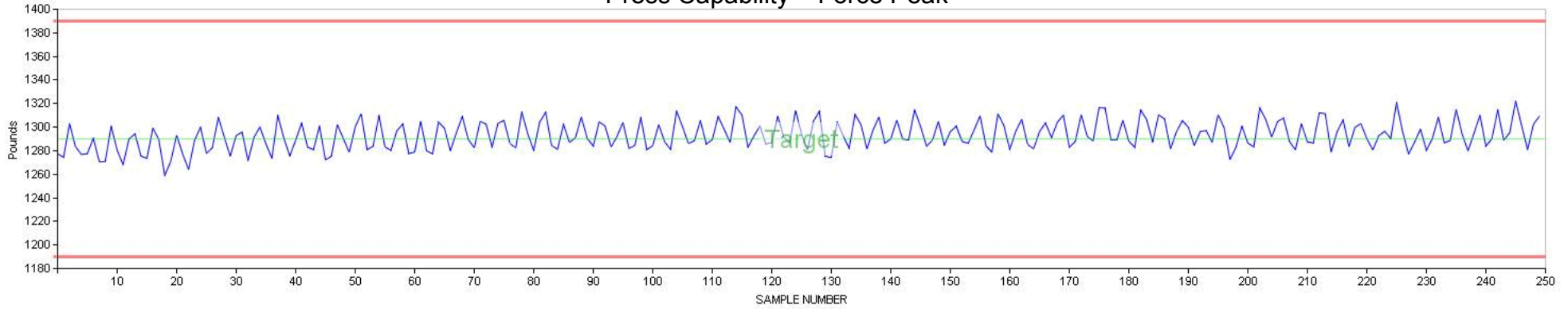


COMPANY
 Delphi
 Juarez Engineering

MACHINE
 TYPE: Delphi
 ID: N/A
 SERIAL NUMBER: N/A

CRIMP PRESS
 TYPE: Delphi 2 ton press
 ID: 31553
 SERIAL NUMBER: MPO177

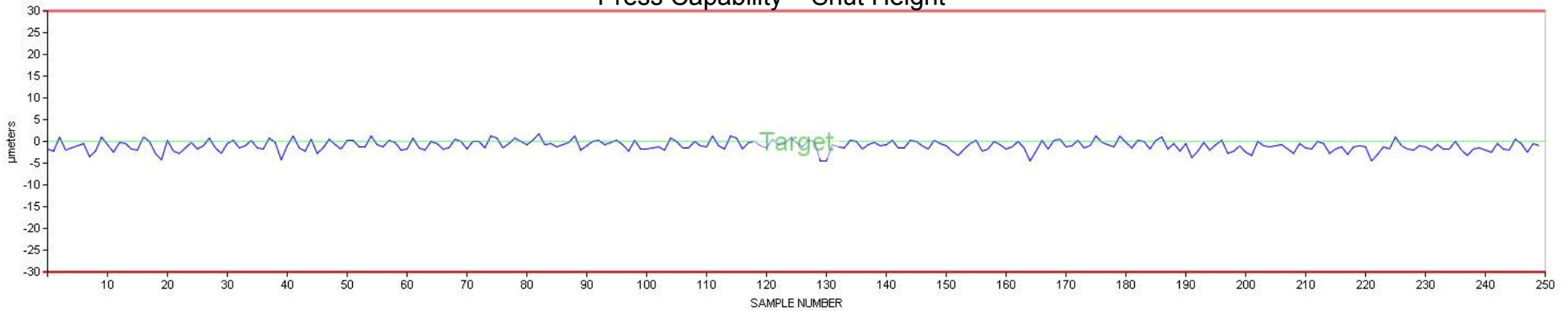
Press Capability – Force Peak



Target		1290 LB
Upper Limit	7.8%	1390 LB
Lower Limit	7.8%	1190 LB

Mean	1293.08 LB
Standard deviation	12.37
Cp	2.69
Cpk	2.61

Press Capability – Shut Height



Target	0.00 μm
Upper Limit	30.00 μm
Lower Limit	30.00 μm

Mean	-0.99 μm
Standard deviation	1.20
Cp	8.31
Cpk	8.04



CALIBRATION SYSTEM:
 MODEL: CAL5000
 SERIAL NUMBER: Unknown
 CALIBRATION DATE: Unknown

CALIBRATION COMPANY
 OES, Inc.
 4056 Blakie Road
 London, ON
 N6L 1P7

DATE: July 29, 2011
 SIGNATURE: _____
 Mike Nagle

COMPANY Delphi Juarez Engineering	MACHINE TYPE: Delphi ID: N/A SERIAL NUMBER: N/A	CRIMP PRESS TYPE: Delphi 2 ton press ID: 31553 SERIAL NUMBER: MPO177
-----------------------------------------	----------------------------------------------------------	-------------------------------------------------------------------------------

Machine Capability Data - CAL5000

Press Capability – Force (LB)

1 - 15	1277	1274	1303	1283	1277	1278	1291	1271	1271	1301	1280	1268	1290	1294	1276
16 - 30	1273	1299	1290	1259	1271	1293	1277	1264	1289	1300	1278	1282	1308	1292	1275
31 - 45	1293	1296	1272	1291	1300	1286	1274	1310	1291	1276	1289	1303	1283	1281	1301
46 - 60	1272	1275	1302	1290	1279	1300	1311	1281	1284	1310	1283	1280	1297	1303	1278
61 - 75	1279	1305	1280	1277	1304	1299	1280	1295	1309	1290	1282	1305	1302	1283	1303
76 - 90	1306	1286	1282	1313	1294	1280	1304	1313	1284	1281	1302	1287	1291	1309	1290
91 - 105	1284	1304	1301	1283	1292	1304	1282	1284	1308	1281	1284	1302	1288	1281	1314
106 - 120	1300	1286	1289	1305	1286	1289	1309	1298	1287	1317	1310	1283	1292	1301	1286
121 - 135	1287	1309	1292	1286	1314	1294	1281	1305	1313	1275	1274	1305	1292	1282	1311
136 - 150	1302	1281	1297	1309	1287	1290	1306	1290	1289	1315	1301	1284	1289	1305	1285
151 - 165	1296	1301	1288	1286	1298	1310	1284	1279	1311	1301	1281	1297	1307	1285	1282
166 - 180	1296	1303	1291	1304	1310	1283	1288	1311	1292	1288	1316	1316	1289	1289	1306
181 - 195	1288	1283	1315	1306	1288	1310	1307	1281	1296	1305	1300	1284	1296	1297	1287
196 - 210	1311	1300	1272	1283	1301	1287	1283	1316	1306	1292	1305	1308	1288	1281	1303
211 - 225	1288	1287	1312	1311	1279	1296	1306	1283	1300	1303	1290	1281	1293	1297	1290
226 - 240	1321	1296	1277	1287	1298	1280	1290	1308	1287	1289	1315	1294	1280	1295	1310
241 - 255	1284	1290	1314	1289	1295	1322	1301	1281	1302	1309					

Press Capability – Shut Height (µm)

1 - 15	-1.75	-2.25	1.00	-2.00	-1.50	-1.00	-0.50	-3.50	-2.25	1.00	-0.75	-2.50	-0.25	-0.50	-1.75
16 - 30	-2.00	1.00	0.00	-2.75	-4.25	0.25	-2.25	-2.75	-1.50	-0.25	-1.75	-1.00	0.75	-1.50	-2.75
31 - 45	-0.50	0.25	-1.50	-1.00	0.25	-1.50	-1.75	0.75	-0.25	-4.25	-1.00	1.25	-1.50	-2.25	0.50
46 - 60	-2.75	-1.50	0.50	-0.75	-1.75	0.25	0.25	-1.25	-1.25	1.25	-0.75	-1.25	0.25	-0.25	-2.00
61 - 75	-1.75	0.75	-1.50	-2.00	0.00	-0.50	-1.75	-1.50	0.50	0.00	-1.75	0.00	0.00	-1.50	1.25
76 - 90	0.75	-1.50	-0.50	0.75	0.00	-0.75	0.25	1.75	-0.75	-0.50	-1.25	-0.75	-0.25	1.25	-2.00
91 - 105	-1.00	0.00	0.25	-0.75	-0.25	0.25	-0.75	-2.25	0.25	-1.75	-1.75	-1.50	-1.25	-2.00	0.75
106 - 120	0.00	-1.50	-1.50	0.00	-1.00	-1.25	1.25	-1.00	-1.75	1.25	0.75	-1.75	-0.25	0.00	-1.00
121 - 135	-1.50	0.50	-0.75	-0.50	0.75	-0.25	-1.25	0.25	0.00	-4.50	-4.50	-0.75	-1.25	-1.50	0.25
136 - 150	0.00	-1.75	-0.75	-0.25	-1.00	-0.75	0.25	-1.50	-1.50	0.25	0.00	-1.00	-1.75	0.25	-0.50
151 - 165	-1.00	-2.25	-3.25	-1.75	-0.50	0.25	-2.25	-1.75	0.00	-0.75	-1.75	-1.25	0.00	-1.50	-4.50
166 - 180	-2.25	0.25	-1.75	0.25	0.50	-1.25	-1.00	0.25	-1.50	-1.00	1.25	-0.25	-0.75	-1.25	1.25
181 - 195	-0.25	-1.50	0.25	0.00	-1.75	0.25	1.00	-1.75	-0.50	-2.25	-0.50	-3.75	-2.25	-0.25	-2.00
196 - 210	-0.75	0.25	-2.75	-2.25	-1.00	-2.50	-3.25	0.00	-1.00	-1.25	-1.00	-0.75	-1.75	-2.75	-0.50
211 - 225	-1.50	-1.75	0.00	-0.50	-2.75	-1.75	-1.25	-3.00	-1.25	-1.00	-1.25	-4.50	-3.00	-1.25	-1.75
226 - 240	1.00	-1.00	-1.75	-2.00	-1.00	-1.25	-2.00	-0.75	-1.75	-1.75	0.00	-2.00	-3.25	-1.75	-1.50
241 - 255	-2.00	-2.50	-0.50	-1.75	-2.00	0.50	-0.50	-2.50	-0.50	-1.00					



www.OES technologies.com

CALIBRATION SYSTEM:
MODEL: CAL5000
SERIAL NUMBER: Unknown
CALIBRATION DATE: Unknown

CALIBRATION COMPANY
OES, Inc.
4056 Blakie Road
London, ON
N6L 1P7

DATE: July 29, 2011
SIGNATURE: _____
Mike Nagle

COMPANY

Delphi
Juarez Engineering

MACHINE

TYPE: Delphi

ID: N/A

SERIAL NUMBER: N/A

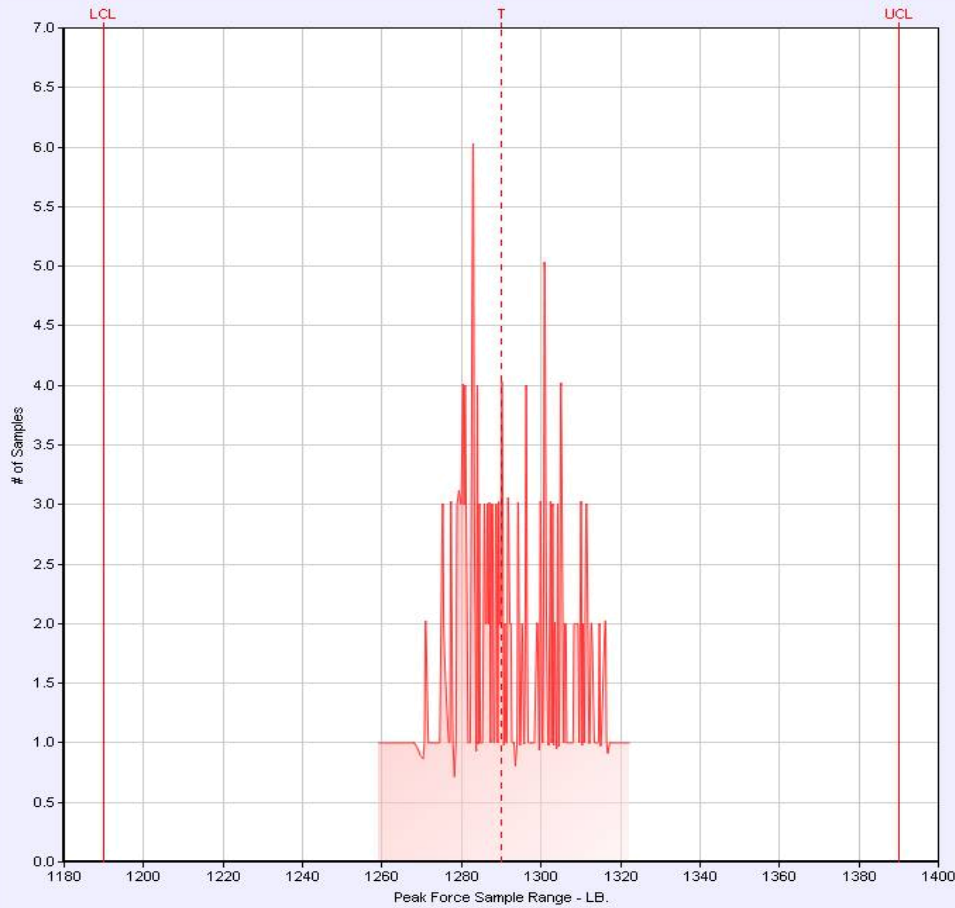
CRIMP PRESS

TYPE: Delphi 2 ton press

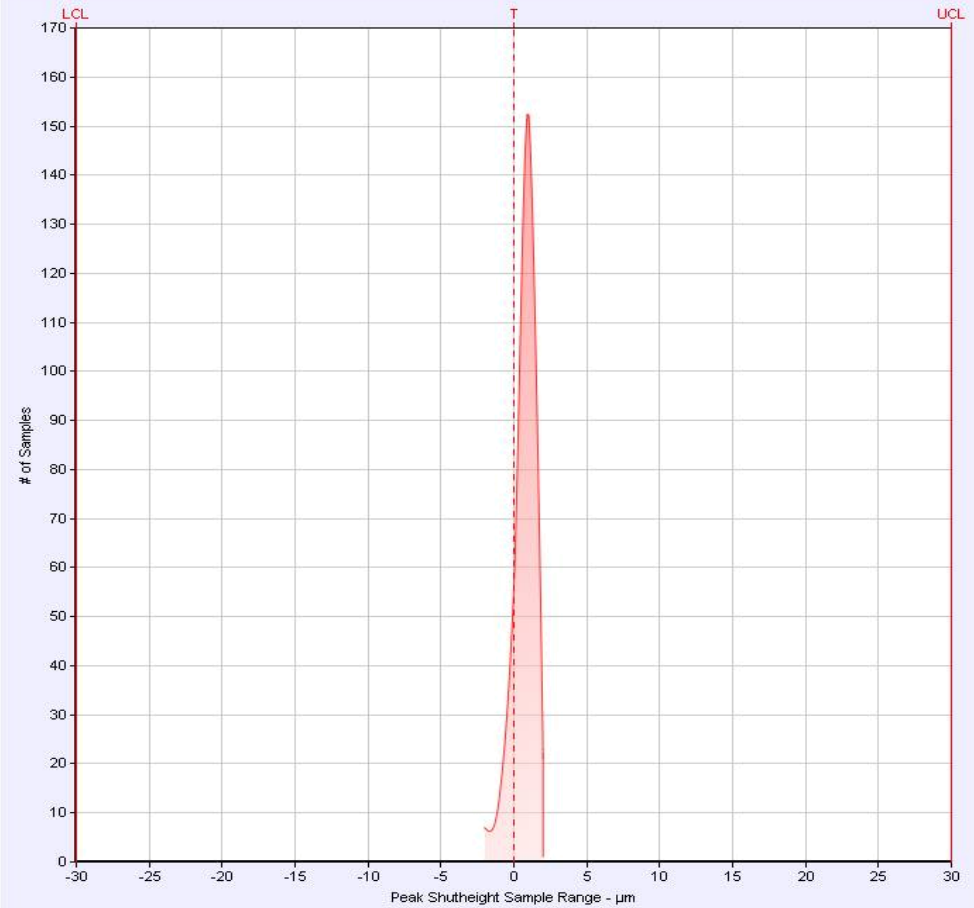
ID: 31553

SERIAL NUMBER: MPO177

Histogram - Peak Force



Histogram - Peak Shutheight



Target	1290 LB	Mean	1293.08 LB
Upper Limit	1390 LB	Standard deviation	12.37
Lower Limit	1190 LB	Cp	2.69
		Cpk	2.61

Target	0.00 μm	Mean	-0.99 μm
Upper Limit	30.00 μm	Standard deviation	1.20
Lower Limit	30.00 μm	Cp	8.31
		Cpk	8.04



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