

Chapter 14

Nested and Split-Plot Designs

Solutions

In this chapter we have not shown residual plots and other diagnostics to conserve space. A complete analysis would, of course, include these model adequacy checking procedures.

14.1. A rocket propellant manufacturer is studying the burning rate of propellant from three production processes. Four batches of propellant are randomly selected from the output of each process and three determinations of burning rate are made on each batch. The results follow. Analyze the data and draw conclusions.

Batch	Process 1				Process 2				Process 3			
	1	2	3	4	1	2	3	4	1	2	3	4
25	19	15	15	19	23	18	25	14	35	38	25	
30	28	17	16	17	24	21	27	15	21	34	29	
26	20	14	13	14	21	17	25	20	24	30	33	

MINITAB Output

ANOVA: Burn Rate versus Process, Batch

Factor	Type	Levels	Values
Process	fixed	3	1 2 3
Batch (Process)	random	4	1 2 3 4

Analysis of Variance for Burn Rate

Source	DF	SS	MS	F	F
Process	2	676.06	338.03	1.46	0.281
Batch (Process)	9	2077.58	230.84	12.30	0.000
Error	24	454.00	18.92		
Total	35	3207.64			

Source	Variance Component	Error term	Expected Mean Square for Each Term
1 Process	2	(3) = 3(2) = 120(1)	
2 Batch (Process)	70.64	3	(3) = 3(2)
3 Error	18.92	(1)	

There is no significant effect on mean burning rate among the different processes; however, different batches from the same process have significantly different burning rates.

14.2. The surface finish of metal parts made on four machines is being studied. An experiment is conducted in which each machine is run by three different operators and two specimens from each operator are collected and tested. Because of the location of the machines, different operators are used on each machine, and the operators are chosen at random. The data are shown in the following table. Analyze the data and draw conclusions.

Operator	Machine 1			Machine 2			Machine 3			Machine 4		
	1	2	3	1	2	3	1	2	3	1	2	3
79	94	46	92	85	76	88	53	46	36	40	62	
62	74	57	99	79	68	75	56	57	53	56	47	

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Floyd A. Beams

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