

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	-0.96	1.34	0.47	-0.90	0.62	0.59	-0.21	2.28	-1.35	0.194
2.	2	0.41	-0.88	1.17	0.50	-0.92	-0.11	0.75	-0.28	1.99	-1.29	0.199
3.	3	0.04	-0.98	1.27	0.04	-0.84	-0.21	0.66	-0.17	2.01	-1.21	0.201
4.	AVE	0.447	-0.607	1.266	0.507	-0.853	-0.105	0.667	-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	1.19	0.21	-0.55	-0.25	-0.47	-0.63	1.30	-1.08	0.001
7.	2	0.25	-1.22	0.94	1.03	-1.25	0.22	0.55	0.58	2.12	-1.62	0.115
8.	3	0.07	-0.88	1.34	0.25	-1.28	0.06	0.83	-0.34	2.19	-1.50	0.089
9.	AVE	0.133	-0.716	1.157	0.493	-1.013	0.027	0.177	-0.287	2.037	-1.000	\bar{X}_p 0.098
10.	R	0.18	0.75	0.40	1.02	0.73	0.42	0.36	0.71	0.39	0.18	\bar{R}_p 0.613
11. C	1	0.04	-1.38	0.88	0.14	-1.45	-0.28	0.82	-0.46	1.77	-1.49	-0.223
12.	2	-0.11	-1.13	1.09	0.28	-1.07	-0.87	0.81	-0.98	1.46	-1.77	-0.258
13.	3	-0.15	-0.95	0.87	0.11	-1.45	-0.48	0.21	-0.46	1.87	-2.15	-0.284
14.	AVE	-0.073	-1.157	0.930	0.156	-1.327	-0.483	0.080	-0.603	1.697	-1.607	\bar{X}_p -0.254
15.	R	0.19	0.42	0.42	0.08	0.39	0.38	0.20	0.15	0.42	0.67	\bar{R}_p 0.328
16. PART												\bar{X}_p 0.001
	AVE (\bar{X}_p)	0.188	-0.651	1.098	0.287	-1.054	-0.185	0.454	-0.342	1.948	-1.271	\bar{R}_p 3.511
17.	$(\bar{X}_p - \bar{X}_p) / (\# \text{ OF APPRAISERS}) =$											R_p 0.342
18.	$(\text{Max } \bar{X}_p - \text{Min } \bar{X}_p) =$											R_{app} 0.465
19.	$R \times G_r =$	APPRAISER					B	OUT OF CONTROL			\bar{X}_{CLR} 0.862	
20.	$R \times G_r =$											\bar{X}_{CLR} 0.600

Measurement Unit Analysis				% Total Variation (TV)	
Repeatability - Equipment Variation (EV)					
EV =	$R \times K_1$	Trials	K1	% EV =	100 (EV/TV)
=	0.342×0.5968	2	0.6982	=	100(0.202/1.148)
=	0.202	3	0.5968	=	17.61
Repeatability - Appraiser Variation (AV)					
AV =	$(\text{Max } \bar{X}_p - \text{Min } \bar{X}_p) / \sqrt{2}$			% AV =	100 (AV/TV)
=	$(0.445 - 0.103) / \sqrt{2}$			=	100(0.240/1.148)
=	0.239	\bar{X}_p	2	=	20.04
Repeatability & Reproducibility (GRR)					
GRR =	$(EV^2 + AV^2)^{1/2}$	Parts	K2	% GRR =	100 (GRR/TV)
=	$(0.202^2 + 0.239^2)^{1/2}$	2	0.7071	=	100(0.309/1.148)
=	0.309	3	0.5231	=	26.88
Part Variation (PV)					
PV =	$R \times K_3$			% PV =	100 (PV/TV)
=	3.511×0.3148	4	0.4487	=	100(1.105/0.900)
=	1.105	5	0.4030	=	96.38
Total Variation (TV)					
TV =	$(GRR^2 + PV^2)^{1/2}$	6	0.3575	ndc =	1.41 (PV/GRR)
=	$(0.309^2 + 1.105^2)^{1/2}$	8	0.3248	=	1.41(1.105/0.800)
=	1.148	10	0.3148	=	5.09880 - 5

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

Msa Testing 2013 Study Guide

Didier Musso



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Table of Contents Msa Testing 2013 Study Guide

1. Understanding the eBook Msa Testing 2013 Study Guide
 - The Rise of Digital Reading Msa Testing 2013 Study Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Msa Testing 2013 Study Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Msa Testing 2013 Study Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Msa Testing 2013 Study Guide
 - Personalized Recommendations
 - Msa Testing 2013 Study Guide User Reviews and Ratings
 - Msa Testing 2013 Study Guide and Bestseller Lists
5. Accessing Msa Testing 2013 Study Guide Free and Paid eBooks

- Msa Testing 2013 Study Guide Public Domain eBooks
 - Msa Testing 2013 Study Guide eBook Subscription Services
 - Msa Testing 2013 Study Guide Budget-Friendly Options
6. Navigating Msa Testing 2013 Study Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Msa Testing 2013 Study Guide Compatibility with Devices
 - Msa Testing 2013 Study Guide Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Msa Testing 2013 Study Guide
 - Highlighting and Note-Taking Msa Testing 2013 Study Guide
 - Interactive Elements Msa Testing 2013 Study Guide
 8. Staying Engaged with Msa Testing 2013 Study Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Msa Testing 2013 Study Guide
 9. Balancing eBooks and Physical Books Msa Testing 2013 Study Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Msa Testing 2013 Study Guide
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Msa Testing 2013 Study Guide
 - Setting Reading Goals Msa Testing 2013 Study Guide
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Msa Testing 2013 Study Guide
 - Fact-Checking eBook Content of Msa Testing 2013 Study Guide
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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