

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	-0.31	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	-0.887	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	-0.923	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.	$\bar{R}_p = \bar{R}_p = \bar{R}_p / (\# \text{ OF APPRAISERS}) =$										\bar{R}_p 0.382	
18.	$(\text{Max } \bar{R}_p - \text{Min } \bar{R}_p) =$										$\bar{R}_{p\text{max}}$ 0.485	
19.	$R_p \times 50\% =$ APPRAISER B OUT OF CONTROL										$\bar{R}_{p\text{max}}$ 0.882	
20.	$R_p \times 6\% =$										$\bar{R}_{p\text{max}}$ 0.005	

Measurement Unit Analysis				% Total Variation (TV)		
Repeatability - Equipment Variation (EV)				% EV	= 100 (EV/TV)	
EV = $R \times K_1$		Trials	K1			
= 0.342×0.5888						
= 0.202		2	0.5888	= 100(0.202/1.148)		
		3	0.5888	= 17.61		
Reproducibility - Appraiser Variation (AV)				% AV	= 100 (AV/TV)	
AV = $(\bar{R}_{p\text{max}} \times K_2)^2 - (EV^2 \times \text{trials})^{1/2}$		trials	K2			
= $(0.448 \times 0.5231)^2 - (0.202^2 \times 3)^{1/2}$						
= 0.238		2	0.5231	= 100(0.238/1.148)		
		3	0.5231	= 20.64		
Repeatability & Reproducibility (GRR)				% GRR	= 100 (GRR/TV)	
GRR = $(EV^2 + AV^2)^{1/2}$		Parts	K3			
= $(0.202^2 + 0.238^2)^{1/2}$						
= 0.308		2	0.7871	= 100(0.308/1.148)		
		3	0.5231	= 26.68		
		Gage system may be acceptable				
Part Variation (PV)				% PV	= 100 (PV/TV)	
PV = $R \times K_3$		4	0.4487			
= 3.811×0.3148		5	0.4838			
= 1.195		6	0.3742	= 100(1.195/0.000)		
		7	0.3824			
		8	0.3375	not	= 1.41(PV/GRR)	
		9	0.3248			
		10	0.3148			
Total Variation (TV)						
TV = $(GRR^2 + PV^2)^{1/2}$						
= $(0.308^2 + 1.185^2)^{1/2}$						
= 1.148						

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

Msa Testing 2013 Study Guide

J Spring



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web we prefer to use original type wiring diagrams most electronic looms are nothing more than a standard loom with one wire taken out and a new terminal fitted to the green using this type of loom does mean that fitted and h t coil refer to the lambretta manual if necessary for this procedure 2 secure stator into mag flange as normal

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web it is designed in such a way that you don't need a junction box it just connects to your electronic regulator coil and your rear light stop switch horn and headset junction box a much simpler method of wiring your scooter the loom comes complete with a wiring diagram grey color

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web section one li 125 150 s1 s2 s3 and many servetas the following diagram may not represent your machines bulb holder for instance series 1 and 2 li models have a separate junction box and bulb holder where as series 3 lambrettas bulb

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