

Appendix A

Shewhart Constants for Control Charts

The main Shewhart constants d_2 , d_3 , and c_4 can be obtained for any n using R as shown in the following examples:

```
library(SixSigma)
ss.cc.getd2(n = 5)

##          d2
## 2.325929

ss.cc.getd3(n = 5)

##          d3
## 0.8640819

ss.cc.getc4(n = 5)

##          c4
## 0.9399856
```

The rest of Shewhart constants that can be found at any textbook are computed using those three basic constants. A full table of constants can also be generated using R. Table A.1 shows the constants used in this book. There are other constants not covered by this book which could also be computed just using the appropriate formula. A data frame with the constants in Table A.1 can be obtained with the following code:

```
nmax <- 25
n <- 2:nmax
d2 <- sapply(2:nmax, ss.cc.getd2)
d3 <- sapply(2:nmax, ss.cc.getd3)
c4 <- sapply(2:nmax, ss.cc.getc4)
A2 <- 3 / (d2 * sqrt(n))
```

Table A.1 Shewhart constants

n	d2	d3	c4	A2	D3	D4	B3	B4
2	1.1284	0.8525	0.7979	1.8800	0.0000	3.2665	0.0000	3.2665
3	1.6926	0.8884	0.8862	1.0233	0.0000	2.5746	0.0000	2.5682
4	2.0588	0.8798	0.9213	0.7286	0.0000	2.2821	0.0000	2.2660
5	2.3259	0.8641	0.9400	0.5768	0.0000	2.1145	0.0000	2.0890
6	2.5344	0.8480	0.9515	0.4832	0.0000	2.0038	0.0304	1.9696
7	2.7044	0.8332	0.9594	0.4193	0.0757	1.9243	0.1177	1.8823
8	2.8472	0.8198	0.9650	0.3725	0.1362	1.8638	0.1851	1.8149
9	2.9700	0.8078	0.9693	0.3367	0.1840	1.8160	0.2391	1.7609
10	3.0775	0.7971	0.9727	0.3083	0.2230	1.7770	0.2837	1.7163
11	3.1729	0.7873	0.9754	0.2851	0.2556	1.7444	0.3213	1.6787
12	3.2585	0.7785	0.9776	0.2658	0.2833	1.7167	0.3535	1.6465
13	3.3360	0.7704	0.9794	0.2494	0.3072	1.6928	0.3816	1.6184
14	3.4068	0.7630	0.9810	0.2354	0.3281	1.6719	0.4062	1.5938
15	3.4718	0.7562	0.9823	0.2231	0.3466	1.6534	0.4282	1.5718
16	3.5320	0.7499	0.9835	0.2123	0.3630	1.6370	0.4479	1.5521
17	3.5879	0.7441	0.9845	0.2028	0.3779	1.6221	0.4657	1.5343
18	3.6401	0.7386	0.9854	0.1943	0.3913	1.6087	0.4818	1.5182
19	3.6890	0.7335	0.9862	0.1866	0.4035	1.5965	0.4966	1.5034
20	3.7349	0.7287	0.9869	0.1796	0.4147	1.5853	0.5102	1.4898
21	3.7783	0.7242	0.9876	0.1733	0.4250	1.5750	0.5228	1.4772
22	3.8194	0.7199	0.9882	0.1675	0.4345	1.5655	0.5344	1.4656
23	3.8583	0.7159	0.9887	0.1621	0.4434	1.5566	0.5452	1.4548
24	3.8953	0.7121	0.9892	0.1572	0.4516	1.5484	0.5553	1.4447
25	3.9306	0.7084	0.9896	0.1526	0.4593	1.5407	0.5648	1.4352

```

D3 <- sapply(1:(nmax-1), function(x) {
  max(c(0, 1 - 3*(d3[x]/d2[x]))))})
D4 <- (1 + 3*(d3/d2))
B3 <- sapply(1:(nmax-1), function(x) {
  max(0, 1 - 3*(sqrt(1-c4[x]^2)/c4[x]))})
B4 <- 1 + 3*(sqrt(1-c4^2)/c4)
constdf <- data.frame(n, d2, d3, c4, A2,
  D3, D4, B3, B4)

```

The table of constants is also available as a one-page pdf document through one of the SixSigma package *vignettes*:

```

vignette(topic = "Shewhart Constants",
  package = "SixSigma")

```

Appendix B

ISO Standards Published by the ISO/TC69: Application of Statistical Methods

This appendix contains all the international standards and technical reports published by the ISO TC69—Application of Statistical Methods, grouped by subcommittees. Please note that ISO standards are continuously evolving. All references to standards in this appendix and throughout the book are specific for a given point in time. In particular, this point in time is end of June 2015. Therefore, some new standards may have appeared when you are reading this book, or even other changes may have happen in ISO. For example, at the time of publishing a subcommittee has changed its denomination! Keep updated in the committee website: http://www.iso.org/iso/home/store/catalogue_tc/catalogue_tc_browse.htm?commid=49742.

TC69/SCS: Secretariat

ISO 11453:1996 Statistical interpretation of data—Tests and confidence intervals relating to proportions.

ISO 11453:1996/Cor 1:1999 .

ISO 16269-4:2010 Statistical interpretation of data—Part 4: Detection and treatment of outliers.

ISO 16269-6:2014 Statistical interpretation of data—Part 6: Determination of statistical tolerance intervals.

ISO 16269-7:2001 Statistical interpretation of data—Part 7: Median—Estimation and confidence intervals.

ISO 16269-8:2004 Statistical interpretation of data—Part 8: Determination of prediction intervals.

ISO 2602:1980 Statistical interpretation of test results—Estimation of the mean—Confidence interval.

ISO 2854:1976 Statistical interpretation of data—Techniques of estimation and tests relating to means and variances.

ISO 28640:2010 Random variate generation methods.

ISO 3301:1975 Statistical interpretation of data—Comparison of two means in the case of paired observations.

ISO 3494:1976 Statistical interpretation of data—Power of tests relating to means and variances.

ISO 5479:1997 Statistical interpretation of data—Tests for departure from the normal distribution.

ISO/TR 13519:2012 Guidance on the development and use of ISO statistical publications supported by software.

ISO/TR 18532:2009 Guidance on the application of statistical methods to quality and to industrial standardization.

TC69/SC1: Terminology and Symbols

Statistics

ISO 3534-1:2006 —Vocabulary and symbols—Part 1: General statistical terms and terms used in probability.

ISO 3534-2:2006 Statistics—Vocabulary and symbols—Part 2: Applied statistics.

ISO 3534-3:2013 Statistics—Vocabulary and symbols—Part 3: Design of experiments.

ISO 3534-4:2014 Statistics—Vocabulary and symbols—Part 4: Survey sampling.

TC69/SC4: Applications of Statistical Methods in Process Management

ISO 11462-1:2001 Guidelines for implementation of statistical process control (SPC)—Part 1: Elements of SPC.

ISO 11462-2:2010 Guidelines for implementation of statistical process control (SPC)—Part 2: Catalogue of tools and techniques.

ISO 22514-1:2014 Statistical methods in process management—Capability and performance—Part 1: General principles and concepts.

ISO 22514-2:2013 Statistical methods in process management—Capability and performance—Part 2: Process capability and performance of time-dependent process models.

ISO 22514-3:2008 Statistical methods in process management—Capability and performance—Part 3: Machine performance studies for measured data on discrete parts.

- ISO 22514-6:2013** Statistical methods in process management—Capability and performance—Part 6: Process capability statistics for characteristics following a multivariate normal distribution.
- ISO 22514-7:2012** Statistical methods in process management—Capability and performance—Part 7: Capability of measurement processes.
- ISO 22514-8:2014** Statistical methods in process management—Capability and performance—Part 8: Machine performance of a multi-state production process.
- ISO 7870-1:2014** Control charts—Part 1: General guidelines.
- ISO 7870-2:2013** Control charts—Part 2: Shewhart control charts.
- ISO 7870-3:2012** Control charts—Part 3: Acceptance control charts.
- ISO 7870-4:2011** Control charts—Part 4: Cumulative sum charts.
- ISO 7870-5:2014** Control charts—Part 5: Specialized control charts.
- ISO/TR 22514-4:2007** Statistical methods in process management—Capability and performance—Part 4: Process capability estimates and performance measures.

TC69/SC5: Acceptance Sampling

- ISO 13448-1:2005** Acceptance sampling procedures based on the allocation of priorities principle (APP)—Part 1: Guidelines for the APP approach.
- ISO 13448-2:2004** Acceptance sampling procedures based on the allocation of priorities principle (APP)—Part 2: Coordinated single sampling plans for acceptance sampling by attributes.
- ISO 14560:2004** Acceptance sampling procedures by attributes—Specified quality levels in nonconforming items per million.
- ISO 18414:2006** Acceptance sampling procedures by attributes—Accept-zero sampling system based on credit principle for controlling outgoing quality.
- ISO 21247:2005** Combined accept-zero sampling systems and process control procedures for product acceptance.
- ISO 24153:2009** Random sampling and randomization procedures.
- ISO 2859-10:2006** Sampling procedures for inspection by attributes—Part 10: Introduction to the ISO 2859 series of standards for sampling for inspection by attributes.
- ISO 2859-1:1999** Sampling procedures for inspection by attributes—Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection.
- ISO 2859-1:1999/Amd 1:2011** .
- ISO 2859-3:2005** Sampling procedures for inspection by attributes—Part 3: Skip-lot sampling procedures.
- ISO 2859-4:2002** Sampling procedures for inspection by attributes—Part 4: Procedures for assessment of declared quality levels.

- ISO 2859-5:2005** Sampling procedures for inspection by attributes—Part 5: System of sequential sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection.
- ISO 28801:2011** Double sampling plans by attributes with minimal sample sizes, indexed by producer's risk quality (PRQ) and consumer's risk quality (CRQ).
- ISO 3951-1:2013** Sampling procedures for inspection by variables—Part 1: Specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection for a single quality characteristic and a single AQL.
- ISO 3951-2:2013** Sampling procedures for inspection by variables—Part 2: General specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection of independent quality characteristics.
- ISO 3951-3:2007** Sampling procedures for inspection by variables—Part 3: Double sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection.
- ISO 3951-4:2011** Sampling procedures for inspection by variables—Part 4: Procedures for assessment of declared quality levels.
- ISO 3951-5:2006** Sampling procedures for inspection by variables—Part 5: Sequential sampling plans indexed by acceptance quality limit (AQL) for inspection by variables (known standard deviation).
- ISO 8422:2006** Sequential sampling plans for inspection by attributes.
- ISO 8423:2008** Sequential sampling plans for inspection by variables for percent nonconforming (known standard deviation).

TC69/SC6: Measurement Methods and Results

- ISO 10576-1:2003** Statistical methods—Guidelines for the evaluation of conformity with specified requirements—Part 1: General principles.
- ISO 10725:2000** Acceptance sampling plans and procedures for the inspection of bulk materials.
- ISO 11095:1996** Linear calibration using reference materials.
- ISO 11648-1:2003** Statistical aspects of sampling from bulk materials—Part 1: General principles.
- ISO 11648-2:2001** Statistical aspects of sampling from bulk materials—Part 2: Sampling of particulate materials.
- ISO 11843-1:1997** Capability of detection—Part 1: Terms and definitions.
- ISO 11843-2:2000** Capability of detection—Part 2: Methodology in the linear calibration case.
- ISO 11843-3:2003** Capability of detection—Part 3: Methodology for determination of the critical value for the response variable when no calibration data are used.
- ISO 11843-4:2003** Capability of detection—Part 4: Methodology for comparing the minimum detectable value with a given value.

- ISO 11843-5:2008** Capability of detection—Part 5: Methodology in the linear and non-linear calibration cases.
- ISO 11843-6:2013** Capability of detection—Part 6: Methodology for the determination of the critical value and the minimum detectable value in Poisson distributed measurements by normal approximations.
- ISO 11843-7:2012** Capability of detection—Part 7: Methodology based on stochastic properties of instrumental noise.
- ISO 21748:2010** Guidance for the use of repeatability, reproducibility and trueness estimates in measurement uncertainty estimation.
- ISO 5725-1:1994** Accuracy (trueness and precision) of measurement methods and results—Part 1: General principles and definitions.
- ISO 5725-2:1994** Accuracy (trueness and precision) of measurement methods and results—Part 2: Basic method for the determination of repeatability and reproducibility of a standard measurement method.
- ISO 5725-3:1994** Accuracy (trueness and precision) of measurement methods and results—Part 3: Intermediate measures of the precision of a standard measurement method.
- ISO 5725-4:1994** Accuracy (trueness and precision) of measurement methods and results—Part 4: Basic methods for the determination of the trueness of a standard measurement method.
- ISO 5725-5:1998** Accuracy (trueness and precision) of measurement methods and results—Part 5: Alternative methods for the determination of the precision of a standard measurement method.
- ISO 5725-6:1994** Accuracy (trueness and precision) of measurement methods and results—Part 6: Use in practice of accuracy values.
- ISO/TR 13587:2012** Three statistical approaches for the assessment and interpretation of measurement uncertainty.
- ISO/TS 21749:2005** Measurement uncertainty for metrological applications—Repeated measurements and nested experiments.
- ISO/TS 28037:2010** Determination and use of straight-line calibration functions.

TC69/SC7: Applications of Statistical and Related Techniques for the Implementation of Six Sigma

- ISO 13053-1:2011** Quantitative methods in process improvement—Six Sigma—Part 1: DMAIC methodology.
- ISO 13053-2:2011** Quantitative methods in process improvement—Six Sigma—Part 2: Tools and techniques.
- ISO 17258:2015** Statistical methods—Six Sigma—Basic criteria underlying benchmarking for Six Sigma in organisations.
- ISO/TR 12845:2010** Selected illustrations of fractional factorial screening experiments.

ISO/TR 12888:2011 Selected illustrations of gauge repeatability and reproducibility studies.

ISO/TR 14468:2010 Selected illustrations of attribute agreement analysis.

ISO/TR 29901:2007 Selected illustrations of full factorial experiments with four factors.

ISO/TR 29901:2007/Cor 1:2009 .

TC69/SC8: Application of Statistical and Related Methodology for New Technology and Product Development

ISO 16336:2014 Applications of statistical and related methods to new technology and product development process—Robust parameter design (RPD).

Appendix C

R Cheat Sheet for Quality Control

R Console

↑ ↓ Navigate expressions history
CTRL+L Clear console
ESC Cancel current expression

RStudio

CTRL + number Go to panel:

- 1: Editor
- 2: Console
- 3: Help
- 4: History
- 5: Files
- 6: Plots
- 7: Packages
- 8: Environment

CTRL + MAYÚS + K *knit* current R Markdown report

CTRL + MAYÚS + I Compile R Sweave (L^AT_EX) current report

CTRL + S Save file

F1 Contextual help (upon the cursor position)

CTRL + F Activates search (within different panels)¹

<console>

¹See ‘Edit’ menu for further options.

↑↓ Expressions history
 CTRL+L Clear console
 ESC Cancel current expression
 <editor and console>
 TAB Prompt menu:

- Select objects in the workspace
- Select function arguments (when in parenthesis)
- Select list elements (after the \$ character)
- Select chunk options (when in *chunk* header)
- Select files (when in quotes)

<editor>
 CTRL + ENTER Run current line or selection
 CTRL + MAYÚS + S Source full script
 CTRL + ALT + I Insert code *chunk*
 CTRL + ALT + C Run current code *chunk* (within a chunk)
 CTRL + MAYÚS + P Repeat last code run
 CTRL + MAYÚS + C Comment current line or selection (add # at the beginning of the line)
 CTRL + D Delete current line
 ALT + ↑ ↓ Move current line or selection up or down
 ALT + MAYÚS + ↑ ↓ Copy current line or selection up or down

Help

?, help Help on a function

```
help("mean")
?mean
```

??, help.search Search help over a topic

```
help.search("topic")
```

apropos Show function containing a given string

```
apropos("prop.test")

## [1] "pairwise.prop.test" "power.prop.test"
## [3] "prop.test"
```

General

`;` Separate expressions in the same line
`<-` Assignment operator
`{ <code> }` Code blocks within curly brackets
Comment (ignores the remaining of the line)
`'<string>'` (backtick) Allow using identifiers with special characters and/or blank spaces

```
?('['')  
'my var' <- 1:5  
'my var'
```

Math Operators

`+`, `-`, `/`, `*`, `^` Arithmetic

```
5 + 2  
## [1] 7  
  
pi - 3  
## [1] 0.1415927  
  
1:5 * 2  
## [1] 2 4 6 8 10  
  
3 / 1:3  
## [1] 3.0 1.5 1.0  
  
3^4  
## [1] 81
```

`<`, `>`, `<=`, `>=`, `==`, `!=`, `%in%` Comparisons

```
5 >= 3
```

```
## [1] TRUE
5 %in% 1:4
## [1] FALSE
"a" %in% letters
## [1] TRUE
3.14 != pi
## [1] TRUE
```

&, &&, |, ||, ! Logic operations²

```
5 >= 3 | 8 > 10
## [1] TRUE
5 >= 3 & 8 > 10
## [1] FALSE
1:2 < 3 & 3:4 > 2
## [1] TRUE TRUE
1:2 < 3 && 3:4 > 2
## [1] TRUE
```

Integer Operations

%% Integer division

```
15 %% 2
## [1] 7
```

%% Module (remainder of a division)

```
15 %% 2
## [1] 1
```

²Double operators && and || are used to compare vectors globally. Single operators, element-wise.

Comparison Functions

all Are all elements TRUE?

```
all(1 > 2, 1 < 2)
## [1] FALSE
```

any Is any element TRUE?

```
any(1 > 2, 1 < 2)
## [1] TRUE
```

Math Functions

sqrt Square root

```
sqrt(16)
## [1] 4
```

exp, log Exponential and logarithmic

```
exp(-5)
## [1] 0.006737947
log(5)
## [1] 1.609438
```

sin, cos, tan Trigonometry

```
sin(pi)
## [1] 1.224647e-16
```

asin, acos, atan Inverse trigonometry

```
asin(1)
## [1] 1.570796
```

abs Absolute value

```
abs(log(0.5))  
## [1] 0.6931472
```

round, floor, ceiling Rounding

```
round(5.5)  
## [1] 6  
floor(5.5)  
## [1] 5  
ceiling(5.4)  
## [1] 6
```

max, min Maximum and minimum

```
x <- 1:10  
max(x)  
## [1] 10  
min(x)  
## [1] 1
```

sum, prod Sums and products

```
sum(x)  
## [1] 55  
prod(x)  
## [1] 3628800
```

cumsum, cumprod, cummax, cummin Cumulative operations

```
cumsum(x)  
## [1] 1 3 6 10 15 21 28 36 45 55  
cumprod(1:5)  
## [1] 1 2 6 24 120
```

factorial Factorial

```
factorial(5)

## [1] 120
```

choose Binomial coefficient

```
choose(5, 3)

## [1] 10
```

Vectors

c Create a vector (combine values)

```
svec <- c(1, 2, 5, 7, 4); svec

## [1] 1 2 5 7 4
```

seq : Creates a sequence

```
seq(4, 11, 2)

## [1] 4 6 8 10

4:11

## [1] 4 5 6 7 8 9 10 11
```

rep Repeat values

```
rep(1:2, each = 2)

## [1] 1 1 2 2

rep(1:2, times = 2)

## [1] 1 2 1 2
```

length Vector length

```
length(svec)

## [1] 5
```

[] Item selection

```
x[3]
## [1] 3
x[-3]
## [1] 1 2 4 5 6 7 8 9 10
```

sort Sorting

```
svec
## [1] 1 2 5 7 4
sort(svec)
## [1] 1 2 4 5 7
```

order Get indices ordered by magnitude

```
order(svec)
## [1] 1 2 5 3 4
```

rev Reverse order

```
rev(sort(svec))
## [1] 7 5 4 2 1
```

unique Get unique values

```
x2 <- c(1, 2, 2, 3, 4, 5, 5); x2
## [1] 1 2 2 3 4 5 5
unique(x2)
## [1] 1 2 3 4 5
```

which Devuelve índices que cumplen condición

```
which(x2 == 5)
## [1] 6 7
```


union, intersect, setdiff, setequal, %in% Sets operations

```
union(1:3, 3:5)

## [1] 1 2 3 4 5

intersect(1:3, 3:5)

## [1] 3

setdiff(1:3, 3:5)

## [1] 1 2

setequal(1:3, 3:5)

## [1] FALSE

3 %in% 1:3

## [1] TRUE
```

Matrices

matrix Create a matrix

```
A <- matrix(1:4, nrow=2); A

##           [,1] [,2]
## [1,]         1     3
## [2,]         2     4

B <- matrix(1:2, ncol=1); B

##           [,1]
## [1,]         1
## [2,]         2
```

%*% Matrix multiplication

```
A %*% B

##           [,1]
## [1,]         7
## [2,]        10
```

t Transpose a matrix

```
t(A)

##           [,1] [,2]
## [1,]         1   2
## [2,]         3   4
```

solve Inverse a matrix

```
solve(A)

##           [,1] [,2]
## [1,]        -2  1.5
## [2,]         1 -0.5
```

colSums, rowSums Sum by rows or columns

```
colSums(A)

## [1] 3 7
```

colMeans, rowMeans Average by rows or columns

```
rowMeans(B)

## [1] 1 2
```

colnames, rownames Column or rows names

```
colnames(A) <- c("col1", "col2"); A

##           col1 col2
## [1,]         1   3
## [2,]         2   4
```

dim, nrow, ncol Dimensions

```
dim(A)

## [1] 2 2

nrow(A)

## [1] 2

ncol(A)

## [1] 2
```

rbind, cbind Add columns or rows to a matrix matrix

```
rbind(A, 10:11)

##           col1 col2
## [1,]         1    3
## [2,]         2    4
## [3,]        10   11

cbind(B, 10:11)

##           [,1] [,2]
## [1,]         1   10
## [2,]         2   11
```

[,] Items selection

```
A[1, ] # row

## col1 col2
##     1    3

A[, 1] # column

## [1] 1 2

A[1, 2]#cell

## col2
##     3

A[1, , drop = FALSE]

##           col1 col2
## [1,]         1    3
```

Factors

factor Create a factor

```
xf <- factor(rep(1:2, 2)); xf

## [1] 1 2 1 2
## Levels: 1 2
```

gl Generate levels of a factor

```
xgl <- gl(3, 2, labels = LETTERS[1:3])
```

expand.grid Generate factors combinations

```
my.factors <- expand.grid(xf, xgl)
```

Dates

as.Date Convert to date

```
my.date <- as.Date("10/06/2014",  
  format("%d/%m/%Y")); my.date  
  
## [1] "2014-06-10"
```

format Returns a date in a given format

```
format(my.date, "%m-%y")  
  
## [1] "06-14"
```

ISOweek Returns the week of a date in ISO format (ISOweek package)

```
library(ISOweek)  
ISOweek(my.date)  
  
## [1] "2014-W24"
```

Character String

nchar Get number of characters

```
my.string <- "R is free software"  
nchar(my.string)  
  
## [1] 18
```

`paste, paste0` *Paste* character strings

```
your.string <- "as in Beer"
paste(my.string, your.string)

## [1] "R is free software as in Beer"
```

`cat` Print a character string in the console

```
cat("Hello World!")

## Hello World!
```

Lists

`list` Create a list

```
my.list <- list(a_string = my.string,
               a_matrix = A,
               a_vector = svec)
my.list

## $a_string
## [1] "R is free software"
##
## $a_matrix
##      col1 col2
## [1,]    1    3
## [2,]    2    4
##
## $a_vector
## [1] 1 2 5 7 4

my.list$a_vector

## [1] 1 2 5 7 4

my.list[1]

## $a_string
## [1] "R is free software"

my.list[[1]]

## [1] "R is free software"
```

Data Frames

data.frame Create a data frame

```
my.data <- data.frame(variable1 = 1:10,
  variable2 = letters[1:10],
  group = rep(1:2, each = 5))
my.data$variable1

## [1] 1 2 3 4 5 6 7 8 9 10

my.data[2, ]

## variable1 variable2 group
## 2         2         b     1
```

str Get data frame structure: column names, types, and sample data

```
str(my.data)

## 'data.frame': 10 obs. of 3 variables:
## $ variable1: int 1 2 3 4 5 6 7 8 9 10
## $ variable2: Factor w/ 10 levels "a","b","c","..
## $ group : int 1 1 1 1 1 2 2 2 2 2
```

head, tail Get first or last rows of a data frame

```
head(my.data)

## variable1 variable2 group
## 1         1         a     1
## 2         2         b     1
## 3         3         c     1
## 4         4         d     1
## 5         5         e     1
## 6         6         f     2

tail(my.data)

## variable1 variable2 group
## 5         5         e     1
## 6         6         f     2
## 7         7         g     2
## 8         8         h     2
## 9         9         i     2
## 10        10        j     2
```

subset Get a (filtered) subset of data

```
subset(my.data, group == 1)

##   variable1 variable2 group
## 1          1         a     1
## 2          2         b     1
## 3          3         c     1
## 4          4         d     1
## 5          5         e     1
```

aggregate Get aggregate data applying a function over groups

```
aggregate(variable1 ~ group, my.data, mean)

##   group variable1
## 1     1          3
## 2     2          8
```

Files

download.file Download files

```
download.file(
  url = "http://emilio.lcano.com/qcrbook/lab.csv",
  destfile = "lab.csv")
```

read.table Import data

```
importedData <- read.table("lab.csv",
  header = TRUE,
  sep = ",",
  dec = ".")
```

read.csv2 Import data from csv file

```
importedData <- read.csv("lab.csv")
```

write.csv2 Save csv data file

```
write.csv2(importedData,
  file = "labnew.csv",
  row.names = FALSE)
```

scan Read data from the console or text

```
scannedVector <- scan()
typedData <- scan(text = "1 2 3 4 5 6")
```

save Save an R data file

```
save(importedData, file = "lab.RData")
```

load Load an R data file into the workspace

```
load("lab.RData")
```

Data Simulation

set.seed Fix the seed³

```
set.seed(1234)
```

sample Draw a random sample from a set

```
sample(letters, 5)
## [1] "c" "p" "o" "x" "s"
sample(1:6, 10, replace = TRUE)
## [1] 4 1 2 4 4 5 4 2 6 2
```

rnorm, rbinom, rpois, ... Draw random variates from probability distributions (normal, binomial, Poisson, ...)

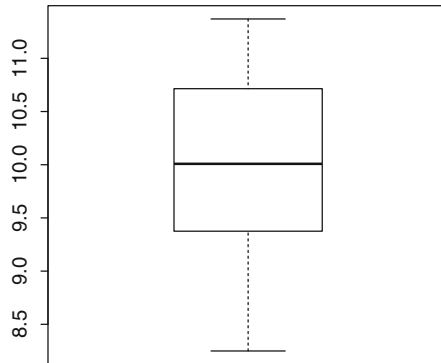
```
snorm <- rnorm(20, mean = 10, sd = 1)
spois <- rpois(20, lambda = 3)
```

³This makes results reproducible.

Graphics

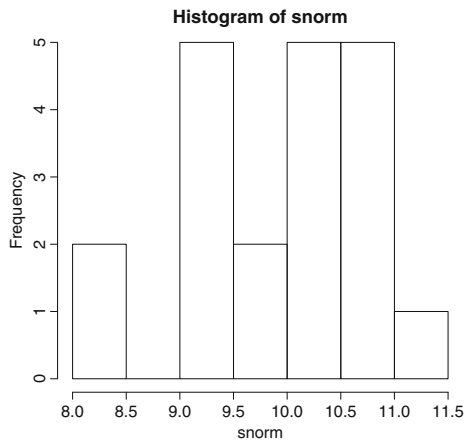
boxplot Box plot

```
boxplot(snorm)
```



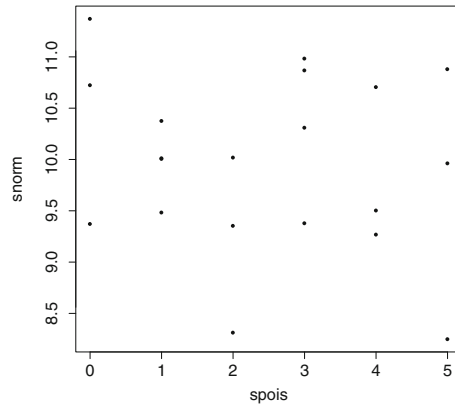
hist Histogram

```
hist(snorm)
```



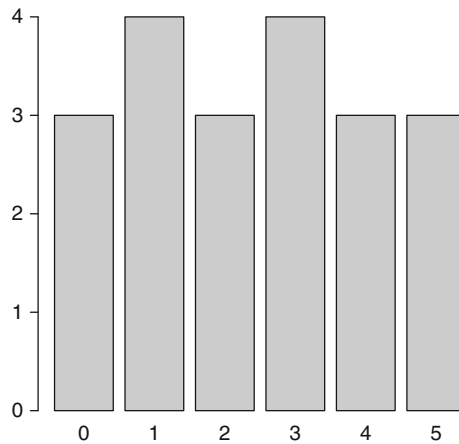
plot Scatter plot (for two numeric vectors)

```
plot(spois, snorm, pch = 20, )
```



`barplot` Bar plot (for counts)

```
barplot(table(spois))
```

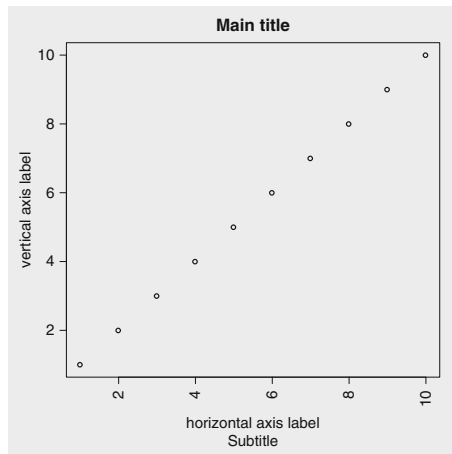


`par` Graphical parameters (see `?par`)

- `par` Get or set graphical parameters
- `main` Add a title to a plot (top)
- `sub` Add a subtitle to a plot (bottom)
- `xlab, ylab` Set horizontal and vertical axes labels
- `legend` Add a legend
- `col` Set color (see link at the end)
- `las` Axes labels orientation
- `lty` Line type
- `lwd` Line width
- `pch` Symbol (for points)

```
par(bg = "gray90")
```

```
plot(1:10, main = "Main title", sub = "Subtitle",
     xlab = "horizontal axis label",
     ylab = "vertical axis label",
     las = 2)
```



```
par(bg = "white")
```

graphics Graphical functions

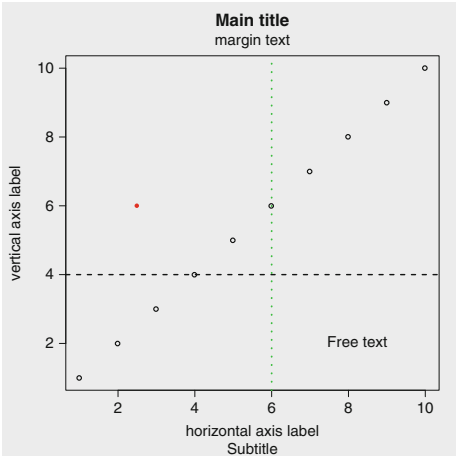
points Add points to a plot

abline Draw a straight line (horizontal, vertical, or with a slope)

text Put text in the plot

mtext Add text in the margins

```
par(bg = "gray90")
plot(1:10, main = "Main title", sub = "Subtitle",
     xlab = "horizontal axis label",
     ylab = "vertical axis label",
     las = 2)
par(bg = "white")
points(x = 2.5, y = 6, col = "red", pch = 16)
abline(h = 4, lty = 2, lwd = 2)
abline(v = 6, lty = 3, lwd = 3, col = 3)
text(x = 8, y = 2, labels = "Free text")
mtext(text = "margin text", side = 3)
```



Descriptive Statistics

table Count the elements within each category

```
table(spois)

## spois
## 0 1 2 3 4 5
## 3 4 3 4 3 3
```

summary Five-num summary (plus the mean)

```
summary(snorm)

##      Min. 1st Qu.  Median    Mean 3rd Qu.    Max.
##  8.249   9.376  10.010   9.957  10.710  11.370
```

mean Average

```
mean(snorm)

## [1] 9.956699
```

median Median

```
median(snorm)

## [1] 10.0082
```

quantile Percentiles, quantiles

```
quantile(snorm, 0.1)

##          10%
## 9.172885
```

var Variance

```
var(snorm)

## [1] 0.7240189
```

sd Standard deviation

```
sd(snorm)

## [1] 0.850893
```

cor Correlation

```
cor(snorm, spois)

## [1] -0.1691365
```

max, min, range Maximum, minimum, range

```
max(x)

## [1] 10

min(x)

## [1] 1

range(x)

## [1] 1 10

diff(range(x))

## [1] 9
```

Acceptance Sampling

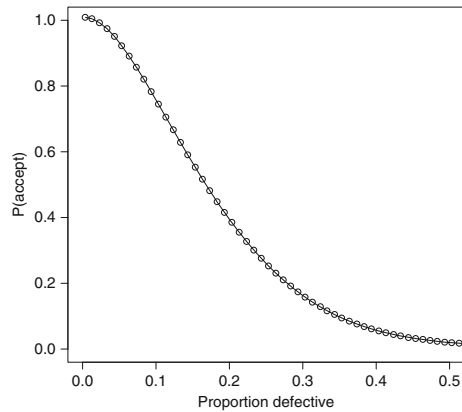
- Simple sampling plan

```
x <- OC2c(10, 1); x

## Acceptance Sampling Plan (binomial)
##
##                               Sample 1
```

```
## Sample size(s)          10
## Acc. Number(s)          1
## Rej. Number(s)          2

plot(x, xlim=c(0,0.5))
```

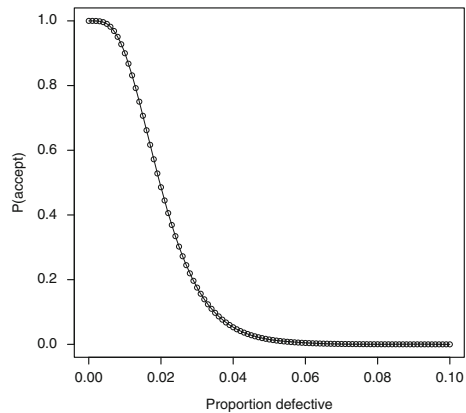


- Double sampling plan

```
x <- OC2c(c(125,125), c(1,4), c(4,5),
  pd = seq(0,0.1,0.001)); x

## Acceptance Sampling Plan (binomial)
##
##           Sample 1 Sample 2
## Sample size(s)      125      125
## Acc. Number(s)       1        4
## Rej. Number(s)       4        5

plot(x)
```



- Assess plan

```

assess(x, PRP=c(0.01, 0.95), CRP=c(0.05, 0.04))

## Acceptance Sampling Plan (binomial)
##
##               Sample 1 Sample 2
## Sample size(s)      125      125
## Acc. Number(s)        1        4
## Rej. Number(s)        4        5
##
## Plan CANNOT meet desired risk point(s):
##
##           Quality    RP P(accept) Plan P(accept)
## PRP           0.01                0.95    0.89995598
## CRP           0.05                0.04    0.01507571

```

Control Charts

qcc Library

```

library(qcc)
data(pistonrings)
str(pistonrings)

## 'data.frame': 200 obs. of  3 variables:
## $ diameter: num  74 74 74 74 74 ...
## $ sample : int   1 1 1 1 1 2 2 2 2 2 ...
## $ trial  : logi  TRUE TRUE TRUE TRUE TRUE TRUE TRUE..

head(pistonrings)

##   diameter sample trial
## 1    74.030      1  TRUE
## 2    74.002      1  TRUE
## 3    74.019      1  TRUE
## 4    73.992      1  TRUE
## 5    74.008      1  TRUE
## 6    73.995      2  TRUE

table(pistonrings$trial)

##
## FALSE  TRUE
##    75   125

```

```
str(qcc)

## function (data, type = c("xbar", "R", "S",
##   "xbar.one", "p", "np", "c", "u", "g"),
##   sizes, center, std.dev, limits, data.name,
##   labels, newdata, newsizes, newlabels,
##   nsigmas = 3, confidence.level, rules = shewh..
##   plot = TRUE, ...)
```

qcc.groups Create object with grouped data

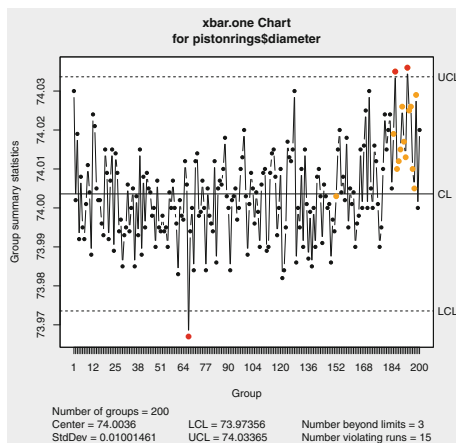
```
my.groups <- qcc.groups(data = pistonrings$diameter,
  sample = pistonrings$sample)
```

qcc Create control chart object. Some options:

data Vector, matrix or data frame with the data
type One of: “xbar”, “R”, “S”, “xbar.one”, “p”, “np”, “c”, “u”, “g”
sizes Vector with sample sizes for charts: “p”, “np”, o “u”
center Known center value
std.dev Known standard deviation
limits Phase I limits (vector with LCL, UCL)
plot If FALSE the chart is not shown
newdata Phase II data
newsizes Phase II sample sizes
nsigmas Number of standard deviations to compute control limits
confidence.level Confidence level to compute control limits (instead of nsigmas)

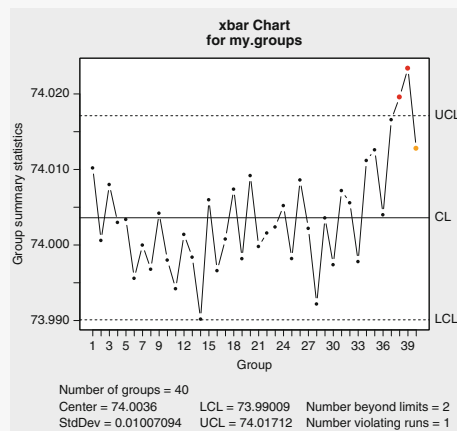
Control charts for variables:

```
# Individual values chart
qcc(pistonrings$diameter, type = "xbar.one")
```




```
## List of 11
## $ call      : language qcc(data = pistonrings"..
## $ type      : chr "xbar.one"
## $ data.name : chr "pistonrings$diameter"
## $ data      : num [1:200, 1] 74 74 74 74 74 ...
##   ..- attr(*, "dimnames")=List of 2
## $ statistics: Named num [1:200] 74 74 74 74 74..
##   ..- attr(*, "names")= chr [1:200] "1" "2" "3"..
## $ sizes     : int [1:200] 1 1 1 1 1 1 1 1 1 1 ..
## $ center    : num 74
## $ std.dev   : num 0.01
## $ nsigmas   : num 3
## $ limits    : num [1, 1:2] 74 74
##   ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"

# X-bar chart
qcc(my.groups, type = "xbar")
```

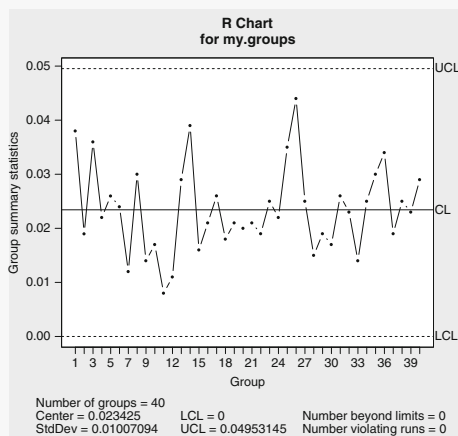


```
## List of 11
## $ call      : language qcc(data = my.groups, "..
## $ type      : chr "xbar"
## $ data.name : chr "my.groups"
## $ data      : num [1:40, 1:5] 74 74 74 74 74 ...
##   ..- attr(*, "dimnames")=List of 2
## $ statistics: Named num [1:40] 74 74 74 74 74 ..
##   ..- attr(*, "names")= chr [1:40] "1" "2" "3"..."
## $ sizes     : Named int [1:40] 5 5 5 5 5 5 5 5..
##   ..- attr(*, "names")= chr [1:40] "1" "2" "3"..."
```

```
## $ center      : num 74
## $ std.dev     : num 0.0101
## $ nsigmas     : num 3
## $ limits      : num [1, 1:2] 74 74
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"
```

Range chart

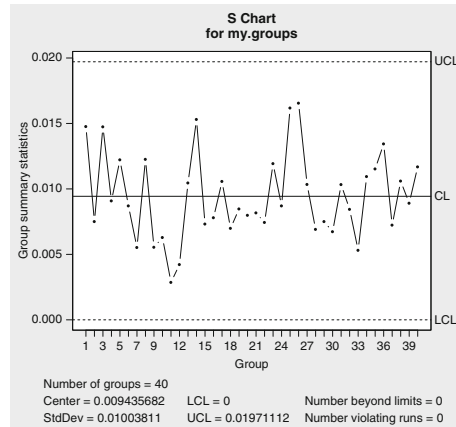
```
qcc(my.groups, type = "R")
```



```
## List of 11
## $ call       : language qcc(data = my.groups, "..
## $ type       : chr "R"
## $ data.name  : chr "my.groups"
## $ data       : num [1:40, 1:5] 74 74 74 74 74 ...
## ..- attr(*, "dimnames")=List of 2
## $ statistics: Named num [1:40] 0.038 0.019 0.0..
## ..- attr(*, "names")= chr [1:40] "1" "2" "3"..
## $ sizes      : Named int [1:40] 5 5 5 5 5 5 5..
## ..- attr(*, "names")= chr [1:40] "1" "2" "3"..
## $ center     : num 0.0234
## $ std.dev    : num 0.0101
## $ nsigmas    : num 3
## $ limits     : num [1, 1:2] 0 0.0495
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"
```

S chart

```
qcc(my.groups, type = "S")
```



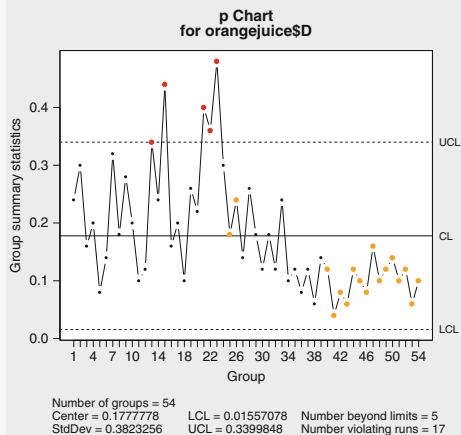
```
## List of 11
## $ call      : language qcc(data = my.groups, "...
## $ type      : chr "S"
## $ data.name : chr "my.groups"
## $ data      : num [1:40, 1:5] 74 74 74 74 74 ...
## ..- attr(*, "dimnames")=List of 2
## $ statistics: Named num [1:40] 0.01477 0.0075 ..
## ..- attr(*, "names")= chr [1:40] "1" "2" "3"..."
## $ sizes     : Named int [1:40] 5 5 5 5 5 5 5 5..
## ..- attr(*, "names")= chr [1:40] "1" "2" "3"..."
## $ center    : num 0.00944
## $ std.dev   : num 0.01
## $ nsigmas   : num 3
## $ limits    : num [1, 1:2] 0 0.0197
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"
```

Control charts for attributes:

```
# p chart
data(orangejuice)
str(orangejuice)

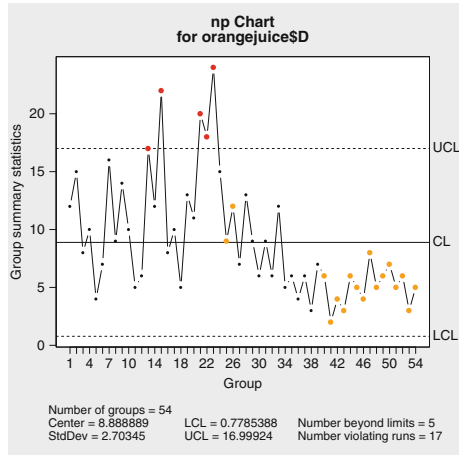
## 'data.frame': 54 obs. of 4 variables:
## $ sample: int 1 2 3 4 5 6 7 8 9 10 ...
## $ D : int 12 15 8 10 4 7 16 9 14 10 ...
## $ size : int 50 50 50 50 50 50 50 50 50 50 ...
## $ trial : logi TRUE TRUE TRUE TRUE TRUE TRUE ..

qcc(orangejuice$D, sizes = orangejuice$size,
    type = "p")
```



```
## List of 11
## $ call      : language qcc(data = orangejuice"..
## $ type      : chr "p"
## $ data.name : chr "orangejuice$D"
## $ data      : int [1:54, 1] 12 15 8 10 4 7 16 ..
## ..- attr(*, "dimnames")=List of 2
## $ statistics: Named num [1:54] 0.24 0.3 0.16 0..
## ..- attr(*, "names")= chr [1:54] "1" "2" "3".."
## $ sizes     : int [1:54] 50 50 50 50 50 50 50 ..
## $ center    : num 0.178
## $ std.dev   : num 0.382
## $ nsigmas   : num 3
## $ limits    : num [1, 1:2] 0.0156 0.34
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"

# np chart
qcc(orangejuice$D, sizes = orangejuice$size,
    type = "np")
```

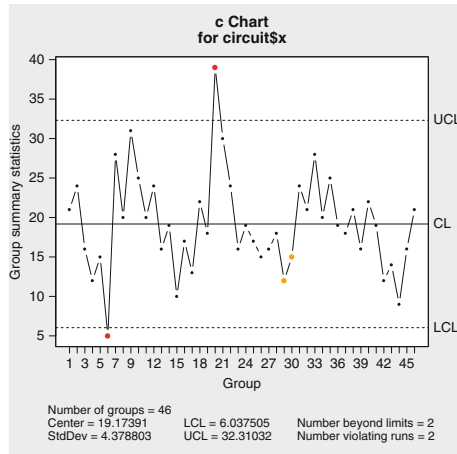


```
## List of 11
## $ call      : language qcc(data = orangejuice"..
## $ type      : chr "np"
## $ data.name : chr "orangejuice$D"
## $ data      : int [1:54, 1] 12 15 8 10 4 7 16 ..
## ..- attr(*, "dimnames")=List of 2
## $ statistics: Named int [1:54] 12 15 8 10 4 7 ..
## ..- attr(*, "names")= chr [1:54] "1" "2" "3".."
## $ sizes     : int [1:54] 50 50 50 50 50 50 50 ..
## $ center    : num 8.89
## $ std.dev   : num 2.7
## $ nsigmas   : num 3
## $ limits    : num [1, 1:2] 0.779 16.999
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"

# chart for counts
data(circuit)
str(circuit)

## 'data.frame': 46 obs. of 3 variables:
## $ x      : int  21 24 16 12 15 5 28 20 31 25 ...
## $ size   : int  100 100 100 100 100 100 100 100 ..
## $ trial: logi  TRUE TRUE TRUE TRUE TRUE TRUE ...

qcc(circuit$x, sizes = circuit$size, type = "c")
```

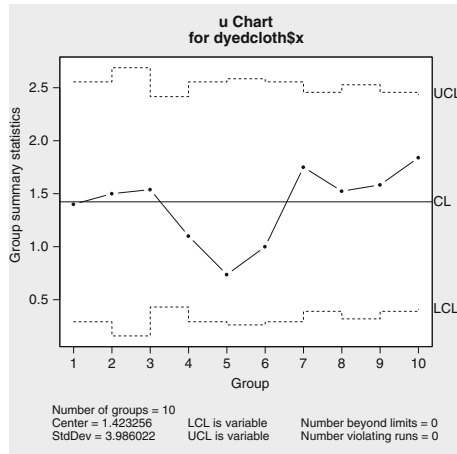


```
## List of 11
## $ call      : language qcc(data = circuit$x, "..
## $ type      : chr "c"
## $ data.name : chr "circuit$x"
## $ data      : int [1:46, 1] 21 24 16 12 15 5 2..
## ..- attr(*, "dimnames")=List of 2
## $ statistics: Named int [1:46] 21 24 16 12 15 ..
## ..- attr(*, "names")= chr [1:46] "1" "2" "3".."
## $ sizes     : int [1:46] 100 100 100 100 100 1..
## $ center    : num 19.2
## $ std.dev   : num 4.38
## $ nsigmas   : num 3
## $ limits    : num [1, 1:2] 6.04 32.31
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"

# Chart for counts per unit
data(dyedcloth)
str(dyedcloth)

## 'data.frame': 10 obs. of 2 variables:
## $ x : int 14 12 20 11 7 10 21 16 19 23
## $ size: num 10 8 13 10 9.5 10 12 10.5 12 12.5

qcc(dyedcloth$x, sizes = dyedcloth$size, type = "u")
```



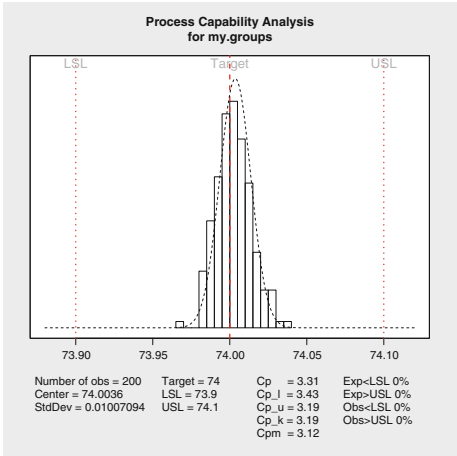
```
## List of 11
## $ call      : language qcc(data = dyedcloth$x"..
## $ type      : chr "u"
## $ data.name : chr "dyedcloth$x"
## $ data      : int [1:10, 1] 14 12 20 11 7 10 2..
## ..- attr(*, "dimnames")=List of 2
## $ statistics: Named num [1:10] 1.4 1.5 1.538 1..
## ..- attr(*, "names")= chr [1:10] "1" "2" "3".."
## $ sizes     : num [1:10] 10 8 13 10 9.5 10 12 ..
## $ center    : num 1.42
## $ std.dev   : num 3.99
## $ nsigmas   : num 3
## $ limits    : num [1:10, 1:2] 0.291 0.158 0.43..
## ..- attr(*, "dimnames")=List of 2
## $ violations:List of 2
## - attr(*, "class")= chr "qcc"
```

Process Capability

qcc Package

process.capability Needs a qcc object

```
my.qcc <- qcc(my.groups, type = "xbar", plot = FALSE)
process.capability(my.qcc,
  spec.limits = c(73.9, 74.1),
  target = 74)
```

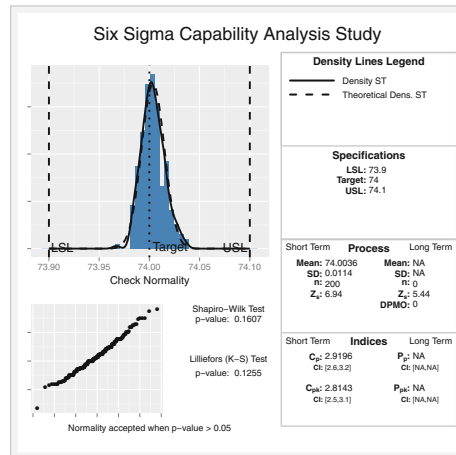


```
##
## Process Capability Analysis
##
## Call:
## process.capability(object = my.qcc, spec.limits
##   = c(73.9, 74.1), target = 74)
##
## Number of obs = 200                    Target = 74
##           Center = 74                    LSL = 73.9
##           StdDev = 0.01007                USL = 74.1
##
## Capability indices:
##
##           Value    2.5%   97.5%
## Cp        3.310   2.985   3.635
## Cp_l      3.429   3.144   3.715
## Cp_u      3.191   2.925   3.456
## Cp_k      3.191   2.874   3.507
## Cpm      3.116   2.794   3.438
##
## Exp<LSL 0%    Obs<LSL 0%
## Exp>USL 0%    Obs>USL 0%
```


SixSigma Package

`ss.study.ca` Returns graphical and numerical capability analysis

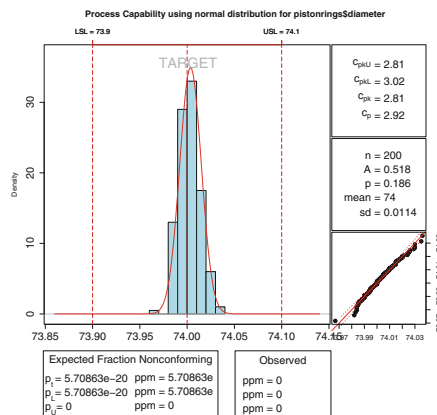
```
ss.study.ca(pistonrings$diameter,
            LSL = 73.9, USL = 74.1, Target = 74)
```



qualityTools Package

`cp` Process capability indices

```
library(qualityTools)
cp(x = pistonrings$diameter,
   lsl = 73.9, usl = 74.1,
   target = 74)
```



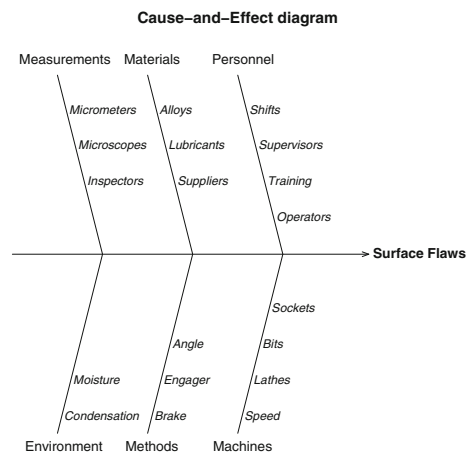
```
##
##  Anderson Darling Test for normal
##  distribution
##
## data:  pistonrings$diameter
## A = 0.5181, mean = 74.004, sd = 0.011,
## p-value = 0.1862
## alternative hypothesis: true distribution is not
##        equal to normal
```

Pareto Analysis

qcc Package

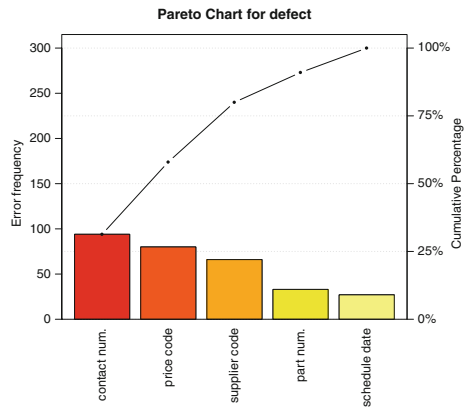
cause.and.effect Cause-and-effect analysis

```
cause.and.effect(cause = list(
  Measurements=c("Micrometers", "Microscopes",
    "Inspectors"),
  Materials=c("Alloys", "Lubricants",
    "Suppliers"),
  Personnel=c("Shifts", "Supervisors",
    "Training", "Operators"),
  Environment=c("Condensation", "Moisture"),
  Methods=c("Brake", "Engager", "Angle"),
  Machines=c("Speed", "Lathes", "Bits",
    "Sockets")),
  effect = "Surface Flaws")
```



pareto.chart Pareto Chart

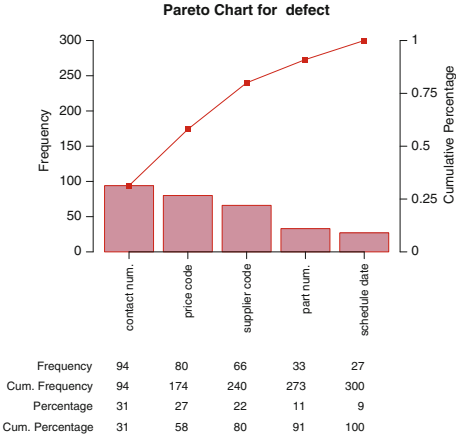
```
defect <- c(80, 27, 66, 94, 33)
names(defect) <- c("price code", "schedule date",
  "supplier code", "contact num.", "part num.")
pareto.chart(defect, ylab = "Error frequency")
```



```
##
## Pareto chart analysis for defect
##           Frequency Cum.Freq. Percentage
## contact num.           94          94    31.33333
## price code             80         174    26.66667
## supplier code          66         240    22.00000
## part num.              33         273    11.00000
## schedule date          27         300     9.00000
##
## Pareto chart analysis for defect
##           Cum.Percent.
## contact num.    31.33333
## price code      58.00000
## supplier code   80.00000
## part num.       91.00000
## schedule date  100.00000
```

qualityTools Package**paretoChart** Pareto chart

```
paretoChart(defect, las = 2)
```



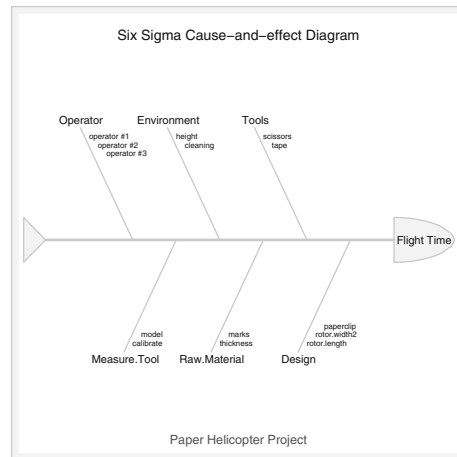
```
##
## Frequency          94      80      66      33      27
## Cum. Frequency     94     174     240     273     300
## Percentage         31.3%  26.7%  22.0%  11.0%   9.0%
## Cum. Percentage    31.3%  58.0%  80.0%  91.0%  100.0%
##
## Frequency          94.00000  80.00000  66  33  27
## Cum. Frequency     94.00000 174.00000 240 273 300
## Percentage         31.33333  26.66667  22  11  9
## Cum. Percentage    31.33333  58.00000  80  91 100
```

SixSigma Package

ss.ceDiag Cause-and-effect diagram

```
effect <- "Flight Time"
causes.gr <- c("Operator", "Environment", "Tools",
              "Design", "Raw.Material", "Measure.Tool")
causes <- vector(mode = "list",
                 length = length(causes.gr))
causes[1] <- list(c("operator #1", "operator #2",
                  "operator #3"))
causes[2] <- list(c("height", "cleaning"))
causes[3] <- list(c("scissors", "tape"))
causes[4] <- list(c("rotor.length", "rotor.width2",
                  "paperclip"))
causes[5] <- list(c("thickness", "marks"))
causes[6] <- list(c("calibrate", "model"))
```

```
ss.ceDiag(effect, causes.gr, causes,
  sub = "Paper Helicopter Project")
```



Probability

p* Distribution function for a given value

```
pnorm(q = 8, mean = 10, sd = 1)
## [1] 0.02275013
## help("distributions") for further distributions
```

q* Quantile for a given cumulative probability probabilidad «>= qnorm(p = 0.95, mean = 10, sd = 1) @

d* Density for a given value (probability in discrete distributions)

```
dpois(2, lambda = 3)
## [1] 0.2240418
```

Objects

str Get the structure of an object

```
str(log)
## function (x, base = exp(1))
str(xgl)
## Factor w/ 3 levels "A","B","C": 1 1 2 2 3 3
```

class Get the class of an object

```
class(xgl)

## [1] "factor"
```

is.* Return a logic value TRUE if the object is of the specified class, for example, numeric

as.* Coerce to the specified class

```
as.character(1:3)

## [1] "1" "2" "3"

as.data.frame(A)

##      col1 col2
## 1      1    3
## 2      2    4
```

Vectorized Functions

tapply Apply a function to values for each level of a factor

```
tapply(pistonrings$diameter, pistonrings$trial,
summary)

## $`FALSE`
##      Min. 1st Qu.  Median    Mean 3rd Qu.    Max.
##  73.98   74.00   74.00   74.01   74.02   74.04
##
## $`TRUE`
##      Min. 1st Qu.  Median    Mean 3rd Qu.    Max.
##  73.97   73.99   74.00   74.00   74.01   74.03
```

lapply Apply a function to each element of a list returning a list

```
lapply(1:3, factorial)
```

```
## [[1]]
## [1] 1
##
## [[2]]
## [1] 2
##
## [[3]]
## [1] 6
```

sapply Apply a function to each element of a list returning a list, vector, or matrix

```
sapply(1:3, factorial)

## [1] 1 2 6
```

apply Apply a function to the rows or columns of a matrix

```
apply(A, 1, median)

## [1] 2 3
```

split Divide an object over factor levels returning a list

```
groups <- split(pistonrings$diameter, pistonrings$
  trial)
str(groups)

## List of 2
## $ FALSE: num [1:75] 74 74 74 74 74 ...
## $ TRUE : num [1:125] 74 74 74 74 74 ...
```

mapply Multivariate version of sapply

```
mapply(rep, 1:4, 4:1)

## [[1]]
## [1] 1 1 1 1
##
## [[2]]
## [1] 2 2 2
##
## [[3]]
## [1] 3 3
##
## [[4]]
## [1] 4
```

rapply Recursive version of **lapply**

```
X <- list(list(a = pi, b = list(c = 1:1)), d =
  "a test")
rapply(X, sqrt, classes = "numeric", how = "replace")

## [[1]]
## [[1]]$a
## [1] 1.772454

##
## [[1]]$b
## [[1]]$b$c
## [1] 1
##
##
##
## $d
## [1] "a test"
```

Programming

for Loop over the values of a vector or list

```
x <- numeric()
for (i in 1:3){
  x[i] <- factorial(i)
}
x

## [1] 1 2 6
```

if...else Control flow

```
if (is.numeric(x)) {
  cat("Is numeric")
} else if (is.character(x)) {
  cat("Is character")
} else {
  cat("Is another thing")
}

## Is numeric
```


function Create functions

```
# Function that computes the difference between
two vectors' means
mifunction <- function(x, y){
  mean(x) - mean(y)
}
mifunction(1:10, 11:20)

## [1] -10
```

Useful functions within a function:

```
warning warning("This is a warning")
## Warning: This is a warning
```

```
message message("This is a message")
## This is a message
```

stop Stops the execution of code

```
stop("An error occurs")
## Error in eval(expr, envir, enclos): An error occurs
```

Reports**xtable** Package

xtable Create tables in different formats, e.g., \LaTeX , HTML

```
caption Table caption
label Table label
align Alignment
digits Number of significant digits
display Format (see ?xtable)
```

More options can be passed to the print generic function `?print.xtable`

```
library(xtable)
xtable(A)
```

	col1	col2
1	1	3
2	2	4

Package **knitr**

knitr Converts Rmd, Rhtml and Rnw files into HTML, MS Word o PDF reports.

See documentación at <http://yihui.name/knitr/>.

Main options in a code chunk header:

echo Show code in the report
error Show error messages in the report
warning Show warning messages in the report
message Show messages in the report
eval Evaluate the chunk
fig.align Figure alignment
fig.width Figure width (in inches, 7 by default)
fig.height Figure height (in inches, 7 by default)
out.width Figure width within the report
out.height Figure height within the report
fig.keep Keep plots in the report
include Show text output in the report
results How to show the reports

Useful Links

- R-Project: <http://www.r-project.org>
- RStudio: <http://www.rstudio.com>
- Easy R practice: <http://tryr.codeschool.com/>
- List of colours with names: <http://www.stat.columbia.edu/~tzheng/files/Rcolor.pdf>
- <http://www.cyclismo.org/tutorial/R/>
- <http://www.statmethods.net/index.html>
- *Recipes*: <http://www.cookbook-r.com/>
- Search documentation: <http://www.rdocumentation.org/>
- http://www.computerworld.com/s/article/9239625/Beginner_s_guide_to_R_Introduction
- <http://www.inside-r.org/>
- <http://www.r-bloggers.com/>
- Google R styleguide: <http://google-styleguide.googlecode.com/svn/trunk/Rguide.xml>
- Book *Six Sigma with R*: www.sixsigmawithr.com

R Packages and Functions Used in the Book

Symbols

., 52
., 52
<-, 51
>, 53
[, 54, 59, 64
[[, 61
\$, 61, 64

A

AcceptanceSampling, 88, 208, 217
 assess, 209
 find.plan, 88, 209, 214, 216
 OC2c, 208, 217

B

base, 86
 anyNA, 80, 82
 array, 60
 as.Date, 73, 82
 as.numeric, 72
 c, 52, 95
 class, 51, 72
 colMeans, 60
 colnames, 59, 66
 cut, 157, 162
 data.frame, 63, 97, 133, 147, 169
 detach, 48
 diff, 161
 dir, 46
 exp, 38
 expression, 21, 103

factor, 54, 153
format, 74
getwd, 46
gl, 54
grep, 135
is.na, 70, 79
is.numeric, 72
length, 54, 157, 191, 227
library, 21, 48
list, 60, 158
list.dirs, 46
list.files, 46
load, 44, 84
log, 38
ls, 44, 52
matrix, 58, 255
max, 157
mean, 57, 70, 80, 86, 156, 190, 215, 228, 255
names, 54, 157, 249
ncol, 65
nrow, 65
options, 40
order, 57, 66, 73, 74, 107
paste, 66
range, 161
rbind, 97, 133
rep, 52, 111, 114, 196
require, 48
rev, 57
rm, 44
RNG, 133
round, 157, 214
rownames, 59, 66

base (*cont.*)

- rowSums, 60
- sample, 56, 68, 189, 191
- sapply, 134
- save, 44, 84
- save.image, 44
- scan, 51
- search, 48
- seq, 39, 52
- seq_along, 53
- set.seed, 56, 68, 113, 189, 191, 214, 255
- setwd, 46
- sort, 57
- source, 41, 83, 98
- sqrt, 58
- strsplit, 134
- subset, 67, 190, 192
- sum, 53, 227
- summary, 79, 80, 86, 162, 248, 259
- table, 82, 86, 157, 162, 191
- tapply, 156, 161
- typeof, 50
- unlist, 134
- which, 82

C

- car, 172
 - bcPower, 173
 - powerTransform, 172
- constants
 - LETTERS, 54
 - letters, 54
 - pi, 38

D

- Deducer, 32

F

- foreign, 85

G

- ggplot2, 43, 86, 104
 - geom_boxplot, 114
 - geom_histogram, 104
 - geom_point, 114
 - ggplot, 104
 - labs, 104
- graphics, 43, 86
 - abline, 21, 150, 158
 - barplot, 86, 107

- boxplot, 86, 114, 154, 155
- curve, 86
- hist, 86, 102, 103, 148, 158, 227
- legend, 158
- lines, 86
- par, 103, 255, 257
- plot, 86, 113, 150, 158, 248, 255, 257
- points, 86
- polygon, 86
- rect, 86
- text, 21, 86
- grDevices, 42
- grid, 43, 86

H

- h5, 85
- Hmisc, 176
 - binconf, 177, 182

I

- IQCC, 87
- ISOweek, 90

K

- knitr, 23, 88

L

- lattice, 43, 86, 103, 148, 152, 224
 - bwplot, 114, 155
 - dotplot, 153, 224
 - histogram, 103, 148
 - llines, 153
 - panel.dotplot, 153
 - panel.superpose, 153
 - trellis.par.get, 104
 - trellis.par.set, 104, 148
 - xyplot, 104, 114

M

- MASS, 171
 - boxcox, 171
- MSQC, 87

N

- nortest, 227
 - ad.test, 227

Q

- qcc, 19, 51, 94, 101, 170, 196, 232, 247, 263
 - cause.and.effect, 86, 95
 - cusum, 87, 259

- ewma, 87, 261
- mqcc, 87
- oc.curves, 87, 196, 251
- pareto.chart, 86, 107
- process.capability, 87, 232
- qcc, 21, 87, 101, 170, 173, 196, 232, 248, 254, 255, 257, 263, 266
- qcc.groups, 87, 196, 232, 247
- qcc.options, 250
- summary.qcc, 101
- qcr, 87
- qicharts, 111
 - paretochart, 86, 111
- qic, 87
- trc, 87
- qualityTools, 234
 - cp, 87
 - paretoChart, 86, 109

R

- Rcmdr, 32
- RJDBC, 85
- RMongo, 85
- RMySQL, 85
- RODBC, 85
- ROracle, 85
- RPostgreSQL, 85
- RSQLite, 85
- rvest, 135
 - html, 135
 - html_nodes, 135
 - html_text, 135

S

- SixSigma, 94, 147, 189, 234, 272, 285
 - climProfiles, 277, 279
 - outProfiles, 278–280
 - plotControlProfiles, 283
 - plotProfiles, 273–275, 277, 281, 282
 - smoothProfiles, 273, 275
 - ss.ca.cp, 87
 - ss.ca.cpk, 87
 - ss.ca.study, 87
 - ss.ca.z, 87
 - ss.cc, 87
 - ss.cc.getc4, 285
 - ss.cc.getd2, 285
 - ss.cc.getd3, 285
 - ss.ceDiag, 86, 96
 - ss.data.bills, 189
 - ss.data.wbx, 272, 273
 - ss.data.wby, 272, 273

- special values, 69
 - FALSE, 53
 - i, 71
 - Inf, 70
 - LETTERS, 71
 - letters, 71
 - month.abb, 71
 - month.name, 71
 - NA, 69, 98
 - NaN, 71
 - NULL, 68
 - pi, 71
 - TRUE, 53
- stats, 86
 - aggregate, 67, 246, 263, 266
 - anova, 86
 - arima, 86
 - bartlett.test, 180
 - binom.test, 177, 182
 - chisq.test, 180
 - coef, 172
 - complete.cases, 80
 - cov, 86
 - dbinom, 166
 - dhyper, 164
 - dnorm, 86
 - dpois, 167
 - dypcr, 165
 - IQR, 162
 - lm, 86
 - mad, 162
 - median, 86
 - pbinom, 166
 - phyper, 164
 - pnorm, 86, 168, 228
 - poisson.test, 180
 - ppois, 167
 - prop.test, 176, 182
 - qbinom, 166
 - qchisq, 179
 - qhyper, 164
 - qnorm, 86, 168
 - qpois, 167
 - qqline, 183, 184
 - qqnorm, 183, 184
 - quantile, 162
 - rbinom, 166
 - rhyper, 164
 - rnorm, 40, 86, 113, 168, 214
 - rpois, 167
 - sd, 86, 160, 228
 - shapiro.test, 183
 - t.test, 178, 181
 - ts, 86

stats (*cont.*)

var, 86, 160

var.test, 181

weighted.mean, 192

T

tolerance, 87, 88

acc.samp, 88

U

utils

apropos, 49, 72

available.packages, 48

browseVignettes, 49

demo, 49, 87

download.file, 76

example, 49

head, 224

help, 39

history, 43

install.packages, 48

installed.packages, 48

loadhistory, 43

read.csv, 78

read.table, 78

remove.packages, 48

savehistory, 43

str, 38, 44, 52, 59, 62, 64, 73, 133, 224

Sweave, 88

vignette, 49, 286

write.csv, 83

X

XLConnect, 85

XML, 85, 133

xmlSApply, 133

xmlTreeParse, 133

xpathApply, 133

xtable, 98

print.xtable, 98

xtable, 98

ISO Standards Referenced in the Book

I

- ISO 10576-1:2003, 27, 130, 290
- ISO 10725:2000, 130, 290
- ISO 11095:1996, 130, 290
- ISO 11453:1996, 126, 185, 287
- ISO 11453:1996/Cor 1:1999, 126, 287
- ISO 11462-1, 269
- ISO 11462-1:2001, 27, 127, 288
- ISO 11462-2, 117
- ISO 11462-2:2010, 198, 288
- ISO 11648-1:2003, 130, 290
- ISO 11648-2:2001, 130, 290
- ISO 11843-1:1997, 130, 290
- ISO 11843-2:2000, 130, 290
- ISO 11843-3:2003, 130, 290
- ISO 11843-4:2003, 130, 290
- ISO 11843-5:2008, 130, 283, 291
- ISO 11843-6:2013, 130, 291
- ISO 11843-7:2012, 130, 291
- ISO 12207:2008, 90
- ISO 13053-1, 115
- ISO 13053-1:2011, 131, 291
- ISO 13053-2, 94, 97, 116, 117
- ISO 13053-2:2011, 131, 291
- iso 13179-1:2012, 283
- ISO 13448-1:2005, 128, 289
- ISO 13448-2:2004, 128, 289
- ISO 14560:2004, 129, 289
- ISO 15746-1:2015, 283
- ISO 16269-4:2010, 81, 82, 90, 126, 186, 287
- ISO 16269-6:2014, 126, 287
- ISO 16269-7:2001, 126, 287
- ISO 16269-8:2004, 126, 287
- ISO 16336:2014, 132, 234, 292
- ISO 17258:2015, 132, 291
- ISO 18414:2006, 129, 289
- ISO 19011:2011, 122
- ISO 21247:2005, 129, 289
- ISO 21748:2010, 130, 291
- ISO 22514-1:2014, 27, 127, 234, 288
- ISO 22514-2:2013, 128, 235, 288
- ISO 22514-3:2008, 128, 288
- ISO 22514-6:2013, 128, 235, 288
- ISO 22514-7:2012, 128, 235, 289
- ISO 22514-8:2014, 128, 235, 289
- ISO 24153:2009, 129, 197, 198, 219, 289
- ISO 2602:1980, 126, 184, 287
- ISO 2854:1976, 126, 185, 287
- ISO 2859-10:2006, 129, 289
- ISO 2859-1:1999, 129, 217, 289
- ISO 2859-1:1999/Amd 1:2011, 129, 289
- ISO 2859-3:2005, 129, 218, 289
- ISO 2859-4:2002, 129, 289
- ISO 2859-5:2005, 129, 218, 289
- ISO 28640, 133
- ISO 28640:2010, 90, 126, 190, 287
- ISO 28801:2011, 129, 290
- ISO 3301:1975, 126, 185, 288
- ISO 3494:1976, 126, 185, 288
- ISO 3534-1, 116
- ISO 3534-1:2006, 27, 127, 135, 170, 186, 198, 219, 235, 269, 288
- ISO 3534-2, 117
- ISO 3534-2:2006, 27, 127, 198, 219, 235, 269, 288
- ISO 3534-3:2013, 127, 288
- ISO 3534-4, 117
- ISO 3534-4:2014, 127, 198, 219, 288
- ISO 3951-1:2013, 129, 218, 290
- ISO 3951-2:2013, 129, 218, 290

- ISO 3951-3:2007, 129, 218, 290
ISO 3951-4:2011, 129, 290
ISO 3951-5:2006, 129, 218, 290
ISO 5479:1997, 126, 185, 288
ISO 5725-1:1994, 27, 130, 291
ISO 5725-2:1994, 130, 291
ISO 5725-3:1994, 131, 291
ISO 5725-4:1994, 131, 291
ISO 5725-5:1998, 131, 291
ISO 5725-6:1994, 131, 291
ISO 7870-1, 116, 269
ISO 7870-1:2014, 27, 128, 289
ISO 7870-2, 116, 269
ISO 7870-2:2013, 27, 128, 198, 283, 289
ISO 7870-3, 116, 269
ISO 7870-3:2012, 128, 289
ISO 7870-4, 116, 269
ISO 7870-4:2011, 128, 289
ISO 7870-5, 116, 269
ISO 7870-5:2014, 128, 283, 289
ISO 8422:2006, 129, 290
ISO 8423:2008, 129, 290
ISO 8601:2004, 90
ISO 9000:2005, 121
ISO 9001:2008, 121
ISO 9004:2009, 121
ISO FDIS 7870-6, 117
ISO.16336:2014, 222
ISO.22514-3:2008, 235
ISO/DIS 22514-4, 226, 228, 235
ISO/IEC 14882:2014, 133
ISO/IEC 9899, 133
ISO/TR 12845, 132
ISO/TR 12845:2010, 132, 291
ISO/TR 12888, 132
ISO/TR 12888:2011, 132, 291
ISO/TR 13519:2012, 126, 288
ISO/TR 13587:2012, 131, 291
ISO/TR 14468:2010, 132, 292
ISO/TR 18532:2009, 126, 288
ISO/TR 22514-4:2007, 128, 226, 228, 235, 289
ISO/TR 29901, 132
ISO/TR 29901:2007, 132, 292
ISO/TR 29901:2007/Cor 1:2009, 132, 292
ISO/TS 21749:2005, 131, 291
ISO/TS 28037:2010, 131, 291

Subject Index

Symbols

- C_p , 231
- C_{pkL} , 231
- C_{pkU} , 231
- C_{pk} , 231
- C_{pmk} , 232
- $F(x)$, 163
- H_0 , 179, 194
- H_1 , 179, 194
- P_p , 228
- P_{pkL} , 229
- P_{pkU} , 229
- P_{pk} , 229
- Q_1 , 154, 161
- Q_2 , 161
- Q_3 , 154, 161
- α , 176, 180, 194, 205, 211, 212, 226, 229
- \bar{x} , 16, 211
- β , 194, 206, 211, 212, 242
- χ^2 , 179
- δ , 195, 207
- γ , 195
- λ , 167, 171, 261
- μ , 6, 16, 163, 168, 226, 229, 231, 241
- $\bar{\bar{x}}$, 246
- \bar{x} , 156, 214, 231, 246
- σ , 6, 16, 211, 226, 229, 245
- σ^2 , 159, 163, 168
- σ_{ST} , 231
- θ , 176
- c_4 , 160, 245, 285
- d_2 , 16, 160, 245, 256, 257, 285
- d_3 , 257, 285
- $f(x)$, 168
- p -value, 180
- s^2 , 159
- LaTeX, 23, 88
- FDIS*, 117
- IDE*, 32
- MDB*, 32
- D_3 , 253
- D_4 , 253
- d_2 , 253
- d_3 , 253
- ANOVA, 86
- ANSI, 119
- AQL*, 205, 211, 213, 217
- ARL*, 241
- BSI*, 119
- CD*, 124
- CLI*, 31
- CL*, 240, 246, 253, 254, 257, 259, 260, 262–264, 266, 268
- CRAN, 9, 47, 85
- CSV, 75
- DBMS*, 8
- DFSS*, 222
- DIS*, 124, 132, 222
- DMAIC*, 116
- DPMO*, 226
- DoE*, 242
- EWMA*, 117, 260
- FAQ*, 13
- FDA*, 90
- FDIS*, 124
- FOSS*, 8, 30, 85
- GUI*, 11, 31, 36, 41, 43
- HTML*, 135
- ICS*, 133
- IEC*, 90, 122

IQR, 161
ISO, 27, 89
JTC, 90, 133
LCL, 7, 195, 221, 240, 246, 253, 254, 257, 259, 260, 262, 263, 265, 266, 268
LL, 175
LSL, 211, 221
LTPD, 206, 211, 213, 217
LT, 228, 230, 231
MAD, 161
MR, 16, 256
NCD, 195
NP, 123
OBP, 133
OC, 87, 194, 204, 211, 241
ODBC, 85
OS, 8, 19
PAS, 120, 123
PLC, 75
PMBok, 115
PWI, 123
QFD, 222
RCA, 116
RNG, 56
RPD, 222
RSS, 133
RUG, 10
R, 161
SC, 122
SDLC, 90
SME, 9
SPC, 117, 239, 271, 282
SR, 124
SVM, 273
TC, 27, 119, 122, 133
TMB, 119, 120
TR, 120, 122, 127
TS, 120, 123
UCL, 7, 195, 221, 240, 246, 253, 254, 257, 259, 260, 262, 263, 265, 266, 268
UL, 175
URL, 13
USL, 4, 211, 214, 221
VoC, 221
VoP, 221
WD, 124
WG, 120
XML, 85, 133
5Ms, 94

A

acceptability constant, 211, 212
 acceptance, 203

acceptance quality level, 205
 acceptance sampling, 85, 128, 203
 for attributes, 204
 for variables, 211
 AENOR, 119
 aggregate values, 66
 alternative hypothesis, 194
 Anderson-Darling test, 228
 anonymous function, 161
 argument, 38
 assignable causes, 239
 asymmetric, 146
 attribute, 261
 attributes control charts, 261
 average, 5, 57

B

bar chart, 146
 baseline profile, 275, 280
 Bernoulli trial, 165
 Big Data, 10
 binomial, 165
 binomial distribution, 262
 black belt, 116
 box plot, 114, 154, 158
 box-and-whisker plot, 154
 Box-Cox transformation, 171, 184
 brainstorming, 94, 116
 browser, 98

C

c chart, 264
 capability analysis, 8, 85, 87, 127, 221, 225
 capability index, 221, 231
 capability indices, 229, 230
 cause, 93
 cause-and-effect, 113
 cause-and-effect diagram, 86, 93, 97, 102, 105, 115
 center line, 150, 240
 central limit theorem, 168, 176, 178, 246
 central tendency, 156
 character, 50
 characteristic, 122, 163
 check sheet, 96, 105, 116
 chunk (code), 23
 class, 50, 162
 cluster, 193
 cluster sampling, 193
 column, 58, 65
 comment, 41
 common causes, 239, 242

complementary event, 165
confidence bands, 273, 280
confidence interval, 171, 172, 174, 178, 233, 240
confidence level, 175
consumer's risk, 206, 211
continuous distributions, 167
continuous scale, 167, 211
continuous variable, 243
control chart, 7, 8, 51, 85, 87, 100, 116, 127, 170, 193, 232, 239, 240, 242, 271
 constants, 16
 individuals, 21
control chart power, 242
control chart tests, 243
control chart zones, 243
control limits, 7, 16, 100, 195, 221, 225, 239, 240, 243, 273
cost of poor quality, 223
crossings, 151
csv file, 98
customer, 4
customer specification limit, 222
customer's risk, 217
CUSUM chart, 259
cusum coefficients, 259
cycle, 150

D

data, 8, 145
 acquisition, 8
 database, 8
 export, 8, 75
 raw data, 8
 treatment, 8
data acquisition, 96
data analysis, 8
data cleaning, 84
data collection plan, 97
data frame, 50, 63
data import, 75
data reuse, 97
data structures, 50
data transformation, 170
data type, 50, 72
database, 8
dataset, 50
date, 50
dates, 73
debugging, 10
decreasing, 57
defect, 4, 145

defect-free, 4
defective, 223
defective fraction, 205
defects, 265
defects per million opportunities, 226
defects per unit, 226
degrees of freedom, 178
density, 103, 164
design for six sigma, 222
design of experiments, 242
design specifications, 187
destructive test, 187
device, 42
dimension, 50
discrete distribution, 163
distribution, 102
 normal distribution, 5
distribution function, 164, 167, 168
distribution parameters, 174
distributions, 170
 binomial, 165, 176, 204, 211
 exponential, 169
 geometric, 166, 241
 hypergeometric, 164, 211
 lognormal, 169
 negative binomial, 166
 normal, 168, 188, 195, 211
 Poisson, 166, 188, 211
 uniform, 169
 Weibull, 169
double, 50
double sampling plan, 204

E

effect, 93, 94
environment, 44
error, 175, 188
error type I, 194
error type II, 194
escaping, 34
especial variability, 100
estimation, 163, 190, 193, 226, 243
estimator, 175, 231
event, 264
EWMA chart, 260
exclude, 55
expectation, 163, 175
expected value, 163
experimental design, 113
exploratory data analysis, 79
export graphics, 42
export data, 83
extract, 55, 59, 61

extraction, 82
extreme values, 161

F

factor, 50, 53, 77
files, 33
finite population, 164
first-time yield, 226
fishbone diagram, 93
fitness of use, 121
flow chart, 115
formula, 67, 114, 149
fraction defective, 204
frequency, 102, 146, 162
frequency table, 82, 158, 162
function, 38
functional tolerance, 224

G

global standard deviation, 256
goodness of fit, 174
graphical system, 42
graphics
 grid, 183, 184
 par, 148
graphics options, 103
green belt, 116
groups, 152, 154, 174

H

histogram, 102, 146, 158, 170
histogram bars, 105
history, 43
hypothesis test, 163, 179, 183, 193, 204, 226, 239, 241
hypothesis testing, 228

I

I Chart, 256
image, 43
import csv, 75
import data, 77
improvement, 93, 105, 121
in-control process, 100, 150, 226, 239, 259, 273
independent event, 164
independent samples, 258
independent trial, 165
index, 54
individuals chart, 256
individuals control chart, 170

inference, 163, 174, 179, 193, 226
inspection, 203
integer, 50
interface, 31
Internet, 8
interquartile range, 161
interval, 146, 158
interval estimation, 175
interview, 94
IQR, 154
Ishikawa diagram, 93
Ishikawa, Kaoru, 93
ISO, 217
ISO Council, 119
ISO members, 119
ISO website, 126

K

knit, 25

L

label, 54
larger-the-better, 222
Lean, 9, 26
length, 54
liaison, 123
liaisons, 120
 category A, 121
 category B, 121
 category D, 121
limits
 control limits, 7
 specification limits, 4
linear relation, 271
list, 50, 60, 101
location, 97
log-Likelihood, 171
logical, 50, 56
logical expressions, 37
long-term variation, 152, 228, 233
longest run, 151
Loss function analysis, 222
lot, 145, 203, 211
lower capability index, 231
lower control limit, 240
lower performance index, 229
lower specification limit, 221

M

manufacturing specification limit, 223
markdown, 23

matrix, 50, 58
 maximum, 154
 mean, 6, 156, 157, 159, 178, 229, 240
 mean tests, 180
 measure, 187
 measurement, 145
 measurement methods, 130
 mechanical devices, 198
 median, 150, 154, 157, 161
 median absolute deviation, 161
 Mersenne-Twister algorithm, 133
 minimum, 154
 minimum capability index, 231
 missing, 31
 missing values, 69, 78
 mode, 157
 model, 174
 moving range, 257
 moving Range chart, 256
 MR Chart, 256

N

names, 65
 national body, 119, 123, 124
 natural limits, 100, 221, 225, 239, 271
 natural variation, 228, 242
 nomilan-is-best, 222
 nominal values, 241
 nomogram, 206
 nomograph, 206
 non normality, 171
 non-random variation, 150
 nonlinear profile, 271
 nonlinearity, 283
 normal distribution, 113, 147, 170, 183, 195, 213, 226, 240, 241
 normality, 179, 183
 np chart, 263
 null hypothesis, 179, 194
 numeric, 50

O

O-member, 120
 object, 40, 50
 one-sided test, 180
 open source, 133
 operating characteristic, 204, 241
 operating characteristic curve, 87, 194
 operator, 94, 97
 optimization, 114
 order, 57
 order data frame, 66

out of control, 94
 out-of-control process, 150, 239, 243, 258, 273
 outlier, 78, 154, 156, 161

P

p chart, 262, 283
 P-member, 120, 123
 p-value, 228
 package, 47
 package installation, 47
 package update, 47
 panel (lattice), 149
 parameter, 227
 Pareto Analysis, 105
 Pareto chart, 86, 105
 partial matching, 38
 path, 34
 pattern, 8, 150, 243
 percentile, 213
 Phase I control charts, 240, 276
 Phase II control charts, 240, 280
 plot, 42
 lines, 22
 text, 22
 plots, 86
 point estimation, 174
 point estimator, 172
 Poisson distribution, 262, 264
 Poisson rate, 167
 poor quality, 222
 population, 159, 163, 164, 174, 187, 188, 193, 215, 226, 245
 population mixture, 114
 power, 193, 194
 predictive variable, 114, 271
 print, 99
 probability, 6–8
 probability distribution, 113, 145, 188, 204, 226, 227, 262
 probability distribution model, 163
 problem-solving techniques, 115
 procedure, 122
 process, 3, 5, 7, 146
 control, 16
 out of control, 4, 5, 8
 shift, 87
 process capability, 221
 process change, 240, 241
 process control, 127, 187
 process data, 226
 process map, 115
 process owner, 187
 process parameter, 187

process performance indices, 228
 process shift, 196, 242
 process tolerance, 222
 producer, 4
 producer's risk, 205, 211, 217
 product
 quality, 16
 profile, 271
 profiles control chart, 282
 programme of work, 123
 programming language, 8
 Ada, 133
 C, 133
 Fortran, 133
 Pascal, 133
 Prolog, 133
 Python, 133
 R, 133
 Ruby, 133
 proportion of defects, 226
 proportions test, 182
 prototype profile, 276
 pseudo-random numbers, 190

Q

quality
 characteristic, 16
 quality (definition), 121
 quality assurance, 122
 quality characteristic, 203, 211, 214, 222, 239, 261
 larger-the-better, 217
 nominal-is-best, 217
 smaller-the-better, 217
 quality control, 3, 121
 history, 3, 9
 plan, 8
 quality definition, 221
 quality function deployment, 222
 quality management systems, 122
 quantile, 176
 quantile function, 164
 quantile-quantile plot, 183
 quartile, 154, 161

R

R, 8, 17, 29
 CRAN, 13
 FAQ, 13
 foundation, 11
 base, 12, 23, 30
 code, 37

community, 10
 conferences, 12
 Console, 30
 console, 10, 35
 contributors, 11
 definition, 9
 documentation, 12
 environment, 35
 expression, 10, 30, 40
 Foundation, 30
 foundation, 10
 Help, 48
 history, 9, 35
 installation, 18
 interface, 10, 31
 journal, 12
 learning curve, 11
 libraries, 21
 mailing lists, 10
 manuals, 13
 markdown, 24, 98
 object, 40
 output, 37
 packages, 10, 14, 30
 programming language, 10
 R-core, 11, 30
 release, 12
 reports, 12
 script, 10, 20, 30
 scripts, 12
 session, 45
 source code, 13
 task views, 14
 website, 10, 12
 R Commander, 32
 R Chart, 252, 257
 R expression, 33
 random, 5, 56, 204
 random noise, 113
 random numbers, 188
 random sampling, 241
 random variable, 145, 163
 random variate, 133, 164, 189
 randomness, 242
 range, 245, 252
 Range chart, 231, 245, 252
 rare event, 166
 rational subgroups, 230, 241, 245, 256
 raw data, 84, 162
 recycling, 58
 reference interval, 231
 reference limits, 225, 226, 228
 regular expression, 135
 regularization, 273

rejection, 203
 rejection region, 180
 relative frequency, 162
 reliability, 169
 replace, 55
 replacement, 189
 representative sample, 188
 reproducible report, 23
 reproducible research, 12, 23, 30, 33, 97, 113
 requirement, 121, 122
 response, 172
 response variable, 114, 271
 reverse, 57
 risk management, 116
 robust parameter design, 222
 rolled throughput yield, 226
 row, 58, 65, 97
 RStudio, 17, 29, 34, 98

- help, 49
- installation, 18
- layout, 35
- plots, 42
- plots pane, 21
- source, 21
 - source editor, 20, 24, 40

run chart, 87, 115, 150

run tests, 152

S

S Chart, 231, 254
 sample, 16, 56, 174, 187, 203, 226, 229, 240, 243
 sample data, 163
 sample distribution, 212
 sample mean, 16, 156, 174
 sample size, 193, 196, 204, 211, 212, 241
 sample standard deviation, 245
 sample variance, 159
 sampling, 115, 187, 188, 241
 sampling distribution, 174, 175, 195, 234, 239, 246
 sampling frequency, 241
 sampling plans, 217
 scatter plot, 113
 script, 10, 83
 seasonality, 243
 secretariat (of a TC), 120
 seed, 113, 190
 sequence, 52
 Seven Quality Tools, 93
 Shapiro-Wilks test, 183
 Shewhart, 3

- constants, 285

Shewhart charts, 243
 Shewhart control charts, 258
 shift, 150, 243
 short-term variation, 152, 231, 233
 significance level, 180
 simple random sampling, 188
 simulation, 113
 single sampling plan, 204
 Six Sigma, 8, 115, 131
 skewness, 170
 smaller-the-better, 222
 smooth function, 273
 software, 8

- FOSS, 8
 - Apache, 8
 - C, 12
 - commercial software, 8
 - eclipse, 32
 - emacs, 32
 - Fortran, 12
 - freedoms, 9
 - Internet, 8
 - Java, 34
 - JMP, 132
 - LibreOffice, 23
 - licence, 8
 - Linux, 8, 9, 13, 17
 - mac, 9, 13, 17
 - Microsoft Office, 23
 - Minitab, 85, 132
 - MySQL, 8
 - open source, 9
 - pandoc, 23
 - php, 8
 - Python, 12, 41
 - R, 8
 - RStudio, 17
 - S, 9, 85
 - SAS, 85
 - source code, 9
 - SPSS, 85
 - Stata, 85
 - statistical software, 8
 - support, 9
 - Systat, 85
 - Ubuntu, 8
 - Windows, 9, 13, 17

sort, 57

source files, 98

special causes, 233, 242

special values, 69

specification, 203

specification limit, 212

specification limits, 4, 100, 221, 222, 225–228

specification tolerance, 229, 231
 specifications, 221
 specifications design, 221
 specifications limits, 240
 spreadsheet, 8, 75, 98
 standard, 8
 standard development, 124
 standard deviation, 5, 6, 160, 215, 229, 240, 243
 Standard deviation chart, 254
 standard errors, 259
 standard normal distribution, 176
 standard stages, 222
 standards, 27
 standards development, 122
 standards maintenance, 123
 statistic, 174, 180, 239
 statistical software, 132
 strata, 191
 stratification, 114, 117, 157, 191
 stratified sampling, 191
 Student's *t*, 178
 Sturges, 158
 subgroup, 150
 subprocess, 115
 subset data frame, 66
 summary
 mean, 80
 summary statistic, 240
 support vector machines, 273, 283
 system locale, 76
 systematic sampling, 193

T

Taguchi capability index, 232
 Taguchi loss function, 222
 tally sheet, 97
 target, 222, 229
 task view, 85
 TC/69 Secretariat, 125
 TC69, 126
 TC69/AHG1, 126
 TC69/SC1, 126, 127
 TC69/SC1/WG2, 127
 TC69/SC1/WG5, 127
 TC69/SC1/WG6, 127
 TC69/SC4, 126, 127
 TC69/SC4/WG10, 127
 TC69/SC4/WG11, 127
 TC69/SC4/WG12, 127
 TC69/SC5, 126, 128

TC69/SC5/WG10, 128
 TC69/SC5/WG2, 128
 TC69/SC5/WG3, 128
 TC69/SC5/WG8, 128
 TC69/SC6, 126, 130
 TC69/SC6/WG1, 130
 TC69/SC6/WG5, 130
 TC69/SC6/WG7, 130
 TC69/SC6/WG9, 130
 TC69/SC7, 126, 131, 132
 TC69/SC7/AHG1, 131
 TC69/SC7/WG1, 131
 TC69/SC7/WG2, 131
 TC69/SC7/WG3, 131
 TC69/SC8, 126, 132
 TC69/SC8/WG1, 132
 TC69/SC8/WG2, 132
 TC69/SC8/WG3, 132
 TC69/WG3, 126
 tendency, 5
 terminology, 127
 tier chart, 152
 time series, 150
 time-dependent process, 258
 tolerance limits, 221
 trend, 150, 243
 trivial causes, 105
 two-sided test, 180

U

u chart, 265
 unbiased estimator, 245
 unbiasedness, 175
 upper capability index, 231
 upper control limit, 240
 upper performance index, 229
 upper specification limit, 221

V

variability, 122, 145, 159, 243
 variable, 50, 77, 145, 203, 240
 categorical, 157
 continuous, 145, 154
 discrete, 145, 162
 qualitative, 145
 quantitative, 145
 variables control charts, 243
 variables relation, 113
 variance, 159, 163, 178, 195
 variance tests, 181

- variation, 4
 - assignable cause, 7, 8
 - assignable causes, 5
 - assignable variation, 5
 - causes, 5
 - chance variation, 5, 8
 - common causes, 5
 - special causes, 5
- vector, 50, 51, 53, 94
- vectorized functions, 161
- vignette, 49
- vital causes, 105
- voice of stakeholders, 221
- voice of the customer, 221, 222
- voice of the process, 221, 225
- VoS, 221

W

- WD, 120
- webscrapping, 135
- weighted mean, 192
- weighted moving average, 260
- Wikipedia, 8
- working directory, 19, 34, 37, 45, 76
- workspace, 44

X

- x-bar chart, 194, 245, 246

Y

- yield, 226