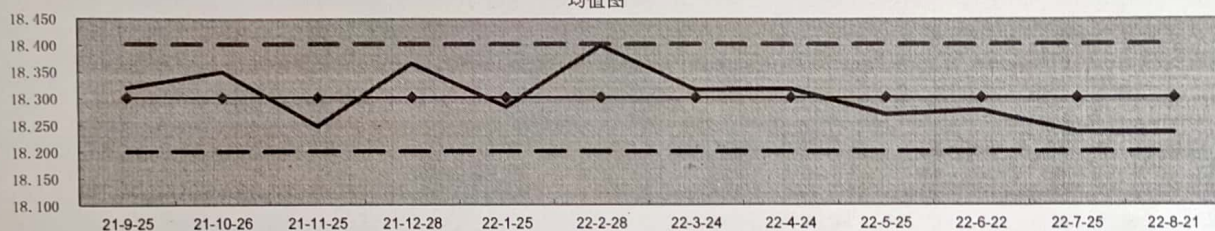


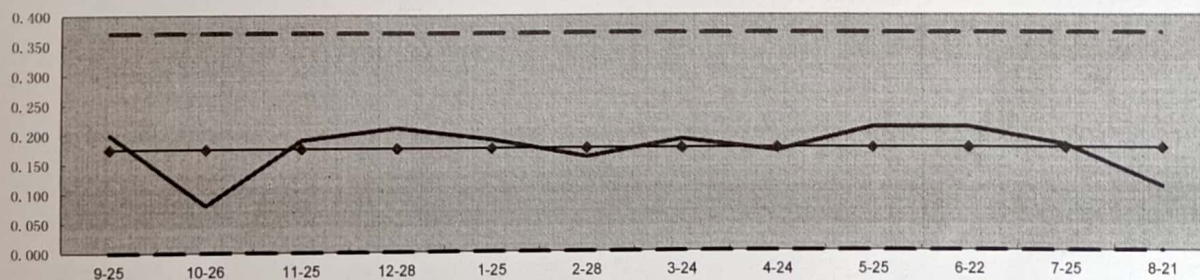
## 测量过程监视方法、监视记录及控制图

|        |                |          |          |                                 |         |            |         |         |         |                                          |         |         |       |
|--------|----------------|----------|----------|---------------------------------|---------|------------|---------|---------|---------|------------------------------------------|---------|---------|-------|
| 过程名称:  | 圆股钢丝绳直径测量过程    |          |          |                                 | 技术要求    | T=0.4mm    |         |         |         | 导出设备最大允许误差:                              | 0.13mm  |         |       |
| 测量仪器:  | 数显游标卡尺/DD13611 |          |          |                                 | 测量范围:   | (0~200) mm |         |         |         | 最大允许误差:                                  | ±0.03mm |         |       |
| 日期:    | 21-9-25        | 21-10-26 | 21-11-25 | 21-12-28                        | 22-1-25 | 22-2-28    | 22-3-24 | 22-4-24 | 22-5-25 | 22-6-22                                  | 22-7-25 | 22-8-21 |       |
| 测量值    | 1.000          | 18.38    | 18.39    | 18.21                           | 18.36   | 18.40      | 18.47   | 18.21   | 18.38   | 18.21                                    | 18.18   | 18.15   | 18.18 |
|        | 2.000          | 18.21    | 18.33    | 18.21                           | 18.21   | 18.21      | 18.38   | 18.21   | 18.37   | 18.18                                    | 18.21   | 18.21   | 18.21 |
|        | 3.000          | 18.21    | 18.39    | 18.21                           | 18.42   | 18.21      | 18.47   | 18.40   | 18.26   | 18.21                                    | 18.39   | 18.33   | 18.21 |
|        | 4.000          | 18.39    | 18.33    | 18.40                           | 18.42   | 18.39      | 18.31   | 18.36   | 18.21   | 18.36                                    | 18.39   | 18.29   | 18.29 |
|        | 5.000          | 18.41    | 18.31    | 18.21                           | 18.42   | 18.21      | 18.37   | 18.40   | 18.37   | 18.39                                    | 18.22   | 18.21   | 18.29 |
| 平均值(X) | 18.32          | 18.35    | 18.25    | 18.37                           | 18.28   | 18.40      | 18.32   | 18.32   | 18.27   | 18.28                                    | 18.24   | 18.24   |       |
| 极差(R)  | 0.20           | 0.08     | 0.19     | 0.21                            | 0.19    | 0.16       | 0.19    | 0.17    | 0.21    | 0.21                                     | 0.18    | 0.11    |       |
|        | $\bar{X}$      | 18.302   |          | $UCL_X = \bar{X} + A_2 \bar{R}$ |         | 18.403     |         | 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。 |         |         |       |
|        | $\bar{R}$      | 0.175    |          | $LCL_X = \bar{X} - A_2 \bar{R}$ |         | 18.201     |         | D3      | 0       |                                          |         |         |       |
|        |                |          |          | $UCL_R = D_4 \bar{R}$           |         | 0.370      |         | D4      | 2.114   |                                          |         |         |       |
|        |                |          |          | $LCL_R = D_3 \bar{R}$           |         | 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:

刘小辉



扫描全能王 创建