

Statistical Process Control

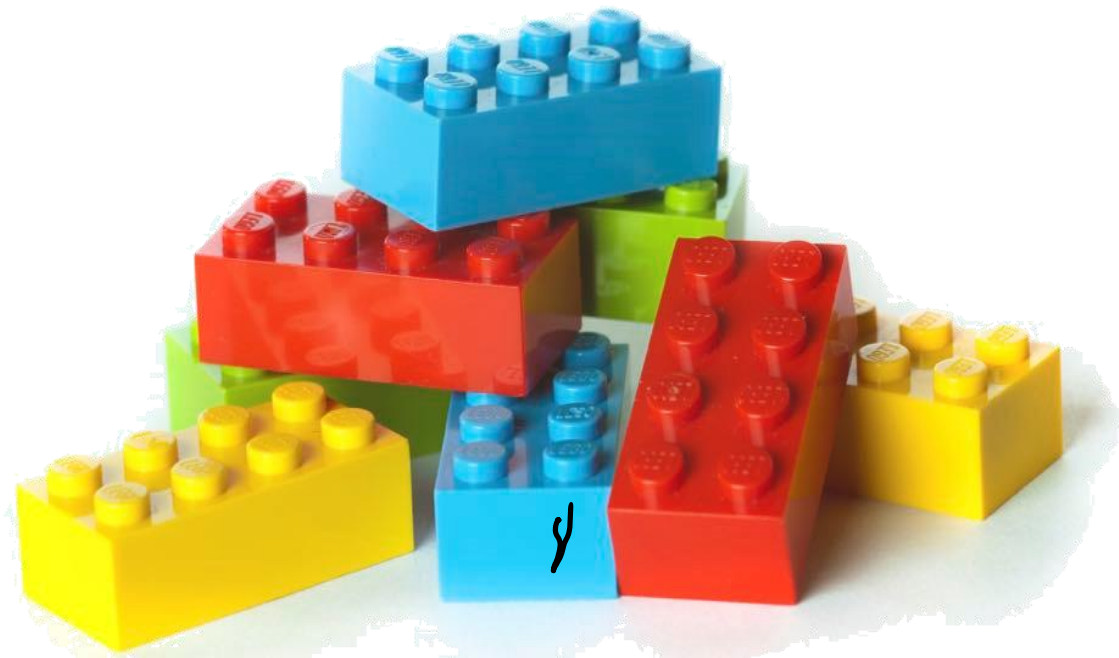
Lego Defect Process Control



Scenario:

The Lego® Block production line produces a certain percentage of defects.

The customer accepts less than 2 mm defect length. The Quality Control team will reject defect greater than 2mm.



Instructions:

1. Receive the blocks at the end of the line. Measure the defect length, if any.
2. Prepare an ImR chart and track the results in real time as the production line keeps producing blocks.
 1. Any changes?
 2. Is the production under specification?
 3. Any trends to be out of specification?
 4. Discuss finding and opportunities to improve during production.

Sample Number	Obs 1	Obs 2	Obs 3	Obs 4	Obs 5	Obs 6	Obs 7	Obs 8	Obs 9	Obs 10
1	265									
2	268									
3	197									
4	200									
5	268									
6	197									
7	234									
8	320									
9	233									
10	200									
11	189									
12	250									
13	250									
14	250									
15	250									
16	250									
17	250									
18	250									
19	240									
20	245									
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