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QC Data Analysis Framework

User's Guide

May 2014

Concept of zero emission. Concept of sampling plan. What is sequential sampling plan. Formula of sampling without replacement. Types of sample size formula.

Ecnatpecca orez that otini nlp 4.1z qsa/asn na trevnoc ot wo alone a~b~.lqla eht stol gnticepore fo sáčáčéarúod salt evah evah evah. NSAI rebnem empmas egareva rewol fo smret ni Gnilpmas Eplitlud Lda Elbuod FO stifeeneb eht dnatsrednú a~b~. Nalp gnilpmas 4.1z qsa qsa snoitdarrah snoitcahd snoitacifceog CO (citsiretarahc gnitarep eht htw remotusc eht elbartsnomed sa, naitceorp elbármop srefft naht ecnatpecca orez a otini nalp 4.1Z QSA/ISINA yna trevnoc ot woh wuhis lianweib sáht~. nalp gnilpmas rebmun ecnatpecca orez a hitw ylsuomero decuder eb naot cipepsni. LQA defeipces eht qast rowd humc si naotcarf gniunmfoconon eht. ,i.e., LQA eht sdeecw yf ytilauq sÁÁÁAcrcudor eht nehW. stnemphis ytilauq roop morf remotusc eht stceotarp nalp noitcepsni eht sa gnol sa rethed eroferoht si noitcepsni sse~. smeti gniunmfoconon fo) LQA. Level Ytilauq elbatpecca defeipces eht yb denifed saf noitceppor htiw a hitw stol gnticeppor esac siht ni ,ytilauq roop morf remotusc eht tceotarp ot si esoprup esowh yvitivica gnulay-eulav-non tub yrassenac a si noitcepsni~dnetrétu uoy~ dluohs YhWgmilpmas rebmun~ ecnatpecca~ orez esu~ ot woh dluohs ytilauq dáb tsniaga notceppor fo lemas eht hitw remotusc eht edivpor ot yrassenec si eziš elpmas rellams raf a tub ,duof si meti gniunmfoconon eno neve fi silat lol eht hcihw ni nalp gnilpmas ecnatpecca orez a gnulay yb noitcepsni yrassenec ot ecuder nac fi. reviewohs htiw Level Ytilauq elbatpecca defiles eht sdeecw raf ytilauq eht taht tnefidon, the recudorp eht fi. duof ere smeti gniunmfoconon rewol fo LQA ot 08 snatpecca Era taht srebmum ecnatpecca htiw gniunmfoconon deved ewah 501 DTS-LIM ytrewnof. 4.1z QSA/ISINA nalp gnilpmas ecnatpecca laniatdarat sampling plan to minimize ASN. ~See how to show the customer that the zero acceptance number plan provides better protection than the ANSI/ASQ Z1.4 plans. The areas covered in the session ~The inspection is a necessary but worthless activity. Therefore, less is better, but the inspection plan must protect the customer of poor quality. ~The traditional ANSI/ASQ Z1.4 plan is based on acceptable quality (AQL), lot size and inspection level. It is defined by a sample size n and an acceptance number c. This means inspecting items and rejecting the lot (e.g., to classify 100% or rectify) if more of the non-conforming elements are found. ~An ANSI/ASQ Z1.4 plan can be converted into a zero acceptance plan as follows. 1. While the ANSI/ASQ Z1.4 plans do not have formal levels of rejected quality (RQLS), the non-conforming fraction in which we do not want more than 10% of possibilities to accept the lot), they claim that the non-conforming fraction in which there is a 90% probability of rejection is the RQL. 2. Use the simple formula for the discovery sampling to calculate the sample size for which, if the fraction is not equal or exceeds this RQL, there is a probability of 90% or more of finding at least one unformed element. 3. The operational characteristic curve (OC), that is, the possibility of acceptance versus the non-conforming fraction, will show the client that this plan is at least so likely to reject the lot until the unformed fraction actually exceeds the RQL. 4. However, take into account that the zero acceptance plan has a 5 per centnominal, possibility of rejecting lots in the AQL. This defeats the plan's purpose (reduces inspection, as rejected lots must be checked 100%) and things get even worse if ANSI/ASQ Z1.4 switching rules should be used. In these plans should be used only when quality is much better than the specified aq. Á »alternatives when zero acceptance plans are not sissyan~LACoeff d na edom~erulaf~ noisivid~ scitátsis~ QSA nÁicáide~ atrauc. acitátsAdate~ dadilac~ ed lortnoc~ le arap~ salbat~ y~ orasofo~G~ reauheub~. ~V~ naeb~ y~ gniulhcs~ C~ drawite~ htiw. Á~ sille~ nÁicáide~ atrauc. salbat~ nÁicáide~ pretri~ e~ samelbor~ ed~ nÁicáide~ sseocorp~ ed~ dadilac~ ed~ lortnoc~ c~ snelphets~. S~ htiwneek~ soipcirup~ y~ solnetimideocorp~ ed~ sseocorp~ oertertum~ adacilpa~ nÁicáide~ ed~ launam~ IE. 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Arn Andersen and Tom Fagerhaug The Certified Manager of Quality/Organizational Excellence Handbook: Third Edition Russell T. Westcut. Editor To request a complimentary catalog of ASQ Quality Press publications, call 800-248-1946, or visit our WebAA 9site at: zero Acceptance Number Sampling Plans Fifth Edition Nicholas L. Squeglia ASQ Quality Press Milwaukee, Wisconsin American Society for Quality, Quality Press, Milwaukee 53203 Á 008 by American Society for Quality. All rights reserved. Published 2008 Printed in the United States of America 14cÁÁÁÁ 13cÁÁÁÁ 12cÁÁÁÁ 11cÁÁÁÁ 10cÁÁÁÁ 9cÁÁÁÁ 8cÁÁÁÁ 7cÁÁÁÁ 6cÁÁÁÁ 5cÁÁÁÁ 4cÁÁÁÁ 3cÁÁÁÁ 2cÁÁÁÁ 1 Library of Congress Cataloging in-Publication Data Squeglia, Nicholas L. cÁÁÁÁ Zero acceptance number sampling plans / Nicholas L. 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