BC Framing CMM BENCHMARK Feb-2019 Mar-2019 **Apr-2019** Feb-2019 Mar-2019 **Apr-2019** Pр Pр Pp Ppk **Ppk** Ppk 100-100-100 100 100-100 95-95-95-95-95 95 90-90-90-90-90 90-85-85 85-85 85 85-80-80 80 80-80-80 75 75-75 75 75 75 70-70 70-70 70 70 65 65-65-65 65-65 60-60-60-60-60 60 55-55-55 55 55-55 50 50-50-50-50 45-45-45-45-45 45 40-40-40 40 40-40 35-35 35-35 35-35 30-30-30 30-30 30 25-25-25 25 25 25 20-20-20-20 20 20 15-15 15 15 15 15 10-10-10 10 10-10 5-5-5-5 5-7 Samples 7 Samples 5 Samples 7 Samples 5 Samples 7 Samples #/17 % #/17 % #/17 % #/17 % #/17 #/17 Other 0 Other 0 0 0 Other Other Other 0 Other 0 0 0 0 0 0 <0 0 0 0 0-0.49 0 0-0.49 0 0-0.49 0-0.49 0 0 0 6 0 1 0-0.49 0-0.49 1 2 12 0.5-0.99 0.5-0.99 2 12 2 0.5-0.99 12 0.5-0.99 12 2 3 18 0.5-0.99 0.5-0.99 2 11 6 1-1.32 1-1.32 1-1.32 1-1.32 0 2 12 1.0-1.32 17 1.0-1.32 2 12 3 1.33-1.66 3 18 1.33-1.66 3 1.33-1.66 3 18 1.33-1.66 3 18 18 1.33-1.66 17 1.33-1.66 5 3 29 >=1.67 11 65 >=1.67 11 65 >=1.67 12 71 7 >=1.67 8 >=1.67 8 47 >=1.67 41 FRAMING ASY EB3B-6X70_-A_41-01 Part Number: U375 EB3B-6X70 -A 41-01 CMM Plant Name: JIANGLING ASSEMBLY

FRAMING ASY EB3B-6X70_-A_41-0⁻
BODY CHARACTERISTIC POINTS
U375 CMM BENCHMARK & PIST
JIANGLING ASSEMBLY

Date: 4/29/2019 Time: 09:48:43

PAGE: 1

PRINTED COPIES ARE UNCONTROLLED



PLANT: JIANGLING ASSEMBLY

4/29/2019

VEHICLE LINE: U375

DATE:

PART NAME: FRAMING ASY

SAMPLE SIZE:

Feb-2019 = 7 samples Mar-2019 = 5 samples

Apr-2019 = 7 samples

	Pp		Ppk	F
777	0.0-0.49		<0.0	١.
	0.5-0.99	7777	0.0-0.49	ı
∞	1.0-1.32		0.5-0.99	ı
	1.33-1.66	∞	1.0-1.32	ı
	>=1.67		1.33 - 1.66	ı
	Other		>=1.67	ı
			Other	

SHEET METAL Pp/Ppk BC PRIORITIZATION MATRIX Priority:

1) Must be fixed before next build based upon internal and	l
external indicators.	

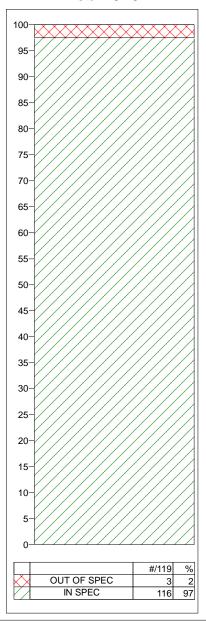
- 2) Must be fix by agreed-upon date. Intermin action required.3) Effect on build unclear, further evaluation required.
- 4) No corrective action required.

			Feb-	Feb-2019		Mar-2019		Apr-2019		
Label	Dir of Check	Description	Pp	Ppk	Pp	Ppk	Pp	Ppk	Priority	Comments
U912OLX41015,	Χ,	PNL CWL TOP,	+2.40,	+2.16,	+2.29,	+1.85,	+1.94,	+1.73,		
U912NHP41015,	Χ,	PNL CWL TOP,	+2.73,	+1.74,	+1.38,	+0.58,	+3.00,	+1.75,		
U912NHP41015,	Y,	PNL CWL TOP,	+3. <mark>36,</mark>	+3.15,	+2.19,	+2.06,	+1.77,	+1,55,		
L912MCS41847,	Χ,	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,	Χ,	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,	41.62,	+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,	Χ,	PNL FRT RF OTR,	+1.64,	+1.50,	+2.23,	+2.04,	+1.71,	+1.64,		
U749WSX41202,	Χ,	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,		

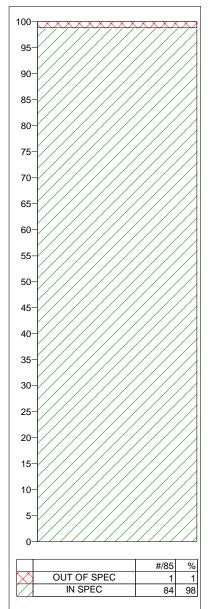


BC PIST BENCHMARK

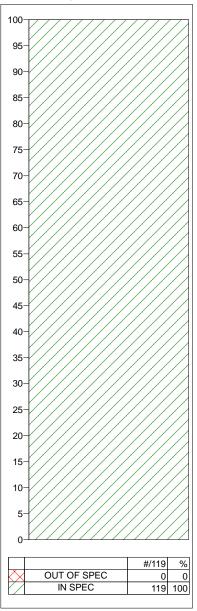
Feb-2019



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: 09:48:56

PAGE: 1

PRINTED COPIES ARE UNCONTROLLED



BC PIST MATRIX

			Feb-2019				Mar-2019)	Apr-2019		
Label	Dir of Check	Spec Limits	oos	Mean	6 Sigma	oos	Mean	6 Sigma	oos	Mean	6 Sigma
U912OLX41015	Х	+1.50/-1.50	0,	+0.15,	+1.25,	0,	-0.29,	+1.31,	0,	-0.17,	+1.55,
U912NHP41015	Х	+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	Х	+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	Х	+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	Х	+1.50/-1.50	0,	+0.13,	+1.83,	0,	-0.13,	+1.35,	0,	-0.06,	+1.75,
U749WSX41202	Х	+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,

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: 09:49:02

PRINTED COPIES ARE UNCONTROLLED