



International
Standard

ISO 22514-2

**Statistical methods in process
management — Capability and
performance —**

Part 2:
**Process capability and performance
of time-dependent process models**

*Méthodes statistiques dans la gestion de processus — Aptitude et
performance —*

*Partie 2: Aptitude de processus et performance des modèles de
processus dépendants du temps*

Third edition
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Contents

Page

Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms, definitions, symbols and abbreviated terms	1
3.1 Terms and definitions	1
3.2 Symbols	2
3.3 Abbreviated terms	3
4 Process analysis	3
5 Time-dependent distribution models	3
5.1 Model A1	6
5.2 Model A2	8
5.3 Model B	9
5.4 Model C1	10
5.5 Model C2	12
5.6 Model C3	13
5.7 Model C4	14
5.8 Model D	16
6 Process capability and performance indices	17
6.1 Methods for determination of performance and capability indices — Overview	17
6.1.1 General geometric method	17
6.1.2 Calculation of location	19
6.1.3 Calculation of dispersion	19
6.1.4 Calculation of $X_{0,135\%}$, $X_{50\%}$, and $X_{99,865\%}$	20
6.2 One-sided specification limits	20
6.3 Use of different calculation methods	22
7 Reporting process performance/capability indices	23
https://standards.iteh.ai/catalog/standards/iso-9e4b3/c8-964d-4343-9534-1597dc54ca45/iso-22514-2-2026	23
Bibliography	24

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 69, *Applications of statistical methods*, Subcommittee SC 4, *Applications of statistical methods in product and process management*.

This third edition cancels and replaces the second edition (ISO 22514-2:2017), which has been technically revised.

The main changes are as follows:

[ISO 22514-2:2026](http://www.iso.org/iso/20170313/9e4b37c8-964d-4343-9534-1597dc54ca45/iso-22514-2-2026)

- three new process models have been added;
- more information about process in control has been added in [Clause 4](#);
- [Table 1](#) and [Table 2](#) have been revised and the new process models added;
- $\hat{X}_{\text{mid}} = X_{50\%}$ was added in [Table 3](#);
- recommendation was added in [6.3](#);
- information about finding the distribution was added in [Clause 7](#);
- location calculation 5 was added in [Table 5](#);
- editorial adjustments have been made.

A list of all parts in the ISO 22514 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

Many standards have been created concerning the quality capability/performance of processes by international, regional and national standardization bodies and also by industry. All of them assume that the process is in a state of statistical control, with stationary, normally distributed processes. However, a comprehensive analysis of production processes shows that, over time, it is very rare for processes to remain in such a state.

In recognition of this fact, this document provides a framework for estimating the quality capability/performance of industrial processes for an array of standard circumstances. These circumstances are categorized based on the stability of the mean and variance, as to whether they are constant, changing systematically, or changing randomly. As such, the quality capability/performance can be assessed for very differently shaped distributions with respect to time.

In other parts of ISO 22514 more detailed information about calculations of indices can be found. It should be noted that where the capability indices given in this document are computed they only form point estimates of their true values. It is therefore recommended that wherever possible the indices' confidence intervals are computed and reported.

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