

Update to the AIAG- SPC Reference Manual

Michael Down

General Motors Corporation/SPC Rewrite Chairman

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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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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 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

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

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Minitab and SigmaXL software programs *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 **Statistical Process Control (SPC)** ,1995

Design for Six Sigma Statistics : 59 Tools for Diagnosing and Solving Problems in DFSS Initiatives Andrew Sleeper, 2005-12-05 In today's competitive environment companies can no longer produce goods and services that are merely good with low defect levels they have to be near perfect Design for Six Sigma Statistics is a rigorous mathematical roadmap to help companies reach this goal As the sixth book in the Six Sigma operations series this comprehensive book goes beyond an introduction to the statistical tools and methods found in most books but contains expert case studies equations and step by step MINTAB instruction for performing DFSS Design of Experiments Measuring Process Capability Statistical Tolerancing in DFSS and DFSS Techniques within the Supply Chain for Improved Results The aim is to help you better diagnosis and root out potential problems before your product or service is even launched *Randall's Practical Guide to ISO 9000* Richard C. Randall, 1995 Randall's Practical Guide to ISO 9000 offers well organized and easy to use coverage of how to understand register for and implement the new ISO 9000 Standard for certification **Tooling and Equipment Suppliers Quality Assurance Manual** ,1989 **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 **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 **Minitab Demystified** Andrew

Sleeper, 2011-08-10 Need to learn Minitab Problem Solved Get started using Minitab right way with help from this hands on guide Minitab Demystified walks you through essential Minitab features and shows you how to apply them to solve statistical analysis problems Featuring coverage of Minitab 16 this practical guide explores the Minitab interface and the full range of Minitab graphics Distribution models statistical intervals hypothesis testing and sample size calculations are clearly explained The book covers modeling tools of regression and the design of experiments DOE as well as the industrial quality tools of measurement systems analysis control charts capability analysis acceptance sampling and reliability analysis Detailed examples and concise explanations make it easy to understand the material and end of chapter quizzes and a final exam help reinforce key concepts It s a no brainer You ll learn about Accessing powerful Minitab functions with the Minitab assistant Confidence prediction and tolerance intervals Designing and analyzing experiments with hard to change variables Statistical process control SPC Six Sigma applications and quality control Predicting the economic impact of sampling Analyzing life data with additional variables Simple enough for a beginner challenging enough for an advanced student and thorough enough for a Six Sigma professional Minitab Demystified is your shortcut to statistical analysis success *CEP Software Directory* ,1999 *Annual Book of ASTM Standards* American Society for Testing and Materials, 2003 A compilation of all ASTM standards issued each year *Annual Book of ASTM Standards* ASTM International, American Society for Testing and Materials, 2003 **Conference Proceedings** Society of Plastics Engineers. Technical Conference, 1999 *SAS/QC Software* SAS Institute, 1995 The CAPABILITY procedure The CUSUM procedure The FACTEX procedure The ISHIKAWA procedure The MACONTROL procedure The OPTEC procedure The PARETO procedure The SHEWHART procedure **Quality Progress** ,1993

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