NISSAN
MOTOR CORPORATION

Process Capability Study Results (PCSR)

Key Point(s):

- The Process Capability Study Results is a document that records the result of the detailed capability study for each feature identified on the the Planning.

  - Phase 3 for off-tool parts if applicable
  - Phase 4 for off-process parts
  - Phase 5 Mass Production (Actual mass-production capability study result. On demand.)

Minimum Content Requirement(s):

The Process Capability Study Results shall include the followings (as a minimum):

- Identification of all characteristics to be studied
  (These shall include items from the Special Characteristics and Key Features diagram as a minimum.)
- Measurement data analysis method to be used (e.g. Cpk)
- Target value of process capability for each identified characteristics
- Specification (nominal and tolerance) of each identified characteristics
- Sample size for each identified characteristics
- Device/Tool for measuring/inspect characteristics of a product (e.g. Coordinate Measuring Machine (CMM))
- Measured raw data and result of analysis (i.e. Raw data and Cp, Cpk calculation)
- Recovery plan including containment actions and permanent countermeasures for those features that do not meet the targets.

Output Document Description:

- Supplier own document or NISSAN designated.

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