－解答用紙－

|  |  |  |  |
| --- | --- | --- | --- |
| 入所年月 | 番号 | 氏　名 | 点数 |
| 年　　月 |  |  |  |

**問題1～5及び7～10は各2点　問題6、11は各1点**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 【問題1】 | a | エ | b | ウ | c | ア |
|  | d | キ | e | ク | f | ケ |

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| --- | --- | --- | --- | --- | --- | --- |
| 【問題2】 | a | 清掃 | b | 躾（しつけ） | c | 整理 |
|  | d | 整頓 |  |  |  |  |

|  |  |  |  |  |  |  |  |  |  |
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| 【問題3】 | E | イ | エ | C | ア | カ | R | オ | ク |
|  | S | ウ | キ |  | ※順不同 | | | | |

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| 【問題4】 | ① | 420秒 | ② | 480秒 | ③ | 87.5％ |

**ピッチタイム：（360+420+390+480+450+420）÷6=420秒**

**ラインバランス率：420÷480×100=87.5％**

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| 【問題5】 | ① | a | 3.35mm | b | 53.50mm |
|  | ② | a | 1.65mm | b | 30.70mm |
|  | ③ | a | 2.66mm | b | 20.32mm |

|  |  |  |  |  |  |  |
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| 【問題6】 | ① | オ | ② | ウ | ③ | カ |
|  | ④ | エ | ⑤ | キ | ⑥ | イ |
|  | ⑦ | ア |  |  |  |  |

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| 【問題7】 | ① | 1.811 | ② | 1.014 | ③ | 0.70 |

**① Cp:**

**② Cpk:**

**③ →　ｓ=0.70175**

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| 【問題8】 | a | ア | b | カ | c | キ |
|  | d | ク | e | コ | f | シ |

**⑤ Cpk:**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 【問題9】 | ① | イ | ② | ウ | ③ | カ |

**① → 標準正規分布表0.29673**

**→ 標準正規分布表0.49379**

**→ 20.95%**

**② → 標準正規分布表0.40824**

**→ 標準正規分布表0.47725**

**→ 11.45%**

**③ ←現状の1/10の不適合率**

**← 標準正規分布表にあてはめるため1/2にする**

**→ 標準正規分布表から近い確率の数値を探し出す → 2.31**

**→ σ=4.32900 → 4.33**

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| --- | --- | --- | --- | --- | --- | --- |
| 【問題10】 | ① | エ | ② | オ | ③ | カ |
|  | ④ | イ |  |  |  |  |

**① → 50.0741**

**② → 49.9021**

**③ → 0.269**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| 【問題11】 | ① | オ | ② | キ | ③ | ウ |
|  | ④ | エ | ⑤ | イ | ⑥ | ア |
|  | ⑦ | カ |  |  |  |  |