

Update to the AIAG- SPC Reference Manual

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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)

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Andrew Sleeper

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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 **Statistical Engineering**

Stefan H. Steiner, R. Jock MacKay, 2005-01-02 Reducing the variation in process outputs is a key part of process improvement. For mass produced components and assemblies reducing variation can simultaneously reduce overall cost, improve function and increase customer satisfaction with the product. The authors have structured this book around an algorithm for reducing process variation that they call Statistical Engineering. The algorithm is designed to solve chronic problems on existing high to medium volume manufacturing and assembly processes. The fundamental basis for the algorithm is the belief that we will discover cost effective changes to the process that will reduce variation if we increase our knowledge of how and why a process behaves as it does. A key way to increase process knowledge is to learn empirically that is to learn by observation and experimentation. The authors discuss in detail a framework for planning and analyzing empirical investigations known by its acronym QPDAC: Question, Plan, Data, Analysis, Conclusion. They classify all effective ways to reduce variation into seven approaches. A unique aspect of the algorithm forces early consideration of the feasibility of each of the approaches. Also includes case studies, chapter exercises, chapter supplements and six appendices. PRAISE FOR Statistical Engineering: I found this book uniquely refreshing. Don't let the title fool you. The methods described in this book are statistically sound but require very little statistics. If you have ever wanted to solve a problem with statistical certainty without being a statistician then this book is for you. A reader in Dayton, OH. This is the most comprehensive treatment of variation reduction methods and insights I've ever seen. Gary M. Hazard, Tellabs. Throughout the text emphasis has been placed on teamwork, fixing the obvious before jumping to advanced studies and cost of implementation. All this makes the manuscript attractive for real life application of complex techniques. Guru Chadhabr, Comcast IP Services. COMMENTS FROM OTHER CUSTOMERS: Average Customer Rating: 5 of 5 based on 1 review. This is NOT a typical book on statistical tools. It is a strategy book on how to search for cost effective changes to reduce variation using empirical means, i.e. observation and experiment. The uniqueness of this book summarizes the seven ways to reduce variation so we know the goal of the data gathering and analysis, present analysis results using graphs instead of P value and integrates Taguchi, Shainin methods and classical statistical approach. It is a must read for those who are in the business of reducing variation using data, in particular for the Six Sigma Black Belts and Master Black Belts. Don't forget to read the solutions to exercises and supplementary materials to each chapter on the enclosed CD ROM. A Wong, Canada. *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

The ASQ Certified Quality Engineer Handbook Scott A. Laman, 2022-12-01 The ASQ Certified Quality Engineer Handbook Fifth Edition covers a wide range of topics in the quality engineering field and is organized to align with the 2022 ASQ Certified Quality Engineer CQE Body of Knowledge BoK This handbook is essential for candidates preparing for the ASQ CQE examination For working engineers it is a convenient and thorough guide to the profession In addition to providing detailed explanations of each section of the 2022 CQE BoK this current edition includes An explanation of cost benefit analysis CBA and the RACI matrix critical to quality as a design input hazard analysis and FMEA overall equipment effectiveness OEE 5 Whys analysis data automation and database integration and assessing risk in audit planning and implementation New chapter on risk management Appendices and a Glossary of Terms for reference purposes Content in this fifth edition has been restructured to provide tools and concepts that match the 2022 CQE BoK as well as improved textbook and journal article references throughout the entire book This handbook also provides case studies that give readers a broader context for real life scenarios and applications The ASQ CSSGB Study Guide Rodrick A. Munro, Daniel

Zrymiak, Elizabeth Rice-Munro, 2017-03-20 Practice questions and test to aid those studying to take the ASQ Certified Six Sigma Green Belt exam Six Sigma for Business Excellence: Approach, Tools and Applications Hemant Urdhwarshie, 2011 Six Sigma for Business Excellence Approach Tools and Applications based on the author's first hand experience in quality engineering provides a comprehensive coverage of the Six Sigma methodology This book provides the complete study material for students taking the certified Six Sigma Black Belt and Green Belt examinations conducted internationally by the American Society for Quality ASQ At the same time it adequately fills the need of management professionals with numerous application examples and case studies providing an insight into the practical aspect of implementing Six Sigma tools The book begins with providing an overview of the evolution of Six Sigma explains the basic concepts and then takes the readers step by step through the process The focus is more on enabling the implementation of the Six Sigma tools by providing illustrations tables application examples and templates as well as Minitab and Excel data files for project work and exercises in the soft form on a CD accompanying the book The templates carried in the book include the Sigma calculator Six Sigma project review checklist process mapping confidence intervals hypothesis tests project charter and measurement systems analysis Gauge R R Study The CD also contains a 30 day trial version of the Minitab and SigmaXL software programs

Vehicle and Automotive Engineering 3 Károly Jármai, Katalin Voith, 2020-10-19 This book presents the proceedings of the third Vehicle and Automotive Engineering conference reflecting the outcomes of theoretical and practical studies and outlining future development trends in a broad field of automotive research The conference's main themes included design manufacturing economic and educational topics *Design for Six Sigma Statistics, Chapter 6 - Measuring Process Capability* Andrew Sleeper, 2005-12-05 Here is a chapter from Design for Six Sigma Statistics written by a Six Sigma practitioner with more than two decades of DFSS experience who provides a detailed goal focused roadmap It shows you how to execute advanced mathematical procedures specifically aimed at implementing fine tuning or maximizing DFSS projects to yield optimal results For virtually every instance and situation you are shown how to select and use appropriate mathematical methods to meet the challenges of today's engineering design for quality **Six Sigma For Dummies** Craig Gygi, Bruce Williams, 2012-09-17 The fast and easy way to understand and implement Six Sigma The world's largest and most profitable companies including the likes of GE Bank of America Honeywell DuPont Samsung Starwood Hotels Bechtel and Motorola have used Six Sigma to achieve breathtaking improvements in business performance in everything from products to processes to complex systems and even in work environments Over the past decade over 100 billion in bottom line performance has been achieved through corporate Six Sigma programs Yet despite its astounding effectiveness few outside of the community of Six Sigma practitioners know what Six Sigma is all about With this book Six Sigma is revealed to everyone You might be in a company that's already implemented Six Sigma or your organization may be considering it You may be a student who wants to learn how it works or you might be a seasoned business professional who needs to get up to speed In any case this updated edition of Six Sigma For Dummies is the most straightforward non intimidating guide on the market New and updated material including real world examples What Six Sigma is all about and how it works The benefits of Six Sigma in organizations and businesses The powerful DMAIC problem solving roadmap Yellow Green and Black how the Six Sigma belt system works How to select and utilize the right tools and technologies Speaking the language of Six Sigma knowing the roles and responsibilities and mastering the statistics skills and analytical methods Six Sigma For Dummies will become everyone's No 1 resource for discovering and mastering the world's most famous and powerful improvement tool Stephen Covey is spot on when he says Six Sigma For Dummies is a book to be read by everyone **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

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