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Two general approaches Sample produced at the same time consecutive units Sample representing all units produced since last sample Often used to make decisions about acceptance of product Effective at detecting shifts to out-of-control state and back into in-control state between samples Care must be taken because we can often make any process appear to be in statistical control just by stretching out the interval between observations in the sample.

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Statistical quality control provides off-line tools to support analysis- and decision-making to help determine if a process is stable and predictable. When SPC and SQC tools work together, users see the current and long-term picture about processing performance (refer Figure 9.9).

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