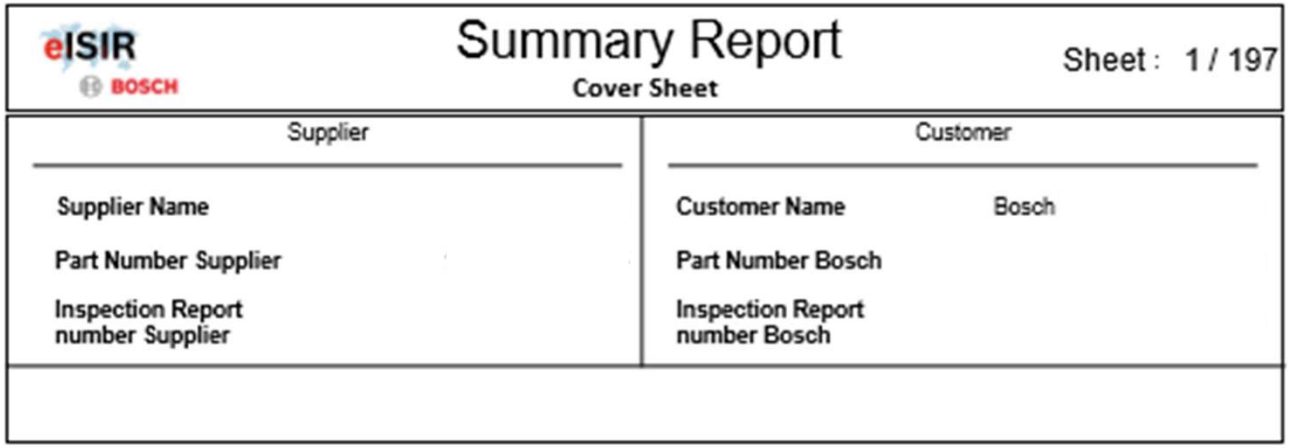


1. **OVERVIEW ICL-SEQUENCE**
   All cmk values in a table according to ICL sequence

2. **OVERVIEW CMK ASCENDING**
   All cmk values in a table sorted by cmk ascending

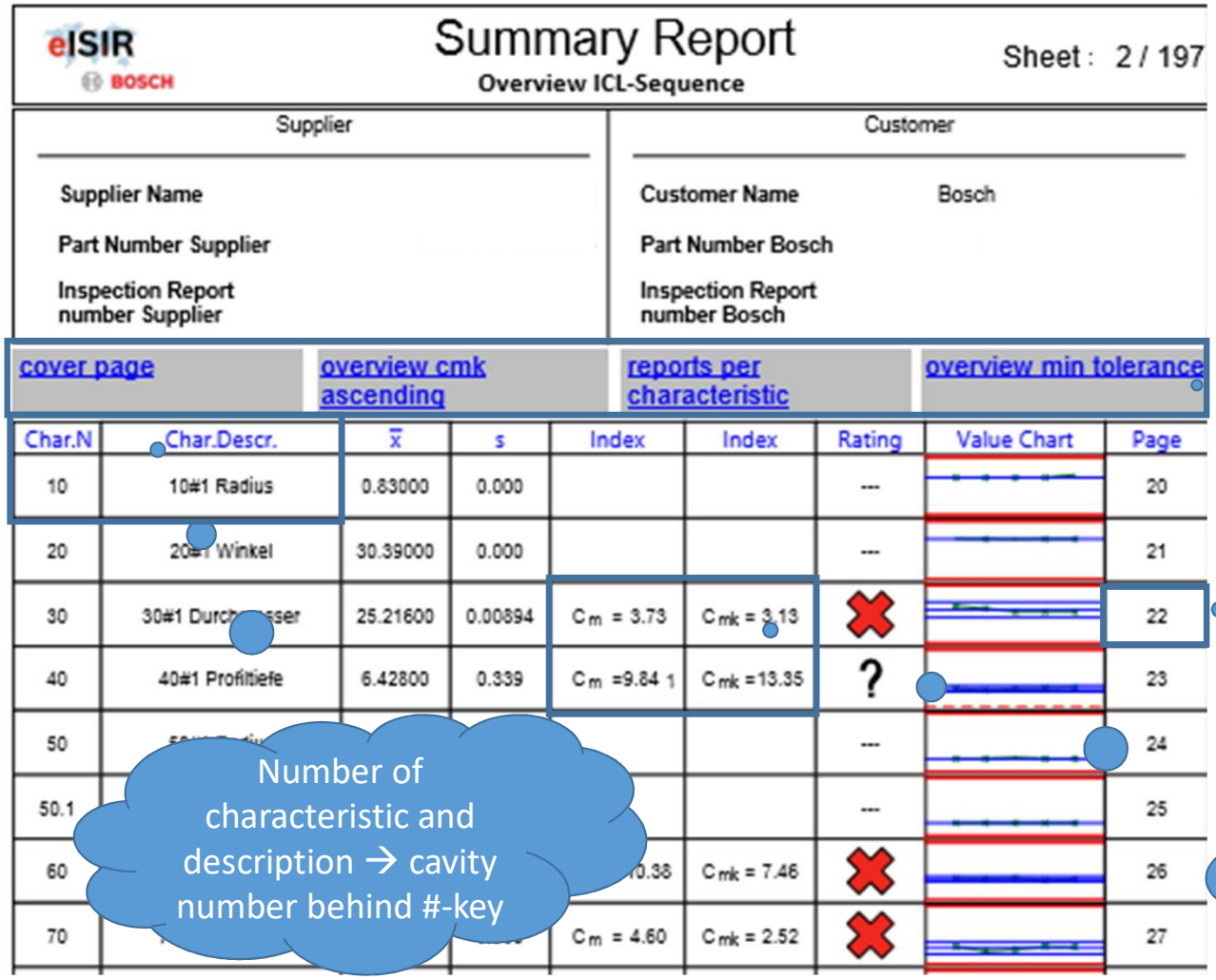
3. **DETAILED EVALUATION SHEET PER CHARACTERISTIC**

4. **OVERVIEW MIN-TOLERANCE**
   All cmk values in a table (ICL sequence) – Info of the minimum tolerance for a capable characteristic

The summary report contains all calculated capabilities in one PDF file. With a linked table of content a comfortable navigation between the different content is possible:

1. Overview table of all cmk values in ICL sequence
2. Overview table of all cmk values in ascending sequence (worst results first)
3. Detailed evaluation sheet per characteristic
4. Overview table of all cmk values in ICL sequence – info of min tolerances for a capable characteristic

1. Overview table of all cmk values in ICL sequence



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BOSCH

Summary Report

Overview ICL-Sequence

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Supplier		Customer	
Supplier Name		Customer Name	Bosch
Part Number Supplier		Part Number Bosch	
Inspection Report number Supplier		Inspection Report number Bosch	

cover page | overview cmk ascending | reports per characteristic | overview min tolerance

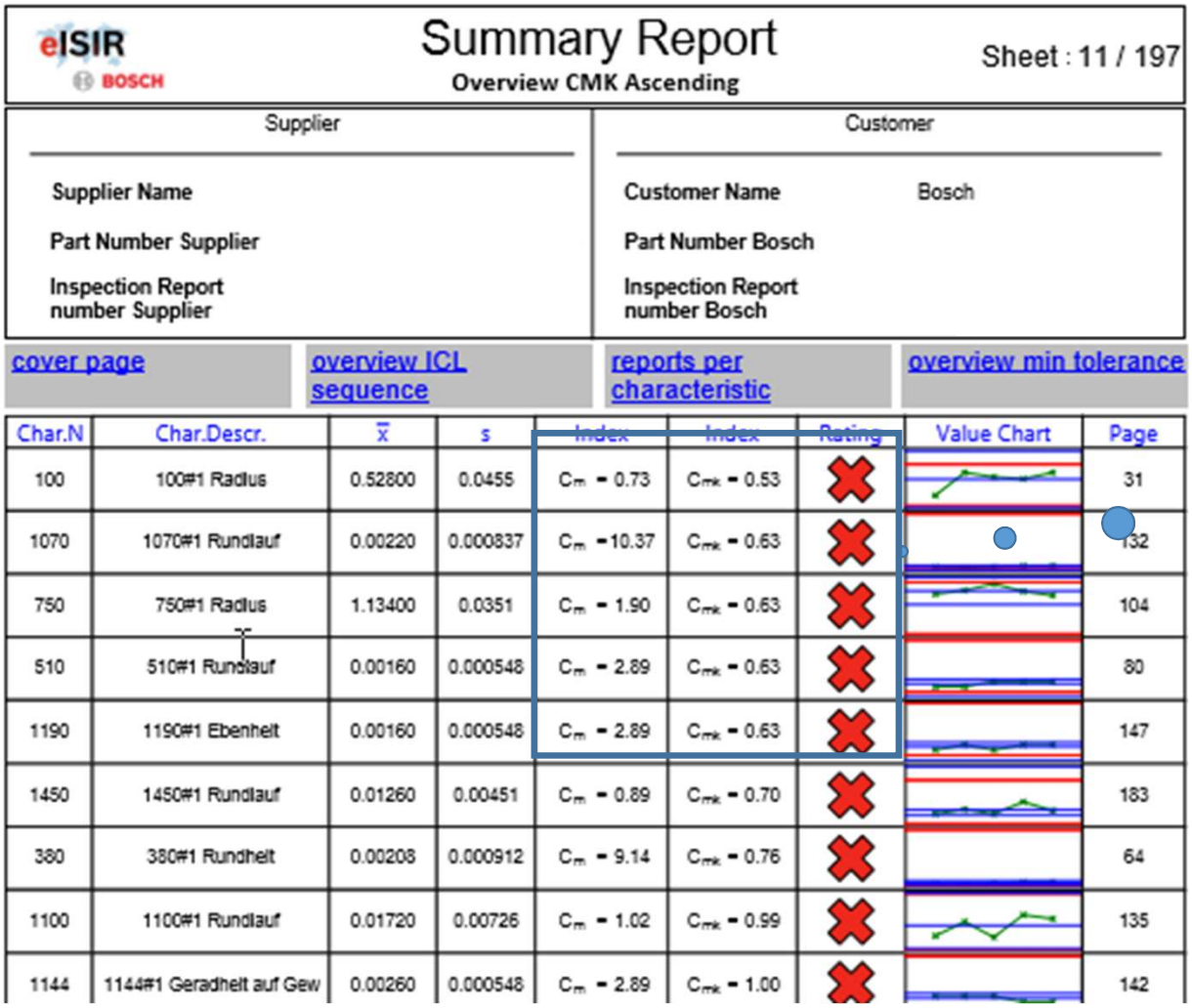
Char.N	Char.Descr.	$\bar{x}$	s	Index	Index	Rating	Value Chart	Page
10	10#1 Radius	0.83000	0.000			---		20
20	20#1 Winkel	30.39000	0.000			---		21
30	30#1 Durchmesser	25.21600	0.00894	C_m = 3.73	C_{mk} = 3.13	✖		22
40	40#1 Profiltiefe	6.42800	0.339	C_m =9.84 1	C_{mk} =13.35	?		23
50						---		24
50.1						---		25
60				0.38	C_{mk} = 7.46	✖		26
70				C_m = 4.60	C_{mk} = 2.52	✖		27

Navigation bar quick links to entire content

Link to detailed evaluation sheet of characteristic

Number of characteristic and description → cavity number behind #-key

Cm/cmk-value including rating (assessment) for each characteristic



eISIR BOSCH

Summary Report

Overview CMK Ascending

Sheet : 11 / 197

Supplier		Customer	
Supplier Name		Customer Name	Bosch
Part Number Supplier		Part Number Bosch	
Inspection Report number Supplier		Inspection Report number Bosch	

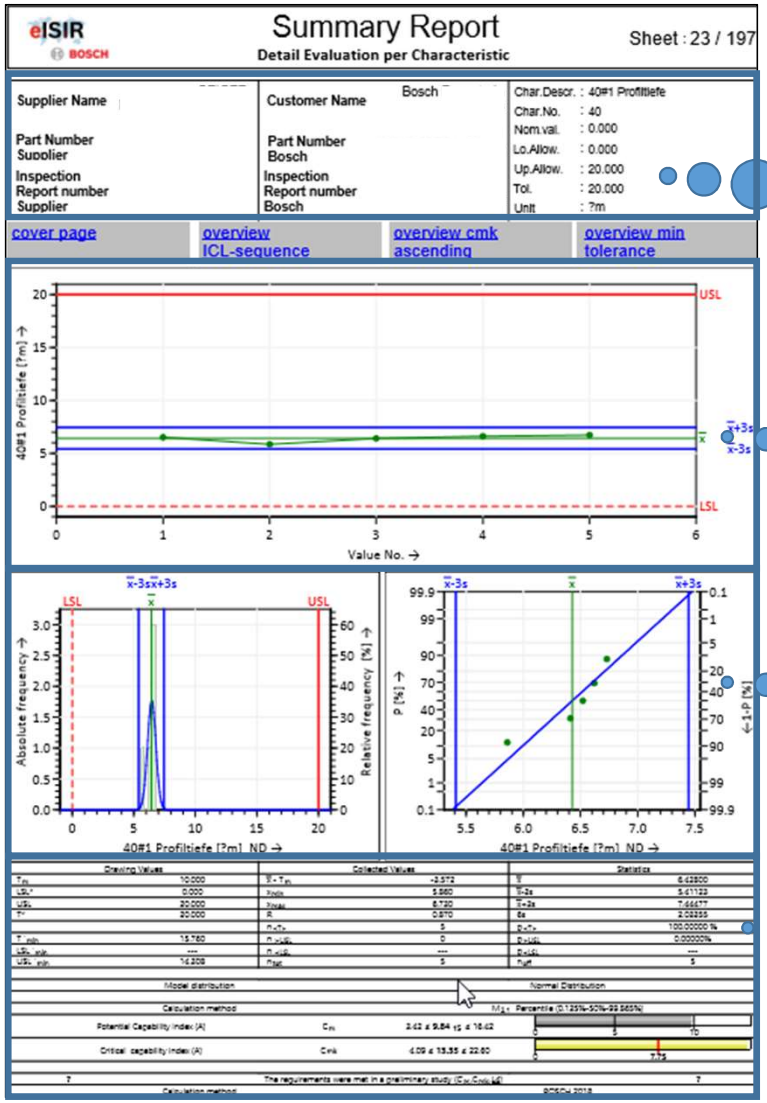
cover page | overview ICL sequence | reports per characteristic | overview min tolerance

Char.N	Char.Descr.	$\bar{x}$	s	Index	Index	Rating	Value Chart	Page
100	100#1 Radius	0.52800	0.0455	C_m = 0.73	C_{mk} = 0.53	✗		31
1070	1070#1 Rundlauf	0.00220	0.000837	C_m = 10.37	C_{mk} = 0.63	✗		132
750	750#1 Radius	1.13400	0.0351	C_m = 1.90	C_{mk} = 0.63	✗		104
510	510#1 Rundlauf	0.00160	0.000548	C_m = 2.89	C_{mk} = 0.63	✗		80
1190	1190#1 Ebenheit	0.00160	0.000548	C_m = 2.89	C_{mk} = 0.63	✗		147
1450	1450#1 Rundlauf	0.01260	0.00451	C_m = 0.89	C_{mk} = 0.70	✗		183
380	380#1 Rundheit	0.00208	0.000912	C_m = 9.14	C_{mk} = 0.76	✗		64
1100	1100#1 Rundlauf	0.01720	0.00726	C_m = 1.02	C_{mk} = 0.99	✗		135
1144	1144#1 Geradheit auf Gew	0.00260	0.000548	C_m = 2.89	C_{mk} = 1.00	✗		142

2. Overview table of all cmk values in ascending sequence

Overview of the lowest cmk values of the report

3. Detailed evaluation sheet per characteristic



Headerdata: Report-, part- and characteristics identification, tolerances

Time line plot of measurements in sequence of measuring

Histogram and propability plot for data analysis

Statistical results (cm, cmk, min tolerances)

3. Detailed evaluation sheet per characteristic

Drawingdata/set tolerances and minimal toleranzes for capable cmk (tolerance discussion)

Infos to measured values

Statistical calculations

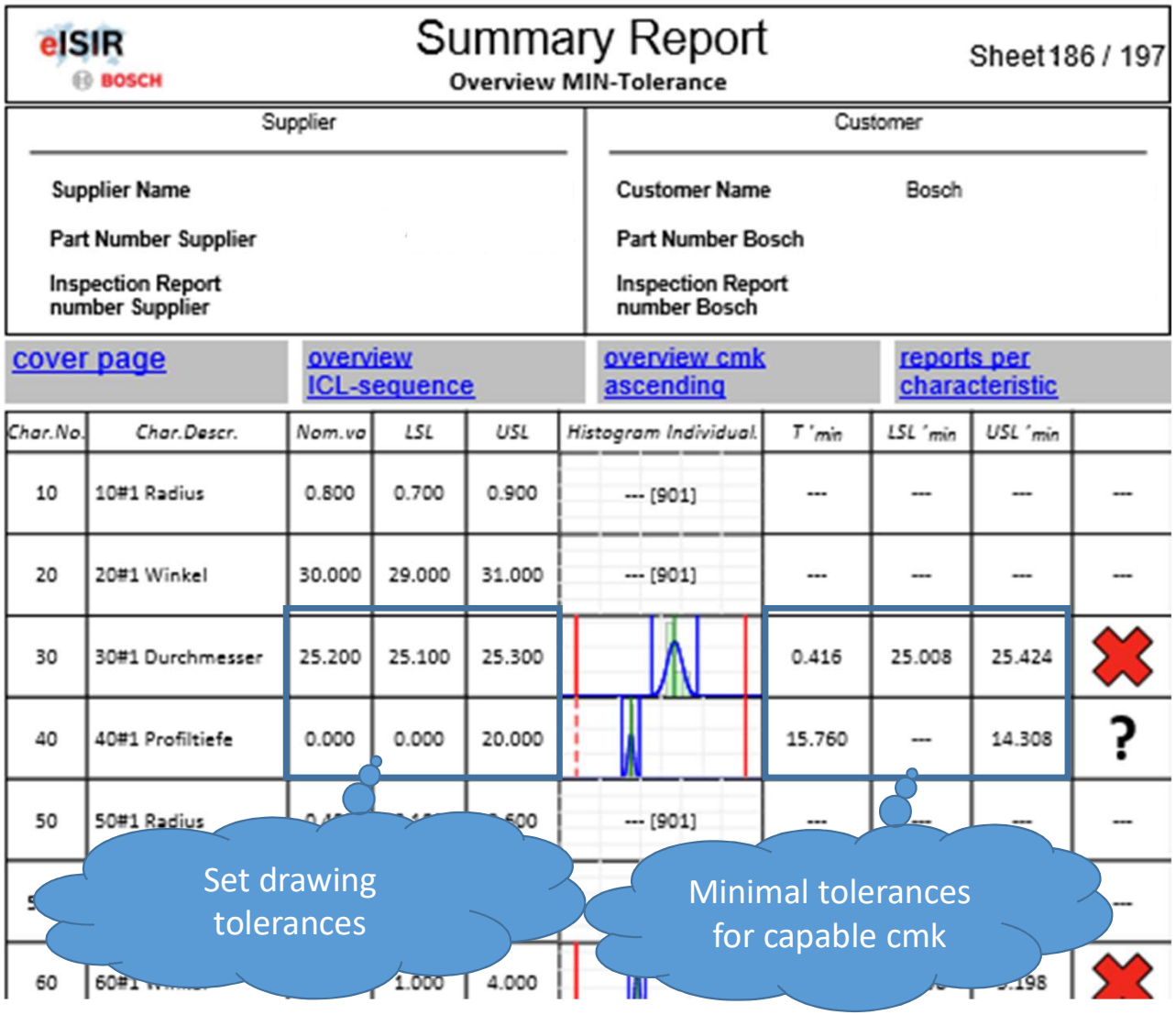
Drawing Values		Collected Values		Statistics	
T_m	10.000	$\bar{x} - T_m$	-3.572	$\bar{x}$	6.42800
LSL*	0.000	x_{min}	5.860	$\bar{x}$-3s	5.41123
USL	20.000	x_{max}	6.730	$\bar{x}$+3s	7.44477
T*	20.000	R	0.870	6s	2.03355
		$n_{<T>}$	5	$p_{<T>}$	100.00000 %
T'_{min}	15.760	$n_{>USL}$	0	$p_{>USL}$	0.00000%
LSL'_{min}	---	$n_{<LSL}$	---	$p_{<LSL}$	---
USL'_{min}	14.308	n_{tot}	5	n_{eff}	

Model of distribution chosen for the calculation

Model distribution			Normal Distribution
Calculation method			$M_{2,1}$ Percentile (0.135%-50%-99.865%)
Potential Capability index (A)	C_m	3.42 ≤ **9.84** $_{15}$ ≤ 16.42	0 5 10
Critical capability index (A)	C_{mk}	4.09 ≤ **13.35** ≤ 22.60	0 7.75
?	The requirements were met in a preliminary study (C_m C_{mk} I.4)		?
Calculation method			BOSCH 2018

Calculation method

4. Overview table of all cmk values in ICL sequence – info of min tolerances for a capable characteristic



eISIR BOSCH

Summary Report

Overview MIN-Tolerance

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Supplier		Customer	
Supplier Name		Customer Name	Bosch
Part Number Supplier		Part Number Bosch	
Inspection Report number Supplier		Inspection Report number Bosch	

cover page | overview ICL-sequence | overview cmk ascending | reports per characteristic

Char.No.	Char.Descr.	Nom.va	LSL	USL	Histogram Individual	T 'min	LSL 'min	USL 'min	
10	10#1 Radius	0.800	0.700	0.900	--- [901]	---	---	---	---
20	20#1 Winkel	30.000	29.000	31.000	--- [901]	---	---	---	---
30	30#1 Durchmesser	25.200	25.100	25.300		0.416	25.008	25.424	✖
40	40#1 Profiltiefe	0.000	0.000	20.000		15.760	---	14.308	?
50	50#1 Radius			600	--- [901]	---	---	---	---

60	60#1		1.000	4.000				198	✖

Set drawing tolerances

Minimal tolerances for capable cmk