

Measurement System Analysis

Introduction to MSA

We have learned that the heart and soul of Lean Six Sigma is that it is a data-driven methodology.

- How do you know that the data you have used is accurate and precise?
- How do you know if a measurement is a repeatable and reproducible?



How good are these?

Measurement System Analysis or MSA

Measurement System Analysis is one of those non-negotiable items! MSA is applicable in 95% of Lean Six Sigma projects and it alone can have a massive effect on the success of your project and improvements within the company.

Measurement System Analysis

Measurement System Analysis is the entire system, NOT just calibration or how good the measurement instrument is. We must evaluate the entire environment and Measurement System Analysis gives us a way to evaluate the measurement environment mathematically.

All these sources of variation combine to yield a measurement that is different from the true value.

It is also referred to as "Gage R&R" studies where R&R is: Reliability & Reproducibility.

MSA is a mathematical procedure to identify variation introduced to a process or product by the act of measuring.



The act of measuring can be a physical act. Document it is always the natural process.
Accuracy refers to a group of various different instruments measuring the same process.
Reference can describe the used to calibrate the measured.
Repeatability is the related act to perform the test.
Reproducibility is the related act to repeat the test.
Reliability is the relationship within the measures are performed.

Measurement System Analysis

Measurement System Analysis Components

In order to improve processes, it is necessary to collect data on the "critical to" characteristics. When there is variation in the data, it can either be attributed to the characteristics that is being measured and to the way that measurements are being taken which is known as measurement error. When there is a large measurement error, it affects the data and may lead to inaccurate decision-making.



Measurement error is defined as the effect of all sources of measurement variability that causes an observed value (measured value) to deviate from the true value. The measurement system is the complete process used to obtain measurements, such as the procedures, pages and personnel that are employed to obtain measurements. Each component of the system represents a potential source of error. It is important to identify the amount of error and, if necessary, the sources of error. This can only be done by evaluating the measurement system with statistical tools.

There are several types of measurement error which affect the location and the spread of the distribution. Accuracy, linearity and stability affect location (the average). Measurement accuracy describes the difference between the observed average and the true average based on a master reference value for the measurements. A linearity problem describes a change in accuracy through the expected operating range of the measuring instrument. A stability problem suggests that there is a lack of consistency in the measurement over time. Precision is the variability in the measured value and is quantified like all variation by using the standard deviation of the distribution of measurements. For estimating accuracy and precision, multiple measurements of one single characteristic must be taken.

The primary contributors to measurement system error are repeatability and reproducibility. **Repeatability** is the variation in measurements obtained by one individual measuring the same characteristics on the same item with the same measuring instrument. **Reproducibility** refers to the variation in the average of measurements of an identical characteristic taken by different individuals using the same instrument.

Given that repeatability and reproducibility are important types of error, they are the object of a specific study called a Gage Repeatability & Reproducibility study (Gage R&R). This study can be performed on either attribute-based or variable-based measurement systems. It involves an evaluation of the consistency in measurements among individuals after having at least two individuals measure several parts at random on a few trials. If there are inconsistencies, then the measurement system

must be improved.

Measurement System Analysis Reference Manual

**Chrysler Corporation, Ford Motor
Company, General Motors Corporation**



Measurement System Analysis Reference Manual:

Measurement Systems Analysis ,2003 *Measurement system analysis* Chrysler Corporation,Ford Motor Company,General Motors Corporation,1995 **Measurement Systems Analysis** MSA Measurement Systems Analysis Work Group, General measurement system guidelines The measurement process The effects of measurement system variability Measurement strategy and planning Measurement source development Gage source selection process Measurement issues Measurement uncertainty Measurement problem analysis Selecting developing test procedures Preparation for a measurement system study Analysis of the results Variable measurement system study guidelines Range method Average and range method Attribute measurement system study Practices for complex or non replicable measurement system Stability studies Variability studies Recognizing the effect of excessive within part variation Average and range method additional treatment Gage performance curve Reducing variation through multiple readings Pooled standard deviation approach to GRR **Problem Solving for New Engineers** Melisa Buie,2017-07-20 This book brings a fresh new approach to practical problem solving in engineering covering the critical concepts and ideas that engineers must understand to solve engineering problems Problem Solving for New Engineers What Every Engineering Manager Wants You to Know provides strategy and tools needed for new engineers and scientists to become apprentice experimenters armed only with a problem to solve and knowledge of their subject matter When engineers graduate they enter the work force with only one part of what s needed to effectively solve problems Problem solving requires not just subject matter expertise but an additional knowledge of strategy With the combination of both knowledge of subject matter and knowledge of strategy engineering problems can be attacked efficiently This book develops strategy for minimizing eliminating and finally controlling unwanted variation such that all intentional variation is truly representative of the variables of interest

Manufacturing Handbook of Best Practices Jack B. ReVelle,2001-12-26 Manufacturing Handbook of Best Practices An Innovation Productivity and Quality Focus gives you a working knowledge of today s cutting edge tools preparing you for the way you will be doing your job tomorrow With contributions from seasoned manufacturing experts the book provides a single source reference to what s currently happening in mod *Automotive Quality Systems Handbook* David Hoyle,2000-07-28 The Automotive Quality Systems Handbook is a step by step guide to interpreting and implementing the ISO TS 16949 Accepted by major vehicle manufacturers as an alternative to the existing US German French and Italian automotive quality system requirements this Technical Specification defines specific requirements for the application of ISO 9001 1994 throughout the automotive supply chain While initially the standard will be voluntary for the first time second and third tier suppliers may be faced with pressure to undergo third party registration After the year 2000 the next version of the standard has actually replaced the four existing standards AVSQ EAQF QS 9000 and VDA 6 1 and the price of entry to the global automotive market is conformance to this new standard This handbook is an essential and comprehensive guide to

enable organizations to interpret and implement the ISO TS 16949 Unlike other books on the subject each element clause and requirement is analyzed in detail with guidance provided for its implementation The handbook is written primarily for implementers and discerning managers for instructors and auditors and contains a range of solutions that would be acceptable in the automobile industry It includes details of the certification scheme the differences with existing standards check lists questionnaires tips for implementers flow charts and a glossary of terms This book gives more than an overview it tells how you to do it Contains detailed instructions and check lists for implementationAddresses all ISO requirements

The Certified Quality Inspector Handbook H. Fred Walker,Ahmad K. Elshennawy,2019-03-09 The quality inspector is the person perhaps most closely involved with day to day activities intended to ensure that products and services meet customer expectations The quality inspector is required to understand and apply a variety of tools and techniques as codified in the American Society for Quality ASQ Certified Quality Inspector CQI Body of Knowledge BoK The tools and techniques identified in the ASQ CQI BoK include technical math metrology inspection and test techniques and quality assurance Quality inspectors frequently work with the quality function of organizations in the various measurement and inspection laboratories as well as on the shop floor supporting and interacting with quality engineers and production service delivery personnel This handbook supports individuals preparing to perform or those already performing this type of work It is intended to serve as a ready reference for quality inspectors and quality inspectors in training as well as a comprehensive reference for those individuals preparing to take the ASQ CQI examination Examples and problems used throughout the handbook are thoroughly explained are algebra based and are drawn from real world situations encountered in the quality profession To assist readers in using this book as a ready reference or as a study aid the book has been organized to conform explicitly to the ASQ CQI BoK Each chapter title all major topical divisions within the chapters and every main point has been titled and then numbered exactly as they appear in the CQI BoK *The Six Sigma Performance Handbook* Praveen Gupta,2005 Publisher s Note Products purchased from Third Party sellers are not guaranteed by the publisher for quality authenticity or access to any online entitlements included with the product Written with managers not statisticians in mind this reference shows readers how to statistically evaluate a Six Sigma program identify problems and make tailor made adjustments to get the desired results and revitalize a program Profits in tough times require prioritization and focus If properly managed Six Sigma methods can deliver dramatic improvement by increasing manufacturing and process efficiencies But nearly 60% of all corporate Six Sigma initiatives fail to yield the desired results often companies take the fighting fires approach to business and do not take time to understand what the data is telling them which is why many Six Sigma projects fail The high visibility of the Six Sigma Initiative has corporate executives committing to significant investment in resources often without any tangible improvement in profitability a fact neglected by most Six Sigma books Written with Green belts and managers in mind this reference shows readers how to statistically evaluate a Six Sigma program identify problems and make tailor made

adjustments to get the desired results and revitalize a program *Electronic Systems Quality Management Handbook* Marsha Ludwig-Becker,1997 Annotation Quality management for electronic systems has grown far beyond the basic inspection techniques of the past New performance based quality management approaches are now used at every electronics company from huge corporations to small start ups This book goes beyond generic quality approaches to present an electronics specific program for quality management **Instrumentation Reference Book** Walt Boyes,2010 keeping with the same proven formula of practical advice for real world applications from some of the world's leading authorities on instrumentation control and automation Book Jacket Measurement Systems Analysis Chrysler Corporation,1995

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