Example 21.1
(1). Open data xm21-01.jmp;
(2). Click “Graph -> Control Chart”, choose “Springs” as “Process”, choose “XBar” and “S”; choose “Sample Size Constant” and input “4”;
(3). Click “OK” and you get the following result:

Variable Control Chart
XBar of Springs

Note: Sigma used for limits based on standard deviation.

S of Springs

Eight tests for X-Bar control chart:
(1). From the above graph output, click the red triangle before “XBar for Springs”, choose Tests -> All Tests, then we get the following graph, we can see that “5” is marked on one point, which means Test 5 failed at this point;
**Example 21.2**
We have already get the S-Chart from example 21.1, it is just the graph above.

**Example 21.3**
(1). Open data xm21-01.jmp;
(2). Click “Graph -> Control Chart”, choose “Springs” as “Process”, choose “XBar” and “R”; choose “Sample Size Constant” and input “4”;
(3). Click “OK” and you get the following result:

Note: Sigma used for limits based on range.
Example 21.4
Same as example 21.3.

Example 21.5
(1). Open data “xm21-05.jmp”;
(2). Click “Graph -> Control Chart”;
(3). Choose “Disks” as “Process”, choose “Chart Type -> P”;
(4). Fill in constant size “200”, then click “OK”;
(5). The following is the result: