

DATE: 2013/01/28

HONDA NEW MODEL DEVELOPMENT INSPECTION DATA SHEET

PART NUMBER: 237465		SIDE: <input checked="" type="checkbox"/> Right <input type="checkbox"/> Left		PART RANK				DATA EVALUATION AND RESULTS							
PART NAME: INS37465_MA16_11PT		MODEL:						HONDA			SUPPLIER			PAGE: Page 1 of 3	
SUPPLIER: Transformation Software Inc.		FACILITY:						WHO			WHO				
DATA PURPOSE: <input checked="" type="checkbox"/> REGULAR INSPECTION <input type="checkbox"/> PROBLEM INVESTIGATION <input type="checkbox"/> NEW MODEL INSPECTION <input type="checkbox"/> OTHER: _____		REPORT FREQUENCY TO HONDA F - FILE M - MONTHLY D - DAILY Q - QUARTERLY W - WEEKLY Y - YEARLY		REGULATION PART YES NO				DATE			DATE			#PTS	%
REVISION RECORD							D/C NUMBER:			CATEGORY			18	94.74	
							LOT NUMBER / EVENT:			OK WITHIN DRAWING TOLERANCE					
							TOOLING LEVEL:			NG OUT OF DRAWING SPECIFICATION			1	5.26	
							HANDWORK: Y <input type="checkbox"/> N <input checked="" type="checkbox"/>			TOTAL POINTS			19	100	
							COMMENTS:								

DEVIATIONS FROM NOMINAL MUST BE RECORDED

No.	INSPECTION ITEM	Method	NM INSP FREQ.	MP INSP FREQ.	(-) LSL	(+) USL	T B H / rx ry Z	Nominal	RESULTS						X-Bar	R	
									File: 1	File: 2	File: 3						
1	DIM LOC7= LOCATION OF POINT IT1	CMM	Weekly	Daily	0.0200	0.0200	B	0.3250	0.0033	0.0022	0.0033					0.0029	0.0011
2	DIM LOC6= LOCATION OF POINT IT2	CMM	Weekly	Daily	0.0200	0.0200	B	0.6180	-0.0004	-0.0018	-0.0026					-0.0016	0.0022
3	DIM LOC8= LOCATION OF POINT IT3	CMM	Weekly	Daily	0.0200	0.0200	B	0.6800	-0.0003	-0.0016	0.0047					0.0009	0.0063
4	DIM LOC14= LOCATION OF POINT IT4A	CMM	Weekly	Daily	0.0200	0.0200	B	0.7500	0.0092	0.0073	0.0068					0.0078	0.0024
	0.0099								0.0087	0.0051					0.0079	0.0048	
6	DIM LOC9= LOCATION OF POINT IT6_1	CMM	Weekly	Daily	0.0100	0.0100	T		0.0028	0.0064	0.0049					0.0047	0.0036
	Prf								Prf	Prf							
	0.0034								0.0108	0.0058					0.0067	0.0074	
	Prf								Prf	Prf							
	0.0089								0.0073	0.0050					0.0071	0.0039	
	Prf								Prf	Prf							
	0.0053								0.0059	0.0053					0.0055	0.0006	
	Prf								Prf	Prf							
	0.0034								0.0056	0.0044					0.0045	0.0022	
	Prf								Prf	Prf							
	0.0026	0.0042	0.0046					0.0038	0.0020								
	Prf	Prf	Prf														
	0.0036	0.0023	0.0027					0.0029	0.0013								
	Prf	Prf	Prf														
	0.0032	0.0032	0.0036					0.0033	0.0004								
	Prf	Prf	Prf														
	0.0053	0.0072	0.0066					0.0064	0.0019								
	Prf	Prf	Prf														

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No.	INSPECTION ITEM	Method	NM INSP FREQ.	MP INSP FREQ.	(-) LSL	(+) USL	T B H / rx ry Z	Nominal	RESULTS							X-Bar	R											
									File: 1	File: 2	File: 3																	
6	DIM LOC22= LOCATION OF POINT IT6_10	CMM	Weekly	Daily	0.0100	0.0100	T		0.0045	0.0050	0.0040							0.0045	0.0010									
	Prf								Prf	Prf																		
	0.0088								0.0062	0.0050																		
	DIM LOC23= LOCATION OF POINT IT6_11								Prf	Prf	Prf									0.0067	0.0038							
	DIM LOC24= LOCATION OF POINT IT6_12								0.0055	0.0015	0.0031											0.0034	0.0040					
									Prf	Prf	Prf																	
7	DIM PERP2= PERPENDICULARITY OF PLANE PLN_C,RFS TO WORKPLANE ZPLUS	CMM	Weekly	Daily		0.0100	M		0.0054	0.0047	0.0062									0.0054	0.0015							
	0.0067								0.0051	0.0058																0.0059	0.0016	
8	DIM LOC10= LOCATION OF POINT IT8A	CMM	Weekly	Daily	0.0200	0.0200	T	2.8750	0.0054	0.0066	0.0076									0.0065	0.0022							
	0.0065								0.0053	0.0062																	0.0060	0.0012
	DIM LOC11= LOCATION OF POINT IT8B																											
9	DIM LOC6= LOCATION OF POINT IT2	CMM	Weekly	Daily	0.0040	0.0030	T	3.2060	0.0011	0.0023	0.0011									0.0015	0.0012							
10	DIM LOC4= LOCATION OF POINT IT10A	CMM	Weekly	Daily	0.0040	0.0030	T	3.5000	0.0023	0.0026	0.0024									0.0024	0.0003							
	0.0016								0.0018	0.0027																	0.0020	0.0011
	DIM LOC5= LOCATION OF POINT IT10B																											
11	DIM PERP1= PERPENDICULARITY OF PLANE PLN_B,RFS TO WORKPLANE ZPLUS	CMM	Weekly	Daily		0.0050	M		0.0024	0.0032	0.0028									0.0028	0.0008							
12	DIM FLAT1= FLATNESS OF PLANE PLN_A	CMM	Weekly	Daily		0.0020	M		0.0014	0.0017	0.0014									0.0015	0.0003							
13	DIM LOC32= LOCATION OF POINT IT13_1	CMM	Weekly	Daily	0.0200	0.0200	H	0.2500	0.0084	0.0036	0.0028									0.0049	0.0056							
	DIM LOC33= LOCATION OF POINT IT13_2								0.0072	0.0068	0.0052															0.0064	0.0020	
	DIM LOC34= LOCATION OF POINT IT13_3								0.0086	0.0045	0.0037																0.0056	0.0049
	DIM LOC35= LOCATION OF POINT IT13_4								0.0073	0.0062	0.0048																0.0061	0.0025
	DIM LOC36= LOCATION OF POINT IT13_5								0.0088	0.0077	0.0072																0.0079	0.0016
	DIM LOC37= LOCATION OF POINT IT13_6								0.0079	0.0063	0.0069																0.0070	0.0016
	DIM LOC38= LOCATION OF POINT IT13_7								0.0104	0.0083	0.0062																0.0083	0.0042
	DIM LOC39= LOCATION OF POINT IT13_8								0.0097	0.0092	0.0071																0.0087	0.0026
14	DIM LOC28= TRUE POSITION OF CIRCLE	CMM	Weekly	Daily	0.0050	0.0050	DF	0.2810	0.0003	0.0009	0.0017									0.0010	0.0014							
	DIM LOC29= TRUE POSITION OF CIRCLE								0.0017	0.0013	0.0026															0.0019	0.0013	
15	DIM LOC28= TRUE POSITION OF CIRCLE DIA14_1	CMM	Weekly	Daily		0.0200	TP		0.0127	0.0137	0.0136									0.0133	0.0010							
	Bon								Bon	Bon																		
	DIM LOC29= TRUE POSITION OF CIRCLE DIA14_2								0.0114	0.0126	0.0141									0.0127	0.0027							
									Bon	Bon	Bon																	
16	DIM LOC30= TRUE POSITION OF CIRCLE	CMM	Weekly	Daily	0.0050	0.0050	DF	0.4060	0.0018	0.0002	0.0008									0.0009	0.0016							
	DIM LOC31= TRUE POSITION OF CIRCLE								0.0003	0.0004	0.0009															0.0005	0.0006	
17	DIM DIST1= 3D DISTANCE FROM POINT IT15A_1 TO PLANE PLN_2, NO_RADIUS	CMM	Weekly	Daily	0.0050	0.0050	M	0.1560	0.0003	-0.0018	-0.0016									-0.0010	0.0021							
	DIM DIST2= 3D DISTANCE FROM POINT IT15A_2 TO PLANE PLN_2, NO_RADIUS								0.0009	-0.0022	-0.0017																-0.0010	0.0031

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No.	INSPECTION ITEM	Method	NM INSP FREQ.	MP INSP FREQ.	(-) LSL	(+) USL	T B H / rx ry Z	Nominal	RESULTS							X-Bar	R								
									File: 1	File: 2	File: 3														
18	DIM LOC30= TRUE POSITION OF CIRCLE DIA16_1	CMM	Weekly	Daily		0.0200	TP		0.0173	0.0148	0.0137							0.0153	0.0036						
	Bon								Bon	Bon															
19	DIM LOC31= TRUE POSITION OF CIRCLE DIA16_2	CMM	Weekly	Daily	0.0050	0.0050	DF	0.1250	0.0164	0.0137	0.0149							0.0150	0.0027						
	Bon								Bon	Bon															
19	DIM LOC25= TRUE POSITION OF CIRCLE	CMM	Weekly	Daily	0.0050	0.0050	DF	0.1250	0.0001	0.0018	0.0019							0.0013	0.0018						
	DIM LOC26= TRUE POSITION OF CIRCLE								0.0012	0.0028	0.0025												0.0022	0.0016	
	DIM LOC27= TRUE POSITION OF CIRCLE								0.0008	0.0014	0.0019													0.0014	0.0011
20	DIM LOC25= TRUE POSITION OF CIRCLE DIA18_1	CMM	Weekly	Daily		0.0200	TP		0.0142	0.0126	0.0124							0.0131	0.0018						
	Bon								Bon	Bon															
	DIM LOC26= TRUE POSITION OF CIRCLE DIA18_2								0.0127	0.0118	0.0128													0.0124	0.0010
	DIM LOC27= TRUE POSITION OF CIRCLE DIA18_3								0.0214	0.0158	0.0158							0.0177	0.0056						
									Bon	Bon	Bon														