

附2

测量过程监视记录及控制图

|             |                            |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
|-------------|----------------------------|---------------|---------|-------------------------------------------|---------|---------|----------------------------------|----------|----------|---------|------------------------------------------|----------------|---------|
| 过程名称:       |                            | 壳体隔爆面内径尺寸测量过程 |         |                                           | 技术参数    |         | 内径尺寸:<br>Φ270mm (+0.07/+0.02) mm |          |          | 最大允许误差: |                                          | ±0.0083mm      |         |
| 测量仪器:       |                            | 内径千分尺         |         |                                           | 测量范围:   |         | (50-600) mm                      |          |          | 校准不确定度  |                                          | U=0.004mm ,k=2 |         |
| 核查标准:       |                            |               |         |                                           | 被测物件    |         |                                  |          |          |         |                                          |                |         |
| 日 期:        |                            | 21/5/18       | 21/6/16 | 21/7/13                                   | 21/8/20 | 21/9/21 | 21/10/20                         | 21/11/19 | 21/12/16 | 21/1/13 | 21/2/20                                  | 22/3/14        | 22/4/8  |
| 测<br>量<br>值 | 1                          | 270.040       | 270.040 | 270.048                                   | 270.042 | 270.042 | 270.042                          | 270.040  | 270.044  | 270.040 | 270.042                                  | 270.036        | 270.040 |
|             | 2                          | 270.040       | 270.038 | 270.040                                   | 270.040 | 270.046 | 270.046                          | 270.038  | 270.040  | 270.038 | 270.040                                  | 270.038        | 270.038 |
|             | 3                          | 270.042       | 270.038 | 270.040                                   | 270.038 | 270.038 | 270.040                          | 270.038  | 270.042  | 270.038 | 270.044                                  | 270.036        | 270.036 |
|             | 4                          | 270.042       | 270.042 | 270.038                                   | 270.038 | 270.042 | 270.036                          | 270.040  | 270.040  | 270.042 | 270.042                                  | 270.038        | 270.038 |
|             | 5                          | 270.038       | 270.036 | 270.038                                   | 270.040 | 270.040 | 270.040                          | 270.040  | 270.038  | 270.034 | 270.042                                  | 270.038        | 270.038 |
| 平均值(X)      |                            | 270.040       | 270.039 | 270.041                                   | 270.040 | 270.042 | 270.041                          | 270.039  | 270.041  | 270.038 | 270.042                                  | 270.037        | 270.038 |
| 全距 (R)      |                            | 0.004         | 0.006   | 0.010                                     | 0.004   | 0.008   | 0.010                            | 0.002    | 0.006    | 0.008   | 0.004                                    | 0.002          | 0.004   |
|             | $\bar{X}$                  | 270.040       |         | UCLx= $\bar{X}$ +A <sub>2</sub> $\bar{R}$ |         | 270.043 |                                  | A2       | 0.577    |         | 注：<br>1) 每次测量数据不少于5个。<br>2) 每组测量数据数量应统一。 |                |         |
|             | $\bar{R}$                  | 0.006         |         | LCLx= $\bar{X}$ -A <sub>2</sub> $\bar{R}$ |         | 270.037 |                                  | D3       | 0        |         |                                          |                |         |
|             |                            |               |         | UCLr=D4 $\bar{R}$                         |         | 0.012   |                                  | D4       | 2.114    |         |                                          |                |         |
|             |                            |               |         | LCLr=D3 $\bar{R}$                         |         | 0.000   |                                  |          |          |         |                                          |                |         |
| 均值图         |                            |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
|             |                            |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
| 极差图         |                            |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
|             |                            |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
| 判           | 均值、极差控制图状态正常，测量过程中未出现非正常变异 |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
| 定           | 若有任何一个X值及R值在管制上下限外则不可接受    |               |         |                                           |         |         |                                  |          |          |         |                                          |                |         |
| 判定者:        |                            | 吉凯华           |         |                                           |         |         |                                  | 审核:      | 李万杰      |         |                                          |                |         |