

SPC Rules

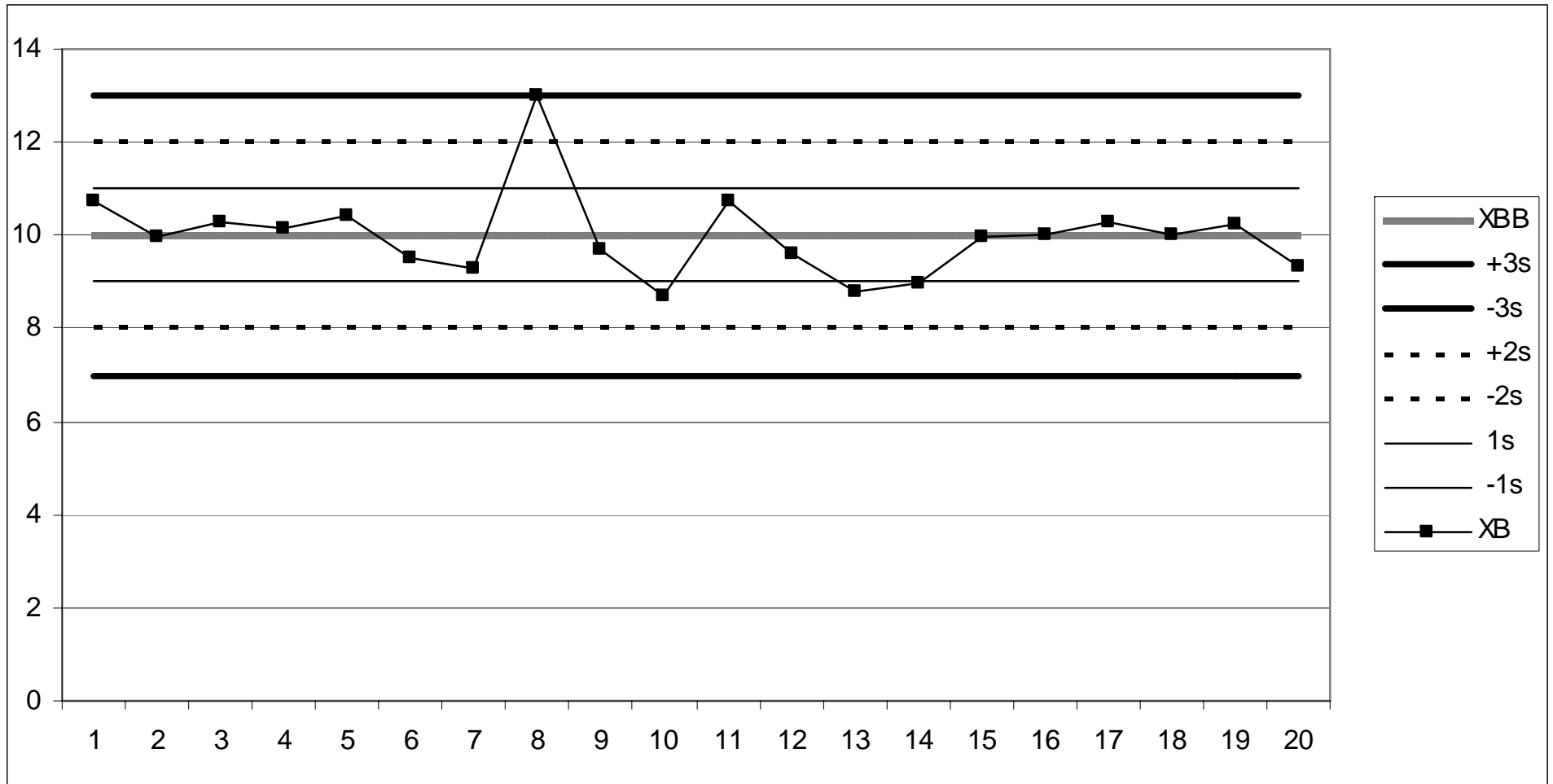
D. W. Parent

How does one decide if a point is part of an uncontrolled process?

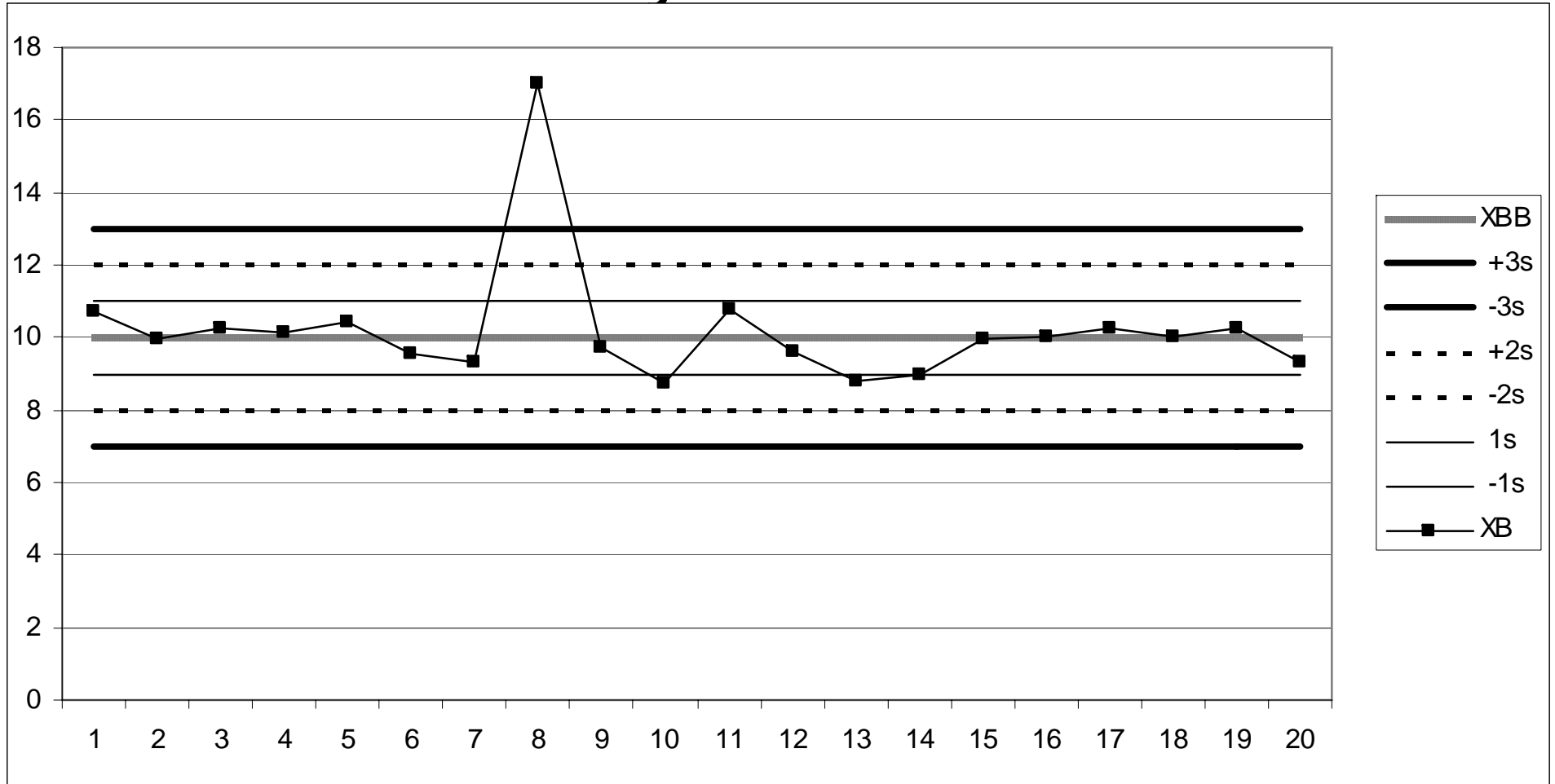
- One point beyond the 3σ control limit
- 2 out of 3 consecutive points plot outside of the 2σ control limit
- 4 out of 5 consecutive points plot outside of the 1σ control limit
- 9 consecutive points on the same side of the centerline
- 6 consecutive points increase or decrease
- 14 consecutive points oscillate up and down
- 15 consecutive points inside of the 1σ control limit.

These are the “Western Electric” Rules

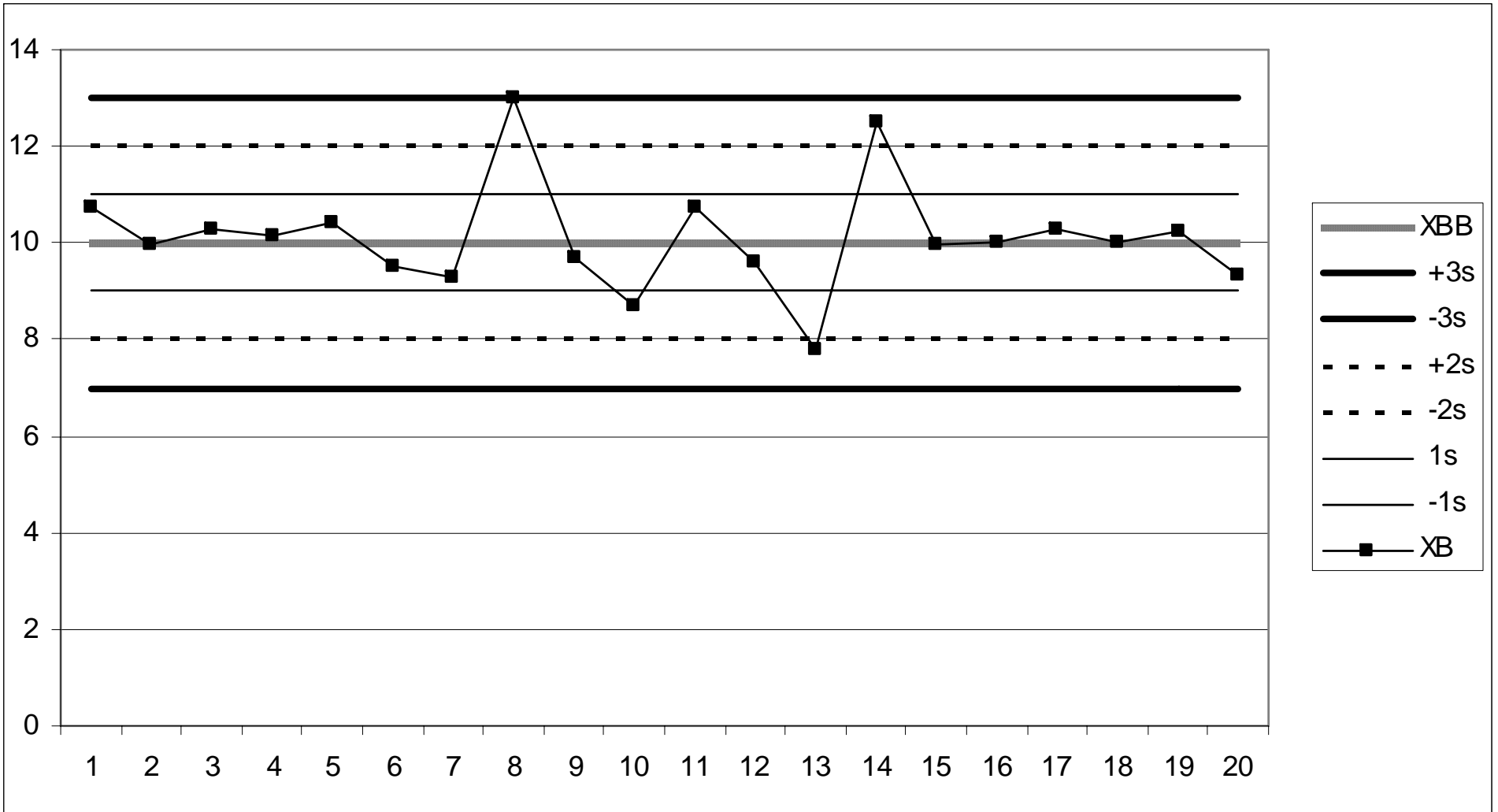
Any Errors?



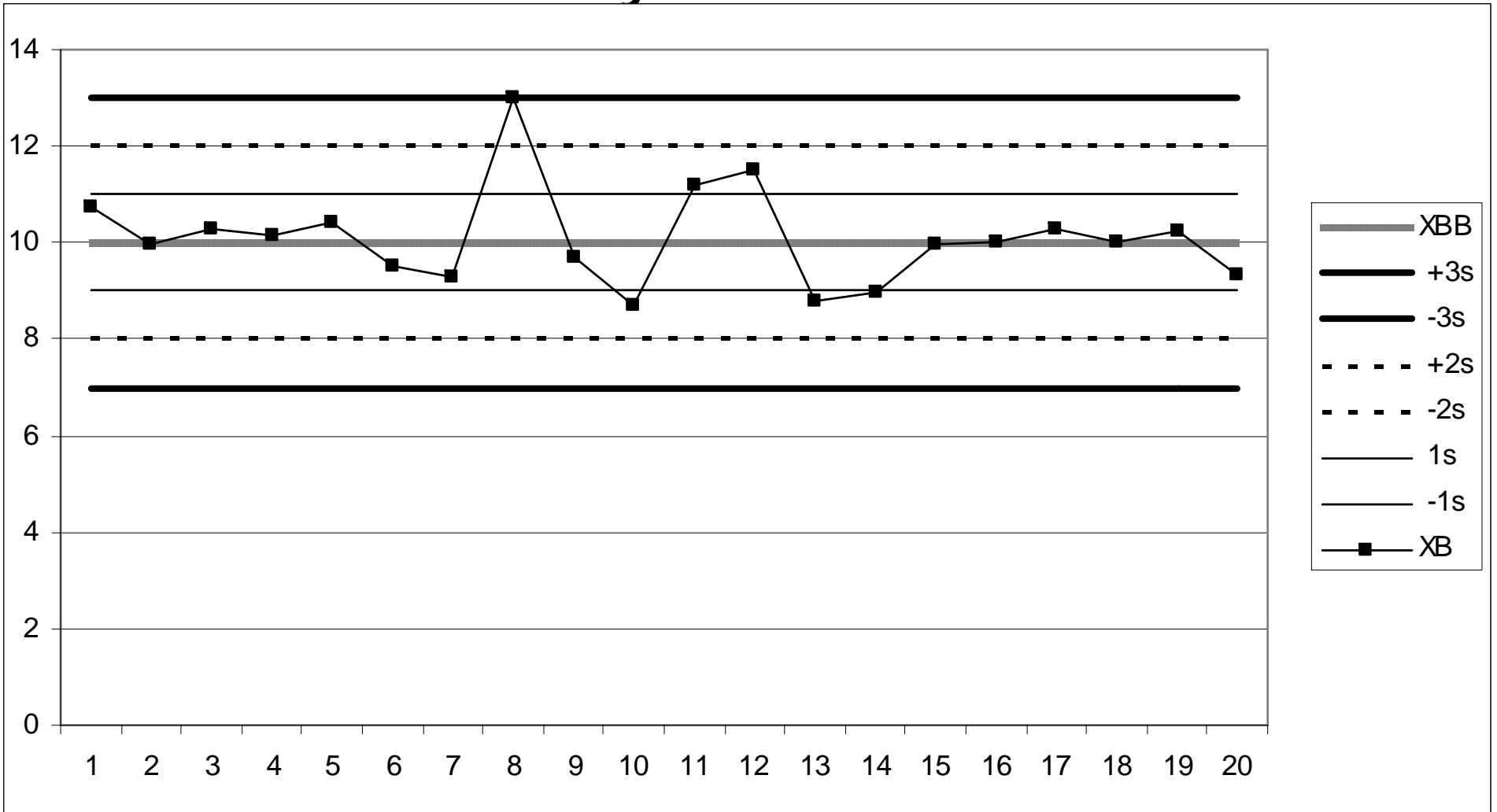
Any Errors?



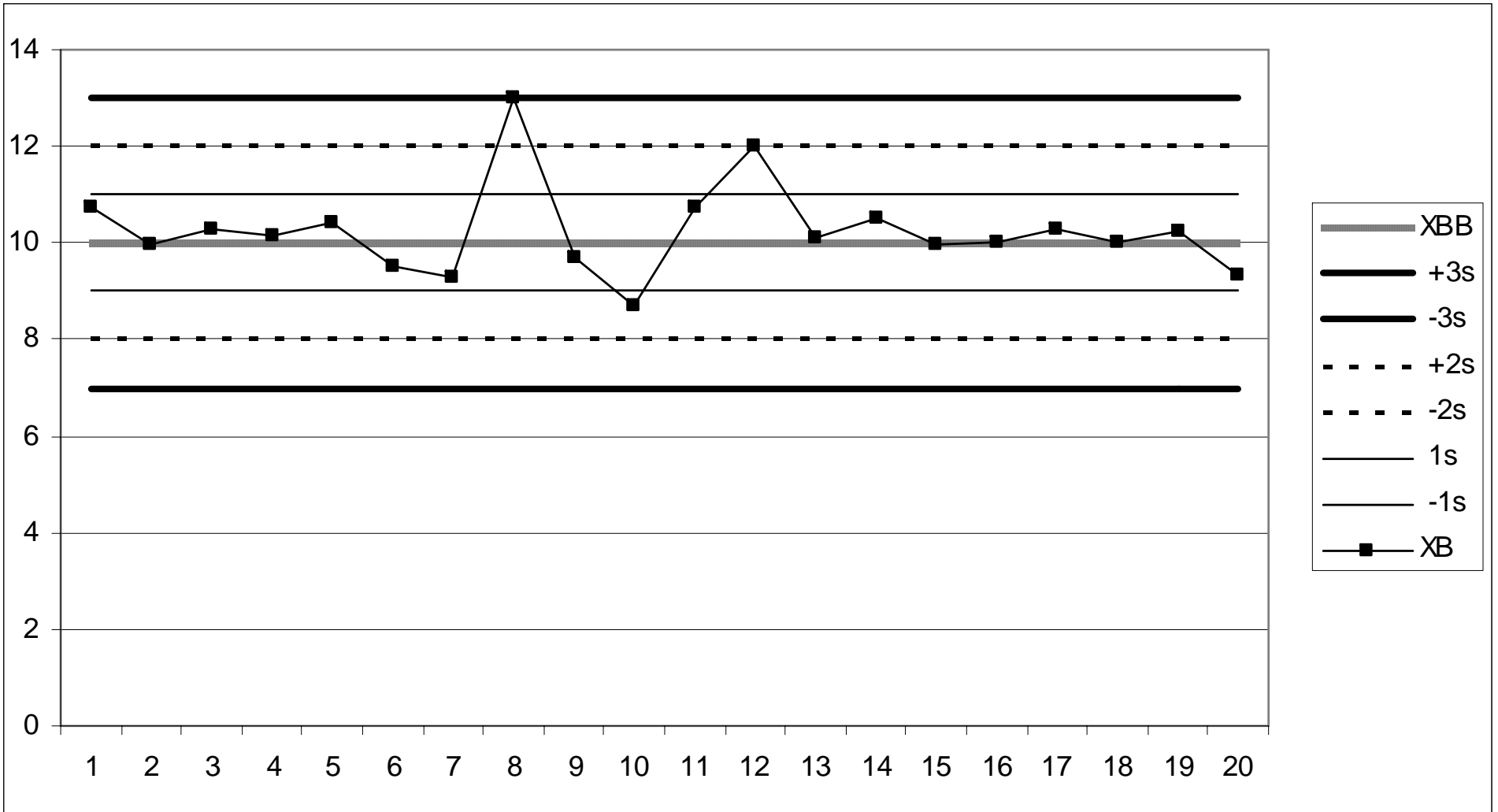
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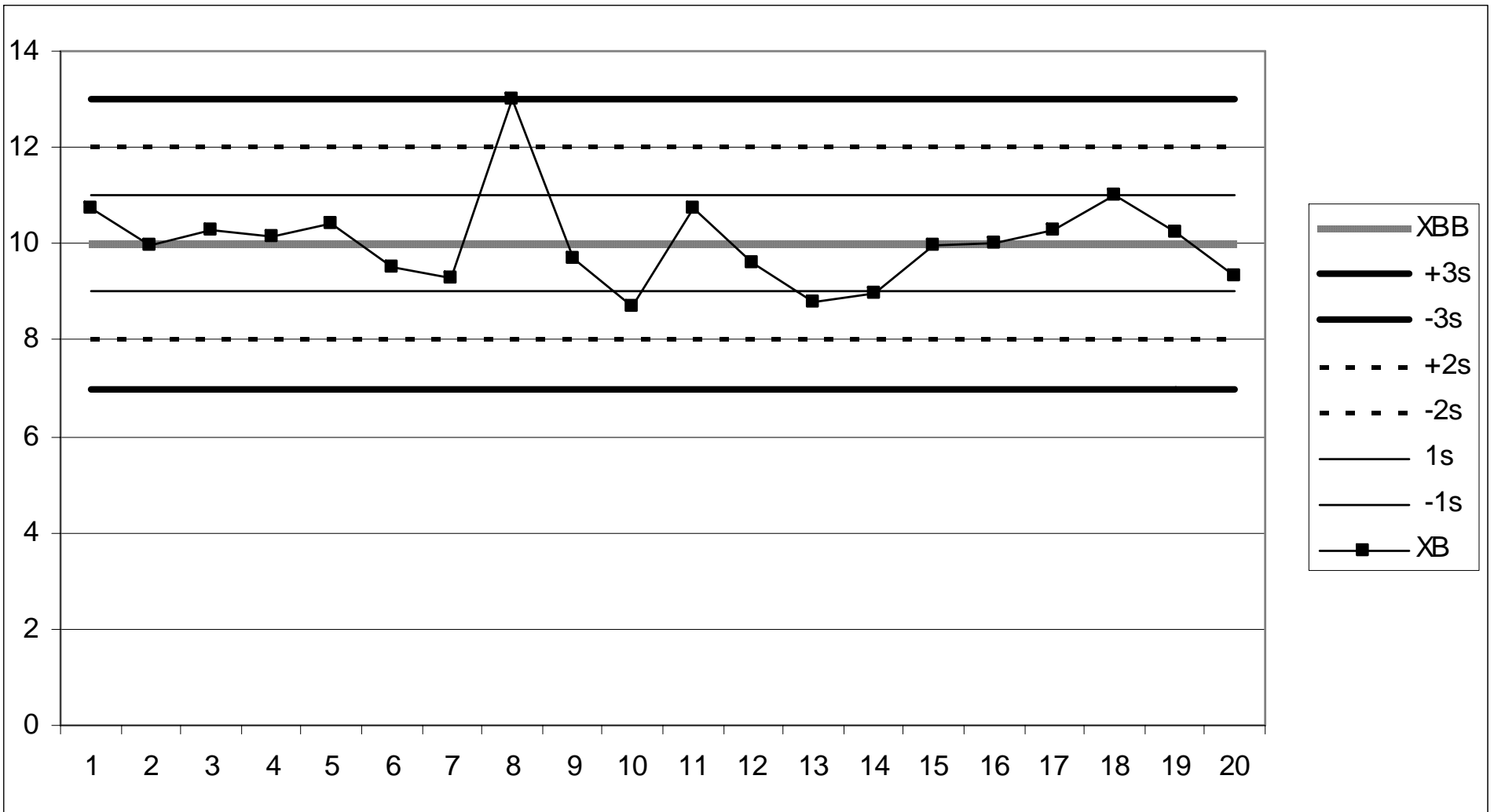
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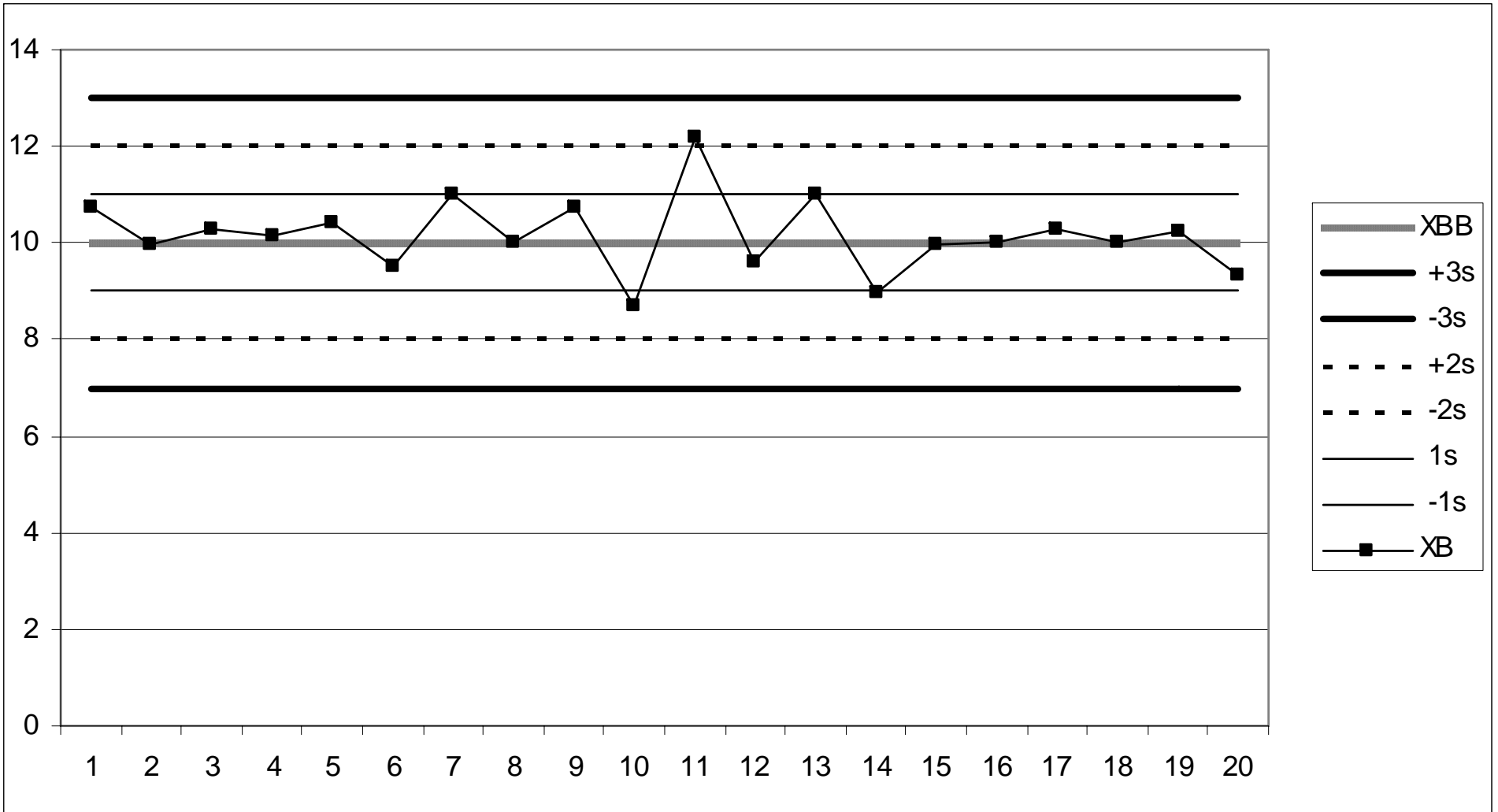
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