Implementation of an SPC system

Selecting Control Charts

Process Measurements are available

- X - R Charts
- Median Charts
- X - s Charts
- Charts for Individuals

Process Measurements are not available

- np - Charts
- p - Charts
- c - Charts
- u - Charts

Set up the process for Optimum Performance

Collect data from the process (≥ 30 samples)

Plot the data & Calculate Control Limits

Check for Process Control & Process Capability (Cp/Cpk or Pp/Ppk)

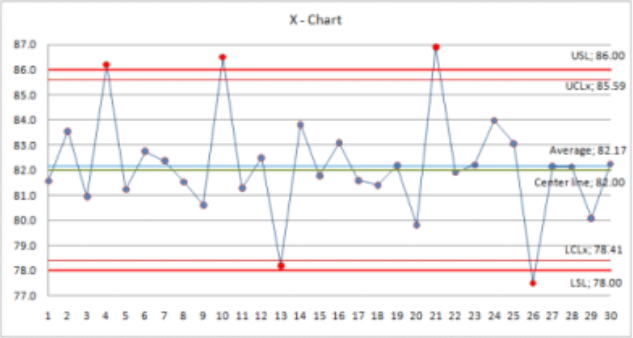
Process in Control & Capable
Cpk/Ppk ≥ 1

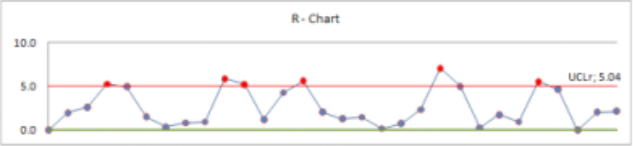
Process Not Capable
Cpk/Ppk < 1

Set up an SPC Control Chart
Define the statistical alarms

Collect and Plot data from the process

Identify and eliminate special causes of variation → Perform a new Capability Study





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