

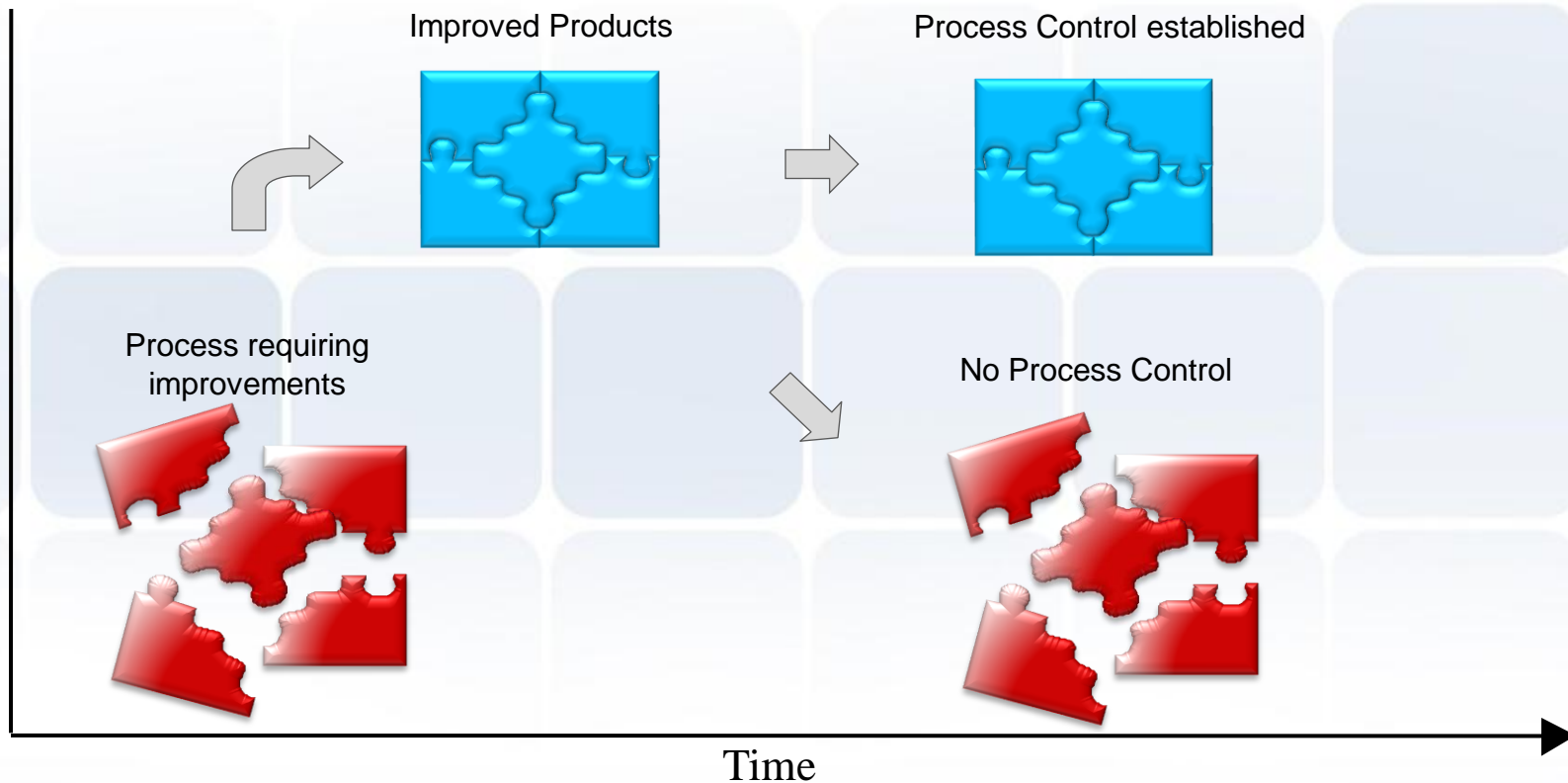
# Start Up Screen

**Control Plan**

**Take Aways**

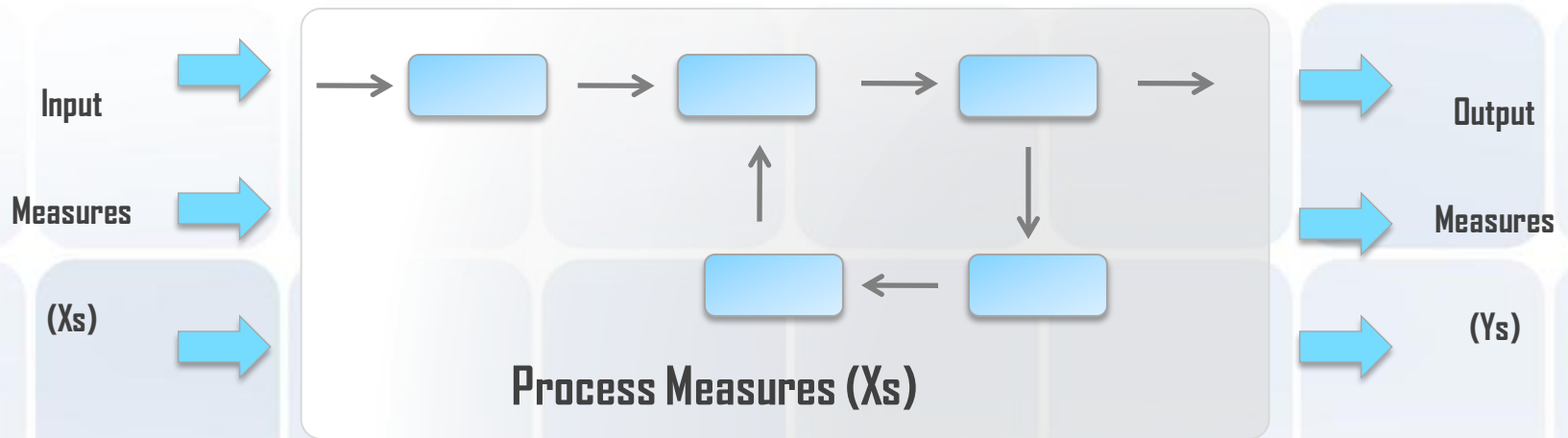


# Role of Process Control in 6σ projects



Improvements achieved through Six Sigma projects don't sustain over time if process control mechanism isn't established

# Control Parameters



- 👍 At the barest minimum, monitor CTQs (Ys)
- 👍 Strive to measure critical input & process measures (Xs)
- 👍 Keep control measures to a minimum

# Process Control Plan

- 👍 List of CTQ and critical Xs that will be monitored on-going basis
- 👍 Specifies actions that need to be taken when the process parameters go out of control
- 👍 Aka Process Management Plan

Process	Metric	Frequency of measurement	Control Method	Reaction Plan	Person Responsible
Turning	Shaft Dia	20 components/Day	Statistical Process Control Charts	Stop Production and Correct	Dick
Grinding	Shaft Dia	Every 5th Component	Statistical Process Control Charts	Stop Production and Correct	Mark

# Reaction Plan

Reaction plan can include:



Continue with close monitoring



Enforce manual override



Follow special instructions



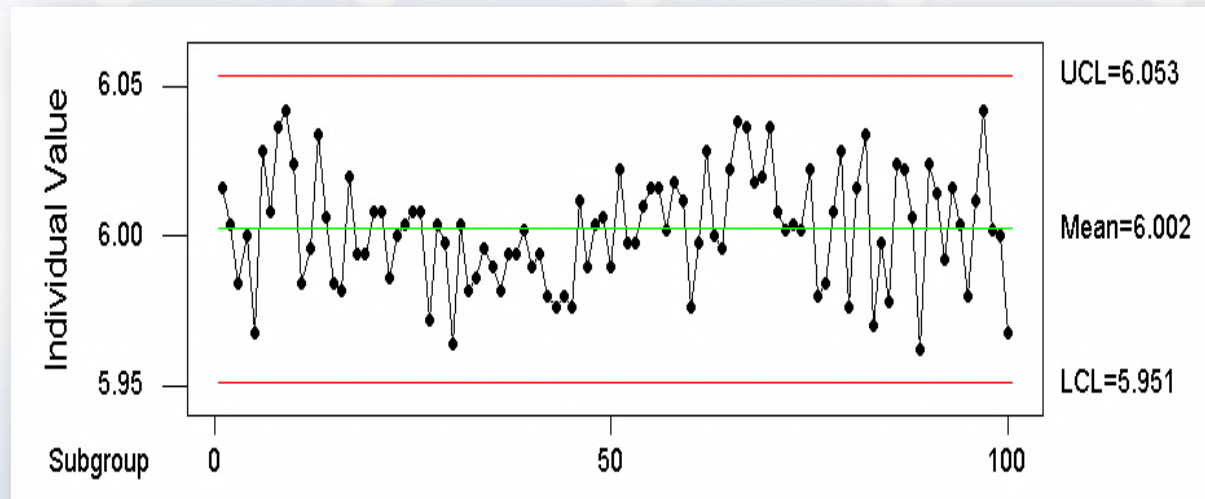
Stop & escalate



Stop, correct & resume

# Control Chart

- 👍 A line chart of any metric with upper & lower threshold limits
- 👍 Y axis contains metric & X axis contains samples collected in chronological order (against time)
- 👍 Threshold limits are called Control limits



# Control Limits & Specification Limits

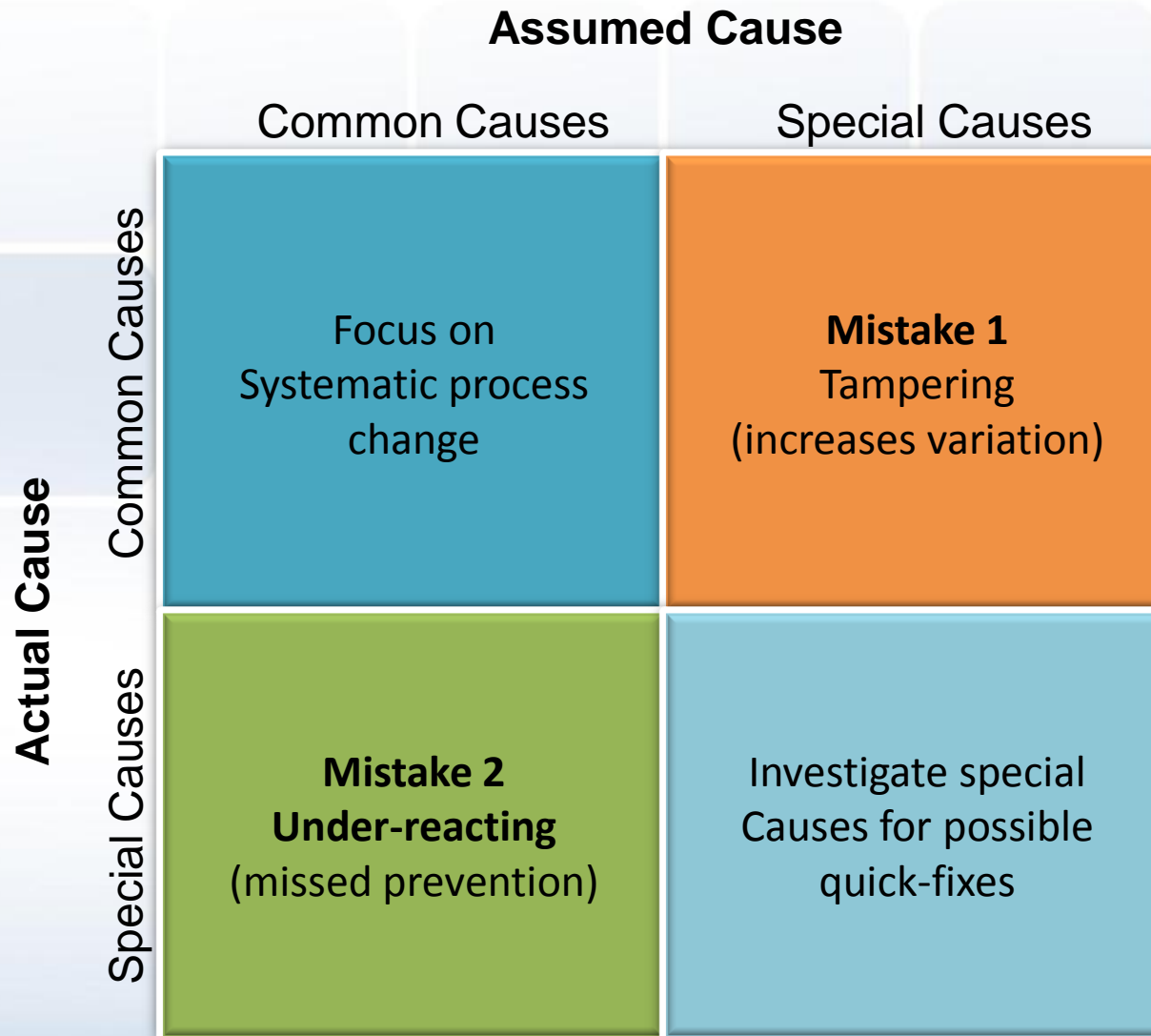
## Control Limits

- 👍 Control Limits computed from the process performance
- 👍 Assumed as Voice of process
- 👍 Process with lesser variation will have tighter control limits

## Specification Limits

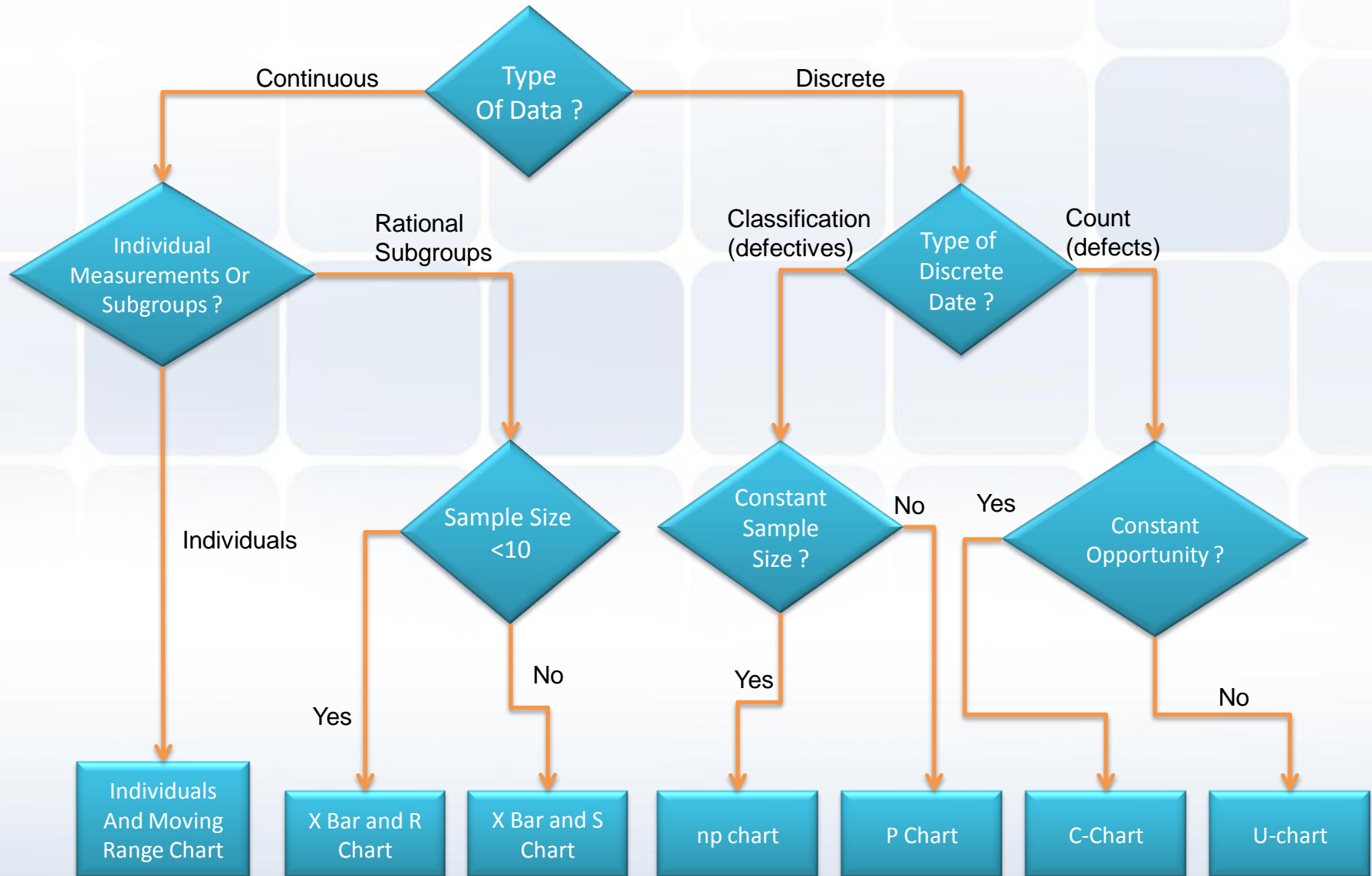
- 👍 Specifications Limits are set by the customers
- 👍 Assumed as Voice of Customer
- 👍 Process variation has no bearing on customer specification limits

# Interpretation Scenarios





# Choosing Control Charts



# Project Closure

- 👍 Project goal has been accomplished
- 👍 Project documentation is complete
- 👍 Formal sign-off by project champion
- 👍 New process is institutionalized
- 👍 Team members are recognized
- 👍 Celebration of success

# About Us

**We are a Consulting & Management firm & help clients in:**

- Deriving & executing **Business & Functional Strategies**
- Making **Customer Experience** a competitive advantage
- Improving profitability by leading **Business Transformation** initiatives

## Consulting Clientele

