

MSA – Gage R&R Study Example

APPRAISER/ TRIAL #	PART										AVERAGE	Measurement Unit Analysis			% Total Variation (TV)				
	1	2	3	4	5	6	7	8	9	10									
1. A	1	0.29	-0.90	1.34	0.47	-0.93	-0.02	0.59	-0.21	2.28	-1.38	0.194	EV = $R \times K_1$ = 0.342×0.5808 = 0.200	Trials	K1	% EV = 100 (EV/TV) = 100(0.202/1.148) = 17.81			
2	2	0.41	-0.88	1.17	0.50	-0.92	-0.11	0.79	-0.28	1.88	-1.28	0.198					2	0.5808	= 100(0.202/1.148)
3	3	0.04	-0.98	1.27	0.04	-0.84	-0.21	0.88	-0.17	2.01	-1.31	0.201					3	0.5808	
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	Reproducibility - Appraiser Variation (AV) AV = $(\bar{R}_{p\text{max}} \times K_2)^2 - (EV^2 \times \text{trials})^{1/2}$ = $(0.448 \times 0.5231)^2 - (0.202^2 \times 3)^{1/2}$ = 0.238			trials	K2	% AV = 100 (AV/TV) = 100(0.238/1.148) = 20.64	
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	2	0.5231	n = number of parts r = number of trials				
6. B	1	0.08	-0.47	1.18	0.01	-0.58	-0.28	0.47	-0.53	1.88	-1.08	0.001	3	0.5231					
7	2	0.28	-1.28	0.94	1.08	-1.28	0.22	0.58	0.08	2.12	-1.82	0.118	Repeatability & Reproducibility (GRR) GRR = $(EV^2 + AV^2)^{1/2}$ = $(0.202^2 + 0.238^2)^{1/2}$ = 0.308			Parts	K3	% GRR = 100 (GRR/TV) = 100(0.308/1.148) = 26.68	
8	3	0.07	-0.88	1.34	0.28	-1.28	0.08	0.83	-0.34	2.18	-1.88	0.089	2	0.7871	Gage system may be acceptable				
9	Avg	0.133	-0.793	1.187	0.413	-1.013	0.227	0.817	-0.287	2.037	-1.603	\bar{X}_p 0.088	3	0.5231					
10	R	0.18	0.78	0.40	1.02	0.72	0.42	0.38	0.71	0.38	0.18	\bar{R}_p 0.613	Part Variation (PV) PV = $R \times K_3$ = 3.011×0.3148 = 1.125			4	0.4487	% PV = 100 (PV/TV) = 100(1.125/0.600) = 96.38	
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	5	0.4838					
12	2	-0.11	-1.13	1.08	-0.28	-1.07	-0.87	0.01	-0.98	1.48	-1.77	-0.288	6	0.3742					
13	3	-0.18	-0.98	0.87	0.11	-1.48	-0.48	0.21	-0.48	1.87	-2.18	-0.284	Total Variation (TV) TV = $(GRR^2 + PV^2)^{1/2}$ = $(0.308^2 + 1.185^2)^{1/2}$ = 1.148			7	0.3524	not	% = 1.41(PV/GRR) = 1.41(1.125/0.308) = 5.08082 - 5
14	Avg	-0.073	-1.197	0.983	0.183	-1.327	-0.483	0.083	-0.823	1.887	-1.807	\bar{X}_p -0.284	8	0.3375					
15	R	0.18	0.42	0.42	0.08	0.38	0.38	0.28	0.18	0.42	0.07	\bar{R}_p 0.328	9	0.3248					
16. PART AVE (\bar{X}_p)		0.188	-0.881	1.088	0.387	-1.084	-0.188	0.484	-0.342	1.948	-1.371	\bar{X}_p 0.001 \bar{R}_p 3.011				10	0.3148		
17.	$\bar{R}_p = \bar{R}_p / (\# \text{ OF APPRAISERS}) =$										\bar{R}_p 0.302								
18.	$(\text{Max } \bar{R}_p - \text{Min } \bar{R}_p) =$										$\bar{R}_{p\text{max}}$ 0.405								
19.	$R \times 50\% =$ APPRAISER B OUT OF CONTROL										$\bar{R}_{p\text{max}}$ 0.882								
20.	$R \times 60\% =$										$\bar{R}_{p\text{max}}$ 0.905								

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

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