

Index

- % R&R, *see* percentage gauge R&R
 α (alpha), *see* intercept parameter/significance level/type I error
 β (beta), *see* slope parameter/type II error
 η (eta), *see* population median
 μ (mu), *see* population mean
 ν (nu), *see* degrees of freedom
 ρ (rho), *see* population correlation coefficient
 σ (sigma), *see* population standard deviation
 σ^2 (sigma squared), *see* population variance
 χ^2 (chi-squared), *see* chi-square test
1 proportion test 247, 248
1-sample t test 243–246
1-sample z test 234–241
2 proportions test 256, 257
 2^2 factorial experiments 326–334
 2^3 factorial experiments 343–355
 2^4 factorial experiment 355–357
 2^k factorial experiments 326–357
 2^{k-p} fractional factorial experiments 357–366
2-sample t test 252–255
3D scatterplot 342

absolute deviation 41, 178
acceptance sampling
 by attributes 129–132
 by variables 132, 133
adjusted R^2 , *see* R^2 /R-squared (adjusted)
alias, aliased 355, 359, 360, 363, 365
alternative hypothesis 227, 228, 231
analysis of variance (ANOVA) 266–268
analyze 7, 8, 481
analyze factorial design 330
analyze Taguchi design 372
append graph to report 22
assignable causes 24, 152
assistant 10, 468–472
attribute agreement analysis 408–412
autocorrelation 189
available designs 304, 346, 376, 434
average run length (ARL) 179

balanced ANOVA 277, 280, 323
bar chart 62, 85, 100, 101, 107, 404
best subsets regression 429
bias 391, 392
binary logistic regression 441–450
binning 30, 36
binomial distribution 99–105
bins 27
bivariate data 27, 72–74, 193
bivariate normal distribution 127
black belts 7, 10
Bland-Altman plot 407
blocking in experimental designs 264, 283–291, 386
Bonferroni confidence intervals 295
Box, George E. P. 93, 189, 413
Box-Cox transformation 215–217
boxplot(s) 68–70
brushing 70–72

calibration 392
capability sixpack, *see also* process capability analysis
 nonnormal distribution 215
 normal distribution 211
cause-and-effect diagram 87
central composite design 434–436
central limit theorem 121
central tendency, *see* location
change data type 48
chi-square test 137, 292–294, 436–440
coded units 331, 434, 453–455
coded variables 335, 354
code data 52
coefficient of determination 78, 271, 416, 430
column
 date/time data 43, 54
 numeric(al) data 14, 15, 25, 48
 text data 32, 40, 43

- command(s)
 enable 78, 106
 line editor 477
 menu 106
 session 106, 460, 476
 set 106
- common cause(s) 17, 142
- comparisons
 Dunnett's procedure 272
 family error rate 267
 Tukey's method 267
 with a control 272
- comparison of measurement systems 406–408
- complement of an event 95
- component(s) of variance 278, 279, 321, 400
- confidence interval(s) 241
- confidence interval(s) for
 comparisons 268, 273, 287, 288, 313, 314
 C_{pk} 214
 difference between means 254
 difference between medians 260
 difference between proportions 256
 mean 237, 240, 244
 mean difference 262
 median 251
 odds ratio 444
 proportion 256
 sigma quality level 214
- confounding 359, 360
- constant (term), in model 279, 324, 331
- constant, in regression 414, 415, *see also*
 intercept parameter
- constants in Minitab 43, 138
- contingency table 437–439
- continual improvement 2–3, 226
- contour plot 342–343
- control chart(s) 9, 141
 attribute data 160–170
 constants 154–155
 count of nonconformities (C) 168
 cumulative sum (CUSUM) 181–186
 exponentially weighted moving average (EWMA) 179–181
 generalised variance 193
 Hotelling's T^2 193
 individuals (I or X) 141–148
 means (X_{bar}) 151–160
 measurement data 141
 moving Ranges (MR) 147
 multivariate 193
- nonconformities per unit (U) 169–170
 number nonconforming (NP) 167
 proportions non-conforming (P) 160–167
 ranges (R) 151–160
 standard deviations (S) 160
 subgroups (between/within) (I-MR-R/S) 160, 201
 tests 148–151
 three sigma limits 144
- control group 272
- correlation 9, 74–82
- correlation coefficient 77
- correlation matrix 78, 79
- covariance 74–77
- covariance matrix 127
- C_p index, *see* process capability analysis
- C_p (Mallow's statistic) 429
- C_{pk} index, *see* process capability analysis
- C_{pm} index, *see* process capability analysis
- create factorial design 304, 327, 346, 358, 432
- create indicator variable, *see* brushing
- critical region 229, 230, 240, 241
- cross tabulation and chi-square 97, 439, 441
- cube plot 329, 330, 348, 356
- cumulative probability function 102, 110, 111
- customer tolerance range 205, 211
- cutpoint(s) 30
- d_2 constant 144, 145
- data
 input 15, 43, 44
 manipulation 13, 43–54
 sets associated with book xv
 sets in Minitab, *see* sample data folder
 transformation 215, 425, 426
 window 14, 15, 22, 43, 44
- defect(s) 1, 4–6, 84–86, 98, 130, 168, 221, 457
- defectives 131, 221
- define 1, 6, 7
- degrees of freedom 243, 254, 275, 293, 311, 437
- Deming, W. Edwards 2, 3, 5, 13, 186, 473
- density histogram 108, 109
- design of experiments (DOE) 8, 10, 304, 326, 358, 369, 432
- deviation 41
- dialog box 15
- discrimination ratio 404
- distribution of
 multiple of a random variable 118
 sample mean 120–125

- sample proportion 125, 126
 sum of independent random variables
 118, 119
 DMADV 7
 DMAIC 7, 480–481
DOE, see design of experiments
 dotplot (dot plot) 40, 73, 239, 255
- EDA, *see* exploratory data analysis
 edit last dialog 154
 enable commands 78, 106
 erase variables 52, 58
 estimation 9, 144, 181, 193, 209, 225, 243
 event 95
 exec file 478
 expected value 104, 105
 experimental design 264, 283, 291, 304,
 326, 357
 exploratory data analysis (EDA) 8, 9, 63–72
 exponential distribution 121–123
 exponentially weighted moving average
 (EWMA) 174–179
- F-distribution 268, 270, 271, 311, 320
 factor level combination(s) (FLC(s)) 304
 factor(s) 7, 18, 326, 357
 factorial experiment(s) 303–389
 fall-out (ppm) 203–208
 false alarm 152, 160, 191, 193
 family error rate, *see* comparisons
 file types 22, 23, 44, 53
 Fisher, Ronald A. 94, 241, 268
 Fisher's exact test 439, 440
 fit additive model 284, 287, 311
 fit(s), *see* fitted value
 fitted line plot 417, 420–422
 fitted value(s) (fit(s)) 177, 267, 270, 271,
 311–313, 416
 fixed effects model 274–276, 286, 313
 FLC(s), *see* factor level combination(s)
 format column 137
 four in one plot 267–271
 fractional factorial experiments 304, 357–366
 frequency histogram 108
 F-test 271, 294, 311, 418
 full factorial experiments 326–357
 funnel experiments 186–189
 funnel plot 170–171, 221
- gage R&R study (crossed) 403
 gage R&R study (nested) 405
- gauge repeatability and reproducibility (R&R)
 studies 399–406
 gage run chart 400, 401
 Gaussian distribution, *see* normal distribution
 general factorial experiments 304–326
 general linear model 287–289, 313, 321
 Gosset, William S. 94, 243
 green belts 8, 10
- help 17, 18, 20, 48, 51, 96, 460–462
 HI 68
 histogram 27–30
 history 15, 477–478
- I chart, *see* control charts
 improve 1, 7, 8
 I-MR-R/S charts, *see* control charts
 inadequate measurement units 396–399
 independent events 97
 independent random variables 118–120
 individual value plot 239, 244, 254, 262
 individuals chart, *see* control charts
 input(s) 7, 8, 226, 251
 interaction effect(s) 303, 315, 317–326
 interaction(s) plot 309, 310
 interaction plot matrix 310, 316, 327
 intercept parameter 415, 422, 426
 inter-quartile range (IQR) 67
 interval(s) 28–30, 36, 65
 inverse cumulative probability 114, 115,
 137, 229
 IQR, *see* inter-quartile range
- jitter 240
- kappa statistic 409–411
 knowledgebase 473
 Kruskal-Wallis test 281–283
- leaf value 64
 level of significance, *see* significance level
 Levene's test 294–296
 line of steepest ascent 343, 433
 linearity 391, 394–396
 LO 68
 location 13, 16, 17, 29, 30–38
 logarithmic transformation 425, 426
 LCL, lower control(chart) limit, *see* control
 charts, three sigma limits
 LSL, lower specification limit 38, 116,
 203, 205

- macro(s) 10, 186, 407, 476–479
MAD, *see* mean absolute deviation
 main effect(s) 306–309
 main effects plot 306, 307
 make patterned data 134, 143, 164, 165, 195, 197
 Mann-Whitney test 259–261
 margin of error 243
 marginal plot 72–73
 master black belts 8
 matrix 76, 78–80
 matrix plot 80–81
 mean 16, 32–34
 mean absolute deviation (MAD) 41
 mean squared deviation (MSD) 41
 measure 1, 7–8, 481
 measure of location 16, 17, 33, 35, 36
 measure of variability 35, 40–42
 measurement 8, 9, 391–412
 measurement process 9, 391–412
 measurement system 10, 324, 391–412
 median 16, 17, 33, 35
 menus 13–15
 menu commands, *see* commands
 midpoint 30, 36
 Minitab xiii, 1
 Minitab Inc xiii, 459
 Minitab project 15, 20–24
 Minitab worksheet 22–24, 38
 modelling 73–74, 413–450
 move columns 53
 moving average 171–174
 MR chart, *see* control charts
 MSD, *see* mean squared deviation
 multiple regression 426–431
 multi-vari chart 82–84
 multivariate data 27, 63, 72–82
 multivariate normal distribution 127, 128
 multivariate statistical methods 479
 mutually exclusive events 96
 natural tolerance range 205
 nonconforming 4, 84, 99
 nonconformity 84–96, 168, 169
 nonlinear relationship 78, 82
 nonlinearity 394, 395
 nonparametric tests 249–264
 normal distribution 108–117
 normal plot of (standardized) effects 351
 normal probability plot, *see* normality test
 normality test 112, 113
 NP chart, *see* control charts
 null hypothesis 227, 228
 number of distinct categories 405–406
 odds ratio
 one-sample t-test 261
 one-tailed test 230
 one-way ANOVA 266–268
 open worksheet 25, 44, 51
 outcome 94–96
 outlier detection 67–70
 outliers 67–70
 P chart, *see* control charts
 paired t-test 261–264
 parameter(s) of distributions 43, 100, 105, 111, 127
 parameters in regression 415, 441
 Pareto chart 84–86
 Pareto plot of (standardized) effects 351, 352
 PDSA, *see* plan-do-study-act cycle
 Pearson product moment correlation, *see* correlation coefficient
 percentage gauge R&R 402–406
 percentile 67, 114
 performance measures 7, 8, 413
 place bounds on control limits 200
 plan-do-study-act cycle 2
 Poisson distribution 105–108
 population 41
 correlation coefficient, 78
 mean 43, 104, 105
 median 251
 standard deviation 43
 variance 104, 105
 power 230, 231, 233, 246, 247
 power and sample size 246, 248, 257–259
 P_p index, *see* process performance indices
 P_{pk} index, *see* process performance indices
 prediction intervals 419, 420, 428
 predictor(s) 414, 419, 423, 426, 427
 probability 93–99
 probability density function 110, 111, 117, 123, 245
 probability function 99–103
 process capability analysis, 203–222, *see also* capability sixpack
 attribute data, 220
 binomial 220

- C_p index 205
- C_{pk} index 206
- C_{pm} index 212
- measurement data, 203
- non-normal 214, 215
- normal 208
- Poisson 221
- and sigma quality levels, 212–214
- using data transformation, 216–217
- process improvement 7, 9
- process model 7, 8, 413
- process performance indices 211
- project 1, 3, 7, 8, 480, *see also* Minitab Project
- P-value 18–20, 78, 227, 241
- quadratic regression 82, 421–425
- quality 1–3
- quality companion 480
- quality improvement 1–6
- quartiles 36, 66, 67
- R chart, *see* control charts
- R²/R-squared 271, 416, 417, 429
- R²(adj)/R-squared (adjusted) 429, 430
- r², *see* coefficient of determination
- random data 103, 119, 121, 126, 128, 131
- random effects model 276–280, 321–326
- random events 106
- random variable(s)
 - continuous 23, 93, 108, 127, 141
 - discrete 24, 99, 102, 105, 141
- random variation 142, 264, 275, 276
- randomization 265, 266, 305, 370, 377
- randomized complete block experiments 283, 291
- range 40–42
- ranking 54, 56, 259
- reference lines 38
- regression 9, 73, 82, 395, 413–431, *see also*
 - binary logistic regression 441–450
 - multiple regression 426–431
 - quadratic regression 421–426
 - with a single predictor variable 413–426
- reliability and survival statistics 479
- repeatability 391–393
- replication(s)/replicate(s) 265, 274, 309, 313
- ReportPad 15, 21–23
- reproducibility 392, 393
- residual plots 267, 271, 277
- residual(s) 177, 267, 269–273
- resolution 326, 347, 357–360, 365
- response(s) 7, 8
- response optimizer 339, 340, 362, 363
- response surface 341–343, 431–436
- response surface design 434–436
- row statistics 119, 121
- rules for probabilities 95–99
- run length 156, 179
- run chart
- run(s) about the median 18–20
- run(s) in process experimentation 304, 305, 359
- run(s) up or down 18–20
- S chart, *see* control charts
- sample data folder 51
- sample mean 43
- sample size determination 242, 243
- sample space 94, 95, 99
- sample standard deviation 41, 43
- Save Current Worksheet As 23
- Save Project 23
- Save Worksheet 23
- scale 30, 32, 36
- scatterplot 72–74
- scatterplot with groups 91
- Session command, *see* command
- Session window 14, 15
- Set command, *see* command
- Shewhart, Walter A. 2, 3, 9, 94, 141, 142
- Show Design 382, 383
- sigma quality level 3–5, 98, 115–117
- sign test 250, 251, 263, 264
- significance level 18, 228, 229, 232, 237
- Six Sigma 1–8
- Six Sigma process 98, 117, 206
- Six Sigma project, *see* project
- Six Sigma roadmap 6–8
- slope 76, 78, 182, 183, 395, 415
- slope parameter 415, 418, 421, 444
- sorting 56
- special cause variation 17–20, 68, 144, 148–152, 183
- specification limits 17, 38, 39, 112, 115–117, 203, 211
- spread, *see* variability
- stable, predictable process 17, 18, 27, 152
 - see also* statistical control
- Stack columns 44, 45
- Stack blocks of columns 48
- Stack rows 45
- stages with control charts 157, 158

- standard normal distribution 111
 standardized effects 351, 356
 standardized residuals 418
 standardized values/variables 77, 213
 StatGuide 23, 48, 462–466
 statistical control 17, 144
 statistical model(s) 99–129
 stem value 64
 stem-and-leaf display 63–68
 stratification 50
 subdialog box 16
 subgroup(s) 16, 22, 143, 151
 Submit Commands 477
 subscripts 44, 45, 47, 52
 Subset Worksheet 71
 sum of independent random variables 118–120
 surface plot 342, 433
 survival statistics, *see* reliability and survival statistics
 t-distribution 243
 tables 51, 97
 tally individual variables 51
 tampering 186–189
 target 2, 5, 115, 117, 160, 182, 186
 test statistic 113, 241, 243, 244, 246, 257, 268
 275, 282, 292, 293, 437
 test for a single proportion, *see* 1 proportion test
 test for equality of variance 294–296
 tests for evidence of special causes, *see* control chart, tests
 tests for more than two proportions 291–294
 tests for two proportions, *see* 2 proportions test
 tests of hypotheses 241
 time series plot 49, 171
 toolbar(s) 15, 20, 22, 32
 trials 100
 t-test 243–246
 tutorials 466–468
 two-sample t-test 252–255
 two-tailed test 240
 two-way ANOVA 284, 285
 type I error 228, 229
 type II error 228, 229
 U chart, *see* control charts
 uniform distribution 119, 120
 unstack columns 52, 53
 Update Graph Automatically 146
 UCL, upper control(chart) limit, *see* control charts, three sigma limits
 USL, upper specification limit 38, 116, 203, 205
 variability 1, 5, 29, 38–43
 variable name 15
 variance components 277, 323–325
 variance-covariance matrix 76
 Weibull distribution 215, 216
 Western Electric Company (WECO) rules 160
 Wilcoxon test 249–251
 worksheet, *see* Minitab worksheet
 X chart, *see* control charts
 Xbar chart, *see* control charts
 Xs 7–9, 80, 413
 Yellow Belts 8
 Ys 7–9, 80, 413
 z-test 234–241

SQL	0.00	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09
3.30	35931	35149	34380	33626	32885	32157	31443	30742	30055	29379
3.40	28717	28067	27429	26804	26190	25588	24998	24420	23852	23296
3.50	22750	22216	21692	21179	20675	20182	19699	19226	18763	18309
3.60	17865	17429	17003	16586	16178	15778	15386	15004	14629	14262
3.70	13904	13553	13209	12874	12546	12225	11911	11604	11304	11011
3.80	10724	10444	10170	9903	9642	9387	9138	8894	8656	8424
3.90	8198	7976	7760	7549	7344	7143	6947	6756	6569	6387
4.00	6210	6037	5868	5703	5543	5386	5234	5085	4940	4799
4.10	4661	4527	4396	4269	4145	4025	3907	3793	3681	3573
4.20	3467	3364	3264	3167	3072	2980	2890	2803	2718	2635
4.30	2555	2477	2401	2327	2256	2186	2118	2052	1988	1926
4.40	1866	1807	1750	1695	1641	1589	1538	1489	1441	1395
4.50	1350	1306	1264	1223	1183	1144	1107	1070	1035	1001
4.60	968	935	904	874	845	816	789	762	736	711
4.70	687	664	641	619	598	577	557	538	519	501
4.80	483	466	450	434	419	404	390	376	362	349
4.90	337	325	313	302	291	280	270	260	251	242
5.00	233	224	216	208	200	193	185	178	172	165
5.10	159	153	147	142	136	131	126	121	117	112
5.20	108	104	100	96	92	88	85	82	78	75
5.30	72	69	67	64	62	59	57	54	52	50
5.40	48	46	44	42	41	39	37	36	34	33
5.50	32	30	29	28	27	26	25	24	23	22
5.60	20.7	19.8	19.0	18.1	17.4	16.6	15.9	15.2	14.6	14.0
5.70	13.4	12.8	12.2	11.7	11.2	10.7	10.2	9.8	9.4	8.9
5.80	8.5	8.2	7.8	7.5	7.1	6.8	6.5	6.2	5.9	5.7
5.90	5.4	5.2	4.9	4.7	4.5	4.3	4.1	3.9	3.7	3.6
6.00	3.4	3.2	3.1	3.0	2.8	2.7	2.6	2.4	2.3	2.2