

## 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 formal MSA is applicable in 95% of Lean Six Sigma projects and if done 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. Accuracy is a property of natural objects. Precision refers to a group of similar objects measured by the same process. Reference is a device that used to calibrate the measured. Reproducibility is the ability to perform the test. Reliability is the ability to repeat the test. Reproducibility is the consistency within the measure 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      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

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**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 implementation Addresses all ISO requirements

*The Six Sigma Performance Handbook* Praveen Gupta, 2005

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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

**Production Part Approval Process (PPAP)**, 2000 *Quality Manager's Complete Guide to ISO 9000* Richard B. Clements, 1999

**Transactions of the American Foundrymen's Society** American Foundrymen's Society, 1998

**ASQC ... Annual Quality Congress Proceedings**, 1995 Integrating QS-9000 with Your Automotive Quality System D. H. Stamatis, 1999 This detailed reference was the first of its kind to discuss the requirements for QS 9000 certification Written for automotive suppliers and manufacturers responsible for developing a quality strategy for achieving high quality standards this book serves as an overview and critical interpretation of the ISO 9000 quality standards and the QS 9000 requirements In this revised and expanded edition to his best selling book *Integrating QS 9000 with Your Automotive Quality System* D H Stamatis explains the changes to the QS 9000 requirements the author also introduces some issues regarding the applicability of audits and auditors to the industry perspective Two new chapters dealing with auditors and auditing have been added to address concerns most often expressed by those involved with an evaluation A new chapter discusses the environmental impacts relating to QS 9000 and the role ISO 14000 plays in the QS 9000 arena the VDA 6 German requirement is also introduced You'll find a full quality manual QM to demonstrate how a QM can be written in a paragraph format combining the elements with the subelements of the standard Two revised appendices offer an overview of the production part approval process PPAP and the advanced product quality planning process APQP

**Measuring Instrument Calibration**, 1998 QS-9000 Answer Book Rob Kantner, 1997-01-02 An in depth accessible guide to the intricacies of QS 9000 With QS 9000 certification deadlines just around the corner you want to be sure your company is on the right track to meeting requirements This timely and indispensable guide answers the most commonly asked questions about QS 9000 compliancy offering in depth explanations as well as capsule answers for quick reference What are the characteristics of a QS 9000 quality system A QS 9000 quality system is a documented self improving union of resources and activities that governs every aspect of a process that affects quality What firms are required to register with QS 9000 Direct suppliers of production materials parts or key finishing services and certain other suppliers must register What are the advantages or benefits of QS 9000 registration It improves customer confidence provides access to markets improves competitive standing and reduces supplier quality assurance program costs What quality tools and techniques are mandated

by QS 9000 QS 9000 requires the use of mistake proofing methods disciplined problem solving methods and the use of cross functional teams for decision making What are some of the common perils and pitfalls to effective system implementation Pitfalls you should avoid include trying to implement from the bottom up doing just enough to get registered getting carried away with documentation and springing the system on the work force all at once **Manual of Blowpipe Analysis, Qualitative and Quantitative, with a Complete System of Determinative Mineralogy** Henry Bedinger Cornwall,1902 *Monitoring and Control of Micro-Hole Electrical Discharge Machining* Chen-Chun Kao,2007

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