

ISO 7870-1:2019-11 (E)

Control charts - Part 1: General guidelines

| Contents | | Page |
|---|--|-------------|
| Foreword | | iv |
| Introduction | | v |
| 1 | Scope | 1 |
| 2 | Normative references | 1 |
| 3 | Terms and definitions | 1 |
| 4 | Symbols and abbreviated terms | 7 |
| 4.1 | Symbols | 7 |
| 4.2 | Abbreviated terms | 8 |
| 5 | Concepts | 8 |
| 5.1 | Control chart | 8 |
| 5.2 | Statistical control of a process | 9 |
| 5.3 | Acceptance of a process | 9 |
| 5.4 | Management of a process with a natural drift | 9 |
| 5.5 | Risks of decision errors | 9 |
| 5.6 | Design of data collection | 10 |
| 5.6.1 | General | 10 |
| 5.6.2 | Choice of characteristic | 10 |
| 5.6.3 | Measurement process evaluation | 10 |
| 5.6.4 | Subgroup selection | 10 |
| 5.6.5 | Subgroup size | 11 |
| 5.6.6 | Sampling frequency | 11 |
| 5.7 | Control charts for variables and attributes data | 11 |
| 6 | Types of control charts | 12 |
| 7 | Charts for process stability | 12 |
| 7.1 | General | 12 |
| 7.2 | Partial listing of Shewhart and related control charts | 13 |
| 7.2.1 | General | 13 |
| 7.2.2 | Charts using data from only one rational subgroup for each plotted value | 13 |
| 7.2.3 | Charts using data from more than one subgroup for each plotted value | 14 |
| 7.2.4 | Charts for non-independent (autocorrelated) observations | 14 |
| 8 | Charts for process acceptance | 15 |
| 8.1 | General | 15 |
| 9 | Process adjustment | 16 |
| Annex A (informative) Charting styles and colours for control charts | | 17 |
| Bibliography | | 19 |