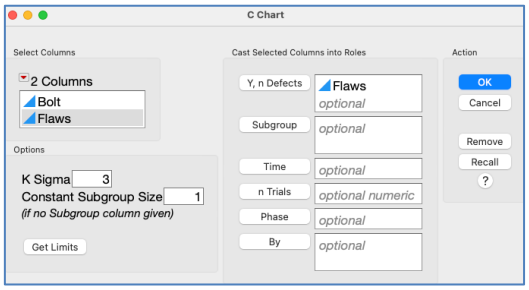
Attribute Control Charts – C and U Charts

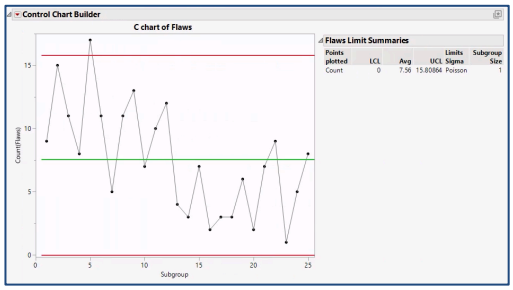
This guide provides instructions on creating C and U attribute control charts. C charts are often used to plot the number of nonconformities (or defects) in a subgroup that usually, but not necessarily, consists of one inspection unit, while U charts are often used to plot the number of nonconformities per unit, where the number of units per subgroup can vary.

C Charts

1. From an open JMP® data table, select **Analyze > Quality and Process > Control Chart > C Control Chart**.
2. Select one or more continuous variables from **Select Columns**, and click **Process**.
3. Select the column defining the unit size (if not a constant size) and place in the **n Trials** role. Click **OK**.
   Note: If sample sizes are not constant, the control limits will vary.

Fabric.jmp (Help > Sample Data Folder > Quality Control)



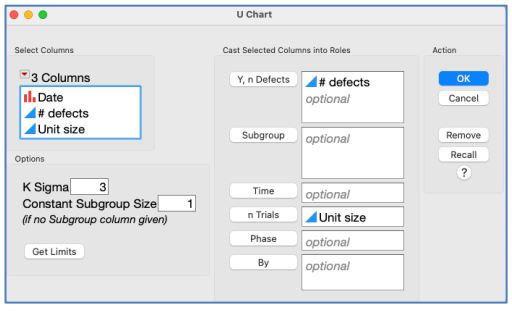


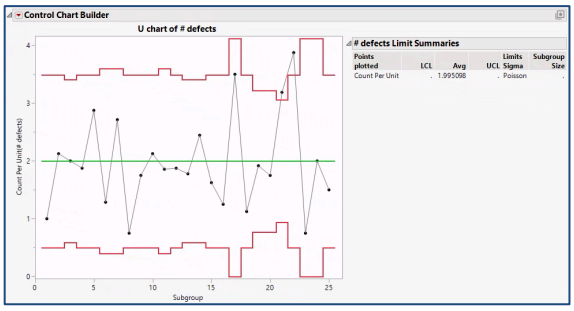
U Charts (or DPU Charts)

1. From an open JMP data table, select **Analyze > Quality and Process > Control Chart > U Control Chart**.
2. Select one or more continuous variables from **Select Columns**, and click **Process**.
3. Select the column defining the unit size (if not a constant size) and place in the **n Trials** role. Click **OK**.

   In the example below, the number of defects (# defects) per unit inspected (Unit Size) is plotted on a U
   Note: Since the Unit size is not constant, the control limits vary.

Example: Braces.jmp (Help > Sample Data > Quality Control)





Tips:

- The process variable must be sorted in time order.
- Many options, such as **tests** for special causes and **capability** analysis, are available from the **red triangles**.

Visit **Quality and Process Methods > Legacy Control Charts** in **JMP Help** to learn more.