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| DEFINE | <ul style="list-style-type: none"> Project Charter Identify Team Select Performance Metrics COPQ, Productivity or Inventory Savings Prediction Leverage Potential |
| MEASURE | <ul style="list-style-type: none"> Value Stream Map – Current State Performance Metrics Scorecard – baseline SIPOC Process Flow Chart Pareto Histogram Gage R&R Process Performance Scorecard Created |
| ANALYZE | <ul style="list-style-type: none"> Cause and Effect Diagram with CNX Control Charts MSA Before Capability Analysis (Cpk) Value Stream Map - Future State Failure Modes and Effects Analysis Statistical Tests Screening DOE Key Variables Defined (CTQ) Process Performance Scorecard Updated |
| IMPROVE | <ul style="list-style-type: none"> Modeling DOE $Y = f(x)$ Optimal Settings Confirmation Runs After Capability Analysis (Histogram, Control Charts, and Cpk) Process Performance Scorecard Updated |
| CONTROL | <ul style="list-style-type: none"> SOP Control Plan Process Performance Scorecard Updated (with new baselines) Visual controls Error Proofing COPQ Savings Realized Leverage Realized |