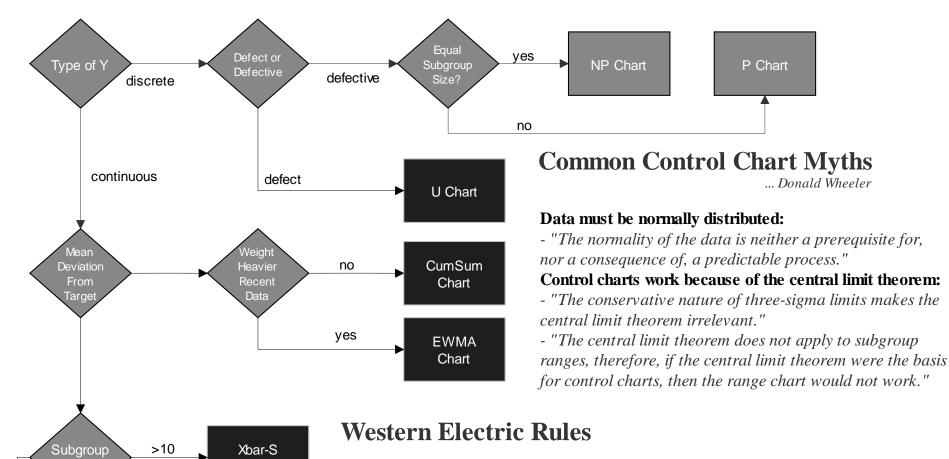
Qualitas

Control Charts Roadmap



Chart

Xbar-R

Chart

I-MR

Chart

2 to 10

1

- 1. One point more than three standard deviations from the center line
- 2. Nine points in a row on the same side of the center line
- 3. Six points in a row steadily increasing or steadily decreasing
- 4. Fourteen points in a row alternating up and down
- 5. Two out of three points in a row at least two standard deviations from the center line on the same side of the center line
- 6. Four out of five points in a row at least one standard deviation from the center line on the same side of the center line
- 7. Fifteen points in a row within one standard deviation from the center line on either side of the center line
- 8. Eight points in a row beyond one standard deviation from the center line on either side of the center line