



**Trials/Tribulations of ITDE's Statistical Process Control(SPC) Process:**

What/How in small machine shop took a paper-based SPC collection system into a network-based organization wide system in three years. This type of "talkin' shop" topic could be beneficial to APICS/ASQ members contemplating what/how to improve monitoring and controlling their processes

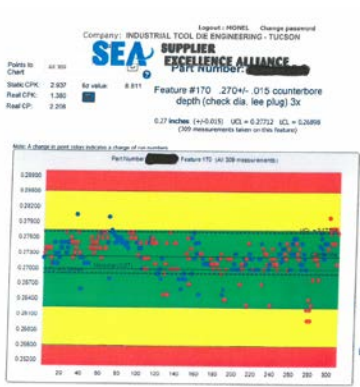
**Act One: Past**

- Handwritten Ballooned Print
- Handwritten Requirements/Results
- Handwritten SPC
- Labour intensive AS9102 Package
- Storage/Printing Reams of Paper
- Hidden Factory: Rejects/Scrap/RWK

Key No.	Dep. Feature / Characteristic	Dep. Zone	Method of Inspection	1st Article Results	Mean	Std Dev	Range
1	3.058 005	304	Q-T M/C	2.976	2.997	0.000	0.000
2	Ø.0000.003	208	FINN	Acc	Acc	Acc	Acc
3	Ø.32 5T		GAGE	Acc	Acc	Acc	Acc
4	X STEP 0.00 005	401	CALIPER	Acc	Acc	Acc	Acc
5	Ø.168 005		FINN	Acc	Acc	Acc	Acc
6	Ø.170-20-33	304	TRO GAGE	Acc	Acc	Acc	Acc
7	Ø.100 005	305	CALIPER	Acc	Acc	Acc	Acc
8	Ø.35 00000	304	FINN	Acc	Acc	Acc	Acc
9	1.70 0.453 005	304	FINN	Acc	Acc	Acc	Acc
10	Ø.050 002	305	FINN	Acc	Acc	Acc	Acc
11	Ø.430 010	304	FINN	Acc	Acc	Acc	Acc
12	Ø.250 010	408	CALIPER	Acc	Acc	Acc	Acc
13	Ø.150	408	FINN	Acc	Acc	Acc	Acc
14	Ø.1875-1880	407	FINN	Acc	Acc	Acc	Acc
15							
16							

**Act Two: Present**

- Define/Aid Machine Seq# Requirement
- C<sub>pk</sub> Review to Reduce Inspection
- Continuous Improvement Projects
- Monthly Metrics
- Electronic Rejection Notification
- MFD Package.PDF: Appr/Link Subtiers



**Act Three: Future**

- Electronic MFD Package Review/Appr
- Product Audits/AQL to Streamline FAI
- Users Group
- Integrate: ERP to CAPAR/NCMR
- Integrate: DISCUS/NetInspect
- Alerts: Maintenance/Calibration