4 Gauge R&R

0.1929 Historical Process Sigma

| Measurement | | Variation (6*StdDev) | % of Tolerance | % Process | | which is 6*sgrt of |
|--------------------------|--------|-------------------------|-------------------|---------------|-----------------------|--|
| Operator*part# | (IV) | 0.4480823 | 89.62 | 38.71 | Interaction Variation | V(Operator*part#) |
| Repeatability | (EV) | 0.3860052 | 77.20 | 33,35 | Equipment Variation | V(Within) |
| Reproducibility | (AV) | 0.4568005 | 9136 | 39.47 | Appraiser Variation | V(Operator) + V(Operator*part#) |
| Gauge R&R | (RR) | 0.5980524 | 119.61 | 51.67 | Measurement Variation | V(Within) + V(Operator) + V(Operator*part#) |
| Part Variation | (PV) | 1.0425929 | 208.52 | 90.08 | Part Variation | V(part#) |
| Total Variation | (TV) | 1.2019429 | 240.39 | 103.85 | Total Variation | V(Within) + V(Operator) + V(Operator*part#) + V(part#) |
| -Summary and | Gaug | e R&R Statistic | 5 | | | |
| 6 k | | | | | | |
| | 100 | R&R = 100*(R | | | | |
| 0.57362 Prec | ision | to Part Variatio | n = RR/PV | | | |
| 2 Nun | iber o | of Distinct Cate | gories = Flor | or(sqrt(2)*(P | V/RRJ) | |
| 0.5 Lower Tolerance (LT) | | | | | | |
| 1 Upp | er Tol | erance (UT) | | | | |
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