

Nonparametric Shewhart-type quality control charts in fuzzy environment

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Abstract Nonparametric control charts are presented in order to figure out the problem of detecting changes in the process median (or mean), or changes in the variability process where there is limited knowledge regarding the underlying process. When observations are reported imprecise, then it is impossible to use classical nonparametric control charts. This paper is devoted to the problem of constructing nonparametric control charts in presence of fuzzy data and parameters. For this aim, we propose two different methods: distance between fuzzy numbers and credibility measure for ranking fuzzy data, that can be used to construct sign and Wilcoxon signed-rank control charts. Then, this statistical control charts are applied to monitor location and scale parameters of a continuous statistical process. Finally, proposed control charts application is evaluated with numerical examples.

Keyword: Fuzzy Sign Control Chart, Synthetic Control Chart, Average Run Length, $D_{p,q}$ – Distance, Credibility Measure.

1 Introduction

A control chart is one of the most used tools for monitoring the central and dispersion parameters in a manufacturing process. The most common type of these statistic control charts is Shewhart- type control chart. In the Shewhart- type control charts, the control limits is derived based upon parametric assumptions as normal distribution.

Hence, in the functional issues due to lack enough assumptions about the statistical process distribution, using traditional control charts in these situations can have negative effects.

Nonparametric control charts are parallel alternatives if one is concerned about the non-normality process. A nonparametric control chart is defined in term of run length distribution when the process is in- control.

Amin et al. [1] considered nonparametric charts for process median based on the sign test. They compared the parametric shewhart chart and sign (SN) chart for various shift sizes and underlying distributions based on their average run length (ARL). The main practical

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advantage of the SN chart is that the false alarm rate (FAR) and average run length (ARL_0) remain the same for all continuous distributions, this is not true for shewhart chart.

Bakir [2] presented a shewhart type nonparametric control chart for monitoring the median of a continuous symmetric distribution using Wilcoxon signed-rank (SR) statistic. He showed that the SR chart can compete well with the parametric shewhart chart. In fact, for some heavy-tailed symmetric distributions, the SR chart is more efficient than parametric chart.

Amin et al. [1] provided nonparametric control chart for detecting changes in the variability process based on sign test. Khilare and Shirke [12] proposed synthetic control chart which combines sign chart presented by Amin et al. [1] and conforming run length (CRL) chart suggested by Bourke [3].

Precise data are not always available. After the introduction of fuzzy sets theory by Zadeh [27], Wang and Raz [25] and Raz and Wang [20] proposed two approaches for the construction of control charts, namely a probabilistic approach and a membership approach. In the probabilistic approach, first the representative values of fuzzy observations computed and then utilized to construct control charts using traditional statistical methods. Kanagawa et al. [10] proposed linguistic control charts to monitor the process average and variability. They aimed directly at controlling the underlying probability distributions of linguistic data. α -cut fuzzy control charts for attributes were developed by Gulbay and Kahraman [9]. α -cut approach provides the ability to determine the tightness of the inspection by selecting a suitable level. Gulbay and Kahraman [8] developed a direct fuzzy approach (DFA) to fuzzy control charts without any defuzzification and then defined fuzzy unnatural pattern rules based on the probabilities of fuzzy events. Also, they [7] proposed a method to construct fuzzy control charts for categorical data in which the linguistic data are changed into representative values. They used the three-sigma rule to compute fuzzy control limits having a strong base founded upon the properties of the normal distribution, i.e., on the three-sigma rule. Nguyen et al. [18] proposed a detailed procedure to classify a process, but some of their rules were found indistinguishable by Nguyen et al. [19], who later proposed a remedy for a better performance.

Faraz and Moghaddam [4] presented a fuzzy control chart for controlling the process mean with a warning line. The warning line designed for detecting desired shift in the process mean that is important to the company. Also, Faraz et al. [5] introduced a control chart for monitoring variables and showed that the control limits in classical Shewhart charts must be adjusted when there is on ambiguity in the process mean beside randomness. Senturk and Erginel [22] propose fuzzy \bar{X} -R and \bar{X} -S control charts with α -cuts. Their idea can be traced to traditional \bar{X} -R and \bar{X} -S control charts, which rely on the properties of the normal distribution. Unfortunately, this assumption is not addressed in their paper. It should be noted that, in the presence of fuzzy data, the variance of normal observations is increased (see, Kurner [13]). Shu and Wu [24] proposed fuzzy \bar{X} -R control charts whose fuzzy control limits are obtained based on the result of the resolution identity. They utilized fuzzy dominance approach, which directly compares the fuzzy sample mean to the fuzzy control limits to determine the process condition. Recently, Zabihinpour et al. [26] developed a fuzzy mean and range control charts. In their approach, the observations and control limits are triangular fuzzy numbers. Instead of using transformation or defuzzifications techniques to determine the process condition, they proposed a direct approach based on the percentage of area of the sample mean which remains outside the control limits. The non-parametric control charts are based upon accurate data and conditions. Although in uncertain conditions, these

charts are mostly used in quality control, no research has been done in this regard so far. The goal of this research is to identify non-parametric control charts in a fuzzy environment to monitor the location and scale parameters that not only do not need the assumptions of parametric models and defuzzification functions but also have a satisfactory performance.

This paper is organized as follows. In Section 2, we recall some definitions of fuzzy number, distance between them and credibility measure theory. In Section 3, we present sign and Wilcoxon signed-rank control charts based on distance and credibility measure ranking methods in order to monitor the median process continuously. We also explain their application with numerical examples. In Section 4, we utilize sign control chart for monitoring variability process when process information is reported as imprecise data. We then describe its application with a numerical example. Section 5, presents results and conclusion.

2 Fuzzy Numbers

In this section, few definitions of fuzzy numbers, distance between two fuzzy numbers, credibility measure and ranking of fuzzy variables are explained.

2.1 Fuzzy numbers

A fuzzy subset \tilde{A} of the universal set \mathcal{X} is defined by its membership function $\mu_{\tilde{A}} : \mathcal{X} \rightarrow [0,1]$, with the set $\text{supp}(\tilde{A}) = \{x \in \mathcal{X} : \mu_{\tilde{A}}(x) > 0\}$, the support of \tilde{A} . In this work, \mathbb{R} (the real line) is considered as the universal set. It is denoted by $\tilde{A}[\alpha]$ the α -cut of the fuzzy subset \tilde{A} of \mathbb{R} , is defined for every $\alpha \in [0,1]$, by $\tilde{A}[\alpha] = \{x \in \mathbb{R}, \mu_{\tilde{A}}(x) \geq \alpha\}$, and $\tilde{A}[0]$ is the closure of $\text{supp}(\tilde{A})$. The fuzzy subset \tilde{A} of \mathbb{R} is called a fuzzy number if for every $\alpha \in [0,1]$, the set $\tilde{A}[\alpha]$ is a non-empty compact interval. Such an interval will be denoted by $\tilde{A}[\alpha] = [\tilde{A}_{\alpha}^L, \tilde{A}_{\alpha}^U]$, where $\tilde{A}_{\alpha}^L = \inf\{x : x \in \tilde{A}_{\alpha}\}$ and $\tilde{A}_{\alpha}^U = \sup\{x : x \in \tilde{A}_{\alpha}\}$. The set of all fuzzy numbers is denoted by $\mathcal{F}(\mathbb{R})$.

One of the most popular types of a fuzzy number, being considered in this work, is the recalled trapezoidal fuzzy number $\tilde{A} = (a_1, a_2, a_3, a_4)_T$ whose membership function is given by

$$\mu_{\tilde{A}}(x) = \begin{cases} 0, & x < a_1 \\ \frac{x - a_1}{a_2 - a_1}, & a_1 \leq x < a_2 \\ \frac{a_4 - x}{a_4 - a_3}, & a_3 \leq x < a_4 \\ 0, & x > a_4 \end{cases}$$

If $a_2 = a_3$, it is called a triangular fuzzy number and denoted by $\tilde{A} = (a_1, a_2, a_3, a_4)_T$. For more detailed information regarding fuzzy numbers, see Lee [15].

2.2 $D_{p,q}$ -Distance between two fuzzy numbers

Definition 1 The $D_{p,q}$ -distance, indexed by parameters $1 \leq p < \infty$ and $0 \leq q < 1$, between two fuzzy numbers \tilde{A} and \tilde{B} is a nonnegative function given as follows [23]:

$$D_{p,q}(\tilde{A}, \tilde{B}) = \begin{cases} \left[(1-q) \int_0^1 |A_\alpha^- - B_\alpha^+|^p d\alpha + q \int_0^1 |A_\alpha^+ - B_\alpha^-|^p d\alpha \right]^{\frac{1}{p}}, & p < \infty \\ (1-q) \sup_{0 < \alpha \leq 1} (|A_\alpha^- - B_\alpha^-|) + (q) \inf_{0 < \alpha \leq 1} |A_\alpha^+ - B_\alpha^+|, & p = \infty \end{cases}$$

The analytical properties of $D_{p,q}$ is depend on the first parameter p, while the second parameter q is the weighted one. $(\mathcal{F}(\mathbb{R}), D_{p,q})$ is a complete metric space. If there is no reason for distinguishing any side of the fuzzy numbers, $D_{2, \frac{1}{2}}$ is recommended.

For instance, for trapezoidal fuzzy numbers $\tilde{A} = (a_1, a_2, a_3, a_4)_T$ and $\tilde{B} = (b_1, b_2, b_3, b_4)_T$ the above distance with $p = 2$ and $q = \frac{1}{2}$ is calculated as [19]:

$$D_{2, \frac{1}{2}}(\tilde{A}, \tilde{B}) = \sqrt{\frac{1}{6} \left[\sum_{i=1}^3 (b_i - a_i)^2 + (b_2 - a_2)^2 + \sum_{i \in \{1,2\}} (b_i - a_i)(b_{i+1} - a_{i+1}) \right]} \quad (2.1)$$

Example 1 Let $\tilde{A} = (1.5, 2, 2.7)_T$ and $\tilde{B} = (0.5, 0.9, 1.8)_T$ be two fuzzy triangular numbers.

The $D_{2, \frac{1}{2}}(\tilde{A}, \tilde{B})$ is obtained as $D_{2, \frac{1}{2}}(\tilde{A}, \tilde{B}) = \sqrt{\frac{1}{6}(1 + 2.42 + 0.25 + 1.1 + 0.55)} = 0.942$.

2.3 Credibility Measure

Here we introduce an index proposed by Liu [16] which is also the foundation of the very popular credibility theory. For two fuzzy numbers \tilde{A} and \tilde{B} , the map $Cr: \mathcal{F}(\mathbb{R}) \times \mathcal{F}(\mathbb{R}) \rightarrow [0,1]$ which is defined as follows:

$$Cr(\tilde{A} > \tilde{B}) = \frac{1}{2} \left[\sup_{x, y: x > y} \min \{ \mu_{\tilde{A}}(x), \mu_{\tilde{B}}(y) \} + 1 - \sup_{x, y: x \leq y} \min \{ \mu_{\tilde{A}}(x), \mu_{\tilde{B}}(y) \} \right]$$

that \tilde{A} is larger than \tilde{B} is called the credibility degree. In addition, the credibility degree of $\tilde{A} \leq \tilde{B}$ is given by

$$Cr(\tilde{A} > \tilde{B}) = \frac{1}{2} \left[\sup_{x, y: x \leq y} \min \{ \mu_{\tilde{A}}(x), \mu_{\tilde{B}}(y) \} + 1 - \sup_{x, y: x > y} \min \{ \mu_{\tilde{A}}(x), \mu_{\tilde{B}}(y) \} \right]$$

It is easy to verify that the credibility index Cr has the following properties:

lemma 1 For two fuzzy number \tilde{A} and \tilde{B} , it is easy to verify that

- $Cr\{\tilde{A} > \tilde{B}\} \in [0,1]$,
- $Cr\{\tilde{A} > \tilde{B}\} = 1 - Cr\{\tilde{A} \leq \tilde{B}\}$,
- $Cr\{\tilde{A} > \tilde{B}\} = 1$ if only if $\tilde{B}_0^U \leq \tilde{A}_0^L$.

3 Nonparametric control chart to monitor location parameter in fuzzy environment

Nonparametric control charts are based on crisp (exact / non fuzzy) observations. However, in practice, there are many situations in which it has been found that the available data are imprecise (fuzzy) quantities rather than being precise (crisp) numbers. Many researchers have designed fuzzy control charts to communicate uncertainly due to fuzziness. Using defuzzification approach reduces the vague observation to exact numbers and it also reduces the informational content of the original fuzzy data. In addition, various defuzzification methods may result in different conclusions about the process.

In practice, there are many situations in which process is to be controlled in the presence of the two kinds of uncertainty (unknown underlying process distribution and imprecise information). In such situation, neither fuzzy nor underlying process distribution can monitor the process adequately individually. In this section, we propose a new approaches for construction control charts that can handle both uncertainties. As shewhart control charts follow parametric assumption (normal distribution) and crisp data, when do not have enough information about population distribution or parametric distribution, one possible solution is using nonparametric inferences for location and scale parameters under condition of available crisp data. If observations are reported as imprecise (fuzzy), then it is impossible to use classical nonparametric control charts. Hence, designed control charts that are unable to control lack of enough parametric assumptions and imprecise data simultaneously, will be significant.

To perform nonparametric control charts for monitoring the median of a continuous process based on imprecise observation, we propose two different methods: $D_{p,q}$ - distance ranking and credibility measure, that can be used for computing sign and Wilcoxon signed-rank statistics in every sub group of a continuous process, when observations are reported as imprecise.

3.1 Nonparametric control charts based on $D_{p,q}$ - distance ranking method

Fuzzy nonparametric control chart is based on fuzzy nonparametric tests. Each of this fuzzy nonparametric tests have their advantages. For instance, fuzzy sign tests are applicable due to its simplicity and having the less assumptions on quantiles related continuous distribution, while, fuzzy Wilcoxon signed-rank test is used for median related symmetric and continuous distribution. In order to construct fuzzy nonparametric control charts, at first, we obtain control limits based on classical methods and a nominal specified value. Then, in each subgroup sample, we determine nonparametric statistics based on - distance ranking approach. If sample statistics fall between control limits, we can say, it is in-control (IC) process, otherwise, the process is declared out-of-control state.

3.1.1 Sign control chart based on $D_{p,q}$ - distance ranking method

Fuzzy sign control chart is based on the fuzzy sign test. Let $\tilde{X}_{i1}, \tilde{X}_{i2}, \dots, \tilde{X}_{in}$ be a random sample (subgroup) of size $n > 1$ observed from a continuous process with median M (crisp or imprecise) at sampling instances $i = 1, 2, \dots, m$. It is assumed that the IC process median is

known or specified to be equal to \tilde{M}_0 . We further assume that \tilde{M}_0 is known and when $\tilde{M} \neq \tilde{M}_0$ the process is out of control (OoC). A control chart is a graphic consisted of values of a plotting statistic and the associated control limits. The steps for fuzzy sign plotting statistic computation are as follows:

1. Set the arbitrary value \tilde{B} , where \tilde{B} is a fuzzy value which is less than the smallest observation among sample observation,
2. Determine the distance between \tilde{M} and \tilde{B} i.e. $D_{2, \frac{1}{2}}(\tilde{M}, \tilde{B})$,
3. Compute the distance between \tilde{X}_{ij} and \tilde{B} i.e. $D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{B})$, for $i = 1, 2, \dots, m$.
4. The fuzzy sign statistic is obtained by the following formula:

$$SN_i = \sum_{j=1}^n \text{sign} \left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{B}) - \left(D_{2, \frac{1}{2}}(\tilde{M}_0, \tilde{B}) \right) \right), \quad i = 1, 2, \dots, m \quad (4.1)$$

for $i = 1, 2, \dots, m$, where $\text{sign}(\cdot)$ is the sign function.

In order to find the control limits, we know that the distribution of classical SN_i is known. This can be easily obtained using the relation $SN_i = 2T_i - n$, where T_i is the usual sign test statistic, which is counting the number of sample observations greater than \tilde{M} . Also, the IC distribution of T_i is binomial with parameters n and 0.5 . It follows that the IC distribution of SN_i is symmetric about 0 , hence the upper and lower control limits and the centerline of the two sided nonparametric sign chart are given by $UCL = c, CL = 0, LCL = -c$, where c is some positive integer between 0 and n .

If the plotting statistic SN_i falls on or outside one of the control limits, that is, if $SN_i \leq -c$ or $SN_i \geq c$, the process is declared to be OoC. The charting constant c is obtained for a specified ALR_0 , which in standard known case, is equal to the reciprocal of the nominal false alarm rate (FAR) and is denoted by α . Since the IC distribution of SN_i is symmetric about 0 , c is obtained as the smallest integer such that $P(SN_i \geq c | IC) \leq \frac{\alpha}{2}$. For example, for $n = 5$, using the binomial tables, we find $P(SN_i \geq 5 | IC) = 0.0312$, which leads to a $FAR = 0.0624$. This is the lowest attainable FAR for $n = 5$.

3.1.2 Wilcoxon signed-rank control chart based on $D_{p,q}$ -distance ranking method

Fuzzy Wilcoxon signed-rank control chart is based on the fuzzy Wilcoxon signed-rank test. Let $\tilde{X}_{i1}, \tilde{X}_{i2}, \dots, \tilde{X}_{in}$ be a random sample (subgroup) of size $n > 1$ observed from a continuous and symmetric process with median \tilde{M} (crisp or imprecise) at sampling instances $i = 1, 2, \dots, m$. It is assumed that the IC process median is known to be equal to \tilde{M} . The steps for fuzzy Wilcoxon signed-rank plotting statistics computation being similar to SN statistic can be summarized as follows:

1. Set the arbitrary value \tilde{B} as observations' origin,

2. Determine $D_{2, \frac{1}{2}}(\tilde{M}, \tilde{B})$,
3. Determine $D_{2, \frac{1}{2}}(X_{ij}, \tilde{B})$ and $D_{2, \frac{1}{2}}(X_{ij}, M_0)$ for $i = 1, 2, \dots, m$, $j = 1, 2, \dots, n$,
4. Ranking $D_{2, \frac{1}{2}}(X_{ij}, M_0)$ for every subgroup. Note that we use midrank method to deal with tied observations,
5. The final fuzzy signed-rank SR statistics is obtained by the following formula:

$$SR_i = \sum_{j=1}^n \text{sign} \left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{B}) - D_{2, \frac{1}{2}}(\tilde{M}_0, \tilde{B}) \right) r \left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{M}_0) \right), \quad i = 1, 2, \dots, m \quad (4.2)$$

for $i = 1, 2, \dots, m$, where $r(A)$ is the A rank value in the sample.

In the classical case, SR statistic is linearly related to the more well-known Wilcoxon signed-rank statistic W^+ through the relation $SR_i = 2W^+ - \frac{n(n+1)}{2}$, where W^+ is the sum of the ranks of absolute values corresponding to the positive deviations. Because W^+ is known to be free-distribution [6], so are the SR_i and hence the classical SR chart.

The IC distribution of SR_i is symmetric about 0, thus, choosing $UCL = -LCL$ appears to be reasonable and similar to the fuzzy sign chart results in a symmetric control chart. Thus, the control limits and central line of the two sided SR chart are: $UCL = d, CL = 0, LCL = -d$, where d is some positive integer between 1 and $\frac{n(n+1)}{2}$. If the plotting statistic SR_i fall on or outside the control limits, the process is declared to be OoC; otherwise, the process is considered to be IC. The constant d is found so that a specified FAR (or an ALR_0) is attained.

Example 2 We illustrate the sign and Wilcoxon signed-rank control charts using a fuzzy data set related to the inside diameters of piston rings manufactured by a foreign process [11]. There are the 25 samples, each of size five that were collected when the process was thought to be IC, Table 1. We assume that the underlying distribution is symmetric with a known median $M = 74$ mm. Table 2 shows the SN_i and SR_i statistics.

The sign and Wilcoxon signed-rank control charts are shown in Figures 1 and 2 with control limits at ± 5 and ± 15 , respectively. The results from these charts indicate that the medians of all groups fall between control limits, and we can conclude that the process is IC.

Table 1 TFNs for inside piston diameter measurements

| Sample Number | X_a | | | | | X_b | | | | | X_c | | | | |
|---------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| | 1 | 2 | 3 | 4 | 5 | 1 | 2 | 3 | 4 | 5 | 1 | 2 | 3 | 4 | 5 |
| 1 | 74.029 | 74.001 | 74.018 | 73.991 | 74.007 | 74.03 | 74.002 | 74.019 | 73.991 | 74.008 | 74.031 | 74.003 | 74.02 | 73.993 | 74.009 |
| 2 | 73.994 | 73.991 | 74 | 74.01 | 74.003 | 73.995 | 73.992 | 74.001 | 74.01 | 74.004 | 73.996 | 73.993 | 74.002 | 74.012 | 74.005 |
| 3 | 73.987 | 74.023 | 74.02 | 74.004 | 74.001 | 73.988 | 74.024 | 74.021 | 74.004 | 74.002 | 73.989 | 74.025 | 74.022 | 74.006 | 74.003 |
| 4 | 74.001 | 73.995 | 73.992 | 74.014 | 74.008 | 74.002 | 73.996 | 73.993 | 74.014 | 74.008 | 74.003 | 73.997 | 73.994 | 74.016 | 74.01 |
| 5 | 73.991 | 74.006 | 74.014 | 73.988 | 74.013 | 73.992 | 74.007 | 74.015 | 73.988 | 74.014 | 73.993 | 74.008 | 74.016 | 73.99 | 74.015 |
| 6 | 74.008 | 73.993 | 73.996 | 73.984 | 73.994 | 74.009 | 73.994 | 73.997 | 73.984 | 73.995 | 74.01 | 73.995 | 73.998 | 73.986 | 73.996 |
| 7 | 73.994 | 74.005 | 73.993 | 73.999 | 74.004 | 73.995 | 74.006 | 73.994 | 73.999 | 74.005 | 73.996 | 74.007 | 73.995 | 74.001 | 74.006 |
| 8 | 73.984 | 74.002 | 73.992 | 74.014 | 73.987 | 73.985 | 74.003 | 73.993 | 74.014 | 73.988 | 73.986 | 74.004 | 73.994 | 74.016 | 73.989 |
| 9 | 74.007 | 73.994 | 74.008 | 74.004 | 74.003 | 74.008 | 73.995 | 74.009 | 74.004 | 74.004 | 74.009 | 73.996 | 74.01 | 74.006 | 74.005 |
| 10 | 73.997 | 73.999 | 73.989 | 74.006 | 73.994 | 73.998 | 74 | 73.99 | 74.006 | 73.995 | 73.999 | 74.001 | 73.991 | 74.008 | 73.996 |
| 11 | 73.993 | 73.997 | 73.993 | 73.994 | 73.989 | 73.994 | 74.001 | 73.994 | 73.994 | 74.002 | 73.995 | 73.999 | 73.995 | 73.996 | 74.003 |
| 12 | 74.003 | 73.999 | 74.006 | 73.999 | 73.995 | 74.004 | 74 | 74.007 | 73.999 | 73.996 | 74.005 | 74.001 | 74.008 | 74.001 | 73.997 |
| 13 | 73.982 | 74.001 | 73.997 | 73.996 | 74.011 | 73.983 | 74.002 | 73.998 | 73.996 | 74.012 | 73.984 | 74.003 | 73.999 | 73.998 | 74.013 |
| 14 | 74.005 | 73.966 | 73.993 | 73.999 | 73.983 | 74.006 | 73.967 | 73.994 | 73.999 | 73.984 | 74.007 | 73.968 | 73.995 | 74.001 | 73.985 |
| 15 | 74.011 | 74.013 | 73.997 | 73.998 | 74.006 | 74.012 | 74.014 | 73.998 | 73.998 | 74.007 | 74.013 | 74.015 | 73.999 | 74 | 74.008 |
| 16 | 73.999 | 73.983 | 74.004 | 73.997 | 73.995 | 74 | 73.984 | 74.005 | 73.997 | 73.996 | 74.001 | 73.985 | 74.006 | 73.999 | 73.997 |
| 17 | 73.993 | 74.011 | 73.985 | 74.004 | 74.006 | 73.994 | 74.012 | 73.986 | 74.004 | 74.007 | 73.995 | 74.013 | 73.987 | 74.006 | 74.008 |
| 18 | 74.005 | 74.009 | 74.017 | 74.002 | 73.999 | 74.006 | 74.01 | 74.018 | 74.002 | 74 | 74.007 | 74.011 | 74.019 | 74.004 | 74.001 |
| 19 | 73.983 | 74.001 | 74.002 | 74.004 | 73.996 | 73.984 | 74.002 | 74.003 | 74.004 | 73.997 | 73.985 | 74.003 | 74.004 | 74.006 | 73.998 |
| 20 | 73.999 | 74.009 | 74.012 | 74.019 | 74.002 | 74 | 74.01 | 74.013 | 74.019 | 74.003 | 74.001 | 74.011 | 74.014 | 74.021 | 74.004 |
| 21 | 73.981 | 74 | 74.014 | 74.004 | 73.995 | 73.982 | 74.001 | 74.015 | 74.004 | 73.996 | 73.983 | 74.002 | 74.016 | 74.006 | 73.997 |
| 22 | 74.003 | 73.998 | 73.989 | 74.005 | 74.008 | 74.004 | 73.999 | 73.99 | 74.005 | 74.009 | 74.005 | 74 | 73.991 | 74.007 | 74.01 |
| 23 | 74.009 | 73.988 | 73.989 | 74.008 | 74.013 | 74.01 | 73.989 | 73.99 | 74.008 | 74.014 | 74.011 | 73.99 | 73.991 | 74.01 | 74.015 |
| 24 | 74.014 | 74.007 | 73.992 | 73.999 | 74.009 | 74.015 | 74.008 | 73.993 | 73.999 | 74.01 | 74.016 | 74.009 | 73.994 | 74.001 | 74.011 |
| 25 | 73.981 | 73.983 | 73.994 | 74.016 | 74.012 | 73.982 | 73.984 | 73.995 | 74.016 | 74.013 | 73.983 | 73.985 | 73.996 | 74.018 | 74.014 |

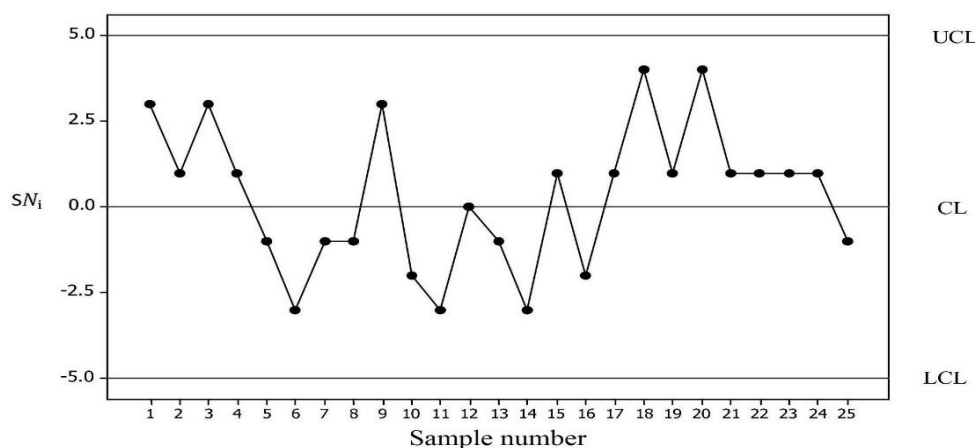
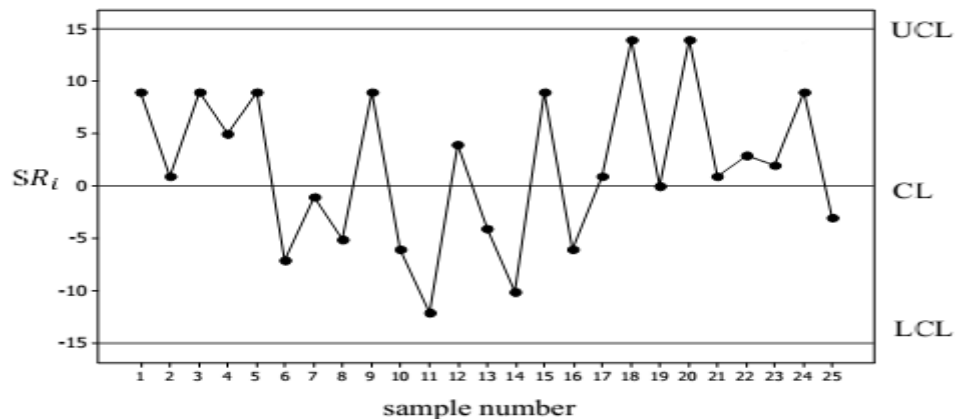
**Fig. 1** Shewhart type control chart.**Fig. 2** Shewhart type control chart.

Table 2 SN and SR statistics

| Sample number | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 |
|---------------|----|----|----|----|----|----|----|----|----|----|-----|----|----|-----|
| SN_i | 3 | 1 | 3 | 1 | -1 | -3 | -1 | -1 | 3 | -2 | -3 | 0 | -1 | -3 |
| SR_i | 9 | 1 | 9 | 5 | 9 | -7 | -1 | -5 | 9 | -6 | -12 | 4 | -4 | -10 |
| | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | | | |
| | 1 | -2 | 1 | 4 | 1 | 4 | 1 | 1 | 1 | 1 | 1 | -1 | | |
| | 9 | -6 | 1 | 14 | 0 | 14 | 1 | 3 | 2 | 9 | -3 | | | |

3.3 Nonparametric control charts based on credibility measure ranking method

In this subsection, we suggest nonparametric control charts based on credibility measure ranking approach. In this method, nonparametric test statistics are computed as a set, hence we apply concept to make a decision rule due to in control or out of the control statistical process.

P-value is the probability of obtaining a test statistic at least as extreme as the one that was actually observed assuming that the null hypothesis is true. A statistical process can consider as a series of hypothesis tests. Hence, control charts can be thought of as repeated hypothesis tests of the null hypothesis that the process is in control. Considering concept, we propose fuzzy sign control chart and fuzzy Wilcoxon control chart to monitor median of a statistical continuous process.

3.3.1 Fuzzy sign control chart based on credibility measure ranking method

Let $\tilde{X}_{i1}, \tilde{X}_{i2}, \dots, \tilde{X}_{in}$ be a random sample (sub-group) of the size $n > 1$ observed from a continuous process with median \tilde{M} (crisp or imprecise) at sampling instances $i = 1, 2, \dots, m$. It is assumed that the IC process median is known or specified to be equal to \tilde{M} . In each sub-group, the fuzzy sign (FSN) plotting statistics is computed as follows:

$$\tilde{t}_i = \{\tilde{t}_i^L, \tilde{t}_i^L + 1, \dots, \tilde{t}_i^U\}, \quad i = 1, 2, \dots, m,$$

in which

$$\tilde{t}_i^L = \inf_{\alpha > 0.5} \sum_{j=1}^n I(Cr\{\tilde{X}_{ij} \geq \tilde{M}\}), \quad \tilde{t}_i^U = \sup_{\alpha > 0.5} \sum_{j=1}^n I(Cr\{\tilde{X}_{ij} \geq \tilde{M}\}).$$

Now, to make a decision rule to in control or out of control regarding a statistical process, for imprecise observations, we apply a decision rule based on the concept of \tilde{p} -value = $[\tilde{p}^L\text{-value}, \tilde{p}^U\text{-value}]$ as follows [14]:

$$\begin{aligned} \tilde{p}^L\text{-value} &= \min_{\omega \in I_i} 2 \min \left\{ \sum_{j=0}^{\omega} \binom{j}{n} (0.5)^n, \sum_{j=\omega}^n \binom{j}{n} (0.5)^n \right\}, \\ \tilde{p}^U\text{-value} &= \max_{\omega \in I_i} 2 \min \left\{ \sum_{j=0}^{\omega} \binom{j}{n} (0.5)^n, \sum_{j=\omega}^n \binom{j}{n} (0.5)^n \right\}. \end{aligned}$$

Since the \tilde{p} -value is an interval, at significance level $\delta = 0.0027$, a degree of in-control process would be given as follows:

$$\varphi_{\delta}(\tilde{X}_{i1}, \tilde{X}_{i2}, \dots, \tilde{X}_{in}) = \begin{cases} 1, & \tilde{p}^L > 0.0027 \\ \frac{\tilde{p}^U - 0.0027}{\tilde{p}^U - \tilde{p}^L}, & \tilde{p}^L \leq 0.0027 \leq \tilde{p}^U \\ 0, & \tilde{p}^U < 0.0027 \end{cases}$$

Clearly \tilde{p} -value control chart has some properties that help the user to determine whether the point in a statistical process control is in control or not?

3.3.2 Fuzzy Wilcoxon signed-rank control chart based on credibility measure ranking method

Let $\tilde{X}_{i1}, \tilde{X}_{i2}, \dots, \tilde{X}_{in}$ be a random sample (sub-group) of the size $n > 1$ observed from a continuous and a symmetric process with median \tilde{M} (crisp or imprecise) at sampling instances $i = 1, 2, \dots, m$. It is assumed that the IC process median is known to be equal to \tilde{M} . In each sub-group, the fuzzy Wilcoxon signed-rank (FSR) plotting statistics is computed as follows:

$$\tilde{W}_i = \{\tilde{W}_i^L, \tilde{W}_i^L + 1, \dots, \tilde{W}_i^U\}, \quad i = 1, 2, \dots, m,$$

in which,

$$\tilde{W}_i^L = \inf_{\alpha > 0.5} \sum_{j=1}^n I(Cr\{\tilde{X}_{ij} \geq \tilde{M}\}) r\left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{M})\right),$$

$$\tilde{W}_i^U = \sup_{\alpha > 0.5} \sum_{j=1}^n I(Cr\{\tilde{X}_{ij} \geq \tilde{M}\}) r\left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{M})\right).$$

In making decision to in control or out of control regarding a statistical process, we apply the \tilde{p} -value concept as follows:

$$\tilde{p}^L\text{-value} = \min_{[\omega] \in \tilde{W}_i} 2 \min\{P(\tilde{W} \geq \omega), P(\tilde{W} \leq \omega)\},$$

$$\tilde{p}^U\text{-value} = \max_{[\omega] \in \tilde{W}} 2 \min\{P(\tilde{W} \geq \omega), P(\tilde{W} \leq \omega)\}.$$

For the similar fuzzy SN chart, at significance level $\delta = 0.0027$, IC process degree is as follows:

$$\varphi_{\delta}(\tilde{X}_{i1}, \tilde{X}_{i2}, \dots, \tilde{X}_{in}) = \begin{cases} 1, & \tilde{p}^L > 0.0027 \\ \frac{\tilde{p}^U - 0.0027}{\tilde{p}^U - \tilde{p}^L}, & \tilde{p}^L \leq 0.0027 \leq \tilde{p}^U \\ 0, & \tilde{p}^U < 0.0027 \end{cases}$$

Example 3 We illustrate the proposed approach by using a fuzzy data set related to inside piston diameter measurements in Example 2. The \tilde{t}_i and \tilde{W}_i statistics and \tilde{p} -values

corresponding to their for each sub-group are calculated. The obtained results for 25 samples are shown in Table 3. This table indicates that the process is in control.

Remark 2 Kaya and Kahraman [11] considered the problem of monitoring location and scale parameters of a statistical process when sample observations are reported as imprecise. To accomplish this, they calculate fuzzy control limits based on three-sigma rule with sprite of Montgomery [17]. Then, the authors utilized defuzzification methods for imprecise control limits and thus change imprecise mean and range values in every sub-group of sample as crisp values. Finally, we applied classical methods for decision making. Note that, three-sigma rules are employed when the underlying distribution is normal, that unfortunately, this assumption is completely ignored in their approach. Hence, our proposed methods can be suitable to apply when there is no any knowledge regarding the underlying process distribution.

Remark 3 Senturk and Erginel [22] studied fuzzy $\bar{X} - R$ and $\bar{X} - S$ control charts with α -cuts by using α -level fuzzy midrange transformation techniques. In their approach, α -cuts of control limits were calculated based on three-sigma rule. Note that, three-sigma rules are used when process is normal, unfortunately, this assumption is ignored in their method.

Using the fuzzy data set of example 2, we compare the proposed control charts with respect to above mentioned control charts. The results comparing is listed Table 4. It is clear that all approaches produce similar results. The main advantages of our approach are simplicity in performance and computation, non usage defuzzification operators and flexibility in designing charts.

Table 3 The result of FSN and FSR control charts based on Cr measure ranking method

| Sample number | $Cr\{\tilde{X}_{ij} \geq \tilde{M}\} \left(r \left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{M}) \right) \right)$ | | | | | \tilde{t}_i | \tilde{W}_i | \tilde{P} For SN chart | \tilde{P} For SR chart | Result |
|---------------|---|----------|----------|---------|---------|---------------|----------------|--------------------------|--------------------------|------------|
| | 1 | 2 | 3 | 4 | 5 | | | | | |
| 1 | 1(5) | 0.75(1) | 1(4) | 0(2) | 1(3) | {3,4} | {12,12.5,13} | 1 | [0.094,0.156] | In conrtol |
| 2 | 0(2) | 0(4) | 0.625(1) | 1(5) | 1(3) | {1,2} | {3,3.5,4} | [0.375,1] | [0.156,0.438] | In conrtol |
| 3 | 0(3) | 1(5) | 1(4) | 1(2) | 0.75(1) | {3,4} | {12,12.5,13} | 1 | [0.094,0.156] | In conrtol |
| 4 | 0.75(2) | 0(1) | 0(3) | 1(5) | 1(4) | {2,3} | {9,9.5,...,11} | 1 | [0.219,0.406] | In conrtol |
| 5 | 0(1) | 1(2) | 1(5) | 0(3) | 1(4) | {3} | {11} | 1 | 0.219 | In conrtol |
| 6 | 1(4) | 0(3) | 0.125(1) | 0(5) | 0(2) | {1} | {4} | 0.375 | 0.438 | In conrtol |
| 7 | 0(2) | 1(5) | 0(3) | 0.33(1) | 1(4) | {2} | {9} | 1 | 0.406 | In conrtol |
| 8 | 0(4) | 0.875(1) | 0(2) | 1(5) | 0(3) | {1,2} | {5,5.5,6} | [0.375,1] | [0.312,0.406] | In conrtol |
| 9 | 1(4) | 0(1) | 1(5) | 1(3) | 1(2) | {4} | {14} | 1 | 0.062 | In conrtol |
| 10 | 0.25(1) | 0.5(2) | 0(4) | 1(5) | 0(3) | {1} | {5} | 0.375 | 0.312 | In conrtol |
| 11 | 0(4.5) | 0.25(1) | 0(4.5) | 0(3) | 0.75(2) | {1} | {2} | 0.375 | 0.094 | In conrtol |
| 12 | 1(4) | 0.5(2) | 1(5) | 0.33(1) | 0(3) | {2} | {9} | 1 | 0.406 | In conrtol |
| 13 | 0(5) | 0.75(3) | 0.25(1) | 0(2) | 1(4) | {1,2} | {3,3.5,...,7} | [0.375,1] | [0.156,0.5] | In conrtol |
| 14 | 1(3) | 0(5) | 0(2) | 0.33(1) | 0(4) | {1} | {3} | 0.375 | 0.156 | In conrtol |
| 15 | 1(4) | 1(5) | 0.25(1) | 0.17(2) | 1(3) | {3} | {12} | 1 | 0.156 | In conrtol |
| 16 | 0.5(2) | 0(5) | 1(4) | 0(1) | 0(3) | {1} | {4} | 0.375 | 0.219 | In conrtol |

| | | | | | | | | | | |
|----|--------|----------|----------|---------|----------|---------|------------------|-----------|---------------|------------|
| 17 | 0(1) | 1(5) | 0(4) | 1(2) | 1(3) | {3} | {10} | 1 | 0.312 | In control |
| 18 | 1(3) | 1(4) | 1(5) | 0.83(2) | 0.5(1) | {3,4} | {12,12.5,...,14} | 1 | [0.062,0.156] | In control |
| 19 | 0(5) | 0.75(2) | 0.875(3) | 1(4) | 0.125(1) | {1,2,3} | {4,4.5,...,9} | [0.375,1] | [0.219,0.406] | In control |
| 20 | 0.5(1) | 1(3) | 1(4) | 1(5) | 0.875(2) | {3,4} | {12,12.5,...,14} | 1 | [0.062,0.156] | In control |
| 21 | 0(4) | 0.625(2) | 1(5) | 1(3) | 0(1) | {3,4} | {8,8.5,...,10} | 1 | [0.312,0.5] | In control |
| 22 | 1(2) | 0.375(1) | 0(4) | 1(3) | 1(5) | {3} | {10} | 1 | 0.312 | In control |
| 23 | 1(4) | 0(2) | 0(1) | 1(3) | 1(5) | {3} | {12} | 1 | [0.624,1] | In control |
| 24 | 1(5) | 1(3) | 0(2) | 0.33(1) | 1(4) | {3} | {12} | 1 | 0.156 | In control |
| 25 | 0(4) | 0(2) | 0(1) | 1(5) | 1(3) | {2} | {8} | 1 | 0.5 | In control |

4 Sign chart to monitor variability process in fuzzy environment

In this section, we extend the sign chart for variability process to the case when the observation are imprecise rather than crisp.

Suppose that a sample of size m ($m \geq 20$), $\tilde{X}_1, \tilde{X}_2, \dots, \tilde{X}_m$ is available from an IC process. Then at each sub-group i , a sample of size n is obtained from the process, and the pooled sample of size $m.n$ is obtained. In this situation, we have to combine imprecise observations as $\tilde{X}_{11}, \tilde{X}_{12}, \dots, \tilde{X}_{1n}, \tilde{X}_{21}, \tilde{X}_{22}, \dots, \tilde{X}_{mn}$. Then, observations in the pooled sample are ranked from smallest to the largest, and the ranks of observations is calculated. Hence, we apply distance between two fuzzy numbers to rank imprecise observations.

In order to obtain the fuzzy sign statistic at sample i , we need to be within third quartile (\tilde{Q}_3) and the first quartile (\tilde{Q}_1) estimated from process data when the process is IC. The steps of fuzzy sign statistic computation for control chart are as follows:

1. Set the arbitrary origin \tilde{B} ,
2. Determine $D_{2, \frac{1}{2}}(\tilde{Q}_1, \tilde{B})$ and $D_{2, \frac{1}{2}}(\tilde{Q}_3, \tilde{B})$,
3. Determine $D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{B})$ for $i = 1, 2, \dots, m$, $j = 1, 2, \dots, n$.

4. The fuzzy sign statistics are obtained by the following formula:

$$U_i = \sum_{j=1}^n \left[I \left(D_{2, \frac{1}{2}}(\tilde{Q}_1, \tilde{B}) > D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{B}) \right) + I \left(D_{2, \frac{1}{2}}(\tilde{X}_{ij}, \tilde{B}) > D_{2, \frac{1}{2}}(\tilde{Q}_3, \tilde{B}) \right) \right],$$

(4.1)

for $i = 1, 2, \dots, m$, where I is the indicator function.

The two sided chart signals OoC status when $U_i \geq d$ or $U_i \leq -d$.

Table 4 Comparison between various control charts for median in fuzzy environment

| Sample number | SN control chart based on $D_{p,q}$ - distance method | SR control chart based on $D_{p,q}$ - distance method | Fuzzy control chart based on Kaya and Khahraman method | Fuzzy control chart based on Senturk and Erginel method |
|---------------|---|---|--|---|
| 1 | In conrtol | In conrtol | In conrtol | In conrtol |
| 2 | In conrtol | In conrtol | In conrtol | In conrtol |
| 3 | In conrtol | In conrtol | In conrtol | In conrtol |
| 4 | In conrtol | In conrtol | In conrtol | In conrtol |
| 5 | In conrtol | In conrtol | In conrtol | In conrtol |
| 6 | In conrtol | In conrtol | In conrtol | In conrtol |
| 7 | In conrtol | In conrtol | In conrtol | In conrtol |
| 8 | In conrtol | In conrtol | In conrtol | In conrtol |
| 9 | In conrtol | In conrtol | In conrtol | In conrtol |
| 10 | In conrtol | In conrtol | In conrtol | In conrtol |
| 11 | In conrtol | In conrtol | In conrtol | In conrtol |
| 12 | In conrtol | In conrtol | In conrtol | In conrtol |
| 13 | In conrtol | In conrtol | In conrtol | In conrtol |
| 14 | In conrtol | In conrtol | In conrtol | In conrtol |
| 15 | In conrtol | In conrtol | In conrtol | In conrtol |
| 16 | In conrtol | In conrtol | In conrtol | In conrtol |
| 17 | In conrtol | In conrtol | In conrtol | In conrtol |
| 18 | In conrtol | In conrtol | In conrtol | In conrtol |
| 19 | In conrtol | In conrtol | In conrtol | In conrtol |
| 20 | In conrtol | In conrtol | In conrtol | In conrtol |
| 21 | In conrtol | In conrtol | In conrtol | In conrtol |
| 22 | In conrtol | In conrtol | In conrtol | In conrtol |
| 23 | In conrtol | In conrtol | In conrtol | In conrtol |
| 24 | In conrtol | In conrtol | In conrtol | In conrtol |
| 25 | In conrtol | In conrtol | In conrtol | In conrtol |

Example 4 We illustrate the operations of the synthetic control chart using fuzzy data set related to Table 1. The data set includes 25 samples each of five observations. Based on example 2, we conclude that this process is in control. Hence, we estimated $\tilde{Q}_1 = (73.991, 73.995, 73.996)_T$ and $\tilde{Q}_1 = (74.004, 74.008, 74.009)_T$ based on $mn = 125$ sample observations. To have an in control ARL equal to 32, the parameters of the synthetic control chart are $UCL = d = 4$ and $L = 1$ [12].

Table 5 illustrates the values of the fuzzy sign statistic U_i for 25 samples. We have constructed fuzzy sign chart and the CRL chart in Figure 3. At the beginning, we set CRL to be zero and increased its value by one for every conforming sample. Here, the sample is conforming, if $U_i < 4$. Otherwise, the sample is nonconforming. From Figure 3, it is clear that the first nonconforming sample occurs at time epoch 5 and the CRL at that time point is 5, which is greater than $L = 1$. Therefore, the process is assumed to be in-control and we reset CRL to be zero. The next nonconforming samples occurs at time epoch's 8, 12, 23 and 25

with CRL's equal to 3, 4, 11 and 2 respectively, again which is above L . Hence, we conclude that the process run is in-control.

It should be noted that Kaya and Kahraman approach [11] for these data has led to the same conclusion with respect to the variability process, see Table 6. Of course, the main advantages of the proposed approach in comparison with Kaya and Kahraman method are Simplicity and also there is no need to assume a particular distribution for the underlying process.

Table 5 Sign chart statistics to monitor variation

| Sample number | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 |
|---------------|----|----|----|----|----|----|----|----|----|----|----|----|----|----|
| U_i | 3 | 2 | 3 | 3 | 4 | 3 | 1 | 4 | 1 | 1 | 2 | 0 | 1 | 3 |
| | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | | | |
| | 3 | 1 | 3 | 2 | 1 | 3 | 2 | 3 | 5 | 3 | 4 | | | |

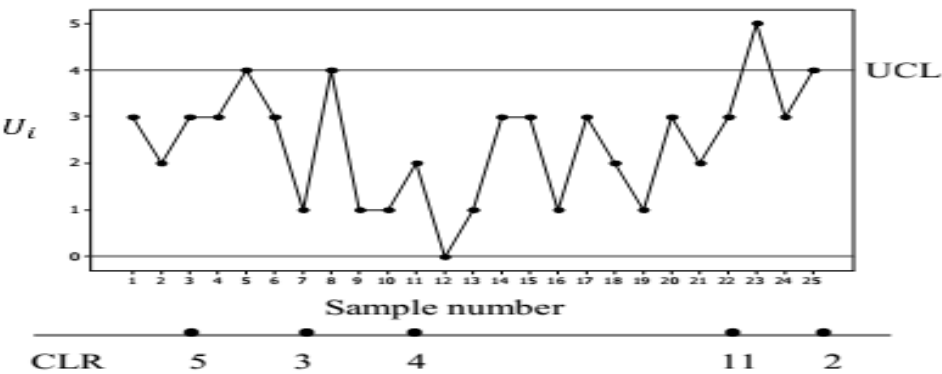


Fig. 3 Signed chart and fuzzy synthetic chart

Table 6 Comparison between control charts to monitor process variation in fuzzy environment

| Sample number | SN control chart based on $D_{p,q}$ -distance method | Fuzzy control chart based on Kaya and Khahraman method | Sample number | SN control chart based on $D_{p,q}$ -distance method | Fuzzy control chart based on Kaya and Khahraman method |
|---------------|--|--|---------------|--|--|
| 1 | In conrtol | In conrtol | 14 | In conrtol | In conrtol |
| 2 | In conrtol | In conrtol | 15 | In conrtol | In conrtol |
| 3 | In conrtol | In conrtol | 16 | In conrtol | In conrtol |
| 4 | In conrtol | In conrtol | 17 | In conrtol | In conrtol |
| 5 | In conrtol | In conrtol | 18 | In conrtol | In conrtol |
| 6 | In conrtol | In conrtol | 19 | In conrtol | In conrtol |
| 7 | In conrtol | In conrtol | 20 | In conrtol | In conrtol |
| 8 | In conrtol | In conrtol | 21 | In conrtol | In conrtol |
| 9 | In conrtol | In conrtol | 22 | In conrtol | In conrtol |
| 10 | In conrtol | In conrtol | 23 | In conrtol | In conrtol |
| 11 | In conrtol | In conrtol | 24 | In conrtol | In conrtol |
| 12 | In conrtol | In conrtol | 25 | In conrtol | In conrtol |
| 13 | In conrtol | In conrtol | | | |

5 Conclusion

In this paper, we proposed a new approach to monitor median and the variability process, when there is no crisp data and suitable parametric assumptions. The advantages of our approach are as follows: simplicity in performance and computation, non usage defuzzification methods and flexibility in designing charts. We analyzed and evaluated the proposed control charts with numerical examples. We concluded that our approach in comparison with the same other methods can be efficient as compared with its fuzzy parametric control charts to identify the change location of the parameter and variability.

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