

For Comments Only

Draft Indian Standard
Control Charts —
Part 2: Shewhart Control Charts
ICS 03.120.30

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NATIONAL FOREWORD

(Formal clauses to be added later on)

The text of the International Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.

In this adopted standard, reference appears to an International Standard for which Indian Standard also exists. The corresponding Indian Standard, which is to be substituted in its place, is listed below along with its degree of equivalence for the editions indicated:

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 3534 - 2, Statistics — Vocabulary and Symbols — Part 2: Applied Statistics	IS 7920 (Part 2) : 2012/ ISO 3534-2:2006, Statistics - Vocabulary and symbols Part 2 applied statistics Third Revision	Identical

Annexes A and B are for information only.

Note: The technical content of the document is not available on website. For details, please refer the corresponding ISO 7870-2 : 2023 or kindly contact:

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Scope

This document establishes a guide to the use and understanding of Shewhart control chart approach to the methods for statistical control of a process.

This document is limited to the treatment of statistical process control methods using only Shewhart system of charts. Some supplementary material that is consistent with Shewhart approach, such as the use of warning limits, analysis of trend patterns and process capability is briefly introduced. However, there are several other types of control charts which can be used in different situations.

Introduction

A traditional approach to manufacturing has been to depend on production to make the product and on quality control to inspect the final product and screen out items not meeting specifications. This strategy of detection is often wasteful and uneconomical because it involves after-the-event inspection when the wasteful production has already occurred. Instead, it is much more effective to institute a strategy of prevention to avoid waste by not producing unusable output in the first place. This can be accomplished by gathering process information and analysing it so that timely action can be taken on the process itself.

Dr. Walter Shewhart in 1924 developed the control chart method for controlling the quality during production. Control chart theory recognizes two kinds of variability. The first kind is random variability (also known as natural/inherent/uncontrollable variation) arising due to causes known as chance/common/random causes. This is due to the wide variety of causes that are consistently present and not readily identifiable, each of which constitutes a very small component of the total variability but none of them contributes any significant amount. Nevertheless, the sum of the contributions of all of these unidentifiable random causes is measurable and is assumed to be inherent to the process. The elimination or correction of common causes may well require a decision to allocate resources to fundamentally change the process and system.

The second kind of variability represents a real change in the process. Such a change can be attributed to some identifiable causes that are not an inherent part of the process and which can, at least theoretically, be eliminated. These identifiable causes are referred to as “assignable causes” (also known as special/unnatural/systematic/controllable causes) of variation. They may be attributable to such matters as the lack of uniformity in material, a broken tool, workmanship or procedures, the irregular performance of equipment, or environmental changes.

A process is said to be in a state of statistical control, or simply “in control”, if the process variability results only from random causes. Once this level of variation is determined, any deviation from this level is assumed to be the result of assignable causes that should be identified and eliminated.

The major statistical tool used to do this is the control chart, which is a method of presenting and comparing information based on a sequence of observations representing the current state of a process against limits established after consideration of inherent process variability. The control chart method helps first to evaluate whether a process has attained, or continues in, a state of statistical control. When the process is deemed to be stable and predictable, then further analysis regarding the ability of the process to satisfy the requirements of the customer may be conducted. The control chart also can be used to provide a continuous record of a quality characteristic of the

process output while process activity is ongoing. Control charts aid in the detection of unnatural patterns of variation in data resulting from repetitive processes and provide criteria for detecting a lack of statistical control. The use of a control chart and its careful analysis leads to a better understanding of the process and will often result in the identification of ways to make valuable improvements.