

表1 ある電子部品の歩留まりデータ(%)
(3年前の生産実績から20ロット/日 サンプルング, 4週間分)

M/D	1	2	3	4	5	6	7	8	9	10	平均値	シグマ
6/1	87.7	86.7	83.2	78.0	86.0	84.9	89.1	90.3	82.4	77.0	84.5	4.4
	84.1	93.2	83.2	89.4	91.0	87.6	76.8	82.5	86.3	90.0	86.4	4.9
6/2	85.7	67.8	90.0	73.0	89.1	81.3	89.9	90.9	85.6	84.9	83.8	7.8
	87.7	79.2	87.1	86.1	89.5	84.4	82.4	88.7	84.6	93.3	86.3	3.9
6/3	90.0	81.3	86.7	89.6	88.7	93.1	85.8	95.7	85.9	83.2	88.0	4.4
	90.5	87.5	77.6	89.5	87.2	75.2	86.5	88.3	91.0	85.2	85.8	5.3
6/4	84.8	88.9	88.9	81.8	91.4	81.8	84.6	91.0	92.8	91.0	87.7	4.1
	89.1	86.0	90.7	76.0	88.6	86.1	93.9	88.8	81.4	79.2	86.0	5.5
6/5	95.1	86.9	88.9	91.0	82.2	87.4	91.7	90.0	93.6	92.8	90.0	3.8
	92.6	87.8	89.7	94.5	89.8	90.2	93.2	88.9	92.2	92.1	91.1	2.1
											87.0	4.6
6/7	95.2	94.1	69.4	84.5	95.0	90.7	87.5	87.5	91.5	94.6	89.0	7.8
	90.2	79.4	88.5	93.4	94.3	93.0	88.3	95.8	91.2	88.0	90.2	4.7
6/8	90.8	88.4	88.0	94.8	91.7	91.1	86.6	91.1	83.0	91.3	89.7	3.3
	93.0	90.8	88.9	87.4	93.0	92.9	87.9	76.6	97.3	89.5	89.7	5.5
6/9	90.2	91.7	83.4	75.1	92.9	85.1	89.5	88.2	82.2	92.7	87.1	5.7
	85.5	77.7	80.9	81.9	86.8	92.2	87.2	85.4	88.5	83.4	85.0	4.1
6/10	92.7	89.3	90.7	88.2	90.9	87.4	89.0	93.0	92.7	76.8	89.1	4.7
	91.9	93.0	85.8	84.7	82.4	89.9	85.4	81.8	96.0	92.7	88.4	5.0
6/11	87.2	88.6	88.9	87.5	86.4	90.9	94.6	92.2	95.0	92.8	90.4	3.1
	92.8	91.6	87.8	88.8	84.4	90.8	85.1	91.8	88.2	94.8	89.6	3.3
											88.8	4.7
6/14	92.9	73.3	93.3	90.6	82.6	87.4	86.2	86.4	91.8	87.3	87.2	5.9
	89.6	92.0	91.1	89.4	79.2	90.8	93.9	92.2	90.7	91.6	90.1	4.0
6/15	92.8	79.6	88.4	90.8	89.6	95.7	81.3	93.1	92.7	88.9	89.3	5.2
	90.4	94.7	90.5	95.0	89.8	94.5	93.3	88.2	92.2	93.2	92.2	2.3
6/16	86.9	87.4	83.6	89.7	84.3	78.8	97.8	94.6	88.6	90.4	88.2	5.5
	90.1	88.0	87.0	87.7	91.8	88.2	90.1	84.4	95.5	92.8	89.6	3.2
6/17	80.9	84.3	93.9	84.7	85.4	90.5	88.6	86.3	88.4	85.0	86.8	3.7
	82.8	90.7	95.1	94.9	84.0	91.0	93.5	95.5	97.1	97.4	92.2	5.1
6/18	95.7	93.6	93.7	83.4	90.6	75.2	93.3	85.4	91.1	92.4	89.4	6.3
	92.1	89.8	94.2	94.0	87.8	90.6	91.9	92.1	89.6	92.1	91.4	2.0
											89.6	4.3
6/21	94.4	77.8	87.3	95.0	86.3	81.3	92.3	96.8	90.4	91.2	89.3	6.1
	93.4	90.2	94.2	94.5	86.5	92.4	92.8	94.6	95.1	79.8	91.4	4.8
6/22	92.2	86.9	95.3	95.7	95.6	79.0	92.3	88.2	93.2	87.1	90.6	5.3
	93.0	94.0	93.3	88.4	97.3	92.6	88.3	92.0	88.4	84.9	91.2	3.6
6/23	91.8	78.8	88.4	93.5	91.2	92.2	91.3	85.3	91.2	81.5	88.5	5.0
	89.2	89.5	91.9	91.6	95.0	92.3	90.7	89.2	94.4	95.3	91.9	2.3
6/24	93.3	95.3	92.3	93.0	92.2	90.9	91.4	91.5	92.8	93.4	92.6	1.3
	89.4	87.1	95.7	84.7	97.8	93.6	89.7	96.5	82.7	90.6	90.8	5.1
6/25	91.4	93.5	95.0	94.0	87.8	98.7	88.2	87.7	84.9	95.5	91.7	4.4
	82.5	97.4	82.4	98.8	87.7	84.2	96.0	82.4	96.0	89.7	89.7	6.8
											90.8	4.5