

Update to the AIAG- SPC Reference Manual

Michael Down

General Motors Corporation/SPC Rewrite Chairman

Greg Gruska, Peter Cvetkovski (Ford), Dave Benham (DaimlerChrysler)

SPC Rewrite Committee

ABSTRACT

The SPC reference manual was one of the first manuals released by Ford, GM, and DaimlerChrysler (formally Chrysler) to communicate the methods and application of Statistical Process Control. It has been useful, but it was released in the early 80's and required updating in relation to style, changes in philosophy, and the introduction of new methods.

INTRODUCTION

SPC- Statistical Process Control has been around for many years, first created by Walter Shewhart in the 1920. It came to the forefront by Dr. W. Edwards Deming's teaching and application in Japan in the mid 40's after World War Two and into the early 80's when it became recognized in the US. It eventually became a requirement of all US automotive suppliers to have proof of the application of SPC and that the parts being delivered were from a stable process.

MAIN SECTION

The main purpose of this paper is to review the philosophy used in the development of the new SPC reference manual, the changes and additional methods reviewed and supported.

PHILOSOPHY OF THE SUBCOMMITTEE

Prior to starting the rewrite the committee established specific norms to follow while developing the manual. They were as follows:

- Update the format to match current manuals
- Evaluate order, improve logic
- Customer focused: Easier to use and understand
- Reduce focus on indices
- Up-front reinforce the need for a system of application and analysis
- Add additional methods that have been introduced since the manual was published
- Improve the glossary and index
- Review and update reference list

Introduction

The manual contains information from the basics of SPC, management support process, the common statistical methods, and additional methods that can be used in special situations. The introduction sets the stage by showing the importance of using SPC to define variation.

- Establish where the process is centered
- Whether the process is stable or unstable
- The amount of variation that exists.

Data, Results, and Measurement

Decisions and estimates are based on a perception of what the population is doing. The quality of this perception is based on a number of issues.

- Homogeneous population
- Distribution of the population
- Sampling plan
- Whether the process and population are stable
- Measurement variation
- Interdependent variables

The stability and uniformity of the population is critical to understand prior to collecting and analyzing data. The uniformity and stability of the population impact the way that collect the data and the way the data is analyzed. This is not just a "point of view", it always exist whether it taken into account or ignored. In most cases a normal distribution (bell curve) in relation to a continuous process.

Sampling can also impact the results of data collection and analysis. In some cases a randomized sample is required. This means by where, when and how the sample is taken from the population. Randomization helps to limit bias and also gives a better picture of what the variation in the population looks like. In other cases, the sample isn't random; parts are either specifically selected or made to specific requirements. This often occurs in engineering development or when problem solving issues. (Note: Distribution, Uniformity, and stability of the population are assumed/ Measurement variation is small)

Aiag Manual For Spc

**Roderick A. Munro, Govindarajan
Ramu, Daniel J. Zrymiak**



Aiag Manual For Spc:

Statistical Process Control, Statistical Process Control (SPC), 1995 Understanding ISO 9001 : 2015 Quality Management System, 2nd Edition, Revised and Expanded Virendra Kumar Gupta, 2017-06-15 The 2015 version of ISO 9001 brings many enriching changes to promote quality excellence by organizations The most significant change is the reinforcement of the fact that ISO 9001 is not just a quality issue It is relevant as an overarching management topic The book explains the requirements of the revised 2015 version of ISO 9001 in simple and practical manner The objective has been to enhance understanding of the subject matter by managers and quality professionals A conceptual understanding shall enable managers and professionals to design better systems and processes uniquely suited to their respective organizations In view of this the first five chapters of the book explain concepts on QUALITY PROCESS PROCESS APPROACH MANAGEMENT and PDCA These are relevant for all management system standards being developed by International Organization for Standardization with the High Level Structure Part II of the book goes into details of each clause focusing on processes and process interactions We expect that the readers will appreciate that ISO 9001 now focuses more on expected outcomes through processes than mandating too many requirements Measurement of Geometric Tolerances in Manufacturing

James D. Meadows, 1998-05-28 This insightful reference demonstrates a system of measurement inspection gaging geometric tolerancing and fixturing of products in full compliance with the American National Standards Institute ANSI the American Society of Mechanical Engineers ASME and the International Organization for Standardization ISO approved standards

The Certified Quality Engineer Handbook Rachel Silvestrini, Sarah E. Burke, 2017-01-25 A comprehensive reference manual to the Certified Quality Engineer Body of Knowledge and study guide for the CQE exam The ASQ Certified Six Sigma Green Belt Handbook Roderick A. Munro, Govindarajan Ramu, Daniel J. Zrymiak, 2022-06-30 This handbook is designed to help candidates preparing for the ASQ Six Sigma Green Belt certification exam Meant for those who already understand the basic concepts of reducing variation and improving processes it also serves as a helpful reference to the appropriate materials needed to conduct successful Green Belt projects The layout of the handbook is mapped to the 2022 version of ASQ s Body of Knowledge BoK This revised edition includes new information about SMART goals key process indicators Takt time just in time processes and spaghetti diagrams The Kano model risk management business continuity planning SWOT analysis and RACI charts Data collection plans and quality checks Gap analysis 5 Whys analysis and fault tree analysis Maintaining quality improvements Document control audits training plans the PDCA cycle Andon and Jidoka system *The Certified Six Sigma Green Belt Handbook, Second Edition* Roderick A. Munro, Govindarajan Ramu, Daniel J. Zrymiak, 2015-05-13 This reference manual is designed to help those interested in passing the ASQ s certification exam for Six Sigma Green Belts and others who want a handy reference to the appropriate materials needed to conduct successful Green Belt projects It is a reference handbook on running projects for those who are already knowledgeable about process improvement and variation

reduction The primary layout of the handbook follows the ASQ Body of Knowledge BoK for the Certified Six Sigma Green Belt CSSGB updated in 2015 The authors were involved with the first edition handbook and have utilized first edition user comments numerous Six Sigma practitioners and their own personal knowledge gained through helping others prepare for exams to bring together a handbook that they hope will be very beneficial to anyone seeking to pass the ASQ or other Green Belt exams In addition to the primary text the authors have added a number of new appendixes an expanded acronym list new practice exam questions and other additional materials

Coloring of Plastics Robert A. Charvat, 2005-02-25 Expert coverage of the state of the art in plastics coloring This latest edition of Coloring of Plastics Fundamentals offers an updated introduction to color as a science while also providing the foundation for many additional technological subjects The basic families of colorants are described along with their properties The material examines how statistical analysis can improve the consistency of colored polymer production runs as well as the colorants used to match the color Other important topics covered in Coloring of Plastics Fundamentals Second Edition include Environmental issues and the reuse of discarded material Potential problems with the interaction between colorants and other additives Measurement information and matching visually and instrumentally Techniques for incorporating colorants into polymers as compounds or concentrates Special effect colorants Polymer and colorant manufacturers plastics compounders and coating and synthetic fiber industries will acquire an enhanced appreciation of the complex technological issues a colorist must consider if a plastics coloring project is to succeed

Short-Run SPC for Manufacturing and Quality Professionals William A. Levinson, 2022-09-07 On the manufacturing shop floor the principle of value comes from the production of parts rather than charts crucially applies when using practical statistical process control SPC The production worker should need to enter only a sample s measurements to get immediately actionable information as to whether corrective action e g as defined by a control plan s reaction plan is necessary for an out of control situation and should not have to perform any calculations draw control charts or use sophisticated statistical software This book s key benefit for readers consists of spreadsheet deployable solutions with all the mathematical precision of a vernier along with the simplicity of a stone ax Traditional SPC relies on the assumption that sufficient data are available with which to estimate the process parameters and set suitable control limits Many practical applications involve however short production runs for which no process history is available There are nonetheless tested and practical control methods such as PRE Control and short run SPC that use the product specifications to set appropriate limits PRE Control relies solely on the specification limits while short run SPC starts with the assumption that the process is capable that is at least a 4 sigma process and works from there to set control limits Cumulative Sum CUSUM and exponentially weighted moving average EWMA charts also can be used for this purpose Specialized charts can also track multiple part characteristics and parts with different specifications simultaneously This is often useful for example where the same tool is engaged in mixed model production Readers will be able to deploy practical and simple control charts for

production runs for which no prior history is available and control the processes until enough data accumulate to enable the traditional methods assuming it ever does They will be able to track multiple product features with different specifications and also control mixed model applications in which a tool generates very short runs of parts with different specifications The methods will not require software beyond readily available spreadsheets nor will they require specialized tables that are not widely available Process owners and quality engineers will be able to perform all supporting calculations in Microsoft Excel and without the need for advanced software

Implementing Six Sigma Forrest W. Breyfogle, III, 2003-11-10 Das bew hrte Handbuch zum Statistiktool Six Sigma jetzt in neuer aktualisierter Auflage besprochen werden t glich ben tigte Verfahren und deren Implementation erweiterte Behandlung u a des Benchmarkings mit vielen praxisnahen bungen enth lt Pl ne Checklisten und bersichten h ufig auftretender Fehler

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