

ISO 26303:2022-03 (E)

Machine tools - Short-term capability evaluation of machining processes on metal-cutting machine tools

Contents	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Symbols	4
4.1 Uppercase letters	4
4.2 Lowercase letters	5
4.3 Greek letters	5
5 Preliminary remarks	6
6 Procedure for short-term capability evaluation	7
6.1 General	7
6.2 Agreements	8
6.3 Warm-up procedure	10
6.4 Adjustment	10
6.5 Production	11
6.6 Measurement	11
6.7 Computation and analysis	12
6.7.1 General	12
6.7.2 Trend correction	14
6.7.3 Outlier management	15
6.7.4 Stability of the process	15
6.7.5 Calculation of indices	16
7 Factors influencing short-term capability evaluation	17
7.1 General	17
7.2 Thermal influences	18
7.3 Influences due to measuring uncertainty	19
7.4 Influences arising from statistical analysis	19
7.4.1 Confidence level and sample size	19
7.4.2 Type of distribution	19
Annex A (informative) Additional information related to statistical evaluations	21
Annex B (informative) Agreement forms	29
Annex C (informative) Evaluation forms	33
Annex D (informative) Examples of capability agreements and analysis	37
Bibliography	45