Variable Control Chart

Cell:		Part Number:		Part Name:		Date Calculated:	
Characteristic:		Specification:		Gauge Id.			

Averages (X Bar Chart) X dbl bar=average of X bar UCL=X dbl bar+A_2Rbar UCL=X dbl bar-A_2Rbar

Ranges (R Chart) Rbar= average of R UCL= D_4Rbar LCL =0 (Sample size<7)

Date/Time																				
Readings	1																			
	2																			
	3																			
	4																			
	5																			
Sum																				
X bar.=Sum/No. Of Readings																				
R= Highest – Lowest Reading																				

Action on Special Causes

- Any point outside the Control Limits
- A run of 7 points above, or below the center line
- A run of 7 points in an up, or down, direction
- Any other obvious non-random pattern

Action Instructions:

1. Point outside the control limits:
   a. Check equipment & parts for damage
   b. Measure another sample, if still out of control, notify cell and quality supervisors.
2. For any other Special Causes , notify quality supervisor.

Subgroup Size	A_2	D_4
2	1.88	3.27
3	1.02	2.57
4	.73	2.28
5	.58	2.11

Variable Control Chart

Control Chart Notes

Process Log Sheet

ANY CHANGE in the process should be noted.

Date	Time	Comments		Date	Time	Comments