

# SUB-GROUP DATA COLLECTION SHEET / IN - PROCESS WORKSHEET / INSPECTION RECORD

CUSTOMER \_\_\_\_\_

DIM (NOMINAL): \_\_\_\_\_

PART# \_\_\_\_\_

LOWER TOLERANCE: \_\_\_\_\_

P.O.# \_\_\_\_\_ SO. \_\_\_\_\_ Lot# \_\_\_\_\_

UPPER TOLERANCE: \_\_\_\_\_

OPERATOR CAL # \_\_\_\_\_

INSPECTOR CAL # \_\_\_\_\_

FIRST ARTICLE PIECE INSPECTION		Tubing ID	DATE																			
			TIME																			
			A																			
			B																			
			C																			
			D																			
		E																				
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19

DATE																					
TIME																					
A																					
B																					
C																					
D																					
E																					
	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40

DATE \_\_\_\_\_ OP# \_\_\_\_\_ QTY \_\_\_\_\_ 1st Art \_\_\_\_\_ Marking \_\_\_\_\_

CHAR. SIZE \_\_\_\_\_ CHAR. COLOR \_\_\_\_\_ PRODUCT COLOR \_\_\_\_\_ FOIL TYPE \_\_\_\_\_ SUPPLIER \_\_\_\_\_ CERT/LOT# \_\_\_\_\_

PERMANENCY TEST Y( ) N( )      INSP       Q.A. FINAL APPROVAL

FOD FREE VERIFICATION OPER       INSP

**Work Instructions:** Not to be used for SPC collection, see separate work instruction.

- 1) Complete Customer Name, P/N., W.O., P.O., and S.O. according to current picking slip being processed.
- 2) Record exact (nominal) size upper and lower limits of dimensional tolerances to be audited.
- 3) Under interval (1) write down date/time of recording in date and time slots. Continue (2,3, & 4, etc.) each time parts are checked.
- 4) Select 5 consecutive samples and record each observed dimension under a,b,c,d & e section. Verify dimension are in tolerance. If out of tolerance, stop machine and report to supervisor or quality for instructions.
- 5) (Quantity) record total progressive quantity of parts that have been run up to this point
- 6) (initial) each recording: Newly trained employees must get qualified person (supr, insp, other to verify under your initials.

**Sampling Chart Guide**

C=0	
5,000-10,000	90 or more
10,001-35,000	130 or more
35,001-150,000	200 or more
150,001-500,000	320 or more
Repeat for quantities over 500,000	
If any non-conformances are found scrap <b>entire</b> lot.	