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If the reader chooses to increase the coverage level, or spread, of the total measurement variation to 99.73%, use 6.0 as a multiplier in place of 5.15 in the calculations. Note: The approach used in the 4th Edition is to compare standard deviations.

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It says on page 78 of AIAG's Measurement Systems Analysis, 4th Edition that "every effort should be

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made to improve the measurement system” when it is unacceptable. There does not appear to be any rationale in using the values of 10% and 30% as the criteria.

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Linearity, Stability) (Q053) Objective (s):
- To understand and to have guidelines
on creating measurement evaluation
system according to standard
requirement

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Analysis (MSA) Use MSA to evaluate your measurement system - NOT your parts.

... You will want most of the variation to be between the parts, and less than 10% to be caused by the measurement system (appraisers and equipment.) ...

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measurement systems within your own working area. ...

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the variation into specific sources -Gage Repeatability and Reproducibility (R&R) is a subset of MSA •Provides estimate of "measurement

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intended to limit evolution of analysis methods suited to particular processes or commodities.

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Variable Measurement System Study -
Guidelines MSA (Measurement Systems
Analysis) 4th Edition Errata Sheet.
Analysis of Results - Numerical . 5)
Compute the average bias of the n
readings. $\bar{1} n i i \text{ bias avg bias } n = = \sum 6)$
Compute the repeatability standard
deviation (see also Gage Study, Range

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Method, below): $2 \sqrt{\frac{1}{n} \sum_{i=1}^n r_i^2}$ repeatability
 $r. X X n. \sigma \sigma = - == - \sum$ If a

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established set of terms to refer to the common statistical properties and related elements of the measurement system.

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