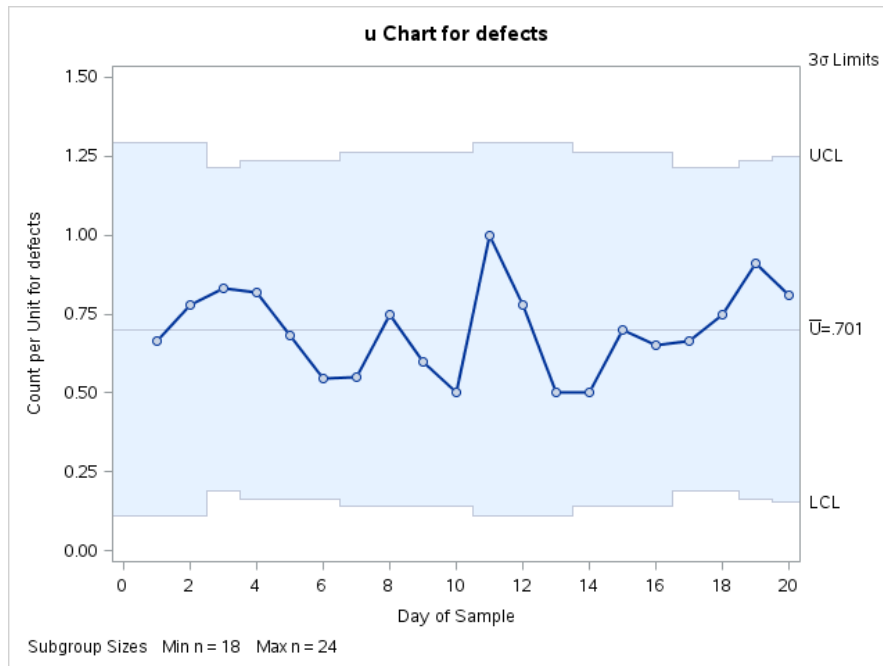# STATS 528: HW5

John Sherrill

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7.37 The process appears to be in statistical control based on the u-chart generated.

The centerline should be $\bar{U} = \frac{\sum d_i}{\sum n_i} = 0.701$. To get control limits for production monitoring that are independent of sample size one could 1) take the average of control limits over the days to get control limits for production monitoring, 2) compute $\bar{n} = \frac{1}{m}\sum_{i=1}^{m} n = 20.55$ and let

$$UCL = \bar{u} + 3\sqrt{\frac{\bar{u}}{\bar{n}}} = 0.701 + 3\sqrt{\frac{0.701}{20.55}} = 1.255$$

$$LCL = \bar{u} - 3\sqrt{\frac{\bar{u}}{\bar{n}}} = 0.701 - 3\sqrt{\frac{0.701}{20.55}} = 0.147$$

or 3) normalize the data but that's not really a solution as it's essentially the same as having control limits dependent on sample size.

7.40 The process appears in statistical control once the "outlying" observation on deck 2425 is removed:

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c Chart for defects
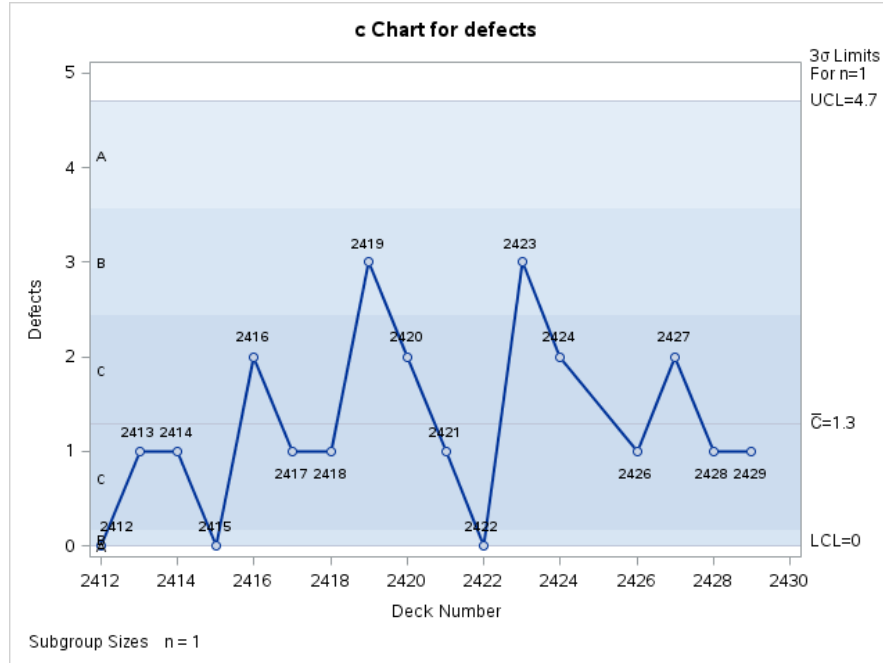
The centerline should be $\bar{c} = \frac{1}{m} \sum_{i=1}^{m} c_i = 1.294$ and recommended control limits could be given by

$$UCL = \bar{c} + 3\sqrt{\bar{c}} = 1.294 + 3\sqrt{1.294} = 4.707$$
$$LCL = \bar{c} - 3\sqrt{\bar{c}} = 1.294 - 3\sqrt{1.294} = -2.119$$

Since it doesn't make sense to have a LCL be negative, it is then recommended that the LCL is 0. Thus, the UCL and LCL coincide with the c chart given by SAS.
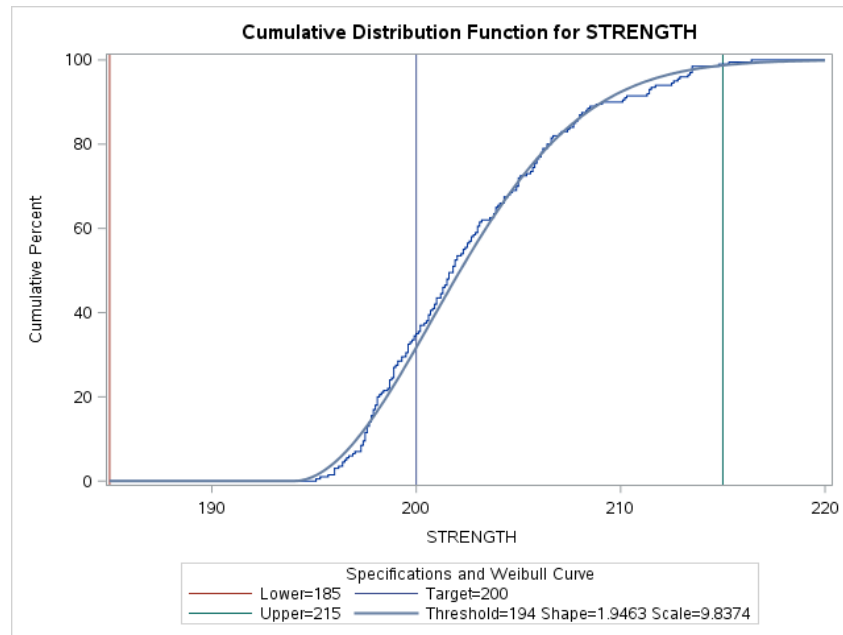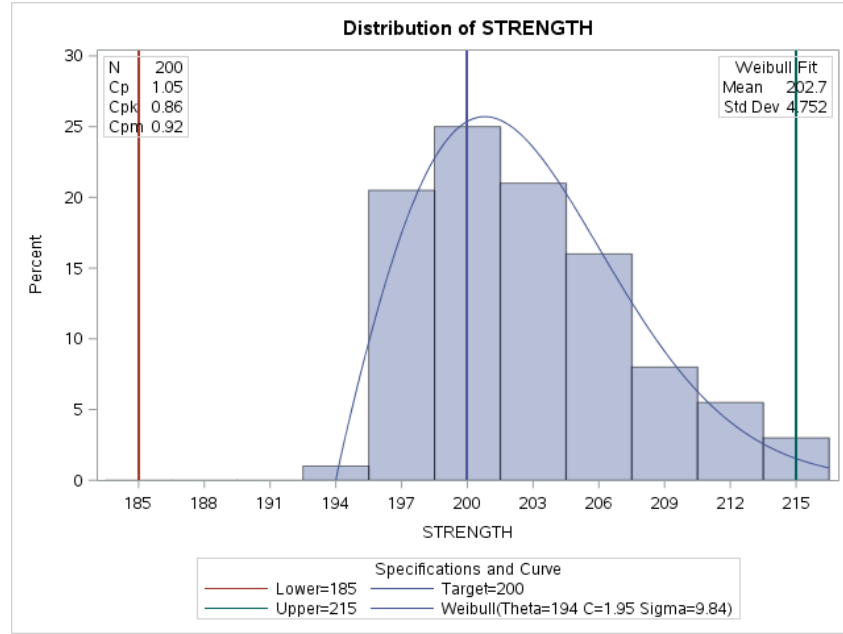
Question 3   (a)

$$\text{Normal} : \mu = 202.69 \quad \sigma = 4.752$$
$$\text{Gamma} : \text{shape } = 3.24 \quad \text{scale } = 2.68 \quad \text{threshold } = 194$$
$$\text{Weibull} : \text{shape } = 1.95 \quad \text{scale } = 9.84 \quad \text{threshold } = 194$$
$$\text{Beta} : \alpha = 2.29 \quad \beta = 5.57 \quad \text{threshold } = 194 \quad \text{scale } = 30$$
$$\text{Lognormal} : \text{shape } = 0.45 \quad \text{scale } = 2.27 \quad \text{threshold } = 192$$

(b) Of the distributions fit, the Weibull and Beta distributions appear to fit the best across the entire range of observations. Neither appears to over estimate the amount of observations at the mean (≈ 202.7) and both have right tails that extend to account for some of the larger observations (> 210). Plot the CDF plot and histogram/PDF plots appear about the same for both distributions:

Distribution of STRENGTH

N	200
Cp	1.05
Cpk	0.86
Cpm	0.92

Weibull Fit
Mean 202.7
Std Dev 4.752

Specifications and Curve
Lower=185   Target=200
Upper=215   Weibull(Theta=194 C=1.95 Sigma=9.84)

Cumulative Distribution Function for STRENGTH

Specifications and Weibull Curve
Lower=185   Target=200
Upper=215   Threshold=194 Shape=1.9463 Scale=9.8374

(c) For the Weibull distribution we have:

$$\hat{C}_p = 1.05$$

$$\hat{C}_{pk} = 0.86$$

$$\hat{C}_{pm} = 0.92$$

One way to interpret the $\hat{C}_p$ value is by considering that we estimate that $\frac{100}{\hat{C}_p} = \frac{100}{1.05} = 95.238$ percent of the specification band for the breaking strengths is being used up by the process

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(assuming breaking strengths are normally distributed and that the mean is centered between the USL and LSL).

Because $\hat{C}_{pk}$ is less than $\hat{C}_p$ we know that the process is not centered in the specification band and that there would be potential improvement by centering the process.

Because the $\hat{C}_{pm}$ is relatively close to one, we can assume that the process center is approximately somewhere within the middle third of the specification band. This is of course the case since $\bar{x} = 202.7$.