
Overview

This standard covers the competences required for contributing to the application of measurement systems analysis (MSA). You will contribute to the selection of an appropriate measurement system on which to carry out the analysis, and to the obtaining of all the necessary data in order to carry out the measurement systems analysis. You will be expected to contribute to the application of the principles and processes of measurement system analysis, which will include such things as completing a calibration study on a gauge, conducting a gauge linearity study, completing either an attribute or a variable gauge repeatability and reproducibility study, and conducting a metrology study on a measurement system which includes either a variable or attribute gauge repeatability and reproducibility study.

You will be required to contribute to the analysis, using the appropriate techniques and recording the results of the analysis in the appropriate format. From this information, you will contribute to determining the percentage gauge repeatability and reproducibility of the measurement system under study, and to producing a detail report suggesting ways in which the measurement system might be improved.

Your responsibilities will require you to comply with organisational policy and procedures for the activities undertaken, and to report any problems with the activities that you cannot solve, or that are outside your responsibility, to the relevant authority. You will need to ensure that all the necessary documentation is completed accurately and legibly. You will be expected to take responsibility for your own actions within the activity, and for the quality and accuracy of the work that you produce.

Your underpinning knowledge will provide a good understanding of measurement systems analysis, and will provide an informed approach to the techniques and procedures used. You will need to understand the principles and application of MSA, in adequate depth to provide a sound basis for carrying out the activities to the required criteria.

Applying safe working practices will be a key issue throughout.

Performance criteria

You must be able to:

1. work safely at all times, complying with health and safety and other relevant regulations, directives and guidelines
2. contribute to the selection of an appropriate measurement system on which to carry out the analysis
3. contribute to obtaining all the necessary data in order to carry out the measurement systems analysis
4. contribute to the analysis, using the appropriate techniques
5. record the results of the analysis in the appropriate format
6. contribute to determining the percentage gauge repeatability and reproducibility of the measurement system under study, and to suggesting ways of improving the measurement system
7. contribute to the production of a measurement systems analysis report, detailing ways of improving the measurement system under study

Knowledge and understanding

You need to know and understand:

1. how to work safely at all times, complying with health and safety and other relevant regulations, directives and guidelines
2. why we should study our measurement systems
3. how to select a measurement system for analysis
4. the possible sources of measurement system variation
5. how measurement systems analysis be used in a Six Sigma improvement project
6. the meaning of 'repeatability and reproducibility study'
7. the terminology used in measurement systems analysis
8. how to conduct a measurement systems analysis study
9. the calculation for gauge repeatability and reproducibility
10. the calculation for gauge precision and tolerance
11. the industry rules for repeatability and reproducibility results
12. the extent of your own authority within the project, and to whom you should report in the event of problems that you cannot resolve

Scope/range related to performance criteria

1. Contribute to a measurement system analysis, which includes **two** from the following:
 1. completing a calibration study on a gauge
 2. conducting a gauge linearity study
 3. completing either an attribute or a variable gauge repeatability and reproducibility study
 4. conducting a metrology study on a measurement system, which includes either a variable or attribute gauge repeatability and reproducibility
2. Contribute to determining the type of measurement system variation, to include **two** of the following:
 1. bias
 2. linearity
 3. stability
 4. accuracy
 5. repeatability
 6. reproducibility

Developed by	Enginuity
Version Number	3
Date Approved	30 Mar 2023
Indicative Review Date	31 Mar 2028
Validity	Current
Status	Original
Originating Organisation	Enginuity
Original URN	SEMBIT218
Relevant Occupations	Associate Professionals and Technical Occupations, Business and Finance Associate Professionals, Business Management, Business, Administration and Law
Suite	Business Improvement Techniques Suite 2
Keywords	Engineering; business; improvement; techniques; measurement systems analysis; MSA; repeatability; reproducibility