

## *Measurement System Analysis Reference Manual 4th Edition*

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This Reference Manual was developed by a Measurement Systems Analysis (MSA) Work Group, sanctioned by the Chrysler Group LLC, Ford Motor Company, and General Motors Corporation Supplier Quality Requirements Task Force, and under the auspices of the Automotive Industry Action Group (AIAG).

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$x = 25 \sim 51 = 25.4051$  mm The bias is the average minus the reference value, that is, bias = average - reference value. =  $25.4051 \text{ mm} - 25.400 \text{ mm} = 0.0051 \text{ mm}$  The bias of the measurement system can be stated as a percentage of the tolerance or as a percentage of the process variation.

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Measurement Systems Analysis (MSA), 4th Edition. The purpose of this document is to present

guidelines for assessing the quality of a measurement system. This document is not intended to be a compendium of analyses for all measurement systems. Its primary focus is measurement systems where the readings can be replicated on each part.

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### **Details**

The 3 Portions of this chapter adapted with permission from Measurement Systems Analysis - A Tutorial by G. F. Gruska and M. S. Heaphy, The Third Generation, 1987, 1998. 4 See the Potential Failure Mode and Effects Analysis (FMEA) Reference Manual - 4th Edition. OperationInput Output 23.

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AcrossedgageR&Rstudyestimateshowmuchtotalprocess  
variationiscausedbythemeasurementsystem.Totalprocess

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The AIAG has recently released a new revision to the Measurement System Analysis (MSA) reference manual. As you know, the MSA manual is intended to provide guidelines for assessing the quality of a measurement system. While this manual is used primarily in the automotive industry, the guidelines that are presented can be applied to any ...

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This chapter presents statistical methods that are used to

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