



Gage R&R Study

Data Collection

Part	Operator	Response	Part	Operator	Response
1	1	0.3565	1	2	0.356
1	1	0.353	1	2	0.3565
2	1	0.3615	2	2	0.3635
2	1	0.361	2	2	0.363
3	1	0.3605	3	2	0.3625
3	1	0.362	3	2	0.3635
4	1	0.3635	4	2	0.3695
4	1	0.366	4	2	0.364
5	1	0.364	5	2	0.3695
5	1	0.367	5	2	0.37
6	1	0.324	6	2	0.3235
6	1	0.322	6	2	0.3275
7	1	0.375	7	2	0.375
7	1	0.3755	7	2	0.3735
8	1	0.3595	8	2	0.3625
8	1	0.3615	8	2	0.3615
9	1	0.353	9	2	0.3535
9	1	0.349	9	2	0.3535
10	1	0.3575	10	2	0.3605
10	1	0.3575	10	2	0.358

Study Results

%Contribution		
Source	VarComp	(of VarComp)
Total Gage R&R	0.0000041	2.18
Repeatability	0.0000024	1.30
Reproducibility	0.0000016	0.87
Operator	0.0000016	0.87
Part-To-Part	0.0001834	97.82
Total Variation	0.0001874	100.00
Process tolerance = 0.07		

Study Var %Study Var %Tolerance				
Source	StdDev (SD)	(6 × SD)	(%SV)	(SV/Toler)
Total Gage R&R	0.0020201	0.0121203	14.75	17.31
Repeatability	0.0015637	0.0093820	11.42	13.40
Reproducibility	0.0012789	0.0076733	9.34	10.96
Operator	0.0012789	0.0076733	9.34	10.96
Part-To-Part	0.0135410	0.0812458	98.91	116.07
Total Variation	0.0136908	0.0821449	100.00	117.35
Number of Distinct Categories = 9				



Gage R&R Study – Graphical Analysis

