Six Sigma DMAIC 15-Step Process

**DEFINE**
1. Define CTQ
2. Develop Charter
3. Define Performance Standards

**MEASURE**
4. Identify Data, Plan and Collect Data
5. Measurement Systems Analysis
6. Finalize Performance Measures

**ANALYZE**
7. Define Entitlement
8. Identify Variation Sources
9. Screen Potential Root Causes

**IMPROVE**
10. Establish Transfer Function
11. Establish Operating Tolerances
12. Confirm Results

**CONTROL**
13. Measurement Systems Analysis
14. Determine Process Capability
15. Implement Process Controls

Process Map to a Successful DMAIC Project