CMM BENCHMARK & PIST
JIANGLING ASSEMBLY

Part Number: U375_EB3B-6X70_-A_41-01_CMM
 Plant Name: JIANGLING ASSEMBLY
 Date: 4/29/2019 Time: 09:48:43

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PLANT: JIANGLING ASSEMBLY
 VEHICLE LINE: U375
 PART NAME: FRAMING ASY
 SAMPLE SIZE: Feb-2019 = 7 samples
 DATE: 4/29/2019

Mar-2019 = 5 samples

SHEET METAL Pp/Ppk BC PRIORITIZATION MATRIX

Pp	Ppk
0.0-0.49	<0.0
0.5-0.99	0.0-0.49
1.0-1.32	0.5-0.99
1.33-1.66	1.0-1.32
>=1.67	1.33 - 1.66
Other	>=1.67
	Other

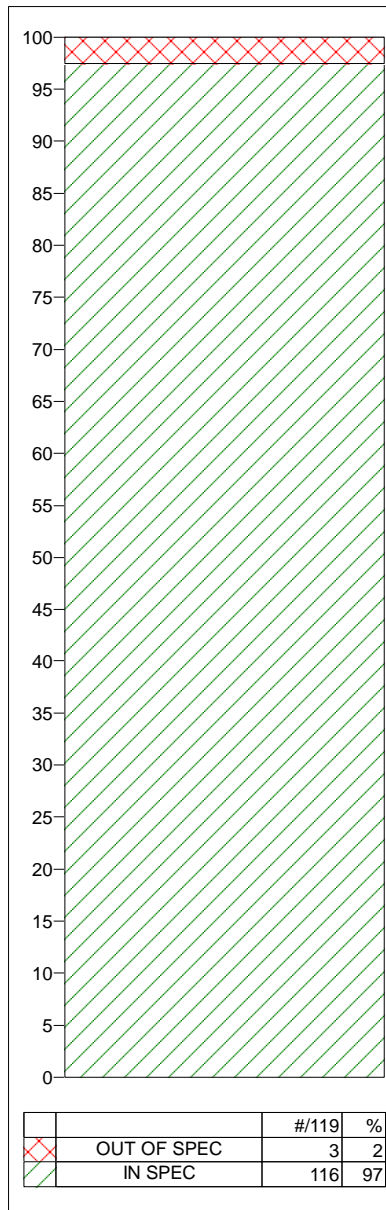
- Priority:
- 1) Must be fixed before next build based upon internal and external indicators.
 - 2) Must be fix by agreed-upon date. Intermin action required.
 - 3) Effect on build unclear, further evaluation required.
 - 4) No corrective action required.

Label	Dir of Check	Description	Feb-2019		Mar-2019		Apr-2019		Priority	Comments
			Pp	Ppk	Pp	Ppk	Pp	Ppk		
U912OLX41015,	X,	PNL CWL TOP,	+2.40,	+2.16,	+2.29,	+1.85,	+1.94,	+1.73,		
U912NHP41015,	X,	PNL CWL TOP,	+2.73,	+1.74,	+1.38,	+0.58,	+3.00,	+1.75,		
U912NHP41015,	Y,	PNL CWL TOP,	+3.36,	+3.15,	+2.19,	+2.06,	+1.77,	+1.55,		
L912MCS41847,	X,	PNL BDY SD,	+1.94,	+1.35,	+1.59,	+1.50,	+6.06,	+5.59,		
L912MCS41847,	Z,	PNL BDY SD,	+2.17,	+2.14,	+5.94,	+5.56,	+3.08,	+3.00,		
R912MCS41846,	X,	PNL BDY SD,	+1.65,	+1.50,	+4.70,	+4.30,	+2.00,	+1.99,		
R912MCS41846,	Z,	PNL BDY SD,	+4.72,	+3.66,	+3.06,	+1.87,	+2.46,	+1.65,		
R924ELY41202,	Y,	PNL FRT RF OTR,	+1.31,	+1.03,	+1.73,	+1.62,	+2.60,	+2.14,		
L188CGY41847,	Nor,	PNL BDY SD,	+1.99,	+0.07,	+2.04,	+1.16,	+1.58,	+0.39,		
R188CGY41846,	Nor,	PNL BDY SD,	+2.31,	+1.51,	+0.91,	+0.86,	+2.05,	+1.72,		
L7727SY41847,	Y,	PNL BDY SD,	+1.84,	+1.68,	+2.39,	+1.86,	+1.35,	+1.21,		
R7727SY41846,	Y,	PNL BDY SD,	+2.33,	+2.21,	+1.62,	+1.15,	+0.75,	+0.63,		
C936PRY41202,	Y,	PNL FRT RF OTR,	+1.43,	+1.02,	+1.94,	+1.49,	+1.92,	+1.19,		
U7723SX41202,	X,	PNL FRT RF OTR,	+1.64,	+1.50,	+2.23,	+2.04,	+1.71,	+1.64,		
U749WSX41202,	X,	PNL FRT RF OTR,	+2.00,	+1.54,	+2.37,	+1.76,	+1.53,	+0.78,		
L936YLZ41847,	Z,	PNL BDY SD,	+0.84,	+0.45,	+0.77,	+0.33,	+3.06,	+1.73,		
R936YLZ41846,	Z,	PNL BDY SD,	+0.59,	+0.51,	+1.26,	+1.10,	+0.93,	+0.58,		

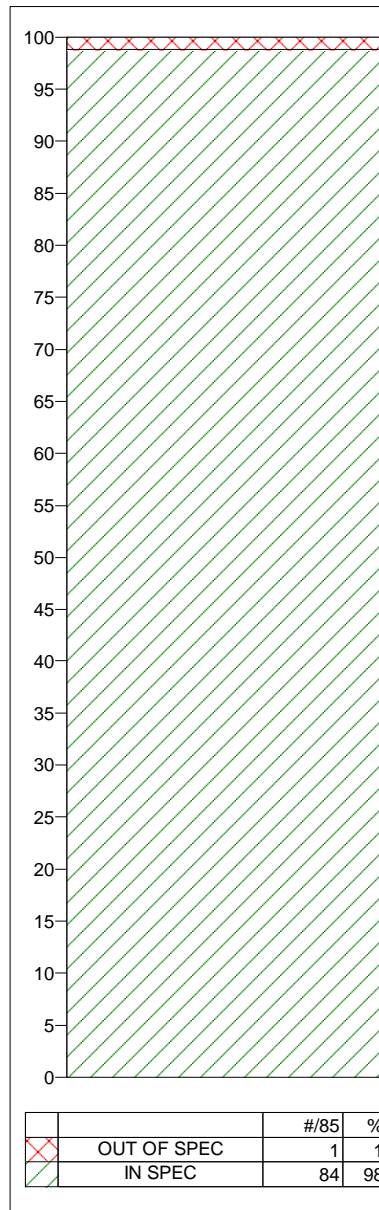


BC PIST BENCHMARK

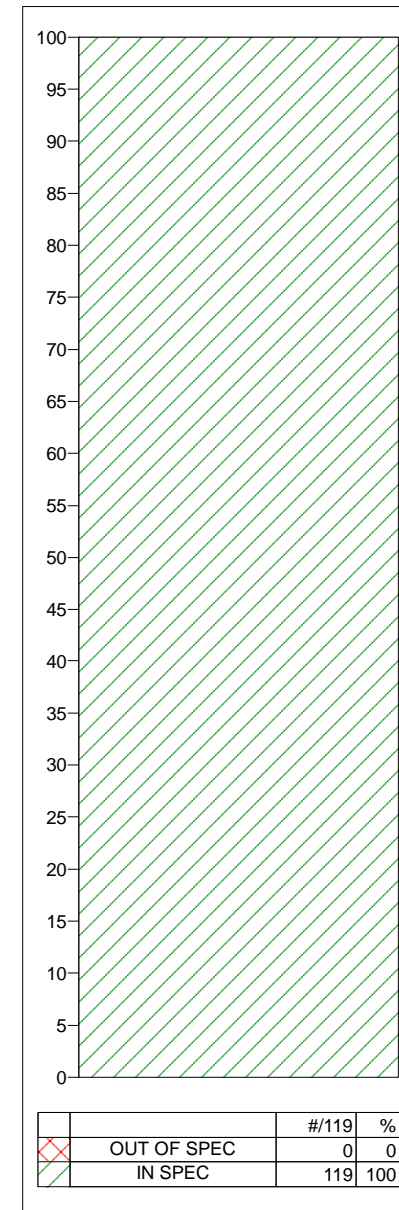
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BODY CHARACTERISTIC POINTS
U375 CMM BENCHMARK & PIST
JIANGLING ASSEMBLY

Part Number: U375_EB3B-6X70_-A_41-01_CMM
 Plant Name: JIANGING ASSEMBLY
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BC PIST MATRIX

Label	Dir of Check	Spec Limits	Feb-2019			Mar-2019			Apr-2019		
			OOS	Mean	6 Sigma	OOS	Mean	6 Sigma	OOS	Mean	6 Sigma
U912OLX41015	X	+1.50/-1.50	0,	+0.15,	+1.25,	0,	-0.29,	+1.31,	0,	-0.17,	+1.55,
U912NHP41015	X	+1.50/-1.50	0,	-0.54,	+1.10,	0,	-0.87,	+2.18,	0,	-0.63,	+1.00,
U912NHP41015	Y	+1.50/-1.50	0,	-0.09,	+0.89,	0,	+0.09,	+1.37,	0,	-0.19,	+1.69,
L912MCS41847	X	+1.50/-1.50	0,	+0.46,	+1.55,	0,	+0.08,	+1.89,	0,	+0.12,	+0.49,
L912MCS41847	Z	+1.50/-1.50	0,	-0.03,	+1.38,	0,	+0.09,	+0.51,	0,	+0.04,	+0.97,
R912MCS41846	X	+1.50/-1.50	0,	+0.13,	+1.82,	0,	-0.13,	+0.64,	0,	+0.00,	+1.50,
R912MCS41846	Z	+1.50/-1.50	0,	-0.34,	+0.64,	0,	-0.58,	+0.98,	0,	-0.50,	+1.22,
R924ELY41202	Y	+1.50/-1.50	0,	-0.32,	+2.29,	0,	+0.09,	+1.74,	0,	-0.27,	+1.16,
L188CGY41847	Nor	+1.50/-1.50	3,	+1.45,	+1.51,	0,	+0.64,	+1.47,	0,	+1.13,	+1.90,
R188CGY41846	Nor	+1.50/-1.50	0,	-0.52,	+1.30,	0,	-0.09,	+3.29,	0,	-0.24,	+1.46,
L7727SY41847	Y	+1.50/-1.50	0,	+0.13,	+1.63,	0,	-0.33,	+1.25,	0,	-0.15,	+2.23,
R7727SY41846	Y	+1.50/-1.50	0,	+0.07,	+1.29,	0,	+0.43,	+1.86,	0,	-0.24,	+3.98,
C936PRY41202	Y	+1.50/-1.50	0,	-0.42,	+2.10,	0,	-0.35,	+1.55,	0,	-0.57,	+1.56,
U7723SX41202	X	+1.50/-1.50	0,	+0.13,	+1.83,	0,	-0.13,	+1.35,	0,	-0.06,	+1.75,
U749WSX41202	X	+1.50/-1.50	0,	+0.35,	+1.50,	0,	+0.38,	+1.27,	0,	+0.73,	+1.96,
L936YLZ41847	Z	+1.50/-1.50	0,	-0.70,	+3.55,	1,	-0.85,	+3.89,	0,	-0.65,	+0.98,
R936YLZ41846	Z	+1.50/-1.50	0,	+0.19,	+5.11,	0,	-0.19,	+2.38,	0,	+0.57,	+3.22,

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JIANGLING ASSEMBLY

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