

Contents

1	Basic Concepts, Quality and Reliability Assurance of Complex Equipment & Systems	1
1.1	Introduction	1
1.2	Basic Concepts	2
1.2.1	Reliability	2
1.2.2	Failure	3
1.2.3	Failure Rate	4
1.2.4	Maintenance, Maintainability	8
1.2.5	Logistical Support	8
1.2.6	Availability	9
1.2.7	Safety, Risk, and Risk Acceptance	9
1.2.8	Quality	11
1.2.9	Cost and System Effectiveness	11
1.2.10	Product Liability	15
1.2.11	Historical Development	16
1.3	Basic Tasks & Rules for Quality & Reliability Assurance of Complex Equip. & Systems	17
1.3.1	Quality and Reliability Assurance Tasks	17
1.3.2	Basic Quality and Reliability Assurance Rules	19
1.3.3	Elements of a Quality Assurance System	21
1.3.4	Motivation and Training	24
2	Reliability Analysis During the Design and Development Phase	25
2.1	Introduction	25
2.2	Predicted Reliability of Equipment and Systems with Simple Structure	28
2.2.1	Required Function	28
2.2.2	Reliability Block Diagram	28
2.2.3	Operating Conditions at Component Level, Stress Factors	33
2.2.4	Failure Rate of Electronic Components	35
2.2.5	Reliability of One-Item Structures	39
2.2.6	Reliability of Series-Parallel Structures	41
2.2.6.1	Items without Redundancy	41
2.2.6.2	Concept of Redundancy	42
2.2.6.3	Parallel Models	43
2.2.6.4	Series - Parallel Structures	45
2.2.6.5	Majority Redundancy	47
2.2.7	Part Count Method	51
2.3	Reliability of Systems with Complex Structure	52
2.3.1	Key Item Method	52
2.3.1.1	Bridge Structure	53
2.3.1.2	Rel. Block Diagram in which Elements Appear More than Once	54
2.3.2	Successful Path Method	55
2.3.3	State Space Method	56
2.3.4	Boolean Function Method	57

2.3.5	Parallel Models with Constant Failure Rates and Load Sharing	61
2.3.6	Elements with more than one Failure Mechanism or one Failure Mode	64
2.3.7	Basic Considerations on Fault Tolerant Structures	66
2.4	Reliability Allocation	67
2.5	Mechanical Reliability, Drift Failures	67
2.6	Failure Mode Analyses	72
2.7	Reliability Aspects in Design Reviews	77
3	Qualification Tests for Components and Assemblies	81
3.1	Basic Selection Criteria for Electronic Components	81
3.1.1	Environment	82
3.1.2	Performance Parameters	84
3.1.3	Technology	84
3.1.4	Manufacturing Quality	90
3.1.5	Long-Term Behavior of Performance Parameters	90
3.1.6	Reliability	90
3.2	Qualification Tests for Complex Electronic Components	91
3.2.1	Electrical Test of Complex ICs	92
3.2.2	Characterization of Complex ICs	94
3.2.3	Environmental and Special Tests of Complex ICs	96
3.2.4	Reliability Tests	105
3.3	Failure Modes, Failure Mechanismus, and Failure Analysis of Electronic Components	105
3.3.1	Failure Modes of Electronic Components	105
3.3.2	Failure Mechanisms of Electronic Components	106
3.3.3	Failure Analysis of Electronic Components	106
3.4	Qualification Tests for Electronic Assemblies	110
4	Maintainability Analysis	114
4.1	Maintenance, Maintainability	114
4.2	Maintenance Concept	117
4.2.1	Fault Detection / Verification and Isolation	118
4.2.2	Equipment and System Partitioning	120
4.2.3	User Documentation	120
4.2.4	Training of Operating and Maintenance Personnel	121
4.2.5	User Logistical Support	121
4.3	Maintainability Aspects in Design Reviews	123
4.4	Predicted Maintainability	123
4.4.1	Calculation of $MTTR_S$	123
4.4.2	Calculation of $MTTPM_S$	127
4.5	Basic Models for Spare Part Provisioning	127
4.5.1	Centralized Logistical Support, Nonrepairable Spare Parts	127
4.5.2	Decentralized Logistical Support, Nonrepairable Spare Parts	130
4.5.3	Repairable Spare Parts	132
4.6	Cost Considerations	136
5	Design Guidelines for Reliability, Maintainability, and Software Quality	137
5.1	Design Guidelines for Reliability	137
5.1.1	Derating	137

5.1.2	Cooling	138
5.1.3	Moisture	140
5.1.4	Electromagnetic Compatibility, ESD Protection	141
5.1.5	Components and Assemblies	143
5.1.5.1	Component Selection	143
5.1.5.2	Component Use	143
5.1.5.3	PCB and Assembly Design	144
5.1.5.4	PCB and Assembly Manufacturing	145
5.1.5.5	Storage and Transportation	146
5.1.6	Particular Guidelines for IC Design and Manufacturing	146
5.2	Design Guidelines for Maintainability	147
5.2.1	General Guidelines	147
5.2.2	Testability	147
5.2.3	Accessibility, Exchangeability	149
5.2.4	Operation, Adjustment	150
5.3	Design Guidelines for Software Quality	150
5.3.1	Guidelines for Software Defect Prevention	153
5.3.2	Configuration Management	156
5.3.3	Guidelines for Software Testing	156
5.3.4	Software Quality Growth Models	157
6	Reliability and Availability of Repairable Systems	160
6.1	Introduction and General Assumptions	160
6.2	One-Item Structure	166
6.2.1	One-Item Structure New at Time $t = 0$	167
6.2.1.1	Reliability Function	167
6.2.1.2	Point Availability	168
6.2.1.3	Average Availability	169
6.2.1.4	Interval Reliability	170
6.2.1.5	Special Kinds of Availability	171
6.2.2	One-Item Structure New at Time $t = 0$ and with Constant Failure Rate λ	174
6.2.3	One-Item Structure with Arbitrary Initial Conditions at Time $t = 0$	174
6.2.4	Asymptotic Behavior	176
6.2.5	Steady-State Behavior	178
6.3	Systems without Redundancy	180
6.3.1	Series Structure with Constant Failure and Repair Rates	180
6.3.2	Series Structure with Constant Failure and Arbitrary Repair Rates	183
6.3.3	Series Structure with Arbitrary Failure and Repair Rates	184
6.4	1-out-of-2 Redundancy	187
6.4.1	1-out-of-2 Redundancy with Constant Failure and Repair Rates	187
6.4.2	1-out-of-2 Redundancy with Constant Failure and Arbitrary Repair Rates	195
6.4.3	1-out-of-2 Red. with Const. Failure Rate in Res. State and Arb. Repair Rates	198
6.5	k -out-of- n Redundancy	204
6.5.1	k -out-of- n Warm Redundancy with Constant Failure and Repair Rates	205
6.5.2	k -out-of- n Active Redundancy with Const. Failure and Arbitrary Repair Rates	208
6.6	Simple Series - Parallel Structures	211
6.7	Approximate Expressions for Large Series - Parallel Structures	217
6.7.1	Introduction	217
6.7.2	Application to a Practical Example	221

6.8	Systems with Complex Structure	229
6.8.1	General Considerations	229
6.8.2	Preventive Maintenance	231
6.8.3	Imperfect Switching.	234
6.8.4	Incomplete Coverage	239
6.8.5	Elements with more than two States or one Failure Mode	244
6.8.6	Fault Tolerant Reconfigurable Systems	246
6.8.6.1	Ideal Case	246
6.8.6.2	Reconfiguration at Given Fixed Times (Phased-Mission Systems)	246
6.8.6.3	Reconfiguration at System Failures	248
6.8.6.4	With Reward and Frequency / Duration Aspects	252
6.8.7	General Procedure for Complex Systems	253
6.9	Computer-Aided Reliability and Availability Computation	255
6.9.1	Numerical Solution of Equations for Reliability and Availability	255
6.9.2	Monte Carlo Simulations	256
7	Statistical Quality Control and Reliability Tests	259
7.1	Statistical Quality Control	259
7.1.1	Estimation of a Defective Probability p	260
7.1.2	Simple Two-sided Sampling Plans for the Demonstration of a Def. Probability p	262
7.1.2.1	Simple Two-sided Sampling Plans	263
7.1.2.2	Sequential Tests	265
7.1.3	One-sided Sampling Plans for the Demonstration of a Def. Probability p	266
7.2	Statistical Reliability Tests	270
7.2.1	Estimation and Demonstration of a Reliability or Availability Value	270
7.2.2	Estimation and Demonstration of a Constant Failure Rate λ or $MTBF = 1/\lambda$	272
7.2.2.1	Estimation of a Constant Failure Rate λ or $MTBF = 1/\lambda$	274
7.2.2.2	Simple Two-sided Test for the Demonstration of λ or $MTBF = 1/\lambda$	276
7.2.2.3	Simple One-sided Test for the Demonstration of λ or $MTBF = 1/\lambda$	280
7.3	Statistical Maintainability Tests	281
7.3.1	Estimation of an $MTTR$	281
7.3.2	Demonstration of an $MTTR$	283
7.4	Accelerated Testing	285
7.5	Goodness-of-fit Tests	290
7.5.1	Kolmogorov-Smirnov Test	290
7.5.2	Chi-square Test	294
7.6	Statistical Analysis of General Reliability Data	297
8	Quality and Reliability Assurance During the Production Phase	302
8.1	Basic Activities	302
8.2	Testing and Screening of Electronic Components	303
8.2.1	Testing of Electronic Components	303
8.2.2	Screening of Electronic Components	304
8.3	Testing and Screening of Electronic Assemblies	307
8.4	Test and Screening Strategies, Economic Aspects	309
8.4.1	Basic Considerations	309
8.4.2	Quality Cost Optimization at Incoming Inspection Level	311
8.4.3	Procedure to handle first deliveries	317
8.5	Reliability Growth	317

A1 Terms and Definitions 323

A2 Quality and Reliability Standards 337

 A2.1 Introduction 337

 A2.2 Requirements in the Industrial Field 338

 A2.3 Requirements in the Aerospace, Defense, and Nuclear Fields 340

A3 Definition and Realization of Quality and Reliability Requirements 341

 A3.1 Definition of Quality and Reliability Requirements 341

 A3.2 Realization of Quality and Reliability Requirements for Complex Equip. & Systems. 343

 A3.3 Elements of a Quality and Reliability Assurance Program 348

 A3.3.1 Project Organization, Planning, and Scheduling 348

 A3.3.2 Quality and Reliability Requirements 349

 A3.3.3 Reliability and Safety Analysis 349

 A3.3.4 Selection and Qualific. of Components, Materials, and Manuf. Processes . . 350

 A3.3.5 Configuration Management 350

 A3.3.6 Quality Tests 352

 A3.3.7 Quality Data Reporting System 352

A4 Checklists for Design Reviews 355

 A4.1 System Design Review 355

 A4.2 Preliminary Design Reviews 356

 A4.3 Critical Design Review (System Level) 358

A5 Requirements for Quality Data Reporting Systems 360

A6 Basic Probability Theory 363

 A6.1 Field of Events 363

 A6.2 Concept of Probability 365

 A6.3 Conditional Probability, Independence 368

 A6.4 Fundamental Rules of Probability Theory 369

 A6.4.1 Addition Theorem for Mutually Exclusive Events 369

 A6.4.2 Multiplication Theorem for Two Independent Events 370

 A6.4.3 Multiplication Theorem for Arbitrary Events 371

 A6.4.4 Addition Theorem for Arbitrary Events 371

 A6.4.5 Theorem of Total Probability 372

 A6.5 Random Variables, Distribution Functions 373

 A6.6 Numerical Parameters of Random Variables 378

 A6.6.1 Expected Value (Mean) 378

 A6.6.2 Variance 382

 A6.6.3 Modal Value, Quantile, Median 384

 A6.7 Multidimensional Random Variables, Conditional Distributions 384

 A6.8 Numerical Parameters of Random Vectors 386

 A6.8.1 Covariance Matrix, Correlation Coefficient 387

 A6.8.2 Further Properties of Expected Value and Variance 388

 A6.9 Distribution of the Sum of Indep. Positive Random Variables and of $\tau_{\min}$, $\tau_{\max}$. 388

 A6.10 Distribution Functions used in Reliability Analysis 391

 A6.10.1 Exponential Distribution 391

 A6.10.2 Weibull Distribution 392

A6.10.3	Gamma Distribution, Erlangian Distribution, and χ^2 -Distribution	394
A6.10.4	Normal Distribution	396
A6.10.5	Lognormal Distribution	397
A6.10.6	Uniform Distribution	399
A6.10.7	Binomial Distribution	399
A6.10.8	Poisson Distribution	401
A6.10.9	Geometric Distribution	403
A6.10.10	Hypergeometric Distribution	404
A6.11	Limit Theorems	404
A6.11.1	Law of Large Numbers	405
A6.11.2	Central Limit Theorem	406
A7	Basic Stochastic-Processes Theory	410
A7.1	Introduction	410
A7.2	Renewal Processes	413
A7.2.1	Renewal Function, Renewal Density	415
A7.2.2	Recurrence Times	418
A7.2.3	Asymptotic Behavior	419
A7.2.4	Stationary Renewal Processes	421
A7.2.5	Homogeneous Poisson Processes	422
A7.3	Alternating Renewal Processes	424
A7.4	Regenerative Processes	428
A7.5	Markov Processes with Finitely Many States	430
A7.5.1	Markov Chains with Finitely Many States	430
A7.5.2	Markov Processes with Finitely Many States	432
A7.5.3	State Probabilities and Stay (Sojourn) Times in a Given Class of States	441
A7.5.3.1	Method of Differential Equations	441
A7.5.3.2	Method of Integral Equations	445
A7.5.3.3	Stationary State and Asymptotic Behavior	446
A7.5.4	Frequency / Duration and Reward Aspects	448
A7.5.4.1	Frequency / Duration	448
A7.5.4.2	Reward	450
A7.5.5	Birth and Death Process	451
A7.6	Semi-Markov Processes with Finitely Many States	455
A7.7	Semi-regenerative Processes	460
A7.8	Nonregenerative Stochastic Processes	464
A7.8.1	General Considerations	464
A7.8.2	Nonhomogeneous Poisson Processes (NHPP)	465
A8	Basic Mathematical Statistics	469
A8.1	Empirical Methods	469
A8.1.1	Empirical Distribution Function	470
A8.1.2	Empirical Moments and Quantiles	472
A8.1.3	Further Applications of the Empirical Distribution Function	473
A8.2	Parameter Estimation	477
A8.2.1	Point Estimation	477
A8.2.2	Interval Estimation	482
A8.2.2.1	Estimation of an Unknown Probability p	482
A8.2.2.2	Estimation of the Param. λ for an Exp. Distribution, Fixed T	486
A8.2.2.3	Estimation of the Param. λ for an Exp. Distribution, Fixed n	487
A8.3	Testing Statistical Hypotheses	489

A8.3.1 Testing an Unknown Probability p 490

 A8.3.1.1 Simple Two-sided Sampling Plan 491

 A8.3.1.2 Sequential Test 492

 A8.3.1.3 Simple One-sided Sampling Plan 494

A8.3.2 Goodness-of-fit Tests for Completely Specified $F_0(t)$ 495

A8.3.3 Goodness-of-fit Tests for $F_0(t)$ with Unknown Parameters 498

A9 Tables and Charts 501

 A9.1 Standard Normal Distribution 501

 A9.2 χ^2 -Distribution (Chi-Square Distribution) 502

 A9.3 t -Distribution (Student distribution) 503

 A9.4 F Distribution (Fisher distribution) 504

 A9.5 Table for the Kolmogorov-Smirnov Test 505

 A9.6 Gamma Function 506

 A9.7 Laplace Transform 507

 A9.8 Probability Charts (Probability Plot Papers) 509

 A9.8.1 Lognormal Probability Chart 509

 A9.8.2 Weibull Probability Chart 510

 A9.8.3 Normal Probability Chart 511

Acronyms 512

References 513

Index 533