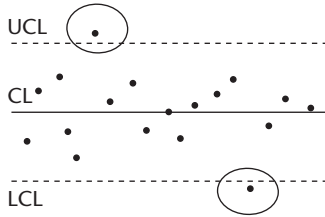
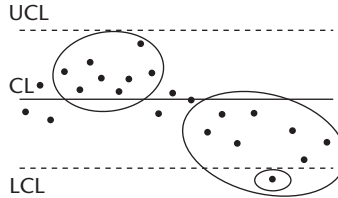


FIGURE 4.5 Rules for Determining a Special Cause

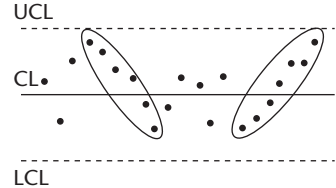
1. A single point outside the control limits.



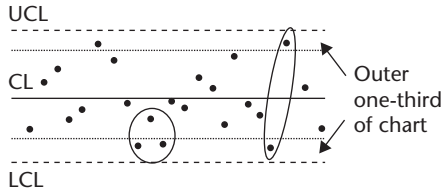
2. A run of eight or more points in a row above (or below) the centerline.



3. Six consecutive points increasing (trend up) or decreasing (trend down).



4. Two out of three consecutive points near (outer one-third) a control limit.



5. Fifteen consecutive points close (inner one-third of the chart) to the centerline.

