

Worksheet for Selecting a QC Procedure

Test	
Method	
System	
Analyst	
Date	

1. Define quality requirement	%TEa at Xc	

2. Determine method performance	%CV	
	%bias	

3. Calculate normalized operating point

a. $y\text{-coordinate} = (\%bias/\%TEa)100$

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b. $x\text{-coordinate} = (\%CV/\%TEa)100$

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4. Select normalized OPSpecs charts for 2 or 3 control materials

5. Plot normalized operating point

6. Inspect OPSpecs chart and select QC procedure

- a. Solution found on lo-N 90% chart
- b. Solution found on lo-N 50% chart
- c. Solution found on hi-N 90% chart
- d. Solution found on hi-N 50% chart
- e. No solution, use max QC

RULES

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Total N

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7. Adopt a Total QC strategy

- a. Solution on 90% chart - Hi-Ped
- b. Solution on 50% chart - Mod-Ped
- c. No solution - Lo-Ped

TQC

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Flow chart for manual quality-planning process using normalized OPSpecs charts

