

## Analysis and Control of Variation: Understanding and Reducing Analytical Error—Why Good Science Requires Operational Excellence



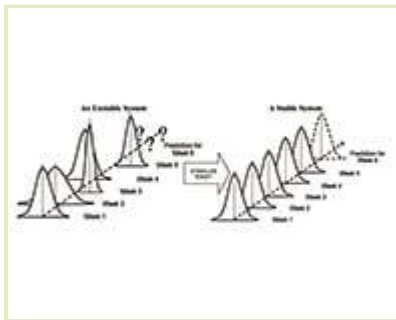
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Good science in discovery, development, production, and in laboratories requires stable operations with low variation. Unstable analytical systems signals from the analytical process add variation to production data. Actual examples of variable processes are presented. “Stabilize first” is the first principle. Stable processes are predictable. Variation in laboratory operations may mask causal relationships in other areas. Compliance to procedures is not acceptable rationale for a variable process. Senior management should remove obstacles to conquering variation by making it a strategic...

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