

PE03-044
FORD
5/13/2005
APPENDIX I
BOOK 24 OF 28
PART 3 OF 4

From: Miers, Jerry [jmiers@wmco.com]
Sent: Thursday, August 21, 2003 10:39 AM
To: Miers, Jerry; West, Gregory (G.S.)
Cc: Liposky, Lawrence (L.J.); Gehl, Laxman (L.D.); Pyle, Ken
Subject: RE: Updated Test Data Entry forms for Offset Load, KLT


KLT_DV_Test_Data
updated forma...

-----Original Message-----

From: Miers, Jerry
Sent: Wednesday, August 20, 2003 1:55 PM
To: 'West, Gregory (G.S.)'
Cc: Liposky, Lawrence (L.J.); Gehl, Laxman (L.D.); Pyle, Ken
Subject: RE: Updated Test Data Entry forms for Offset Load, KLT

Greg attached is the KLT data in your format. The over load data will take a bit longer to put together.

-----Original Message-----

From: West, Gregory (G.S.) [mailto:gwest2@ford.com]
Sent: Tuesday, August 19, 2003 3:40 PM
To: Jerry Miers (E-mail); Ken Pyle (E-mail)
Cc: Liposky, Lawrence (L.J.); West, Gregory (G.S.); Gehl, Laxman (L.D.)
Subject: FW: Updated Test Data Entry forms for Offset Load, KLT

Jerry, please enter the KLT data into the XL file I've included. This is our standard now for suppliers presenting data in a common format to us. I also included a format for offset load testing, please fill this in with the original 03.25 DV data. Thanks.

> -----Original Message-----

> **From:** Gaw, Ron (R.M.)
> **Sent:** Tuesday, July 22, 2003 3:14 PM
> **To:** Bri, Guam (G.T.); Sheth, Rakesh (B.); West, Gregory (G.S.); Weber, Michael (M.J.); Dressing, Thomas (T.G.); Bass, Raynard (R.); Liposky, Lawrence (L.J.); Green, Don (D.L.); Abbasi, Basel (B.A.); Stawara, Mike (M.); Jackson, Leslie (L.E.); McCarthy, Fran (F.)
> **Subject:** Updated Test Data Entry forms for Offset Load, KLT

> Here are the updated documents your suppliers should be using to enter and present KLT and Offset Load data:

> <<KLT_DV_Test_Data_updated_format.xls>>
> <<Offset_Load_DV_Test_Data_updated_format.xls>>

> Ron Gaw
> PTSE D&R
> Electronic Throttle Controls Design & Release
> Ph. #: 313 390-5756 Fax. #: 313 248-2558
> Pager # 313 795-3909

PEB3-014 24867

PP8113A						
	Part 10	0	0.5M	1.0M	1.5M	2.0M
1	441	81.04	80.21	80.22	79.79	79.55
2	444	80.38	80.01			
3	445	80.48	80.08			
4	448	78.85	79.85			
5	447	81.50	81.50			
6	448	78.28	79.41			
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PE83-914 24808

PP82 lbs						
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441	30.82	30.65			
2	444	30.25	29.86			
3	445	28.89	29.77			
4	446	30.58	30.98			
5	447	28.29	29.29			
6	448	30.99	30.79			
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PERG-044 24890

		PPBS id:				
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441	18.56	19.69			
2	444	19.22	18.73			
3	445	18.92	18.16			
4	446	19.55	19.70			
5	447	18.28	18.26			
6	443	20.23	20.00			
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PER3-644 24618

Angular Travel						
Part ID	0	0.5M	1.0M	1.5M	2.0M	
1	441	18.25	18.4	18.24	18.05	18.02
2	444	18.14	18.14	18.09	18.02	17.99
3	445	18.14	18.04	18.01	18.01	18.14
4	446	18.29	18.08	18.29	18.08	18.09
5	447	18.3	18.13	18.13	18.13	18.29
6	449	18.27	18.2	18.12	18.1	18.17
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PERC-014 24811

.WOP-PP81						
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441	12.6		13		
2	444	12.83		12.84		
3	445	13.01		13.08		
4	448	12.83		12.78		
5	447	12.82		12.86		
6	448	12.74		12.87		
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PERC-QM 24612



WOP-FF82						
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441	82.29	82.29			
2	444	82.29	81.67			
3	445	81.84	81.19			
4	448	82.3	82.3			
5	447	81.8	81.48			
6	448	82.17	82.17			
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PERD-044 24813

WOP-PPS3						
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441	71.87	71.83			
2	444	71.81	71.8			
3	443	71.24	70.82			
4	445	71.35	71.81			
5	447	71.47	71.14			
6	448	71.48	71.37			
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FORM-044 24814

WOP Sweeps - PPS						
	Part ID	σ	0.5M	1.0M	1.5M	2.0M
1	441	-88.14	-87.21	-87.43	-88.83	-88.81
2	444	-87.56	-87.97	-87.87	-87.83	-87.8
3	445	-87.47	-87.01	-87.29	-88.93	-87.21
4	448	-87.02	-88.67	-88.98	-88.83	-88.73
5	447	-88.88	-88.68	-88.51	-88.41	-88.83
6	448	-88.82	-88.44	-88.15	-88.3	-88.38
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PERC-044 24815

-WCP Sweeps - PPS2						
Part ID	0	0.5M	1.0M	1.5M	2.0M	
1	441	51.63	51.52	51.54	51.38	51.62
2	444	51.88	51.81	51.74	51.73	51.8
3	445	51.85	51.37	51.44	51.88	51.78
4	446	51.74	51.81	51.7	51.78	51.73
5	447	52.81	52.1	52.08	52.29	52.41
6	448	51.18	51.41	51.08	51.34	51.32
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PERC-044 24016

WDF Sweeps - PFES							
	Part ID	0	0.5M	1.0M	1.5M	2.0M	
1	441	52.01	52	51.8	51.68	51.61	
2	444	52.29	52.57	52.58	52.36	52.37	
3	445	52.32	51.48	51.47	51.53	51.99	
4	448	51.8	51.81	51.89	51.82	51.82	
5	447	53.21	52.88	52.78	53.17	53.34	
6	449	51.25	51.81	51.29	51.85	51.82	
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PER-044 2817

Calculated WCP to Idle slopes - PPS1						
Part-Id	0	0.8M	1.0M	1.5M	2.0M	
1	441					
2	444					
3	445					
4	446					
5	447					
6	448					
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PERC-044 24918

Calculated WOP to idle slopes - PP82						
2	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	448					
4	448					
5	447					
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PER3-014 24818

Calculated WOP to 10% slopes - PP83					
Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441				
2	444				
3	445				
4	448				
5	447				
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PP83-044 24/28

Slope Corr 1-2						
	PartID	0	0.5M	1.0M	1.5M	2.0M
1	441	1.03	0.88			
2	444	1.44	1.58			
3	445	0.89	0.70			
4	446	1.18	1.48			
5	447	0.79	0.69			
6	448	0.88	1.5			
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FORM-014 24621

Slope Corr 2-3

	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441	1.06	1.06			
2	444	1.25	1.52			
3	445	0.68	0.43			
4	446	1.38	1.56			
5	447	1.18	1.25			
6	448	1.72	1.66			
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FE03-014 24822

Slope Corr 1-3				
	Part ID	0	0.5M	1.0M
1	441	0.53	1.46	
2	444	1.97	1.48	
3	443	1.49	0.89	
4	446	1.28	1.86	
5	447	1.48	1.08	
6	448	1.16	1.57	
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PERC-044 24823

Index-PPS1/PPS2						
	ParID	0	0.5M	1.0M	1.5M	2.0M
1	441	0.630	1.480			
2	444	0.920	0.108			
3	446	0.280	0.730			
4	448	1.780	2.670			
5	447	1.180	1.150			
6	448	2.780	2.430			
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PER3-844 20024

Index-PP81-PP88					
Part ID	0	0.8M	1.0M	1.5M	2.0M
1	441	0.890	1.490		
2	444	0.890	0.030		
3	445	0.490	1.120		
4	446	1.750	2.990		
6	447	1.190	1.290		
8	448	3.020	2.700		
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PERI-044 24825

	Pen ID	C	0.5M	1.0M	1.5M	2.0M
1	441	0.06	0.02			
2	444	0.09	0.18			
3	445	0.22	0.30			
4	446	0.01	0.27			
5	447	0.09	0.18			
6	448	0.23	0.27			
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PPSS-041 24825

Not Applicable

Linearity-PP81						
	Part	0	0.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	446					
4	448					
5	447					
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PERC-044 24827

Not Applicable

		Unacety-PPG2				
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	445					
4	446					
5	447					
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PE33-044 24028

Not Applicable

		Linearity: P93				
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	445					
4	446					
5	447					
6	448					
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FD3-846 24029

Not Applicable

	Idle Break-Away Force					
	Part ID	0	0.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	445					
4	448					
6	447					
6	448					
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PROC-014 24630

Not Applicable

WOP Form						
	Part ID	6	8.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	445					
4	446					
5	447					
6	448					
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PERB-014 214351

Not Applicable

Hysteresis Column 1						
	Part ID	0	0.5M	1.0M	2.0M	3.0M
1	441					
2	444					
3	445					
4	448					
5	447					
6	446					
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FE03-044 24032

Not Applicable

Physical Column 2						
Part ID	0	0.5M	1.0M	1.5M	2.0M	
1	441					
2	442					
3	443					
4	444					
5	445					
6	446					
7	447					
8	448					
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Not Applicable

PERG-044 24033

Hydrocreek Column 3						
	PartID	0	0.5M	1.0M	1.5M	2.0M
1	441					
2	444					
3	445					
4	449					
5	447					
6	445					
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PERS-044 24834

P-201 (10 - 2011)				
Page	0 - 0.50	0 - 1.00	0 - 1.50	0 - 2.00
1	441	0.040	0.188	
2	444	0.400	0.400	
3	440	0.200	0.500	
4	440	0.170	0.500	
5	447	0.500	0.500	
6	444	0.300	0.300	
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Average	0.300	0.300	0.300	0.300
Std Dev	0.100	0.140	0.140	0.131
Ave + 3 Std	0.701	0.750	0.780	0.749

PERC-044 20135

PPG 100-411-010					
	Part ID	0-1.00	0-1.00	0-1.20	0-2
1	441	0.070			
2	444	0.080			
3	445	0.020			
4	446	0.180			
5	447	0.000			
6	448	0.170			
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Average		0.167	0.343	0.325	0.334
Std Dev		0.170	0.188	0.115	0.185
Ave + 3 Std		0.687	0.742	0.663	0.743

PERC-014 24037

Average (mg) - dry basis				
Part ID	0-0.50	0-1.00	0-1.50	0-2.00
1	441	0.150	0.150	
2	444	0.000	0.000	
3	446	0.100	0.100	
4	449	0.200	0.200	
5	447	0.100	0.100	
6	448	0.000	0.100	
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Average		0.122	0.130	0.187
Std Dev		0.082	0.086	0.088
Ave + 3 Std		0.366	0.321	0.481

PERC-044 24838

WSP - PPSI CRIT DATA					
Part ID	0-0.25	0-1.25	0-1.25	0-2	0-2 v
1	441		0.10	0.20	
2	442		0.00	0.00	
3	443		0.10	0.10	
4	444		0.00	0.10	
5	447		0.10	0.10	
6	448		0.20	0.20	
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Average		0.00	0.14	0.10	0.10
Std Dev		0.07	0.00	0.00	0.00
Ave + 3 Std		0.20	0.00	0.00	0.00

WSP - PPSI CRIT DATA					
Part ID	0-0.25	0-1.25	0-1.25	0-2	0-2 v
1	441		0.00	0.10	
2	442		0.00	0.00	
3	443		0.00	0.00	
4	444		0.00	0.10	
5	447		0.10	0.10	
6	448		0.00	0.00	
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FEGS-044 24039

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Average		0.302	0.420	0.438	0.488
Std Dev		0.222	0.311	0.289	0.305
Ave + 3 Std		1.000	1.352	1.315	1.232

Cell ID	VOC - WPSB and Total			
	0-0.5M	0-1.5M	0-1.5M	0-2 v
1	441	0.000		0.100
2	441	0.300		0.200
3	441	0.200		0.300
4	441	0.200		0.400
5	441	0.300		0.500
6	441	0.100		0.200
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PERC-014 24JAN

19					
20					
21					
Average		0.378	0.362	0.408	0.432
Std Dev		0.160	0.248	0.240	0.287
Ave + 3 Std		0.647	1.134	1.188	1.119

WCP Sample - PPGI drill holes					
	Part ID	0 - 0.50	0 - 1.25	0 - 1.50	0 - 2.00
1	441	0.00	0.00	0.00	0.00
2	442	0.00	0.00	0.00	0.00
3	443	0.00	0.00	0.00	0.00
4	444	0.00	0.00	0.00	0.00
5	445	0.00	0.00	0.00	0.00
6	446	0.00	0.00	0.00	0.00
7	447	0.00	0.00	0.00	0.00
8	448	0.00	0.00	0.00	0.00
9					
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30					
Average		0.368	0.448	0.368	0.577
Std Dev		0.220	0.232	0.376	0.388
Ave + 3 Std		1.258	1.220	1.603	1.672

WCP Sample - PPGI drill holes

PERO-044 24041

	Part ID	0-0.25	0-1.0M	0-1.5M	0-2.0M
1	441	0.010	0.000		
2	444	0.170	0.200		
3	440	0.000	0.000		
4	446	0.130	0.150		
5	447	0.510	0.500		
6	448	0.530	0.300		
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29					
30					
Average		0.272	0.310	0.340	0.170
Std Dev		0.208	0.202	0.171	0.104
Ave + 3 Std		0.948	0.934	0.861	0.602

WCP Baseco - PPSS 2-48 100%					
	Part ID	0-0.25	0-1.0M	0-1.5M	0-2.0M
1	441	0.010	0.010	0.000	
2	444	0.200	0.200	0.000	
3	440	0.000	0.000	0.000	
4	446	0.110	0.100	0.000	
5	447	0.480	0.480	0.000	
6	448	0.300	0.300	0.000	
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PWS-848 24942

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30				
Average	0.928	0.928	0.436	0.436
Std Dev	0.028	0.023	0.252	0.252
Apr = 2.55d	1.810	1.178	1.158	1.158

Calculated WOP to 1000 ft depth - PPAH drill logs				
Part ID	0-1.00	0-1.00	0-1.00	0-2.00
1	441	0.000		
2	444	0.000		
3	446	0.000		
4	448	0.000		
5	451	0.000		
6	454	0.000		
7	456	0.000		
8	458	0.000		
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PE03-044 24843

30					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Avs + 3 Std		0.000	0.000	0.000	0.000

Calculating WOP to the slopes - PPS 2nd table					
	Part ID	0 - 0.000	0 - 1.000	0 - 1.000	0 - 2.000
1	441	0.000	0.000	0.000	0.000
2	442	0.000	0.000	0.000	0.000
3	443	0.000	0.000	0.000	0.000
4	444	0.000	0.000	0.000	0.000
5	445	0.000	0.000	0.000	0.000
6	446	0.000	0.000	0.000	0.000
7					
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27					
28					
29					
30					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Avs + 3 Std		0.000	0.000	0.000	0.000

Calculating WOP to the slopes - PPS 2nd table					
	Part ID	0 - 0.000	0 - 1.000	0 - 1.000	0 - 2.000
1	441	0.000	0.000	0.000	0.000
2	442	0.000	0.000	0.000	0.000

PENG-014 24844

2	445	0.000		0.000	0.000
3	446	0.000		0.000	0.000
4	447	0.000		0.000	0.000
5	448	0.000		0.000	0.000
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30					
Average		0.000	0.000	0.000	0.000
Rtd Dev		0.000	0.000	0.000	0.000
Ave + 3 Std		0.000	0.000	0.000	0.000

Slope Corr 1-3 diff tests					
Part ID	0-0.100	0-1.00	0-1.00	0-3.00	0-3.00
1	443	0.000	0.000	0.000	0.000
2	444	0.000	0.000	0.000	0.000
3	445	0.000	0.000	0.000	0.000
4	446	0.000	0.000	0.000	0.000
5	447	0.000	0.000	0.000	0.000
6	448	0.000	0.000	0.000	0.000
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PERC-044 20045

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Average		0.218	0.350	0.363	0.427
Std Dev		0.108	0.131	0.160	0.087
Ave + 3 Std		0.527	0.788	0.864	0.687

Stage Corr 2-3 gph tank					
	Part ID	0 - 0.500	0 - 1.000	0 - 1.500	0 - 2
1	441	0.030		0.100	
2	444	0.270		0.270	
3	448	0.190		0.350	
4	448	0.200		0.350	
5	447	0.040		0.400	
6	448	0.140		0.350	
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30					
Average		0.138	0.218	0.275	0.284
Std Dev		0.008	0.006	0.143	0.161

PER3-014 24846

Area 4 S 812

0.412

0.450

0.748

0.819

PERG-041 240477

Signal Corr 1-3 GHz Table				
Part ID	0 - 0.5M	0 - 1.0M	0 - 1.5M	0 - 2.0M
1	441		0.000	
2	444		1.000	
3	445		0.000	
4	448		0.070	
5	447		0.450	
6	448		0.480	
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PERS-044 24048

Average_AG	0.488	0.729	1.016	1.286
Std Dev	0.373	0.367	0.609	0.492
Ave + 3 Std	1.523	1.823	2.957	2.923

Average_AP	0.900100007	1.000000000	1.25	1.25
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Index-PP81					
	PrTID	0 - 0.25	0 - 1.00	0 - 1.25	0 - 2.00
1	441	0.850	0.850	1.370	
2	444	0.850	0.850	0.850	
3	449	0.450	0.470	0.500	
4	448	0.910	0.910	0.890	
5	447	0.510	0.500	0.120	
6	449	0.950	0.770	0.770	
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FERS-011 21119

Average
Std Dev
Avg + 3 Std

0.870	0.844	0.784	0.777
0.388	0.334	0.418	0.481
1.830	1.848	2.004	2.040

Index P-85				
Part ID	0 - 0.500	0 - 1.000	0 - 1.500	0 - 2.000
1	441	0.890		
2	444	0.880		
3	445	0.850		
4	446	0.780		
5	447	0.800		
6	448	0.880		
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30				
Average	0.870	0.844	0.777	0.803
Std Dev	0.388	0.334	0.418	0.484
Avg + 3 Std	1.830	1.848	2.158	2.180

Index P-85				
Part ID	0 - 0.500	0 - 1.000	0 - 1.500	0 - 2.000
1	441	0.890	0.890	0.180
2	444	0.100	0.100	0.180
3	445	0.170	0.890	0.890

P850-844 24858

1	448	0.000	0.000	0.000	0.000
2	448	0.000	0.000	0.000	0.000
3	448	0.000	0.000	0.000	0.000
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Average		0.118	0.190	0.218	0.218
Std Dev		0.080	0.103	0.080	0.080
Ave + 3 Std		0.388	0.474	0.488	0.458

Part ID	Units - PPS			
	0 - 1.0M	0 - 1.0M	0 - 1.0M	0 - 1.0M
1	441	0.000	0.000	0.000
2	444	0.000	0.000	0.000
3	448	0.000	0.000	0.000
4	448	0.000	0.000	0.000
5	447	0.000	0.000	0.000
6	448	0.000	0.000	0.000
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PERC-844 24851

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20					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Ans + 3 Std		0.000	0.000	0.000	0.000

		Units			
	Part No	0-0.001	0-1.001	0-1.001	0-2.001
1	441		0.000		
2	440		0.000		
3	440		0.000		
4	440		0.000		
5	447		0.000		
6	440		0.000		
7					
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28					
29					
30					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Ans + 3 Std		0.000	0.000	0.000	0.000

FORM 344 2-65-52

Unit 20-25					
Part ID	0-0.5M	0-1.0M	0-1.5M	0-2	v
1	441	0.000			
2	442	0.000			
3	443	0.000			
4	444	0.000			
5	445	0.000			
6	446	0.000			
7					
8					
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24					
25					
26					
27					
28					
29					
30					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Ave + 3 Std		0.000	0.000	0.000	0.000

100 Brake-Away Process - Unit 100					
Part ID	0-0.5M	0-1.0M	0-1.5M	0-2	v
1	441	0.000			
2	442	0.000			
3	443	0.000			
4	444	0.000			
5	445	0.000			
6	446	0.000			

PER3-044 24823

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Average 0.000 0.000 0.000 0.000
 Std Dev 0.000 0.000 0.000 0.000
 Ave + 3 Std 0.000 0.000 0.000 0.000

	WOP Points - all trials				
	Part ID	0-0.04	0-1.04	0-1.04	0-2
1	441	0.000		0.000	
2	444	0.000		0.000	
3	445	0.000		0.000	
4	446	0.000		0.000	
5	447	0.000		0.000	
6	448	0.000		0.000	
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PERC-044 24854

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35					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Ave + 3 Std		0.000	0.000	0.000	0.000

	Part No	0 - 1.000	0 - 1.000	0 - 1.000	0 - 2
441		0.000	0.000		
442		0.000	0.000		
443		0.000	0.000		
444		0.000	0.000		
445		0.000	0.000		
446		0.000	0.000		
447		0.000	0.000		
448		0.000	0.000		
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498					
499					
500					
Average		0.000	0.000	0.000	0.000
Std Dev		0.000	0.000	0.000	0.000
Ave + 3 Std		0.000	0.000	0.000	0.000

PE33-041 24855

Horizontal Column 2 - drill totals				
Part ID	D - 0.5M	D - 1.0M	D - 1.5M	D - 2.0M
441	0.000	0.000		
442	0.000	0.000		
443	0.000	0.000		
444	0.000	0.000		
445	0.000	0.000		
446	0.000	0.000		
447	0.000	0.000		
448	0.000	0.000		
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498				
499				
500				
Average	0.000	0.000	0.000	0.000
Std Dev	0.000	0.000	0.000	0.000
Ave + 3 Std	0.000	0.000	0.000	0.000

Horizontal Column 3 - drill totals				
Part ID	D - 0.5M	D - 1.0M	D - 1.5M	D - 2.0M
441	0	0	0	0
442	0	0	0	0
443	0	0	0	0
444	0	0	0	0
445	0	0	0	0
446	0	0	0	0
447	0	0	0	0
448	0	0	0	0
449	0	0	0	0
450	0	0	0	0
451	0	0	0	0
452	0	0	0	0
453	0	0	0	0
454	0	0	0	0
455	0	0	0	0
456	0	0	0	0
457	0	0	0	0
458	0	0	0	0
459	0	0	0	0
460	0	0	0	0
461	0	0	0	0
462	0	0	0	0
463	0	0	0	0
464	0	0	0	0
465	0	0	0	0
466	0	0	0	0
467	0	0	0	0
468	0	0	0	0
469	0	0	0	0
470	0	0	0	0
471	0	0	0	0
472	0	0	0	0
473	0	0	0	0
474	0	0	0	0
475	0	0	0	0
476	0	0	0	0
477	0	0	0	0
478	0	0	0	0
479	0	0	0	0
480	0	0	0	0
481	0	0	0	0
482	0	0	0	0
483	0	0	0	0
484	0	0	0	0
485	0	0	0	0
486	0	0	0	0
487	0	0	0	0
488	0	0	0	0
489	0	0	0	0
490	0	0	0	0
491	0	0	0	0
492	0	0	0	0
493	0	0	0	0
494	0	0	0	0
495	0	0	0	0
496	0	0	0	0
497	0	0	0	0
498	0	0	0	0
499	0	0	0	0
500	0	0	0	0

PE83-844 24028

FD-304 (Rev. 1-25-60)

Average	Std Dev	Avg + 3 Std	Avg - 3 Std
10			
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From: Gehl, Laxman (L.D.)
Sent: Friday, January 31, 2003 11:29 AM
To: 'kpyle@wmco.com'; 'jnlara@wmco.com'; 'dnomovec@wmco.com'
Cc: Hawkins, Fred (F.W.); Kisse, Alan (A.P.); West, Gregory (G.S.); Liposky, Lawrence (L.J.)
Subject: Gage R&I study and improvement of process capability

Gentlemen,

I am enclosing the data that were collected at KTP. One thing that I discussed with Greg West and agree that at this point of time it is imperative that WMCO focus their efforts on improving the process capability and shifting the average to the center, which will produce less scrap and more confidence on the process to produce a good quality product.

Jerry, as I requested, please share the plots of % scrap, average, and Ppk (with histogram of the data) on a regular basis with the Ford team. Since you are testing 100%, please confirm that you are calculating Ppk and average inclusive of the rejected parts and not just based on 'good' parts (within specs).

During my visit at your facility on Jan. 28-29, I observed that you are sincerely trying to improve the process capability, but it needs to be done in a systematic way. That is the reason, I had strongly recommended to start the DOE that will make us understand effect of various process parameter on the output. Please ensure that you are making all your efforts to initiate DOE ASAP. Do not hesitate to let us know if you need any assistance in this regard.

I will be gone to training for 6-1/2 weeks starting Feb. 3, but someone from STA (please contact Fred Hawkins) will certainly help you out.

Thank you.



KTP data.xls

UNITED We STAND

Laxman Gehl

STA Chassis Engineer

✉ email:lgehl@ford.com

VPO 1E-436

☎Phone/Fax (313) 390-0771

ⓧAlternative Fax (313) 390-0793

📠Pager: (313) 796-7701 (Text)

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PEB3-844 24760

	NGS Volts Read	NGS Counts (1024/5)	EOL Data Counts Logfile	Diff. EOL/NGS
B92897				
1-CL	4.08	835.584	838	0.416
2-CL	1.46	299.008	302	2.982
3-CL	0.9	184.32	188	3.68
				0
1-WOT	0.59	120.832	118	2.832
2-WOT	4.15	849.92	853	3.08
3-WOT	3.57	731.136	735	4.864
				0
G01874				
	3.89	817.152	819	1.848
	1.51	309.248	311	1.752
	0.97	198.656	198	0.856
				0
	0.69	141.312	142	0.688
	4.07	833.536	834	0.464
	3.52	720.896	721	0.104
				0
B91922				
	4.04	827.392	825	2.392
	1.45	296.96	298	2.04
	0.87	178.176	182	3.824
				0
	0.53	108.544	109	0.456
	4.12	843.776	848	2.224
	3.55	727.04	729	1.96
				0
G88794				
	4.09	837.632	837	0.632
	1.46	299.008	301	1.892
	0.89	182.272	184	1.728
				0
	0.54	110.592	119	8.408
	4.18	858.084	850	6.064
	3.61	739.328	734	5.328
				0
B92651				
	4.08	835.584	835	0.584
	1.43	292.864	294	1.136
	0.86	180.224	182	1.778
				0
	0.59	120.832	121	0.168
	4.13	845.824	847	1.178
	3.55	727.04	730	2.96
				0
B98445				
	3.98	811.008	813	1.992
	1.45	296.96	298	1.04
	0.91	186.368	186	0.368

				0
	0.71	145.408	147	1.592
	3.97	813.056	814	0.944
	3.39	694.272	695	0.728
				0
B90585				0
	3.95	806.96	809	0.04
	1.49	305.152	306	0.848
	0.95	194.58	193	1.56
				0
	0.89	141.312	143	1.688
	4.04	827.392	829	1.808
	3.47	710.856	712	1.344
				0
B89108				0
	3.89	817.152	819	1.848
	1.53	313.344	315	1.856
	0.89	202.752	203	0.248
				0
	0.88	139.284	140	0.736
	4.15	848.92	852	2.08
	3.6	737.28	737	0.28
				0
B92569				0
	4.11	841.728	840	1.728
	1.4	293.72	290	3.28
	0.89	182.272	184	1.728
				0
	0.82	126.976	130	3.024
	4.11	841.728	842	0.272
	3.53	722.944	722	0.944
				0
B83901				0
	4.03	825.344	825	0.344
	1.43	292.864	293	0.136
	0.88	176.128	178	1.872
				0
	0.58	114.688	114	0.688
	4.14	847.872	848	0.128
	3.47	710.656	712	1.344

From: West, Gregory (G.S.)
Sent: Friday, January 31, 2003 10:29 AM
To: Gehl, Leonan (L.D.); Page, Michael (M.A.); Hawkins, Fred (F.W.)
Subject: FW: Gage R&R

FYI, I don't need to go through this data again and I don't think WMCO needs to give us assignments to perform gage r&r's either. I'm convinced that EOL reads properly and accurately. Having said that what I observed is that the task for the EOL operator is difficult WRT the WOT pedal test and if we were to go back to the EOL specs that match the print we would again have a high rate of pedal failures not due to bad pedals but due to a difficult test procedure.

I say let it erid here.

-----Original Message-----

From: Swicker, Rick (R.M.)
Sent: Friday, January 31, 2003 9:03 AM
To: West, Gregory (G.S.)
Subject: RE: Gage R&R

Greg, Here it is. I didn't take the time to organize it so let me know if you have any questions. The 'NGS Volts Read' column is a combination of the before EOL and after EOL readings. There was never enough difference between the two to bother documenting.



KTP data.xls

-----Original Message-----

From: West, Gregory (G.S.)
Sent: Friday, January 31, 2003 8:39 AM
To: Gehl, Leonan (L.D.); Page, Michael (M.A.)
Cc: Hawkins, Fred (F.W.); Swicker, Rick (R.M.)
Subject: RE: Gage R&R

We didn't do an official gage r&r but we did check ten trucks just before rolls, at rolls and just after rolls. Rick Swicker from the EOL diagnostic group took the data. Rick, do you still have the data? Can you summarize your findings, thanks.

-----Original Message-----

From: Gehl, Leonan (L.D.)
Sent: Thursday, January 30, 2003 3:57 PM
To: Page, Michael (M.A.); West, Gregory (G.S.)
Cc: Hawkins, Fred (F.W.)
Subject: Gage R&R

Gentlemen,

During my recent visit at WMCO, I understood that WMCO folks had requested to have the gage R&R study done at KTP. I was wondering if the study is completed and the data can be made available to them. If the study is not done, is there any plan? Further, please let me know if any assistance from WMCO is needed to complete the gage R&R study - in that case what is the good time (dates) for them to visit KTP.

Thank you.

PER3-844 25668

UNITED We STAND

Laxman Gehi

STA Chassis Engineer

✉ email:lgheh@ford.com

VPO 1E-436

☎ Phone/Fax (313) 390-0771

☎ Alternative Fax (313) 390-0793

☎ Pager: (313) 796-7701 (Text)

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PEBS-044 25081

	NGS Volts Read	NGS Counts *(1024/5)	EOL Data Counts Logfile	DW EOL&NGS
B92887				
1-CL	4.08	835.584	836	0.418
2-CL	1.46	299.008	302	2.992
3-CL	0.9	184.32	188	3.88
				0
1-WOT	0.59	120.832	118	2.832
2-WOT	4.15	849.92	853	3.08
3-WOT	3.57	731.136	738	4.864
				0
C01874				
	3.99	817.152	819	1.848
	1.51	308.248	311	1.752
	0.87	198.656	198	0.656
				0
	0.89	141.312	142	0.698
	4.07	833.536	834	0.464
	3.52	720.896	721	0.104
				0
B91922				
	4.04	827.392	825	2.392
	1.45	298.96	299	2.04
	0.87	178.176	182	3.824
				0
	0.53	108.544	109	0.456
	4.12	843.776	846	2.224
	3.55	727.04	729	1.96
				0
C08784				
	4.09	837.632	837	0.632
	1.46	299.008	301	1.992
	0.89	182.272	184	1.728
				0
	0.54	110.592	119	8.408
	4.18	858.064	850	6.064
	3.61	739.328	734	6.328
				0
B92691				
	4.06	835.584	835	0.584
	1.43	292.864	294	1.136
	0.88	180.224	182	1.776
				0
	0.59	120.832	121	0.168
	4.13	845.824	847	1.176
	3.55	727.04	730	2.96
				0
B88445				
	3.96	811.008	813	1.992
	1.45	298.96	298	1.04
	0.91	186.368	186	0.368

	0.71	145.408	147	0
	3.97	813.058	814	1.592
	3.39	694.272	695	0.944
				0.728
				0
B90565				0
	3.95	806.96	809	0.04
	1.48	305.152	306	0.848
	0.95	194.56	193	1.56
				0
	0.69	141.312	143	1.688
	4.04	827.392	829	1.908
	3.47	710.858	712	1.344
				0
B98108				0
	3.99	817.152	819	1.848
	1.53	313.344	315	1.658
	0.99	202.752	203	0.248
				0
	0.88	139.264	140	0.736
	4.15	849.92	852	2.08
	3.6	737.28	737	0.28
				0
B92589				0
	4.11	841.728	840	1.728
	1.4	286.72	290	3.28
	0.89	182.272	184	1.728
				0
	0.82	126.978	130	3.024
	4.11	841.728	842	0.272
	3.53	722.944	722	0.944
				0
B83901				0
	4.03	825.344	825	0.344
	1.43	292.864	293	0.136
	0.86	176.128	178	1.872
				0
	0.58	114.888	114	0.688
	4.14	847.872	848	0.128
	3.47	710.858	712	1.344

From: West, Gregory (G.S.)
Sent: Tuesday, January 07, 2003 4:31 PM
To: Hawkins, Fred (F.W.)
Subject: FW: 2002-03 MY F-Superduty/Excursion Adjustable Accelerator Pedal Se (14D v1.2.3 WORK Notification)

-----Original Message-----

From: rhilding@ford.com (mailto:rhilding@ford.com)
Sent: Monday, September 23, 2002 10:31 AM
To: gwest2@ford.com
Subject: 2002-03 MY F-Superduty/Excursion Adjustable Accelerator Pedal Se (14D v1.2.3 WORK Notification)

(This is an automated email message sent on behalf of rhilding.)

Instructions:

You have been assigned by a Critical Concern Manager the task of writing a 14D document.

The 14D process is used by Ford to determine if a vehicle concern requires the creation of a Field Service Action. A Field Service Action is the generic term for a Safety Recall, Customer Satisfaction Program, Label Program, or other type of program. An early step in this process requires you to complete a 14D document. This process is now automated on the Ford Intranet. A link to the Intranet site you need to go to is in the Email the Critical Concern Manager sent you. If you double-click on that link, Internet Explorer should launch and the 14D authoring web page should load.

Business Process: 14D v1.2.3
Title: 2002-03 MY F-Superduty/Excursion Adjustable Accelerator Pedal Se
From: rhilding
To: gwest2

Select this URL to access this instance of work:
<http://www.workflow.ford.com/14d/sm.asp?WFID=681986>

Select this URL to access your Workbox:
<http://www.workflow.ford.com>

(End automated email)

Obj#	B1 Area	B2 Area	B3 Area	B4 Area	B5 Area	B6 Area
1	1.6E-05	0.000432	0.000416	0.00048		0.002988
2	0.000258	0.00024	3.2E-05	8E-05		0.001488
3	1.6E-05	1.6E-05	1.6E-05	0.000208		8E-05
4	1.6E-05	9.6E-05	0.001936	0.000488		9.8E-05
5	0.000592	9.8E-05	8.4E-05	1.6E-05		3.2E-05
6	3.2E-05		0.000128	0.000488		0.000192
7	1.6E-05		0.000388	0.00024		0.00144
8	0.00024		1.6E-05	6.4E-05		0.001824
9	1.6E-05		6.4E-05	0.000488		0.001952
10	0.000616		4.8E-05	0.00016		1.8E-05
11	0.00016		0.000176	0.000208		0.003472
12	3.2E-05		0.000576	4.8E-05		0.002432
13	0.000128		3.2E-05	3.2E-05		6.4E-05
14	3.2E-05		0.000416	0.000388		0.000976
15			0.000388	0.00016		0.001104
16			0.000144	8E-05		0.000672
17			9.6E-05	1.6E-05		6.4E-05
18			1.6E-05	6.4E-05		0.000176
19			3.2E-05	0.000992		0.000144
20			1.6E-05	1.6E-05		0.00176
21			4.8E-05	0.000484		0.0016
22			3.2E-05	0.000112		0.000832
23			4.8E-05	0.000432		0.002784
24			0.000488	0.000736		
26				9.6E-05		
28				1.6E-05		
27				1.6E-05		
28				6.4E-05		
29				0.000128		
30				3.2E-05		
31				0.000144		
32				1.6E-05		
33				3.2E-05		
34				1.6E-05		
35				4.8E-05		
36				0.000432		
37				0.001152		
38				0.000192		
39				6.4E-05		
40				0.000304		
41				0.000384		
42				0.000484		

SUM: 2.37E-03 8.60E-04 5.68E-03 1.01E-02 0.00E+00 2.58E-02
MAX

Total Count 14

Obj	Area
1	1.6E-05
2	0.000256
3	1.6E-05
4	1.6E-05
6	0.000592
8	3.2E-05
7	1.6E-05
8	0.00024
9	1.6E-05
10	0.000816
11	0.00018
12	3.2E-05
13	0.000128
14	3.2E-05

Total Count 24

Obj#	Area
1	0.000416
2	3.2E-05
3	1.6E-05
4	0.001938
5	6.4E-05
6	0.000128
7	0.000368
8	1.6E-05
9	6.4E-05
10	4.8E-05
11	0.000176
12	0.000576
13	3.2E-05
14	0.000416
15	0.000368
16	0.000144
17	9.6E-05
18	1.6E-05
19	3.2E-05
20	1.6E-05
21	4.8E-05
22	3.2E-05
23	4.8E-05
24	0.000496

Total Count 5

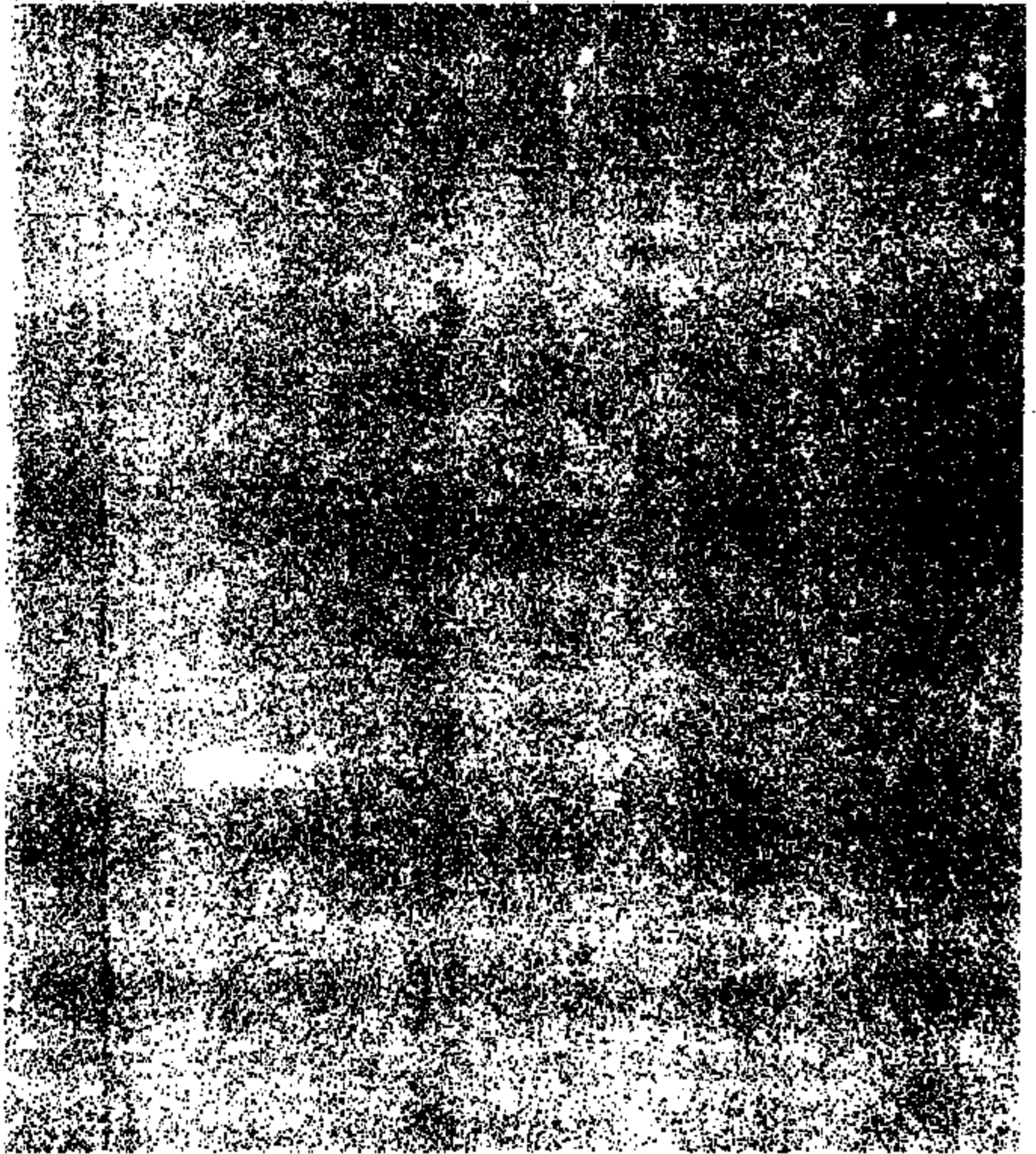
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4	9.8E-05
5	9.8E-05

Total Count 42

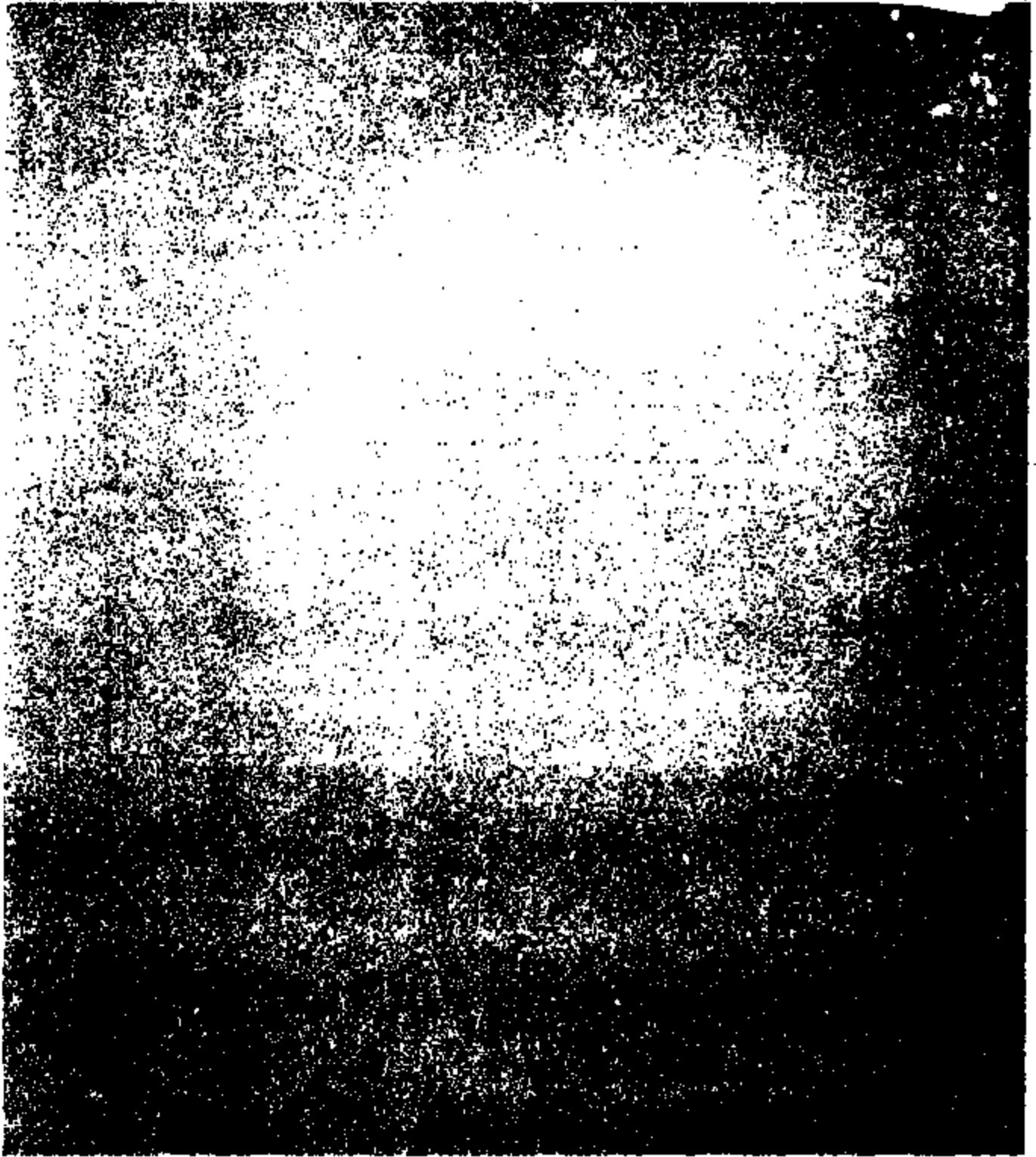
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8	6.4E-05
9	0.000496
10	0.00018
11	0.000208
12	4.8E-05
13	3.2E-05
14	0.000388
15	0.00016
16	8E-05
17	1.6E-05
18	6.4E-05
19	0.000992
20	1.6E-05
21	0.000484
22	0.000112
23	0.000432
24	0.000736
25	9.6E-05
26	1.6E-05
27	1.6E-05
28	6.4E-05
29	0.000128
30	3.2E-05
31	0.000144
32	1.6E-05
33	3.2E-05
34	1.6E-05
35	4.8E-05
36	0.000432
37	0.001152
38	0.000182
39	6.4E-05
40	0.000384
41	0.000384
42	0.000484

Total Count 23

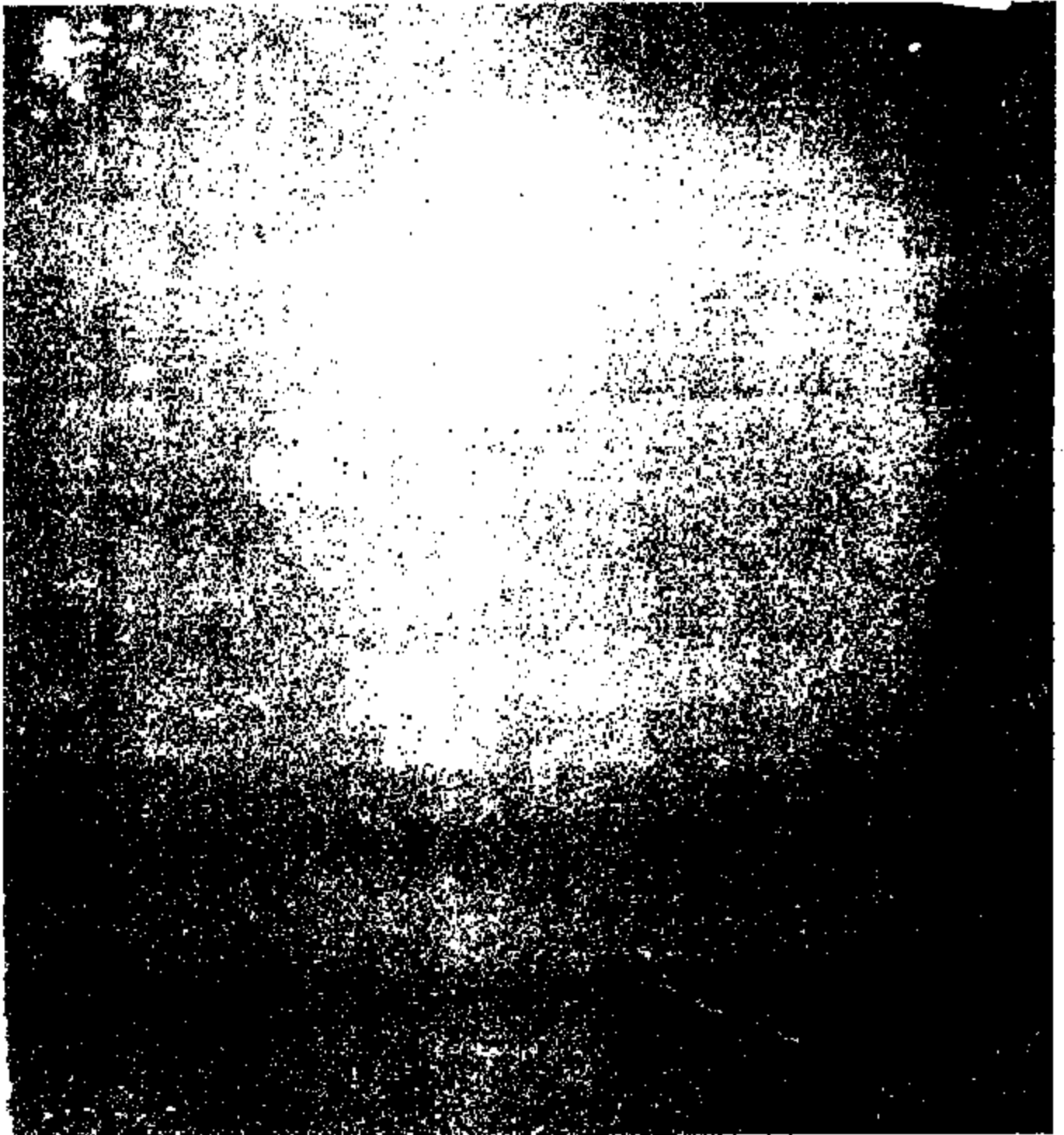
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4	9.8E-05
5	3.2E-05
6	0.000192
7	0.00144
8	0.001824
8	0.001852
10	1.6E-05
11	0.003472
12	0.002432
13	8.4E-05
14	0.000976
15	0.001104
16	0.000672
17	6.4E-05
18	0.000176
19	0.000144
20	0.00176
21	0.0018
22	0.000632
23	0.002784



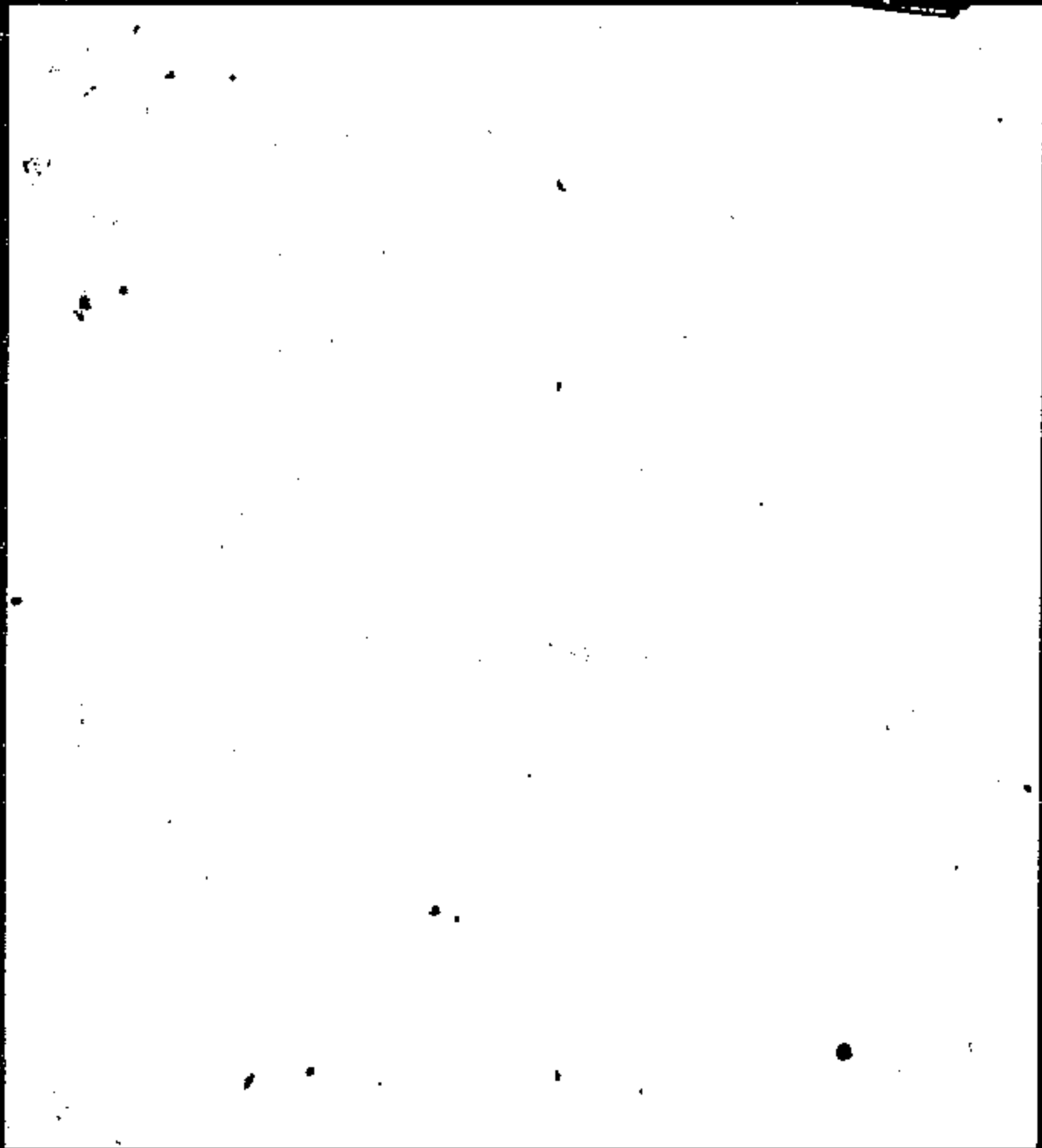
PEB3-044 25218



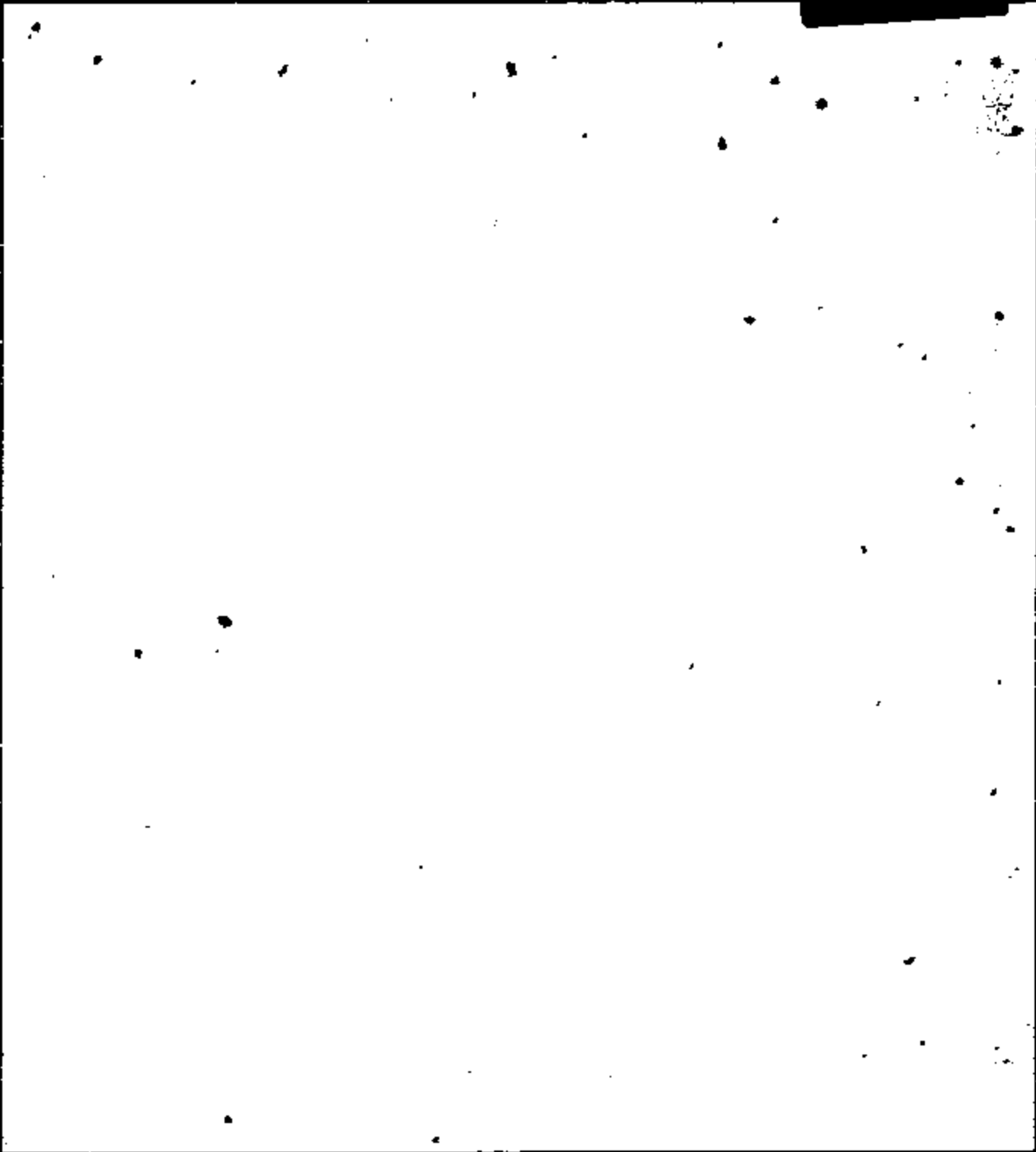
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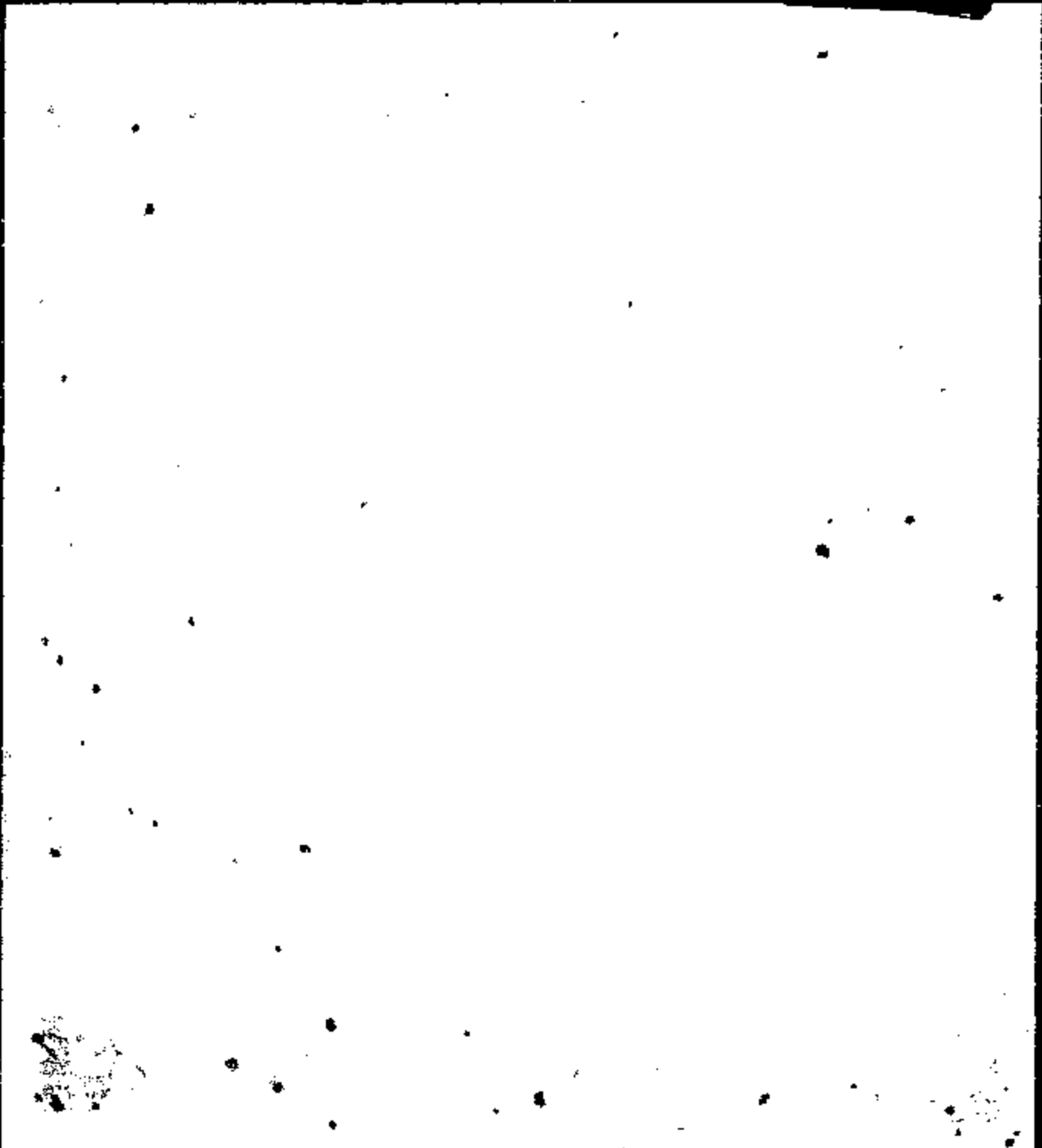
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FEB3-844 25221









PE83-844 25226