4-3. táblázat

Definíció és becslésmód	A kártya típusa			
	R	s	s^2	x-átlag
A kártya paramétereinek definíciója	$CL_R = d_2\sigma$ $UCL_R = \overline{R} + 3\sigma_R$ $LCL_R = \overline{R} - 3\sigma_R$ $\sigma_R = d_3\sigma$	$CL_s = c_4\sigma$ $UCL_s = \overline{s} + 3\sigma_s$ $LCL_s = \overline{s} - 3\sigma_s$ $\sigma_s = \sigma\sqrt{1-c_4^2}$	$CL_{s^2} = \sigma^2$ $UCL_{s^2} = \frac{\sigma^2 \chi^2_{\text{felső}}}{n-1}$ $LCL_{s^2} = \frac{\sigma^2 \chi^2_{\text{alsó}}}{n-1}$	$CL_{\bar{x}} = \mu$ $UCL_{\bar{x}} = \overline{\overline{x}} + 3\frac{\sigma}{\sqrt{n}}$ $LCL_{\bar{x}} = \overline{\overline{x}} - 3\frac{\sigma}{\sqrt{n}}$
σ^2 becslésének módja				
R-ből $\hat{\sigma} = \frac{\overline{R}}{d_2}$	$CL_R = \overline{R}$ $UCL_R = \overline{R} + 3\frac{d_3\overline{R}}{d_2} = D_4\overline{R}$ $LCL_R = \overline{R} - 3\frac{d_3\overline{R}}{d_2} = D_3\overline{R}$	$CL_s = \frac{c_4}{d_2}\overline{R}$ $UCL_s = \frac{c_4}{d_2}\overline{R} + 3\frac{\overline{R}\sqrt{1-c_4^2}}{d_2}$ $LCL_s = \frac{c_4}{d_2}\overline{R} - 3\frac{\overline{R}\sqrt{1-c_4^2}}{d_2}$	$CL_{s^2} = \frac{\overline{R}^2}{d_2^2}$ $UCL_{s^2} = \frac{\overline{R}^2 \chi^2_{\text{felső}}}{d_2^2(n-1)}$ $LCL_{s^2} = \frac{\overline{R}^2 \chi^2_{\text{alsó}}}{d_2^2(n-1)}$	$CL_{\bar{x}} = \mu$ $UCL_{\bar{x}} = \overline{\overline{x}} + \frac{3\overline{R}}{d_2\sqrt{n}} = \overline{\overline{x}} + A_2\overline{R}$ $LCL_{\bar{x}} = \overline{\overline{x}} - \frac{3\overline{R}}{d_2\sqrt{n}} = \overline{\overline{x}} - A_2\overline{R}$
s-ből $\hat{\sigma} = \frac{\overline{s}}{c_4}$	$CL_R = \frac{d_2}{c_4}\overline{s}$ $UCL_R = \frac{d_2}{c_4}\overline{s} + 3\frac{d_3\overline{s}}{c_4}$ $LCL_R = \frac{d_2}{c_4}\overline{s} - 3\frac{d_3\overline{s}}{c_4}$	$CL_s = \overline{s}$ $UCL_s = \overline{s} + 3\frac{\overline{s}}{c_4}\sqrt{1-c_4^2} = B_4\overline{s}$ $LCL_s = \overline{s} - 3\frac{\overline{s}}{c_4}\sqrt{1-c_4^2} = B_3\overline{s}$	$CL_{s^2} = c_4^2\overline{s}^2$ $UCL_{s^2} = \frac{\overline{s}^2 \chi^2_{\text{felső}}}{c_4^2(n-1)}$ $LCL_{s^2} = \frac{\overline{s}^2 \chi^2_{\text{alsó}}}{c_4^2(n-1)}$	$CL_{\bar{x}} = \mu$ $UCL_{\bar{x}} = \overline{\overline{x}} + 3\frac{\overline{s}}{c_4\sqrt{n}} = \overline{\overline{x}} + A_3\overline{s}$ $LCL_{\bar{x}} = \overline{\overline{x}} - 3\frac{\overline{s}}{c_4\sqrt{n}} = \overline{\overline{x}} - A_3\overline{s}$

4-3. táblázat folytatása

σ^2 becslésének módja	A kártya típusa			
	R	*s*	s^2	*x*-átlag
s^2-bôl $\sigma^2 = \overline{s^2}$	$CL_R = d_2\sqrt{\overline{s^2}}$ $UCL_R = d_2\sqrt{\overline{s^2}} + 3d_3\sqrt{\overline{s^2}}$ $LCL_R = d_2\sqrt{\overline{s^2}} - 3d_3\sqrt{\overline{s^2}}$	$CL_s = c_4\sqrt{\overline{s^2}}$ $UCL_R = c_4\sqrt{\overline{s^2}} + 3\sqrt{\overline{s^2}}\sqrt{1-c_4^2}$ $LCL_R = c_4\sqrt{\overline{s^2}} - 3\sqrt{\overline{s^2}}\sqrt{1-c_4^2}$	$CL_{s^2} = \overline{s^2}$ $UCL_{s^2} = \frac{\overline{s^2}\chi^2_{fölsô}}{n-1}$ $LCL_{s^2} = \frac{\overline{s^2}\chi^2_{alsó}}{n-1}$	$CL_{\bar{x}} = \mu$ $UCL_{\bar{x}} = \bar{\bar{x}} + 3\frac{\sqrt{\overline{s^2}}}{\sqrt{n}}$ $LCL_{\bar{x}} = \bar{\bar{x}} - 3\frac{\sqrt{\overline{s^2}}}{\sqrt{n}}$
σ^2 és μ adott	$CL_R = d_2\sigma$ $UCL_R = d_2\sigma + 3d_3\sigma$ $LCL_R = d_2\sigma - 3d_3\sigma$	$CL_s = c_4\sigma$ $UCL_s = c_4\sigma + 3\sigma\sqrt{1-c_4^2}$ $LCL_s = c_4\sigma - 3\sigma\sqrt{1-c_4^2}$	$CL_{s^2} = \sigma^2$ $UCL_{s^2} = \frac{\sigma^2\chi^2_{fölsô}}{n-1}$ $UCL_{s^2} = \frac{\sigma^2\chi^2_{alsó}}{n-1}$	$CL_{\bar{x}} = \mu$ $UCL_{\bar{x}} = \mu + 3\frac{\sigma}{\sqrt{n}}$ $LCL_{\bar{x}} = \mu - 3\frac{\sigma}{\sqrt{n}}$
az előzetes adatfelvétel mintaelemszámához veendő	c_4, d_2	$\sqrt{1-c_4^2}$, d_2	c_4, d_2	
az ellenőrzés mintaelemszámához veendő	d_3	c_4	χ^2	