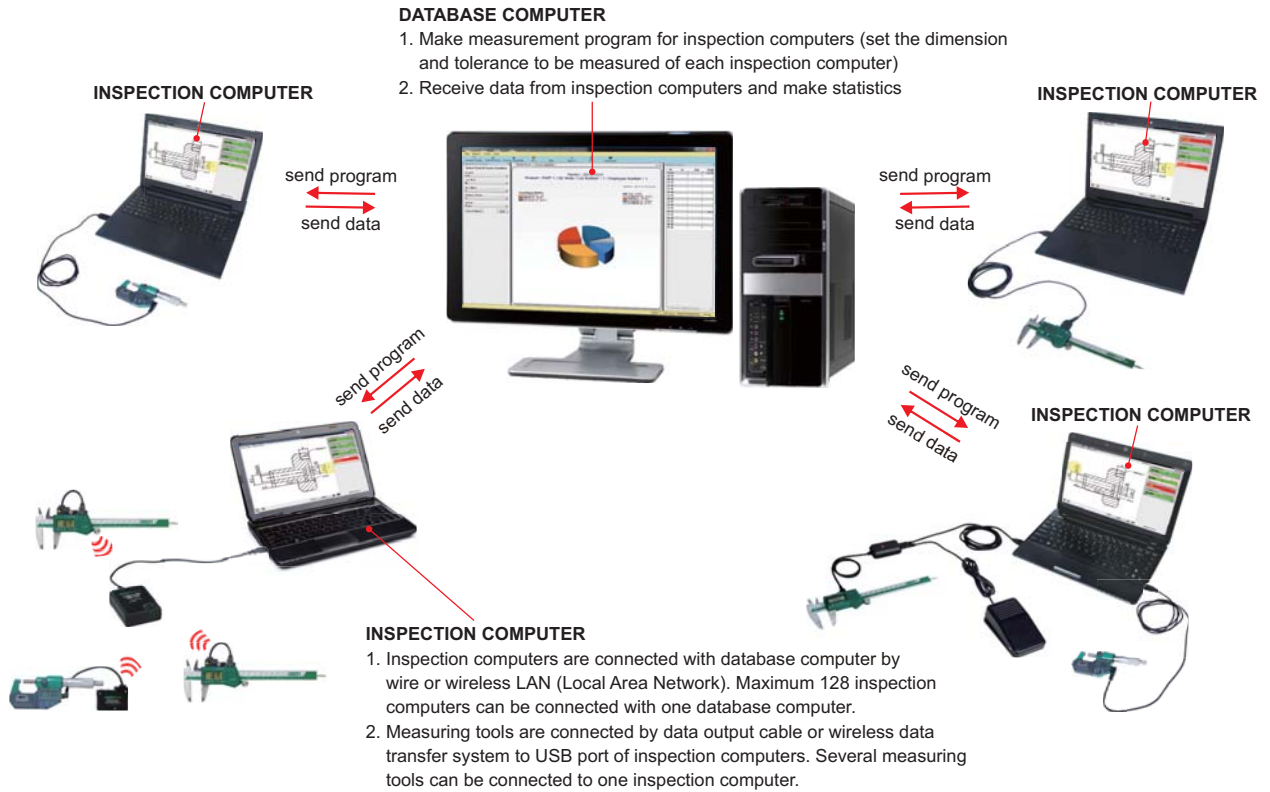


MEASURING DATA MANAGEMENT SOFTWARE



SOFTWARE FOR DATABASE COMPUTER CODE 7311-1

make measurement program

workpiece information

Product: PART 1
 Require Lot Number Require Serial Number
 Part No: SPI-ISP-23015-A1
 Part Name: HANDWHEEL
 Customer: INSIZE
 Comment: All dimensions should be in tolerance.

NO	POINT	PARAMETER	INSTRUMENT TYPE	INSTRUMENT NAME	ID	SPEC TYPE	DATA TYPE	SPEC
1	A	DEPTH	USB	DEPTH CALIPER		Center (+/-)	Decimal	2.5 0.1
2	B	WIDTH	USB	DEPTH CALIPER		Lower/Upper	Decimal	1.9
3	C	DIAMETER	USB	CALIPER		Base+Lower@Upper	Decimal	10 0.1
4	D	DIAMETER	USB	CALIPER		Center (+/-)	Decimal	5 0.05

measuring items

description
measuring code

input port

measuring tools

set tolerance

workpiece drawing

Save *** Close Apply ***

Make measurement program for each one inspection computer. Maximum 200 dimensions can be measured by one inspection computer.

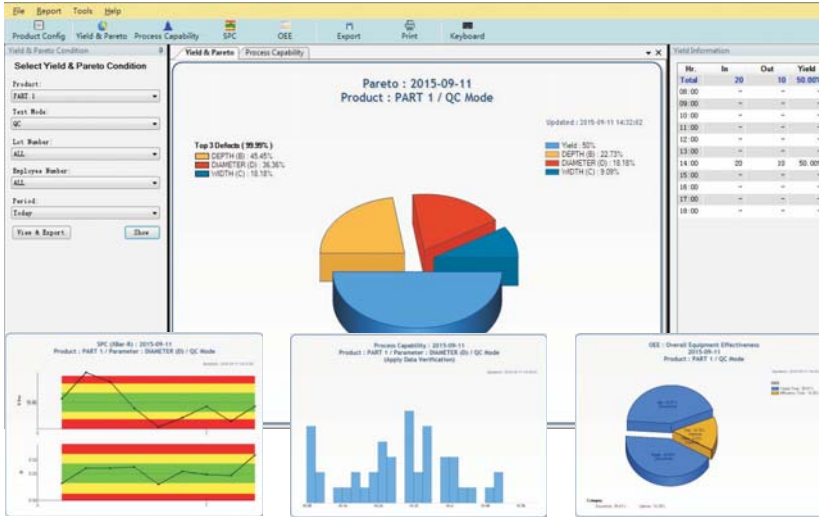
To be continued

Continued from previous page

make data statistics

report

INSPECTION REPORT SHEET



DATE: 2015-09-11 - 2015-09-11
 CUSTOMER NAME: INSIZE
 PART NAME: HANDEWHEEL
 PART NO.: SPC-ESP-27015-A1
 LOT NO.: 2
 QUANTITY: _____

NUMBER PRODUCED: _____
 VISAUJ: _____
 CHECK QUANTITY: 7
 ACCEPT QUANTITY: 3
 REJECT QUANTITY: 4
 MACHINE: _____

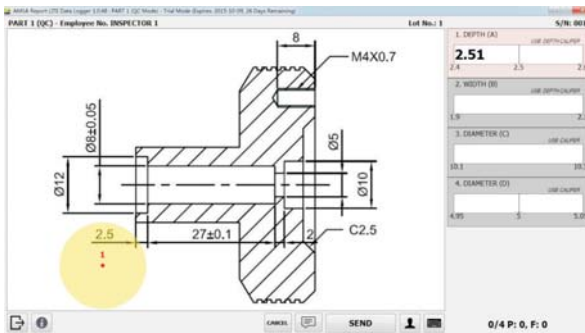
NO.	TYPE	TOL.	REMARK	TOL.	INSTRUMENT	1	2	3	4	5	6	7
A	DEPTH	2.5	±0.1	DEPTH CALIPER	2.46	2.50	2.46	2.50	2.46	2.50		
B	WIDTH	1.8	±0.1	DEPTH CALIPER	1.7	1.80	1.80	1.80	1.80	1.80		
C	DIAMETER	10	±0.1	CALIPER	10.3	10.3	10.4	10.4	10.3	10.3		
D	DIAMETER	5	±0.05	CALIPER	5.07	4.98	5.01	4.94	5.06	5.01		

process control analysis

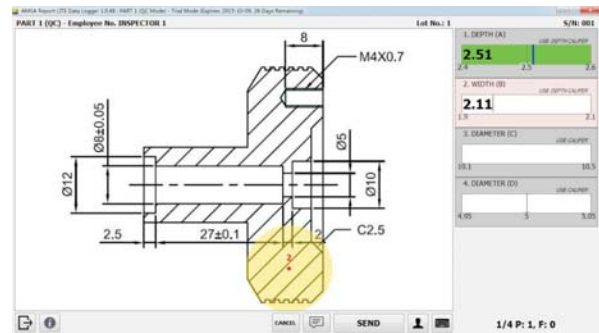
CPK analysis

overall equipment effectiveness analysis

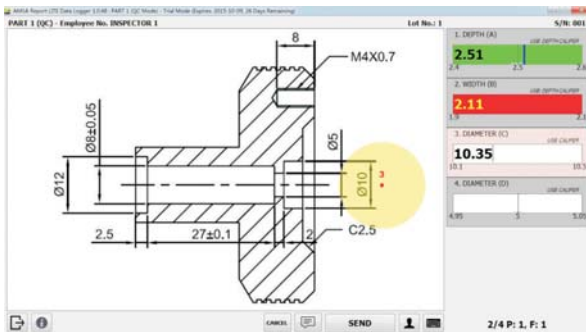
SOFTWARE FOR INSPECTION COMPUTER CODE 7311-2



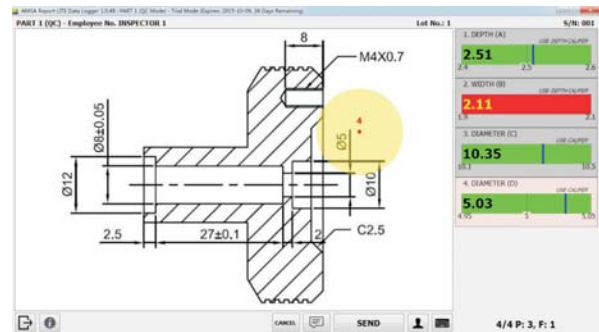
Measure the 1st dimension by following the yellow position indication.



Measure the 2nd dimension by following the yellow position indication. The 1st data will be shown in red or green according its tolerance.



Measure the 3rd dimension by following the yellow position indication. The 2nd data will be shown in red or green according its tolerance.



Measure the 4th dimension by following the yellow position indication. The 3rd data will be shown in red or green according its tolerance. The data of four measurements will be sent to the database computer.