

— Factors for computing control chart lines

Observations in sub-groups of size n	Factors for control limits											Factors for centre line	
	\bar{x} Chart			s Chart				R Chart *				Using s^*	Using R^*
	A	A ₂	A ₃	B ₃	B ₄	B ₅	B ₆	D ₁	D ₂	D ₃	D ₄	C ₄	d ₂
2	2,121	1,880	2,659	-	3,267	-	2,606	-	3,686	-	3,267	0,7979	1,128
3	1,732	1,023	1,954	-	2,568	-	2,276	-	4,358	-	2,575	0,8862	1,693
4	1,500	0,729	1,628	-	2,266	-	2,088	-	4,698	-	2,282	0,9213	2,059
5	1,342	0,577	1,427	-	2,089	-	1,964	-	4,918	-	2,114	0,9400	2,326
6	1,225	0,483	1,287	0,030	1,970	0,029	1,874	-	5,079	-	2,004	0,9515	2,534
7	1,134	0,419	1,182	0,118	1,882	0,113	1,806	0,205	5,204	0,076	1,924	0,9594	2,704
8	1,061	0,373	1,099	0,185	1,815	0,179	1,751	0,388	5,307	0,136	1,864	0,9650	2,847
9	1,000	0,337	1,032	0,239	1,761	0,232	1,707	0,547	5,394	0,184	1,816	0,9693	2,970
10	0,949	0,308	0,975	0,284	1,716	0,276	1,669	0,686	5,469	0,223	1,777	0,9727	3,078
11	0,905	0,285	0,927	0,321	1,679	0,313	1,637	0,811	5,535	0,256	1,744	0,9754	3,173
12	0,866	0,266	0,886	0,354	1,646	0,346	1,610	0,923	5,594	0,283	1,717	0,9776	3,258
13	0,832	0,249	0,850	0,382	1,618	0,374	1,585	1,025	5,647	0,307	1,693	0,9794	3,336
14	0,802	0,235	0,817	0,406	1,594	0,399	1,563	1,118	5,696	0,328	1,672	0,9810	3,407
15	0,775	0,223	0,789	0,428	1,572	0,421	1,544	1,203	5,740	0,347	1,653	0,9823	3,472
16	0,750	0,212	0,763	0,448	1,552	0,440	1,526	1,282	5,782	0,363	1,637	0,9835	3,532
17	0,728	0,203	0,739	0,466	1,534	0,458	1,511	1,356	5,820	0,378	1,622	0,9845	3,588
18	0,707	0,194	0,718	0,482	1,518	0,475	1,496	1,424	5,856	0,391	1,609	0,9854	3,640
19	0,688	0,187	0,698	0,497	1,503	0,490	1,483	1,489	5,889	0,404	1,596	0,9862	3,689
20	0,671	0,180	0,680	0,510	1,490	0,504	1,470	1,549	5,921	0,415	1,585	0,9869	3,735
21	0,655	0,173	0,663	0,523	1,477	0,516	1,459	1,606	5,951	0,425	1,575	0,9876	3,778
22	0,640	0,167	0,647	0,534	1,466	0,528	1,448	1,660	5,979	0,435	1,567	0,9882	3,819
23	0,626	0,162	0,633	0,545	1,455	0,539	1,438	1,711	6,006	0,443	1,557	0,9887	3,858
24	0,612	0,157	0,619	0,555	1,445	0,549	1,429	1,759	6,032	0,452	1,548	0,9892	3,895
25	0,600	0,153	0,606	0,565	1,435	0,559	1,420	1,805	6,056	0,459	1,541	0,9896	3,931

* Not recommended for sample size $n > 10$.

Ref: 7870-2 2013