

ISO 8258:1991-12 (E)

Shewhart control charts

| Contents | Page |
|---|------|
| 1 Scope | 1 |
| 2 Symbols | 1 |
| 3 Nature of Shewhart control charts | 2 |
| 4 Types of control charts..... | 3 |
| 4.1 Control charts where no standard values are given | 3 |
| 4.2 Control charts with respect to given standard values | 3 |
| 4.3 Types of variables and attributes control charts | 3 |
| 5 Variables control charts | 4 |
| 5.1 Mean (X) chart and range (R) or standard deviations (s) chart | 4 |
| 5.2 Control chart for individuals (X) | 5 |
| 5.3 Control charts for medians (Me) | 6 |
| 6 Control procedure and interpretation for variables control charts | 6 |
| 7 Pattern tests for assignable causes of variation | 7 |
| 8 Process control and process capability | 7 |
| 9 Attributes control charts | 9 |
| 10 Preliminary considerations before starting a control chart | 11 |
| 10.1 Choice of quality characteristics | 11 |
| 10.2 Analysis of the production process | 11 |
| 10.3 Choice of rational subgroups | 11 |
| 10.4 Frequency and size of samples | 12 |
| 10.5 Preliminary data collection | 12 |
| 11 Steps in the construction of control charts | 12 |
| 12 Illustrative examples: Variables control charts..... | 13 |
| 12.1 \bar{x} chart and R chart: Standard values given | 13 |
| 12.2 X chart and R chart: No standard values given | 15 |
| 12.3 Control chart for individuals, X, and moving range, R: No standard values given..... | 18 |
| 12.4 Median chart: No standard values given | 20 |
| 13 Illustrative examples: Attributes control charts | 22 |
| 13.1 p chart and np chart: No standard values given | 22 |
| 13.2 p chart: No standard values given..... | 24 |
| 13.3 c chart: No standard values given..... | 26 |
| 13.4 Number of nonconformities per unit: u chart | 26 |
| Annex | |
| A Bibliography | 29 |