

# Q-1

## MSA – Gage R&R Study Example

APPRAISER/		PART										AVERAGE			
TRIAL #		1	2	3	4	5	6	7	8	9	10				
1. A	1	0.29	-0.90	1.34	0.47	-0.93	-0.92	0.99	-0.21	2.28	-1.38	0.194			
2	2	0.41	-0.88	1.17	0.50	-0.92	-0.11	0.79	-0.28	1.88	-1.28	0.198			
3	3	0.04	-0.38	1.27	0.04	-0.84	-0.21	0.88	-0.17	2.01	-1.31	0.201			
4	Avg	0.447	-0.907	1.286	0.607	-0.893	-0.105	0.887	-0.227	2.087	-1.307	$\bar{X}_p$	0.196		
5	R	0.38	0.12	0.17	0.17	0.12	0.23	0.18	0.14	0.27	0.11	$\bar{R}_p$	0.194		
6. B	1	0.08	-0.47	1.18	0.01	-0.98	-0.28	0.47	-0.88	1.88	-1.08	0.001			
7	2	0.28	-1.28	0.94	1.08	-1.28	0.22	0.88	0.88	2.12	-1.82	0.118			
8	3	0.07	-0.88	1.34	0.28	-1.28	0.08	0.83	-0.34	2.18	-1.88	0.089			
9	Avg	0.133	-0.798	1.187	0.413	-1.013	0.027	0.817	-0.287	2.037	-1.688	$\bar{X}_p$	0.088		
10	R	0.18	0.78	0.48	1.02	0.72	0.42	0.38	0.71	0.38	0.18	$\bar{R}_p$	0.613		
11. C	1	0.04	-1.38	0.88	0.14	-1.48	-0.28	0.82	-0.48	1.77	-1.48	-0.223			
12	2	-0.11	-1.13	1.08	-0.28	-1.87	-0.87	0.81	-0.88	1.48	-1.77	-0.288			
13	3	-0.18	-0.88	0.87	0.11	-1.48	-0.48	0.21	-0.48	1.87	-2.18	-0.284			
14	Avg	-0.073	-1.187	0.888	0.188	-1.327	-0.483	0.088	-0.903	1.887	-1.807	$\bar{X}_p$	-0.284		
15	R	0.18	0.42	0.42	0.08	0.38	0.38	0.28	0.18	0.42	0.67	$\bar{R}_p$	0.328		
16. PART												$\bar{X}_p$	0.001		
Avg ( $\bar{X}_p$ )		0.188	-0.881	1.088	0.387	-1.084	-0.188	0.484	-0.342	1.948	-1.371	$\bar{R}_p$	3.811		
17.	$\bar{R}_p = \bar{R}_p / (\# \text{ OF APPRAISERS}) =$											$\bar{R}_p$	0.342		
18.	$(\text{Max } \bar{R}_p - \text{Min } \bar{R}_p) =$											$\bar{R}_{p\text{max}}$	0.485		
19.	$R \times 5p =$	APPRAISER					B					OUT OF CONTROL		$\bar{R}_{p\text{max}}$	0.882
20.	$R \times 6p =$												$\bar{R}_{p\text{max}}$	0.905	

Measurement Unit Analysis				% Total Variation (TV)	
Repeatability - Equipment Variation (EV)				% EV	= 100 (EV/TV) = 100(0.202/1.148) = 17.61
EV = $R \times K_1$		Trials	K1		
= 0.342 x 0.5888		2	0.5888		
= 0.202		3	0.5888		
Reproducibility - Appraiser Variation (AV)				% AV	
AV = $(\bar{R}_{pmax} \times K_2)^2 - (EV^2/nc)^{1/2}$		Trials	K2		
= $(0.448 \times 0.5231)^2 - (0.202^2/2/18 \times 100)^{1/2}$					
= 0.238		2	2		
		$\bar{R}_p$	0.7871 0.5231		
Repeatability & Reproducibility (GRR)				% GRR	= 100 (GRR/TV) = 100(0.306/1.148) = 26.68  Gage system may be acceptable
GRR = $(EV^2 + AV^2)^{1/2}$		Parts	$\bar{R}_p$		
= $(0.202^2 + 0.238^2)^{1/2}$		2	0.7871		
= 0.306		3	0.5231		
		4	0.4487		
Part Variation (PV)				% PV	= 100 (PV/TV) = 100(1.188/5.008) = 96.38
PV = $R \times K_3$		5	0.4838		
= 3.811 x 0.3148		6	0.3742		
= 1.188		7	0.3524		
		8	0.3375		
Total Variation (TV)				npt	= 1.41(PV/GRR) = 1.41(1.188/0.306) = 5.00882 = 5
TV = $(GRR^2 + PV^2)^{1/2}$		9	0.3248		
= $(0.306^2 + 1.188^2)^{1/2}$		10	0.3148		
= 1.148					

The percent error is questionable and may be used under high level of scrutiny at 26.68%

# Msa Testing 2013 Study Guide

**Carmen Rodriguez-Blazquez, Maria  
João Forjaz, Mayela Rodríguez-Violante**

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