

Body of Knowledge

This NEW Quality Technician Body of Knowledge is effective March 3, 2012.

The topics in this Body of Knowledge include additional detail in the form of subtext explanations and the cognitive level at which the questions will be written. This information will provide useful guidance for both the Exam Development Committee and the candidate preparing to take the exam. The subtext is not intended to limit the subject matter or be all-inclusive of what might be covered in an exam. It is meant to clarify the type of content to be included in the exam. The descriptor in parentheses at the end of each entry refers to the maximum cognitive level at which the topic will be tested. A more complete description of cognitive levels is provided at the end of this document.

I. QUALITY CONCEPTS AND TOOLS (22 Questions)

A. Quality Concepts

1. **Customers and suppliers**

Define internal and external customers, identify their expectations, and determine their satisfaction levels. Define internal and external suppliers and key elements of relations with them. (Understand)

2. **Quality principles for products and processes**

Identify basic quality principles related to products (such as features, fitness-for-use, freedom from defects, etc.) and processes (such as monitoring, measuring, continuous improvement, etc.) (Understand)

3. **Quality standards, requirements, and specifications**

Define and distinguish between national or international standards, customer requirements, and product or process specifications. (Understand)

4. **Cost of quality (COQ)**

Describe and distinguish between the four classic cost of quality categories (prevention, appraisal, internal failure, external failure) and classify activities appropriately. (Apply)

5. **Six sigma**

Identify key six sigma concepts and tools, including green belt and black belt roles and responsibilities, project types and processes used, and define terms such as quality function deployment (QFD), design, measure, analyze, improve, control (DMAIC), etc. (Remember)

6. **Lean**

Identify key lean concepts and tools such as, 5S, value-stream mapping, flow, pull, etc. (Remember)

7. **Continuous improvement techniques**

Define and use various continuous improvement techniques including the Plan Do Check Act (PDCA) cycle, brainstorming, benchmarking, etc. (Understand)

B. Quality Tools

Select, construct, apply, and interpret the seven basic quality tools: 1) cause and effect diagrams, 2) flowcharts (process maps), 3) check sheets, 4) Pareto charts, 5) scatter diagrams, 6) control charts, and 7) histograms. (Evaluate)

C. Team Functions

1. **Meeting management**

Meeting management Define, describe, and apply various meeting management techniques, including selecting team members, creating and following an agenda, facilitation techniques, recording and distributing minutes, establishing ground rules and protocols, etc. (Apply)

2. **Team building methods**

Apply basic team building methods and concepts such as, group dynamics, decision-making tools (e.g., majority voting, multi-voting, consensus), and creative-thinking tools (e.g., nominal group technique). (Apply)

3. **Team stages**

Describe the team development stages of forming, storming, norming, and performing, (Understand)

4. **Global communication**

Define and describe the impact that globalization has on team-related issues, including developing virtual teams and participating on them, using electronic communications to support long-distance collaboration, etc. (Understand)

II. STATISTICAL TECHNIQUES (18 Questions)

A. General Concepts

1. **Terminology**

Identify and differentiate between statistical terms such as population, sample, parameter, statistic, statistical process

control (SPC), etc. (Understand)

2. Frequency distributions

Define and compute normal, Poisson, and binomial frequency distributions. (Apply)

B. Calculations

1. Measures of central tendency

Define, compute, and interpret mean, median, and mode. (Analyze)

2. Measures of dispersion

Define, compute, and interpret standard deviation, range, and variance. (Analyze)

3. Statistical inference

Determine, calculate, and apply confidence levels in various situations. (Apply)

4. Confidence limits

Determine, calculate, and apply confidence limits in various situations. (Apply)

5. Probability

Calculate probability using the basic concepts of combinations, permutations, and area under the normal curve. (Apply)

C. Control Charts

1. Control limits vs. specification limits

Identify and describe the different uses of control limits and specification limits. (Understand)

2. Variables charts

Identify, select, construct, and interpret variables charts such as $\bar{X} - R$, $\bar{X} - s$, etc. (Analyze)

3. Attributes charts

Identify, select, construct, and interpret attributes charts such as p, np, c, u, etc. (Analyze)

4. Process capability measures

Define the prerequisites for capability, and calculate and interpret Cp, Cpk, and capability ratio (CR) in various situations. (Analyze)

5. Common and special cause variation

Interpret various control chart patterns (runs, hugging, trends, etc.) and use rules for determining statistical control to distinguish between common cause and special cause variation. (Analyze)

6. Data plotting

Identify the advantages and limitations of using this method to analyze data visually instead of numerically. (Understand)

III. METROLOGY AND CALIBRATION (17 Questions)

A. Measurement and Test Equipment (M&TE)

Describe, select, and use the following types of M&TE, and evaluate their measurement results to determine conformance to specifications. (Evaluate)

1. Hand tools (e.g., calipers, micrometers, linear scales, analog, digital, vernier scales)

2. Gages (e.g., pins, thread, custom gages)

3. Optical tools (e.g., comparators, profiles, microscopes)

4. Coordinate measuring machines (CMM)

5. Electronic measuring equipment (e.g., digital displays, output)

6. Weights, balances and scales

7. Hardness testing equipment (e.g., Brinell, Rockwell)

8. Surface plate methods and equipment

9. **Surface analyzers (e.g., optical flats, roughness testers)**
10. **Force measurement tools (e.g., torque wrenches, tensiometers)**
11. **Angle measurement tools (e.g., protractors, sine bars, angle blocks, gage blocks)**
12. **Color measurement tools (e.g., spectrophotometer, color guides, light boxes)**

B. Control and maintenance of M&TE

1. M&TE identification, control, and maintenance

Describe various methodologies for identifying and controlling M&TE to meet traceability requirements, and apply appropriate techniques for maintaining such equipment to obtain optimum performance. (Apply)

2. Customer-supplied M&TE

Describe and apply requirements for validation and control of customer-supplied equipment. (Apply)

C. Calibration of M&TE

1. Calibration intervals

Establish calibration schedules on the basis of M&TE usage history and gage repeatability and reproducibility (R&R) data. Describe the potential impact of using out-of-calibration tools or failing to calibrate equipment on a regular basis. (Analyze)

2. Calibration error

Identify the causes of calibration error and its effect on processes and products. (Understand)

IV. INSPECTION AND TEST (23 Questions)

A. Blueprint Reading and Interpretation

1. Blueprint symbols and components

Interpret drawings and apply requirements in various test and inspection activities. (Analyze)

2. Geometric dimensioning and tolerancing (GD&T) terminology

Define and use GD&T terms covered in the ASME Y14.5 standard. (Analyze)

3. Classification of product defect characteristics

Define, distinguish between, and classify defect characteristics in terms of critical, major, minor, etc. (Apply)

B. Inspection Concepts

1. Types of measurements

Define and distinguish between direct, differential, and transfer measurements. (Understand)

2. Gage selection

Determine which measurement instrument to use in various situations, based on considerations such as the characteristic to be measured, test uncertainty ratio (TUR), test accuracy ratio (TAR), etc. (Analyze)

3. Measurement systems analysis (MSA)

Define and distinguish between measurement terms such as correlation, bias, linearity, precision-tolerance, percent agreement, etc. Describe how gage repeatability and reproducibility (R&R) studies are performed and how they are applied in support of MSA. (Analyze)

4. Rounding rules

Use truncation and rounding rules on both positive and negative numbers. (Apply)

5. Conversion of measurements

Convert between metric and English units. (Apply)

6. Inspection points

Define and distinguish between inspection point functions (receiving, in-process, final, source, firstarticle, etc.), and determine what type of inspection is appropriate at different stages of production, from raw materials through finished product. (Apply)

7. Inspection error

Define various types of inspection error, including parallax, fatigue, flinching, distraction, etc. (Understand)

8. Product traceability

Describe the requirements for documenting and preserving the identity of a product and its origins. (Understand)

9. Certificates of compliance (COC) and analysis (COA)

Define and distinguish between these two types of certificates. (Understand)

C. Inspection Techniques and Processes

1. Nondestructive testing (NDT) techniques

Identify various NDT techniques (X-ray, eddy current, ultrasonic, liquid penetrant, electromagnetic, magnetic particle, etc.) for specific applications. (Understand)

2. Destructive testing techniques

Identify various destructive tests (tensile, fatigue, flammability, etc.) for specific applications. (Understand)

3. Other testing techniques

Identify characteristics of testing techniques such as those used for electrical measurement (DC, AC, resistance, capacitance, etc.), chemical analysis (pH, conductivity, chromatography, etc.), and physical/mechanical measurement (pressure tests, vacuum, flow, etc.) (Remember)

D. Sampling

1. Sampling characteristics

Identify and define sampling characteristics such as operating characteristic (OC) curve, lot size, sample size, acceptance number, switching rules, etc. (Apply)

2. Sampling types

Define and distinguish between fixed sampling, 100% inspection, attributes and variables sampling, etc. (Apply)

3. Selecting samples from lots

Determine sample size (e.g., AQL), selection method and accept/reject criteria (e.g., zero-defect sampling) used in various situations. (Apply)

E. Nonconforming material

1. Identifying and segregating

Determine whether products or material meet conformance requirements, and use various methods to label and segregate nonconforming materials. (Apply)

2. Material review process

Describe various elements of this process, including the function of the material review board (MRB), the steps in determining fitness-for-use and product disposition, etc. (Understand)

V. QUALITY AUDITS (11 Questions)

A. Audit types and terminology

Define basic audit types: 1) internal, 2) external, 3) systems, 4) product, 5) process; and 6) distinguish between first-, second-, and third-party audits. (Understand)

B. Audit Components

Describe and apply various elements of the audit process: 1) audit purpose and scope, 2) audit reference standard, 3) audit plan (preparation), 4) audit performance, 5) opening and closing meetings, 6) final report and verification of corrective action. (Apply)

C. Audit tools and techniques

Define and apply various auditing tools: 1) checklists and working papers, 2) data gathering and objective evidence, 3) forward- and backward-tracing, 4) audit sampling plans and procedural guidelines. (Apply)

D. Audit communication tools

Identify and use appropriate interviewing techniques and listening skills in various audit situations, and develop and use graphs, charts, diagrams, and other aids in support of written and oral presentations. (Apply)

VI. CORRECTIVE AND PREVENTIVE ACTION (CAPA) (9 Questions)

A. Corrective action

Identify and apply elements of the corrective action process: identify the problem, contain the problem (interim action), assign responsibility (personnel) to determine the causes of the problem and propose solutions to eliminate it or prevent its recurrence (permanent action), verify that the solutions are implemented, and confirm their effectiveness (validation). (Apply)

B. Preventive action

Identify and apply elements of a preventive action process: use various data analysis techniques (e.g., trend analysis, failure mode and effects analysis (FMEA) product and process monitoring reports) to identify potential failures, defects, or process deficiencies; assign responsibility for improving the process (develop error- or mistake-proofing devices or methods, initiate procedural changes, etc.), and verify the effectiveness of the preventive action. (Apply)

Math Note: Approximately 20% of the questions in each CQT exam will require calculation.

Levels of Cognition Based on Bloom's Taxonomy – Revised (2001)

In addition to content specifics, the subtext for each topic in this BOK also indicates the intended complexity level of the test questions for that topic. These levels are based on “Levels of Cognition” (from Bloom's Taxonomy – Revised, 2001) and are presented below in rank order, from least complex to most complex.

Remember

Recall or recognize terms, definitions, facts, ideas, materials, patterns, sequences, methods, principles, etc.

Understand

Read and understand descriptions, communications, reports, tables, diagrams, directions, regulations, etc.

Apply

Know when and how to use ideas, procedures, methods, formulas, principles, theories, etc.

Analyze

Break down information into its constituent parts and recognize their relationship to one another and how they are organized; identify sublevel factors or salient data from a complex scenario.

Evaluate

Make judgments about the value of proposed ideas, solutions, etc., by comparing the proposal to specific criteria or standards.

Create

Put parts or elements together in such a way as to reveal a pattern or structure not clearly there before; identify which data or information from a complex set is appropriate to examine further or from which supported conclusions can be drawn.