

MSA 4th Edition Quick Guide

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Other	White Papers – available at ALAG website (www.alag.org)	

NOTE: Regarding the use of the *GRR* standard deviation

Historically, by convention, a 99% spread has been used to represent the “full” spread of measurement error, represented by a 5.15 multiplying factor (where σ_{GRR} is multiplied by 5.15 to represent a total spread of 99%).

A 99.73% spread is represented by a multiplier of 6.0, which is $\pm 3\sigma$ and represents the full spread of a “normal” curve.

If the reader chooses to increase the coverage level, or spread, of the total measurement variation to 99.73%, use 6.0 as a multiplier in place of 5.15 in the calculations.

Note: *The approach used in the 4th Edition is to compare standard deviations. This is equivalent to using the multiplier of 6 in the historical approach.*

Awareness of which multiplying factor is used is crucial to the integrity of the equations and resultant calculations. This is especially important if a comparison is to be made between measurement system variability and the tolerance. Consequently, if an approach other than that described in this manual is used, a statement of such must be stated clearly in any results or summaries (particularly those provided to the customer).

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