

























- When the warning limits are violated, it's an indication of a *possible* shift or trend. Since this will occur 5% of the time when a real change has not occurred, the only action generally taken is increased attention. Sometimes sampling frequency is increased.
 When the action limits are violated, search for
- a cause or take other appropriate action. This will occur only 0.2% of the time if a real change has not happened.

Module 5.2

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Control Chart Example Time Sample Data (n=3) Means Ranges 108.5 103.6 111.2 107.77 7.6 1 2 116.4 116.0 118.7 117.03 2.7 3 99.1 108.8 115.5 107.80 16.4 106.5 101.5 104.20 4 104.6 5.0 104.00 5 100.8 105.1 106.1 5.3 99.4 107.2 108.0 104.87 6 8.6 7 110.7 108.2 108.4 109.10 2.5 108.1 116.7 109.6 111.47 8.6 8 9 109.1 107.4 119.9 112.13 12.5 10 114.3 121.9 106.7 114.30 15.2 Module 5.2 4

Sample Mean Control Chart Example								
Overall Mean =		109.27						
Mean Range =			8.44					
Stan. Dev. =		0.591*8.44 =	4.99					
Lower Warning Lim	it =	109.27-1.96*(4.99/	103.62					
Upper Warning Limit =		109.27+1.96*(4.99/	114.91					
Lower Action Limit =		109.27-3.09*(4.99/	100.37					
Upper Action Limit =		109.27+3.09*(4.99/	′sqrt(3)) =	118.17				
To find the Stan. Dev. use Manly Table 5.5 for SD Factor (k) with n=3. NOTE, n=3 NOT M=10.								
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Sample Range Control Chart Example								
R bar = Mean of Ranges =		8.44						
Lower Warning Limit =	0.18 * 8.44 =		1.52					
Upper Warning Limit =	2.17 * 8.44 =		18.31					
Lower Action Limit =	0.04 * 8.44 =		0.34					
Upper Action Limit =	2.99 * 8.44 =		25.24					
To find the multipliers for the warning and action limits, use Manly Table 5.5 with n=3.								
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Conti	rol Cha	art Exa	ample -	– New	Data			
<u>Time</u>	Sample Data			<u>Means</u>	Ranges			
11	110.7	108.2	122.1	113.67	13.9			
12	105.9	115.8	110.0	110.57	9.9			
13	110.0	103.8	108.0	107.27	6.2			
14	108.6	111.8	105.9	108.77	5.9			
15	110.1	107.3	107.3	108.23	2.8			
16	108.8	112.1	119.2	113.37	10.4			
17	115.7	118.7	100.3	111.57	18.4			
18	104.5	109.7	104.2	106.13	5.5			
19	111.2	104.3	112.5	109.33	8.2			
Module 5.2								







