
Control charts —

**Part 1:
General guidelines**

Cartes de contrôle —

Partie 1: Lignes directrices générales

iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

[ISO 7870-1:2019](https://standards.iteh.ai/catalog/standards/iso/fe26958a-893f-4c57-bc40-7d6cb5ae9220/iso-7870-1-2019)

<https://standards.iteh.ai/catalog/standards/iso/fe26958a-893f-4c57-bc40-7d6cb5ae9220/iso-7870-1-2019>



iTeh Standards
(<https://standards.iteh.ai>)
Document Preview

[ISO 7870-1:2019](https://standards.iteh.ai/catalog/standards/iso/fe26958a-893f-4c57-bc40-7d6cb5ae9220/iso-7870-1-2019)

<https://standards.iteh.ai/catalog/standards/iso/fe26958a-893f-4c57-bc40-7d6cb5ae9220/iso-7870-1-2019>



COPYRIGHT PROTECTED DOCUMENT

© ISO 2019

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Fax: +41 22 749 09 47
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

Contents

| | Page |
|--|-----------|
| Foreword | iv |
| Introduction | v |
| 1 Scope | 1 |
| 2 Normative references | 1 |
| 3 Terms and definitions | 1 |
| 4 Symbols and abbreviated terms | 7 |
| 4.1 Symbols..... | 7 |
| 4.2 Abbreviated terms..... | 8 |
| 5 Concepts | 8 |
| 5.1 Control chart..... | 8 |
| 5.2 Statistical control of a process..... | 9 |
| 5.3 Acceptance of a process..... | 9 |
| 5.4 Management of a process with a natural drift..... | 9 |
| 5.5 Risks of decision errors..... | 9 |
| 5.6 Design of data collection..... | 10 |
| 5.6.1 General..... | 10 |
| 5.6.2 Choice of characteristic..... | 10 |
| 5.6.3 Measurement process evaluation..... | 10 |
| 5.6.4 Subgroup selection..... | 10 |
| 5.6.5 Subgroup size..... | 11 |
| 5.6.6 Sampling frequency..... | 11 |
| 5.7 Control charts for variables and attributes data..... | 11 |
| 6 Types of control charts | 12 |
| 7 Charts for process stability | 12 |
| 7.1 General..... | 12 |
| 7.2 Partial listing of Shewhart and related control charts..... | 13 |
| 7.2.1 General..... | 13 |
| 7.2.2 Charts using data from only one rational subgroup for each plotted value..... | 13 |
| 7.2.3 Charts using data from more than one subgroup for each plotted value..... | 14 |
| 7.2.4 Charts for non-independent (autocorrelated) observations..... | 14 |
| 8 Charts for process acceptance | 15 |
| 8.1 General..... | 15 |
| 8.2 Acceptance control charts (see ISO 7870-3)..... | 15 |
| 8.3 Modified control charts (control charts with modified limits; see ISO 7870-3)..... | 15 |
| 9 Process adjustment | 16 |
| Annex A (informative) Charting styles and colours for control charts | 17 |
| Bibliography | 19 |

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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

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

This third edition of ISO 7870-1 cancels and replaces the second edition (ISO 7870-1:2014), which has been technically revised.

The main changes compared to the previous edition are as follows:

- Added Annex A, specifying the conventions for drafting control charts.

A list of all parts in the ISO 7870 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.