

## 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<sup>\*</sup> 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.







## 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.