MSA – Gage R&R Study Example

APPRAISER/ TRIAL #		PART 1	2	3	4	5	6	7	8	9	10	AVERAGE
1. A	1	0.29	-0.56	1.34	0.47	-0.80	-0.02	0.59	-0.31	2.26	-1.36	0.194
2.	2	0.41	-0.85	1.17	0.50	-0.92	-0.11	0.75	-0.20	1.99	-1.25	0.155
3.	3	0.64	-0.58	1.27	0.64	-0.84	-0.21	0.86	-0.17	2.01	-1.31	0.211
4.	AVE	0.447	-0.607	1.260	0.537	-0.853	-0.100	0.067	-0.227	2.087	-1.307	$\bar{X}_A$= 0.186
5.	R	0.35	0.12	0.17	0.17	0.12	0.23	0.16	0.14	0.27	0.11	$\bar{R}_A$= 0.184
6. B	1	0.08	-0.47	1.19	0.01	-0.55	-0.20	0.47	-0.55	1.80	-1.68	0.001
7.	2	0.24	-1.28	0.94	1.03	-1.20	0.22	0.95	0.08	2.12	-1.82	0.115
8.	3	0.07	-0.88	1.34	0.30	-1.28	0.08	0.83	-0.34	2.19	-1.80	0.089
9.	AVE	0.133	-0.796	1.157	0.413	-1.010	0.027	0.617	-0.267	2.037	-1.600	$\bar{X}_B$= 0.068
10.	R	0.16	0.75	0.40	1.02	0.73	0.42	0.36	0.71	0.39	0.18	$\bar{R}_B$= 0.513
11. C	1	0.04	-1.38	0.88	0.14	-1.45	-0.29	0.02	-0.46	1.77	-1.48	-0.223
12.	2	-0.11	-1.13	1.09	0.20	-1.67	-0.67	0.01	-0.56	1.46	-1.77	-0.258
13.	3	-0.15	-0.96	0.67	0.11	-1.45	-0.49	0.21	-0.46	1.87	-2.16	-0.254
14.	AVE	-0.073	-1.157	0.880	0.150	-1.527	-0.483	0.080	-0.503	1.697	-1.807	$\bar{X}_C$= -0.254
15.	R	0.19	0.42	0.42	0.09	0.39	0.38	0.20	0.10	0.40	0.67	$\bar{R}_C$= 0.328
16. PART AVE ($\bar{X}_P$)		0.169	-0.851	1.099	0.367	-1.064	-0.195	0.404	-0.343	1.946	-1.571	$\bar{X}_{DIFF}$= 0.001 $\bar{R}_P$= 3.511
17.	$(\bar{R}_A + \bar{R}_B + \bar{R}_C) / (\#\text{ OF APPRAISERS})$ =											$\bar{R}_{DBAR}$= 0.342
18.	(Max $\bar{X}$ - Min $\bar{X}$) =											$\bar{X}_{DIFF}$= 0.445
19.	$\bar{R} \times D_4$ =	APPRAISER		8		OUT OF CONTROL						UCL$_R$= 0.862
20.	$\bar{R} \times D_3$ =											LCL$_R$= 0.000

Measurement Unit Analysis

Repeatability - Equipment Variation (EV)

EV = $\bar{R} \times K_1$

= 0.342 x 0.5908

= 0.202

Trials	K_1
2	0.8862
3	0.5908

Reproducibility - Appraiser Variation (AV)

$AV = [(X_{DIFF} \times K_2)^2 - (EV^2/nr)]^{1/2}$

= [(0.445 x 0.5231)^2 - (0.202^2/(10 x 3))]^1/2

= 0.230

n	r
2	3
0.7071	0.5231

n = number of parts

r = number of trials

Repeatability & Reproducibility (GRR)

$GRR = [EV^2 + AV^2]^{1/2}$

= [(0.202)^2 + 0.230^2]^1/2

= 0.306

Parts	K_3
2	0.7071
3	0.5231
4	0.4467
5	0.4030
6	0.3742
7	0.3534
8	0.3375
9	0.3249
10	0.3146

Part Variation (PV)

PV = $R \times K_3$

= 3.511 x 0.3146

= 1.105

Total Variation (TV)

$TV = [(GRR)^2 + PV^2]^{1/2}$

= [(0.306)^2 + 1.105^2]^1/2

= 1.146

% Total Variation (TV)

%EV = 100 (EV/TV)

= 100(0.202/1.146)

= 17.61

%AV = 100 (AV/TV)

= 100(0.230/1.146)

= 20.04

%GRR = 100 (GRR/TV)

= 100(0.306/1.146)

= 26.68

Gage system may be acceptable

%PV = 100 (PV/TV)

= 100(1.105/1.000)

= 96.38

ndc = 1.41(PV/GRR)

= 1.41(1.105/0.306)

= 5.093892 ~ 5

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

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Msa Testing 2013 Study Guide

Marco Cascella

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