

## MSA – Gage R&R Study Example

APPRAISER/ TRIAL #	PART										AVERAGE	
	1	2	3	4	5	6	7	8	9	10		
1. A	1	0.29	-0.96	1.34	0.47	-0.90	0.62	0.59	-0.21	2.28	-1.35	0.194
2.	2	0.41	-0.88	1.17	0.50	-0.92	-0.11	0.75	-0.28	1.98	-1.29	0.198
3.	3	0.04	-0.98	1.27	0.04	-0.84	-0.21	0.66	-0.17	2.01	-1.21	0.201
4.	AVE	0.447	-0.607	1.266	0.507	-0.853	-0.105	0.667	-0.227	2.087	-1.307	$\bar{X}_p$ 0.190
5.	R	0.38	0.12	0.17	0.17	0.12	0.23	0.18	0.14	0.27	0.11	$\bar{R}_p$ 0.194
6. B	1	0.08	-0.47	1.18	0.21	-0.55	-0.25	-0.47	-0.63	1.80	-1.08	0.081
7.	2	0.25	-1.22	0.94	1.03	-1.25	0.22	0.55	0.58	2.12	-1.62	0.115
8.	3	0.07	-0.88	1.34	0.25	-1.28	0.06	0.83	-0.34	2.18	-1.50	0.089
9.	AVE	0.133	-0.716	1.157	0.493	-1.013	0.027	0.117	-0.287	2.037	-1.000	$\bar{X}_p$ 0.088
10.	R	0.18	0.75	0.40	1.02	0.73	0.42	0.38	0.71	0.38	0.18	$\bar{R}_p$ 0.613
11. C	1	0.04	-1.38	0.88	0.14	-1.45	-0.28	0.82	-0.46	1.77	-1.49	-0.223
12.	2	-0.11	-1.13	1.09	0.28	-1.07	-0.87	0.81	-0.88	1.48	-1.77	-0.258
13.	3	-0.15	-0.95	0.87	0.11	-1.45	-0.48	0.21	-0.48	1.87	-2.15	-0.284
14.	AVE	-0.073	-1.157	0.936	0.156	-1.327	-0.483	0.080	-0.603	1.697	-1.607	$\bar{X}_p$ -0.254
15.	R	0.19	0.42	0.42	0.08	0.38	0.38	0.20	0.19	0.42	0.67	$\bar{R}_p$ 0.328
16. PART												$\bar{X}_p$ 0.001
	AVE ( $\bar{X}_p$ )	0.188	-0.651	1.088	0.287	-1.054	-0.185	0.454	-0.342	1.948	-1.271	$\bar{R}_p$ 3.511
17.	$(\bar{X}_p - \bar{X}_p) / (\# \text{ OF APPRAISERS}) =$											$R_p$ 0.342
18.	$(\text{Max } \bar{X}_p - \text{Min } \bar{X}_p) =$											$R_{app}$ 0.465
19.	$R \times G_p =$											$\bar{X}_{CLR}$ 0.862
20.	$R \times G_p =$											$\bar{X}_{CLR}$ 0.600

Measurement Unit Analysis				% Total Variation (TV)	
Repeatability - Equipment Variation (EV)					
EV =	$R \times K_1$			% EV =	100 (EV/TV)
	=	$0.342 \times 0.5868$			= 100(0.2001/146)
	=	0.200			= 13.6%
			Trials	K1	
			2	0.5868	
			3	0.5868	
Repeatability - Appraiser Variation (AV)					
AV =	$(\text{Max } \bar{X}_p - \text{Min } \bar{X}_p) / (\# \text{ OF APPRAISERS})$			% AV =	100 (AV/TV)
	=	$(0.446 - 0.023) / 3$			= 100(0.2001/146)
	=	0.143			= 20.04%
			Trials	K2	
			2	3	
			K2	0.7071	0.5231
Repeatability & Reproducibility (GRR)					
GRR =	$(EV^2 + AV^2)^{1/2}$			% GRR =	100 (GRR/TV)
	=	$(0.200^2 + 0.143^2)^{1/2}$			= 100(0.2661/146)
	=	0.266			= 26.68%
			Parts	K3	
			2	0.7071	
			3	0.5231	
Part Variation (PV)					
PV =	$R \times K_3$			% PV =	100 (PV/TV)
	=	$3.511 \times 0.3148$			= 100(1.1056/600)
	=	1.105			= 96.3%
			4	0.4467	
			5	0.4030	
			6	0.3742	
			7	0.3524	
			8	0.3375	
			9	0.3248	
			10	0.3148	
Total Variation (TV)					
TV =	$(GRR^2 + PV^2)^{1/2}$			ndc =	1.41 (PV/GRR)
	=	$(0.266^2 + 1.105^2)^{1/2}$			= 1.41(1.1056/600)
	=	1.146			= 5.09682 - 5

The percent error is questionable and may be used under high level of scrutiny at 26.68%

# Msa Testing 2013 Study Guide

**Brendan G. Carr**



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