

Gauge R&R

Measurement		Variation (6*StdDev)	% of Tolerance	% Process		which is 6*sqrt of
Operator*part#	(IV)	0.4480823	89.62	38.71	Interaction Variation	$V(\text{Operator}*\text{part\#})$
Repeatability	(EV)	0.3860052	77.20	33.35	Equipment Variation	$V(\text{Within})$
Reproducibility	(AV)	0.4568005	91.36	39.47	Appraiser Variation	$V(\text{Operator}) + V(\text{Operator}*\text{part\#})$
Gauge R&R	(RR)	0.5980524	119.61	51.67	Measurement Variation	$V(\text{Within}) + V(\text{Operator}) + V(\text{Operator}*\text{part\#})$
Part Variation	(PV)	1.0425929	208.52	90.08	Part Variation	$V(\text{part\#})$
Total Variation	(TV)	1.2019429	240.39	103.85	Total Variation	$V(\text{Within}) + V(\text{Operator}) + V(\text{Operator}*\text{part\#}) + V(\text{part\#})$

Summary and Gauge R&R Statistics

6 k

49.7571 % Gauge R&R = $100*(RR/TV)$

0.57362 Precision to Part Variation = RR/PV

2 Number of Distinct Categories = $\text{Floor}(\text{sqrt}(2)*(PV/RR))$

0.5 Lower Tolerance (LT)

1 Upper Tolerance (UT)

0.5 Tolerance = $UT-LT$

1.1961 Precision/Tolerance Ratio = $RR/(UT-LT)$

0.1929 Historical Process Sigma

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S Baum



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