

# Package ‘industRial’

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**Type** Package

**Date** 2021-06-04

**Title** Data, Functions and Support Materials from the Book “industRial  
Data Science”

**Version** 0.1.0

**Description** Companion package to the book “industRial data science”,  
J.Ramalho (2021) <<https://j-ramalho.github.io/industRial/>>.  
Provides data sets and functions to complete the case studies and contains  
the book original Rmd files and tutorials.

**URL** <https://github.com/J-Ramalho/industRial>

**BugReports** <https://github.com/J-Ramalho/industRial/issues>

**License** GPL (>= 3)

**Encoding** UTF-8

**LazyData** true

**Imports** ggplot2, stats, dplyr, tidyr, magrittr, rlang, lattice,  
SixSigma

**Depends** R (>= 3.5.0)

**RoxygenNote** 7.1.1

**Suggests** glue, tibble, stringr, scales, purrr, janitor, patchwork,  
forcats, broom, viridis, learnr, DoE.base, qcc, car, qicharts2,  
rsm, ggforce, ggraph, tidygraph, igrph, bookdown, rmarkdown,  
knitr, agricolae, RcmdrMisc, gt, skimr, ggtext

**NeedsCompilation** no

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**Repository** CRAN

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battery_charging	<i>Charging time of a lithium-ion battery.</i>
------------------	--

---

**Description**

A data set with charging time in hours required to recharge a lithium-ion battery based on a full factorial design of experiment with four variables (A, B, C, D) coded as +/- 1. Design effects are coded as numerical variables in order to allow to build models without coding the contrasts and then to make predictions on a continuous range from -1 to +1.

**A** Variable A (numerical)

**B** Variable B (numerical)

**C** Variable B (numerical)

**D** Variable B (numerical)

**Replicate** The independent repeat of each unique factor combination.

**charging\_time** Battery charging time [h]

**Usage**

```
battery_charging
```

**Format**

A tibble with 32 observations on 6 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
data(battery_charging)
head(battery_charging)

# Building a linear model:
battery_lm <- lm(
  formula = charging_time ~ A * B * C,
  data = battery_charging
)
summary(battery_lm)
```

---

chart\_Cpk

*Create a capability chart for statistical process control*

---

**Description**

Generate a histogram type chart from a set of consecutive measurements.

**Usage**

```
chart_Cpk(data)
```

**Arguments**

data            A dataset generated by the function [process\\_stats](#)

**Details**

This type of chart is typically applied in product manufacturing to monitor deviations from the target value over time. It is usually accompanied by the statistical process control time series [chart\\_I](#) and [chart\\_IMR](#)

**Value**

This function returns an object of class ggplot

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

---

chart\_I

*Create IMR chart for statistical process control*

---

**Description**

Generate a single point time series chart from a set of consecutive measurements.

**Usage**

```
chart_I(data)
```

**Arguments**

data            A dataset generated by the function [process\\_stats](#)

**Details**

This type of chart is typically applied in product manufacturing to monitor deviations from the target value over time. It is usually accompanied by the [chart\\_IMR](#)

**Value**

This function returns an object of class ggplot

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

---

chart_IMR	<i>Create R MR chart for statistical process control</i>
-----------	--

---

**Description**

Generate a moving range chart chart from a set of consecutive measurements.

**Usage**

```
chart_IMR(data)
```

**Arguments**

data            A dataset generated by the function [process\\_stats](#)

**Details**

This type of chart is typically applied in product manufacturing to monitor deviations from the target value over time. It is usually accompanied by the [chart\\_IMR](#)

**Value**

This function returns an object of class ggplot

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

---

dial_control	<i>Collection of visual defects on watch dial production.</i>
--------------	---

---

**Description**

This data set contains observations of visual defects present in watch dials such as indentations and scratches taken during production. It provides a practical case to establish pareto charts typically with a function like [paretochart](#).

**Operator** The shop floor operator collecting the data

**Date** Data collection date

**Defect** Defect type ("Indent", "Scratch")

**Location** Position on the watch dial referred to as the hour (1h, 2h)

**id** Part unique id number

**Usage**

```
dial_control
```

**Format**

An object of class tibble with 58 observations on 4 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
head(dial_control)
```

---

ebike_hardening	<i>Cycles to failure of ebikes frames after temperature treatment.</i>
-----------------	--

---

**Description**

A data set with the results of aging tests on several groups of ebikes frames (g1, g2, ...). Each entry corresponds to the number of cycles to failure for each level of treatment temperature-

**temperature** Position of the part on the device

**g1** group 1, remaining groups have names g2 to g5

**Usage**

```
ebike_hardening
```

**Format**

A tibble with 4 observations on 6 variables.

**Details**

The ebike\_hardening2 dataset contains alternative data that gives non significant results in the analysis of variance study.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
data(ebike_hardening)
```

---

expand_formula	<i>Formula expansion</i>
----------------	--------------------------

---

**Description**

Takes a linear model formula and returns it expanded version.

**Usage**

```
expand_formula(formulae)
```

**Arguments**

formulae      Takes as input object of class formula, e.g.:  $Y \sim A * B$ , see ?formula for syntax details

**Details**

Supports verification and understanding of the creation of linear models syntax such as \*,+ and other conventions.

**Value**

Returns a character vector such as  $A + B + A:B$

**References**

For an example application refer to <https://j-ramalho.github.io/industrial/>

---

industrial	<i>industrial: companion package to the book "industrial data science"</i>
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---

**Description**

This package contains datasets and toy functions to run the examples from the book "industrial data science". It also contains all the book original Rmd files and the learnr Rmd original tutorial files.

**Author(s)**

João Ramalho

**References**

For complete case studies refer to <https://j-ramalho.github.io/industrial/>

---

juice_drymatter	<i>Dry matter content of different juices obtained with two different measurement devices.</i>
-----------------	--

---

### Description

This data set contains laboratory measurements of the dry matter content of different fruit juices obtained with two different measurement devices. One of the devices is considered the reference (REF) and the other one is a new device (DRX) on which a linearity and bias study has to be performed.

**product** The juice base fruit ("Apple", "Beetroot")

**drymatter\_TGT** Target drymatter content in [g]

**speed** Production line speed

**particle\_size** Dry matter powder particle size [micrometers]

**part** Part number

**drymatter\_DRX** Drymatter content measured with device DRX

**drymatter\_REF** Drymatter content measured with reference device

### Usage

```
juice_drymatter
```

### Format

An object of class tibble with 108 observations on 7 variables.

### Source

Adapted from a real gage bias and linearity study performed in 2021 on industrial beverages dry matter content measurement. The structure of the data corresponds to a full factorial design of 5 factors (3 with 3 levels and 2 with 2 levels).

### References

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

### Examples

```
library(dplyr)
# Calculate the bias between the new device and the reference:
juice_drymatter <- juice_drymatter %>% dplyr::mutate(bias = drymatter_DRX - drymatter_REF)
# Establish the analysis of variance:
juice_drymatter_aov <- aov(
  bias ~ drymatter_TGT * speed * particle_size,
  data = juice_drymatter)
summary(juice_drymatter_aov)
```



---

off_spec	<i>Calculate percentage of out of specification for Statistical Process Control</i>
----------	---

---

**Description**

This function takes process variables and calculates the probability that parts are produced out of specification on the long run.

**Usage**

```
off_spec(UCL, LCL, mean, sd)
```

**Arguments**

UCL	the process upper control limit
LCL	the process lower control limit
mean	the process mean
sd	the process standard deviation

**Value**

This function returns an object of class numeric

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

**Examples**

```
off_spec(100, 0, 10, 3)
```

---

perfume_experiment	<i>Correlation matrix of the input variables of an experiment design in perfume formulation.</i>
--------------------	--

---

**Description**

The data set contains the expected correlation (expressed in 1 to 10) of an experiment anonymized input variables. The dataset consists in a double entry table with the same variables in row and column. It is coded as a tibble but subsequent utilization in network plots requires it to be converted to a matrix format.

**Usage**

```
perfume_experiment
```

**Format**

A tibble with 22 observations on 23 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
data(perfume_experiment)
```

---

pet_delivery	<i>Tensile strength values on PET raw material for the clothing industry.</i>
--------------	---

---

**Description**

Measurements of tensile strength of two different deliveries of PET raw material used in the clothing industry. The two data sets follow approximately a normal distribution.

**A** Tensile strenght measurements for product A [Mpa] (numeric)

**B** Tensile strenght measurements for product B [Mpa] (numeric)

**Usage**

```
pet_delivery
```

**Format**

An object of class tibble with 28 observations on 2 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
data(pet_delivery)
```

---

pet_doe	<i>A factorial design for the improvement of PET film tensile strength.</i>
---------	---

---

**Description**

The data corresponds to full factorial design with two factors coded as +/- and 3 replicates for each combination.

**A** PET formulation A (factor)

**B** PET formulation B (factor)

**replicate** the measurement replicate I to III (factor)

**yield** the output variable measured on the PET, (numerical)

**Usage**

```
pet_doe
```

**Format**

An object of classes design and data.frame with 12 observations of 4 variables.

**Source**

Original data set generated with the function `fac.design` from the package DoE.base.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

**Examples**

```
data(pet_doe)
contrasts(pet_doe$A)
```

---

process_Cpk	<i>Calculate process capability index for Statistical Process Control</i>
-------------	---

---

**Description**

This function takes process variables and calculates the Cpk index which is a measure of the process centering and variability against specification.

**Usage**

```
process_Cpk(UCL, LCL, mean, sd)
```

**Arguments**

UCL	the process upper control limit
LCL	the process lower control limit
mean	the process mean
sd	the process standard deviation

**Value**

This function returns an object of class numeric

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

**Examples**

```
process_Cpk(100, 0, 10, 3)
```

---

process\_stats

*Calculate summary statistics for Statistical Process Control*

---

**Description**

This function takes process variables and calculates summary statistics and presents them in a easy readable table format.

**Usage**

```
process_stats(data, part_spec_percent)
```

**Arguments**

data	This function takes the dataset <code>tablet_thickness</code> cleaned with the <code>clean_names</code> function from the <code>janitor</code> package
part_spec_percent	the process tolerance in percentage.

**Value**

This function returns an object with class tibble (`tbl_df`)

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

---

process\_stats\_table     *Summary statistics table outputs for Statistical Process Control*

---

### Description

This function takes summary statistics and presents them in a easy readable table format.

### Usage

```
process_stats_table(data)
```

### Arguments

data                    A data set generated by the function [process\\_stats](#)

### Value

This function returns an object with classes `gt_tbl` and `list`

### References

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

---

solarcell\_fill            *Yearly outputs and fills factor of solarcells of different types.*

---

### Description

A dataset with the energy output resulting from tests on solarcells made of three different configurations. The fill factor provides an indication of the cell quality and is a non controlled variable that can be taken into consideration in an analysis of covariance to better assess the output variation from material to material.

**material** The solar cell material (character)

**output** he yearly energy output (numeric)

**fillfactor** The fill factor measured for each cell (numeric)

### Usage

```
solarcell_fill
```

### Format

A tibble with 15 observations of 3 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
hist(solarcell_fill$output)
```

---

solarcell_output	<i>Yearly outputs of solarcells of different types.</i>
------------------	---

---

**Description**

A dataset with the energy output resulting from tests on solarcells made of three different raw materials / configurations.

**material** The solar cell type (character)

**run** The test run (numeric)

**T-10** The yearly output for the test result at temperature of 10°C

**T20** The yearly output for the test result at temperature of 20°C

**T50** The yearly output for the test result at temperature of 50°C

**Usage**

```
solarcell_output
```

**Format**

A tibble with 12 observations of 5 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
data(solarcell_output)
```

---

 ss.rr.plots

*Gage R & R plots*


---

## Description

Extracts stand alone plots from the ss.rr function of the SixSigma package.

## Usage

```
ss.rr.plots(
  var,
  part,
  appr,
  lsl = NA,
  usl = NA,
  sigma = 6,
  data,
  main = "Six Sigma Gage R&R Study",
  sub = "",
  alphaLim = 0.05,
  errorTerm = "interaction",
  digits = 4
)
```

## Arguments

var	Measured variable
part	Factor for parts
appr	Factor for appraisers (operators, machines, ...)
lsl	Numeric value of lower specification limit used with USL to calculate Study Variation as %Tolerance
usl	Numeric value of upper specification limit used with LSL to calculate Study Variation as %Tolerance
sigma	Numeric value for number of std deviations to use in calculating Study Variation
data	Data frame containing the variables
main	Main title for the graphic output
sub	Subtitle for the graphic output (recommended the name of the project)
alphaLim	Limit to take into account interaction
errorTerm	Which term of the model should be used as error term (for the model with interaction)
digits	Number of decimal digits for output

**Details**

This is a modified version of the function `ss.rr` from the SixSigma package that allows to extract the individual plots from the output report. The input arguments of the function are the same as the original function. See the original function help with `?ss.rr` for full documentation.

**Value**

Generates a list output that can be assigned to a user created variable. The plots can then be accessed with the syntax `variable$plot1` to `plot6`.

**References**

For an example application refer to <https://j-ramalho.github.io/industrial/>

---

syringe_diameter	<i>Production measurements of the inner diameter of syringes barrels.</i>
------------------	---

---

**Description**

This dataset contains process control measurements of the barrel diameters of pharmaceutical syringes. The sampling rate is hourly and the sample size is 6 syringes.

**Hour** The sampling hour expressed as Hour1, Hour2 (character)

**Sample1** Syringe diameter of sample 1 (numerical)

**Sample2** Syringe diameter of sample 2 (numerical)

**Usage**

```
syringe_diameter
```

**Format**

A tibble with 25 observations on 7 variables.

**Source**

Original data set.

**References**

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>.

**Examples**

```
data(syringe_diameter)
```



---

tablet_thickness	<i>Thickness measurements of pharmaceutical tablets</i>
------------------	---

---

### Description

This data set contains physical measurements of pharmaceutical tablets (pills) including measurement room conditions. The data and the insights it provides are typical of an industrial context with high production throughput and stringent dimensional requirements.

### Usage

```
tablet_thickness
```

### Format

An object of class tibble with 675 observations on 11 variables

### Details

The data set contains other variables not used in the text book related with to the measurement room conditions (not listed).

**Position** Position of the part on the measurement device

**Size** Size class (L, M, S)

**Tablet** Part number (L001, L002, ...)

**Replicate** Measurement replicate, a sequential numbers

**Day** Measurement Day, a sequential numbers

**Date** [DD.MM.YYYY ] Measurement date (POSIXct)

**Operator** Operator name (fictitious)

**Thickness** [micron ] Tablet thickness (micrometers)

**Temperature** [°C ] Room temperature

### Source

Based on a gage r&R (gage reproducibility and repeatability) study performed in 2020 on a physical measurement of parts coming out of a high throughput industrial equipment.

### References

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

### Examples

```
data(tablet_thickness)
```

---

tablet_weight	<i>Weight measurements of pharmaceutical tablets</i>
---------------	--

---

### Description

This data set contains weight measurements of pharmaceutical tablets (pills). The data and the # insights it provides are typical of an industrial context with high production throughput and stringent dimensional requirements.

### Usage

```
tablet_weight
```

### Format

An object of class tibble with 137 observations on 3 variables

### Details

The data set contains other variables not used in the text book related with to the measurement room conditions (not listed).

**part\_id** Unique sequential identifier given during production (numeric)

**Weight Target Value** Tablet weight target specification value in [mg] (numeric)

**Weight Value** Tablet weight measured value [m] (numeric)

### Source

Anonymized data based on statistical process control data obtained in a high volume production setup.

### References

For a complete case study application refer to <https://j-ramalho.github.io/industrial/>

### Examples

```
hist(tablet_weight$`Weight value`)
```

---

theme_industRial	<i>Custom theme "industRial" for the book <code>industRial</code> Data Science plots</i>
------------------	--

---

## Description

This theme aims at optimal balance between readability and precision. It has adapted from the package `cowplot` by Claus O. Wilke and reflects the principles of his book [Fundamentals of Data Visualization](#)

## Usage

```
theme_industRial(  
  font_size = 14,  
  font_family = "",  
  line_size = 0.5,  
  rel_small = 12/14,  
  rel_tiny = 11/14,  
  rel_large = 16/14,  
  base_size = font_size,  
  base_family = font_family  
)
```

## Arguments

font_size	defaults to 14
font_family	defaults to ""
line_size	defaults to 0.5
rel_small	defaults to 12/14
rel_tiny	defaults to 11/14
rel_large	defaults to 16/14
base_size	internal arguments, defaults to font_size
base_family	internal arguments, defaults to font_family

## Details

Apply this theme by adding it at the end of the code of any `ggplot` chart. It basically combines the `half open` theme with a grid background from `cowplot`

## Value

This function returns an object of classes `theme` and `gg` from the `ggplot2` package

## References

For a complete case study application refer to <https://j-ramalho.github.io/industRial/>

## Examples

```
library(dplyr)
library(ggplot2)

pet_delivery %>%
  ggplot(aes(x = A)) +
  geom_histogram(color = "grey", fill = "grey90") +
  labs(title = "PET clothing case study",
       subtitle = "Raw data plot",
       x = "Treatment",
       y = "Tensile strength [MPa]") +
  theme_industRial()
```

---

theme\_qcc

*Custom theme "qcc" for the book industRial Data Science plots*

---

## Description

This theme provides a similar look and feel to the package `qcc` statistical process control charts (SPC) which have themselves a resemblance with Minitab charts. This theme aims at providing a layout that is familiar to readers of Minitab chart to help in reducing transition to R build reports and charts.

## Usage

```
theme_qcc(base_size = 12, base_family = "")
```

## Arguments

<code>base_size</code>	font size, defaults to 12
<code>base_family</code>	font family defaults to ""

## Details

Apply this theme by adding it at the end of the code of any `ggplot` chart. It #’ basically provides a grey background and some highlights to help reading key process statistics such as the population mean.

## Value

This function returns an object of classes `theme` and `gg` from the `ggplot2` package

## References

For a complete case study application refer to <https://j-ramalho.github.io/industRial/>

**Examples**

```
library(dplyr)
library(ggplot2)

pet_delivery %>%
  ggplot(aes(x = A)) +
  geom_histogram(color = "grey", fill = "grey90") +
  labs(title = "PET clothing case study",
        subtitle = "Raw data plot",
        x = "Treatment",
        y = "Tensile strength [MPa]") +
  theme_qcc()
```

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