

Q-1

MSA – Gage R&R Study Example

APPRAISER/ TRIAL #	PART										AVERAGE
	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	-0.98	1.27	0.04	-0.84	-0.21	0.88	-0.17	2.01	-1.31	0.201
4. AVE	0.447	-0.907	1.266	0.667	-0.893	-0.105	0.887	-0.227	2.087	-1.307	$\bar{X}_p$ 0.190
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	-1.82	0.089
9. AVE	0.133	-0.786	1.187	0.413	-1.013	0.027	0.817	-0.287	2.037	-1.000	$\bar{X}_p$ 0.008
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. AVE	-0.073	-1.187	0.883	0.183	-1.327	-0.483	0.683	-0.903	1.687	-1.607	$\bar{X}_p$ -0.284
15. R	0.18	0.42	0.42	0.08	0.38	0.38	0.28	0.18	0.42	0.87	$\bar{R}_p$ 0.328
16. PART AVE ($\bar{X}_p$)	0.188	-0.881	1.088	0.387	-1.084	-0.188	0.484	-0.342	1.348	-1.201	$\bar{X}_p$ 0.001
											$\bar{R}_p$ 3.811
17. $\bar{R}_p = \bar{R}_p = \bar{R}_p / \# \text{ OF APPRAISERS} =$											$\bar{R}_p$ 0.342
18. $(\text{Max } \bar{R}_p - \text{Min } \bar{R}_p) =$											$\bar{R}_{p\text{max}}$ 0.448
19. $R \times 5\sigma =$	APPRAISER B OUT OF CONTROL										UCL_R 0.882
20. $R \times 6\sigma =$											UCL_R 0.908

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		
= 0.342×0.5808					
= 0.200		2	0.5808		
		3	0.5808		
Reproducibility - Appraiser Variation (AV)				% AV	= 100 (AV/TV) = 100(0.238/1.148) = 20.64
AV = $(\bar{R}_{p\max} \times K_2)^2 - (EV^2 \times K_3)^{1/2}$		Trials	K2		
= $(0.448 \times 0.5231)^2 - (0.202^2 \times 2 \times 1.148)^{1/2}$					
= 0.238		2	2		
		$\bar{R}_p$	0.7871		
Repeatability & Reproducibility (GRR)				% GRR	= 100 (GRR/TV) = 100(0.308/1.148) = 26.68 Gage system may be acceptable
GRR = $(EV^2 + AV^2)^{1/2}$		Parts	K3		
= $(0.202^2 + 0.238^2)^{1/2}$					
= 0.308		2	0.7871		
		3	0.5231		
Part Variation (PV)				% PV	= 100 (PV/TV) = 100(1.105/6.000) = 96.38
PV = $R \times K_3$		Parts	K3		
= 3.811×0.3148					
= 1.198		4	0.4487		
		5	0.4838		
		6	0.3742		
		7	0.3524		
Total Variation (TV)				npt	= 1.41(PV/GRR) = 1.41(1.105/0.308) = 5.08082 = 5
TV = $(GRR^2 + PV^2)^{1/2}$		Parts	K3		
= $(0.308^2 + 1.105^2)^{1/2}$					
= 1.148		8	0.3375		
		9	0.3248		
		10	0.3148		

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

Msa Testing 2013 Study Guide

S Ben Porath



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