

**Siemers Inspection Service, inc.**  
*Dimensional Layouts - Statistical Process Control*

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A2LA ACCREDITED  
A2LA TESTING CERTIFICATE #1287.01

**J O B H E A D E R**

LOG NUMBER..... SAMPLE-CAPABILITY  
CUSTOMER..... ABC MANUFACTURING, INC.  
RESPONSIBILITY..... JOHN SMITH  
PART NAME..... COVER, MOLDED  
PART NUMBER..... 123-45-678A  
B/P NUMBER..... 123-45-678XXXX  
REV. LEVEL & DATE... -C- 12MAY06  
TOOL/MOLD NUMBER...  
FIXTURE NUMBER....  
MATERIAL.....  
UNIT OF MEASURE... MM  
GENERAL TOLERANCE 1 POS 2 POS 3 POS 4 POS 5 POS ANGLE  
0.25000 0.13000 0.00000 0.00000 0.00000 0.50  
JOB DATE..... 04/07/11  
CHECK DATE..... 04/07/11  
LAYOUT TYPE..... SPC  
# PIECES..... 30  
TOTAL FEATURES..... 3  
INSPECTED BY..... TAMMY AERTS

COMMENTS: CAPABILITY STUDY ON 30 PCS. OF CAVITY #1

DATE PART RECEIVED: 12/20/06  
CONDITION OF PARTS: GOOD  
THIS REPORT CONTAINS A JOB HEADER PAGE, A NOTEPAD PAGE, AND DETAIL REPORT.

CUSTOMER SIGN OFF: \_\_\_\_\_ DATE: \_\_\_\_\_  
CHECKED BY : \_\_\_\_\_ DATE: \_\_\_\_\_  
REVIEWED BY : \_\_\_\_\_ DATE: \_\_\_\_\_

SAMPLE-CAPABILITY/123-45-678A/COVER, MOLDED/In Process/ABC MANUFACTURING, INC./-C- 12MAY06/04/07/11

NOTE PAD

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**EQUIPMENT USED FOR THIS INSPECTION:**

<u>NAME</u>	<u>SERIAL #</u>	<u>ESTIMATED UNCERTAINTY*</u>
CMM #2	#409	118L+1283 $\mu$ "
SCOPE #2	#10314	104L+296 $\mu$ "

\*\*\* The measured parts were chosen at random from parts supplied by the customer \*\*\*

\*An estimation of the range of values within which the measurand quantity is likely (stated in millionths).  
L = Length in inches

The stated uncertainty represents an expanded uncertainty expressed at approximately the 95% confidence level using a coverage factor of k=2.

The temperature in the laboratory during this inspection was within our acceptable limits of 22 deg C +/- 2 deg C and the humidity was within our acceptable limits of 50% max.

Traceable to SI Units

**The inspection results contained herein pertain ONLY to the samples inspected.  
Siemers Inspection Service, Inc. makes no statements  
or judgements concerning identical or similar parts.**

**All methods used for this inspection are in accordance with  
ASME Y14.5M-1994, unless stated otherwise.**

**THIS DOCUMENT MAY NOT BE REPRODUCED EXCEPT IN ITS ENTIRETY.**

SAMPLE-CAPABILITY/123-45-678A/COVER, MOLDED/In Process/ABC MANUFACTURING, INC./-C- 12MAY06/04/07/11

COLUMN DETAIL - GROUP SIZE: 1 - STD. DEV BASED ON: Population (N)

BAL/Desc/Loc	3	19	27
Nominal	2.45	45.70	3.75
Geo. Name			
Tolerance	+/-0.050	+/-0.130	+/-0.130
Comment			
Device	Microscope #2	CMM #2	Microscope #2
0001	2.431	45.627	3.783
0002	2.454	45.608	3.782
0003	2.447	45.605	3.785
0004	2.445	45.600	3.781
0005	2.463	45.611	3.782
0006	2.449	45.627	3.779
0007	2.453	45.631	3.778
0008	2.461	45.615	3.780
0009	2.448	45.606	3.787
0010	2.467	45.627	3.775
0011	2.448	45.616	3.781
0012	2.435	45.627	3.785
0013	2.442	45.621	3.772
0014	2.457	45.633	3.790
0015	2.465	45.641	3.775
0016	2.447	45.638	3.775
0017	2.456	45.627	3.782
0018	2.456	45.615	3.786
0019	2.438	45.609	3.788
0020	2.439	45.613	3.782
0021	2.451	45.622	3.789
0022	2.455	45.613	3.793
0023	2.443	45.627	3.796
0024	2.438	45.633	3.785
0025	2.437	45.624	3.776
0026	2.456	45.617	3.752
0027	2.446	45.622	3.779
0028	2.448	45.623	3.773
0029	2.465	45.631	3.787
0030	2.431	45.644	3.777
Minimum	2.431	45.600	3.752
Maximum	2.467	45.644	3.796
Range	0.036	0.044	0.044
Mean	2.449	45.622	3.781
Std. Dev.	0.010033	0.010979	0.008026
Cr	0.602	0.253	0.185
Cp	1.661	3.947	5.399
Cpk Sigma +/- 3	1.629	1.572	4.105
Std. Dev. (Range)	0.010033	0.010979	0.008026
XBarBar	2.449	45.622	3.781
RBar	0.000	0.000	0.000
Pp	1.661	3.947	5.399
Ppk	1.629	1.572	4.105