

📌 Cpk的计算公式：

• 双边规格：

$$Cpk = \min\left(\frac{USL - \bar{X}}{3\hat{\sigma}}, \frac{\bar{X} - LSL}{3\hat{\sigma}}\right) \text{ 或 } CpK = (1 - |Ca|) * Cp$$

当Ca=0时，Cpk=Cp；单边规格时，Cpk即以Cp值计之。

• 单边规格：以Cp表示：Cpk=Cp

📌 等级判定：

等级	Cpk值	处理原则
A+	≥ 1.67	无缺点，制程优良，可考虑降低成本
A	$1.33 \leq Cpk < 1.67$	状态良好，继续保持
B	$1.00 \leq Cpk < 1.33$	制程能力稍欠缺，需改进至A级
C	$0.67 \leq Cpk < 1.00$	制程不良较多，务必改进制程
D	$Cpk < 0.67$	制程很差，停线改进制程，方可生产

📌 Cpk与不良率的对应关系：

Cpk	每一百件之不良 Defects per 100 parts	每一百万件之不良(Dppm) Defects per million parts	合格率%
0.33	31.7	317310	68.3
0.67	4.5	45500	95.5
1	0.27	2700	99.73
1.33	0.0063	63	99.994
1.67	0.000057	0.57	100
2	0.0000002	0.002	100

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