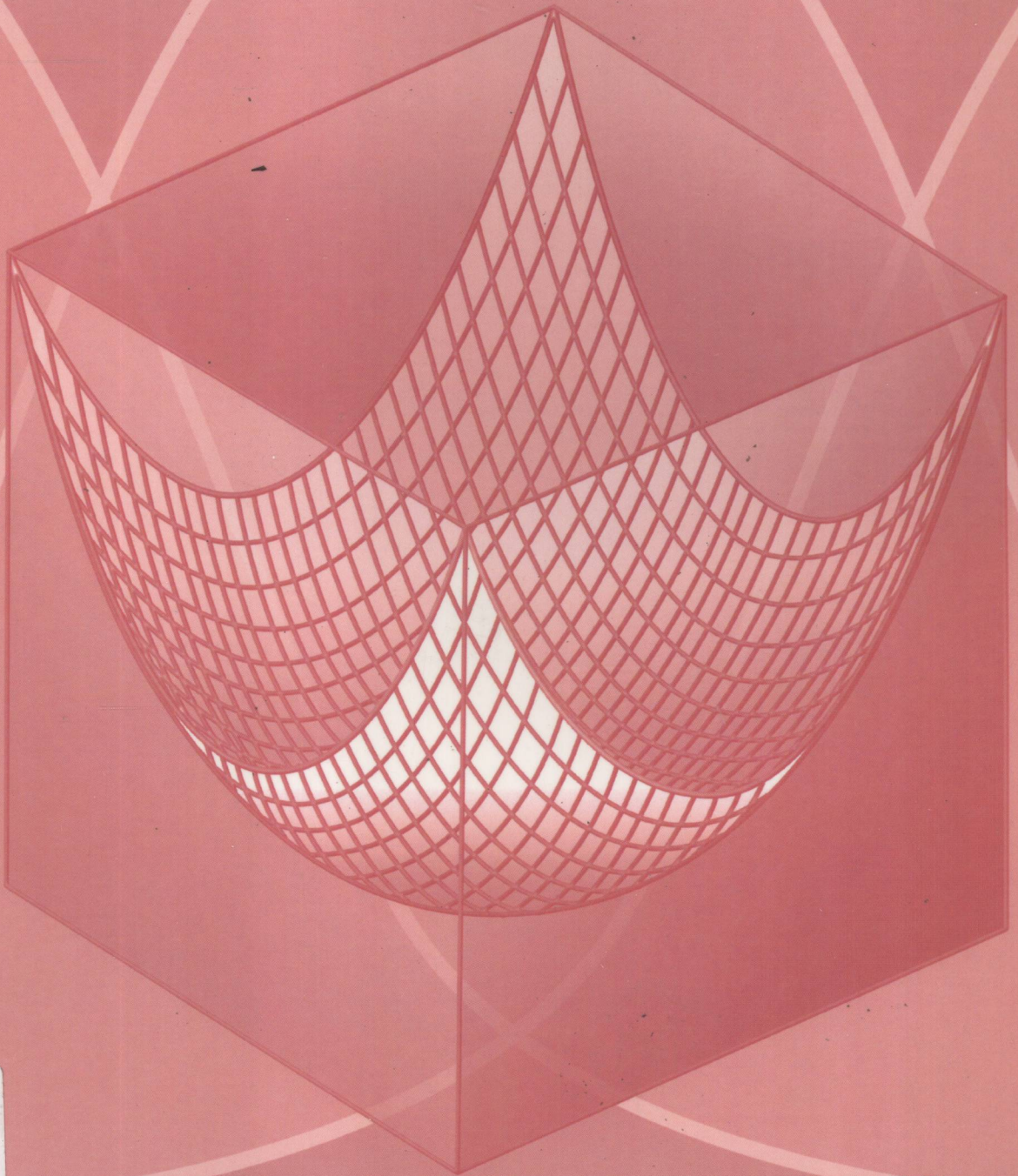


STUDENT SOLUTIONS MANUAL

FOURTH EDITION

ENGINEERING STATISTICS



4
:2
MONTGOMERY

RUNGER

HUBELE

T13114
M787:2
E.4

STUDENT SOLUTIONS MANUAL

ENGINEERING STATISTICS

Fourth Edition

Douglas C. Montgomery

Arizona State University

George C. Runger

Arizona State University

Norma F. Hubele

Arizona State University



E2008001521



John Wiley & Sons, Inc.

Cover Photo: Norm Christiansen

Printed and bound by Hamilton Printing.

Copyright © 2009 John Wiley & Sons, Inc. All rights reserved.

No part of this publication may be reproduced, stored in a retrieval system or transmitted in any form or by any means, electronic, mechanical, photocopying, recording, scanning, or otherwise, except as permitted under Sections 107 or 108 of the 1976 United States Copyright Act, without either the prior written permission of the Publisher, or authorization through payment of the appropriate per-copy fee to the Copyright Clearance Center, Inc., 222 Rosewood Drive, Danvers, MA 01923, or on the web at www.copyright.com. Requests to the Publisher for permission should be addressed to the Permissions Department, John Wiley & Sons, Inc., 111 River Street, Hoboken, NJ 07030-5774, (201) 748-6011, fax (201) 748-6008, or online at <http://www.wiley.com/go/permissions>.

To order books or for customer service, please call 1-800-CALL-WILEY (225-5945).

ISBN-13 978-0-470-11004-1

Printed in the United States of America

10987654321

Table of Contents

Chapter 2	Data Summary and Presentation	1
Chapter 3	Random Variables and Probability Distributions	20
Chapter 4	Decision Making for a Single Sample	49
Chapter 5	Decision Making for Two Samples	83
Chapter 6	Building Empirical Models.....	117
Chapter 7	Design of Engineering Experiments	147
Chapter 8	Statistical Process Control	193

Chapter 2

DATA SUMMARY AND PRESENTATION

Section 2-1

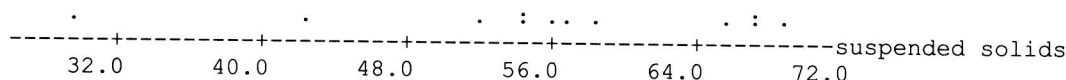
2-1. **Sample average:** $\bar{x} = \frac{\sum_{i=1}^n x_i}{n} = \frac{\sum_{i=1}^{12} x_i}{12} = \frac{673.1}{12} = 56.09$

Sample standard deviation:

$$\sum_{i=1}^{12} x_i = 673.10 \quad \sum_{i=1}^{12} x_i^2 = 39168$$

$$s = \sqrt{\frac{\sum_{i=1}^n x_i^2 - \frac{\left(\sum_{i=1}^n x_i\right)^2}{n}}{n-1}} = \sqrt{\frac{39168 - \frac{(673.10)^2}{12}}{12-1}} = \sqrt{\frac{1412.70}{11}} = \sqrt{128.43} = 11.33$$

Dot diagram:



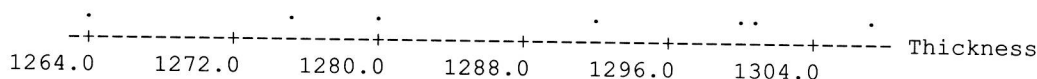
2-3. **Sample average:** $\bar{x} = \frac{\sum_{i=1}^n x_i}{n} = \frac{\sum_{i=1}^7 x_i}{7} = \frac{9019}{7} = 1288.43 \text{ angstroms}$

Sample standard deviation:

$$\sum_{i=1}^7 x_i = 9019 \quad \sum_{i=1}^7 x_i^2 = 11621835$$

$$s = \sqrt{\frac{\sum_{i=1}^n x_i^2 - \frac{\left(\sum_{i=1}^n x_i\right)^2}{n}}{n-1}} = \sqrt{\frac{11621835 - \frac{(9019)^2}{7}}{7-1}} = \sqrt{\frac{1497.71}{6}} = \sqrt{249.62 \text{ (angstroms)}^2} = 15.80 \text{ angstroms}$$

Dot diagram:



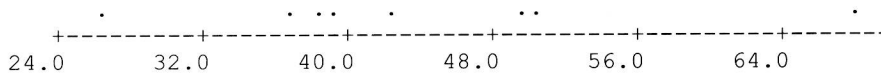
2-5. **Sample average:** $\bar{x} = \frac{\sum_{i=1}^n x_i}{n} = \frac{\sum_{i=1}^8 x_i}{8} = \frac{351.8}{8} = 43.98$

Sample standard deviation:

$$\sum_{i=1}^8 x_i = 351.8 \quad \sum_{i=1}^8 x_i^2 = 16528.40$$

$$s = \sqrt{\frac{\sum_{i=1}^n x_i^2 - \frac{\left(\sum_{i=1}^n x_i\right)^2}{n}}{n-1}} = \sqrt{\frac{16528.40 - \frac{(351.8)^2}{8}}{8-1}} = \sqrt{\frac{1058}{7}} = \sqrt{151.143} = 12.29$$

Dot diagram:



2-7. **Sample average:**

$$\bar{x} = \frac{\sum_{i=1}^{35} x_i}{35} = \frac{28368}{35} = 810.514 \text{ watts/m}^2$$

Sample variance:

$$\sum_{i=1}^{35} x_i = 28368$$

$$\sum_{i=1}^{35} x_i^2 = 23552500$$

$$s^2 = \frac{\sum_{i=1}^n x_i^2 - \frac{\left(\sum_{i=1}^n x_i\right)^2}{n}}{n-1} = \frac{23552500 - \frac{(28368)^2}{35}}{35-1} = \frac{559830.743}{34} = 16465.61 \text{ (watts/m}^2\text{)}^2$$

Sample standard deviation:

$$s = \sqrt{16465.61} = 128.32 \text{ watts/m}^2$$

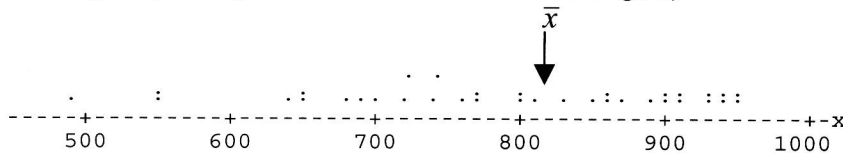
The sample standard deviation could also be found using

$$s = \sqrt{\frac{\sum_{i=1}^n (x_i - \bar{x})^2}{n-1}}$$

where

$$\sum_{i=1}^{35} (x_i - \bar{x})^2 = 559830.743$$

Dot Diagram (rounding of the data is used to create the dot diagram)



The sample mean is the point at which the data would balance if it were on a scale.

2-9. The only two data sets that may have resulted from a designed experiment is in Exercise 2-4 and 2-8.

Section 2-2

2-11. a) Stem-and-leaf display for cycles: unit = 100 1|2 represents 1200

```

1      0T|3
1      0F|
5      0S|7777
10     0o|88899
22     1*|000000011111
33     1T|2222223333
(15)   1F|44444555555555
22     1S|66667777777
11     1o|888899
5      2*|011
2      2T|22

```

b) No, only 5/70 survived beyond 2000 cycles.

2-13. Stem-and-leaf display for yield: unit = 1 1|2 represents 12

```

1      7o|8
1      8*|
7      8T|223333
21     8F|444444455555
38     8S|666666666777777
(11)   8o|88888999999
41     9*|0000000001111
27     9T|22233333
19     9F|44444445555
7      9S|666677
1      9o|8

```

2-15. Stem-and-leaf of solar intensity measurements N = 35

Leaf Unit = 10

```

1      4      9
1      5
3      5      56
3      6
7      6      5569
10     7      003
14     7      5677
(4)    8      0023
17     8      56779
12     9      00113344
4      9      5556

```

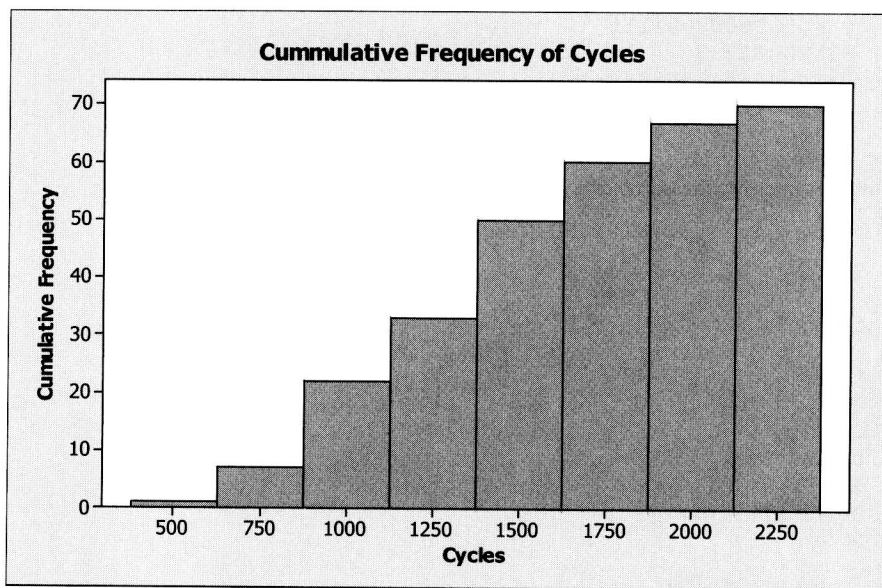
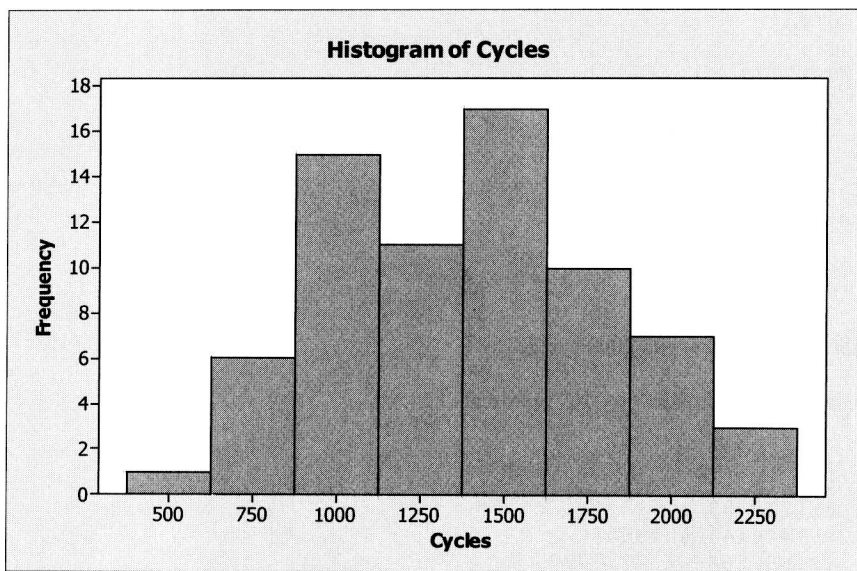
It's not symmetric – left skewed.

2-17.	Variable	N	Median	Q1	Q3	5 th	95 th
	Cycles	70	1436.5	1097.8	1735.0	772.85	2113.5

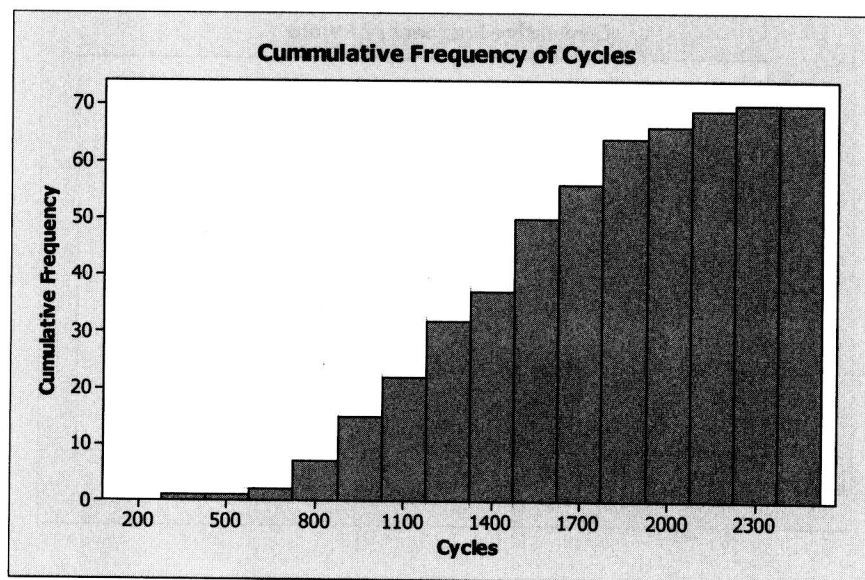
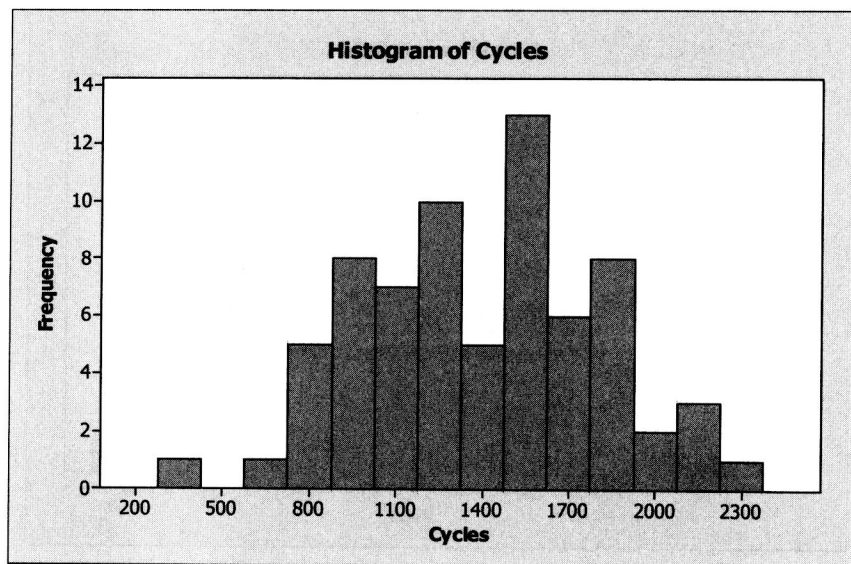
2-19.	Variable	N	Median	Q1	Q3	5 th	95 th
	Yield	90	89.25	86.10	93.125	83.055	96.58

Section 2-3

2-21. a) 8 bins

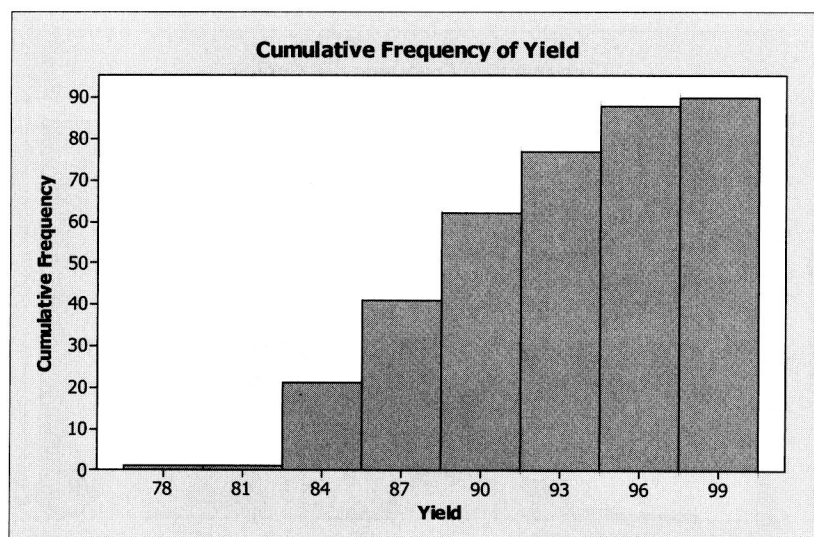
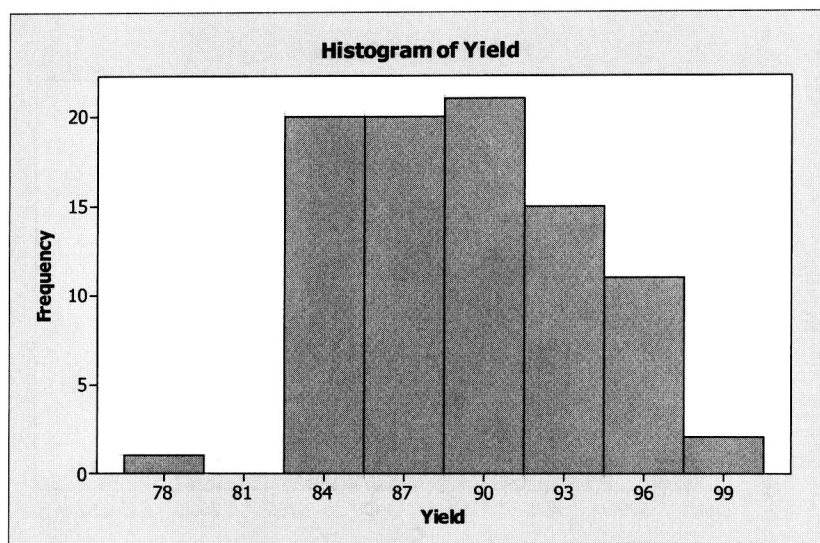


b) 16 bins

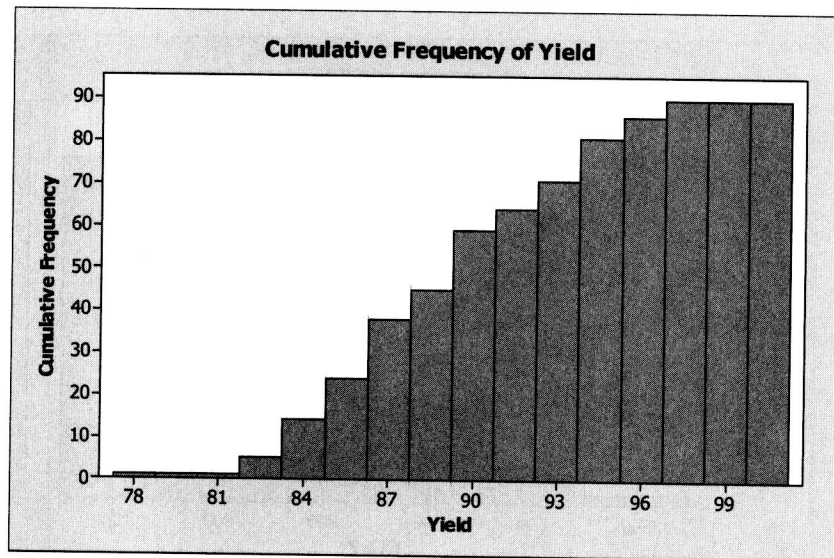
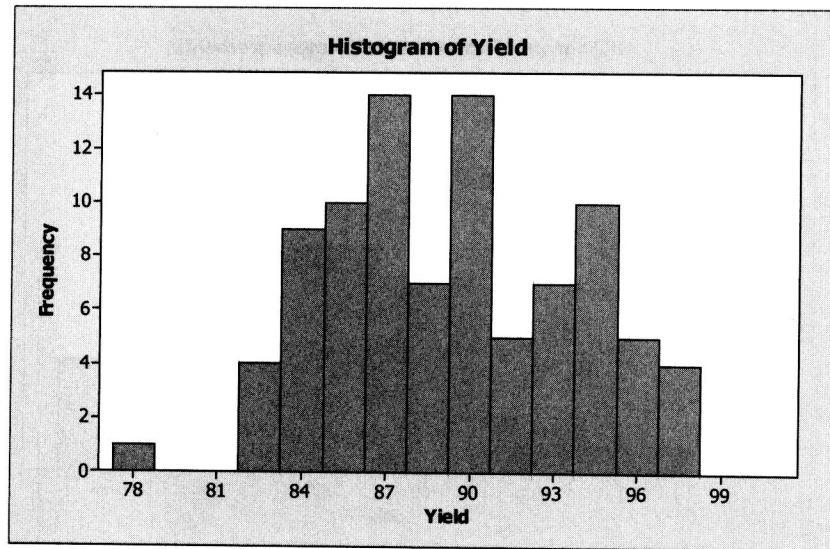


Yes, both histograms display similar information based on this dataset.

2-23. a) 8 bins

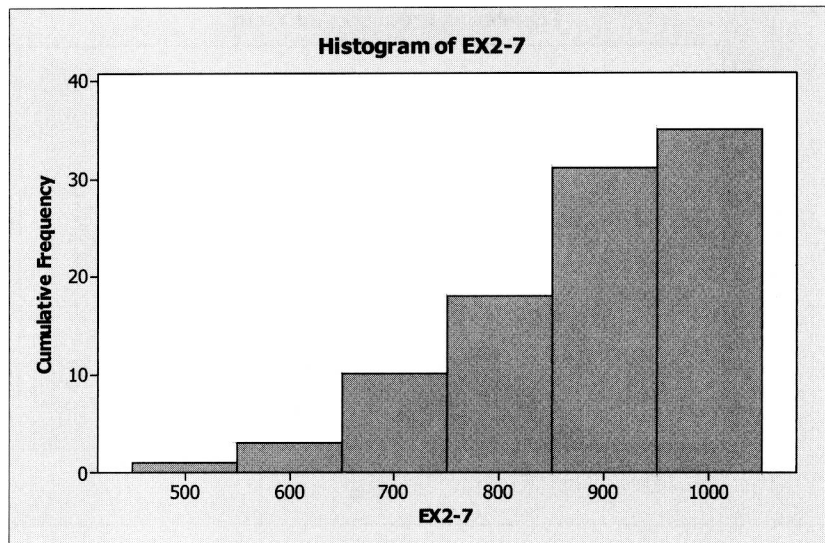
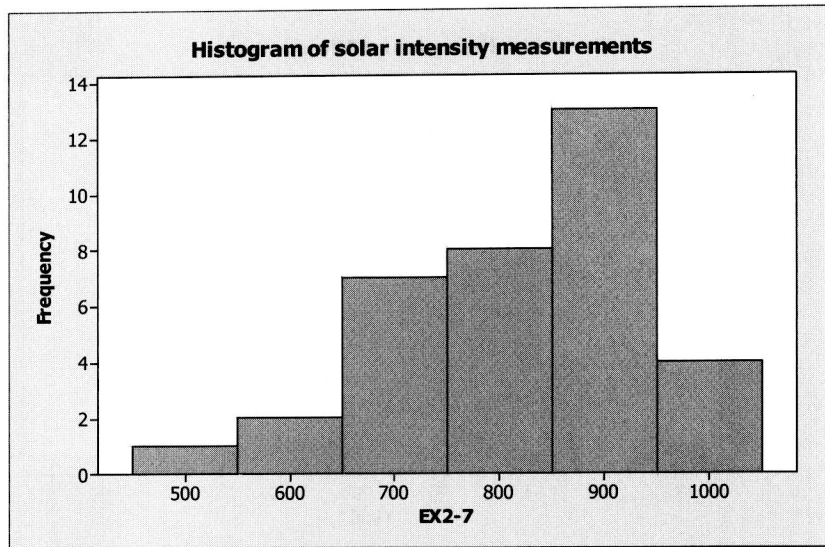


b) 16 bins



Yes, both histograms display similar information based on this dataset.

2-25. 6 bins

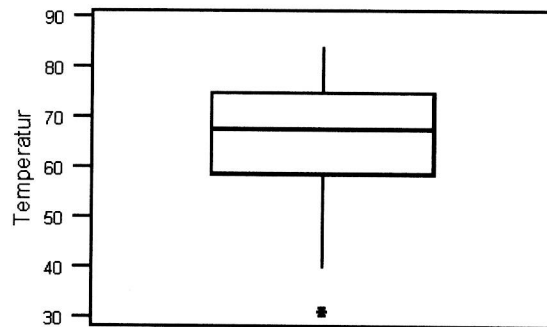


Section 2-4

- 2-27. a) Sample Mean: 65.86, Sample Standard Deviation: 12.16
 b) Q_1 : 58.5, Q_3 : 75
 c) Median: 67.5
 d) Sample Mean: 66.86, Sample Standard Deviation: 10.74, Q_1 : 60, Q_3 : 75, Median: 68

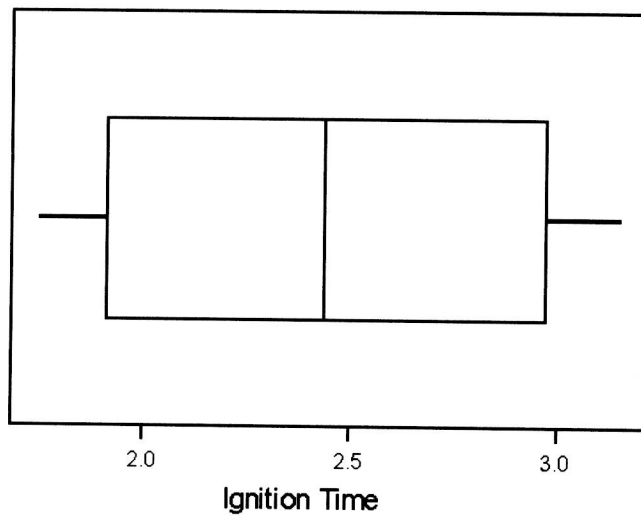
The mean has increased while the sample standard deviation has decreased. The lower quartile has increased while the upper quartile has remained unchanged. The median has increased slightly due to the removal of the data point. The smallest value appears quite different than the other temperature values.

- e) Using the entire data set, the box plot is

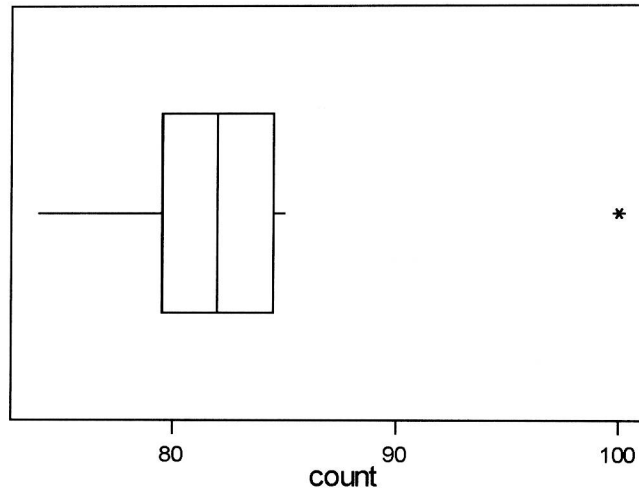


The value of 31 appears to be one possible outlier.

- 2-29. a) Sample mean = 2.415, Sample standard deviation = 0.534
 b)

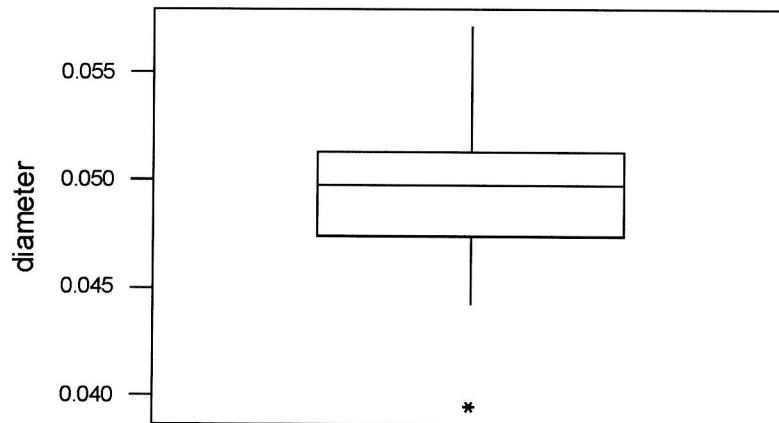


- 2-31. a) Sample mean: 83.11, sample variance = 50.55, sample standard deviation = 7.11
 b) $Q_1 = 79.5$, $Q_3 = 84.50$
 c)



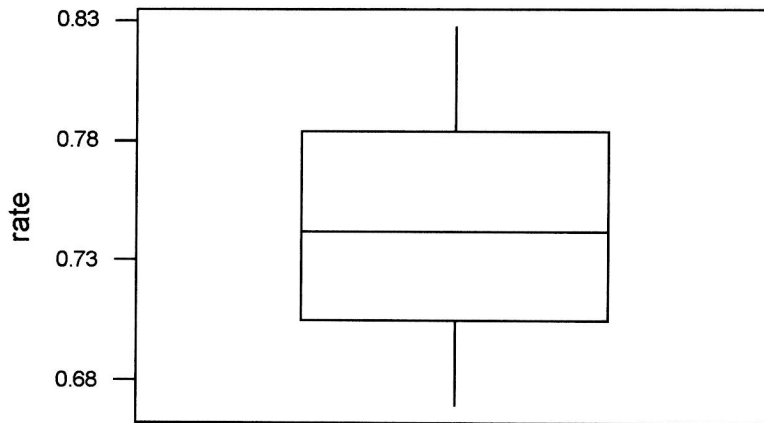
- d) Sample mean = 81, sample standard deviation = 3.46, $Q_1 = 79.25$, $Q_3 = 83.75$. The sample mean and the sample standard deviation have decreased. The lower quartile has decreased slightly while the upper quartile has decreased.

- 2-33. a) Sample Mean: 0.04939, Sample Variance: 0.00001568
 b) Q_1 : 0.04738, Q_3 : 0.0513
 c) Sample Median: 0.04975
 d)



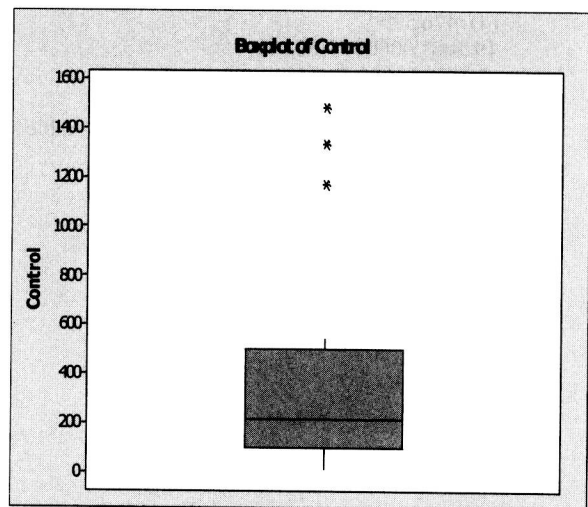
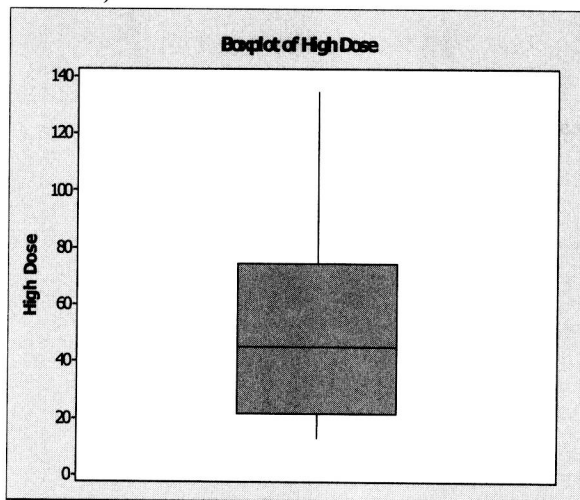
- e) 5th Percentile: 0.03974, 95th Percentile: 0.057

- 2-35. a) Sample Mean: 0.7481, Sample Variance: 0.00226
 b) Q_1 : 0.7050, Q_3 : 0.7838
 c) Sample Median: 0.742
 d)



- e) 5th Percentile: 0.5025, 95th Percentile: 0.821

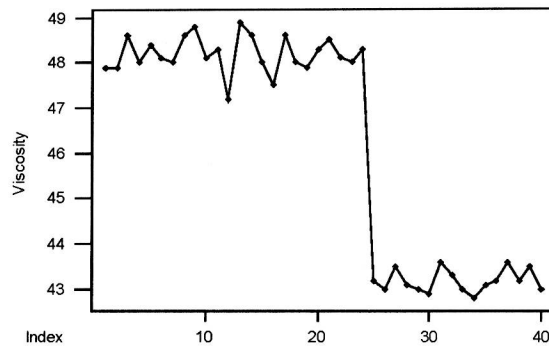
- 2-37. a) High Dose: Sample Mean: 52.65, Sample Variance: 1490.32
 Control: Sample Mean: 382.7, Sample Variance: 175224.35
 b) High Dose: Q_1 : 21.70, Q_3 : 74.38
 Control: Q_1 : 101.9, Q_3 : 501.1
 c) High Dose: Sample Median: 45
 Control: Sample Median: 215.4
 d)



- e) High Dose: 5th Percentile: 13.125, 95th Percentile: 133.67
 Control: 5th Percentile: 17.045, 95th Percentile: 1460.23
 All summary statistics are larger for the control group.

Section 2-5

2-39. a)



Stem-and-leaf display for Problem 2-32. Viscosity: unit = 0.1 1|2 represents 1.2

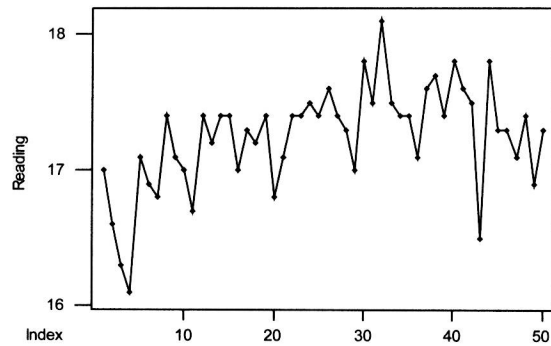
```

2  42o|89
12 43*|0000112223
16 43o|5566
16 44*|
16 44o|
16 45*|
16 45o|
16 46*|
16 46o|
17 47*|2
(4) 47o|5999
19 48*|000001113334
7  48o|5666689

```

b) The plots indicates that the process is not stable and not capable of meeting the specifications.

2-41.



Stem-and-leaf display for Concentration: unit = 0.01 1/2 represents 0.12
LO|1610,1630

```

3 165|0
4 166|0
5 167|0
7 168|00
9 169|00
13 170|0000
18 171|00000
20 172|00
25 173|00000
25 174|0000000000000000
12 175|0000
8 176|000
5 177|0
4 178|000
    
```

HI|1810
The data appear skewed.