



## Effect of Parameters on the **Cost of Memory Type Chart**

**You Huay Woon** 

#### **You Huay Woon**

Pusat GENIUS@Pintar Negara, Universiti Kebangsaan Malaysia, 43600 UKM Bangi, Selangor, Malaysia

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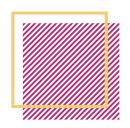




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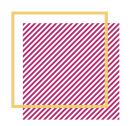
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  CHART
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## Introduction



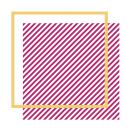
- The control chart was developed by Shewhart in 1924 and it is useful for monitoring and detecting process mean shifts.
- Since then, control charts are used in industries for process monitoring and improvement.



## Introduction



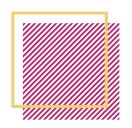
- The Shewhart chart is effective for detecting large process mean shifts.
- It is insensitive towards small and moderate shifts.
- The memory-type control chart, i.e. EWMA chart was introduced to enhance the sensitivity of the Shewhart chart.



## Introduction



- The cost of implementing the control chart will influence the decision on the choice of a control chart.
- Impact of the input parameters on the expected cost of implementing the EWMA control chart will be studied.



## Objectives



- 1. To propose the sensitivity analysis of the EWMA control chart.
- 2. To investigate the impact of the input parameters on the expected cost of implementing the EWMA control chart.



## Exponentially Weighted Moving 201 Average (EWMA) Chart



The EWMA statistic is given as

$$Z_u = \lambda Y_u + (1 - \lambda) Z_{u-1}$$
, for  $u = 1, 2, ...,$ 

where  $\lambda$  is a smoothing constant with  $0 < \lambda \le 1$  and  $Y_u$  is

$$Y_u = \frac{\overline{X}_u - \mu_0}{\sigma_0 / \sqrt{n}}$$
.

- $\mu_0$  and  $\sigma_0$  are the in-control process mean and in-control process standard deviation, respectively, and are assumed known.
- $\overline{X}_u$  is the mean of the  $u^{th}$  sample and n is the sample size.



# Exponentially Weighted Moving 2011 Average (EWMA) Chart



• The lower control limit (LCL) and upper control limit (UCL) of the EWMA chart are defined as

$$LCL = -J\sqrt{\frac{\lambda}{2-\lambda}}$$

and

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$$UCL = J\sqrt{\frac{\lambda}{2 - \lambda}}$$

with J > 0 is the width constant.

- An out-of-control is issued when a point plots above the UCL or below the LCL.
- Commonly used to detect small shifts in the process.



## **Economic Model of the EWMA Chart**



- The optimal charting parameters are obtained based on minimizing the expected cost function.
- The implementing cost of the EWMA control chart is calculated based on the cost function.



## Sensitivity Analysis of the EWMA20 Chart



- •It is crucial to identify the input parameter that has an impact on the cost of implementing the EWMA chart.
- •14 input parameters have been identified.



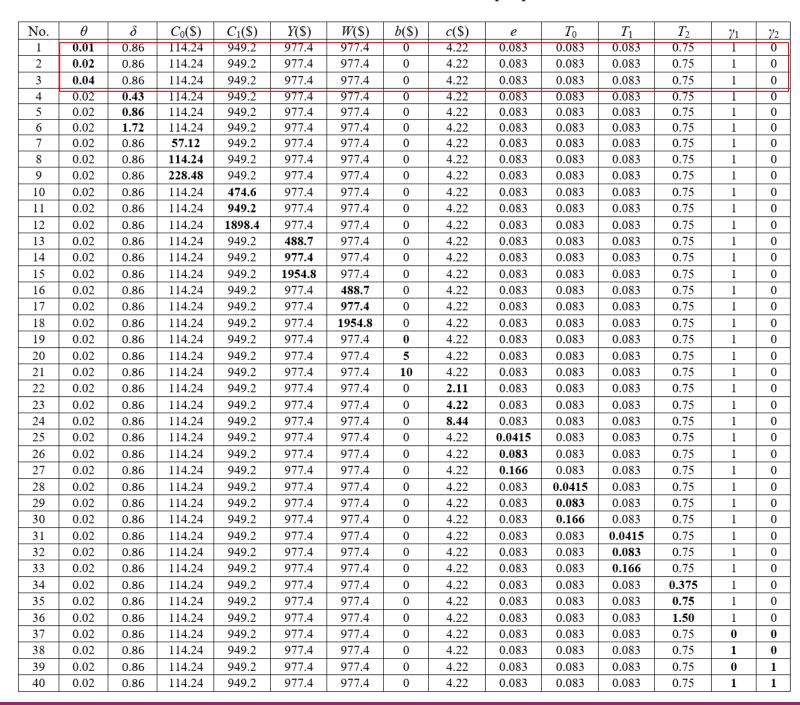
Table 1: Different combinations of the input parameters.

No.			_					4 (+)	(+)	1				T	
2	No.	$\theta$	δ	$C_0(\$)$	$C_1(\$)$	<i>Y</i> (\$)	W(\$)	<i>b</i> (\$)	c(\$)		$T_0$	$T_1$	$T_2$		
3	_														
4															
S														1	_
6         0.02         1.72         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           8         0.02         0.86         57.12         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           9         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.075         1         0           10         0.02         0.86         114.24         474.6         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           11         0.02         0.86         114.24         494.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           12         0.02         0.86         114.24         494.2         488.7         977.4         0         4.22         0.083         0.083         0.75         1         0           13         0.02															_
To   Column   To   Column															
8         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.075         1         0           9         0.02         0.86         228.48         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           10         0.02         0.86         114.24         474.6         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           11         0.02         0.86         114.24         4949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           13         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           15         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0															
9         0.02         0.86         228.48         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           10         0.02         0.86         114.24         474.6         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           11         0.02         0.86         114.24         494.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           12         0.02         0.86         114.24         494.2         477.4         977.4         0         4.22         0.083         0.083         0.75         1         0           13         0.02         0.86         114.24         949.2         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           15         0.02         0.86         114.24         949.2         977.4         0         4.22         0.083         0.083         0.75         1         0           16         0.02         0.86         114.24 <t< td=""><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></t<>															
10															
11															
12															
13															
14         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           15         0.02         0.86         114.24         949.2         1954.8         977.4         0         4.22         0.083         0.083         0.075         1         0           16         0.02         0.86         114.24         949.2         977.4         488.7         0         4.22         0.083         0.083         0.075         1         0           17         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           18         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           20         0.02         0.86         114.24         949.2         977.4         977.4         5         4.22         0.083         0.083         0.083         0.75         1         0           21															
15															-
16         0.02         0.86         114.24         949.2         977.4         488.7         0         4.22         0.083         0.083         0.75         1         0           17         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           18         0.02         0.86         114.24         949.2         977.4         1954.8         0         4.22         0.083         0.083         0.75         1         0           19         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           20         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.75         1         0           21         0.02         0.86         114.24         949.2         977.4         977.4         0         2.11         0.083         0.083         0.083         0.75         1         0           23         0.02         0.86			0.86							0.083				1	_
17         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           18         0.02         0.86         114.24         949.2         977.4         1954.8         0         4.22         0.083         0.083         0.075         1         0           19         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           20         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.083         0.75         1         0           21         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.083         0.75         1         0           22         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0														1	
18         0.02         0.86         114.24         949.2         977.4         1954.8         0         4.22         0.083         0.083         0.75         1         0           19         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           20         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.75         1         0           21         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.75         1         0           22         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           23         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           25         0.02         0.86			0.86					0						1	0
19         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           20         0.02         0.86         114.24         949.2         977.4         977.4         5         4.22         0.083         0.083         0.083         0.75         1         0           21         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.083         0.75         1         0           22         0.02         0.86         114.24         949.2         977.4         977.4         0         2.11         0.083         0.083         0.083         0.75         1         0           23         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.0415         0.083         0.083         0.75         1         0	17	0.02	0.86	114.24	949.2		977.4	0		0.083	0.083	0.083		1	0
20         0.02         0.86         114.24         949.2         977.4         977.4         5         4.22         0.083         0.083         0.75         1         0           21         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.75         1         0           22         0.02         0.86         114.24         949.2         977.4         977.4         0         2.11         0.083         0.083         0.083         0.75         1         0           23         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           24         0.02         0.86         114.24         949.2         977.4         977.4         0         8.44         0.083         0.083         0.083         0.75         1         0           25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0	18	0.02	0.86	114.24	949.2		1954.8	0	4.22	0.083	0.083	0.083		1	0
21         0.02         0.86         114.24         949.2         977.4         977.4         10         4.22         0.083         0.083         0.75         1         0           22         0.02         0.86         114.24         949.2         977.4         977.4         0         2.11         0.083         0.083         0.083         0.75         1         0           23         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           24         0.02         0.86         114.24         949.2         977.4         977.4         0         8.44         0.083         0.083         0.083         0.75         1         0           25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           26         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           28	19	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
22         0.02         0.86         114.24         949.2         977.4         977.4         0         2.11         0.083         0.083         0.75         1         0           23         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           24         0.02         0.86         114.24         949.2         977.4         977.4         0         8.44         0.083         0.083         0.083         0.75         1         0           25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.0415         0.083         0.083         0.75         1         0           26         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           27         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0	20	0.02	0.86	114.24		977.4	977.4	5	4.22	0.083	0.083	0.083	0.75	1	0
23         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           24         0.02         0.86         114.24         949.2         977.4         977.4         0         8.44         0.083         0.083         0.083         0.75         1         0           25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.0415         0.083         0.083         0.75         1         0           26         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           27         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           28         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           29         0.02	21	0.02	0.86	114.24	949.2	977.4	977.4	10	4.22	0.083	0.083	0.083	0.75	1	0
24         0.02         0.86         114.24         949.2         977.4         977.4         0         8.44         0.083         0.083         0.083         0.75         1         0           25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.0415         0.083         0.083         0.75         1         0           26         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           27         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.166         0.083         0.083         0.75         1         0           28         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           29         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0	22	0.02	0.86	114.24	949.2	977.4	977.4	0	2.11	0.083	0.083	0.083	0.75	1	0
25         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.0415         0.083         0.083         0.75         1         0           26         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           27         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.166         0.083         0.083         0.75         1         0           28         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.0415         0.083         0.75         1         0           29         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           30         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.0415         0.75         1         0	23	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
26         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           27         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.166         0.083         0.083         0.75         1         0           28         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.0415         0.083         0.75         1         0           29         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           30         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           31         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.0415         0.75         1         0           32	24	0.02	0.86	114.24	949.2	977.4	977.4	0	8.44	0.083	0.083	0.083	0.75	1	0
27         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.166         0.083         0.083         0.75         1         0           28         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.0415         0.083         0.75         1         0           29         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           30         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.166         0.083         0.75         1         0           31         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.0415         0.75         1         0           32         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1<	25	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.0415	0.083	0.083	0.75	1	0
28         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.0415         0.083         0.75         1         0           29         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           30         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.166         0.083         0.75         1         0           31         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.0415         0.75         1         0           32         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           33         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.166         0.75         1         0	26	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
29         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           30         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.166         0.083         0.75         1         0           31         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.0415         0.75         1         0           32         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           33         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.166         0.75         1         0           34         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.375         1         0	27	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.166	0.083	0.083	0.75	1	0
30         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.166         0.083         0.75         1         0           31         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.0415         0.75         1         0           32         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           33         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.166         0.75         1         0           34         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.375         1         0           35         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0	28	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.0415	0.083	0.75	1	0
31         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.0415         0.75         1         0           32         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           33         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.166         0.75         1         0           34         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.375         1         0           35         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           36         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0<	29	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
32         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           33         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.166         0.75         1         0           34         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.375         1         0           35         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           36         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           37         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         0	30	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.166	0.083	0.75	1	0
33         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.166         0.75         1         0           34         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.375         1         0           35         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         1         0           36         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         1.50         1         0           37         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         0           38         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         0	31	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.0415	0.75	1	0
34         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.375         1         0           35         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           36         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         1.50         1         0           37         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         0           38         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         0           39         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         1	32	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
35         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           36         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         1.50         1         0           37         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.75         0         0           38         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           39         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           39         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         1	33	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.166	0.75	1	0
36         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         1.50         1         0           37         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         0           38         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           39         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         1         0           39         0.02         0.86         114.24         949.2         977.4         977.4         0         4.22         0.083         0.083         0.083         0.75         0         1	34	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.375	1	0
37     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     0     0       38     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     1     0       39     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     0     1	35	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
38     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     1     0       39     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     0     1	36	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	1.50	1	0
38     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     1     0       39     0.02     0.86     114.24     949.2     977.4     977.4     0     4.22     0.083     0.083     0.083     0.75     0     1	37	0.02	0.86	114.24	949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	0	0
39 0.02 0.86 114.24 949.2 977.4 977.4 0 4.22 0.083 0.083 0.083 0.75 <b>0 1</b>	38	0.02	0.86		949.2	977.4	977.4	0	4.22	0.083	0.083	0.083	0.75	1	0
	39	0.02			949.2			0						0	1
			0.86					0						1	











- It can be performed on a one factor at a time basis.
- One of the input parameters is modified each time, while the other 13 input parameters remain unchanged.



Table 2: Optimal cost of the EWMA control chart.

No.	Cost	Percentage difference from optimal cost, %
1	187.91	-15.5
2	222.37	0.0
3	273.66	23.1
4	278.56	25.3
5	222.37	0.0
6	185.48	-16.6
7	194.60	-12.5
8	222.37	0.0
9	327.97	47.5
10	188.49	-15.2
11	222.37	0.0
12	269.11	21.0
13	215.28	-3.2
14	222.37	0.0
15	229.03	3.0
16	213.31	-4.1
17	222.37	0.0
18	240.47	8.1
19	222.37	0.0
20	238.22	7.1
21	250.04	12.4
22	202.44	-9.0
23	222.37	0.0
24	246.67	10.9
25	221.20	-0.5
26	222.37	0.0
27	224.69	1.0
28	222.37	0.0
29	222.37	0.0
30	222.37	0.0
31	221.78	-0.3
32	222.37	0.0
33	223.53	0.5
34	223.92	0.7
35	222.37	0.0
36	219.32	-1.4
37	220.67	-0.8
38	222.37	0.0
39	234.29	5.4
40	236.00	6.1







No.	$C_0(\$)$	$C_1(\$)$	c(\$)
7	57.12	949.2	4.22
8	114.24	949.2	4.22
9	228.48	949.2	4.22
10	114.24	474.6	4.22
11	114.24	949.2	4.22
12	114.24	1898.4	4.22
22	114.24	949.2	2.11
23	114.24	949.2	4.22
24	114.24	949.2	8.44

NT-	Coot	Danage 1: ff from 1 1
No.	Cost	Percentage difference from optimal cost, %
7	194.60	-12.5
8	222.37	0.0
9	327.97	47.5
10	188.49	-15.2
11	222.37	0.0
12	269.11	21.0
22	202.44	-9.0
23	222.37	0.0
24	246.67	10.9

• The implementation cost of the EWMA control chart increases when the expected quality cost per unit time while the process is incontrol,  $C_0$ , expected quality cost per unit time while the process is out-of-control,  $C_1$  and cost per unit sampled, c increase, and vice versa.



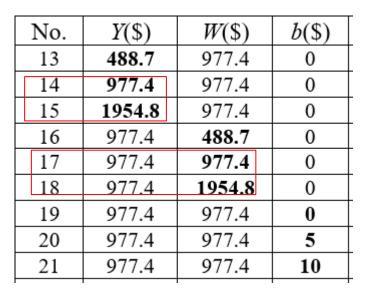


No.	$C_0(\$)$	$C_1(\$)$	c(\$)
7	57.12	949.2	4.22
8	114.24	949.2	4.22
9	228.48	949.2	4.22
10	114.24	474.6	4.22
11	114.24	949.2	4.22
12	114.24	1898.4	4.22
22	114.24	949.2	2.11
23	114.24	949.2	4.22
24	114.24	949.2	8.44

No.	Cost	Percentage difference from optimal cost, %
7	194.60	-12.5
8	222.37	0.0
9	327.97	47.5
10	188.49	-15.2
11	222.37	0.0
12	269.11	21.0
22	202.44	-9.0
23	222.37	0.0
24	246.67	10.9

- The implementation cost of the EWMA control chart increases when the expected quality cost per unit time while the process is incontrol,  $C_0$ , expected quality cost per unit time while the process is out-of-control,  $C_1$  and cost per unit sampled, c increase, and vice versa.
- C<sub>0</sub> has a greater effect on expected cost.
- When C<sub>0</sub> increases, expected cost increases by 47.5%.



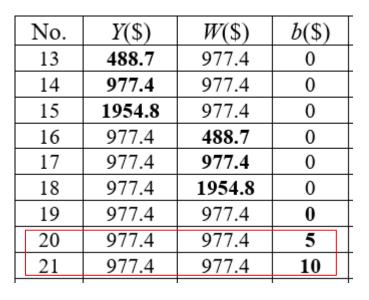


	No.	Cost	Percentage difference from optimal cost, %
	13	215.28	-3.2
	14	222.37	0.0
	15	229.03	3.0
	16	213.31	-4.1
	17	222.37	0.0
	18	240.47	8.1
	19	222.37	0.0
	20	238.22	7.1
	21	250.04	12.4
- 1			



- The input parameters Y and W have a minor effect on the expected cost.
- The increase in the value of *Y* and *W* increased the expected cost by 3% and 8.1%, respectively.





No.	Cost	Percentage difference from optimal cost, %
13	215.28	-3.2
14	222.37	0.0
15	229.03	3.0
16	213.31	-4.1
17	222.37	0.0
18	240.47	8.1
19	222.37	0.0
20	238.22	7.1
21	250.04	12.4



- The input parameters Y and W have a minor effect on the expected cost.
- The increase in the value of *Y* and *W* increased the expected cost by 3% and 8.1%, respectively.
- The expected cost increased when the fixed cost per sample, b, increased.

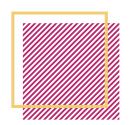




No.	e	$T_0$	$T_1$
25	0.0415	0.083	0.083
26	0.083	0.083	0.083
27	0.166	0.083	0.083
28	0.083	0.0415	0.083
29	0.083	0.083	0.083
30	0.083	0.166	0.083
31	0.083	0.083	0.0415
32	0.083	0.083	0.083
33	0.083	0.083	0.166

No.	Cost	Percentage difference from optimal cost, %
25	221.20	-0.5
26	222.37	0.0
27	224.69	1.0
28	222.37	0.0
29	222.37	0.0
30	222.37	0.0
31	221.78	-0.3
32	222.37	0.0
33	223.53	0.5
1	1	

• The expected cost remains the same for the input parameter expected time to search a false alarm,  $T_0$ .

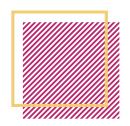




No.	e	$T_0$	$T_1$
25	0.0415	0.083	0.083
26	0.083	0.083	0.083
27	0.166	0.083	0.083
28	0.083	0.0415	0.083
29	0.083	0.083	0.083
30	0.083	0.166	0.083
31	0.083	0.083	0.0415
32	0.083	0.083	0.083
33	0.083	0.083	0.166

4		
No.	Cost	Percentage difference from optimal cost, %
25	221.20	-0.5
26	222.37	0.0
27	224.69	1.0
28	222.37	0.0
29	222.37	0.0
30	222.37	0.0
31	221.78	-0.3
32	222.37	0.0
33	223.53	0.5

- The expected cost remains the same for the input parameter expected time to search a false alarm,  $T_0$ .
- The expected time to sample and interpret one unit, e and the expected time to determine the assignable cause,  $T_1$ , have a small impact on the expected cost.



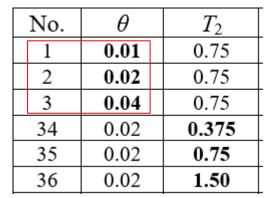


No.	$\theta$	$T_2$
1	0.01	0.75
2	0.02	0.75
3	0.04	0.75
34	0.02	0.375
35	0.02	0.75
36	0.02	1.50

No.	Cost	Percentage difference from optimal cost, %
1	187.91	-15.5
2	222.37	0.0
3	273.66	23.1
34	223.92	0.7
35	222.37	0.0
36	219.32	-1.4

• The expected cost decreases by 1.4% when the expected time to repair the process,  $T_2$ , increases from 0.75 to 1.50.





No.	Cost	Percentage difference from optimal cost, %
1	187.91	-15.5
2	222.37	0.0
3	273.66	23.1
34	223.92	0.7
35	222.37	0.0
36	219.32	-1.4



- The expected cost decreases by 1.4% when the expected time to repair the process,  $T_2$ , increases from 0.75 to 1.50.
- The cost decreases when the process failure rate,  $\theta$  decreases and vice versa.





No.	$\delta$	γ1	$\gamma_2$
4	0.43	1	0
5	0.86	1	0
6	1.72	1	0
37	0.86	0	0
38	0.86	1	0
39	0.86	0	1
40	0.86	1	1

No.	Cost	Percentage difference from optimal cost, %
4	278.56	25.3
5	222.37	0.0
6	185.48	-16.6
37	220.67	-0.8
38	222.37	0.0
39	234.29	5.4
40	236.00	6.1

• When the process shift,  $\delta$ , increases by 50% from 0.86 to 1.72, the cost reduced by 16.6%.





No.	$\delta$	γ1	$\gamma_2$
4	0.43	1	0
5	0.86	1	0
6	1.72	1	0
37	0.86	0	0
38	0.86	1	0
39	0.86	0	1
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No.	Cost	Percentage difference from optimal cost, %
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6	185.48	-16.6
37	220.67	-0.8
38	222.37	0.0
39	234.29	5.4
40	236.00	6.1

- When the process shift,  $\delta$ , increases by 50% from 0.86 to 1.72, the cost reduced by 16.6%.
- As the size of process shift decreases, the cost increased by 25.3% from 222.37 to 278.56.





No.	δ	γ1	γ2
4	0.43	1	0
5	0.86	1	0
6	1.72	1	0
37	0.86	0	0
38	0.86	1	0
39	0.86	0	1
40	0.86	1	1

No.	Cost	Percentage difference from optimal cost, %
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6.1

- When the process shift,  $\delta$ , increases by 50% from 0.86 to 1.72, the cost reduced by 16.6%.
- As the size of process shift decreases, the cost increased by 25.3% from 222.37 to 278.56.

40

236.00





No.	$\delta$	γ1	γ2
4	0.43	1	0
5	0.86	1	0
6	1.72	1	0
37	0.86	0	0
38	0.86	1	0
39	0.86	0	1
40	0.86	1	1

 $y_1$  = 1 if production continues during search

= 0 if production stops during search

 $\gamma_2$  = 1 if production continues during repair

= 0 if production stops during repair

No.	Cost	Percentage difference from optimal cost, %
4	278.56	25.3
5	222.37	0.0
6	185.48	-16.6
37	220.67	-0.8
38	222.37	0.0
39	234.29	5.4
40	236.00	6.1

• The production status during search,  $\gamma_1$ , and production status during repair,  $\gamma_2$ , show that when production stops during search and repair, the optimal cost decreased from 222.37 to 220.67.





No.	$\delta$	γ1	$\gamma_2$
4	0.43	1	0
5	0.86	1	0
6	1.72	1	0
37	0.86	0	0
38	0.86	1	0
39	0.86	0	1
40	0.86	1	1

 $y_1$  = 1 if production continues during search

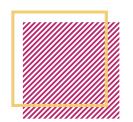
= 0 if production stops during search

 $y_2$  = 1 if production continues during repair

= 0 if production stops during repair

No.	Cost	Percentage difference from optimal cost, %
4	278.56	25.3
5	222.37	0.0
6	185.48	-16.6
37	220.67	-0.8
38	222.37	0.0
39	234.29	5.4
40	236.00	6.1

- The production status during search,  $y_1$ , and production status during repair,  $y_2$ , show that when production stops during search and repair, the optimal cost decreased from 222.37 to 220.67.
- The optimal cost increases by 6.1% when the production continues during search and repair.





No.	δ	γ1	γ2
4	0.43	1	0
5	0.86	1	0
6	1.72	1	0
37	0.86	0	0
38	0.86	1	0
39	0.86	0	1
40	0.86	1	1

 $y_1$  = 1 if production continues during search

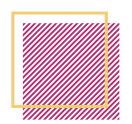
= 0 if production stops during search

 $y_2$  = 1 if production continues during repair

= 0 if production stops during repair

No.	Cost	Percentage difference from optimal cost, %
4	278.56	25.3
5	222.37	0.0
6	185.48	-16.6
37	220.67	-0.8
38	222.37	0.0
39	234.29	5.4
40	236.00	6.1

- The production status during search,  $\gamma_1$ , and production status during repair,  $\gamma_2$ , show that when production stops during search and repair, the optimal cost decreased from 222.37 to 220.67.
- The optimal cost increases by 6.1% when the production continues during search and repairs.
- The same phenomenon occurs when the production stops during search and production continues during repair, i.e. increased by 5.4%.



## Conclusion



- The sensitivity analysis was carried out by increasing and decreasing the values of the input parameters by 50%.
- 13 input parameters influence the cost parameter.
- The effect of each input parameter on the cost is different.
- The cost of implementing the EWMA control chart is increased by 47.5% when the expected quality cost per unit time while the process is in-control, *C*<sub>0</sub> is increased by 50%.
- This research provides an overview of the influence of the input parameters on the cost of implementing the EWMA control chart.





# 21 THANK YOU

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