

<b>X</b>		IPS Inspection System Test Ring			<b>X</b>	
<b>X</b>		Optisense Lense		<b>X</b>		
		<b>3 - Machine Component</b>				
Optisense & IPS Inspection System Cleaning	<b>4 - Machine Parameters</b>		<b>2 - Abnormal Phenomenon</b>	Dirty lense	Dirty Test Ring	
100% clear of debris		<b>1 - Defect Mode</b>				
<b>X</b>		Optisens & IPS Inspection System issues or errors		<b>X</b>	<b>X</b>	

**Q-M Matrix : JENOPTIK BORE GAGE OP 68**

Machine Group	OPTISENSE	IPS INSPECTION SYSTEM
Machine components	LENSE	TEST RING
Parameters	100% Free of Debris	100% Free of Debris
Measuring instruments	JENOPTIK Cleaning Kit - 10047070	JENOPTIK Cleaning Kit - 10047070
Specifications	P21	P21
Frequency	14,400 Cycles	14,400 Cycles
Responsibility	MTTM	MTTM
Q Points		
Operating Instructions	P21	P21

Level of Analysis 1 = Original 2 = After Improvements

		1		2	
		1	2	1	2
<b>Is the condition clear and visible?</b>	Fixed specification range is defined	1		1	
	An easy to check method exists				
	Visual - Easy to see at any time				
<b>Is it easy to set?</b>	Difficult to set, measure by hands				
	Easy to adjust, fixed position	1		1	
	Preset, automatic set up for each product type				
<b>Is the value varying outside the specification range ?</b>	During normal production in less than 1 shift				
	Modified at each set up				
	Exceptionally	1		1	
<b>Is the variation visible ?</b>	Low probability to see it	1		1	
	The Periodical inspection system has more than 90% probability to see the deviation occurred				
	A continuous monitoring ensuring immediate alert				
<b>Is it easy to restore?</b>	Difficult, almost an art, requires technical skills and downtime				
	Easy once a person is qualified	1		1	
	Automatic adjustment (closed loop)				
<b>TOTAL</b>		5	0	5	0
		20%	0%	20%	0%
Before Total Score					
After Total Score					
Total Points	600				

**5QFZD**