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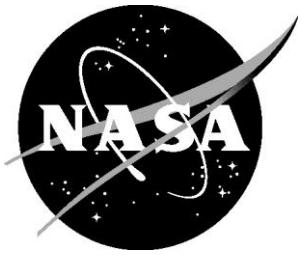


# NASA DOEPOD NDE Capabilities Data Book

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July 2015

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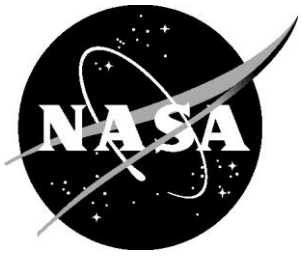

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## Overview

This data book contains the Directed Design of Experiments for Validating Probability of Detection (POD) Capability of NDE Systems (DOEPOD) analyses of the nondestructive inspection data presented in the NTIAC, Nondestructive Evaluation (NDE) Capabilities Data Book [1]. DOEPOD is designed as a decision support system to validate inspection system, personnel, and protocol demonstrating 0.90 POD with 95% confidence at critical flaw sizes, a90/95. Although 0.90 POD with 95% confidence at critical flaw sizes is often stated as an inspection requirement in inspection documents, including NASA Standards [2], NASA critical aerospace applications have historically only accepted 0.978 POD or better with a 95% one-sided lower confidence bound exceeding 0.90 at critical flaw sizes, a90/95. (see Figure 11 of [3]).

The test methodology used in DOEPOD is based on the field of statistical sequential analysis founded by Abraham Wald,

*"Sequential analysis is a method of statistical inference whose characteristic feature is that the number of observations required by the procedure is not determined in advance of the experiment. The decision to terminate the experiment depends, at each stage, on the results of the observations previously made. A merit of the sequential method, as applied to testing statistical hypotheses, is that test procedures can be constructed which require, on average, a substantially smaller number of observations than equally reliable test procedures based on a predetermined number of observations." A. Wald* [4]

Details of the analysis methods used in DOEPOD are fully described in the DOEPOD [5] manual, and "Directed Design of Experiments for Validating Probability of Detection Capability of a Testing System" US Patent Serial Number: US 8,108,178. Additional details are available on the operation [6] [7] and proof property validation [7] of DOEPOD.

The critical importance of validating methodologies used for establishing POD have been highlighted [3] and this data book provides the DOEPOD validation of POD capabilities for NDE systems, materials, structures, and flaw types presented in the NTIAC, Nondestructive Evaluation (NDE) Capabilities Data Book [1].

The maximum likelihood estimation (MLE) method used in DOEPOD to estimate the probability of detection using a two parameter logit model (MLE-Logit) are identical to that used in NTIAC [1]. This MLE method was chosen as a verification of data integrity so that the MLE POD plots in NTIAC [1] and this data book are identical except where this data book provides a correction to NTIAC [1] analysis. Corrections to NTIAC [1] are indicated in the Errata listed at the end of this document. Other MLE-Logit methods may be used, and a simple grid search for maximizing parameters has been demonstrated [3] to be effective. The POD analysis methods of NTIAC [1] and a military handbook [8] use a predetermined number of observations.

It is noted here that the MLE-Logit POD curve fit plots shown in this data book and NTIAC [1] are not validated for implementation [3]. Internal and external validation of MLE-Logit POD estimates is required prior to implementation and initial guidance on validation procedures is provide elsewhere [3]. In contrast, if CASE 1, CASE 1+, CASE 1# identifications are identified by DOEPOD analyses of test data, then the system, personnel, and inspection protocol maybe considered for acceptance by engineering authority for implementation application on relevant systems

437 NTIAC data sets are analyzed by DOEPOD to yield a CASE identification for each data set. Possible CASE identifications are listed in Table 1. The reader is referred to the DOEPOD manual [5] for definitions of the parameters in Table 1, and for design of experiment instructions on how to proceed to validate systems and personnel inspection capability. The DOEPOD analysis highlights 72 NTIAC data sets has CASE 1, CASE 1+, or CASE 1# data sets all exhibit 0.978 POD or better with a 95% one-sided lower confidence bound exceeding 0.90 at critical flaw sizes and meet the historical NASA acceptance criteria when actions in Table 1 are addressed.

DOEPOD acronyms are defined at the end of this overview.

## Table 1

| | Is 90/95 POD at $X_{pod}$ reached? (i.e., lower confidence bound, $X_{Best\_LCL}$, is equal to or greater than 0.9) | DOEPOD Analysis Summary and Recommendations |
|---|---|---|
| CASE 1 |  | 90/95 POD at $X_{pod}$ has been reached.<br>Actions: Address any false call warnings. |
| CASE 1+ |  | 90/95 POD at $X_{pod}$ has been reached.<br>Actions: Misses above Xpod need to be explained and resolved. Address any false call warnings. |
| CASE 1# |  | 90/95 POD at $X_{pod}$ has been reached.<br>Actions: Further validation at flaw sizes greater than Xpod is required. Add large flaws. Address any false call warnings. |
| CASE 1* |  | 90/95 POD at $X_{pod}$ has been reached.<br>Actions: Further validation at flaw sizes greater than Xpod is required. Add large flaws. Misses above Xpod need to be explained and resolved. Address any false call warnings. |
| CASE 2 |  | 90/95 POD at $X_{pod}$ has been reached, however, there are an excessive number Misses above $X_{pod}$.<br>Actions: Additional validation at identified flaw sizes is required. Add flaws per instructions. |
| CASE 4 |  | 90/95 POD at $X_{pod}$ has not been reached.<br>Actions: Increase number of flaws at $X_{POH=1}$ or $X_{Best\_LCL}$. |
| CASE 5 |  | 90/95 POD at $X_{pod}$ has not been reached and there are Misses above $X_{Best\_LCL}$.<br>Actions: Increase the number of flaws at $X_{POH=1}$. |
| CASE 6 |  | 90/95 POD at $X_{pod}$ has not been reached. The POH is fluctuating above $X_{Best\_LCL}$ and $X_{poh}$ is greater than $X_L/3$. The inspection system is unstable for the flaw size range analyzed. Actions: Increase the flaw size range by a factor of two. |
| CASE 7 |  | 90/95 POD at $X_{pod}$ has not been reached. The inspection system is unstable for the entire flaw size range analyzed.<br>Actions: The inspection system may not be appropriate or increase the flaw size range by a factor of two. |
| SURVEY CASES |  | The optimized class width exceeds 1/3 XL and $X_{pod}$ has not been reached. The class width optimization has determined that there is a class width for which the smallest $X_{POH}$=1 class length is identified. Actions: Add flaws at Survey/Optimum $X_{POH}$ |

 = YES  = NO

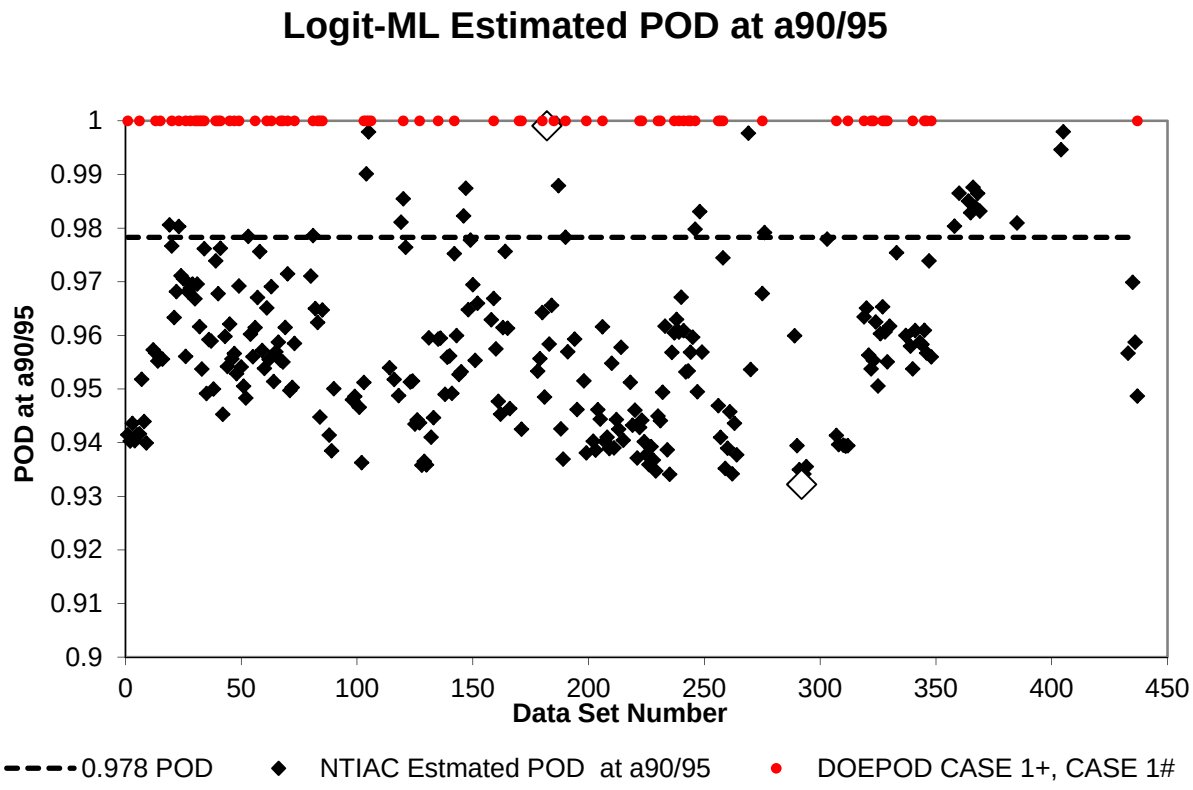


**Figure 1.** Logit-ML Estimated POD at critical flaw size, a90/95, from NTIAC (1997). Open diamonds refer to data sets each having 325 samples. The horizontal dashed line is the NASA minimum binomial estimated POD (0.978) accepted in practice at a flaw size, Xpod, for failure critical applications. DOEPOD analyses identified 72 (red disk) data NTIAC data sets that are classified as CASE 1+, or CASE 1# having estimated POD exceeding 0.978 at a flaw size, Xpod. Note that Xpod and a90/95 are flaw size inspection capability labelling designations for DOEPOD and NTIAC Data Books, respectively. Xpod and a90/95 do not necessarily refer to the same flaw size for the same data sets.

A top level summary of the DOEPOD analyses of the nondestructive inspection data presented in the NTIAC Data Book [1] is provide in Table 2. CASE 1+, CASE 1#, CASE 1*, and CASE 2 all exhibit at least one singular point where the one-sided lower 95% confidence bound on POD exceeds 0.90 at a critical flaw size and additional actions are needed per Table 2 instructions to complete the validation over a range of larger flaw sizes. CASE 4 data sets represent data sets that are similar to CASE 2 data sets, however additional data at selected flaws sizes is needed to move a CASE 4 data set to a CASE 2 data set. The CASE 5 data sets have excessive false negatives in the flaw size range tested, therefore data for larger flaw sizes is needed. CASE 6 data sets exhibit local instability over a portion of the flaw sizes tested, therefore, therefore data for larger flaw sizes is needed or the inspection system is inappropriate for the inspection required. CASE 7 data sets exhibit instability over the entire the flaw size range tested, therefore, therefore data for larger flaw sizes is needed or the inspection system is inappropriate for the

inspection required.

**Table 2**

| CASE ID | Number of Data Sets | Action Needed |
|---|---|---|
| CASE 1+ | 2 | Explain of observed false negatives |
| CASE 1# | 71 | Further validation at larger flaws. Add test specimens with larger flaws. |
| CASE 1* | 80 | Further validation at larger flaw. Add test specimens with larger flaws. Explain observed false negatives. |
| CASE 2 | 46 | Add test specimens at identified flaw sizes to demonstrate POD to be monotonically increasing with flaw size |
| CASE 4 | 37 | Increase amount of relevant data by adding test specimens at identified flaw sizes to establish acceptable POD |
| CASE 5 | 12 | Add test specimens with increased flaw sizes to address excessive false negatives at smaller flaw sizes. |
| CASE 6 | 91 | Add test specimens with flaw sizes at least twice as large to address local inspection system oscillation instability or utilize a different inspection system or method. |
| CASE 7 | 98 | Add test specimens with flaw sizes at least twice as large to address global inspection system instability or utilize a different inspection system or method. |

A summary of the output of parameter values from the DOEPOD analysis of nondestructive inspection data and methods presented in the NTIAC Data Book [1] is listed in Table 3. The descriptions of the parameters in Table 3 are detailed in reference [5]. The data file name is in column 3 of Table 3 and is used to identify the companion DOEPOD analysis output file. The printouts of the DOEPOD analysis output files follow in alphabetic in order to facilitate location. The electronic DOEPOD analysis output files and a searchable summary of parameter values from the DOEPOD analysis (Table 3) are available in the companion CD-ROM entitled "NASA DOEPOD Nondestructive Evaluation (NDE) Capabilities Data Book" which may be obtained upon request from the publisher.

DOEPOD software is available from NASA by contacting Kathy A. Dezern,
phone: 757.864.5704, email: kathy.a.dezern@nasa.gov

**Example**

As an illustrative example we examine the first data set A1001AL. The multi-parameter maximum likelihood analysis in the NTIAC NDE Capabilities Data Book indicates the inspection system to have a 0.94 POD with lower single-sided 95% confidence bound that exceeds 0.9 at 0.27" flaw size (column labeled "NTIAC 90/95 occurs at POD (inch)". In contrast, the NASA DOEPOD point estimate based method (no curve fitting) indicates that the acceptable capability of this inspection system is at or above the 0.61" flaws size (column labeled Xpod CLASSLENGTH) where 1.0 POD is estimated (column labeled POH or POD @Xpod) with a single-sided lower 95% confidence bound that exceeds 0.9 at 0.61" flaw size.

Examining the data analyses for A1001AL (page 20). There are five Misses (Xs) for the 72 flaws larger than the 0.27" flaw size yielding a 0.93 point estimate of POD for these grouped larger flaws with a single-sided lower 95% confidence bound of 0.83. The multi-parameter POD curve fit does not highlight these Misses as important. DOEPOD indicates that the POD capability for this system and for fracture critical inspections is at or above the 0.61" flaw size. Even then, DOEPOD analysis indicates [RED notes in chart] that additional large flaw data is needed to complete the validation before accepting the 0.61" flaw size capability of this inspection system, and that false call analysis is also required.

Accepting the 0.27" flaw size identified by multi-parameter maximum likelihood method as the detection capability of this inspection system for fracture critical inspections adds known risk as highlighted by the 0.93 point estimate of POD with a single-sided lower bound of 0.83 for the largest flaws. DOEPOD analysis indicates that the POD capability for this system and for fracture critical inspections is at or above the 0.61" flaw size.

**DOEPOD DEFINITIONS**

| | |
|---|---|
| $C_L$ | Class length, e.g., inspection parameter (length, depth, area, etc.) |
| $C_W$ | Class width (width of the moving class; all flaws within the range $C_L$ to $C_L$ - $C_W$, inclusively, are group together ) |
| Hit | Flaw is detected |
| Miss | Flaw is not detected |
| MLE | Maximum Likelihood Estimate of POD using a two parameter statistical model. The MLE is included in DOEPOD as a user request for comparison. *The included method is that of the* NDE Capabilities Data Book, 3rd ed., Nov. 1997, NTIAC DB-97-02, DoD. *The use of MLE estimated POD is not recommend unless a full validation of the estimated POD is performed (see Generazio, E. R., Interrelationships Between Receiver/Relative Operating Characteristics Display, Binomial, Logit, and Bayes' Rule Probability of Detection Methodologies, NASA-TM-2014-21818, April 2014.* |
| Need | Add new samples to the existing specimen set in order to reach the number of samples required at the class length. Note that a single specimen may contain more than one flaw, so that "add samples" refers to "add flaws". |
| LCL | Lower confidence bound (value) of POH @ 95% confidence |
| Opt. $X_{POH}$ | Optimum $X_{POH}$ is identified for non-survey data sets. Optimum $X_{POH}$ is the smallest class length and largest class width at which the minimum $X_{POH} = 1$ occurs. Optimum $X_{POH}$ may be more aggressive than optional, $X_{PODopt}$, or $X_{Best\ LCL}$, when the class width is constrained to the companion Optimum $X_{POH}$ class width listed. DOEPOD does not force use of Optimum $X_{POH}$ over $X_{PODopt.}$ or $X_{Best\ LCL}$ Stability has not been demonstrated at Optimum $X_{POH,}$ therefore there is an additional risk that Optimum $X_{POH}$ can not be satisfied to reach $X_{POD}$ |
| POH | Estimate of Probability of Hit (Number of Hits in Class Length/Total Number of Trials in Class Length) |
| POD | Probability of Detection (the true POD obtained if an infinite number of samples are used) |
| Signal Amplitude | Scalar amplitude output of NDE inspection system |

| | |
|---|---|
| Survey Data Sets | Survey Data Sets are data sets that have a sparce or disperse collection of samples. The moving class width optimization has identified this data set as having limited applications where the classwidth has exceeded $X_L/3$ and $X_{POD}$ has not been reached. An alternate optimization of $X_{POH}$ is used to provide guidance. The Survey Set is the recommended initial set for DOEPOD. |
| Survey $X_{POH}$ | Survey $X_{POH}$ is only identified for data sets determined to be Survey Data Sets. Survey $X_{POH}$ is the smallest class length and largest class width at which the minimum $X_{POH} = 1$ class length occurs. Survey $X_{POH}$ is the minimum class length at which $X_{POD}$ may be achieved when the class width is constrained to the companion survey class width listed. Survey $X_{POH}$ is utilized in all cases in which a Survey Set is identified by DOEPOD. |
| $X_{Best\ LCL}$ | Class length exhibiting the maximum or "best" LCL. The best class length is determined by increasing the moving class width until a maximum LCL is obtained |
| $X_i$ | Class length X at point "i" |
| $X_L$ | Largest class length in entire data set |
| $X_m$ | Class length near the mid-point between the largest and the smallest class lengths having no Misses |
| $X_P$ | 90/95 POD or greater is achieve, by grouping numbers of specimens, for the range $X_P$ to $X_L$. $X_P$ is only provided when $X_{POD}$ has been identified.<br><br>For inspector qualification, $X_P$ cannot be less than the largest flaw Missed. The class width of flaw set used for inspector qualification is listed as Inspector Classwidth @ Xp in the charts. The flaw sizes used for inspector qualification range from Xp to (Xp - Classwidth @ Xp ). |
| $X_{POD}$ | Class length at which the lower confidence bound (value) is 0.90 (90/95 POD) @ 95% confidence. |
| $X_{POH=1}$, $X_{POH}$ | Class length where there are no Misses above this class length, and POH = 1 above this class length. |
| $X_{PODopt}$ | Optional existing smaller class length where $X_{POD}$ may also be achieved if additional samples are added and Hits are identified. |
| $X_S$ | Smallest class length in the data set |
| UCL | Upper confidence bound (value) of the false call rate @ 95% confidence |

**Validated 90/95 POD has been reached at a classlength, $X_{POD}$. In order to achieve 90/95 POD for the class length range between $X_{POD}$ and the largest class length in the data set, $X_L$, inclusively, validation at a classlength near the mid-point and largest classlength is required[ξ]. If, in addition, there exists a class length, $X_P$, where 90/95 POD or greater exits for all class lengths in the range $X_P$ to $X_L$, and $X_P = X_{POD}$, and there is a sufficient number and adequate range and distribution of classlengths greater than $X_{POD}$, then the validation extends from $X_{POD}$ to $X_L$. When this occurs, validation at a classlength near the mid-point and largest classlength is satisfied. [ξ]WARNING: There are inspection systems that exhibit an oscillating or non-uniform POD. For example when the flaws are greater than the eddy current footprint, when large flaws are loaded to closure, or when the physics of the inspection processes changes modes over the flaw size range of interest. If flaws in these ranges or conditions are to be detected with a 90/95 POD, then samples in these ranges need to be included. When multiple base parameters are combined, e.g., (length)x(width) = area, and the combine parameter (e.g., area) is used as the class length, then 90/95 POD is only valid if the inspection technology has been validated to quantitatively measure each of the base parameters, or if the inspection technology is validated to quantitatively measure the new combine parameter. When all CASE 1 or CASE 1+ requirements are met, and the above warnings have been evaluated and the upper confidence bound of the false call rate is not excessive, then the inspection system is validated between $X_{POD}$ and the largest class length $X_L$ for the flaw types, materials, and structure of the test specimen set. Validated is defined here to be: "This confidence bound procedure has a probability of at least 0.95 to give a lower bound for the 90% POD point that exceeds true (unknown) 90% POD point. This is referred to as 90/95 POD, and for larger flaws in the evaluation range 90/95 POD is met or exceeded. DOEPOD SOFTWARE AND ANY ACCOMPANYING DOCUMENTATION IS RELEASED "AS IS". THE U.S. GOVERNMENT MAKES NO WARRANTY OF ANY KIND, EXPRESSED OR IMPLIED, INCLUDING, WITHOUT LIMITATION, ANY WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. IN NO EVENT WILL THE U.S. GOVERNMENT BE LIABLE FOR ANY DAMAGES, INCLUDING ANY LOST PROFITS, LOST SAVINGS, OR OTHER INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING OUT OF THE USE, OR INABILITY TO USE THIS SOFTWARE OR ANY ACCOMPANYING DOCUMENTATION, EVEN IF INFORMED IN ADVANCE OF THE POSSIBILITY OF SUCH DAMAGES. THIS SOFTWARE MAY NOT BE MODIFIED, DISTRIBUTED, OR REPRODUCED.

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**[2] NASA, "NASA-STD-5009, Nondestructive Evaluation Requirements for Fracture Critical Metallic Components," 4 April 2008.**

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**[7] E. R. Generazio, "Validating Design of Experiments for Determining Probability of Detection Capability for Fracture CRitical Applications," *Materials Evaluation,* vol. 69, no. No.2, pp. 1399-1407, December 2011.**

**[8] Department of Defense, "MIL-HDBK-1823A, Nondestructive Evaluation System Reliability Assessment," 7 April 2009.**

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2219 Al T-87 | plate | A1001AL.xls | 6/4/15 5:14 PM | CASE 1# | 0.6100 | 0.2000 | 0.9050 | | | | 0.9790 | | 0.7100 | | | | | | | | | | | | 0.5890 | 29 | | | | | | | | Warning: No false call analysis. | | 0.2 | 0.27 | 0.61 | 1.000 | ET |
| 2219 Al T-87 | plate | A1001BL.XLS | 6/4/15 5:16 PM | CASE 2 | 0.3130 | 0.2000 | 0.9040 | | | | 0.9790 | 24 | 0.6460 | 29 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.25 | | 0.961 | ET |
| 2219 Al T-87 | plate | A1001CL.XLS | 6/4/15 5:19 PM | CASE 1* | 0.3360 | 0.0570 | 0.9001 | | | | 0.9790 | | 0.5430 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.3 | 0.41 | 0.496 | 1.000 | ET |
| 2219 Al T-87 | plate | A1002AL.XLS | 6/4/15 5:21 PM | CASE 2 | 0.2980 | 0.0510 | 0.9001 | | | | 0.9790 | 22 | 0.4890 | 24 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.2 | 0.285 | | 1.000 | ET |
| 2219 Al T-87 | plate | A1002BL.XLS | 6/4/15 5:22 PM | CASE 1* | 0.1080 | 0.0310 | 0.9001 | | | | 0.9790 | | 0.3360 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.095 | 0.131 | 0.967 | ET |
| 2219 Al T-87 | plate | A1002CL.XLS | 6/4/15 5:25 PM | CASE 1# | 0.1530 | 0.0360 | 0.9001 | | | | 0.9790 | | 0.5230 | | | | | | | | | | | | 0.1520 | 29 | | | | | | | | Warning: No false call analysis. | | 0.275 | 0.41 | 0.153 | 1.000 | ET |
| 2219 Al T-87 | plate | A1003AL.XLS | 6/4/15 5:27 PM | CASE 1* | 0.0760 | 0.0090 | 0.9077 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.055 | 0.065 | 0.096 | 1.000 | ET |
| 2219 Al T-87 | plate | A1003BL.XLS | 6/4/15 5:30 PM | CASE 1* | 0.0830 | 0.0080 | 0.9001 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.04 | 0.05 | 0.086 | 1.000 | ET |
| 2219 Al T-87 | plate | A1003CL.XLS | 6/4/15 5:34 PM | CASE 1* | 0.0830 | 0.0080 | 0.9001 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.115 | 0.108 | 1.000 | ET |
| 2219 Al T-87 | plate | A2002AL.XLS | 6/4/15 5:36 PM | CASE 7 | | | | 0.8853 | 0.2000 | 0.5100 | | | | | | | | | | | 1.1000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.29 | | | | ET |
| 2219 Al T-87 | plate | A2002BL.XLS | 6/4/15 5:38 PM | CASE 7 | | | | 0.8609 | 0.2000 | 0.3720 | | | | | | | | | | | 1.1000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87 | plate | A2002CL.XLS | 6/4/15 5:39 PM | CASE 1* | 0.4740 | 0.2000 | 0.9001 | | | | 0.5500 | 0 | 0.4960 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.17 | 0.474 | 1.000 | ET |
| Ti 6Al4V | plate | A3001AL.XLS | 6/4/15 5:40 PM | CASE 1# | 0.2250 | 0.0400 | 0.9001 | | | | 0.4070 | | 0.2750 | | | | | | | | | | | | 0.2225 | 29 | | | | | | | | Warning: No false call analysis. | | 0.175 | 0.21 | 0.225 | 1.000 | ET |
| Ti 6Al4V | plate | A3001BL.XLS | 6/4/15 5:41 PM | CASE 2 | 0.2650 | 0.0800 | 0.9001 | | | | 0.4070 | 57 | 0.3150 | 9 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.265 | 0.365 | | 0.978 | ET |
| Ti 6Al4V | plate | A3001CL.XLS | 6/4/15 5:43 PM | CASE 1# | 0.2420 | 0.0420 | 0.9001 | | | | 0.4070 | | 0.3550 | | | | | | | | | | | | 0.2350 | 1 | | | | | | | | Warning: No false call analysis. | | 0.18 | 0.21 | 0.242 | 1.000 | ET |
| Ti 6Al4V | plate | A3003AL.XLS | 6/4/15 5:43 PM | CASE 7 | | | | 0.8719 | 0.0270 | 0.2120 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.275 | 0.36 | | | ET |
| Ti 6Al4V | plate | A3003BL.XLS | 6/4/15 5:45 PM | CASE 7 | | | | 0.7411 | 0.0220 | 0.2470 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.49 | | | | ET |
| Ti 6Al4V | plate | A3003CL.XLS | 6/4/15 5:46 PM | CASE 7 | | | | 0.7942 | 0.0310 | 0.2470 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.585 | | | | ET |
| SS AMS 355 | hole | A400011.XLS | 6/4/15 5:48 PM | CASE 6 | | | | 0.8190 | 0.0750 | 0.1752 | 0.2575 | 24 | | | | | | | 0.2575 | 24 | 0.5150 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.12 | 0.185 | | | ET |
| SS AMS 355 | hole | A400013.XLS | 6/4/15 5:49 PM | CASE 1# | 0.1031 | 0.0540 | 0.9001 | | | | 0.2575 | | 0.1929 | | | | | | | | | | | | 0.1004 | 2 | | | | | | | | Warning: No false call analysis. | | 0.04 | 0.065 | 0.10314 | 1.000 | ET |
| SS AMS 355 | hole | A400014.XLS | 6/4/15 5:50 PM | CASE 6 | | | | 0.6518 | 0.0070 | 0.0559 | 0.2575 | 28 | | | | | | | 0.1559 | 28 | 0.5150 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.205 | | | ET |
| SS AMS 355 | hole | A400015.XLS | 6/4/15 5:51 PM | CASE 5 | | | | 0.5493 | 0.0030 | 0.0579 | 0.2575 | 28 | | | | | | | 0.0663 | 27 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.035 | 0.065 | | | ET |
| SS AMS 355 | hole | A400016.XLS | 6/4/15 5:52 PM | CASE 1# | 0.1031 | 0.0540 | 0.9001 | | | | 0.2575 | | 0.1929 | | | | | | | | | | | | 0.1004 | 2 | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.045 | 0.10314 | 1.000 | ET |
| SS AMS 355 | hole | A500011.XLS | 6/4/15 5:53 PM | CASE 4 | | | | 0.8855 | 0.0230 | 0.0902 | 0.0902 | 4 | | | | | 0.0902 | 4 | 0.0902 | | 0.1803 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.085 | | | ET |
| SS AMS 355 | hole | A500013.XLS | 6/4/15 5:55 PM | CASE 6 | | | | 0.7360 | 0.0050 | 0.0204 | 0.0461 | 28 | | | | | | | 0.0339 | 27 | 0.0921 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.06 | | | ET |
| SS AMS 355 | hole | A500014.XLS | 6/4/15 5:56 PM | CASE 1# | 0.0591 | 0.0180 | 0.9001 | | | | 0.0902 | | 0.0776 | | | | | | | | | | | | 0.0579 | 2 | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.035 | 0.05905 | 1.000 | ET |
| SS AMS 355 | hole | A500015.XLS | 6/4/15 5:57 PM | CASE 5 | | | | 0.5493 | 0.0030 | 0.0579 | 0.2575 | 28 | | | | | | | 0.0663 | 27 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.035 | 0.065 | | | ET |
| SS AMS 355 | hole | A500016.XLS | 6/4/15 5:58 PM | CASE 1# | 0.0610 | 0.0250 | 0.9001 | | | | 0.0815 | | 0.0681 | | | | | | | | | | | | 0.0587 | 3 | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.04 | 0.06102 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001A.XLS | 6/4/15 5:59 PM | CASE 1* | 0.1140 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.1 | 0.114 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001AR.XLS | 6/4/15 6:00 PM | CASE 1# | 0.1140 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | 0.1060 | 3 | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.095 | 0.114 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001B.XLS | 6/4/15 6:01 PM | CASE 1# | 0.0940 | 0.0140 | 0.9001 | | | | 0.8120 | | 0.2760 | | | | | | | | | | | | 0.0930 | 1 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.065 | 0.075 | 0.094 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001C.XLS | 6/4/15 6:03 PM | CASE 1# | 0.1140 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | 0.1060 | 3 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.085 | 0.09 | 0.114 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001D.XLS | 6/4/15 6:04 PM | CASE 1# | 0.1280 | 0.0240 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1270 | 1 | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.115 | 0.128 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001E.XLS | 6/4/15 6:05 PM | CASE 1# | 0.1280 | 0.0240 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1270 | 1 | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.1 | 0.128 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001F.XLS | 6/4/15 6:06 PM | CASE 1* | 0.1200 | 0.0230 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.075 | 0.09 | 0.12 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001G.XLS | 6/4/15 6:07 PM | CASE 4 | | | | 0.8666 | 0.0870 | 0.2760 | 0.8120 | 27 | | | | | 0.2760 | 8 | 0.2760 | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.16 | 0.185 | | | ET |
| 2024 Al T-37 | lap splice | A6001GR.XLS | 6/4/15 6:09 PM | CASE 6 | | | | 0.8707 | 0.0540 | 0.1920 | 0.8120 | 27 | | | | | | | 0.3220 | 24 | 1.6240 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.16 | 0.185 | | | ET |
| 2024 Al T-37 | lap splice | A6001H.XLS | 6/4/15 6:11 PM | CASE 1* | 0.1310 | 0.0250 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.105 | 0.12 | 0.227 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001J.XLS | 6/4/15 6:12 PM | CASE 1# | 0.1310 | 0.0250 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1305 | 29 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.105 | 0.115 | 0.131 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6001JR.XLS | 6/4/15 6:13 PM | CASE 1# | 0.1280 | 0.0240 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1230 | 2 | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.11 | 0.128 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002A.XLS | 6/4/15 6:14 PM | CASE 1# | 0.0940 | 0.0140 | 0.9001 | | | | 0.8120 | | 0.2760 | | | | | | | | | | | | 0.0930 | 1 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.075 | 0.085 | 0.094 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002B.XLS | 6/4/15 6:15 PM | CASE 2 | 0.1050 | 0.0180 | 0.9001 | | | | 0.8120 | 26 | 0.2910 | 26 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.1 | 0.12 | | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002C.XLS | 6/4/15 6:17 PM | CASE 1* | 0.1050 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.07 | 0.08 | 0.105 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002D.XLS | 6/4/15 6:18 PM | CASE 1* | 0.1280 | 0.0240 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.115 | 0.128 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002DR.XLS | 6/4/15 6:19 PM | CASE 1# | 0.1540 | 0.0340 | 0.9077 | | | | 0.8120 | | 0.3220 | | | | | | | | | | | | 0.1530 | 29 | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.11 | 0.154 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002E.XLS | 6/4/15 6:20 PM | CASE 1* | 0.1310 | 0.0250 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.11 | 0.13 | 0.227 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002ER.XLS | 6/4/15 6:21 PM | CASE 1# | 0.1860 | 0.0450 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1840 | 29 | | | | | | | | Warning: No false call analysis. | | 0.11 | 0.125 | 0.186 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002F.XLS | 6/4/15 6:22 PM | CASE 7 | | | | 0.8190 | 0.0710 | 0.2910 | | | | | | | | | | | 1.6240 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.2 | 0.265 | | | ET |
| 2024 Al T-37 | lap splice | A6002G.XLS | 6/4/15 6:24 PM | CASE 1# | 0.1200 | 0.0230 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1190 | 29 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.095 | 0.105 | 0.12 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002H.XLS | 6/4/15 6:25 PM | CASE 1* | 0.2220 | 0.0910 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.12 | 0.135 | 0.222 | 0.978 | ET |
| 2024 Al T-37 | lap splice | A6002HR.XLS | 6/4/15 6:27 PM | CASE 1* | 0.1300 | 0.0250 | 0.9050 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.12 | 0.13 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6002J.XLS | 6/4/15 6:28 PM | CASE 6 | | | | 0.8609 | 0.0200 | 0.1270 | 0.8120 | 27 | | | | | | | 0.2760 | 24 | 1.6240 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.145 | 0.175 | | | ET |
| 2024 Al T-37 | lap splice | A6003A.XLS | 6/4/15 6:30 PM | CASE 1* | 0.1054 | 0.0190 | 0.9001 | | | | 0.8117 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.085 | 0.095 | 0.1054 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6003B.XLS | 6/4/15 6:31 PM | CASE 1* | 0.1141 | 0.0190 | 0.9050 | | | | 0.8117 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.085 | 0.095 | 0.1141 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6003C.XLS | 6/4/15 6:32 PM | CASE 1* | 0.0936 | 0.0150 | 0.9001 | | | | 0.8117 | | 0.2762 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.065 | 0.08 | 0.10405 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6003D.XLS | 6/4/15 6:34 PM | CASE 1# | 0.1054 | 0.0190 | 0.9001 | | | | 0.8117 | | 0.2910 | | | | | | | | | | | | 0.1030 | 1 | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.1 | 0.1054 | 1.000 | ET |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2024 Al T-37 | lap splice | A6003E.XLS | 6/4/15 6:35 PM | CASE 1* | 0.1283 | 0.0360 | 0.9001 | | | | 0.8117 | | 0.3219 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.105 | 0.115 | 0.14525 | 0.978 | ET |
| 2024 Al T-37 | lap splice | A6003F.XLS | 6/4/15 6:37 PM | CASE 1* | 0.1054 | 0.0190 | 0.9001 | | | | 0.8117 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.08 | 0.09 | 0.1054 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6003G.XLS | 6/4/15 6:38 PM | CASE 2 | 0.2100 | 0.0580 | 0.9001 | | | | 0.8117 | 26 | 0.5109 | 29 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.19 | 0.225 | | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6003H.XLS | 6/4/15 6:39 PM | CASE 2 | 0.1308 | 0.0250 | 0.9001 | | | | 0.8117 | 26 | 0.3719 | 28 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.165 | | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6003J.XLS | 6/4/15 6:40 PM | CASE 1# | 0.0982 | 0.0160 | 0.9050 | | | | 0.8117 | | 0.2910 | | | | | | | | | | | | 0.0980 | 29 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.08 | 0.09 | 0.0982 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004A.XLS | 6/4/15 6:42 PM | CASE 1* | 0.0940 | 0.0140 | 0.9001 | | | | 0.8120 | | 0.2760 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.08 | 0.095 | 0.094 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004B.XLS | 6/4/15 6:43 PM | CASE 1# | 0.1140 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | 0.1070 | 3 | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.105 | 0.114 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004BR.XLS | 6/4/15 6:44 PM | CASE 1* | 0.1050 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.07 | 0.085 | 0.105 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004C.XLS | 6/4/15 6:46 PM | CASE 5 | | | | 0.6070 | 0.0010 | 0.1140 | 0.8120 | 27 | | | | | | | 0.1760 | 27 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.165 | | | ET |
| 2024 Al T-37 | lap splice | A6004CR.XLS | 6/4/15 6:48 PM | CASE 5 | | | | 0.6070 | 0.0010 | 0.0960 | 0.8120 | 27 | | | | | | | 0.1760 | 27 | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.13 | 0.145 | | | ET |
| 2024 Al T-37 | lap splice | A6004D.XLS | 6/4/15 6:49 PM | CASE 1# | 0.1050 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | 0.1040 | 3 | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.1 | 0.105 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004E.XLS | 6/4/15 6:50 PM | CASE 1# | 0.1310 | 0.0250 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1305 | 29 | | | | | | | | Warning: No false call analysis. | | 0.11 | 0.125 | 0.131 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004F.XLS | 6/4/15 6:52 PM | CASE 1* | 0.1050 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.065 | 0.075 | 0.105 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004FR.XLS | 6/4/15 6:53 PM | CASE 1# | 0.1050 | 0.0180 | 0.9001 | | | | 0.8120 | | 0.2910 | | | | | | | | | | | | 0.1020 | 2 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.07 | 0.08 | 0.105 | 1.000 | ET |
| 2024 Al T-37 | lap splice | A6004G.XLS | 6/4/15 6:54 PM | CASE 1* | 0.1890 | 0.0640 | 0.9011 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.15 | 0.185 | 0.189 | 0.979 | ET |
| 2024 Al T-37 | lap splice | A6004H.XLS | 6/4/15 6:56 PM | CASE 1* | 0.1890 | 0.0640 | 0.9011 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.135 | 0.165 | 0.189 | 0.979 | ET |
| 2024 Al T-37 | lap splice | A6004J.XLS | 6/4/15 6:57 PM | CASE 1# | 0.1760 | 0.0390 | 0.9001 | | | | 0.8120 | | 0.3720 | | | | | | | | | | | | 0.1710 | 3 | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.12 | 0.176 | 1.000 | ET |
| STEEL 4340 | plate | A7001AL.XLS | 6/4/15 6:58 PM | CASE 7 | | | | 0.5493 | 0.0040 | 0.0933 | | | | | | | | | | | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| STEEL 4340 | plate | A7001BL.XLS | 6/4/15 7:00 PM | CASE 7 | | | | 0.6070 | 0.0050 | 0.0933 | | | | | | | | | | | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| STEEL 4340 | plate | A7001CL.XLS | 6/4/15 7:03 PM | CASE 7 | | | | 0.5493 | 0.0040 | 0.0933 | | | | | | | | | | | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| STEEL 4340 | plate | A7003AL.XLS | 6/4/15 7:05 PM | CASE 7 | | | | 0.6356 | 0.0630 | 0.3500 | | | | | | | | | | | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| STEEL 4340 | plate | A7003BL.XLS | 6/4/15 7:07 PM | CASE 6 | | | | 0.5493 | 0.0010 | 0.1960 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| STEEL 4340 | plate | A7003CL.XLS | 6/4/15 7:09 PM | CASE 6 | | | | 0.6878 | 0.0520 | 0.2480 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| SS AMS 355 | hole | A8001L.XLS | 6/4/15 7:11 PM | CASE 1* | 0.0218 | 0.0050 | 0.9001 | | | | 0.3425 | | 0.1611 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.03 | 0.04404 | 1.000 | ET |
| SS AMS 355 | hole | A8002L.XLS | 6/4/15 7:12 PM | CASE 1# | 0.0147 | 0.0040 | 0.9129 | | | | 0.3425 | | 0.1611 | | | | | | | | | | | | 0.0145 | 29 | | | | | | | | Warning: No false call analysis. | | 0.01 | 0.015 | 0.01468 | 1.000 | ET |
| SS AMS 355 | hole | A8003L.XLS | 6/4/15 7:16 PM | CASE 1* | 0.0147 | 0.0040 | 0.9129 | | | | 0.3425 | | 0.1611 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.01 | 0.015 | 0.01468 | 1.000 | ET |
| SS AMS 355 | hole | A8004L.XLS | 6/4/15 7:22 PM | CASE 1# | 0.0587 | 0.0190 | 0.9050 | | | | 0.3425 | | 0.1694 | | | | | | | | | | | | 0.0581 | 29 | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.04 | 0.05873 | 1.000 | ET |
| SS AMS 355 | hole | A8005L.XLS | 6/4/15 7:23 PM | CASE 1# | 0.0575 | 0.0180 | 0.9104 | | | | 0.3425 | | 0.1694 | | | | | | | | | | | | 0.0567 | 29 | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.035 | 0.05753 | 1.000 | ET |
| SS AMS 355 | hole | A8006L.XLS | 6/4/15 7:24 PM | CASE 1# | 0.0587 | 0.0190 | 0.9050 | | | | 0.3425 | | 0.1694 | | | | | | | | | | | | 0.0581 | 29 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.04 | 0.045 | 0.05873 | 1.000 | ET |
| 2219 Al T-87 | stringer panel | A9001(3)D.xls | 6/4/15 7:26 PM | CASE 6 | | | | 0.7169 | 0.0020 | 0.0650 | 0.0950 | 26 | | | | | | | 0.0800 | 26 | 0.1900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.12 | | | | ET |
| 2219 Al T-87 | stringer panel | A9001(3)L.xls | 6/4/15 7:27 PM | CASE 6 | | | | 0.8444 | 0.0090 | 0.5690 | 0.6840 | 26 | | | | | | | 0.6840 | 26 | 1.3680 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87 | stringer panel | A9002(3)D.xls | 6/4/15 7:29 PM | CASE 6 | | | | 0.8444 | 0.0040 | 0.0650 | 0.0950 | 26 | | | | | | | 0.0950 | 26 | 0.1900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.055 | 0.065 | | | ET |
| 2219 Al T-87 | stringer panel | A9002(3)L.xls | 6/4/15 7:31 PM | CASE 7 | | | | 0.8827 | 0.0190 | 0.5790 | | | | | | | | | | | 1.3680 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.375 | 0.51 | | | ET |
| 2219 Al T-87 | stringer panel | A9003(3)D.xls | 6/4/15 7:32 PM | CASE 6 | | | | 0.7933 | 0.0020 | 0.0570 | 0.0950 | 26 | | | | | | | 0.0760 | 26 | 0.1900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.14 | | | ET |
| 2219 Al T-87 | stringer panel | A9003(3)L.xls | 6/4/15 7:34 PM | CASE 6 | | | | 0.7791 | 0.0020 | 0.1950 | 0.6840 | 26 | | | | | | | 0.6840 | 26 | 1.3680 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87/w2319 | weld LP | AA001(3)L.xls | 6/4/15 7:35 PM | CASE 6 | | | | 0.6070 | 0.0040 | 0.6860 | 1.2710 | 26 | | | | | | | 1.2710 | 26 | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87/w2319 | weld LP | AA002(3)L.xls | 6/4/15 7:37 PM | CASE 7 | | | | 0.7169 | 0.0080 | 0.9430 | | | | | | | | | | | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87/w2319 | weld LP | AA003(3)L.xls | 6/4/15 7:40 PM | CASE 2 | 0.9450 | 0.0560 | 0.9050 | | | | 1.2710 | 155 | 1.1560 | 8 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | 1.000 | | ET |
| 2219 Al T-87/w2319 | weld LFC | AB001(3)L.xls | 6/4/15 7:43 PM | CASE 7 | | | | 0.6070 | 0.0030 | 0.2870 | | | | | | | | | | | 2.3760 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87/w2319 | weld LFC | AB002(3)L.xls | 6/4/15 7:44 PM | CASE 6 | | | | 0.6070 | 0.0030 | 0.2870 | 1.1880 | 26 | | | | | | | 1.1880 | 26 | 2.3760 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87/w2319 | weld LFC | AB003(3)L.xls | 6/4/15 7:46 PM | CASE 7 | | | | 0.7209 | 0.0060 | 0.1000 | | | | | | | | | | | 2.3760 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | ET |
| 2219 Al T-87/w2319 | weld TFC | AC001(3)L.xls | 6/4/15 7:48 PM | CASE 7 | | | | 0.8477 | 0.5000 | 0.9850 | | | | | | | | | | | 2.8700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.445 | 0.67 | | | ET |
| 2219 Al T-87/w2319 | weld TFC | AC002(3)L.xls | 6/4/15 7:49 PM | CASE 6 | | | | 0.7169 | 0.0040 | 0.4820 | 1.4350 | 26 | | | | | | | 0.4980 | 23 | 2.8700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.465 | 0.74 | | | ET |
| 2219 Al T-87/w2319 | weld TFC | AC003(3)L.xls | 6/4/15 7:50 PM | CASE 6 | | | | 0.8666 | 0.2000 | 1.0760 | 1.4350 | 26 | | | | | | | 1.4350 | 26 | 2.8700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.75 | | | | ET |
| 2219 Al T-87/w2319 | weld flush LFC | AD001(3)L.xls | 6/4/15 7:52 PM | CASE 1* | 0.3480 | 0.0290 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.105 | 0.13 | 0.348 | 1.000 | ET |
| 2219 Al T-87/w2319 | weld flush LFC | AD002(3)L.xls | 6/4/15 7:58 PM | CASE 1* | 0.3480 | 0.0290 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.24 | 0.348 | 1.000 | ET |
| 2219 Al T-87/w2319 | weld flush LFC | AD003(3)L.xls | 6/4/15 8:06 PM | CASE 1# | 0.3480 | 0.0290 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | 0.1900 | 23 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.11 | 0.135 | 0.348 | 1.000 | ET |
| 2219 Al T-87/w2319 | weld flush TFC | AE001(3)L.xls | 6/4/15 8:10 PM | CASE 1# | 0.2350 | 0.0570 | 0.9050 | | | | 0.4950 | | 0.3080 | | | | | | | | | | | | 0.2240 | 8 | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.23 | 0.235 | 1.000 | ET |
| 2219 Al T-87/w2319 | weld flush TFC | AE002(3)L.xls | 6/4/15 8:11 PM | CASE 1# | 0.2670 | 0.0850 | 0.9050 | | | | 0.4950 | | 0.3810 | 29 | | | | | | | | | | | 0.2530 | 29 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.2 | 0.23 | 0.267 | 1.000 | ET |
| 2219 Al T-87/w2319 | weld flush TFC | AE003(3)L.xls | 6/4/15 8:11 PM | CASE 1# | 0.2350 | 0.0570 | 0.9050 | | | | 0.4950 | | 0.3080 | | | | | | | | | | | | 0.1380 | 26 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | | 0.235 | 1.000 | ET |
| STEEL 4340 | plate | B1001AD.XLS | 6/4/15 8:12 PM | CASE 6 | | | | 0.8666 | 0.0090 | 0.0620 | 0.2100 | 28 | | | | | | | 0.2100 | 28 | 0.4200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | MT |
| STEEL 4340 | plate | B1001AL.XLS | 6/4/15 8:14 PM | CASE 6 | | | | 0.8855 | 0.0540 | 0.2340 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.695 | | | | MT |
| STEEL 4340 | plate | B1001BD.XLS | 6/4/15 8:15 PM | CASE 6 | | | | 0.8742 | 0.0380 | 0.0620 | 0.2100 | 28 | | | | | | | 0.2100 | 28 | 0.4200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | MT |
| STEEL 4340 | plate | B1001BL.XLS | 6/4/15 8:17 PM | CASE 6 | | | | 0.8719 | 0.0520 | 0.2340 | 2.4030 | 28 | | | | | | | 1.2270 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.4 | | | | MT |
| STEEL 4340 | plate | B1001CD.XLS | 6/4/15 8:19 PM | CASE 2 | 0.0600 | 0.0330 | 0.9001 | | | | 0.2100 | 23 | 0.1173 | 14 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | | 0.978 | MT |
| STEEL 4340 | plate | B1001CL.XLS | 6/4/15 8:19 PM | CASE 2 | 0.2340 | 0.0630 | 0.9001 | | | | 2.4030 | 24 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.37 | | | 1.000 | MT |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| STEEL 4340 | plate | B1003AD.XLS | 6/4/15 8:20 PM | CASE 6 | | | | 0.8514 | 0.0060 | 0.0603 | 0.2100 | 28 | | | | | | | 0.1563 | 26 | 0.4200 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | MT |
| STEEL 4340 | plate | B1003AL.XLS | 6/4/15 8:22 PM | CASE 2 | 0.2340 | 0.0590 | 0.9001 | | | | 2.4030 | 24 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.26 | 0.465 | | 1.000 | MT |
| STEEL 4340 | plate | B1003BD.XLS | 6/4/15 8:23 PM | CASE 6 | | | | 0.8813 | 0.0120 | 0.0663 | 0.2100 | 28 | | | | | | | 0.2100 | 28 | 0.4200 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | MT |
| STEEL 4340 | plate | B1003BL.XLS | 6/4/15 8:25 PM | CASE 2 | 0.2340 | 0.0590 | 0.9001 | | | | 2.4030 | 27 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.11 | 0.135 | | 1.000 | MT |
| STEEL 4340 | plate | B1003CD.XLS | 6/4/15 8:26 PM | CASE 6 | | | | 0.8813 | 0.0120 | 0.0663 | 0.2100 | 28 | | | | | | | 0.1563 | 23 | 0.4200 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.045 | | | | MT |
| STEEL 4340 | plate | B1003CL.XLS | 6/4/15 8:27 PM | CASE 1* | 0.2340 | 0.0590 | 0.9001 | | | | 2.4030 | | 1.6030 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.12 | 0.235 | 0.234 | 1.000 | MT |
| SS AMS 355 | hole | B2001.XLS | 6/4/15 8:29 PM | CASE 6 | | | | 0.8190 | 0.0750 | 0.1752 | 0.2575 | 24 | | | | | | | 0.2575 | 24 | 0.5150 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.115 | 0.175 | | | MT |
| SS AMS 355 | hole | B2002.XLS | 6/4/15 8:30 PM | CASE 1# | 0.1031 | 0.0540 | 0.9001 | | | | 0.2575 | | 0.1929 | | | | | | | | | | | | 0.1004 | 2 | | | | | | | Warning: No false call analysis. | | 0.04 | 0.065 | 0.10314 | 1.000 | MT |
| SS AMS 355 | hole | B2003.XLS | 6/4/15 8:31 PM | CASE 5 | | | | 0.3684 | 0.0010 | 0.0512 | 0.2575 | 28 | | | | | | | 0.0634 | 27 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.045 | 0.07 | | | MT |
| SS AMS 355 | hole | B30011.XLS | 6/4/15 8:32 PM | CASE 7 | | | | 0.8813 | 0.0190 | 0.0866 | | | | | | | | | | | 0.1803 | 29 | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.24 | | | | MT |
| SS AMS 355 | hole | B30012.XLS | 6/4/15 8:34 PM | CASE 4 | | | | 0.8855 | 0.0230 | 0.0902 | 0.0902 | 4 | | | | | 0.0902 | 4 | 0.0902 | | 0.1803 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.095 | | | MT |
| SS AMS 355 | hole | B40011.XLS | 6/4/15 8:36 PM | CASE 5 | | | | 0.4729 | 0.0010 | 0.0623 | 0.3425 | 28 | | | | | | | 0.0821 | 26 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.175 | 0.26 | | | MT |
| 2219 Al T-87 | plate | C1001AL.XLS | 6/4/15 8:38 PM | CASE 7 | | | | 0.8609 | 0.0200 | 0.2610 | | | | | | | | | | | 1.9580 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.395 | 0.63 | | | PT |
| 2219 Al T-87 | plate | C1001BL.XLS | 6/4/15 8:40 PM | CASE 6 | | | | 0.8368 | 0.0850 | 0.3260 | 0.9790 | 28 | | | | | | | 0.6100 | 22 | 1.9580 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.44 | 0.695 | | | PT |
| 2219 Al T-87 | plate | C1001CL.XLS | 6/4/15 8:42 PM | CASE 1# | 0.5390 | 0.2000 | 0.9174 | | | | 0.9790 | | 0.7100 | | | | | | | | | | | | 0.5370 | 29 | | | | | | | Warning: No false call analysis. | | 0.315 | 0.61 | 0.539 | 1.000 | PT |
| 2219 Al T-87 | plate | C1002AL.XLS | 6/4/15 8:45 PM | CASE 1* | 0.2900 | 0.0490 | 0.9001 | | | | 0.9790 | | 0.5430 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.115 | 0.29 | 1.000 | PT |
| 2219 Al T-87 | plate | C1002BL.XLS | 6/4/15 8:47 PM | CASE 1* | 0.1080 | 0.0310 | 0.9001 | | | | 0.9790 | | 0.3420 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.08 | 0.105 | 0.261 | 0.967 | PT |
| 2219 Al T-87 | plate | C1002CL.XLS | 6/4/15 8:49 PM | CASE 1* | 0.2980 | 0.0510 | 0.9001 | | | | 0.9790 | | 0.5430 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.11 | 0.145 | 0.508 | 1.000 | PT |
| 2219 Al T-87 | plate | C1003AL.XLS | 6/4/15 8:51 PM | CASE 1* | 0.0830 | 0.0080 | 0.9001 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.02 | 0.035 | 0.086 | 1.000 | PT |
| 2219 Al T-87 | plate | C1003BL.XLS | 6/4/15 8:56 PM | CASE 2 | 0.1020 | 0.0170 | 0.9001 | | | | 0.6100 | | 0.2620 | 10 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.08 | 0.095 | 0.279 | 1.000 | PT |
| 2219 Al T-87 | plate | C1003CL.XLS | 6/4/15 8:57 PM | CASE 1* | 0.0800 | 0.0130 | 0.9001 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.06 | 0.07 | 0.086 | 0.978 | PT |
| 2219 Al T-87 | plate | C2002AL.XLS | 6/4/15 9:01 PM | CASE 7 | | | | 0.7066 | 0.0520 | 0.5300 | | | | | | | | | | | 1.1000 | 29 | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| 2219 Al T-87 | plate | C2002BL.XLS | 6/4/15 9:02 PM | CASE 1# | 0.5340 | 0.0600 | 0.9001 | | | | 0.5500 | | 0.5380 | | | | | | | | | | | | 0.2880 | 28 | | | | | | | Warning: No false call analysis. | | 0.095 | 0.17 | 0.534 | 1.000 | PT |
| 2219 Al T-87 | plate | C2002CL.XLS | 6/4/15 9:03 PM | CASE 2 | 0.4740 | 0.2000 | 0.9001 | | | | 0.5500 | 0 | 0.4960 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.22 | 0.385 | | 1.000 | PT |
| Ti 6Al4V | plate | C3001AL.XLS | 6/4/15 9:04 PM | CASE 6 | | | | 0.7942 | 0.0180 | 0.1940 | 0.4070 | 28 | | | | | | | 0.3000 | 27 | 0.8140 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.705 | | | | PT |
| Ti 6Al4V | plate | C3001BL.XLS | 6/4/15 9:06 PM | CASE 2 | 0.1950 | 0.0540 | 0.9001 | | | | 0.4070 | | 0.3000 | 17 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.12 | 0.175 | 0.32 | 1.000 | PT |
| Ti 6Al4V | plate | C3001CL.XLS | 6/4/15 9:07 PM | CASE 4 | | | | 0.8768 | 0.0850 | 0.3250 | 0.4070 | 23 | | | | | 0.3250 | 6 | 0.3240 | 7 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.325 | | | PT |
| Ti 6Al4V | plate | C3002AL.XLS | 6/4/15 9:08 PM | CASE 6 | | | | 0.8868 | 0.0960 | 0.2120 | 0.4070 | 18 | | | | | | | 0.3450 | 10 | 0.8140 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.13 | 0.32 | | | PT |
| Ti 6Al4V | plate | C3002BL.XLS | 6/4/15 9:10 PM | CASE 2 | 0.1900 | 0.0530 | 0.9001 | | | | 0.4070 | | 0.3000 | 17 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.12 | 0.165 | 0.315 | 1.000 | PT |
| Ti 6Al4V | plate | C3002CL.XLS | 6/4/15 9:11 PM | CASE 1# | 0.2160 | 0.0340 | 0.9001 | | | | 0.4070 | | 0.2650 | | | | | | | | | | | | 0.1300 | 15 | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.08 | 0.1 | 0.216 | 1.000 | PT |
| Ti 6Al4V | plate | C3003AL.XLS | 6/4/15 9:12 PM | CASE 7 | | | | 0.8965 | 0.1000 | 0.3250 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.465 | | | PT |
| Ti 6Al4V | plate | C3003BL.XLS | 6/4/15 9:13 PM | CASE 2 | 0.2620 | 0.0520 | 0.9050 | | | | 0.4070 | 58 | 0.3000 | 18 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.155 | 0.295 | | 1.000 | PT |
| Ti 6Al4V | plate | C3003CL.XLS | 6/4/15 9:14 PM | CASE 2 | 0.2620 | 0.0520 | 0.9050 | | | | 0.4070 | 58 | 0.3000 | 18 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.155 | 0.305 | | 1.000 | PT |
| SS AMS 355 | hole | C400011.XLS | 6/4/15 9:15 PM | CASE 6 | | | | 0.8074 | 0.0730 | 0.1752 | 0.2575 | 24 | | | | | | | 0.2575 | 24 | 0.5150 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.13 | 0.195 | | | PT |
| SS AMS 355 | hole | C400012.XLS | 6/4/15 9:16 PM | CASE 5 | | | | 0.5493 | 0.0070 | 0.0776 | 0.2575 | 28 | | | | | | | 0.0858 | 27 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.085 | 0.12 | | | PT |
| SS AMS 355 | hole | C400013.XLS | 6/4/15 9:18 PM | CASE 5 | | | | 0.5493 | 0.0070 | 0.0669 | 0.2575 | 28 | | | | | | | 0.0858 | 27 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.1 | 0.185 | | | PT |
| SS AMS 355 | hole | C400014.XLS | 6/4/15 9:19 PM | CASE 4 | | | | 0.8368 | 0.0900 | 0.1929 | 0.2575 | 19 | | | | | 0.1929 | 12 | 0.1929 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.135 | 0.225 | | | PT |
| SS AMS 355 | hole | C500011.XLS | 6/4/15 9:20 PM | CASE 4 | | | | 0.8855 | 0.0230 | 0.0902 | 0.0902 | 4 | | | | | 0.0902 | 4 | 0.0902 | | 0.1803 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.085 | 0.11 | | | PT |
| SS AMS 355 | hole | C500012.XLS | 6/4/15 9:22 PM | CASE 4 | | | | 0.8855 | 0.0230 | 0.0902 | 0.0902 | 4 | | | | | 0.0902 | 4 | 0.0902 | | 0.1803 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.085 | 0.105 | | | PT |
| SS AMS 355 | hole | C500014.XLS | 6/4/15 9:24 PM | CASE 4 | | | | 0.8855 | 0.0230 | 0.0902 | 0.0902 | 4 | | | | | 0.0902 | 4 | 0.0902 | | 0.1803 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.12 | | | PT |
| SS AMS 355 | hole | C500016.XLS | 6/4/15 9:26 PM | CASE 7 | | | | 0.2713 | 0.0150 | 0.0606 | | | | | | | | | | | 0.1315 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | | | | PT |
| STEEL 4340 | plate | C6001AL.XLS | 6/4/15 9:27 PM | CASE 6 | | | | 0.7942 | 0.0100 | 0.1153 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| STEEL 4340 | plate | C6001BL.XLS | 6/4/15 9:30 PM | CASE 6 | | | | 0.7942 | 0.0100 | 0.1153 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| STEEL 4340 | plate | C6001CL.XLS | 6/4/15 9:32 PM | CASE 6 | | | | 0.7942 | 0.0100 | 0.1153 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| STEEL 4340 | plate | C6002AL.XLS | 6/4/15 9:33 PM | CASE 2 | 0.2500 | 0.0700 | 0.9001 | | | | 2.4030 | 26 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.1 | | | 1.000 | PT |
| STEEL 4340 | plate | C6002BL.XLS | 6/4/15 9:35 PM | CASE 1* | 0.0960 | 0.0400 | 0.9001 | | | | 2.4030 | | 1.6030 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.06 | 0.08 | 0.18 | 1.000 | PT |
| STEEL 4340 | plate | C6002CL.XLS | 6/4/15 9:36 PM | CASE 1# | 0.2370 | 0.0620 | 0.9050 | | | | 2.4030 | | 1.6030 | | | | | | | | | | | | 0.1940 | 11 | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.085 | 0.105 | 0.237 | 1.000 | PT |
| STEEL 4340 | plate | C6003AL.XLS | 6/4/15 9:37 PM | CASE 2 | 0.2480 | 0.0680 | 0.9001 | | | | 2.4030 | 27 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.265 | 0.6 | | 1.000 | PT |
| STEEL 4340 | plate | C6003BL.XLS | 6/4/15 9:38 PM | CASE 2 | 0.2480 | 0.0680 | 0.9001 | | | | 2.4030 | 24 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.155 | 0.255 | | 1.000 | PT |
| STEEL 4340 | plate | C6003CL.XLS | 6/4/15 9:40 PM | CASE 1* | 0.2340 | 0.0590 | 0.9001 | | | | 2.4030 | | 1.6030 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.11 | 0.175 | 0.234 | 1.000 | PT |
| STEEL 4340 | hole | C7001L.XLS | 6/4/15 9:41 PM | CASE 5 | | | | 0.5493 | 0.0040 | 0.0738 | 0.3425 | 28 | | | | | | | 0.0881 | 28 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.215 | 0.36 | | | PT |
| STEEL 4340 | hole | C7002L.XLS | 6/4/15 9:43 PM | CASE 4 | | | | 0.8444 | 0.0970 | 0.2131 | 0.3425 | 27 | | | | | 0.2131 | 11 | 0.1992 | 13 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.35 | 0.58 | | | PT |
| STEEL 4340 | hole | C7003L.XLS | 6/4/15 9:45 PM | CASE 4 | | | | 0.7791 | 0.0930 | 0.2512 | 0.3425 | 27 | | | | | 0.2512 | 17 | 0.2512 | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.3 | 0.505 | | | PT |
| 2219 Al T-87 | stringer panel | C8001(3)D.xls | 6/4/15 9:47 PM | CASE 2 | 0.0530 | 0.0020 | 0.9050 | | | | 0.0950 | 17 | 0.0800 | 26 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.12 | | 1.000 | PT |
| 2219 Al T-87 | stringer panel | C8001(3)L.xls | 6/4/15 9:49 PM | CASE 2 | 0.2760 | 0.0050 | 0.9050 | | | | 0.6840 | 23 | 0.5790 | 17 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.445 | | | 1.000 | PT |
| 2219 Al T-87 | stringer panel | C8002(3)D.xls | 6/4/15 9:50 PM | CASE 7 | | | | 0.8739 | 0.0030 | 0.0430 | | | | | | | | | | | 0.1900 | 29 | | | | | | | | | | | Warning: No false call analysis. | | 0.08 | | | | PT |
| 2219 Al T-87 | stringer panel | C8002(3)L.xls | 6/4/15 9:51 PM | CASE 2 | 0.2620 | 0.0680 | 0.9050 | | | | 0.6840 | 26 | 0.4760 | 23 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.395 | | | 1.000 | PT |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2219 Al T-87 | stringer panel | C8003(3)D.xls | 6/4/15 9:53 PM | CASE 1# | 0.0680 | 0.0090 | 0.9050 | | | | 0.0950 | | 0.0760 | | | | | | | | | | | | 0.0665 | 29 | | | | | | | | Warning: No false call analysis. | | 0.095 | | 0.068 | 1.000 | PT |
| 2219 Al T-87 | stringer panel | C8003(3)L.xls | 6/4/15 9:54 PM | CASE 1# | 0.5790 | 0.0130 | 0.9050 | | | | 0.6840 | | 0.6120 | | | | | | | | | | | | 0.2910 | 20 | | | | | | | | Warning: No false call analysis. | | 0.405 | 0.665 | 0.579 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld LOP | C9001(3)L.xls | 6/4/15 9:56 PM | CASE 7 | | | | 0.8813 | 0.0180 | 0.6900 | | | | | | | | | | | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| 2219 Al T-87/w2319 | weld LOP | C9002(3)L.xls | 6/4/15 9:57 PM | CASE 7 | | | | 0.6070 | 0.0040 | 0.3450 | | | | | | | | | | | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| 2219 Al T-87/w2319 | weld LOP | C9003(3)L.xls | 6/4/15 10:00 PM | CASE 7 | | | | 0.6070 | 0.0040 | 0.3450 | | | | | | | | | | | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| 2219 Al T-87/w2319 | weld LOP | C9004(3)L.xls | 6/4/15 10:03 PM | CASE 6 | | | | 0.8931 | 0.0260 | 0.7080 | 1.2710 | 23 | | | | | | | 1.2100 | 23 | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.005 | | | | PT |
| 2219 Al T-87/w2319 | weld LFC | CA001(3)L.xls | 6/4/15 10:04 PM | CASE 2 | 0.1200 | 0.0210 | 0.9050 | | | | 1.1880 | 43 | 0.4930 | 23 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | | 1.000 | PT |
| 2219 Al T-87/w2319 | weld LFC | CA002(3)L.xls | 6/4/15 10:05 PM | CASE 6 | | | | 0.7206 | 0.0060 | 0.1000 | 1.1880 | 26 | | | | | | | 1.1880 | 26 | 2.3760 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| 2219 Al T-87/w2319 | weld LFC | CA003(3)L.xls | 6/4/15 10:06 PM | CASE 1* | 0.3240 | 0.0670 | 0.9050 | | | | 1.1880 | | 0.5400 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.26 | 0.6 | 0.324 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld TFC | CB001(3)L.xls | 6/4/15 10:07 PM | CASE 1* | 0.1040 | 0.0430 | 0.9050 | | | | 1.4350 | | 0.5190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.055 | 0.09 | 0.478 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld TFC | CB002(3)L.xls | 6/4/15 10:08 PM | CASE 1# | 0.3060 | 0.0330 | 0.9050 | | | | 1.4350 | | 0.9920 | | | | | | | | | | | | 0.2950 | 2 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.15 | 0.195 | 0.308 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld TFC | CB003(3)L.xls | 6/4/15 10:09 PM | CASE 1* | 0.3060 | 0.0330 | 0.9050 | | | | 1.4350 | | 0.9920 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.21 | 0.345 | 0.498 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld flush LFC | CC001(3)L.xls | 6/4/15 10:10 PM | CASE 2 | 0.0830 | 0.0230 | 0.9050 | | | | 1.5620 | 26 | 0.6160 | 20 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | 0.075 | | 1.000 | PT |
| 2219 Al T-87/w2319 | weld flush LFC | CC002(3)L.xls | 6/4/15 10:19 PM | CASE 1* | 0.0830 | 0.0230 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.05 | 0.07 | 0.191 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld flush LFC | CC003(3)L.xls | 6/4/15 10:24 PM | CASE 1* | 0.0830 | 0.0230 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.04 | 0.065 | 0.191 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld flush TFC | CD001(3)L.xls | 6/4/15 10:28 PM | CASE 1# | 0.2350 | 0.0570 | 0.9050 | | | | 0.4950 | | 0.3080 | | | | | | | | | | | | 0.1380 | 26 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | | 0.235 | 1.000 | PT |
| 2219 Al T-87/w2319 | weld flush TFC | CD002(3)L.xls | 6/4/15 10:29 PM | CASE 4 | | | | 0.8813 | 0.0840 | 0.3080 | 0.4950 | 26 | | | | | | 0.3080 | 5 | 0.2970 | 8 | | | | | | | | | | | | Warning: No false call analysis. | | 0.205 | 0.725 | | | PT |
| 2219 Al T-87/w2319 | weld flush TFC | CD003(3)L.xls | 6/4/15 10:30 PM | CASE 4 | | | | 0.8666 | 0.0830 | 0.3080 | 0.4950 | 26 | | | | | | 0.3080 | 8 | 0.3080 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.22 | 0.31 | | | PT |
| HAYNES 188 AMS 5 | plate | CE011(6)D.xls | 6/4/15 10:31 PM | CASE 2 | 0.0240 | 0.0060 | 0.9001 | | | | 0.0690 | 43 | 0.0490 | 14 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.04 | | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE011(6)L.xls | 6/4/15 10:32 PM | CASE 2 | 0.1300 | 0.0190 | 0.9001 | | | | 0.3500 | 44 | 0.2280 | 16 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.115 | 0.155 | | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE012(6)D.xls | 6/4/15 10:33 PM | CASE 1+ | 0.0100 | 0.0020 | 0.9129 | | | | 0.0690 | | 0.0280 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | 0.01 | 0.01 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE012(6)L.xls | 6/4/15 10:41 PM | CASE 1* | 0.0480 | 0.0100 | 0.9001 | | | | 0.3500 | | 0.1370 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.04 | 0.107 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE021(6)D.xls | 6/4/15 10:46 PM | CASE 7 | | | | 0.3653 | 0.0510 | 0.0670 | | | | | | | | | | | 0.1380 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE021(6)L.xls | 6/4/15 10:47 PM | CASE 7 | | | | 0.3684 | 0.0010 | 0.1210 | | | | | | | | | | | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE022(6)D.xls | 6/4/15 10:48 PM | CASE 1* | 0.0220 | 0.0050 | 0.9050 | | | | 0.0690 | | 0.0350 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.015 | 0.015 | 0.022 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE022(6)L.xls | 6/4/15 10:51 PM | CASE 1* | 0.1410 | 0.0110 | 0.9050 | | | | 0.3500 | | 0.2500 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.065 | 0.075 | 0.141 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE031(6)D.xls | 6/4/15 10:55 PM | CASE 7 | | | | 0.5343 | 0.0070 | 0.0410 | | | | | | | | | | | 0.1380 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE031(6)L.xls | 6/4/15 10:56 PM | CASE 7 | | | | 0.6070 | 0.0180 | 0.1700 | | | | | | | | | | | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE032(6)D.xls | 6/4/15 10:58 PM | CASE 2 | 0.0550 | 0.0100 | 0.9050 | | | | 0.0690 | | 0.0620 | 29 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.035 | 0.065 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE032(6)L.xls | 6/4/15 10:59 PM | CASE 1# | 0.2600 | 0.0260 | 0.9001 | | | | 0.3500 | | 0.2850 | | | | | | | | | | | | 0.2580 | 29 | | | | | | | | Warning: No false call analysis. | | 0.12 | 0.15 | 0.26 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE041(6)D.xls | 6/4/15 11:00 PM | CASE 7 | | | | 0.4729 | 0.0020 | 0.0410 | | | | | | | | | | | 0.1380 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE041(6)L.xls | 6/4/15 11:01 PM | CASE 7 | | | | 0.5293 | 0.0200 | 0.1850 | | | | | | | | | | | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE042(6)D.xls | 6/4/15 11:04 PM | CASE 1* | 0.0540 | 0.0130 | 0.9050 | | | | 0.0690 | | 0.0590 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.04 | 0.045 | 0.059 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE042(6)L.xls | 6/4/15 11:05 PM | CASE 1* | 0.2620 | 0.0420 | 0.9001 | | | | 0.3500 | | 0.3010 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.225 | 0.262 | 0.978 | PT |
| HAYNES 188 AMS 5 | plate | CE051(6)D.xls | 6/4/15 11:06 PM | CASE 7 | | | | 0.8421 | 0.0350 | 0.0640 | | | | | | | | | | | 0.1380 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.065 | 0.115 | | | PT |
| HAYNES 188 AMS 5 | plate | CE051(6)L.xls | 6/4/15 11:07 PM | CASE 6 | | | | 0.8768 | 0.0090 | 0.1410 | 0.3500 | 27 | | | | | | | 0.2680 | 22 | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.315 | 0.575 | | | PT |
| HAYNES 188 AMS 5 | plate | CE052(6)D.xls | 6/4/15 11:09 PM | CASE 1+ | 0.0170 | 0.0020 | 0.9050 | | | | 0.0690 | | 0.0550 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.015 | 0.02 | 0.017 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE052(6)L.xls | 6/4/15 11:12 PM | CASE 1* | 0.2460 | 0.0190 | 0.9001 | | | | 0.3500 | | 0.2830 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.07 | 0.085 | 0.246 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE061(6)D.xls | 6/4/15 11:14 PM | CASE 2 | 0.0630 | 0.0090 | 0.9104 | | | | 0.0690 | 33 | 0.0660 | 29 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.04 | 0.055 | | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE061(6)L.xls | 6/4/15 11:15 PM | CASE 7 | | | | 0.8829 | 0.0940 | 0.2460 | | | | | | | | | | | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.265 | | | PT |
| HAYNES 188 AMS 5 | plate | CE062(6)D.xls | 6/4/15 11:17 PM | CASE 1* | 0.0180 | 0.0020 | 0.9001 | | | | 0.0690 | | 0.0550 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.015 | 0.02 | 0.018 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE062(6)L.xls | 6/4/15 11:20 PM | CASE 1* | 0.0980 | 0.0180 | 0.9001 | | | | 0.3500 | | 0.2560 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.07 | 0.09 | 0.105 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE071(6)D.xls | 6/4/15 11:24 PM | CASE 7 | | | | 0.8368 | 0.0050 | 0.0610 | | | | | | | | | | | 0.1380 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.07 | 0.105 | | | PT |
| HAYNES 188 AMS 5 | plate | CE071(6)L.xls | 6/4/15 11:25 PM | CASE 6 | | | | 0.7791 | 0.0060 | 0.2480 | 0.3500 | 27 | | | | | | | 0.3470 | 28 | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.31 | 0.455 | | | PT |
| HAYNES 188 AMS 5 | plate | CE072(6)D.xls | 6/4/15 11:27 PM | CASE 1* | 0.0220 | 0.0050 | 0.9050 | | | | 0.0690 | | 0.0350 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.015 | 0.02 | 0.022 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE072(6)L.xls | 6/4/15 11:29 PM | CASE 1* | 0.1410 | 0.0110 | 0.9050 | | | | 0.3500 | | 0.2500 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.09 | 0.141 | 1.000 | PT |
| HAYNES 188 AMS 5 | plate | CE081(6)D.xls | 6/4/15 11:32 PM | CASE 7 | | | | 0.2713 | 0.0010 | 0.0580 | | | | | | | | | | | 0.1380 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| HAYNES 188 AMS 5 | plate | CE081(6)L.xls | 6/4/15 11:33 PM | CASE 7 | | | | 0.2486 | 0.0020 | 0.2450 | | | | | | | | | | | 0.7000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | PT |
| 2219 Al T-87 | plate | D1001AD.XLS | 6/4/15 11:36 PM | CASE 1* | 0.0380 | 0.0040 | 0.9050 | | | | 0.1780 | | 0.1110 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.035 | 0.038 | 1.000 | UT |
| 2219 Al T-87 | plate | D1001AL.XLS | 6/4/15 11:38 PM | CASE 1* | 0.1530 | 0.0360 | 0.9001 | | | | 0.9790 | | 0.5230 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.105 | 0.279 | 1.000 | UT |
| 2219 Al T-87 | plate | D1001BD.XLS | 6/4/15 11:40 PM | CASE 1* | 0.0460 | 0.0090 | 0.9050 | | | | 0.1780 | | 0.1190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.035 | 0.046 | 1.000 | UT |
| 2219 Al T-87 | plate | D1001BL.XLS | 6/4/15 11:42 PM | CASE 1* | 0.1310 | 0.0330 | 0.9001 | | | | 0.9790 | | 0.3450 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.115 | 0.279 | 1.000 | UT |
| 2219 Al T-87 | plate | D1001CD.XLS | 6/4/15 11:44 PM | CASE 1# | 0.0380 | 0.0040 | 0.9050 | | | | 0.1780 | | 0.1110 | | | | | | | | | | | | 0.0375 | 29 | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.03 | 0.038 | 1.000 | UT |
| 2219 Al T-87 | plate | D1001CL.XLS | 6/4/15 11:45 PM | CASE 1# | 0.1530 | 0.0360 | 0.9001 | | | | 0.9790 | | 0.5230 | | | | | | | | | | | | 0.1520 | 29 | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.105 | 0.153 | 1.000 | UT |
| 2219 Al T-87 | plate | D1002AD.XLS | 6/4/15 11:48 PM | CASE 6 | | | | 0.8673 | 0.0080 | 0.0440 | 0.1780 | 28 | | | | | | | 0.1490 | 28 | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.06 | 0.11 | | | UT |
| 2219 Al T-87 | plate | D1002AL.XLS | 6/4/15 11:49 PM | CASE 1* | 0.2900 | 0.0490 | 0.9001 | | | | 0.9790 | | 0.4890 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.17 | 0.265 | 0.29 | 1.000 | UT |
| 2219 Al T-87 | plate | D1002BD.XLS | 6/4/15 11:51 PM | CASE 2 | 0.0430 | 0.0070 | 0.9001 | | | | 0.1780 | 27 | 0.1150 | 11 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.02 | 0.055 | | 1.000 | UT |
| 2219 Al T-87 | plate | D1002BL.XLS | 6/4/15 11:52 PM | CASE 2 | 0.2900 | 0.0490 | 0.9001 | | | | 0.9790 | 27 | 0.4890 | 24 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.125 | 0.295 | | 1.000 | UT |
| 2219 Al T-87 | plate | D1002CD.XLS | 6/4/15 11:54 PM | CASE 1* | 0.0570 | 0.0110 | 0.9050 | | | | 0.1780 | | 0.1170 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.04 | 0.105 | 1.000 | UT |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2219 Al T-87 | plate | D1002CL.XLS | 6/4/15 11:55 PM | CASE 1* | 0.3290 | 0.0820 | 0.9001 | | | | 0.9790 | | 0.5430 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.125 | 0.329 | 0.978 | UT |
| 2219 Al T-87 | plate | D1003AD.XLS | 6/4/15 11:57 PM | CASE 1# | 0.0380 | 0.0040 | 0.9050 | | | | 0.1780 | | 0.1110 | | | | | | | | | | | | 0.0375 | 29 | | | | | | | | Warning: No false call analysis. | | 0.015 | 0.02 | 0.038 | 1.000 | UT |
| 2219 Al T-87 | plate | D1003AL.XLS | 6/4/15 11:59 PM | CASE 1# | 0.1020 | 0.0170 | 0.9001 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | 0.1015 | 29 | | | | | | | | Warning: No false call analysis. | | 0.055 | 0.07 | 0.102 | 1.000 | UT |
| 2219 Al T-87 | plate | D1003BD.XLS | 6/5/15 12:02 AM | CASE 1* | 0.0350 | 0.0030 | 0.9077 | | | | 0.1780 | | 0.1100 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.02 | 0.025 | 0.035 | 1.000 | UT |
| 2219 Al T-87 | plate | D1003BL.XLS | 6/5/15 12:05 AM | CASE 1* | 0.0830 | 0.0080 | 0.9001 | | | | 0.6100 | | 0.2620 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.035 | 0.045 | 0.083 | 1.000 | UT |
| 2219 Al T-87 | plate | D1003CD.XLS | 6/5/15 12:10 AM | CASE 2 | 0.0460 | 0.0130 | 0.9001 | | | | 0.1780 | 27 | 0.1100 | 13 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.035 | 0.05 | | 0.967 | UT |
| 2219 Al T-87 | plate | D1003CL.XLS | 6/5/15 12:12 AM | CASE 2 | 0.2900 | 0.0490 | 0.9001 | | | | 0.6100 | 18 | 0.3800 | 17 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.095 | 0.14 | | 1.000 | UT |
| 2219 Al T-87 | plate | D2002AD.XLS | 6/5/15 12:13 AM | CASE 1* | 0.0360 | 0.0150 | 0.9077 | | | | 0.1440 | | 0.1150 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.04 | 0.094 | 1.000 | UT |
| 2219 Al T-87 | plate | D2002AL.XLS | 6/5/15 12:14 AM | CASE 1# | 0.5340 | 0.0600 | 0.9001 | | | | 0.5500 | | 0.5380 | | | | | | | | | | | | 0.2880 | 28 | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.18 | 0.534 | 1.000 | UT |
| 2219 Al T-87 | plate | D2002BD.XLS | 6/5/15 12:15 AM | CASE 1* | 0.0360 | 0.0150 | 0.9077 | | | | 0.1440 | | 0.1150 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.045 | 0.094 | 1.000 | UT |
| 2219 Al T-87 | plate | D2002BL.XLS | 6/5/15 12:15 AM | CASE 1# | 0.5340 | 0.0600 | 0.9001 | | | | 0.5500 | | 0.5380 | | | | | | | | | | | | 0.2880 | 28 | | | | | | | | Warning: No false call analysis. | | 0.11 | 0.19 | 0.534 | 1.000 | UT |
| 2219 Al T-87 | plate | D2002CD.XLS | 6/5/15 12:16 AM | CASE 1* | 0.0360 | 0.0150 | 0.9077 | | | | 0.1440 | | 0.1150 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.02 | 0.03 | 0.046 | 1.000 | UT |
| 2219 Al T-87 | plate | D2002CL.XLS | 6/5/15 12:17 AM | CASE 1# | 0.5340 | 0.0600 | 0.9001 | | | | 0.5500 | | 0.5380 | | | | | | | | | | | | 0.4260 | 23 | | | | | | | | Warning: No false call analysis. | | 0.085 | 0.145 | 0.534 | 1.000 | UT |
| Ti 6Al4V | plate | D3001AL.XLS | 6/5/15 12:18 AM | CASE 1* | 0.2150 | 0.0350 | 0.9001 | | | | 0.4070 | | 0.2650 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.245 | 0.255 | 1.000 | UT |
| Ti 6Al4V | plate | D3001BL.XLS | 6/5/15 12:19 AM | CASE 1# | 0.3000 | 0.0880 | 0.9001 | | | | 0.4070 | | 0.3450 | | | | | | | | | | | | 0.2875 | 29 | | | | | | | | Warning: No false call analysis. | | 0.235 | 0.345 | 0.3 | 1.000 | UT |
| Ti 6Al4V | plate | D3001CL.XLS | 6/5/15 12:20 AM | CASE 1# | 0.2500 | 0.0450 | 0.9001 | | | | 0.4070 | | 0.3550 | | | | | | | | | | | | 0.2485 | 29 | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.18 | 0.25 | 1.000 | UT |
| Ti 6Al4V | plate | D3003AL.XLS | 6/5/15 12:21 AM | CASE 7 | | | | 0.8444 | 0.0250 | 0.2350 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.265 | 0.555 | | | UT |
| Ti 6Al4V | plate | D3003BL.XLS | 6/5/15 12:22 AM | CASE 1# | 0.2160 | 0.0340 | 0.9001 | | | | 0.4070 | | 0.2650 | | | | | | | | | | | | 0.1760 | 15 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.115 | 0.14 | 0.216 | 1.000 | UT |
| Ti 6Al4V | plate | D3003CL.XLS | 6/5/15 12:23 AM | CASE 1* | 0.2160 | 0.0340 | 0.9001 | | | | 0.4070 | | 0.2650 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.135 | 0.185 | 0.216 | 1.000 | UT |
| SS AMS 355 | hole | D4004.XLS | 6/5/15 12:24 AM | CASE 5 | | | | 0.4729 | 0.0020 | 0.0512 | 0.2575 | 28 | | | | | | | 0.0764 | 28 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.095 | | | UT |
| SS AMS 355 | hole | D5004.XLS | 6/5/15 12:25 AM | CASE 4 | | | | 0.8855 | 0.0230 | 0.0902 | 0.0902 | 4 | | | | | 0.0902 | 4 | 0.0902 | | 0.1803 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.245 | 0.51 | | | UT |
| STEEL 4340 | plate | D6001AL.XLS | 6/5/15 12:28 AM | CASE 6 | | | | 0.8931 | 0.0800 | 0.2620 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.4 | | | | UT |
| STEEL 4340 | plate | D6001BL.XLS | 6/5/15 12:30 AM | CASE 2 | 0.2500 | 0.0700 | 0.9001 | | | | 2.4030 | 27 | 1.6030 | 28 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.315 | | | 1.000 | UT |
| STEEL 4340 | plate | D6001CL.XLS | 6/5/15 12:31 AM | CASE 6 | | | | 0.8931 | 0.0800 | 0.2620 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.33 | | | | UT |
| STEEL 4340 | plate | D6003AL.XLS | 6/5/15 12:33 AM | CASE 6 | | | | 0.8368 | 0.0130 | 0.1183 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.575 | | | | UT |
| STEEL 4340 | plate | D6003BL.XLS | 6/5/15 12:35 AM | CASE 6 | | | | 0.8813 | 0.0680 | 0.2620 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.43 | | | | UT |
| STEEL 4340 | plate | D6003CL.XLS | 6/5/15 12:37 AM | CASE 6 | | | | 0.8813 | 0.0680 | 0.2620 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.45 | | | | UT |
| SS AMS 355 | hole | D7001L.XLS | 6/5/15 12:39 AM | CASE 1# | 0.0833 | 0.0220 | 0.9001 | | | | 0.3425 | | 0.1694 | | | | | | | | | | | | 0.0738 | 3 | | | | | | | | Warning: No false call analysis. | | 0.115 | 0.155 | 0.08333 | 1.000 | UT |
| SS AMS 355 | hole | D7002L.XLS | 6/5/15 12:40 AM | CASE 1# | 0.0663 | 0.0210 | 0.9001 | | | | 0.3425 | | 0.1694 | | | | | | | | | | | | 0.0659 | 1 | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.165 | 0.06626 | 1.000 | UT |
| SS AMS 355 | hole | D7003L.XLS | 6/5/15 12:41 AM | CASE 1# | 0.0833 | 0.0220 | 0.9001 | | | | 0.3425 | | 0.1694 | | | | | | | | | | | | 0.0782 | 4 | | | | | | | | Warning: No false call analysis. | | 0.065 | 0.075 | 0.08333 | 1.000 | UT |
| 2219 Al T-87 | stringer panel | D8001(3)D.xls | 6/5/15 12:42 AM | CASE 6 | | | | 0.8666 | 0.0020 | 0.0290 | 0.0950 | 26 | | | | | | | 0.0730 | 26 | 0.1900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.055 | 0.065 | | | UT |
| 2219 Al T-87 | stringer panel | D8001(3)L.xls | 6/5/15 12:44 AM | CASE 2 | 0.1640 | 0.0040 | 0.9050 | | | | 0.6840 | 23 | 0.5510 | 23 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.34 | 0.51 | | 1.000 | UT |
| 2219 Al T-87 | stringer panel | D8002(3)D.xls | 6/5/15 12:46 AM | CASE 1* | 0.0440 | 0.0030 | 0.9050 | | | | 0.0950 | | 0.0570 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.045 | 0.05 | 0.057 | 1.000 | UT |
| 2219 Al T-87 | stringer panel | D8002(3)L.xls | 6/5/15 12:48 AM | CASE 1* | 0.2000 | 0.0100 | 0.9050 | | | | 0.6840 | | 0.5630 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.22 | 0.255 | 0.542 | 1.000 | UT |
| 2219 Al T-87 | stringer panel | D8003(3)D.xls | 6/5/15 12:50 AM | CASE 2 | 0.0420 | 0.0020 | 0.9050 | | | | 0.0950 | 2 | 0.0650 | 20 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.06 | 0.065 | | 1.000 | UT |
| 2219 Al T-87 | stringer panel | D8003(3)L.xls | 6/5/15 12:51 AM | CASE 2 | 0.2760 | 0.0050 | 0.9050 | | | | 0.6840 | 13 | 0.5690 | 20 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.37 | 0.46 | | 1.000 | UT |
| 2219 Al T-87/w2319 | weld LOP | D9001(3)D.xls | 6/5/15 12:52 AM | CASE 7 | | | | 0.6070 | 0.0010 | 0.1030 | | | | | | | | | | | 0.3200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9001(3)L.xls | 6/5/15 12:54 AM | CASE 7 | | | | 0.6070 | 0.0010 | 0.3380 | | | | | | | | | | | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9002(3)D.xls | 6/5/15 12:57 AM | CASE 7 | | | | 0.6070 | 0.0010 | 0.1030 | | | | | | | | | | | 0.3200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9002(3)L.xls | 6/5/15 12:59 AM | CASE 7 | | | | 0.7169 | 0.0040 | 0.3410 | | | | | | | | | | | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.005 | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9003(3)D.xls | 6/5/15 1:02 AM | CASE 1* | 0.0630 | 0.0020 | 0.9050 | | | | 0.1600 | | 0.1050 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | 0.015 | 0.104 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld LOP | D9003(3)L.xls | 6/5/15 1:19 AM | CASE 1* | 0.6880 | 0.0170 | 0.9050 | | | | 1.2710 | | 0.8460 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.11 | 0.16 | 1.158 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld LOP | D9004(3)D.xls | 6/5/15 1:32 AM | CASE 7 | | | | 0.8444 | 0.0010 | 0.0440 | | | | | | | | | | | 0.3200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9004(3)L.xls | 6/5/15 1:33 AM | CASE 7 | | | | 0.7791 | 0.0010 | 0.2940 | | | | | | | | | | | 1.5000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9005(3)D.xls | 6/5/15 1:36 AM | CASE 7 | | | | 0.8153 | 0.0030 | 0.1050 | | | | | | | | | | | 0.3200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9005(3)L.xls | 6/5/15 1:38 AM | CASE 6 | | | | 0.7169 | 0.0040 | 0.3410 | 1.2710 | 26 | | | | | | | 1.2450 | 26 | 2.5420 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LOP | D9006(3)D.xls | 6/5/15 1:40 AM | CASE 1# | 0.0970 | 0.0010 | 0.9050 | | | | 0.1600 | | 0.1280 | | | | | | | | | | | | 0.0940 | 20 | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.015 | 0.02 | 0.097 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld LOP | D9006(3)L.xls | 6/5/15 1:58 AM | CASE 1* | 0.5180 | 0.0140 | 0.9050 | | | | 0.8890 | | 0.7420 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.03 | 0.1 | 0.659 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld LFC | DA001(3)D.xls | 6/5/15 2:17 AM | CASE 7 | | | | 0.8931 | 0.0190 | 0.0930 | | | | | | | | | | | 0.4300 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LFC | DA001(3)L.xls | 6/5/15 2:19 AM | CASE 6 | | | | 0.8931 | 0.0360 | 0.1650 | 1.6960 | 23 | | | | | | | 1.6920 | 26 | 3.3920 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LFC | DA002(3)D.xls | 6/5/15 2:20 AM | CASE 6 | | | | 0.6467 | 0.0110 | 0.0450 | 0.2150 | 26 | | | | | | | 0.2150 | 26 | 0.4300 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LFC | DA002(3)L.xls | 6/5/15 2:21 AM | CASE 6 | | | | 0.7791 | 0.0920 | 0.2570 | 1.1880 | 26 | | | | | | | 1.1880 | 26 | 2.3760 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld LFC | DA003(3)D.xls | 6/5/15 2:23 AM | CASE 2 | 0.0870 | 0.0220 | 0.9129 | | | | 0.2150 | 20 | 0.1510 | 29 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.145 | | | 1.000 | UT |
| 2219 Al T-87/w2319 | weld LFC | DA003(3)L.xls | 6/5/15 2:24 AM | CASE 2 | 0.1810 | 0.0520 | 0.9129 | | | | 1.6960 | 17 | 0.5600 | 11 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.35 | | | 1.000 | UT |
| 2219 Al T-87/w2319 | weld TFC | DB001(3)D.xls | 6/5/15 2:25 AM | CASE 7 | | | | 0.7791 | 0.0010 | 0.0400 | | | | | | | | | | | 0.4700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.18 | | | | UT |
| 2219 Al T-87/w2319 | weld TFC | DB001(3)L.xls | 6/5/15 2:27 AM | CASE 7 | | | | 0.8190 | 0.1000 | 1.0760 | | | | | | | | | | | 2.8700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld TFC | DB002(3)D.xls | 6/5/15 2:28 AM | CASE 2 | 0.0480 | 0.0090 | 0.9050 | | | | 0.2350 | 14 | 0.1160 | 20 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | | 1.000 | UT |
| 2219 Al T-87/w2319 | weld TFC | DB002(3)L.xls | 6/5/15 2:29 AM | CASE 2 | 0.3060 | 0.0330 | 0.9050 | | | | 1.4350 | 17 | 1.0850 | 23 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | | 1.000 | UT |
| 2219 Al T-87/w2319 | weld TFC | DB003(3)D.xls | 6/5/15 2:30 AM | CASE 6 | | | | 0.7791 | 0.0010 | 0.0400 | 0.2350 | 26 | | | | | | | 0.2350 | 26 | 0.4700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2219 Al T-87/w2319 | weld TFC | DB003(3)L.xls | 6/5/15 2:31 AM | CASE 6 | | | | 0.8666 | 0.0850 | 0.2330 | 1.4350 | 26 | | | | | | | 1.0760 | 20 | 2.8700 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | UT |
| 2219 Al T-87/w2319 | weld flush LFC | DC001(3)D.xls | 6/5/15 2:32 AM | CASE 1* | 0.0590 | 0.0060 | 0.9050 | | | | 0.2760 | | 0.2150 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.03 | 0.04 | 0.059 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld flush LFC | DC001(3)L.xls | 6/5/15 2:37 AM | CASE 1* | 0.3480 | 0.0290 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.18 | 0.215 | 0.348 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld flush LFC | DC002(3)D.xls | 6/5/15 2:43 AM | CASE 2 | 0.0590 | 0.0060 | 0.9050 | | | | 0.2760 | 26 | 0.2150 | 17 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.06 | 0.105 | | 1.000 | UT |
| 2219 Al T-87/w2319 | weld flush LFC | DC002(3)L.xls | 6/5/15 2:47 AM | CASE 1* | 0.3480 | 0.0290 | 0.9050 | | | | 1.5620 | | 1.0610 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.235 | 0.36 | 0.895 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld flush LFC | DC003(3)D.xls | 6/5/15 2:50 AM | CASE 1* | 0.0730 | 0.0080 | 0.9050 | | | | 0.2760 | | 0.2150 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.045 | 0.06 | 0.073 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld flush LFC | DC003(3)L.xls | 6/5/15 2:54 AM | CASE 1* | 0.3480 | 0.0290 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | 0.235 | 0.348 | 1.000 | UT |
| 2219 Al T-87/w2319 | weld flush TFC | DD001(3)D.xls | 6/5/15 3:00 AM | CASE 6 | | | | 0.7169 | 0.0120 | 0.1150 | 0.2150 | 26 | | | | | | | 0.2150 | 26 | 0.4300 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld flush TFC | DD001(3)L.xls | 6/5/15 3:01 AM | CASE 6 | | | | 0.7169 | 0.0580 | 0.2970 | 0.4950 | 26 | | | | | | | 0.4950 | 26 | 0.9900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.64 | | | | UT |
| 2219 Al T-87/w2319 | weld flush TFC | DD002(3)D.xls | 6/5/15 3:02 AM | CASE 6 | | | | 0.8666 | 0.0390 | 0.1100 | 0.2150 | 26 | | | | | | | 0.2150 | 26 | 0.4300 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.13 | | | | UT |
| 2219 Al T-87/w2319 | weld flush TFC | DD002(3)L.xls | 6/5/15 3:03 AM | CASE 6 | | | | 0.8209 | 0.0610 | 0.2390 | 0.4950 | 26 | | | | | | | 0.4950 | 26 | 0.9900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.37 | | | | UT |
| 2219 Al T-87/w2319 | weld flush TFC | DD003(3)D.xls | 6/5/15 3:04 AM | CASE 7 | | | | 0.3152 | 0.0120 | 0.0660 | | | | | | | | | | | 0.4300 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | UT |
| 2219 Al T-87/w2319 | weld flush TFC | DD003(3)L.xls | 6/5/15 3:05 AM | CASE 7 | | | | 0.2713 | 0.0010 | 0.1780 | | | | | | | | | | | 0.9900 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.005 | | | | UT |
| IN 718 and HAYNES | plate | E1001AL.XLS | 6/5/15 3:07 AM | CASE 6 | | | | 0.5709 | 0.0420 | 0.1900 | 0.4220 | 28 | | | | | | | 0.4220 | 28 | 0.8440 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | VT |
| IN 718 and HAYNES | plate | E1002AL.XLS | 6/5/15 3:10 AM | CASE 6 | | | | 0.7169 | 0.0290 | 0.3010 | 0.4220 | 28 | | | | | | | 0.4220 | 28 | 0.8440 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.595 | | | | VT |
| SS AMS 355 | hole | E2006.XLS | 6/5/15 3:11 AM | CASE 7 | | | | 0.7206 | 0.0180 | 0.0669 | | | | | | | | | | | 0.5150 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.28 | 0.715 | | | VT |
| 2219 Al T-87 | plate | F10001AA.XLS | 6/5/15 3:13 AM | CASE 6 | | | | 0.6518 | 0.0100 | 0.5273 | 0.8091 | 28 | | | | | | | 0.8091 | 28 | 1.6182 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10001BA.XLS | 6/5/15 3:14 AM | CASE 6 | | | | 0.4729 | 0.0100 | 0.5136 | 0.8091 | 28 | | | | | | | 0.8091 | 28 | 1.6182 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10001CA.XLS | 6/5/15 3:16 AM | CASE 7 | | | | 0.5493 | 0.0050 | 0.4909 | | | | | | | | | | | 1.6182 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F10002AA.XLS | 6/5/15 3:17 AM | CASE 1# | 0.5833 | 0.0660 | 0.9001 | | | | 0.8091 | | 0.6500 | | | | | | | | | | | | 0.5780 | 29 | | | | | | | | Warning: No false call analysis. | | 0.605 | 0.75 | 0.58333 | 1.000 | RT |
| 2219 Al T-87 | plate | F10002BA.XLS | 6/5/15 3:19 AM | CASE 1* | 0.6773 | 0.2000 | 0.9117 | | | | 0.8091 | | 0.7167 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.48 | 0.585 | 0.67727 | 0.970 | RT |
| 2219 Al T-87 | plate | F10002CA.XLS | 6/5/15 3:21 AM | CASE 2 | 0.5833 | 0.0660 | 0.9001 | | | | 0.8091 | 45 | 0.6500 | 20 | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.595 | | | 1.000 | RT |
| 2219 Al T-87 | plate | F10003AA.XLS | 6/5/15 3:23 AM | CASE 7 | | | | 0.8949 | 0.3000 | 0.8091 | | | | | | | | | | | 1.6182 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.4 | 0.475 | | | RT |
| 2219 Al T-87 | plate | F10003BA.XLS | 6/5/15 3:25 AM | CASE 1* | 0.5045 | 0.0690 | 0.9001 | | | | 0.8091 | | 0.6000 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.435 | 0.525 | 0.53333 | 1.000 | RT |
| 2219 Al T-87 | plate | F10003CA.XLS | 6/5/15 3:26 AM | CASE 1# | 0.6000 | 0.0820 | 0.9001 | | | | 0.8091 | | 0.6833 | | | | | | | | | | | | 0.5917 | 29 | | | | | | | | Warning: No false call analysis. | | 0.505 | 0.635 | 0.6 | 1.000 | RT |
| 2219 Al T-87 | plate | F10601AD.XLS | 6/5/15 3:28 AM | CASE 7 | | | | 0.0398 | 0.0040 | 0.0370 | | | | | | | | | | | 0.0860 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.128 | | | | RT |
| 2219 Al T-87 | plate | F10601AL.XLS | 6/5/15 3:30 AM | CASE 7 | | | | 0.0628 | 0.0020 | 0.2580 | | | | | | | | | | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10601BD.XLS | 6/5/15 3:32 AM | CASE 7 | | | | 0.0064 | 0.0010 | 0.0270 | | | | | | | | | | | 0.0860 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10601BL.XLS | 6/5/15 3:33 AM | CASE 7 | | | | 0.0127 | 0.0010 | 0.0600 | | | | | | | | | | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10601CD.XLS | 6/5/15 3:35 AM | CASE 7 | | | | 0.0127 | 0.0010 | 0.0190 | | | | | | | | | | | 0.0860 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10601CL.XLS | 6/5/15 3:35 AM | CASE 7 | | | | 0.0127 | 0.0010 | 0.2590 | | | | | | | | | | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F10602AD.XLS | 6/5/15 3:37 AM | CASE 1# | 0.0430 | 0.0110 | 0.9001 | | | | 0.0430 | 0 | 0.0430 | | | | | | | | | | | | 0.0420 | 29 | | | | | | | | Warning: No false call analysis. | | 0.04 | 0.055 | | 1.000 | RT |
| 2219 Al T-87 | plate | F10602AL.XLS | 6/5/15 3:37 AM | CASE 4 | | | | 0.8931 | 0.2000 | 0.3420 | 0.3420 | 2 | | | | | 0.3420 | 2 | 0.3420 | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.135 | 0.19 | | | RT |
| 2219 Al T-87 | plate | F10602BD.XLS | 6/5/15 3:38 AM | CASE 7 | | | | 0.8827 | 0.0140 | 0.0430 | | | | | | | | | | | 0.0860 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.035 | 0.045 | | | RT |
| 2219 Al T-87 | plate | F10602BL.XLS | 6/5/15 3:39 AM | CASE 1# | 0.5390 | 0.2000 | 0.9152 | | | | 0.9790 | | 0.7100 | | | | | | | | | | | | 0.5370 | 29 | | | | | | | | Warning: No false call analysis. | | 0.345 | 0.465 | 0.539 | 1.000 | RT |
| 2219 Al T-87 | plate | F10602CD.XLS | 6/5/15 3:41 AM | CASE 1# | 0.0430 | 0.0110 | 0.9001 | | | | 0.0430 | 0 | 0.0430 | | | | | | | | | | | | 0.0420 | 29 | | | | | | | | Warning: No false call analysis. | | 0.04 | 0.055 | | 1.000 | RT |
| 2219 Al T-87 | plate | F10602CL.XLS | 6/5/15 3:41 AM | CASE 4 | | | | 0.8931 | 0.2000 | 0.3420 | 0.3420 | 2 | | | | | 0.3420 | 2 | 0.3420 | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.13 | 0.185 | | | RT |
| 2219 Al T-87 | plate | F10603AD.XLS | 6/5/15 3:43 AM | CASE 7 | | | | 0.8637 | 0.0120 | 0.0430 | | | | | | | | | | | 0.0860 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.03 | 0.035 | | | RT |
| 2219 Al T-87 | plate | F10603AL.XLS | 6/5/15 3:43 AM | CASE 4 | | | | 0.8931 | 0.2000 | 0.3420 | 0.3420 | 2 | | | | | 0.3420 | 2 | 0.3420 | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | 0.125 | | | RT |
| 2219 Al T-87 | plate | F10603BD.XLS | 6/5/15 3:45 AM | CASE 1# | 0.0430 | 0.0110 | 0.9001 | | | | 0.0430 | 0 | 0.0430 | | | | | | | | | | | | 0.0420 | 29 | | | | | | | | Warning: No false call analysis. | | 0.025 | 0.025 | | 1.000 | RT |
| 2219 Al T-87 | plate | F10603BL.XLS | 6/5/15 3:45 AM | CASE 1# | 0.2870 | 0.2000 | 0.9253 | | | | 0.3420 | | 0.3145 | 0 | | | | | | | 0.6840 | 1 | | | 0.2830 | 29 | | | | | | | | Warning: No false call analysis. | | 0.11 | 0.155 | 0.287 | 1.000 | RT |
| 2219 Al T-87 | plate | F10603CD.XLS | 6/5/15 3:46 AM | CASE 1# | 0.0430 | 0.0110 | 0.9001 | | | | 0.0430 | 0 | 0.0430 | | | | | | | | | | | | 0.0420 | 29 | | | | | | | | Warning: No false call analysis. | | 0.035 | 0.05 | | 1.000 | RT |
| 2219 Al T-87 | plate | F10603CL.XLS | 6/5/15 3:47 AM | CASE 4 | | | | 0.8931 | 0.2000 | 0.3420 | 0.3420 | 2 | | | | | 0.3420 | 2 | 0.3420 | | 0.6840 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.205 | | | RT |
| 2219 Al T-87 | plate | F12201AD.XLS | 6/5/15 3:48 AM | CASE 7 | | | | 0.7206 | 0.0660 | 0.1780 | | | | | | | | | | | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F12201AL.XLS | 6/5/15 3:50 AM | CASE 6 | | | | 0.7411 | 0.0250 | 0.5000 | 0.9790 | 28 | | | | | | | 0.6100 | 28 | 1.9580 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F12201BD.XLS | 6/5/15 3:52 AM | CASE 4 | | | | 0.6877 | 0.0620 | 0.1780 | 0.1780 | 21 | | | | | 0.1780 | 21 | 0.1780 | | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.17 | | | RT |
| 2219 Al T-87 | plate | F12201BL.XLS | 6/5/15 3:53 AM | CASE 6 | | | | 0.6070 | 0.0160 | 0.5350 | 0.9790 | 28 | | | | | | | 0.6100 | 28 | 1.9580 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.625 | | | | RT |
| 2219 Al T-87 | plate | F12201CD.XLS | 6/5/15 3:55 AM | CASE 7 | | | | 0.6212 | 0.0430 | 0.1490 | | | | | | | | | | | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.185 | | | | RT |
| 2219 Al T-87 | plate | F12201CL.XLS | 6/5/15 3:56 AM | CASE 6 | | | | 0.6877 | 0.0240 | 0.5430 | 0.9790 | 28 | | | | | | | 0.6100 | 28 | 1.9580 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F12202AD.XLS | 6/5/15 3:58 AM | CASE 4 | | | | 0.8813 | 0.0690 | 0.1780 | 0.1780 | 5 | | | | | 0.1780 | 5 | 0.1780 | | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.13 | 0.185 | | | RT |
| 2219 Al T-87 | plate | F12202AL.XLS | 6/5/15 3:59 AM | CASE 4 | | | | 0.8609 | 0.0720 | 0.5680 | 0.9790 | 28 | | | | | 0.5680 | 9 | 0.5680 | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.62 | | | | RT |
| 2219 Al T-87 | plate | F12202BD.XLS | 6/5/15 4:01 AM | CASE 7 | | | | 0.8739 | 0.0750 | 0.1490 | | | | | | | | | | | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.09 | 0.115 | | | RT |
| 2219 Al T-87 | plate | F12202BL.XLS | 6/5/15 4:02 AM | CASE 1# | 0.5390 | 0.2000 | 0.9152 | | | | 0.9790 | | 0.7100 | | | | | | | | | | | | 0.5370 | 29 | | | | | | | | Warning: No false call analysis. | | 0.345 | 0.465 | 0.539 | 1.000 | RT |
| 2219 Al T-87 | plate | F12202CD.XLS | 6/5/15 4:04 AM | CASE 7 | | | | 0.8739 | 0.0750 | 0.1490 | | | | | | | | | | | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.125 | 0.185 | | | RT |
| 2219 Al T-87 | plate | F12202CL.XLS | 6/5/15 4:05 AM | CASE 6 | | | | 0.4729 | 0.0020 | 0.1530 | 0.9790 | 28 | | | | | | | 0.4990 | 28 | 1.9580 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.605 | | | | RT |
| 2219 Al T-87 | plate | F12203AD.XLS | 6/5/15 4:07 AM | CASE 6 | | | | 0.8768 | 0.0470 | 0.1060 | 0.1780 | 28 | | | | | | | 0.1780 | 28 | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.08 | 0.1 | | | RT |
| 2219 Al T-87 | plate | F12203AL.XLS | 6/5/15 4:08 AM | CASE 7 | | | | 0.8868 | 0.3000 | 0.6100 | | | | | | | | | | | 1.2200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.285 | 0.375 | | | RT |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2219 Al T-87 | plate | F12203BD.XLS | 6/5/15 4:10 AM | CASE 1# | 0.1190 | 0.0430 | 0.9001 | | | | 0.1780 | | 0.1485 | 29 | | | | | | | | | | | 0.1180 | 29 | | | | | | | | Warning: No false call analysis. | | 0.08 | 0.105 | 0.119 | 1.000 | RT |
| 2219 Al T-87 | plate | F12203BL.XLS | 6/5/15 4:11 AM | CASE 1# | 0.5350 | 0.2000 | 0.9129 | | | | 0.6100 | | 0.5680 | | | | | | | | | | | | 0.5290 | 29 | | | | | | | | Warning: No false call analysis. | | 0.305 | 0.41 | 0.535 | 1.000 | RT |
| 2219 Al T-87 | plate | F12203CD.XLS | 6/5/15 4:12 AM | CASE 6 | | | | 0.8668 | 0.0670 | 0.1260 | 0.1780 | 17 | | | | | | | 0.1780 | 17 | 0.3560 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.055 | 0.065 | | | RT |
| 2219 Al T-87 | plate | F12203CL.XLS | 6/5/15 4:14 AM | CASE 1# | 0.5190 | 0.2000 | 0.9253 | | | | 0.6100 | | 0.5430 | | | | | | | | | | | | 0.5185 | 29 | | | | | | | | Warning: No false call analysis. | | 0.3 | 0.415 | 0.519 | 1.000 | RT |
| 2219 Al T-87 | plate | F20002AA.XLS | 6/5/15 4:16 AM | CASE 4 | | | | 0.6518 | 0.0910 | 0.6545 | 0.6545 | 22 | | | | | 0.6545 | 22 | 0.6182 | 23 | 1.3091 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F20002BA.XLS | 6/5/15 4:17 AM | CASE 4 | | | | 0.6518 | 0.0910 | 0.6545 | 0.6545 | 22 | | | | | 0.6545 | 22 | 0.6182 | 23 | 1.3091 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F20002CA.XLS | 6/5/15 4:18 AM | CASE 6 | | | | 0.7616 | 0.0370 | 0.5182 | 0.6545 | 27 | | | | | | | 0.5636 | 28 | 1.3091 | 29 | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | RT |
| 2219 Al T-87 | plate | F20852AD.XLS | 6/5/15 4:20 AM | CASE 6 | | | | 0.3684 | 0.0010 | 0.0440 | 0.0540 | 28 | | | | | | | 0.0540 | 28 | 0.1080 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F20852AL.XLS | 6/5/15 4:20 AM | CASE 7 | | | | 0.5493 | 0.0380 | 0.3260 | | | | | | | | | | | 0.7680 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F20852BD.XLS | 6/5/15 4:22 AM | CASE 7 | | | | 0.4931 | 0.0100 | 0.0540 | | | | | | | | | | | 0.1080 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.13 | | | | RT |
| 2219 Al T-87 | plate | F20852BL.XLS | 6/5/15 4:22 AM | CASE 4 | | | | 0.5493 | 0.0140 | 0.3840 | 0.3840 | 24 | | | | | 0.3840 | 24 | 0.3840 | | 0.7680 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F20852CD.XLS | 6/5/15 4:23 AM | CASE 7 | | | | 0.5619 | 0.0120 | 0.0540 | | | | | | | | | | | 0.1080 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | | | | RT |
| 2219 Al T-87 | plate | F20852CL.XLS | 6/5/15 4:24 AM | CASE 7 | | | | 0.6383 | 0.2000 | 0.3840 | | | | | | | | | | | 0.7680 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.505 | | | | RT |
| 2219 Al T-87 | plate | F22202AD.XLS | 6/5/15 4:25 AM | CASE 4 | | | | 0.6518 | 0.0200 | 0.1440 | 0.1440 | 22 | | | | | 0.1440 | 22 | 0.1360 | 23 | 0.2880 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.2 | | | RT |
| 2219 Al T-87 | plate | F22202AL.XLS | 6/5/15 4:27 AM | CASE 7 | | | | 0.7791 | 0.0270 | 0.4920 | | | | | | | | | | | 1.1000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F22202BD.XLS | 6/5/15 4:28 AM | CASE 7 | | | | 0.6522 | 0.0390 | 0.1440 | | | | | | | | | | | 0.2880 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.14 | 0.195 | | | RT |
| 2219 Al T-87 | plate | F22202BL.XLS | 6/5/15 4:29 AM | CASE 7 | | | | 0.6058 | 0.0200 | 0.4920 | | | | | | | | | | | 1.1000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | plate | F22202CD.XLS | 6/5/15 4:30 AM | CASE 7 | | | | 0.7699 | 0.0380 | 0.1440 | | | | | | | | | | | 0.2880 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.15 | | | | RT |
| 2219 Al T-87 | plate | F22202CL.XLS | 6/5/15 4:31 AM | CASE 6 | | | | 0.7411 | 0.0200 | 0.4920 | 0.5500 | 22 | | | | | | | 0.5500 | 22 | 1.1000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F30651AD.XLS | 6/5/15 4:33 AM | CASE 7 | | | | 0.7411 | 0.0140 | 0.0510 | | | | | | | | | | | 0.2000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.05 | 0.11 | | | RT |
| Ti 6Al4V | plate | F30651AL.XLS | 6/5/15 4:34 AM | CASE 7 | | | | 0.7206 | 0.2000 | 0.4070 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.255 | 0.41 | | | RT |
| Ti 6Al4V | plate | F30651BD.XLS | 6/5/15 4:35 AM | CASE 7 | | | | 0.7411 | 0.0140 | 0.0510 | | | | | | | | | | | 0.2000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.05 | 0.095 | | | RT |
| Ti 6Al4V | plate | F30651BL.XLS | 6/5/15 4:36 AM | CASE 7 | | | | 0.7206 | 0.2000 | 0.4070 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.29 | 0.48 | | | RT |
| Ti 6Al4V | plate | F30651CD.XLS | 6/5/15 4:37 AM | CASE 7 | | | | 0.7740 | 0.0280 | 0.0510 | | | | | | | | | | | 0.2000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.04 | 0.06 | | | RT |
| Ti 6Al4V | plate | F30651CL.XLS | 6/5/15 4:39 AM | CASE 7 | | | | 0.7411 | 0.0930 | 0.2500 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.225 | 0.325 | | | RT |
| Ti 6Al4V | plate | F30653AD.XLS | 6/5/15 4:40 AM | CASE 6 | | | | 0.7791 | 0.0060 | 0.0180 | 0.1000 | 28 | | | | | | | 0.1000 | 28 | 0.2000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F30653AL.XLS | 6/5/15 4:41 AM | CASE 7 | | | | 0.8074 | 0.0240 | 0.0910 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F30653BD.XLS | 6/5/15 4:42 AM | CASE 6 | | | | 0.6877 | 0.0040 | 0.0160 | 0.1000 | 28 | | | | | | | 0.1000 | 28 | 0.2000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F30653BL.XLS | 6/5/15 4:43 AM | CASE 7 | | | | 0.7411 | 0.0170 | 0.0840 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F30653CD.XLS | 6/5/15 4:45 AM | CASE 6 | | | | 0.6360 | 0.0130 | 0.0290 | 0.1000 | 28 | | | | | | | 0.1000 | 28 | 0.2000 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F30653CL.XLS | 6/5/15 4:46 AM | CASE 7 | | | | 0.7411 | 0.0750 | 0.3250 | | | | | | | | | | | 0.8140 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.73 | | | | RT |
| Ti 6Al4V | plate | F32251AD.XLS | 6/5/15 4:47 AM | CASE 6 | | | | 0.5493 | 0.0030 | 0.2150 | 0.3520 | 28 | | | | | | | 0.3200 | 28 | 0.7040 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32251AL.XLS | 6/5/15 4:49 AM | CASE 6 | | | | 0.5493 | 0.0030 | 0.2150 | 0.3520 | 28 | | | | | | | 0.3200 | 28 | 0.7040 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32251BD.XLS | 6/5/15 4:52 AM | CASE 7 | | | | 0.4182 | 0.0290 | 0.0970 | | | | | | | | | | | 0.1940 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.115 | | | | RT |
| Ti 6Al4V | plate | F32251BL.XLS | 6/5/15 4:53 AM | CASE 7 | | | | 0.2486 | 0.0870 | 0.3520 | | | | | | | | | | | 0.7040 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32251CD.XLS | 6/5/15 4:54 AM | CASE 7 | | | | 0.2486 | 0.0870 | 0.3520 | | | | | | | | | | | 0.7040 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32251CL.XLS | 6/5/15 4:55 AM | CASE 7 | | | | 0.2486 | 0.0870 | 0.3520 | | | | | | | | | | | 0.7040 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32253AD.XLS | 6/5/15 4:56 AM | CASE 6 | | | | 0.6837 | 0.0150 | 0.2250 | 0.3700 | 28 | | | | | | | 0.3520 | 28 | 0.7400 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32253AL.XLS | 6/5/15 4:58 AM | CASE 6 | | | | 0.6837 | 0.0150 | 0.2250 | 0.3700 | 28 | | | | | | | 0.3520 | 28 | 0.7400 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.605 | | | | RT |
| Ti 6Al4V | plate | F32253BD.XLS | 6/5/15 4:59 AM | CASE 6 | | | | 0.6770 | 0.0370 | 0.2470 | 0.3700 | 27 | | | | | | | 0.3700 | 27 | 0.7400 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| Ti 6Al4V | plate | F32253BL.XLS | 6/5/15 5:00 AM | CASE 6 | | | | 0.6770 | 0.0370 | 0.2470 | 0.3700 | 27 | | | | | | | 0.3700 | 27 | 0.7400 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.365 | 0.695 | | | RT |
| Ti 6Al4V | plate | F32253CD.XLS | 6/5/15 5:01 AM | CASE 6 | | | | 0.7411 | 0.0050 | 0.0580 | 0.1030 | 28 | | | | | | | 0.1030 | 28 | 0.2060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.18 | | | | RT |
| Ti 6Al4V | plate | F32253CL.XLS | 6/5/15 5:03 AM | CASE 6 | | | | 0.6070 | 0.0020 | 0.2120 | 0.3700 | 28 | | | | | | | 0.3700 | 28 | 0.7400 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F40601A.XLS | 6/5/15 5:04 AM | CASE 7 | | | | 0.5493 | 0.0040 | 0.0913 | | | | | | | | | | | 0.4960 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F40601B.XLS | 6/5/15 5:05 AM | CASE 7 | | | | 0.5293 | 0.0070 | 0.0943 | | | | | | | | | | | 0.4960 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F40601C.XLS | 6/5/15 5:06 AM | CASE 7 | | | | 0.4504 | 0.0070 | 0.1163 | | | | | | | | | | | 0.4960 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F40603A.XLS | 6/5/15 5:08 AM | CASE 6 | | | | 0.6877 | 0.0070 | 0.0943 | 0.2480 | 28 | | | | | | | 0.1750 | 28 | 0.4960 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.265 | | | | RT |
| STEEL 4340 | plate | F40603B.XLS | 6/5/15 5:09 AM | CASE 6 | | | | 0.6877 | 0.0070 | 0.0943 | 0.2480 | 28 | | | | | | | 0.2480 | 28 | 0.4960 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.49 | | | | RT |
| STEEL 4340 | plate | F40603C.XLS | 6/5/15 5:10 AM | CASE 6 | | | | 0.7169 | 0.0080 | 0.0953 | 0.2480 | 28 | | | | | | | 0.1750 | 28 | 0.4960 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.265 | | | | RT |
| STEEL 4340 | plate | F42501A.XLS | 6/5/15 5:12 AM | CASE 6 | | | | 0.2486 | 0.0080 | 0.3300 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F42501B.XLS | 6/5/15 5:13 AM | CASE 6 | | | | 0.1343 | 0.3000 | 0.4000 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F42501C.XLS | 6/5/15 5:16 AM | CASE 6 | | | | 0.2236 | 0.0030 | 0.3300 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F42503A.XLS | 6/5/15 5:17 AM | CASE 6 | | | | 0.7942 | 0.0680 | 0.3500 | 2.4030 | 28 | | | | | | | 1.6030 | 28 | 4.8060 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| STEEL 4340 | plate | F42503B.XLS | 6/5/15 5:19 AM | CASE 5 | | | | 0.7616 | 0.0630 | 0.3500 | 2.4030 | 28 | | | | | | | 0.5320 | 28 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.66 | | | | RT |
| STEEL 4340 | plate | F42503C.XLS | 6/5/15 5:20 AM | CASE 5 | | | | 0.7942 | 0.0680 | 0.3500 | 2.4030 | 28 | | | | | | | 0.5320 | 28 | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.575 | | | | RT |
| 2219 Al T-87 | weld LOP | F5001(3)D.xls | 6/5/15 5:22 AM | CASE 6 | | | | 0.8666 | 0.0010 | 0.0500 | 0.1600 | 26 | | | | | | | 0.1600 | 26 | 0.3200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | 0.15 | | | | RT |
| 2219 Al T-87 | weld LOP | F5001(3)L.xls | 6/5/15 5:24 AM | CASE 1* | 1.1580 | 0.0580 | 0.9050 | | | | 1.2100 | | 1.1750 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | 1.158 | 1.000 | RT |
| 2219 Al T-87 | weld LOP | F5002(3)D.xls | 6/5/15 5:26 AM | CASE 6 | | | | 0.8666 | 0.0010 | 0.0500 | 0.1600 | 26 | | | | | | | 0.1600 | 26 | 0.3200 | 29 | | | | | | | | | | | | Warning: No false call analysis. | | | | | | RT |
| 2219 Al T-87 | weld LOP | F5002(3)L.xls | 6/5/15 5:28 AM | CASE 2 | 0.3370 | 0.0490 | 0.9050 | | | | 1.2100 | | 0.8250 | 8 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | 1.156 | 1.000 | RT |
| 2219 Al T-87 | weld LOP | F5003(3)D.xls | 6/5/15 5:30 AM | CASE 2 | 0.0720 | 0.0020 | 0.9050 | | | | 0.1600 | 20 | 0.1050 | 8 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | 0.005 | | 1.000 | RT |
| 2219 Al T-87 | weld LOP | F5003(3)L.xls | 6/5/15 5:41 AM | CASE 2 | 0.6880 | 0.0170 | 0.9050 | | | | 1.2100 | 16 | 1.0790 | 14 | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.005 | 0.005 | | 1.000 | RT |

*All lengths are in inches

# DOEPOD CAPABILITIES DATA BOOK - SUMMARY
## TABLE 3*

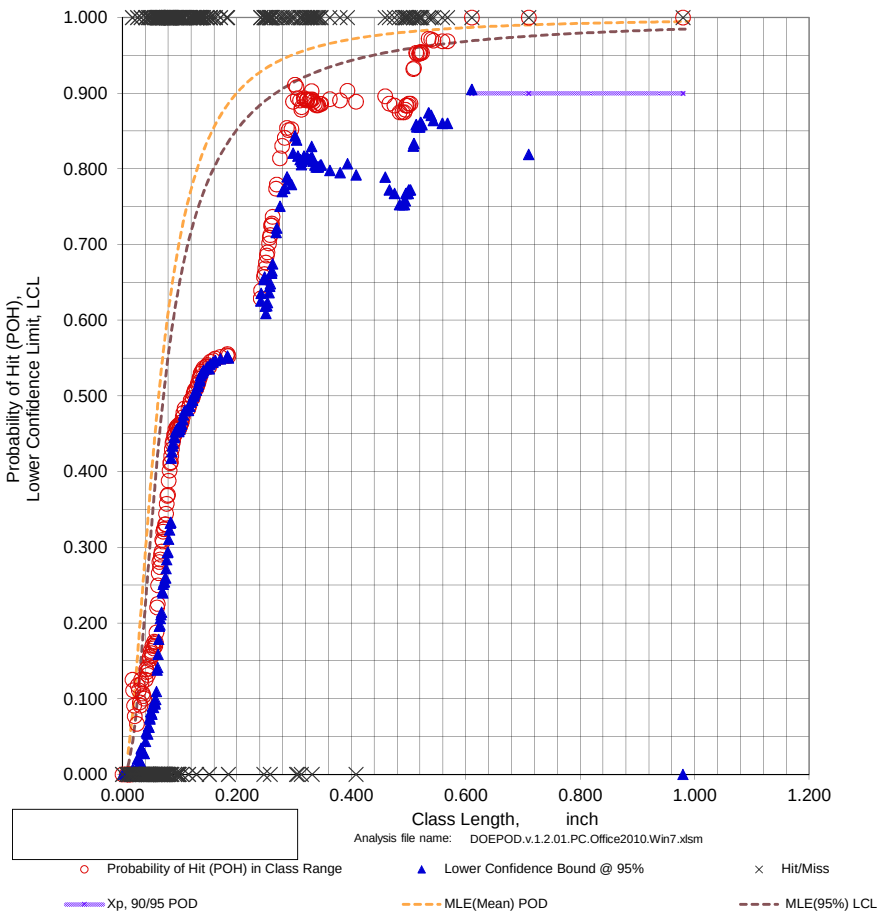
| MATERIAL | STRUCTURE | FILE NAME | Analysis Date/Time | CASE ID | Xpod CLASS-LENGTH | Xpod CLASS-WIDTH | LCL | Best_LCL | Best_LCL CLASS-WIDTH | Best_LCL CLASS-LENGTH | XL | XL # | Xm | Xm # | Xs | Xs # | Xlcl | Xlcl # | Xpoh | Xpoh # | 2XL | 2XL # | Xss | Xss # | Xpodopt | Xpodopt # | False Call UCL | False Call Rate | False Call Length (in) | False Call Area (in^2) | Length or Area per Inspection (in or in^2) = | False Call Opportunities | False Calls | False Call Flag | MLE flag | NTIAC 90% POD occurs at (inch) | NTIAC 90/95 occurs at POD (inch) | XP | POH or POD @ Xpod | METHOD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2219 Al T-87 | | F6001(3)D.xls | 6/5/15 5:49 AM | CASE 7 | | | | 0.6070 | 0.0050 | 0.1780 | | | | | | | | | | | 0.4300 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld LFC | F6001(3)L.xls | 6/5/15 5:50 AM | CASE 7 | | | | 0.6070 | 0.0070 | 0.0790 | | | | | | | | | | | 2.3760 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld LFC | F6002(3)D.xls | 6/5/15 5:52 AM | CASE 7 | | | | 0.5709 | 0.0420 | 0.2150 | | | | | | | | | | | 0.4300 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld LFC | F6002(3)L.xls | 6/5/15 5:53 AM | CASE 6 | | | | 0.6070 | 0.0050 | 0.5030 | 1.1880 | 26 | | | | | | | 1.1880 | 26 | 2.3760 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld LFC | F6003(3)D.xls | 6/5/15 5:55 AM | CASE 4 | | | | 0.8666 | 0.0620 | 0.2150 | 0.2150 | 8 | | | | | 0.2150 | 8 | 0.2150 | | 0.4300 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld LFC | F6003(3)L.xls | 6/5/15 5:56 AM | CASE 4 | | | | 0.8190 | 0.3000 | 1.1880 | 1.1880 | 14 | | | | | 1.1880 | 14 | 0.9810 | 26 | 2.3760 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld TFC | F7001(3)D.xls | 6/5/15 5:58 AM | CASE 4 | | | | 0.6070 | 0.0420 | 0.2350 | 0.2350 | 23 | | | | | 0.2350 | 23 | 0.2350 | | 0.4700 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld TFC | F7001(3)L.xls | 6/5/15 5:59 AM | CASE 6 | | | | 0.6070 | 0.0130 | 0.2730 | 1.4350 | 26 | | | | | | | 1.4350 | 26 | 2.8700 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld TFC | F7002(3)D.xls | 6/5/15 6:01 AM | CASE 4 | | | | 0.6070 | 0.0420 | 0.2350 | 0.2350 | 23 | | | | | 0.2350 | 23 | 0.2350 | | 0.4700 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld TFC | F7002(3)L.xls | 6/5/15 6:03 AM | CASE 6 | | | | 0.6070 | 0.0130 | 0.2730 | 1.4350 | 26 | | | | | | | 1.4350 | 26 | 2.8700 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld TFC | F7003(3)D.xls | 6/5/15 6:05 AM | CASE 6 | | | | 0.8190 | 0.0050 | 0.0480 | 0.2350 | 26 | | | | | | | 0.2350 | 26 | 0.4700 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld TFC | F7003(3)L.xls | 6/5/15 6:06 AM | CASE 6 | | | | 0.7933 | 0.0240 | 0.3060 | 1.4350 | 26 | | | | | | | 1.4350 | 26 | 2.8700 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld flush LFC | F8001(3)D.xls | 6/5/15 6:08 AM | CASE 4 | | | | 0.8444 | 0.0610 | 0.2760 | 0.2760 | 11 | | | | | 0.2760 | 11 | 0.2760 | | 0.5520 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld flush LFC | F8001(3)L.xls | 6/5/15 6:09 AM | CASE 7 | | | | 0.8739 | 0.6000 | 1.5620 | | | | | | | | | | | 3.1240 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | | RT |
| 2219 Al T-87 | weld flush LFC | F8002(3)D.xls | 6/5/15 6:11 AM | CASE 4 | | | | 0.8931 | 0.0690 | 0.2760 | 0.2760 | 2 | | | | | 0.2760 | 2 | 0.2760 | | 0.5520 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | | RT |
| 2219 Al T-87 | weld flush LFC | F8002(3)L.xls | 6/5/15 6:12 AM | CASE 4 | | | | 0.8813 | 0.5000 | 1.5620 | 1.5620 | 5 | | | | | 1.5620 | 5 | 1.5620 | | 3.1240 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld flush LFC | F8003(3)D.xls | 6/5/15 6:15 AM | CASE 4 | | | | 0.8931 | 0.0690 | 0.2760 | 0.2760 | 2 | | | | | 0.2760 | 2 | 0.2760 | | 0.5520 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | | RT |
| 2219 Al T-87 | weld flush LFC | F8003(3)L.xls | 6/5/15 6:17 AM | CASE 1* | 0.3530 | 0.0300 | 0.9050 | | | | 1.5620 | | 1.1190 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | | | 1.061 | 1.000 | RT |
| 2219 Al T-87 | weld flush TFC | F9000CD.XLS | 6/5/15 6:18 AM | CASE 7 | | | | 0.5619 | 0.0120 | 0.0540 | | | | | | | | | | | 0.1080 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | | | | RT |
| 2219 Al T-87 | weld flush TFC | F9001(3)D.xls | | CASE 7 | | | | | | | | | | | | | | | | | 0.4300 | 29 | | | | | | | | | | | | | | MLE Divergence Warning: Initial results listed. | | | | | | RT |
| 2219 Al T-87 | weld flush TFC | F9001(3)L.xls | | CASE 7 | | | | | | | | | | | | | | | | | 0.9900 | 29 | | | | | | | | | | | | | | MLE Divergence Warning: Initial results listed. | | | | | | RT |
| 2219 Al T-87 | weld flush TFC | F9002(3)D.xls | 6/5/15 6:19 AM | CASE 4 | | | | 0.3684 | 0.0010 | 0.2150 | 0.2150 | 26 | | | | | 0.2150 | 26 | 0.2150 | | 0.4300 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | | RT |
| 2219 Al T-87 | weld flush TFC | F9002(3)L.xls | 6/5/15 6:20 AM | CASE 4 | | | | 0.3684 | 0.0010 | 0.4950 | 0.4950 | 26 | | | | | 0.4950 | 26 | 0.4950 | | 0.9900 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.56 | | | | | RT |
| 2219 Al T-87 | weld flush TFC | F9003(3)D.xls | 6/5/15 6:21 AM | CASE 4 | | | | 0.3684 | 0.0010 | 0.2150 | 0.2150 | 26 | | | | | 0.2150 | 26 | 0.2150 | | 0.4300 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | | | | | | RT |
| 2219 Al T-87 | weld flush TFC | F9003(3)L.xls | 6/5/15 6:22 AM | CASE 4 | | | | 0.3684 | 0.0010 | 0.4950 | 0.4950 | 26 | | | | | 0.4950 | 26 | 0.4950 | | 0.9900 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | MLE Divergence Warning: Initial results listed. | 0.56 | | | | | RT |
| 2219 Al T-87 | plate | G10003AA.XLS | 6/5/15 6:23 AM | CASE 7 | | | | 0.8514 | 0.0930 | 0.6333 | | | | | | | | | | | 1.6333 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.64 | | | | HT |
| 2219 Al T-87 | plate | G10003AD.XLS | 6/5/15 6:25 AM | CASE 4 | | | | 0.8190 | 0.0490 | 0.1260 | 0.1780 | 28 | | | | | 0.1260 | 14 | 0.1260 | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.095 | | | | HT |
| 2219 Al T-87 | plate | G10003AL_XLS | 6/5/15 6:26 AM | CASE 1* | 0.3220 | 0.0750 | 0.9001 | | | | 0.6100 | | 0.5350 | | | | | | | | | | | | | | | | | | | | | Warning: No false call analysis. | | 0.245 | 0.4 | 0.475 | 1.000 | HT |
| 2219 Al T-87 | plate | G10003BA.XLS | 6/5/15 6:27 AM | CASE 7 | | | | 0.6532 | 0.2000 | 0.6833 | | | | | | | | | | | 1.6182 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | | | | | HT |
| 2219 Al T-87 | plate | G10003BD.XLS | 6/5/15 6:29 AM | CASE 7 | | | | 0.8074 | 0.0300 | 0.1260 | | | | | | | | | | | 0.3560 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.105 | 0.17 | | | HT |
| 2219 Al T-87 | plate | G10003BL.XLS | 6/5/15 6:30 AM | CASE 6 | | | | 0.7794 | 0.0530 | 0.2950 | 0.6100 | 27 | | | | | | | 0.5680 | 23 | 1.2200 | 29 | | | | | | | | | | | | | Warning: No false call analysis. | | 0.46 | 0.63 | | | HT |
| SS AMS 355 | hole | G2001L.XLS | 6/5/15 6:31 AM | CASE 1# | 0.0845 | 0.0260 | 0.9001 | | | | 0.2425 | | 0.1694 | | | | | | | | | | | | 0.0774 | 2 | | | | | | | | Warning: No false call analysis. | | 0.075 | 0.1 | 0.08452 | 1.000 | HT |

*All lengths are in inches

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.83.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A1001AL.xls**

Data Set Name = **A1001AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:14 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.6100 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.4590 -0.050 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.200 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.270 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.710 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.589 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.6100 | inch |

File Name = A1001AL.xls
Data Set Name = A1001AL(CRACK #)

## Directed DOE Options

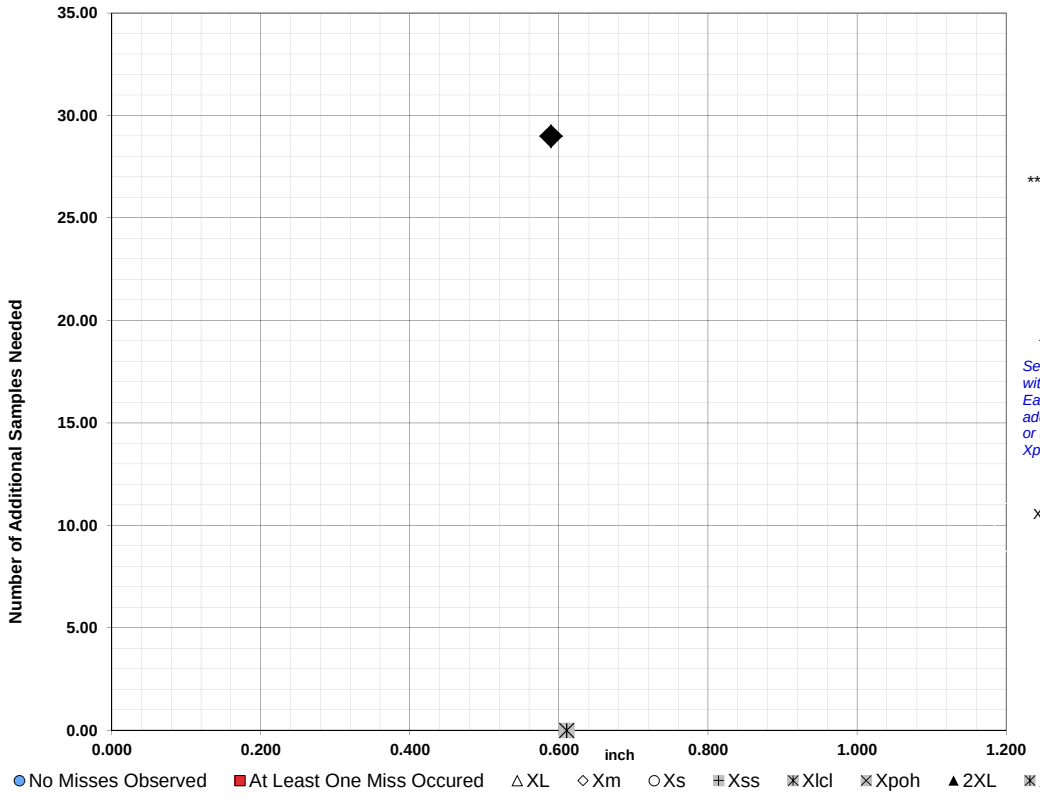



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | |
| Xm = | 0.710 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.589 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

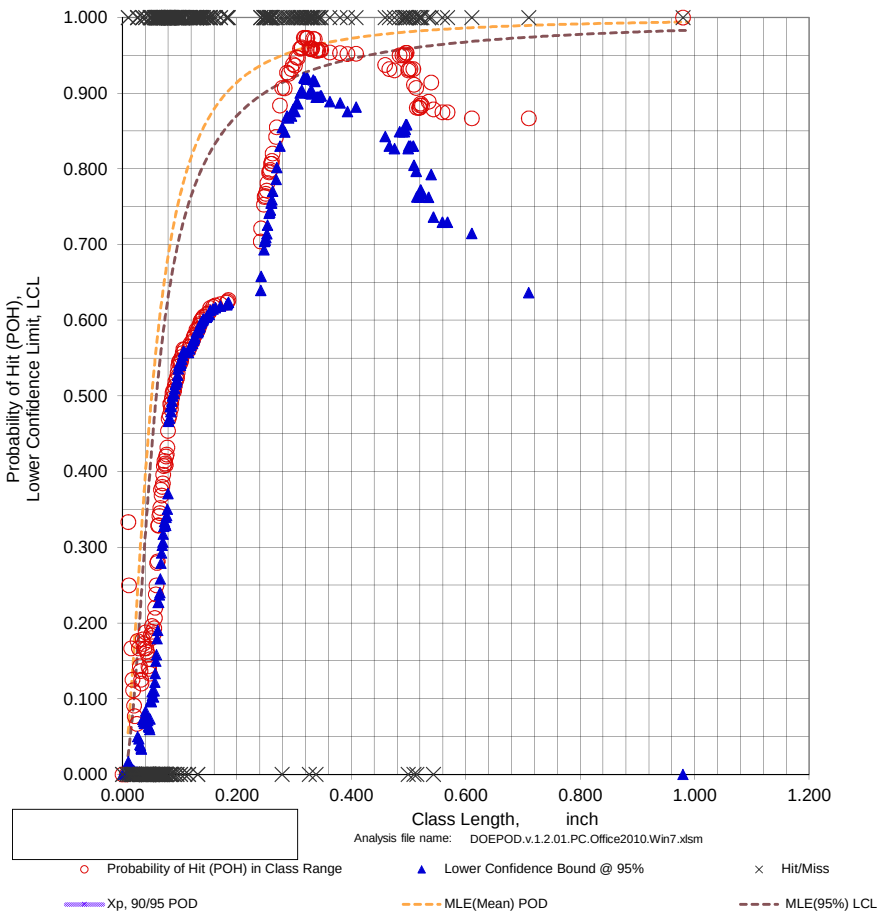
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 12 more large flaws.**

**Warning: No false call analysis.**




File Name = **A1001BL.XLS**

Data Set Name = **A1001BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:16 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.3130 | inch |
| Lower Confidence Bound = | 0.9040 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9605 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.250 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | 0.646 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A1001BL.XLS
Data Set Name = A1001BL(CRACK #)

## Directed DOE Options

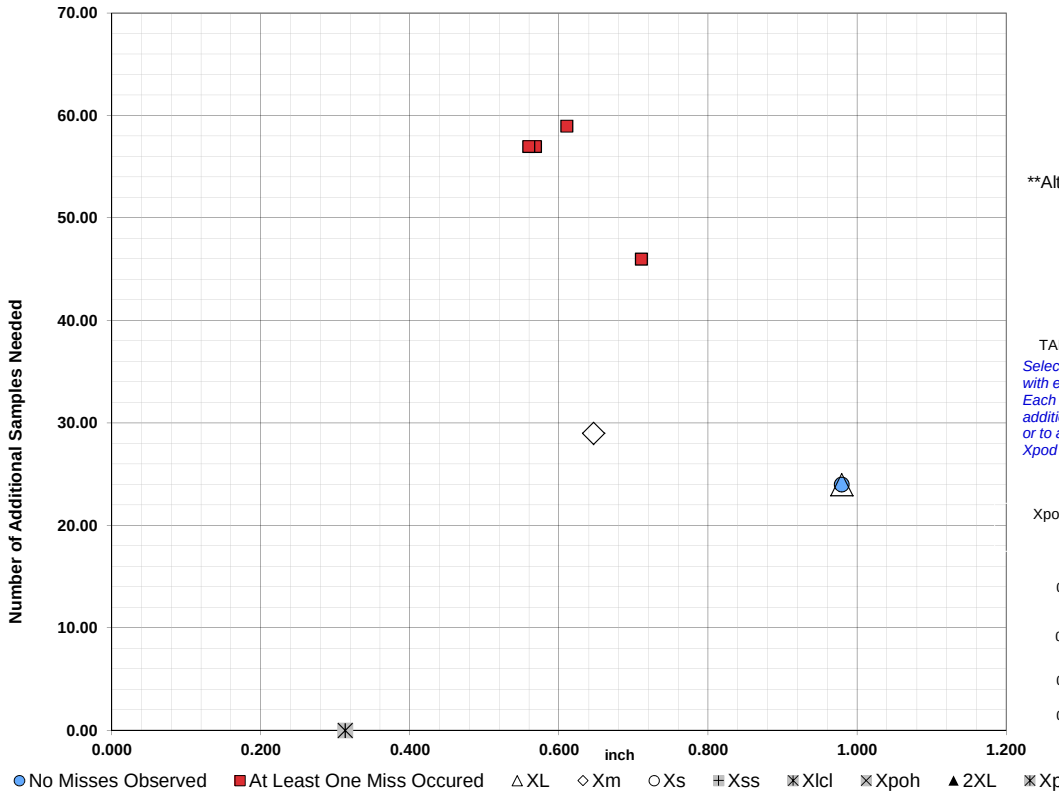



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 24 |
| Xm = | 0.646 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.7100 | 46 |
| 0.6100 | 59 |
| 0.5680 | 57 |
| 0.5590 | 57 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.9790 | 24 |

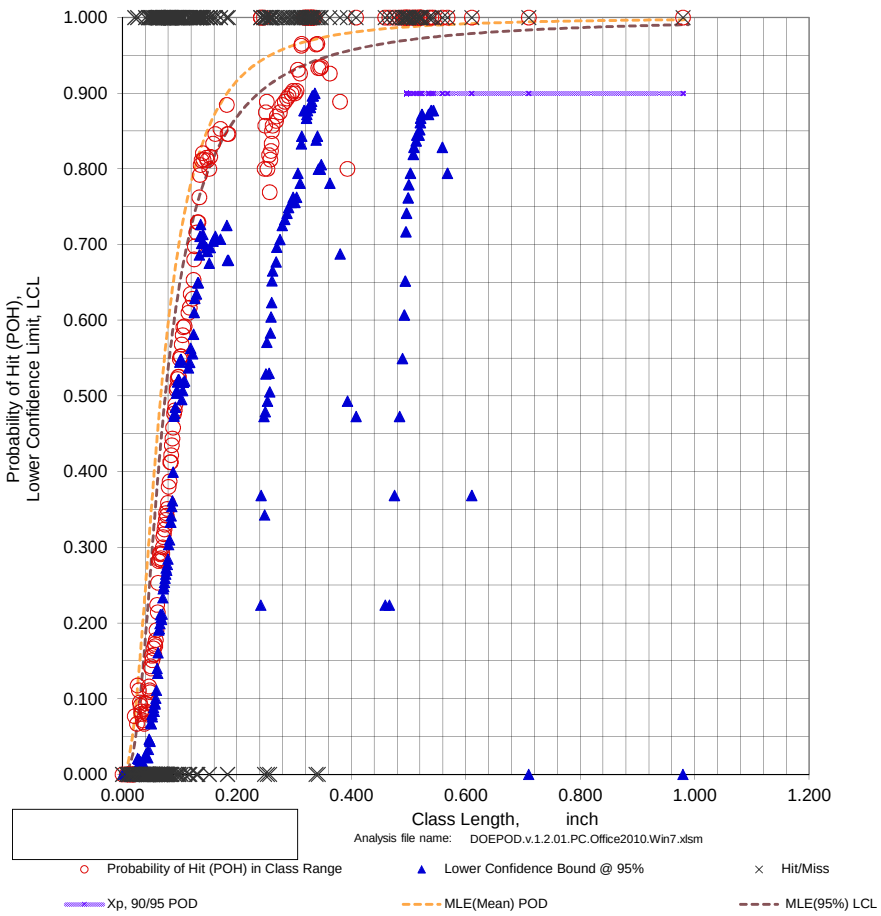
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.008.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A1001CL.XLS**

Data Set Name = **A1001CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:19 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0570 | inch |
| Classlength @ 90/95 Xpod = | 0.3360 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.300 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.410 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.543 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.4960 | inch |

File Name = A1001CL.XLS
Data Set Name = A1001CL(CRACK #)

## Directed DOE Options

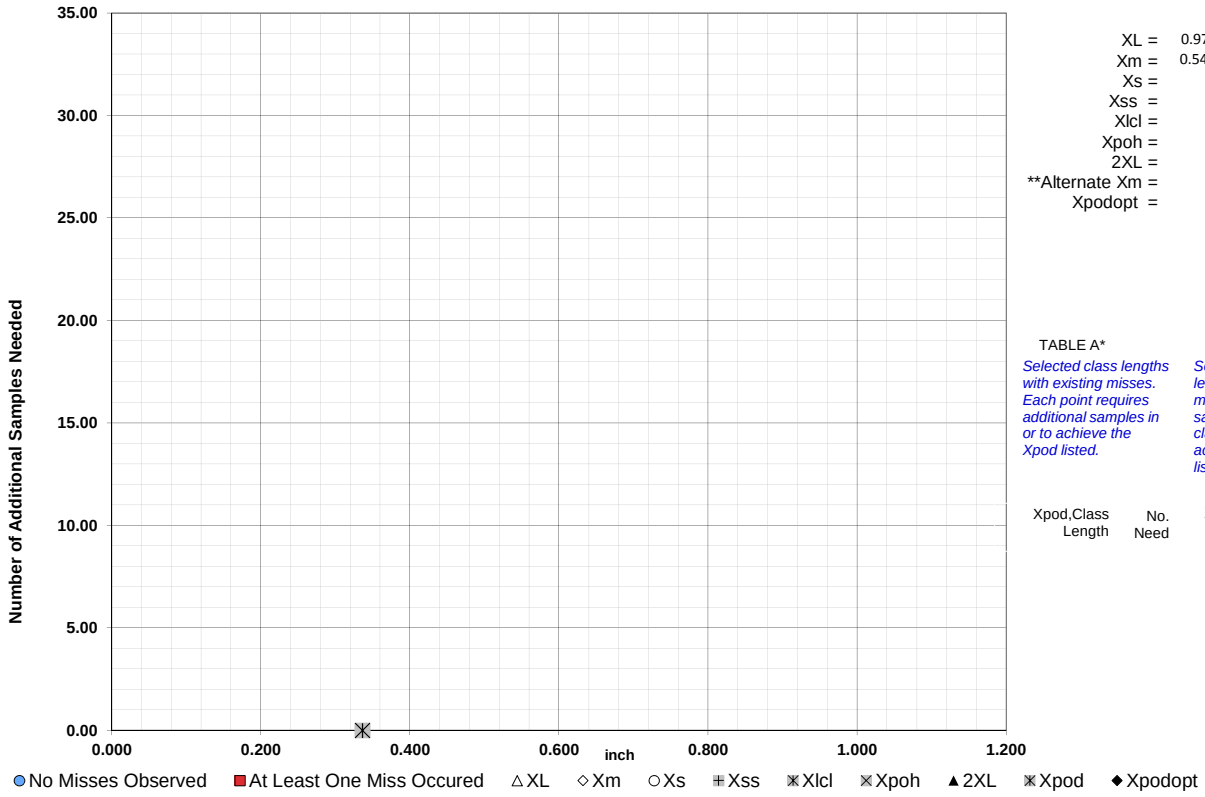



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.543 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

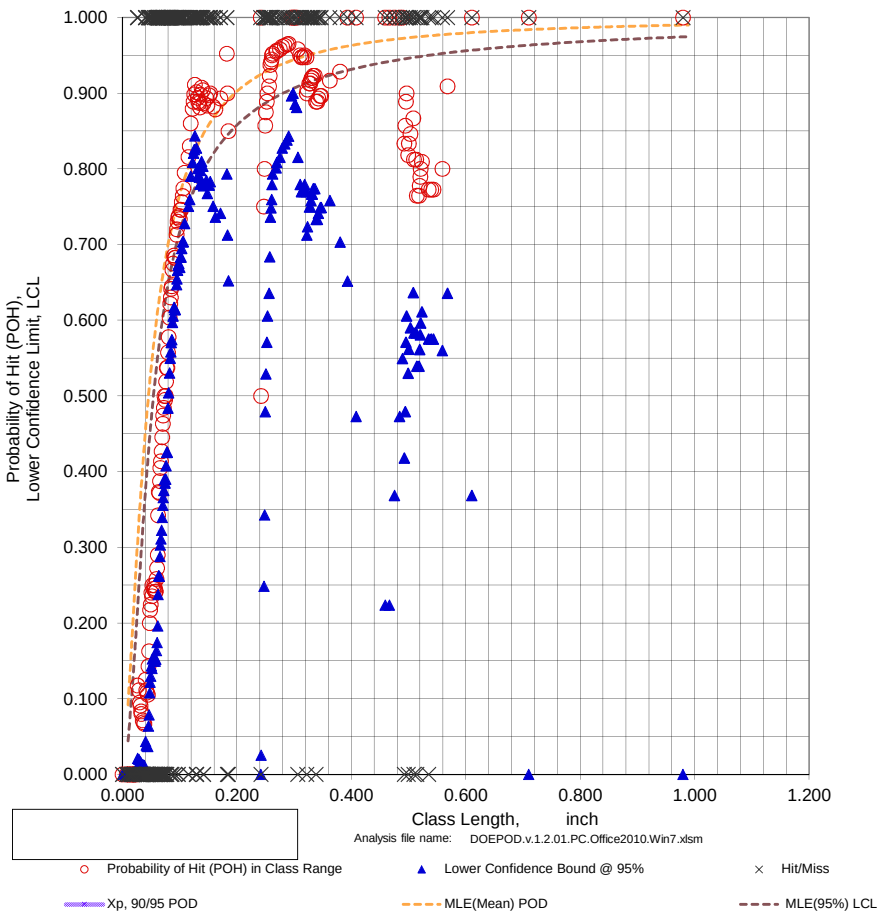
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 13 more large flaws.**

**Warning: No false call analysis.**




File Name = **A1002AL.XLS**

Data Set Name = **A1002AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:21 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0510 | inch |
| Classlength @ 90/95 Xpod = | 0.2980 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.200 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.285 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 22 | |
| Classlength Mid-point , Xm = | 0.489 | inch |
| Samples Needed @ Xm = | 24 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A1002AL.XLS
Data Set Name = A1002AL(CRACK #)

## Directed DOE Options

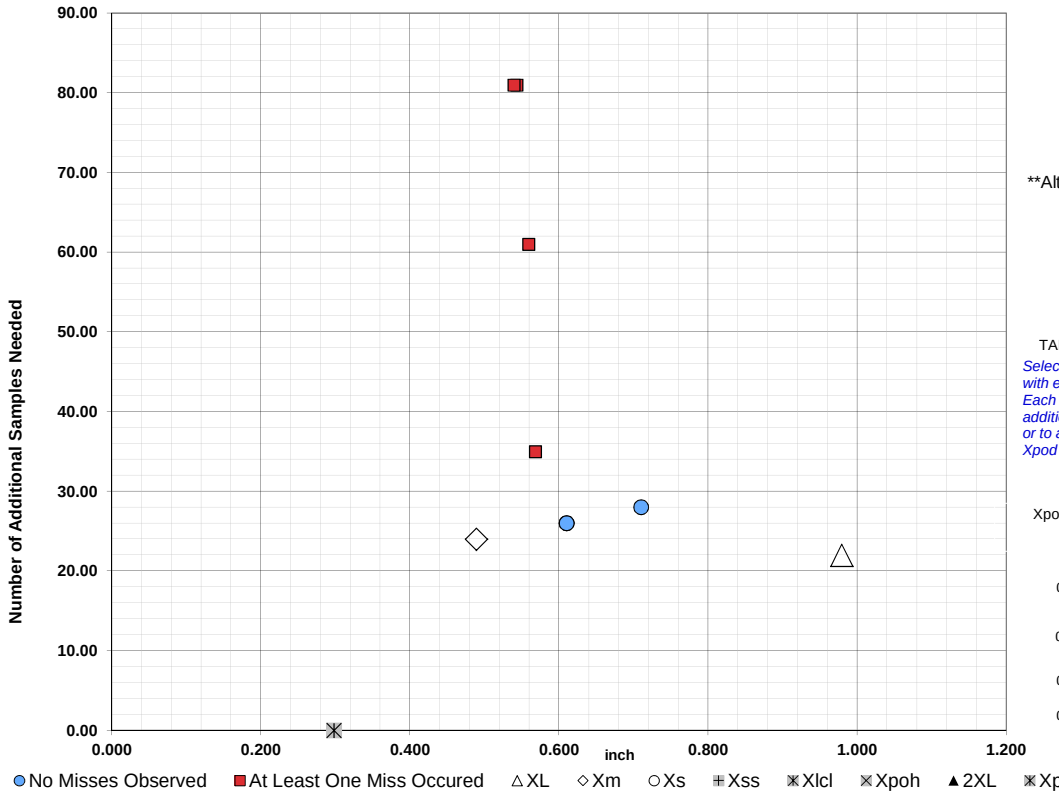



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 22 |
| Xm = | 0.489 | 24 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5680 | 35 |
| 0.5590 | 61 |
| 0.5430 | 81 |
| 0.5390 | 81 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.7100 | 28 |
| 0.6100 | 26 |
| 0.6100 | 26 |

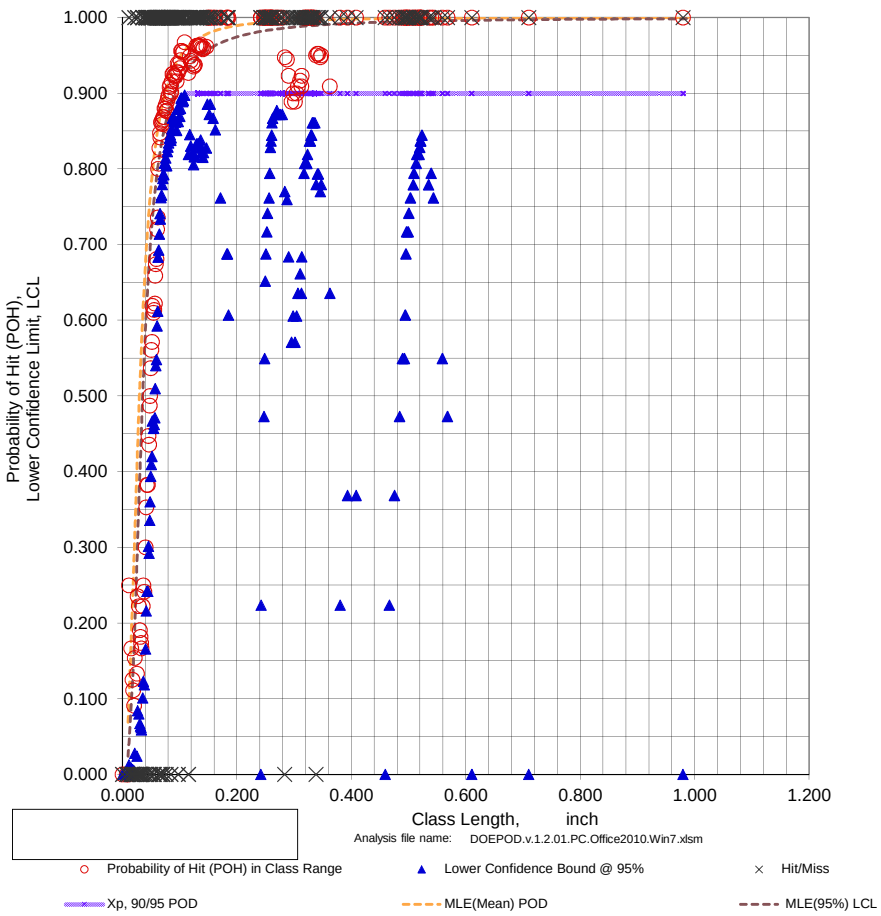
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A1002BL.XLS**

Data Set Name = **A1002BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:22 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0310 | inch |
| Classlength @ 90/95 Xpod = | 0.1080 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9672 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.095 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.336 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1310 | inch |

File Name = A1002BL.XLS
Data Set Name = A1002BL(CRACK #)

## Directed DOE Options

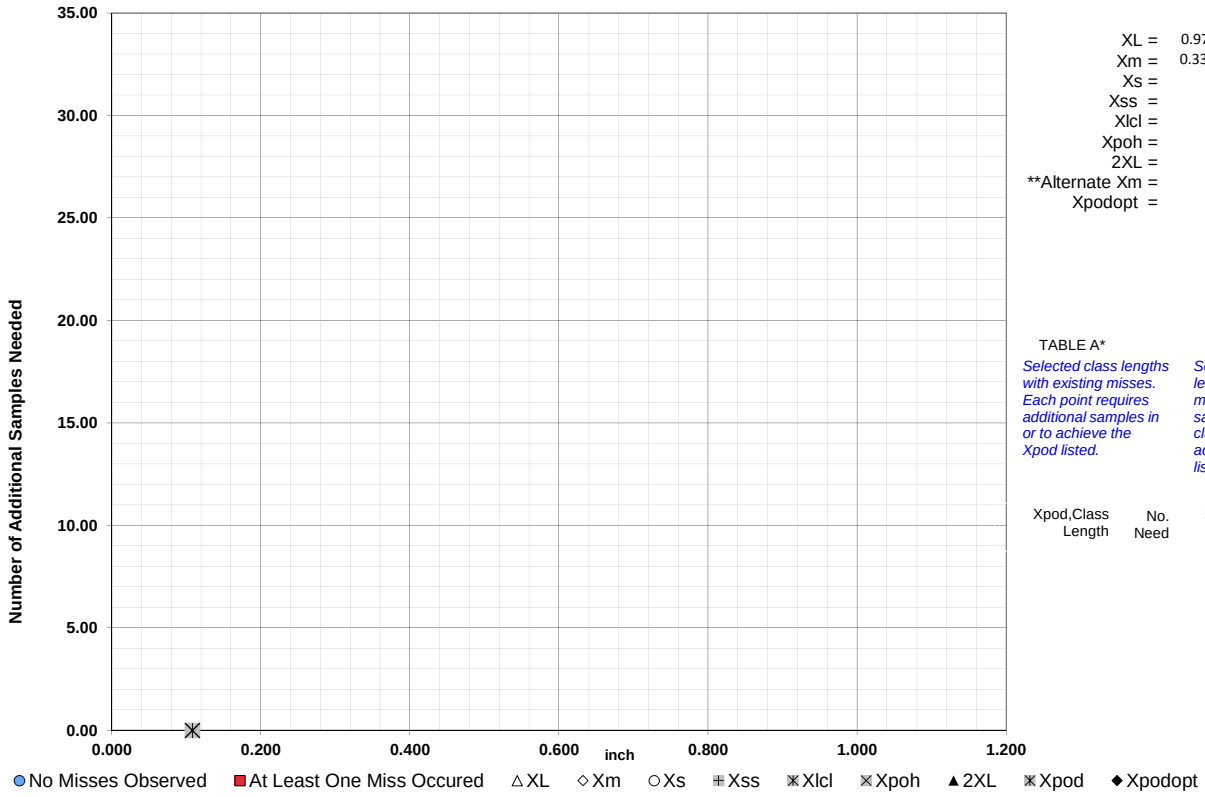



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.336 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

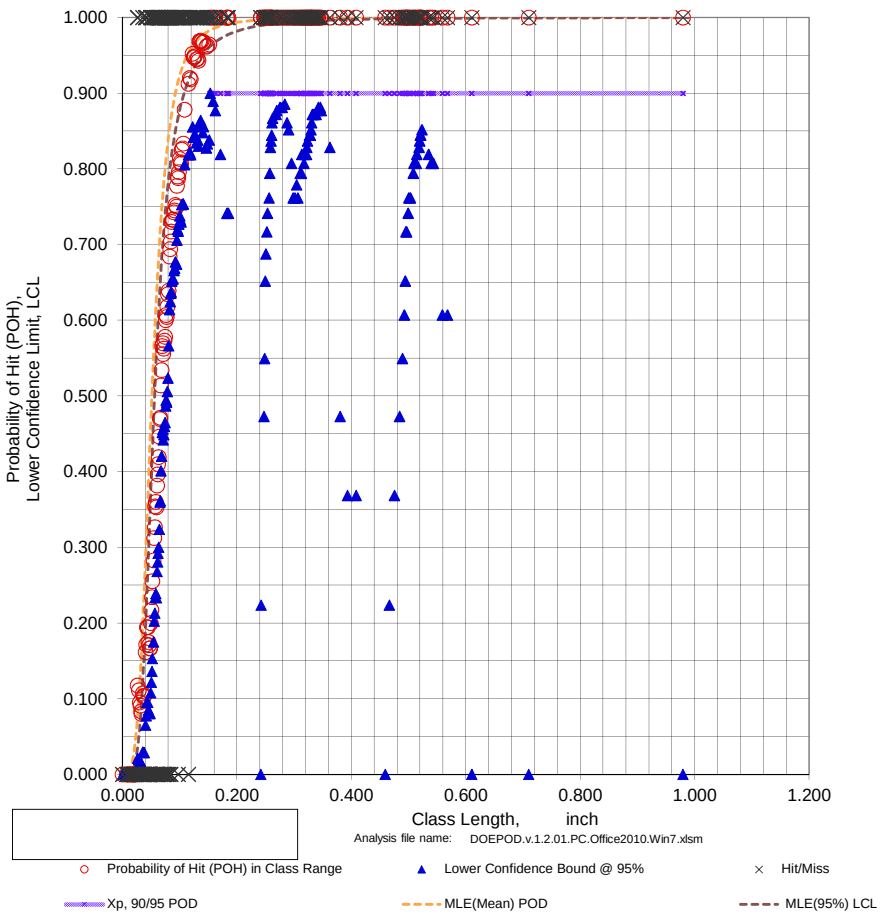
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A1002CL.XLS**

Data Set Name = **A1002CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:25 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0360 | inch |
| Classlength @ 90/95 Xpod = | 0.1530 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1170 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.275 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.410 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.523 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.152 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1530 | inch |

File Name = A1002CL.XLS
Data Set Name = A1002CL(CRACK #)

## Directed DOE Options

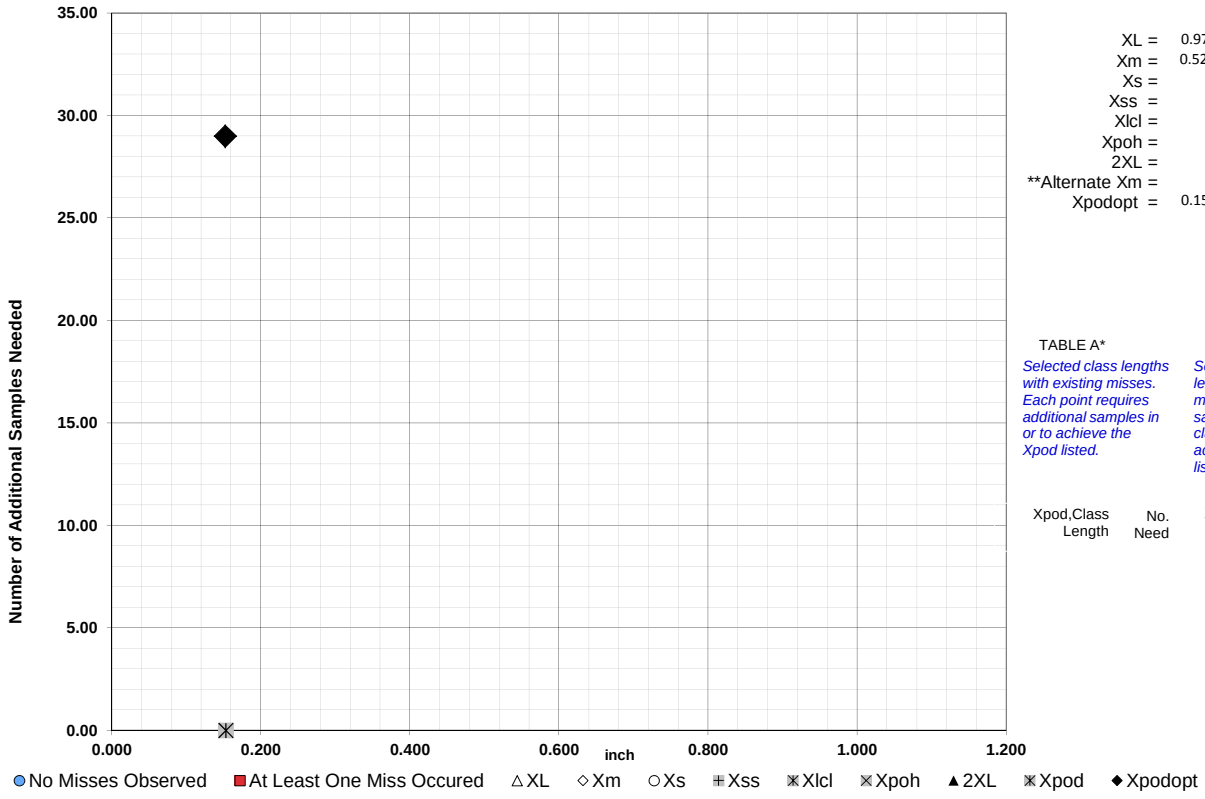



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | |
| Xm = | 0.523 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.152 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 4 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

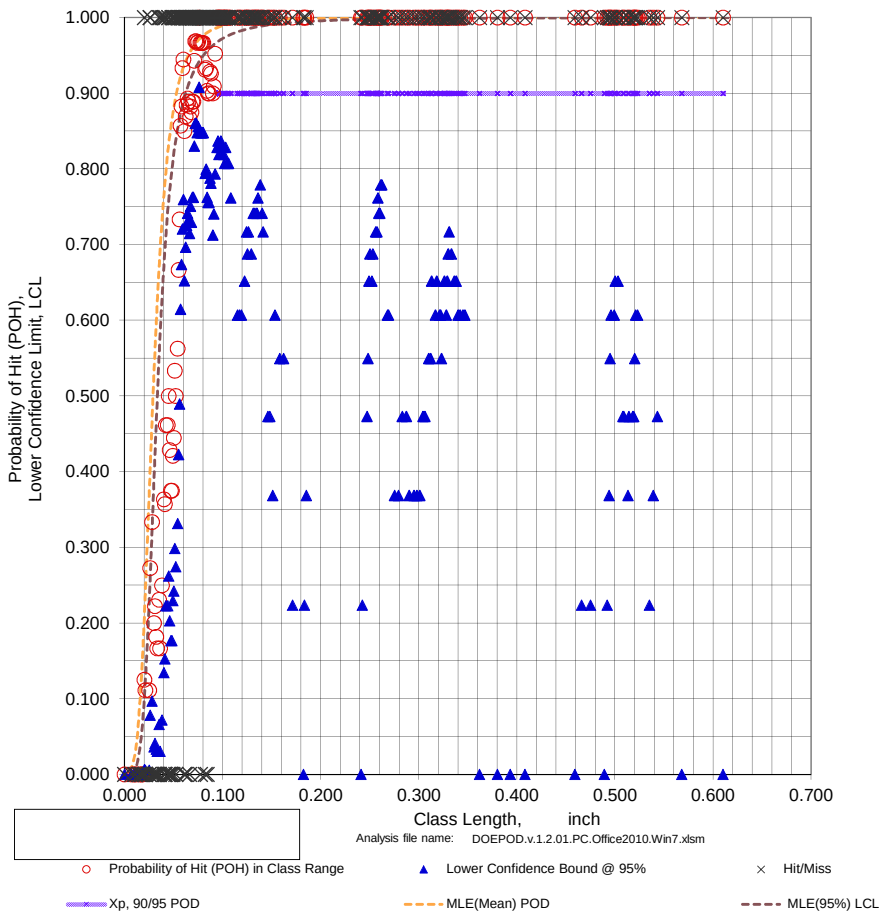
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A1003AL.XLS**

Data Set Name = **A1003AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:27 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0090 | inch |
| Classlength @ 90/95 Xpod = | 0.0760 | inch |
| Lower Confidence Bound = | 0.9077 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.915 | @ | 0.055 | inch |
| NTIAC 90/95 POD = | 0.913 | @ | 0.065 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0960 | inch |

File Name = A1003AL.XLS
Data Set Name = A1003AL(CRACK #)

## Directed DOE Options

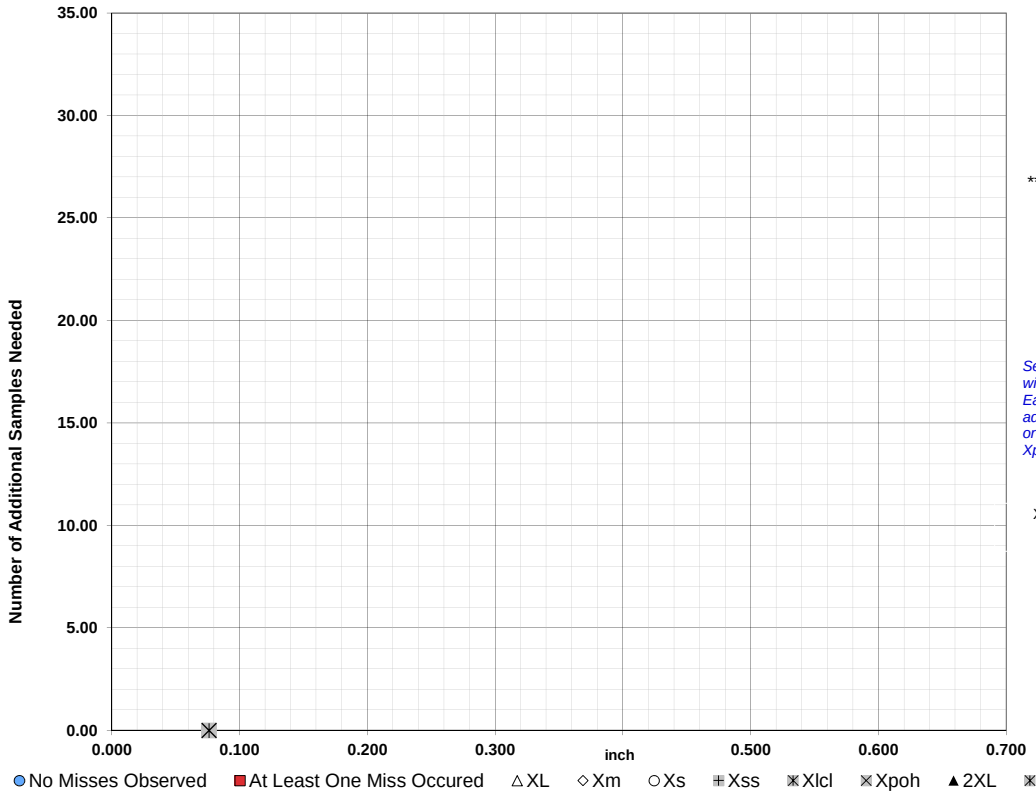



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.262 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 4 more large flaws.

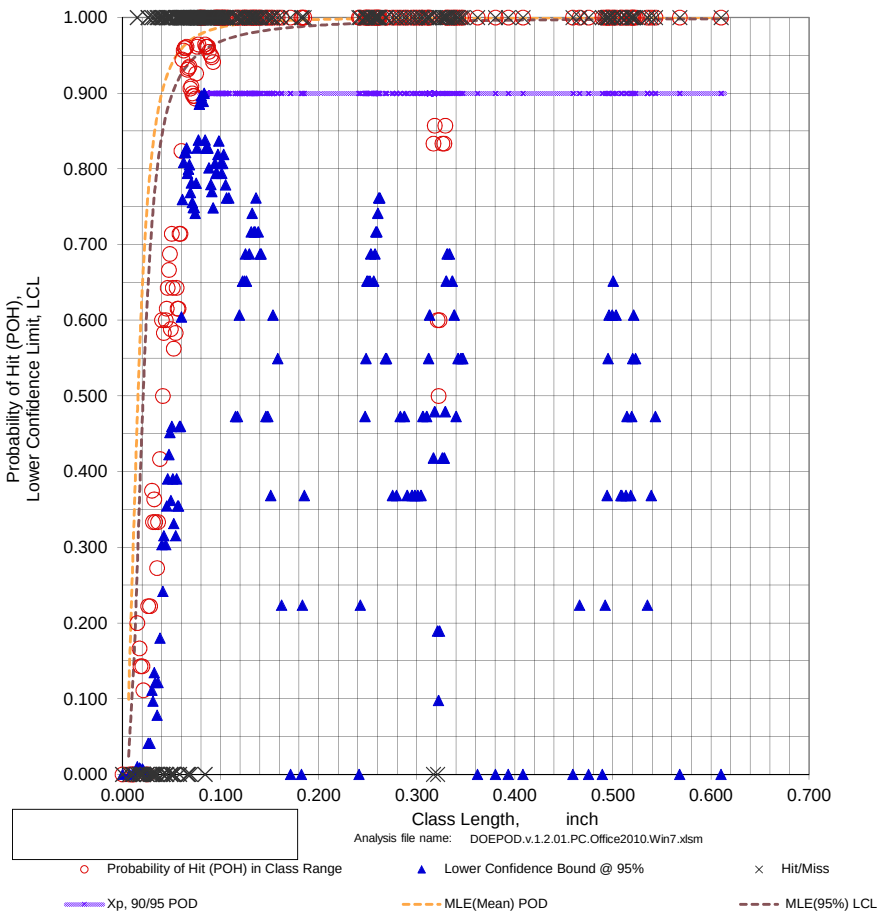
Any highlighted Misses are RED and shown in Column A of this data sheet

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = A1003BL.XLS

Data Set Name = A1003BL(CRACK #)




| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:30 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0080 | inch |
| Classlength @ 90/95 Xpod = | 0.0830 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.910 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.050 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0860 | inch |

File Name = A1003BL.XLS
Data Set Name = A1003BL(CRACK #)

## Directed DOE Options

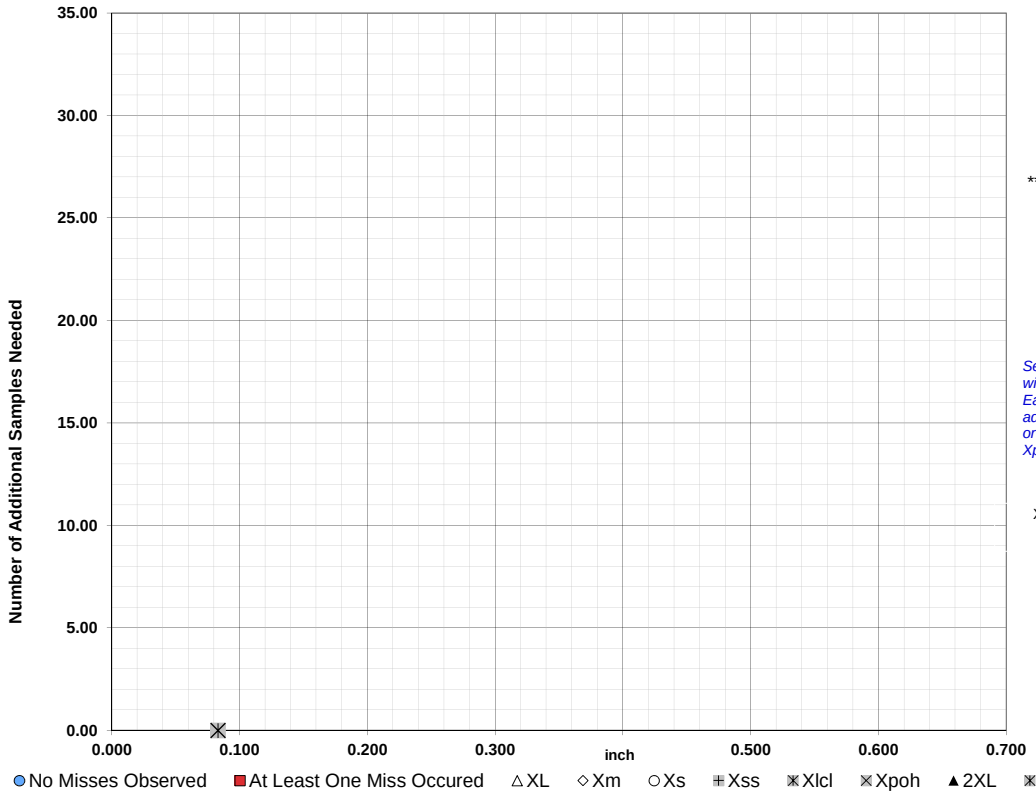



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.262 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

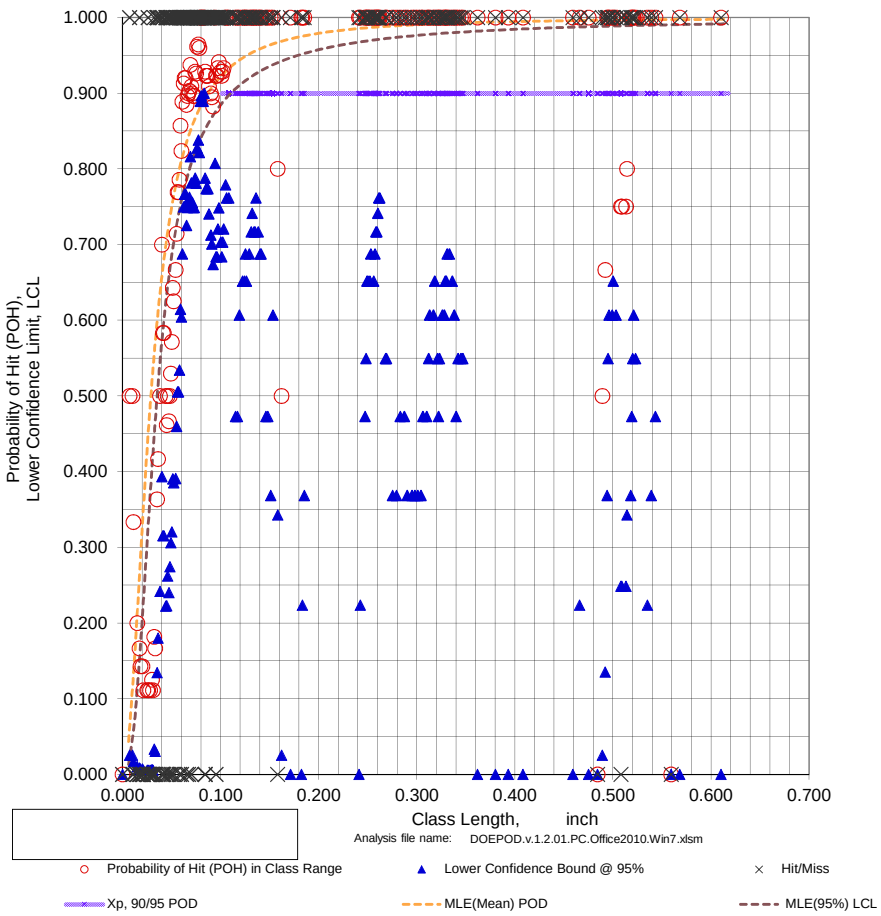
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 4 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A1003CL.XLS**

Data Set Name = **A1003CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:34 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0080 | inch |
| Classlength @ 90/95 Xpod = | 0.0830 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1080 | inch |

File Name = A1003CL.XLS
Data Set Name = A1003CL(CRACK #)

## Directed DOE Options

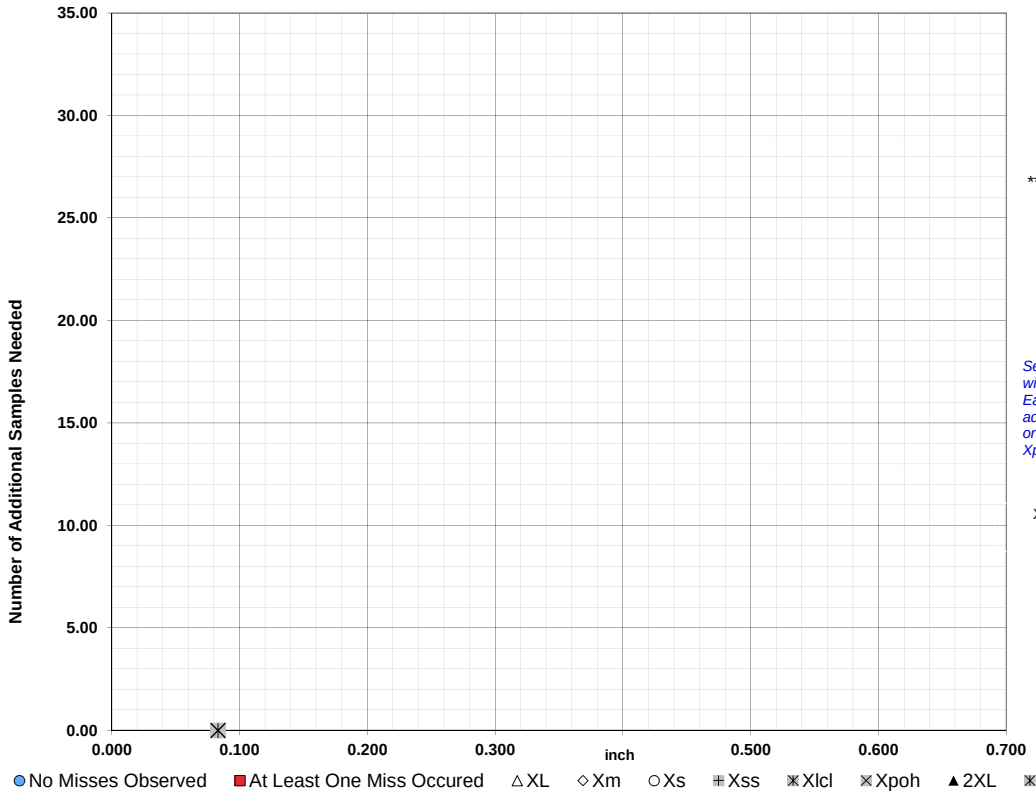



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.262 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

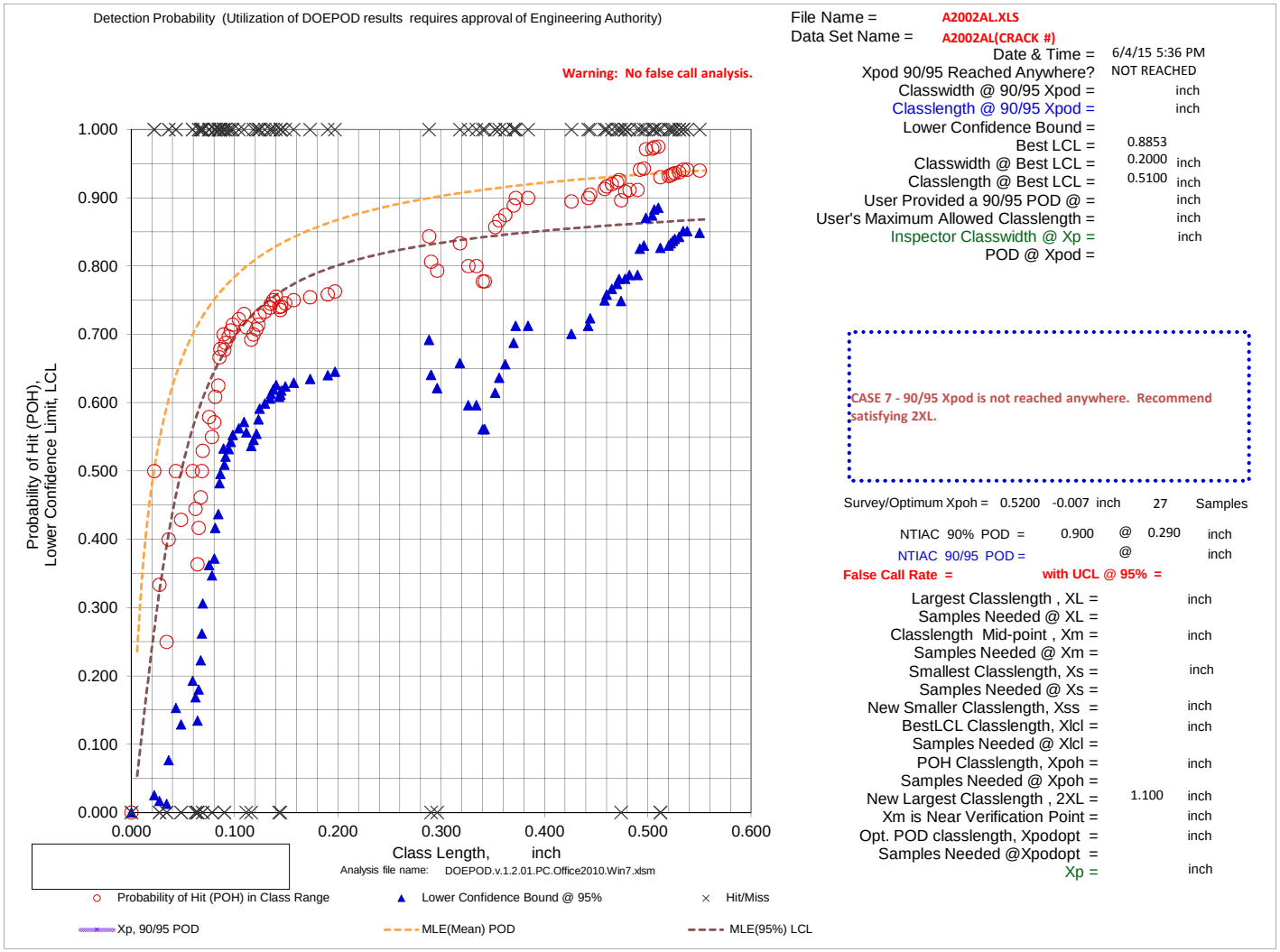
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = A2002AL.XLS
Data Set Name = A2002AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:36 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8853 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.5100 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.5200 -0.007 inch 27 Samples

NTIAC 90% POD = 0.900 @ 0.290 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.100 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A2002AL.XLS
Data Set Name = A2002AL(CRACK #)

## Directed DOE Options

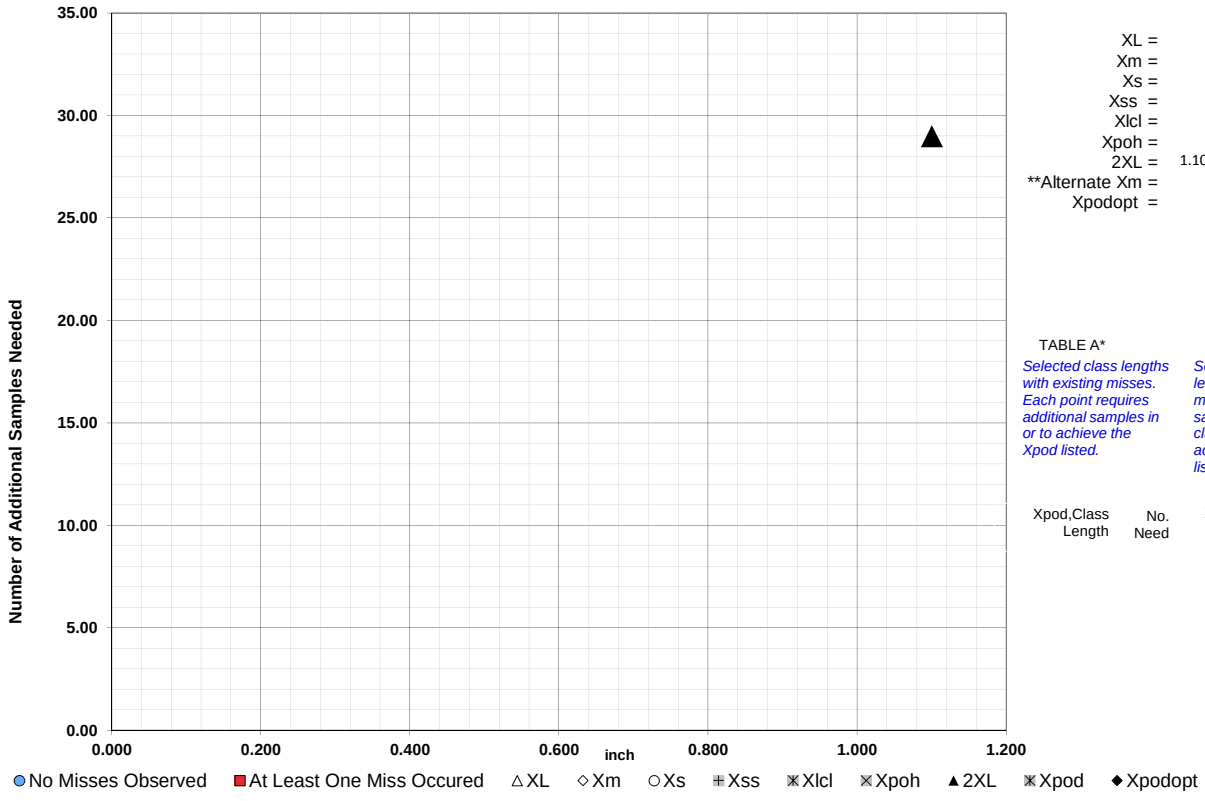



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.100 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

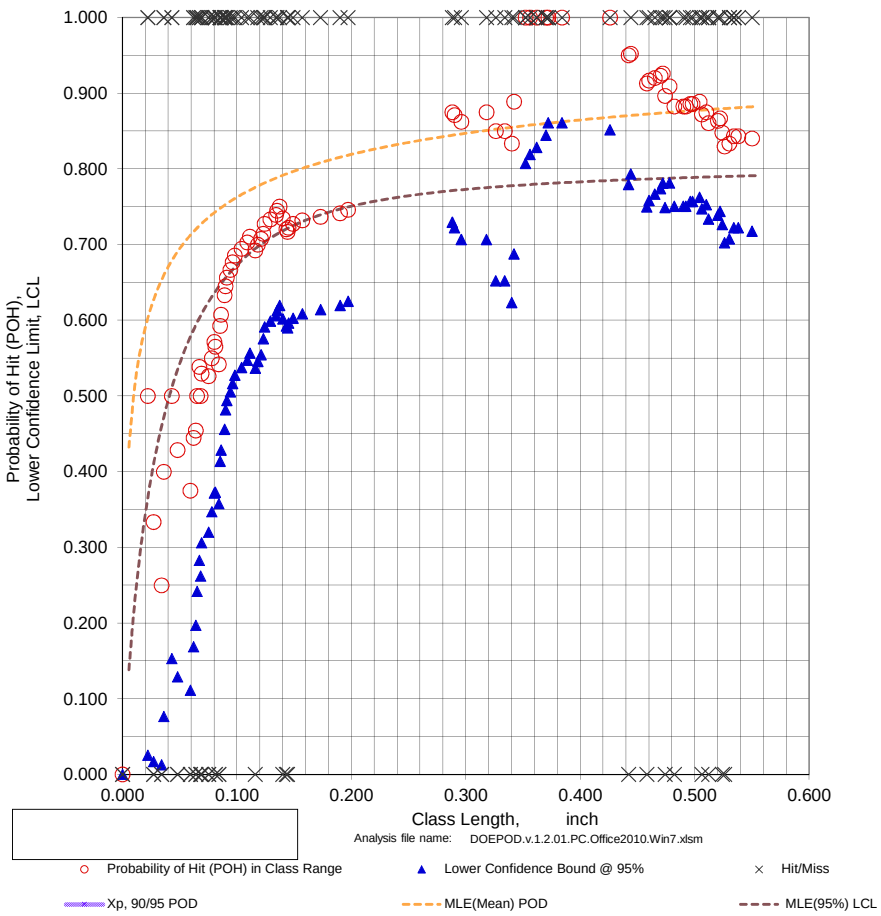
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A2002BL.XLS
Data Set Name = A2002BL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:38 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8609 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.3720 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.5300 -0.003 inch 27 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.100 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A2002BL.XLS
Data Set Name = A2002BL(CRACK #)

## Directed DOE Options

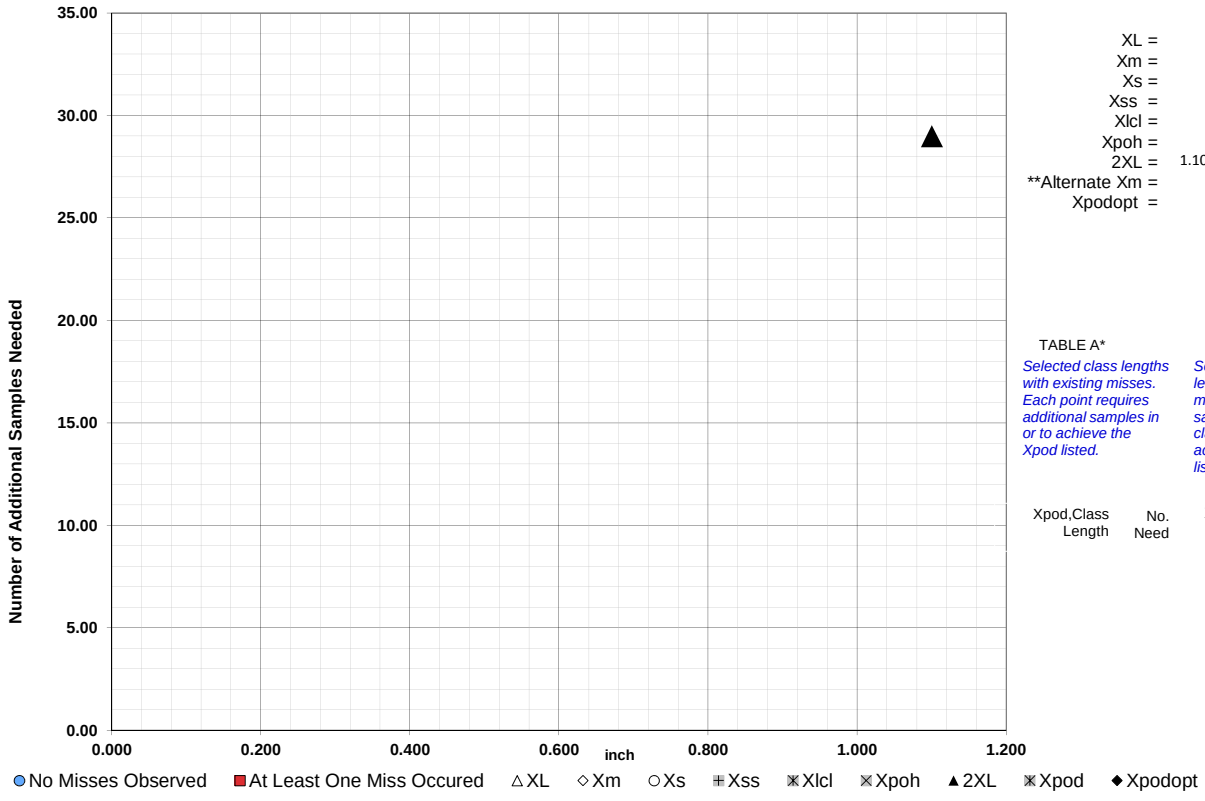



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.100 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

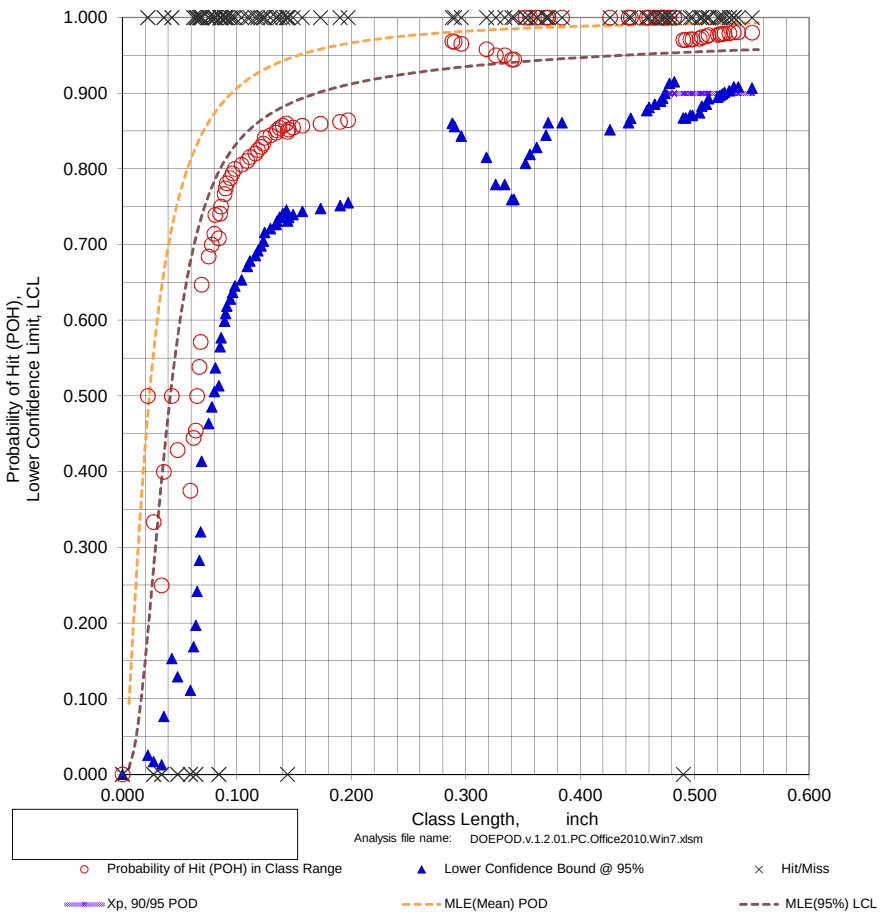
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.422.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A2002CL.XLS**

Data Set Name = **A2002CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:39 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.4740 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy alternate Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.170 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | 0 | |
| Classlength Mid-point , Xm = | 0.496 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.4740 | inch |

File Name = A2002CL.XLS
Data Set Name = A2002CL(CRACK #)

## Directed DOE Options

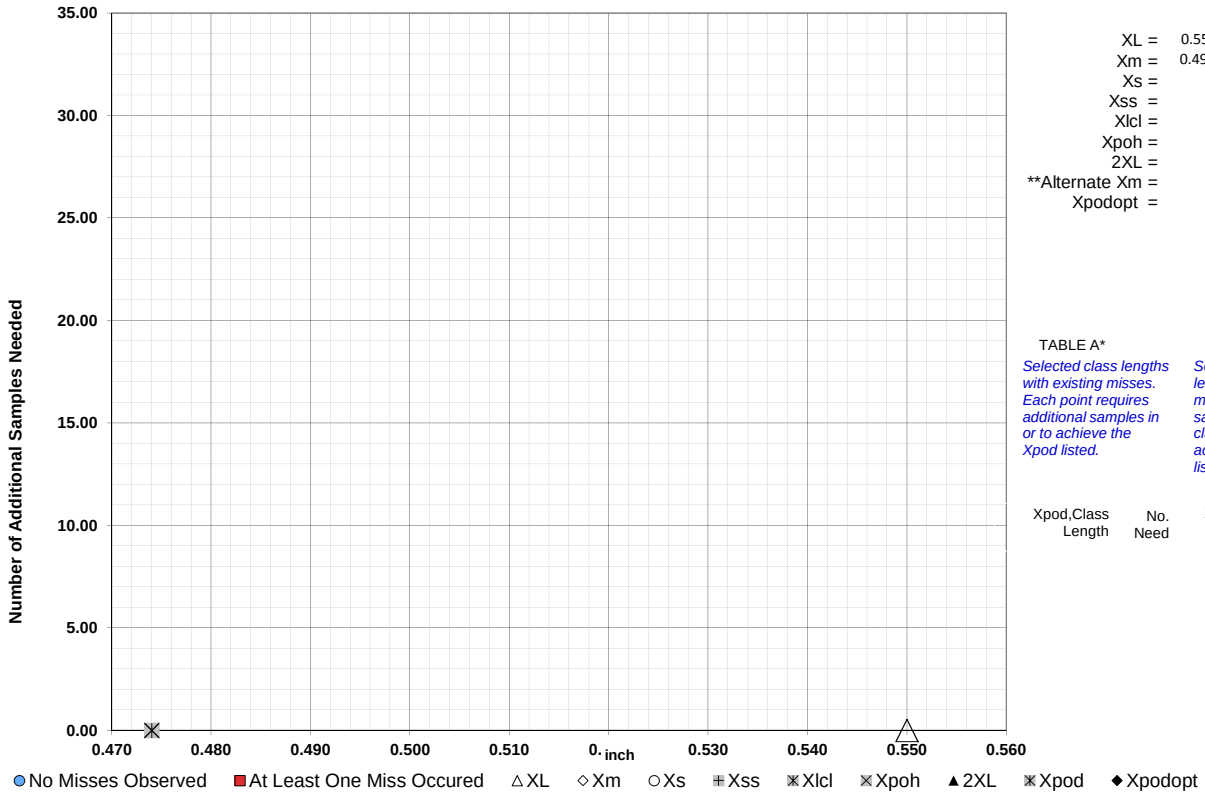



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | 0 |
| Xm = | 0.496 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

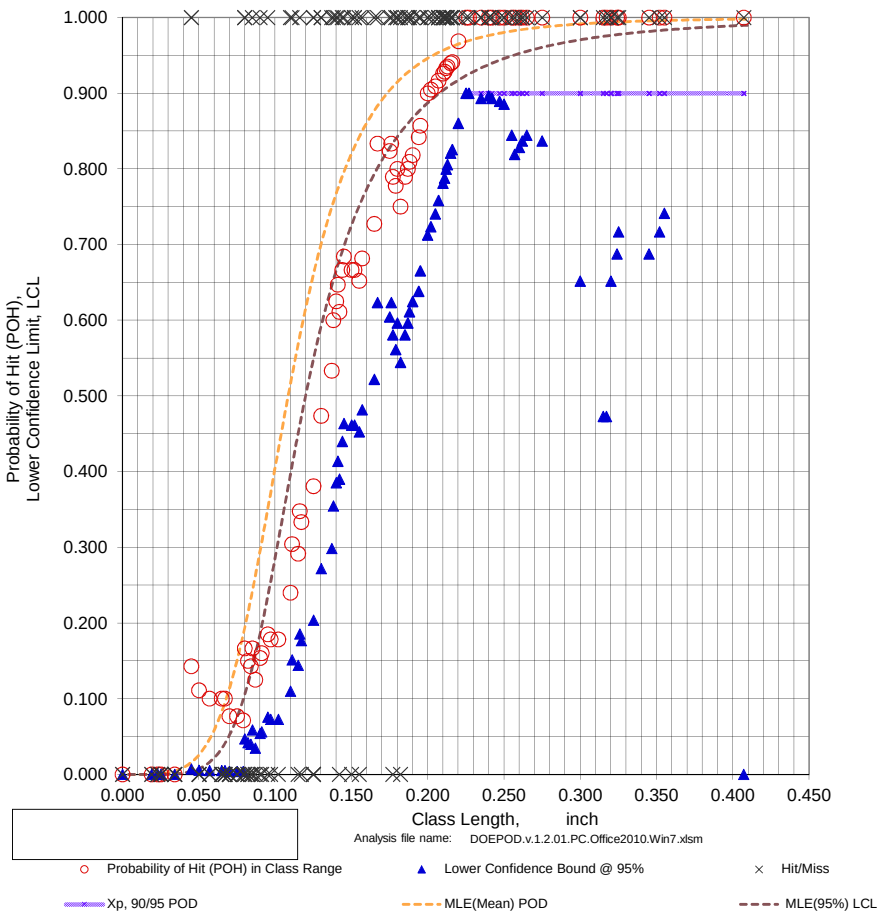
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.675.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A3001AL.XLS**

Data Set Name = **A3001AL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:40 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0400 | inch |
| Classlength @ 90/95 Xpod = | 0.2250 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1850 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.175 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.210 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.275 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.223 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.2250 | inch |

File Name = A3001AL.XLS
Data Set Name = A3001AL(CRK #)

## Directed DOE Options

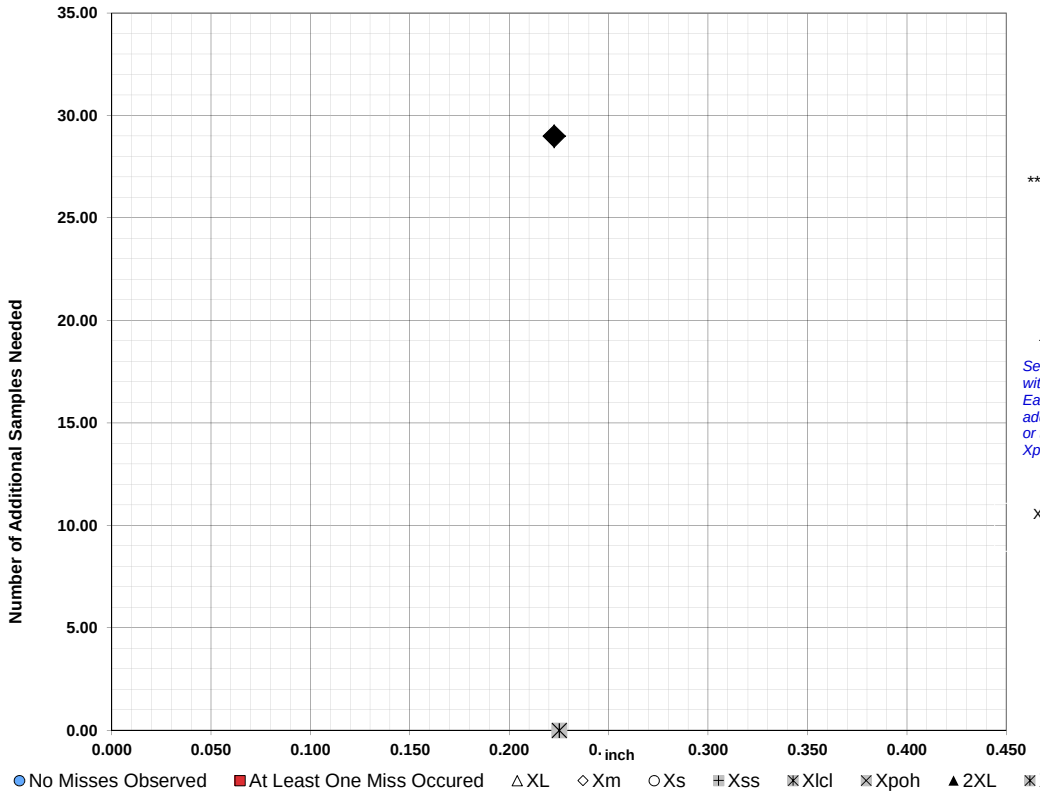



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.275 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.223 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

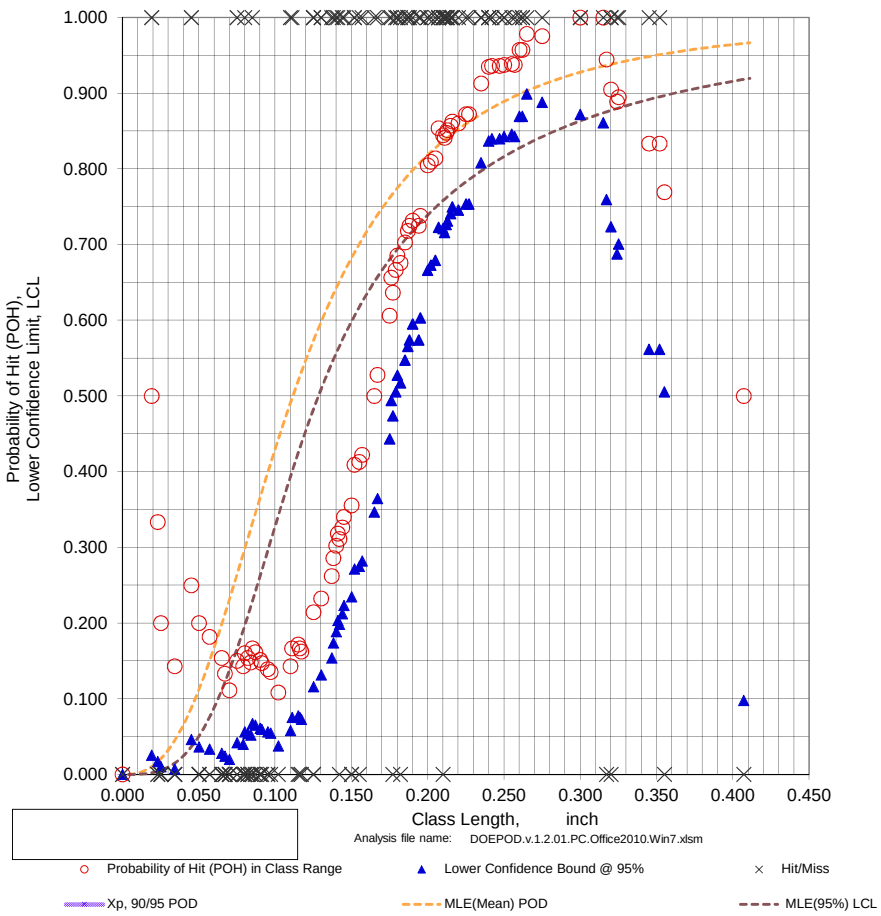
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.795.**

**Warning: No false call analysis.**




File Name = **A3001BL.XLS**

Data Set Name = **A3001BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:41 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0800 | inch |
| Classlength @ 90/95 Xpod = | 0.2650 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.265 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.365 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | 57 | |
| Classlength Mid-point , Xm = | 0.315 | inch |
| Samples Needed @ Xm = | 9 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A3001BL.XLS
Data Set Name = A3001BL(CRK #)

## Directed DOE Options

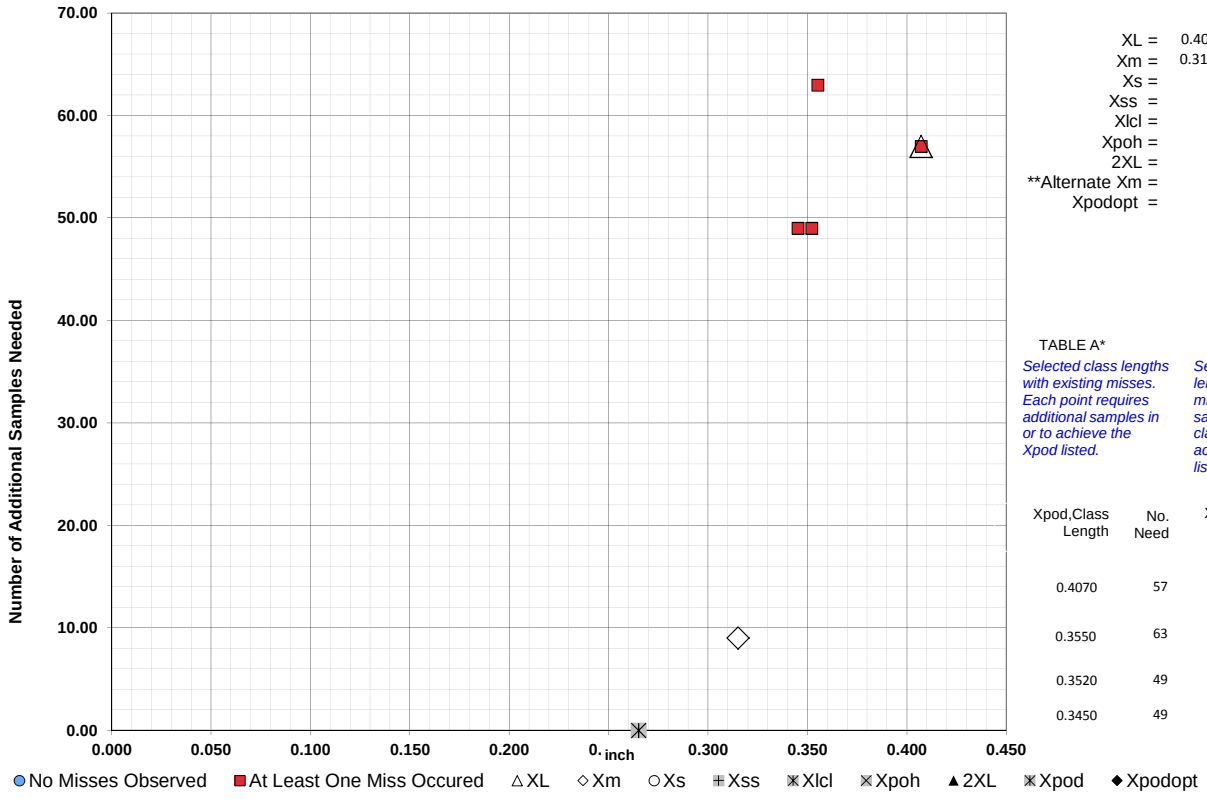



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | 57 |
| Xm = | 0.315 | 9 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4070 | 57 |
| 0.3550 | 63 |
| 0.3520 | 49 |
| 0.3450 | 49 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

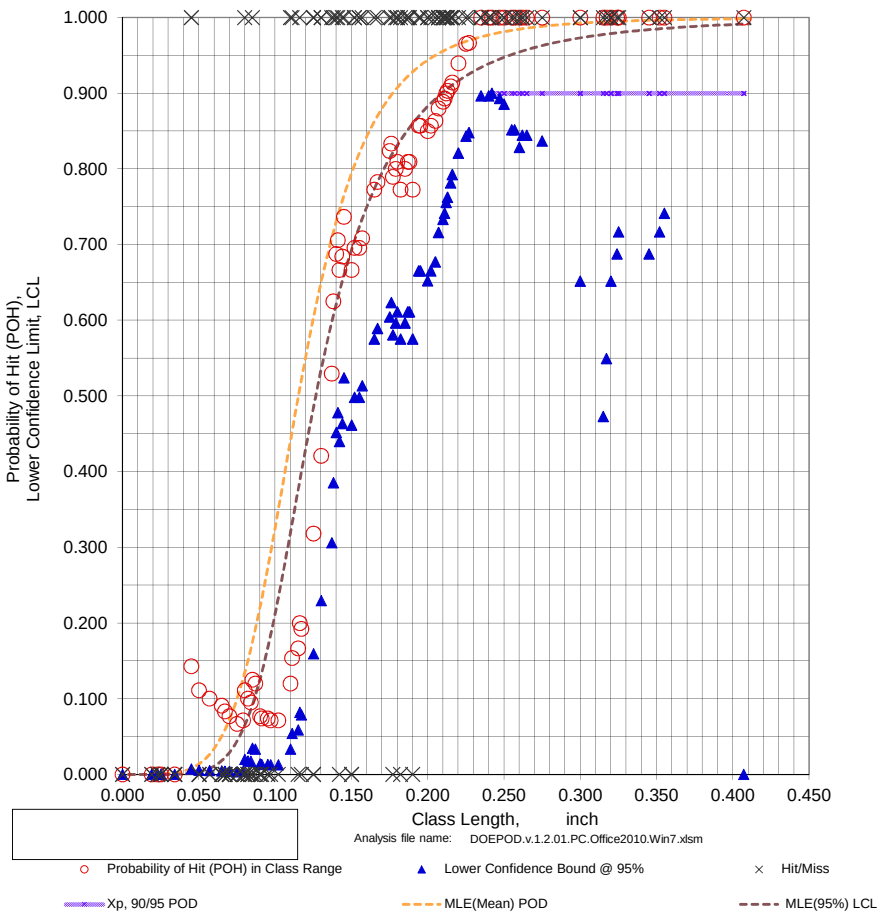
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.726.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A3001CL.XLS**

Data Set Name = **A3001CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:43 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0420 | inch |
| Classlength @ 90/95 Xpod = | 0.2420 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1940 -0.003 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.180 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.210 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.355 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.235 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.2420 | inch |

File Name = A3001CL.XLS
Data Set Name = A3001CL(CRK #)

## Directed DOE Options

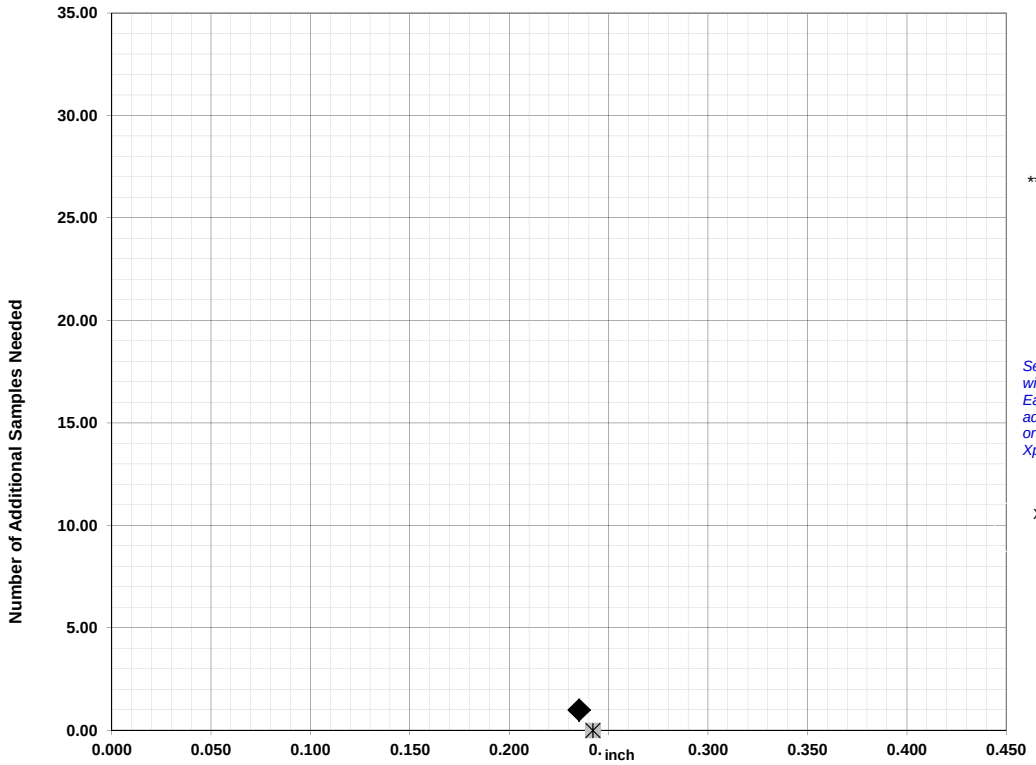



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.355 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.235 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

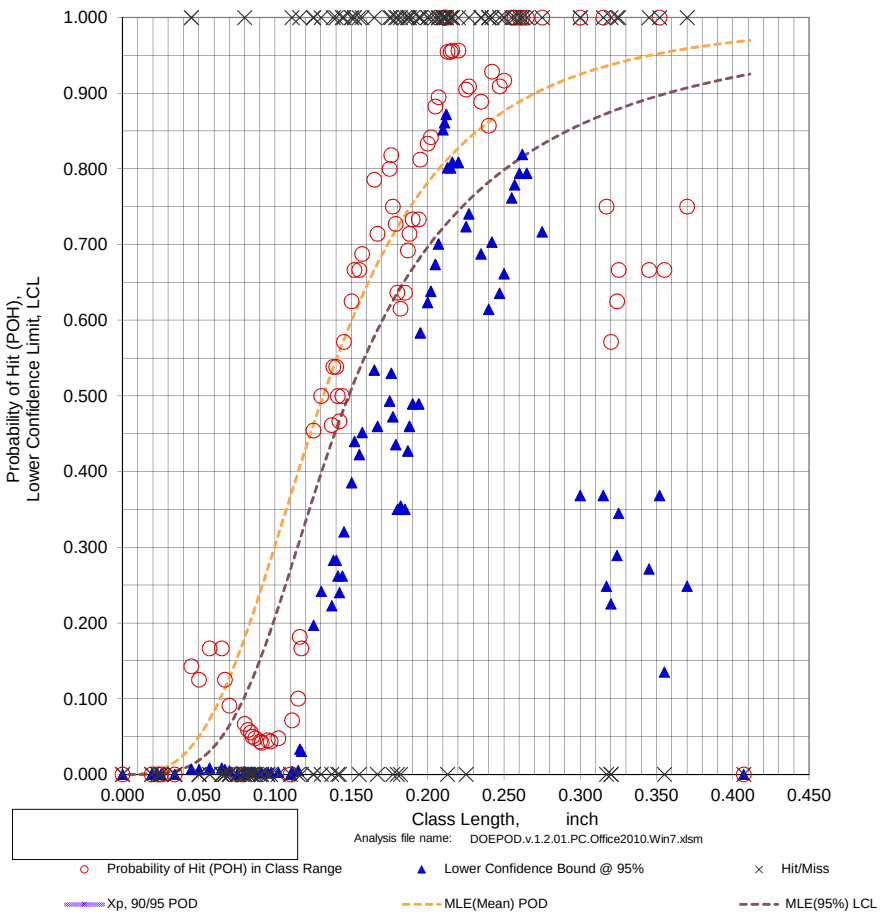
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A3003AL.XLS
Data Set Name = A3003AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:43 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8719 | |
| Classwidth @ Best LCL = | 0.0270 | inch |
| Classlength @ Best LCL = | 0.2120 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.275 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.360 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A3003AL.XLS
Data Set Name = A3003AL(CRK #)

## Directed DOE Options

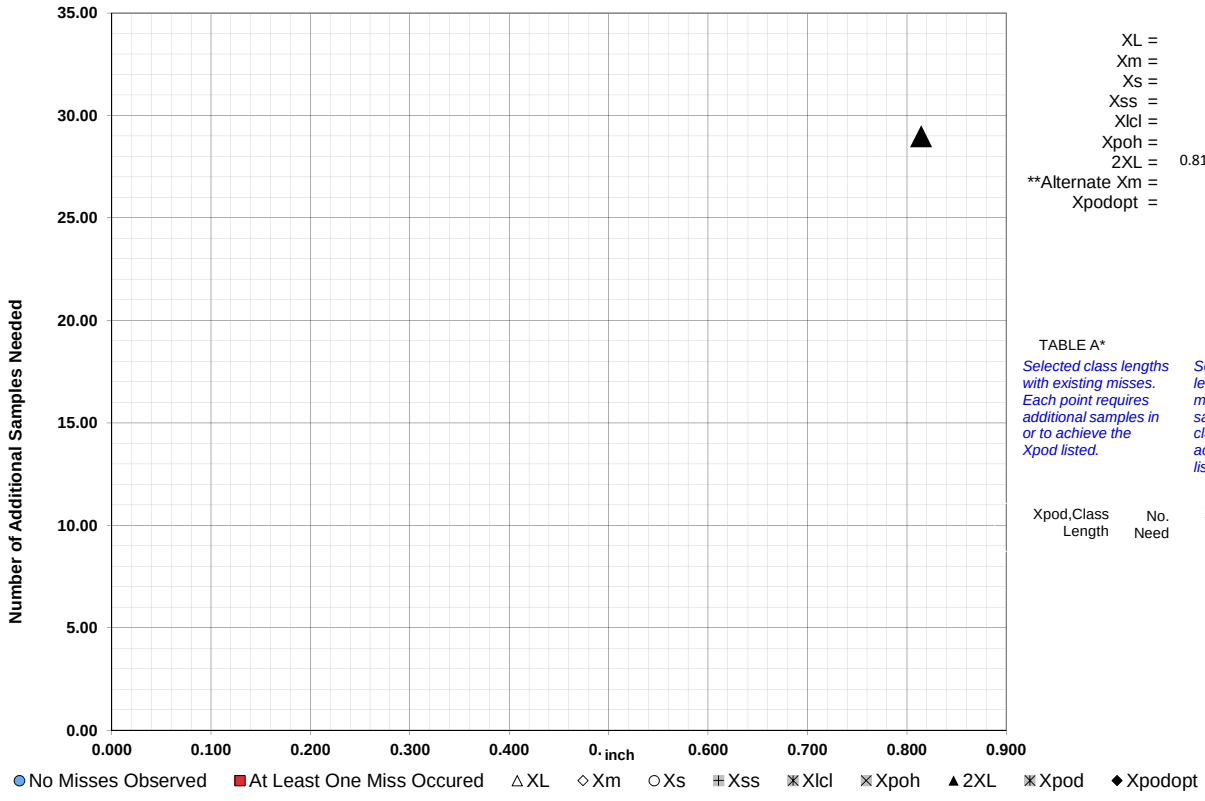



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | |
| Xm = | |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | 0.814 29 |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

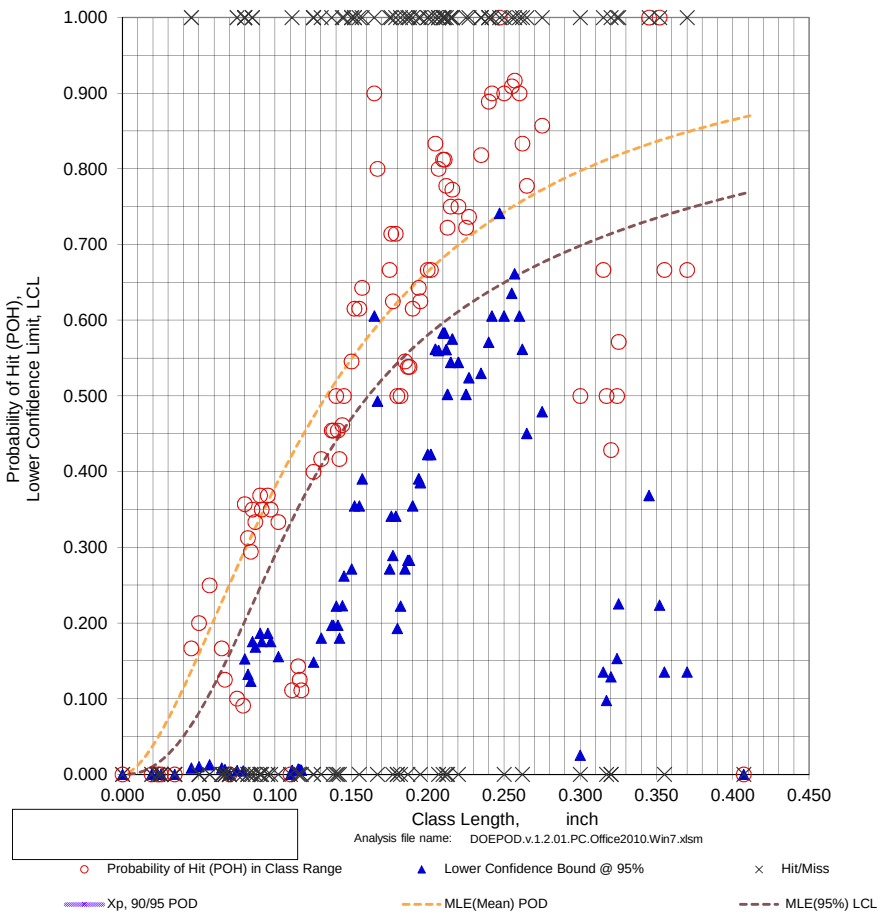
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A3003BL.XLS
Data Set Name = A3003BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:45 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0220 | inch |
| Classlength @ Best LCL = | 0.2470 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ 0.490 | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A3003BL.XLS
Data Set Name = A3003BL(CRK #)

## Directed DOE Options

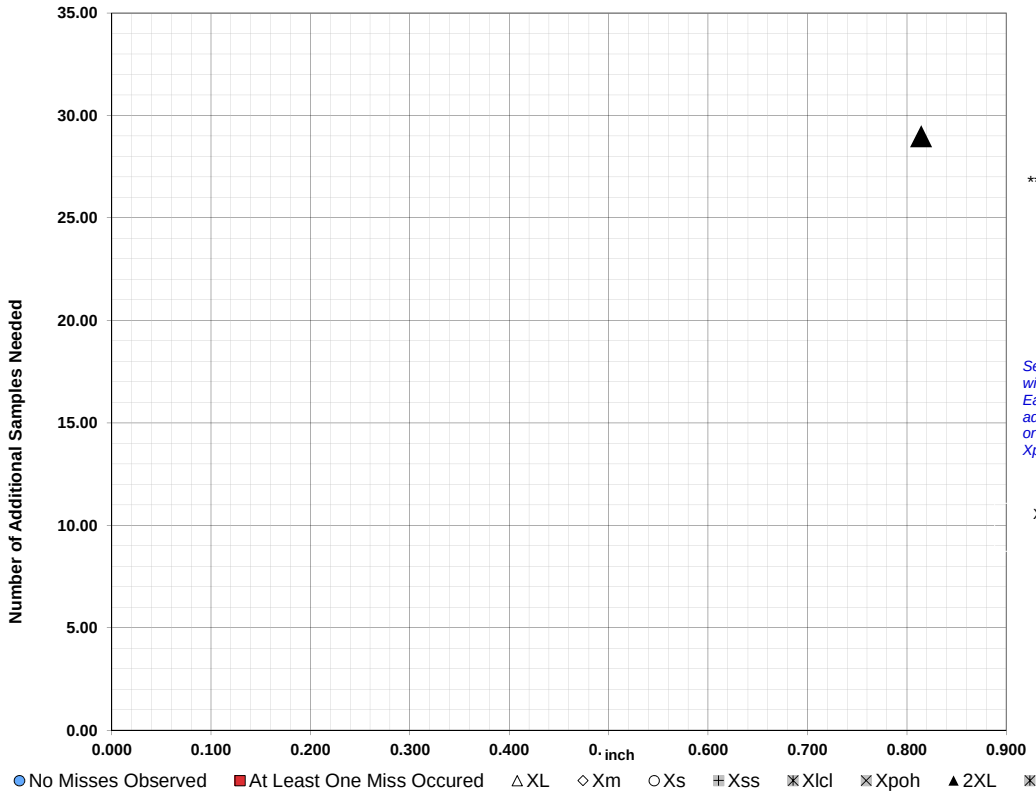



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

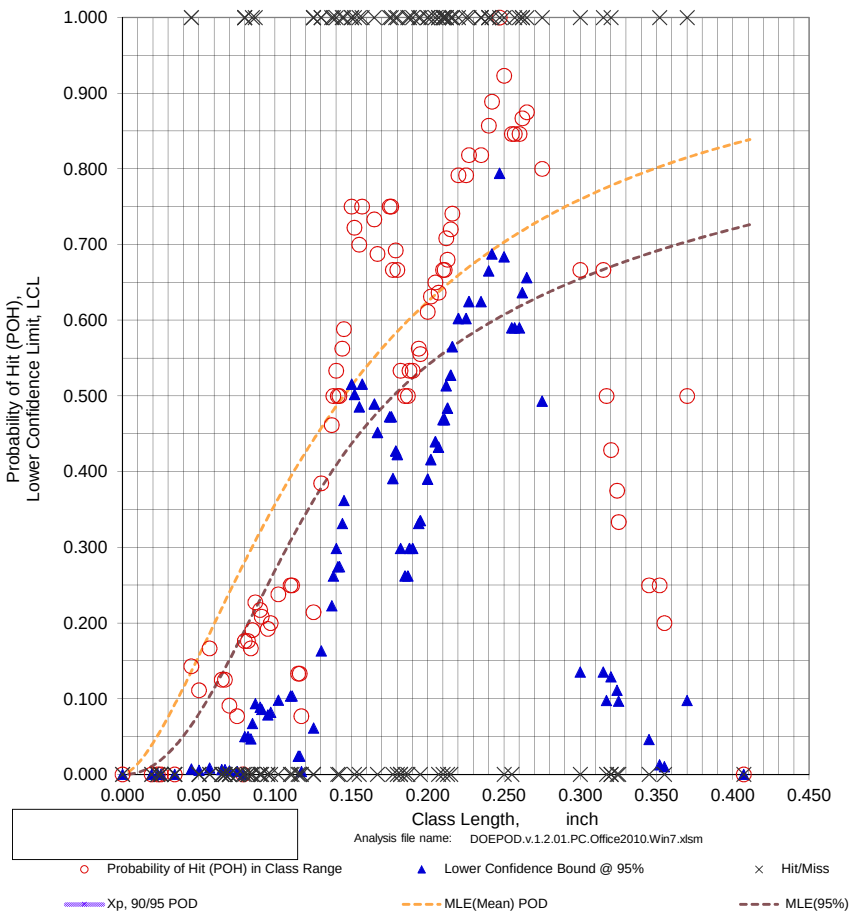
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A3003CL.XLS
Data Set Name = A3003CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:46 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0310 | inch |
| Classlength @ Best LCL = | 0.2470 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.901 @ 0.585 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A3003CL.XLS
Data Set Name = A3003CL(CRK #)

## Directed DOE Options

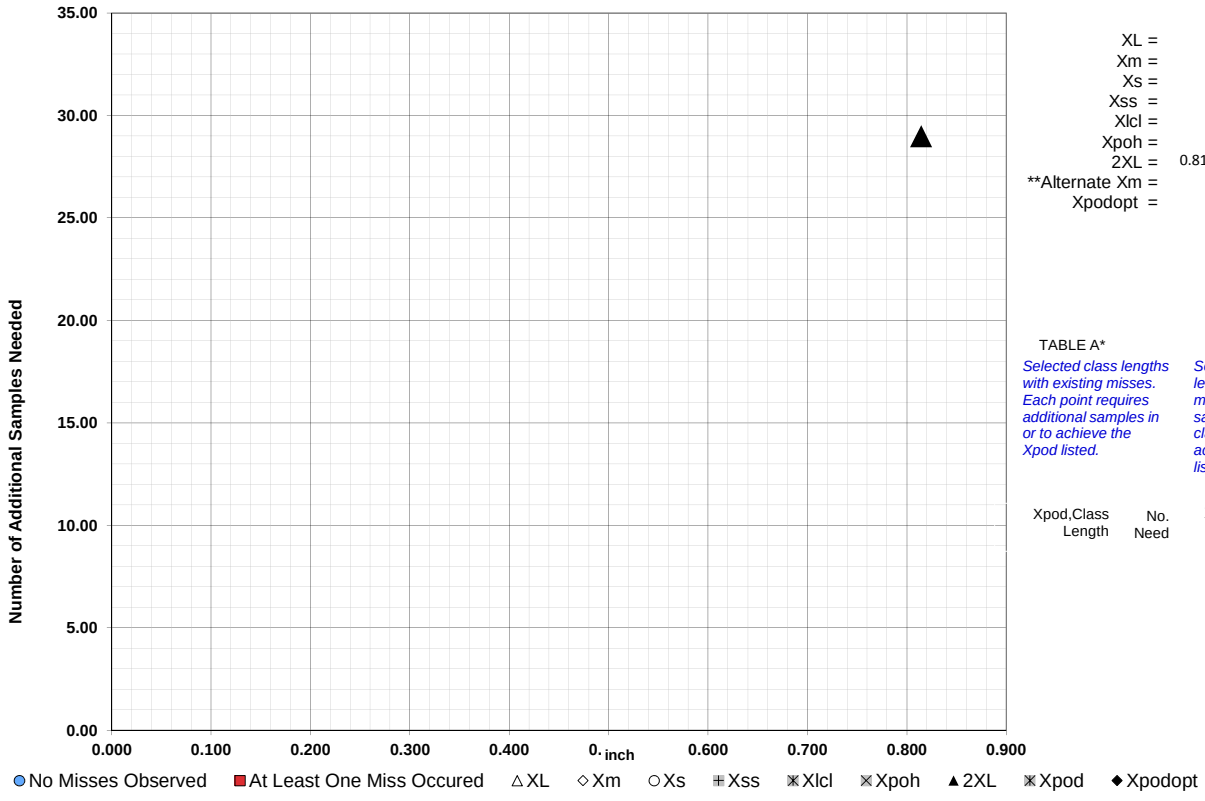



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

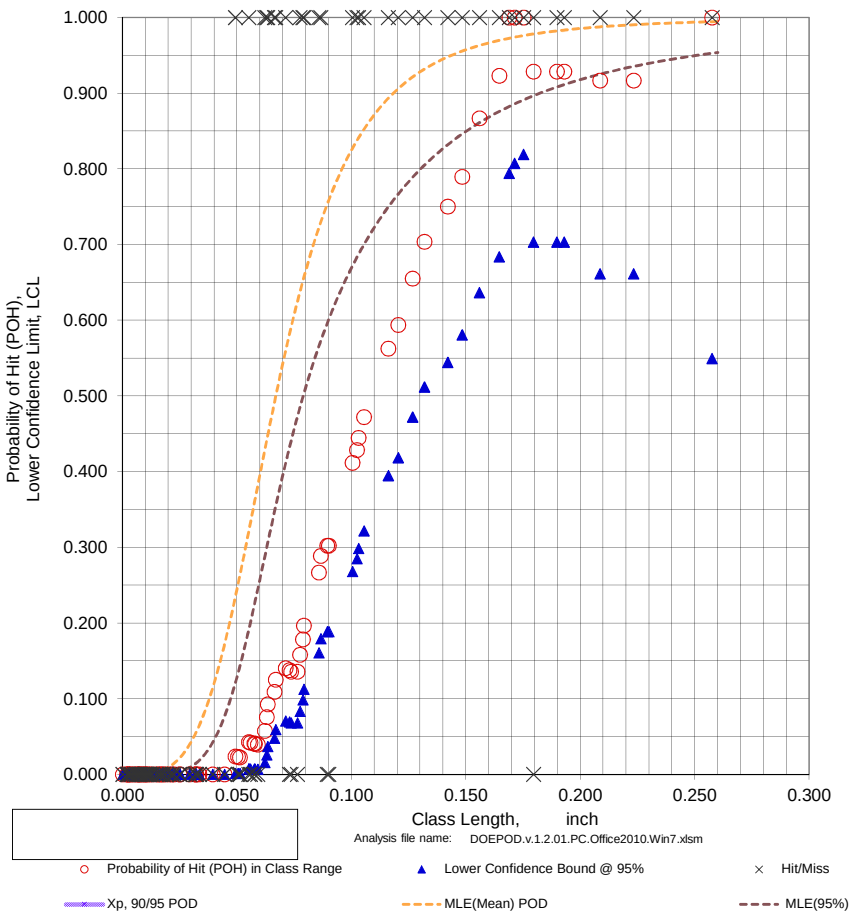
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A400011.XLS
Data Set Name = A400011(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:48 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.0750 | inch |
| Classlength @ Best LCL = | 0.1752 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1898 -0.010 inch 28 Samples

NTIAC 90% POD = 0.905 @ 0.120 inch
NTIAC 90/95 POD = 0.903 @ 0.185 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.257 | inch |
| Samples Needed @ Xpoh = | 24 | |
| New Largest Classlength , 2XL = | 0.515 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A400011.XLS
Data Set Name = A400011(HOLE #)

## Directed DOE Options

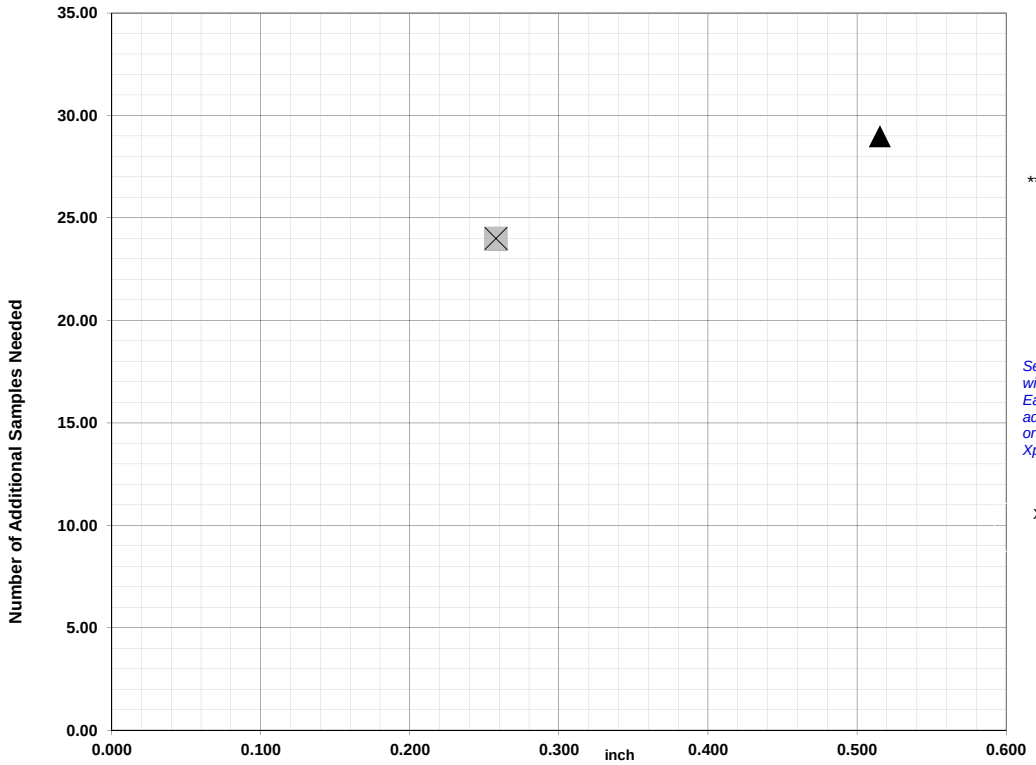



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 24 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.257 | 24 |
| 2XL = | 0.515 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

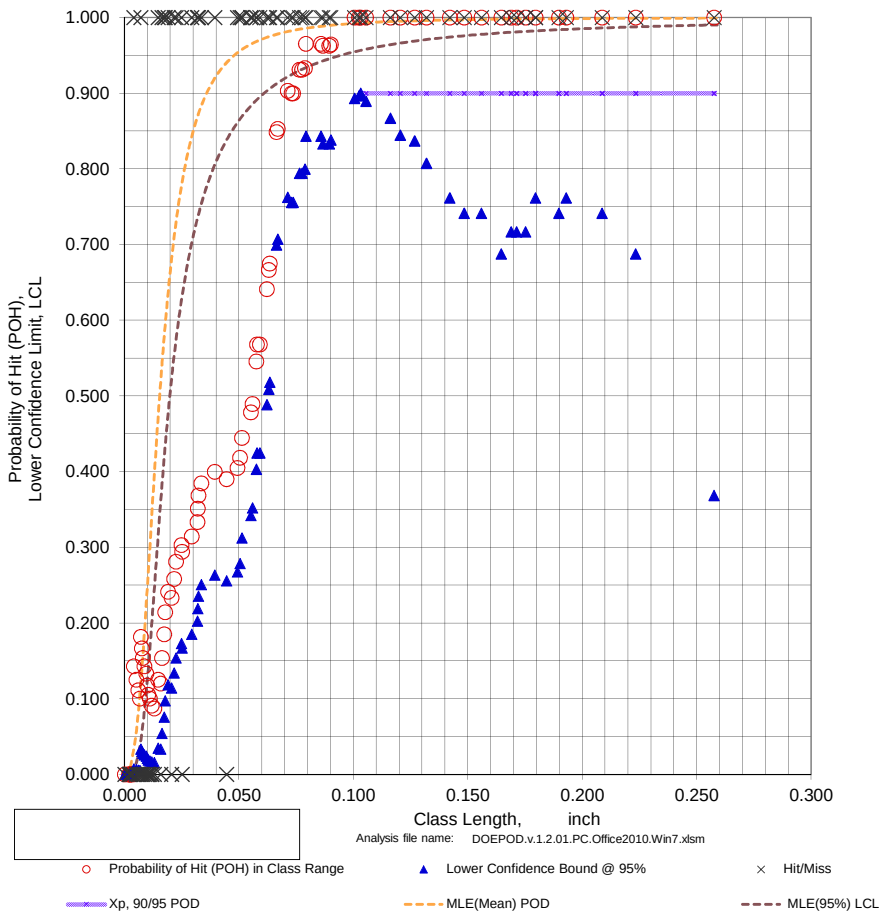
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.30942.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A400013.XLS**

Data Set Name = **A400013(HOLE #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:49 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0540 | inch |
| Classlength @ 90/95 Xpod = | 0.1031 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0492 -0.004 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.923 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.910 | @ | 0.065 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.193 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.100 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.1031 | inch |

File Name = A400013.XLS
Data Set Name = A400013(HOLE #)

## Directed DOE Options

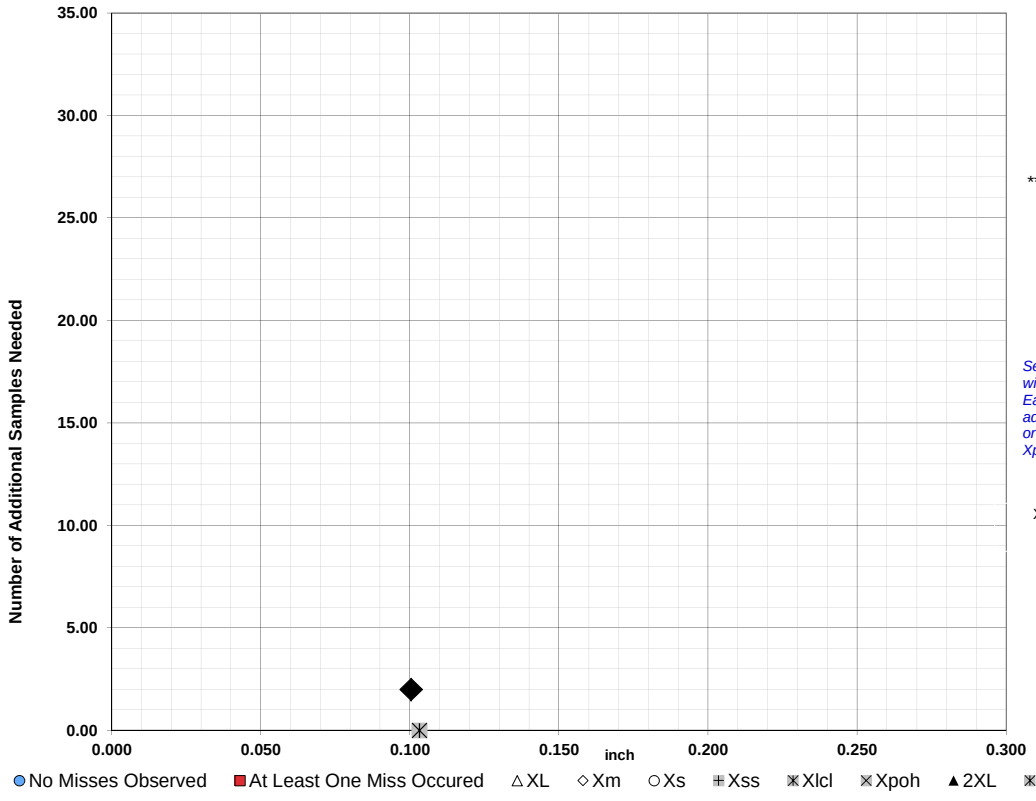



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | |
| Xm = | 0.193 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.100 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

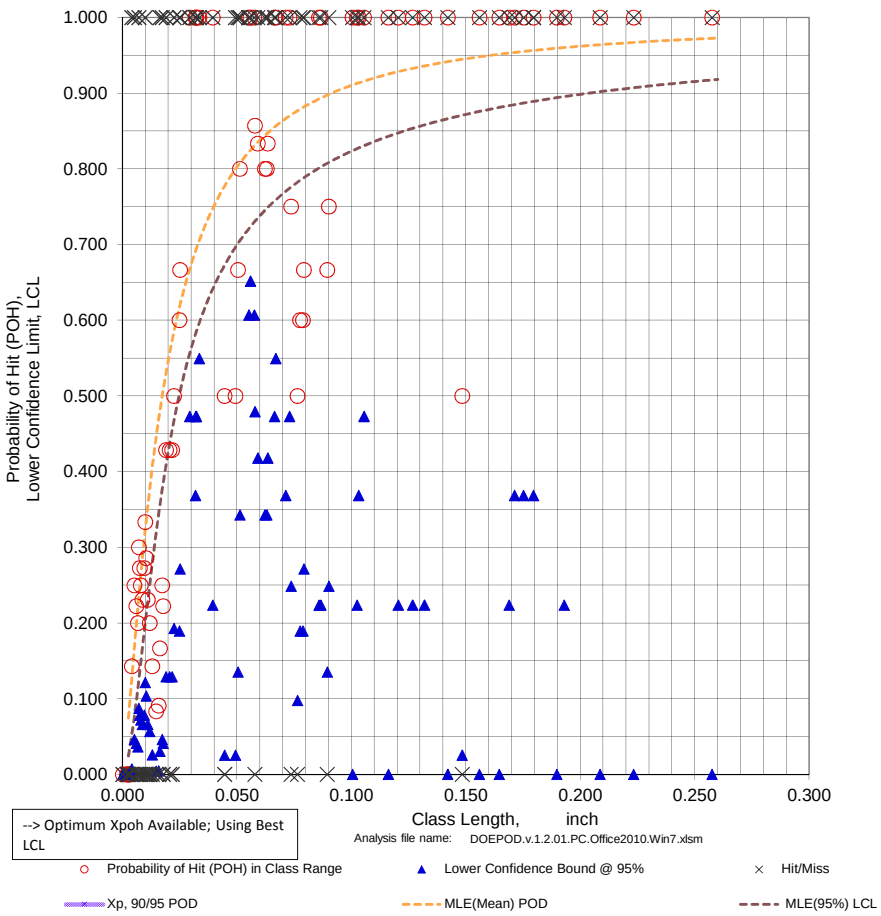
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A400014.XLS
Data Set Name = A400014(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:50 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6518 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0559 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1559 -0.007 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.205 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.156 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.515 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A400014.XLS
Data Set Name = A400014(HOLE #)

## Directed DOE Options

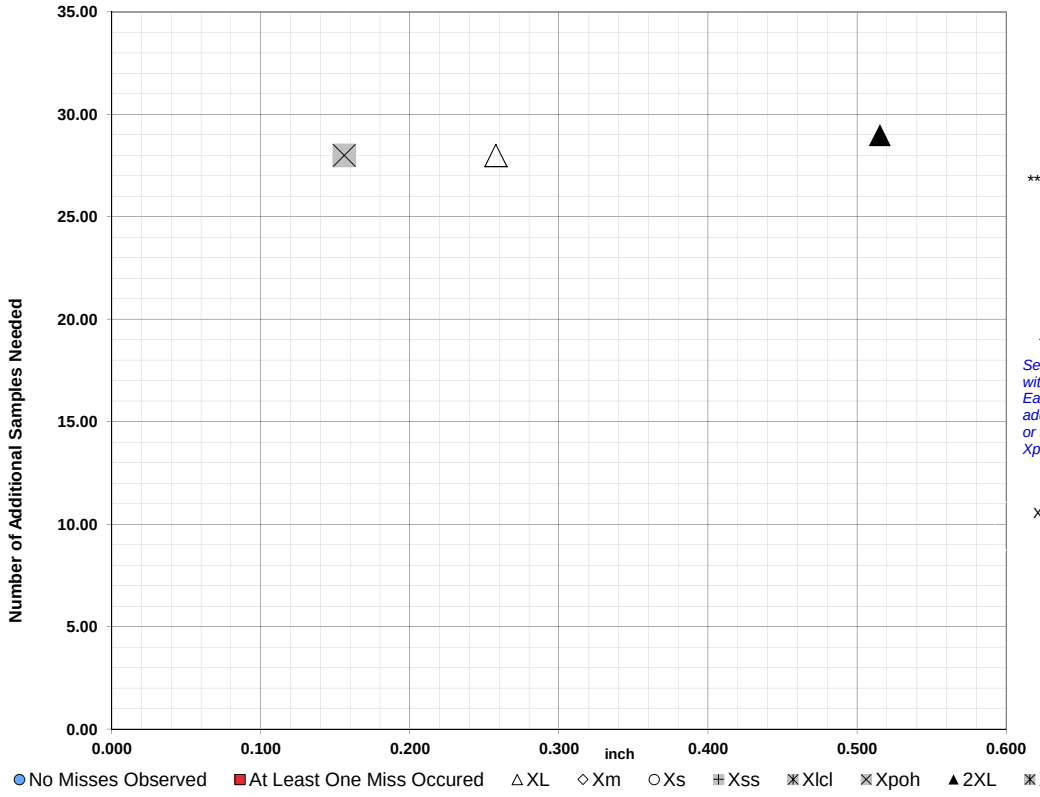



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.156 | 28 |
| 2XL = | 0.515 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

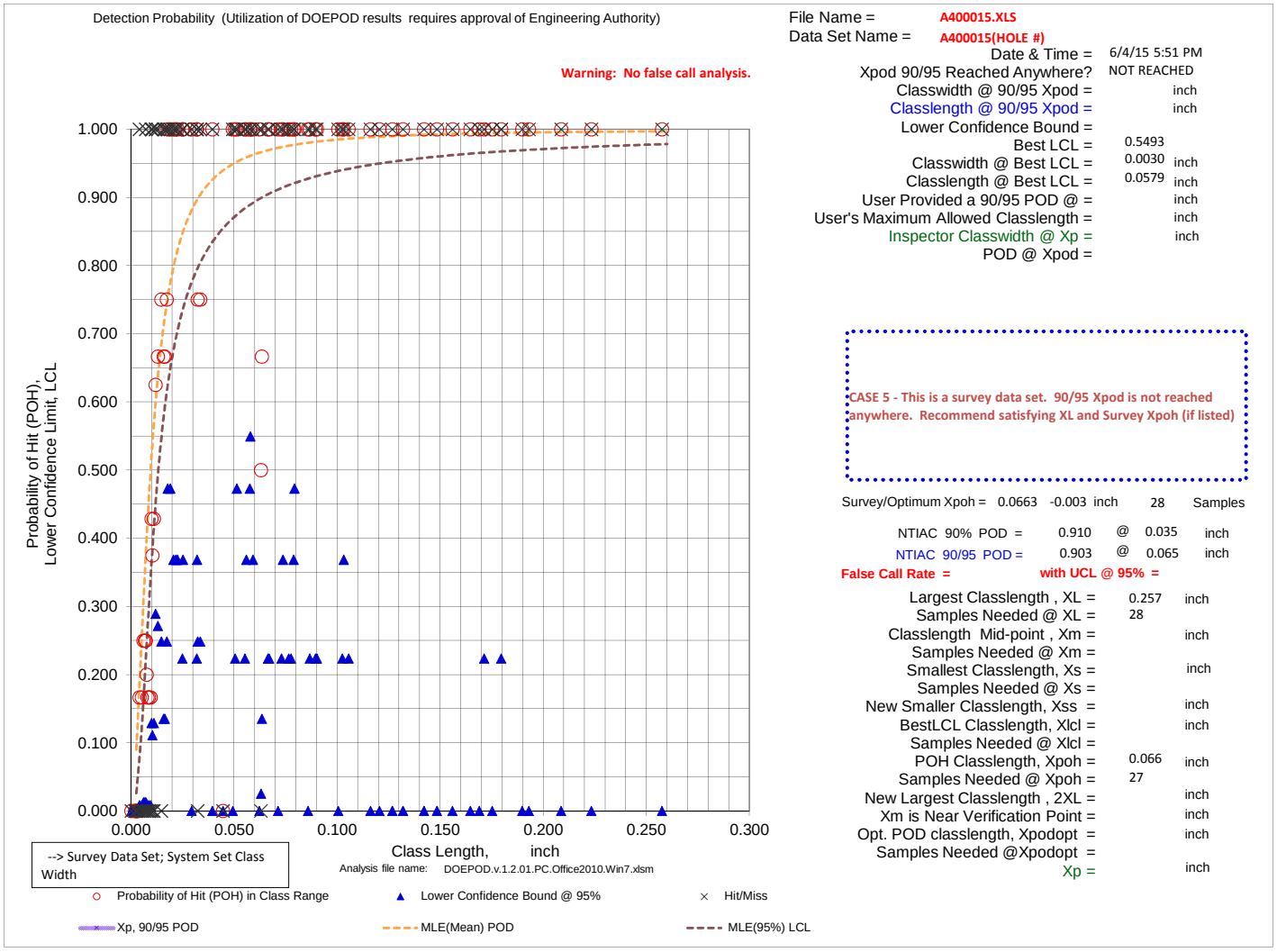
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = A400015.XLS
Data Set Name = A400015(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:51 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.0579 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - This is a survey data set. 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Survey Xpoh (if listed)

Survey/Optimum Xpoh = 0.0663 -0.003 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.910 | @ | 0.035 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.065 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.066 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A400015.XLS
Data Set Name = A400015(HOLE #)

## Directed DOE Options

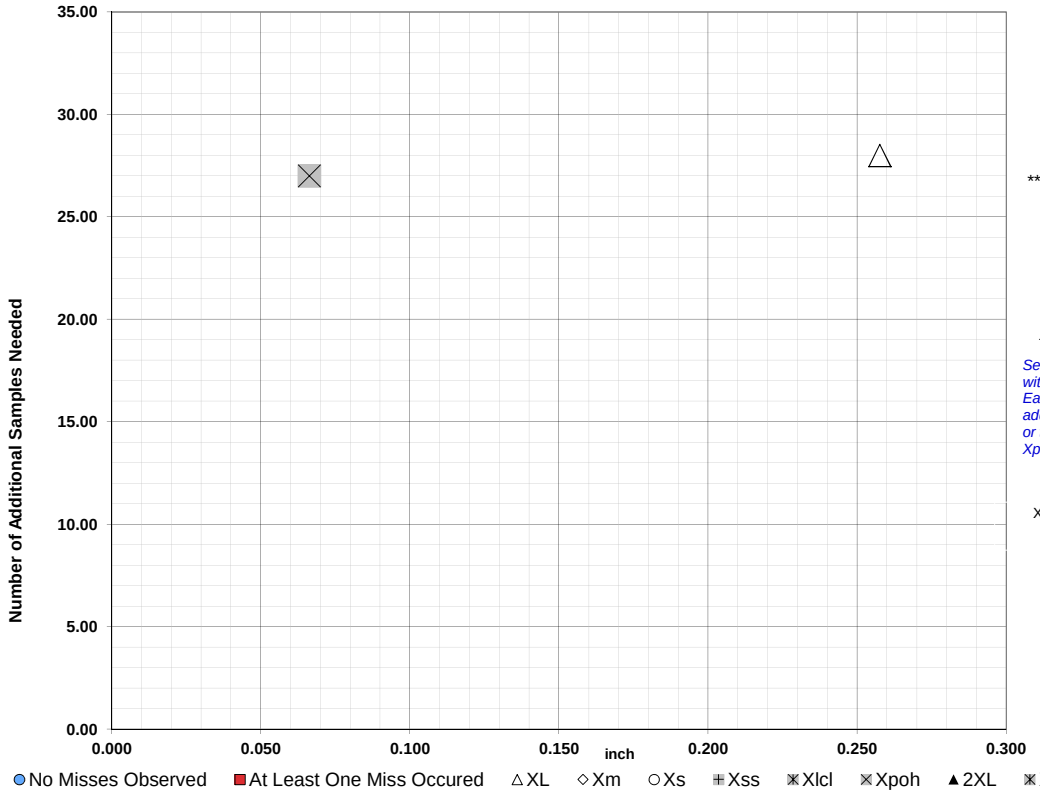



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.066 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

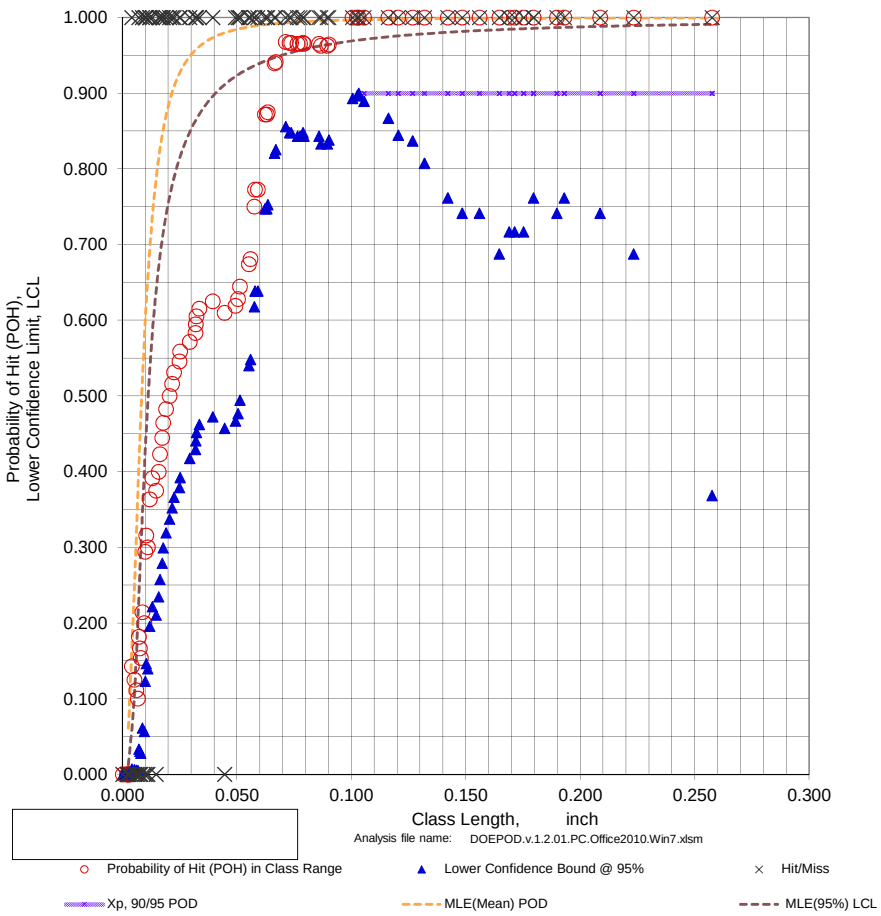
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.30942.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A400016.XLS**

Data Set Name = **A400016(HOLE #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:52 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0540 | inch |
| Classlength @ 90/95 Xpod = | 0.1031 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0492 -0.004 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.927 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.912 | @ | 0.045 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.193 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.100 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.1031 | inch |

File Name = A400016.XLS
Data Set Name = A400016(HOLE #)

## Directed DOE Options

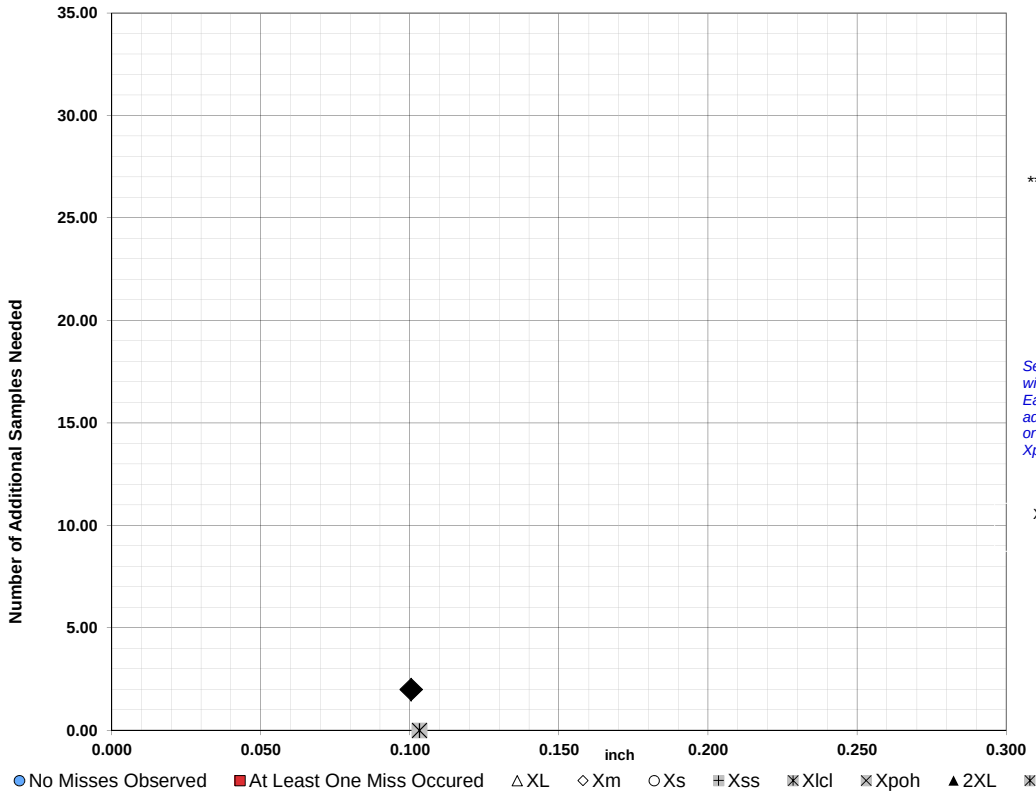



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | |
| Xm = | 0.193 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.100 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

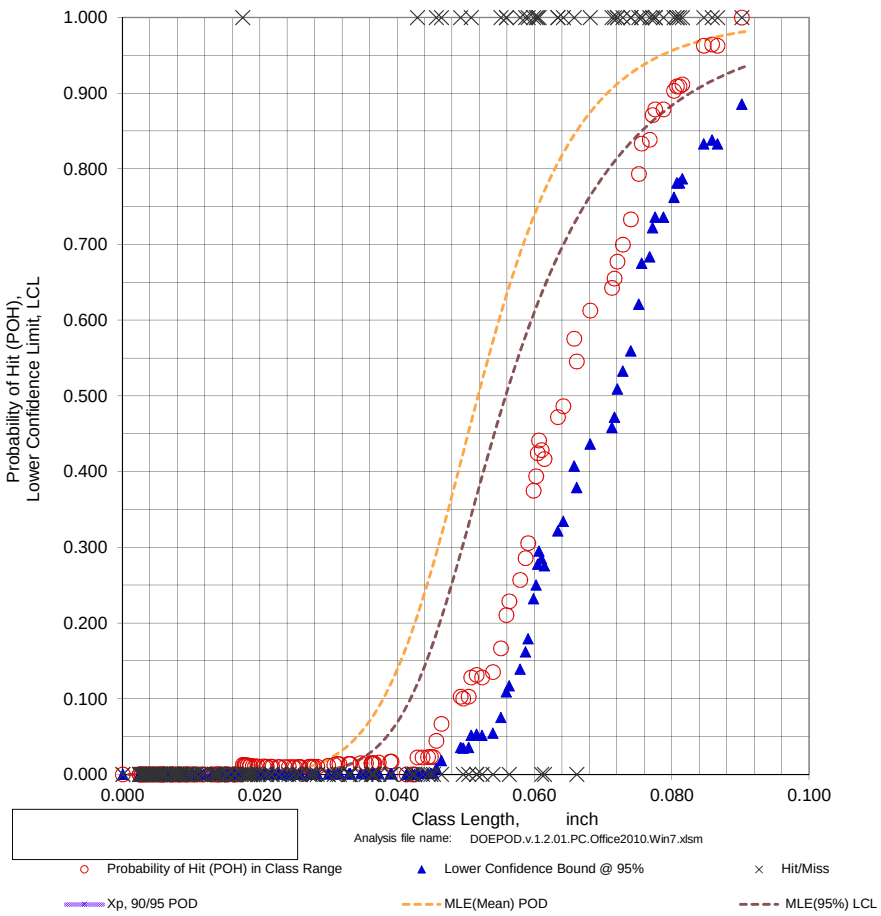
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = A500011.XLS
Data Set Name = A500011(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:53 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0230 | inch |
| Classlength @ Best LCL = | 0.0902 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0681 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.933 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.912 | @ | 0.085 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | 4 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.090 | inch |
| Samples Needed @ Xlcl = | 4 | |
| POH Classlength, Xpoh = | 0.090 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.180 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A500011.XLS
Data Set Name = A500011(HOLE #)

## Directed DOE Options

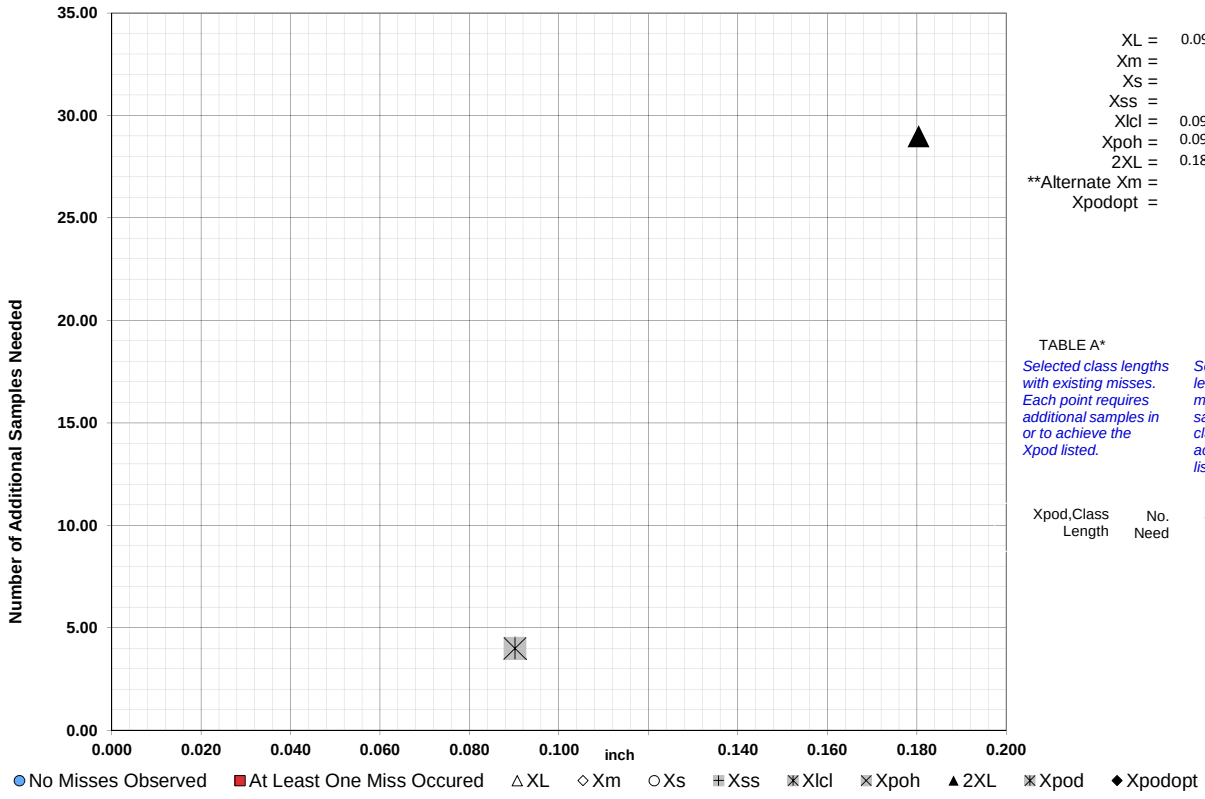



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | 4 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.090 | 4 |
| Xpoh = | 0.090 | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

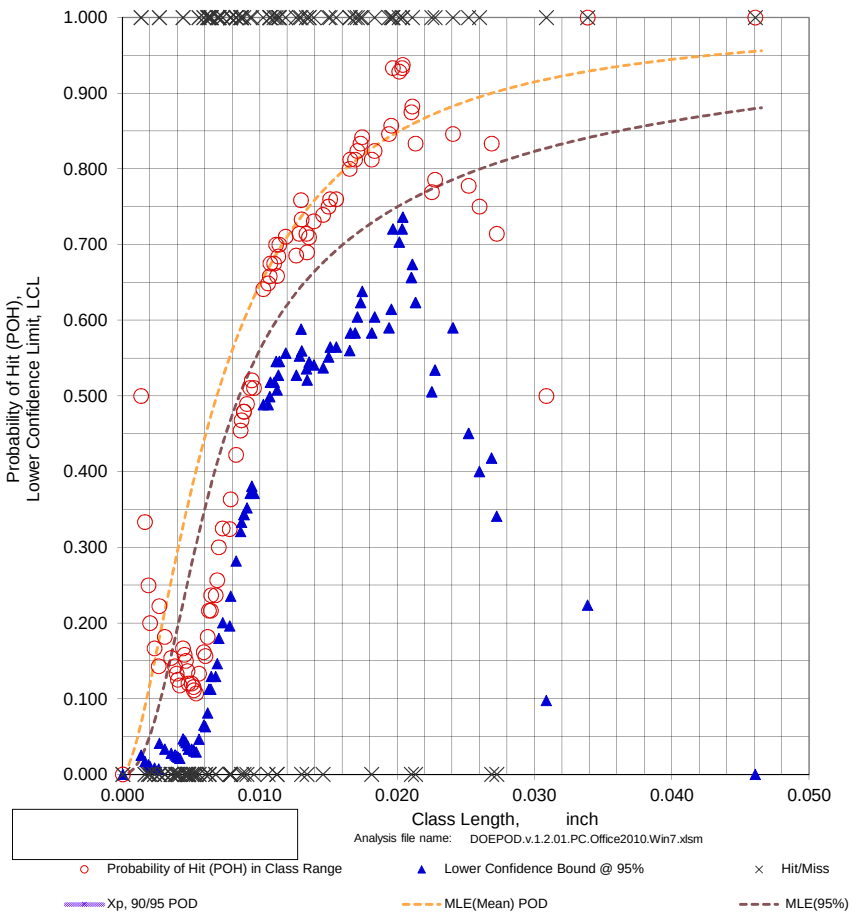
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A500013.XLS
Data Set Name = A500013(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:55 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7360 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.0204 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0309 -0.003 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.915 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.060 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.046 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.034 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | 0.092 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A500013.XLS
Data Set Name = A500013(HOLE #)

## Directed DOE Options

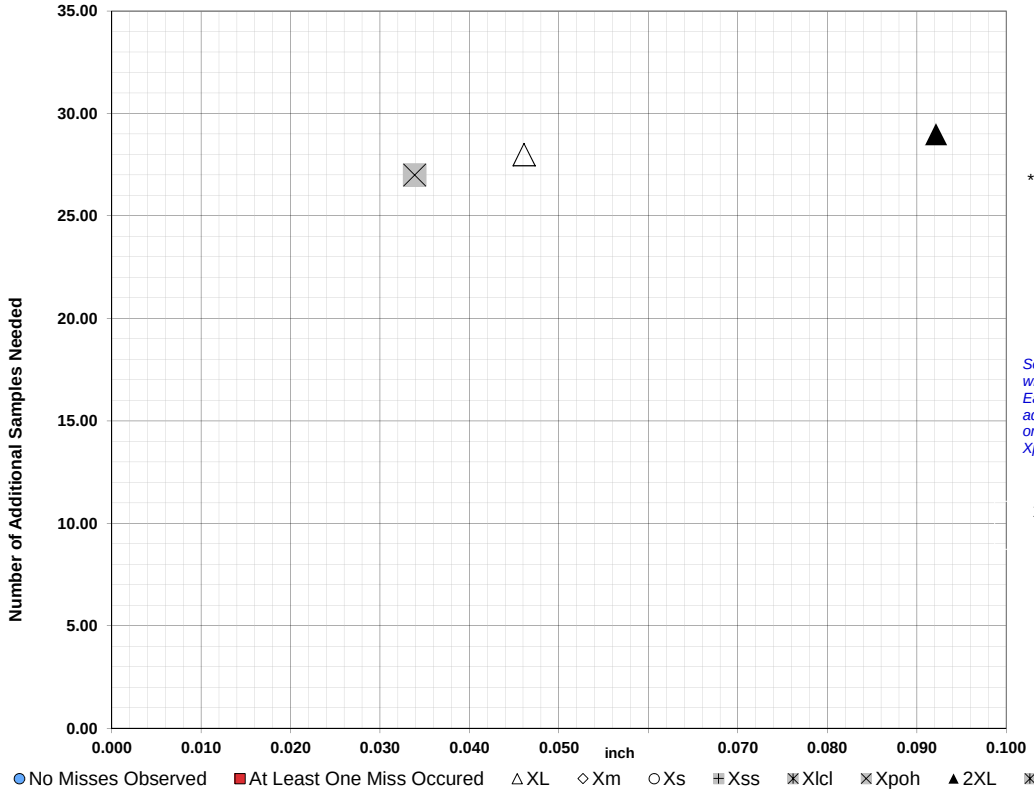



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.046 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.034 | 27 |
| 2XL = | 0.092 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

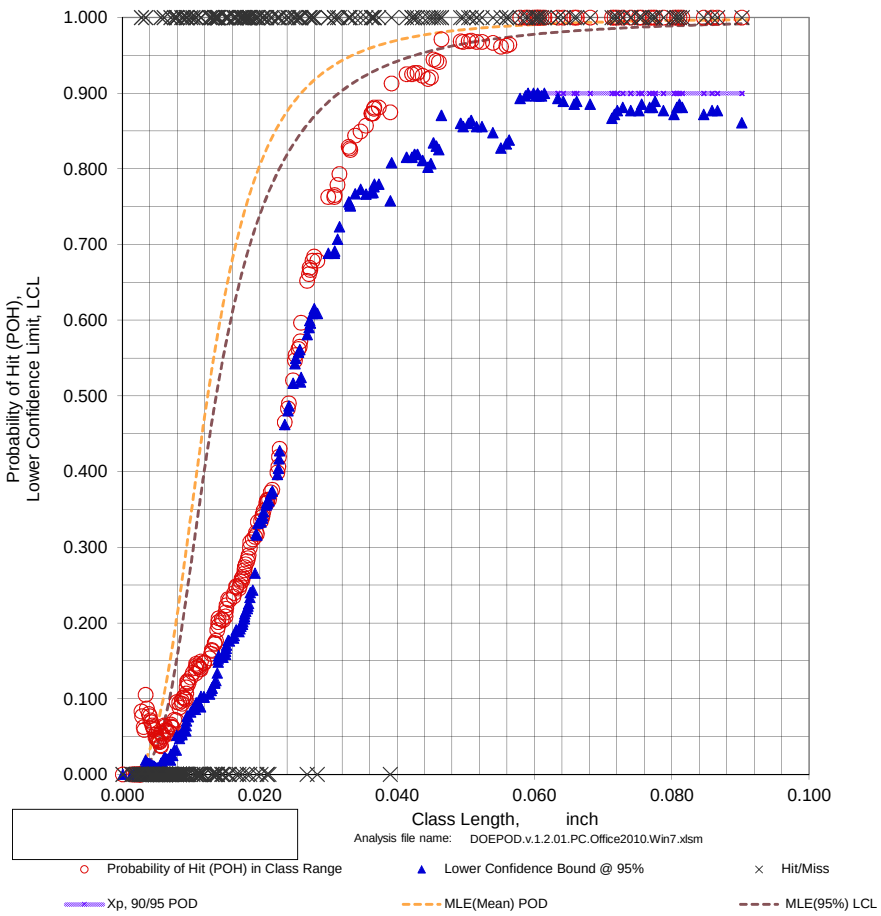
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.17715.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




| | | |
|---|---|---|
| File Name = | A500014.XLS | |
| Data Set Name = | A500014(HOLE #) | |
| Date & Time = | 6/4/15 5:56 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.0591 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0413 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.932 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.921 | @ | 0.035 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.078 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.058 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.0591 | inch |

File Name = A500014.XLS
Data Set Name = A500014(HOLE #)

## Directed DOE Options

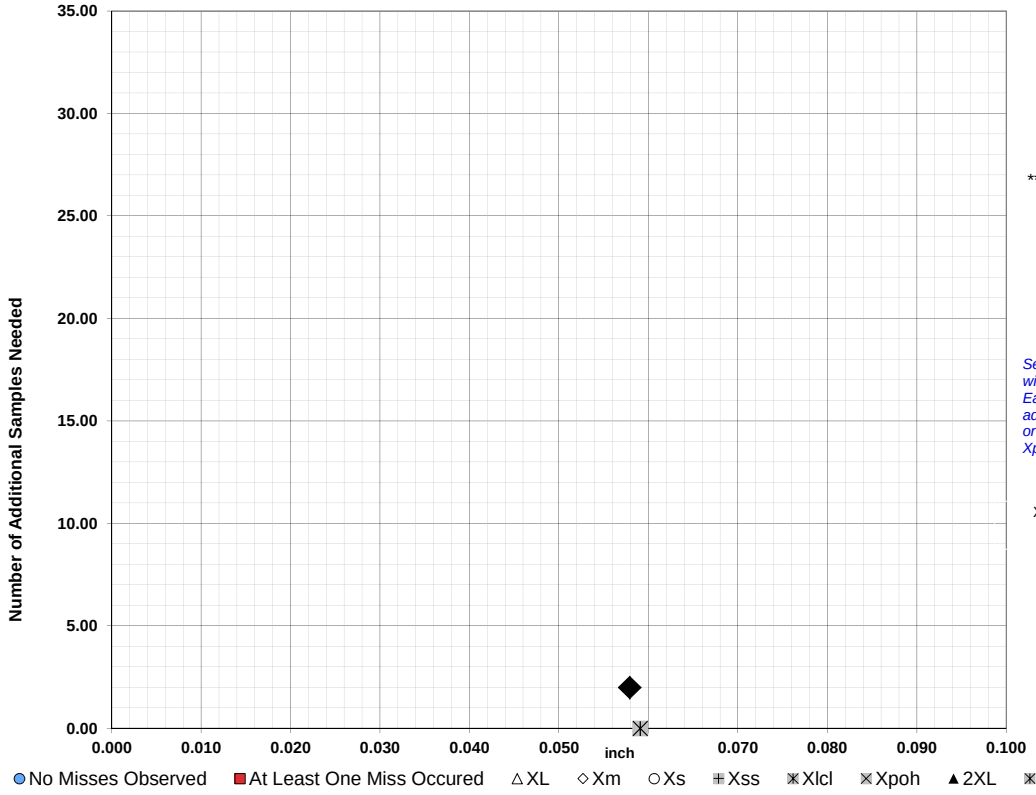



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | |
| Xm = | 0.078 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.058 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

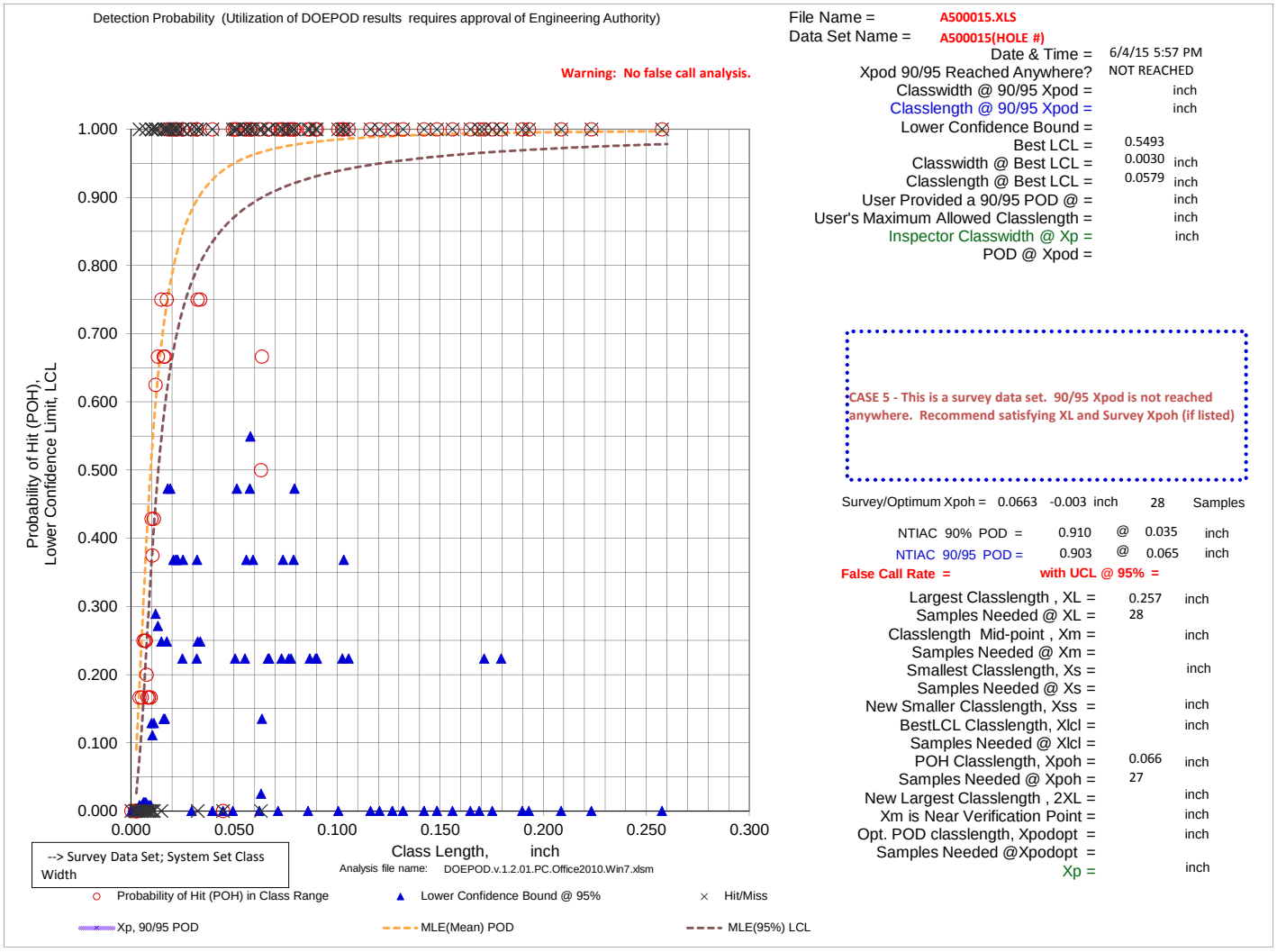
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = A500015.XLS
Data Set Name = A500015(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:57 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.0579 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - This is a survey data set. 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Survey Xpoh (if listed)

Survey/Optimum Xpoh = 0.0663 -0.003 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.910 | @ | 0.035 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.065 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.066 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A500015.XLS
Data Set Name = A500015(HOLE #)

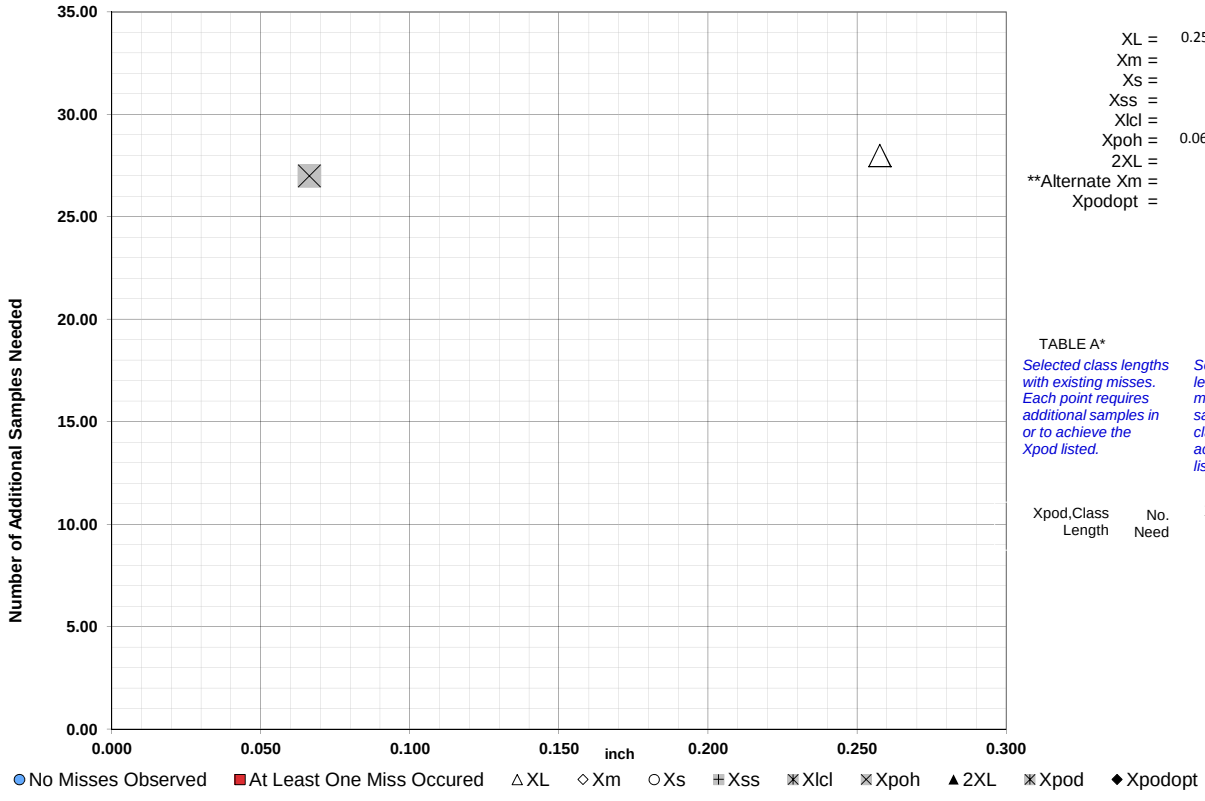



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.066 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

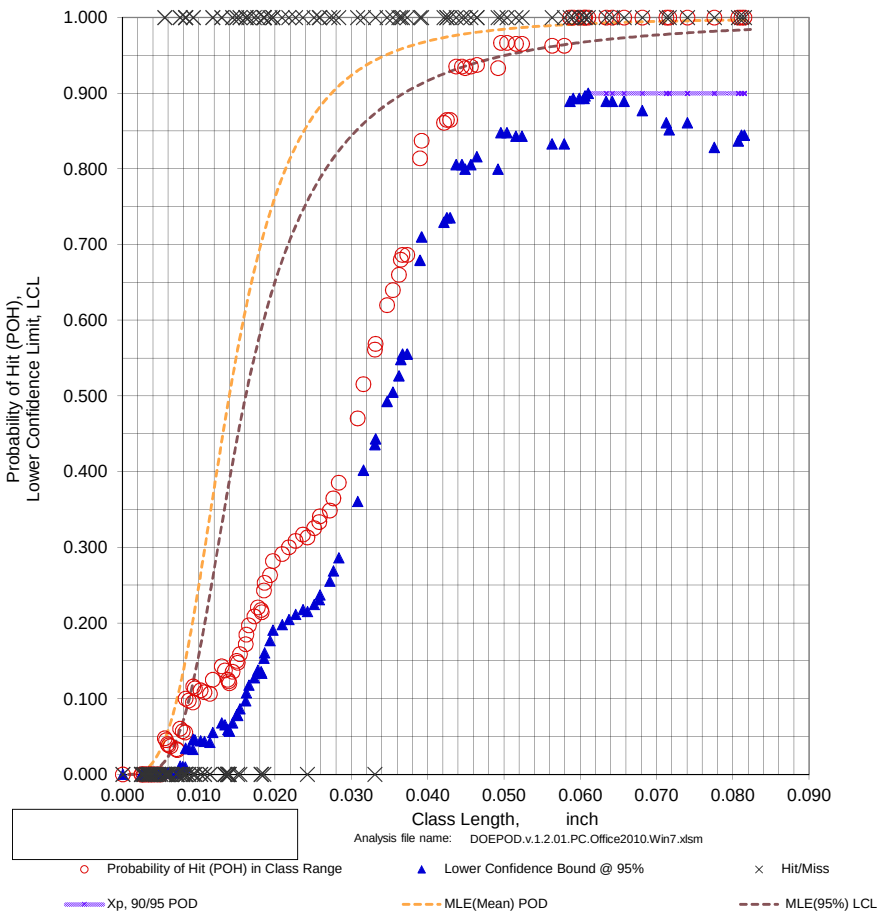
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.18306.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A500016.XLS**

Data Set Name = **A500016(HOLE #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:58 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0250 | inch |
| Classlength @ 90/95 Xpod = | 0.0610 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0346 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.924 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.917 | @ | 0.040 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.081 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.068 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.059 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.0610 | inch |

File Name = A500016.XLS
Data Set Name = A500016(HOLE #)

## Directed DOE Options

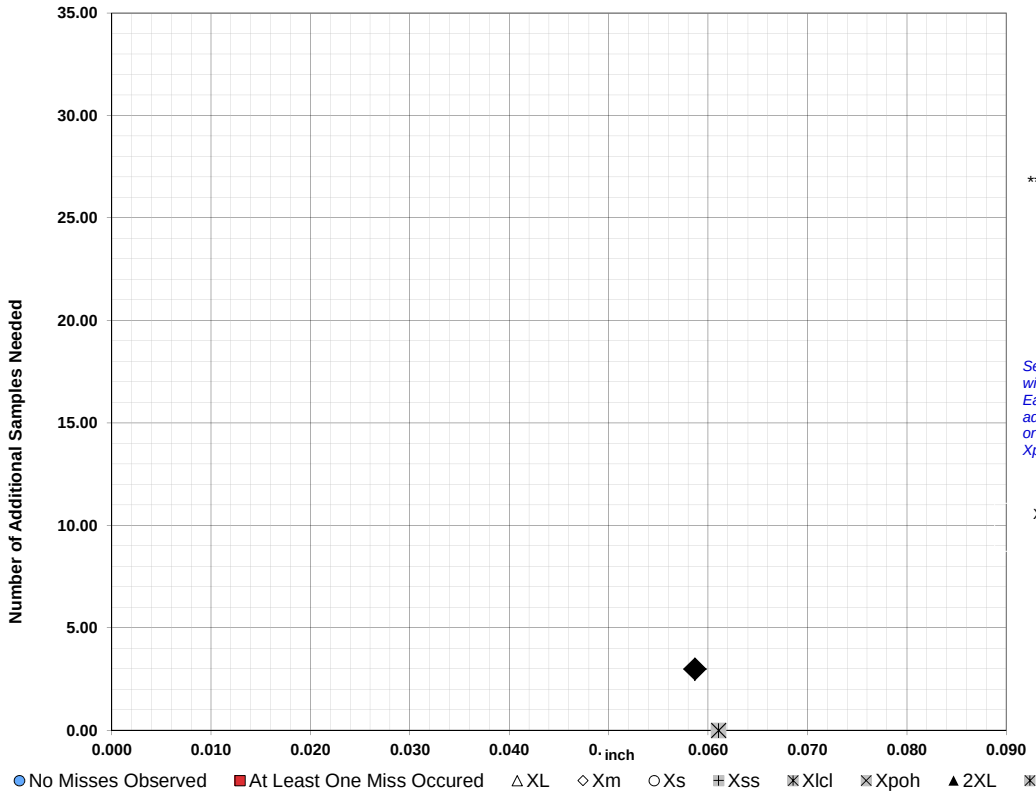



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.081 | |
| Xm = | 0.068 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.059 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

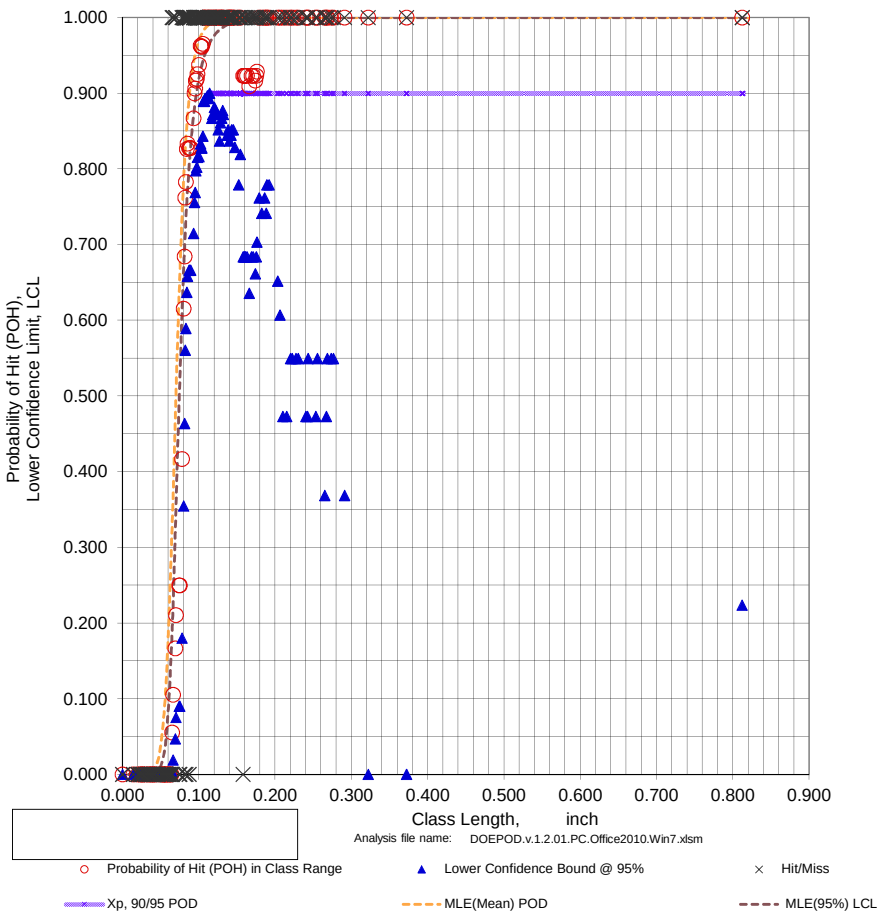
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6001A.XLS**

Data Set Name = **A6001A(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 5:59 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1140 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.920 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.919 | @ | 0.100 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1140 | inch |

File Name = A6001A.XLS
Data Set Name = A6001A(SITE CODE)

## Directed DOE Options

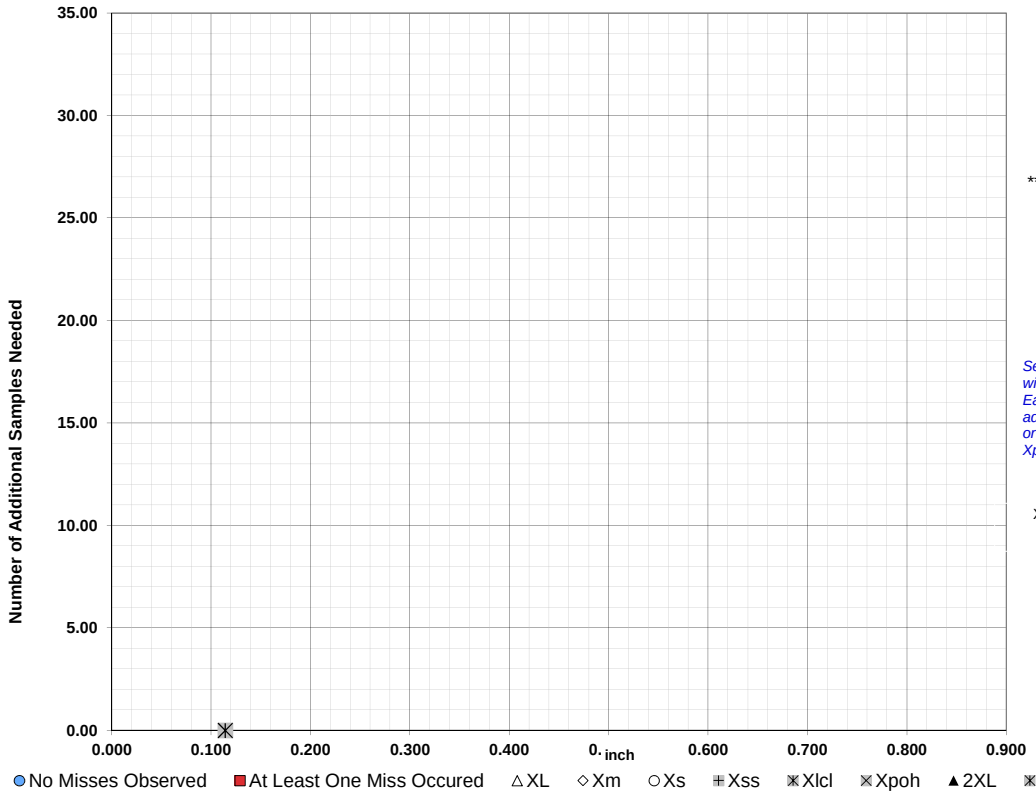



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

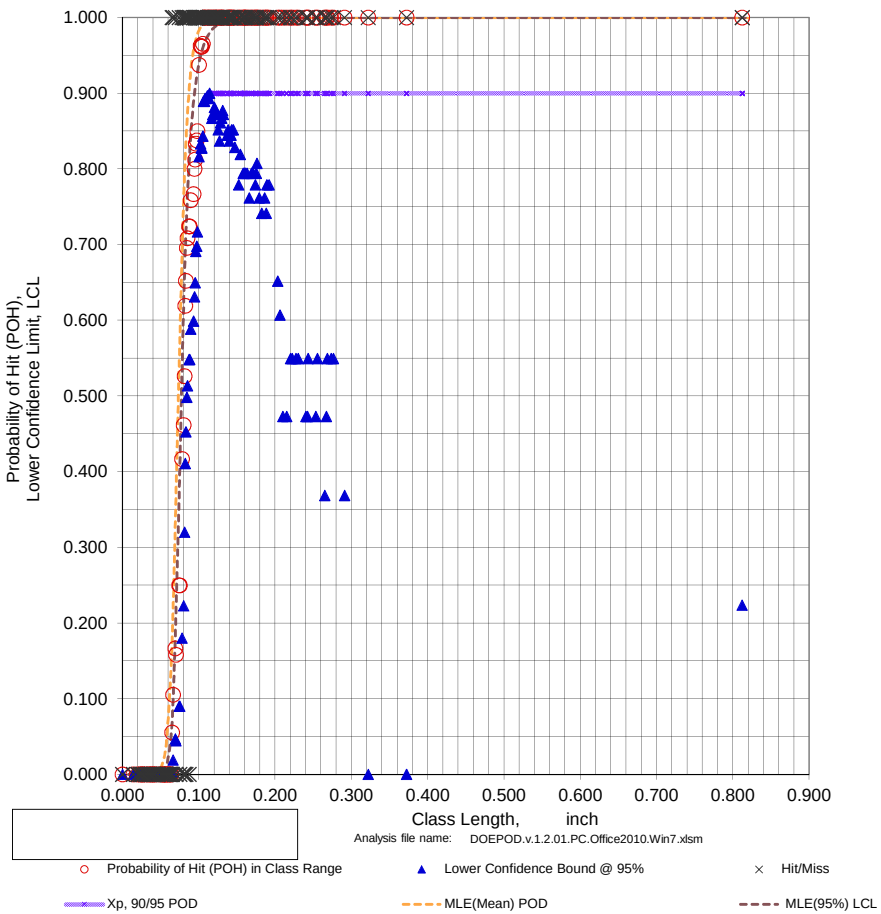
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6001AR.XLS**

Data Set Name = **A6001AR(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:00 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1140 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0890 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.935 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.095 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.106 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.1140 | inch |

File Name = A6001AR.XLS
Data Set Name = A6001AR(SITE CODE)

## Directed DOE Options

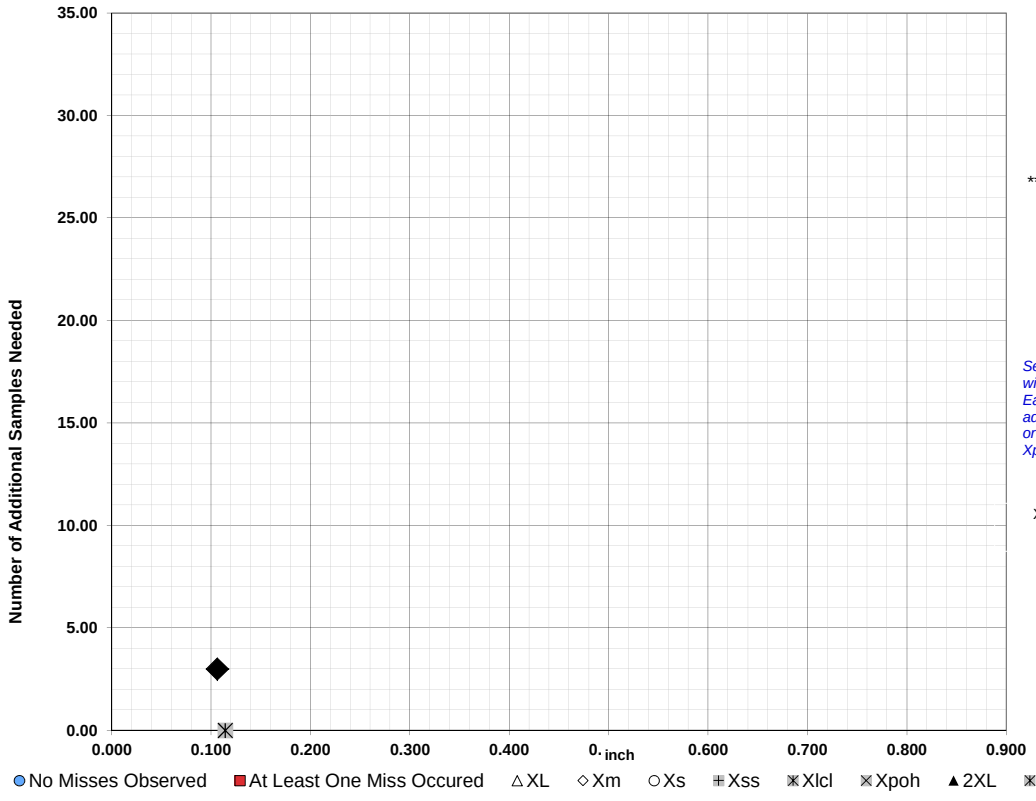



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.106 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

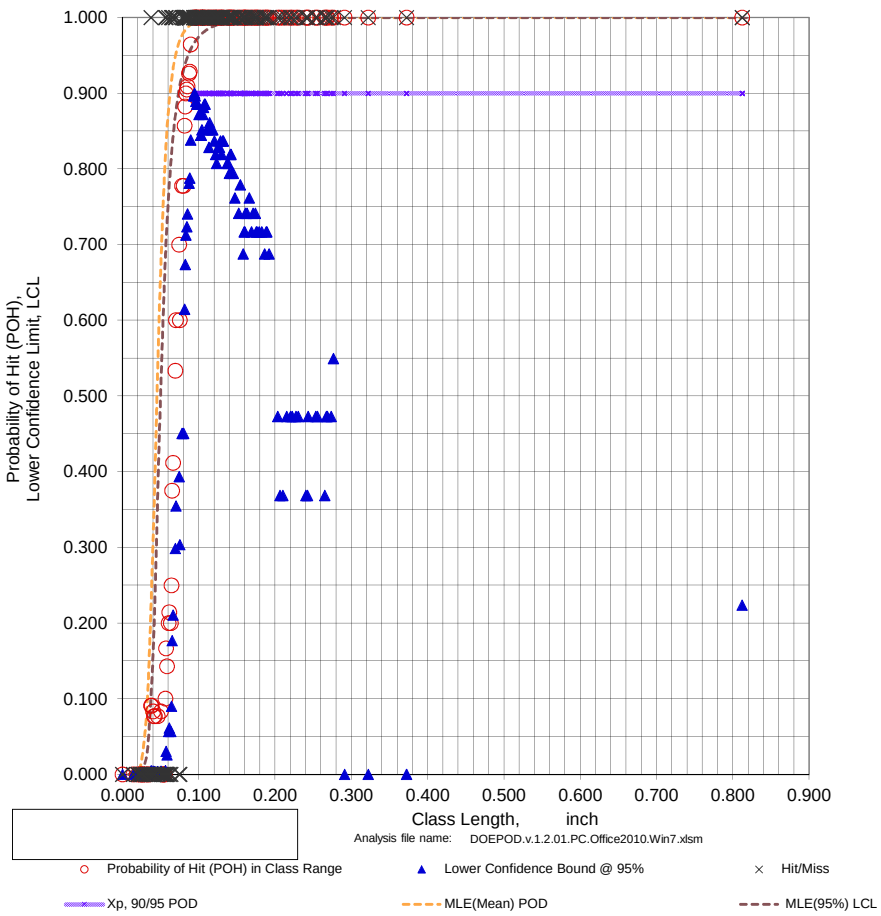
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6001B.XLS**

Data Set Name = **A6001B(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:01 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0140 | inch |
| Classlength @ 90/95 Xpod = | 0.0940 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0780 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.923 | @ | 0.065 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.075 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.276 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.093 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.0940 | inch |

File Name = A6001B.XLS
Data Set Name = A6001B(SITE CODE)

## Directed DOE Options

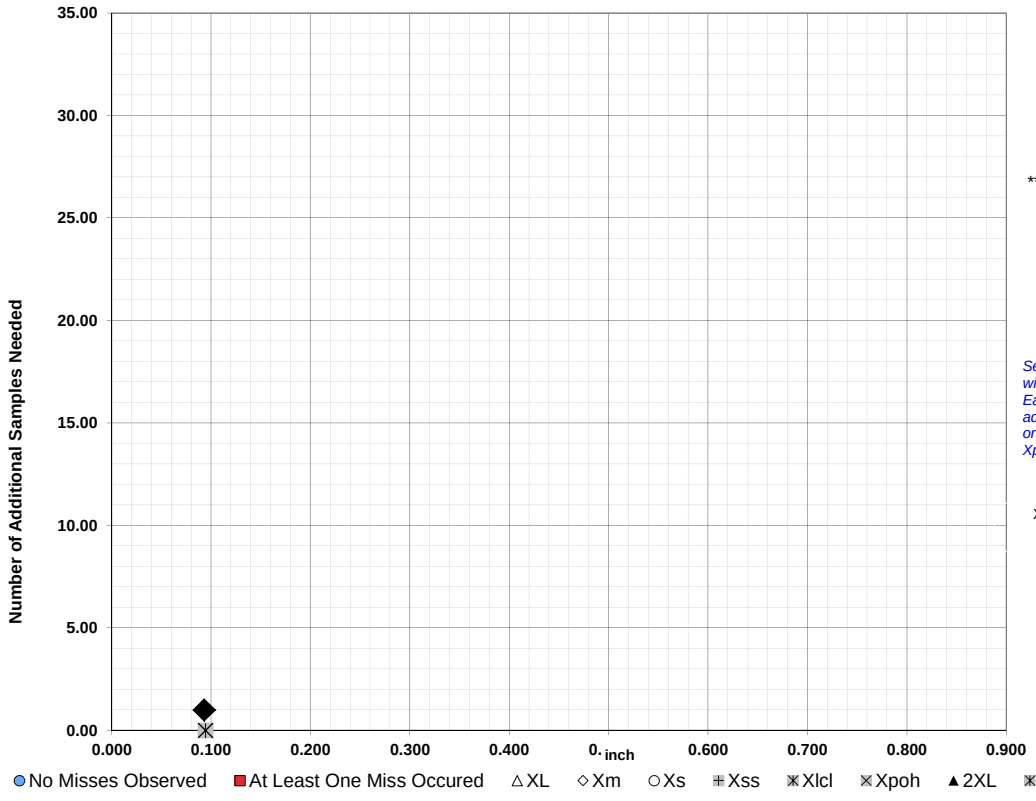



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.276 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.093 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

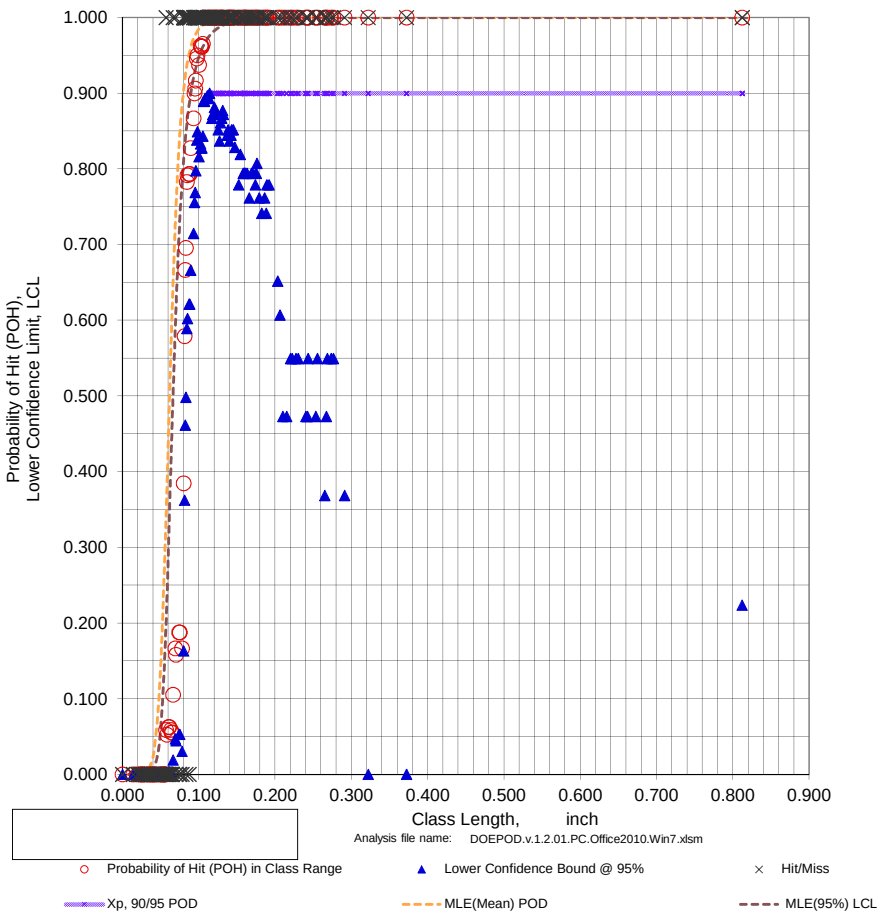
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6001C.XLS**

Data Set Name = **A6001C(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:03 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1140 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0890 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.938 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.106 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.1140 | inch |

File Name = A6001C.XLS
Data Set Name = A6001C(SITE CODE)

## Directed DOE Options

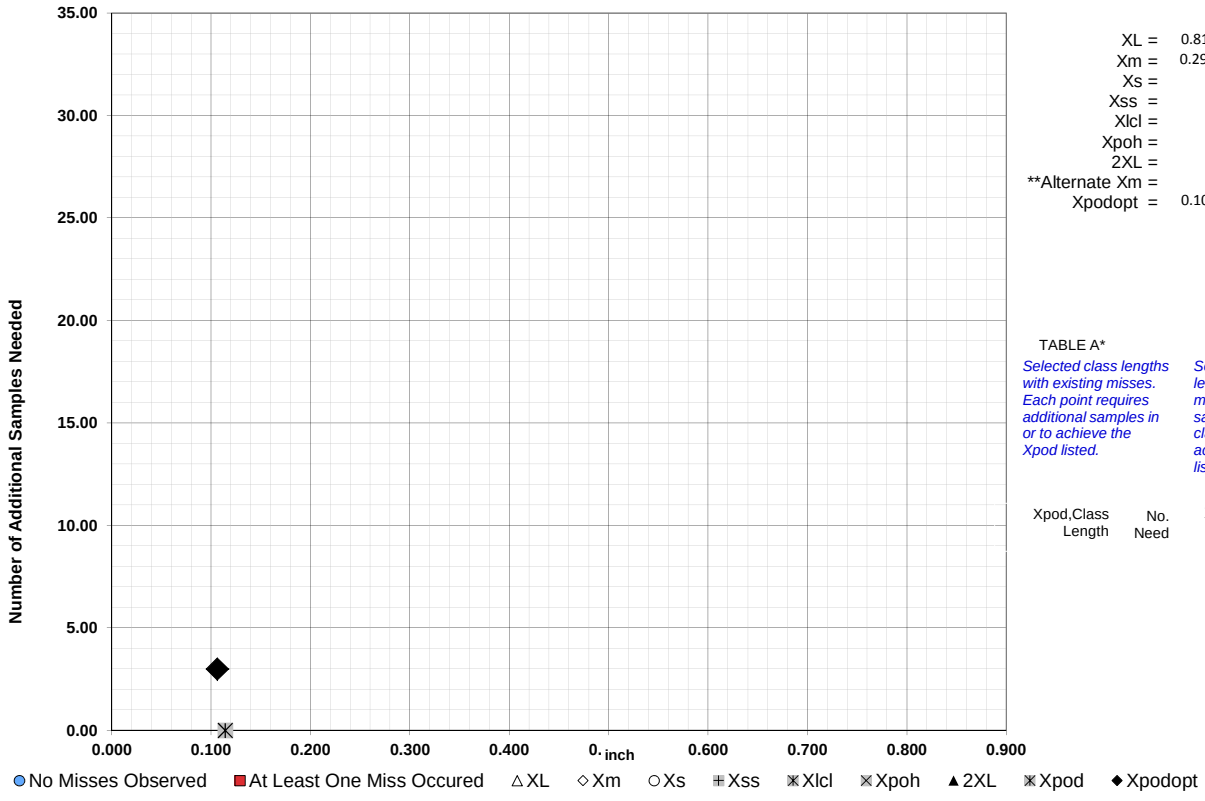



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.106 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

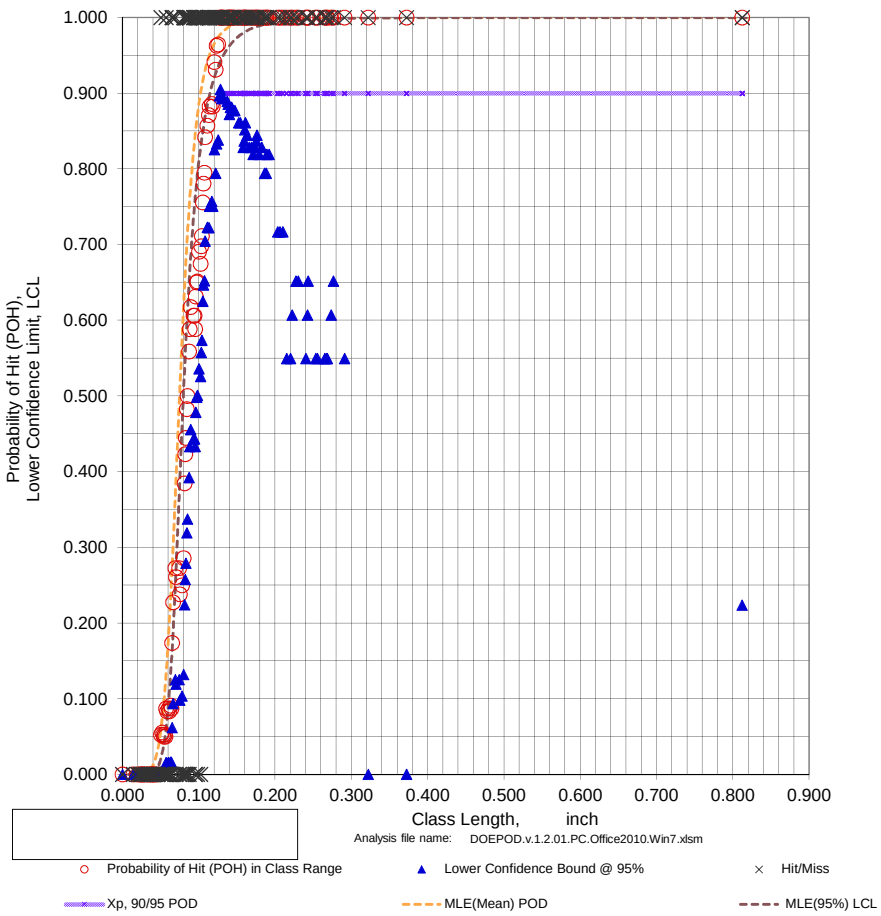
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6001D.XLS**

Data Set Name = **A6001D(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:04 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0240 | inch |
| Classlength @ 90/95 Xpod = | 0.1280 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1040 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.916 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.127 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.1280 | inch |

File Name = A6001D.XLS
Data Set Name = A6001D(SITE CODE)

## Directed DOE Options

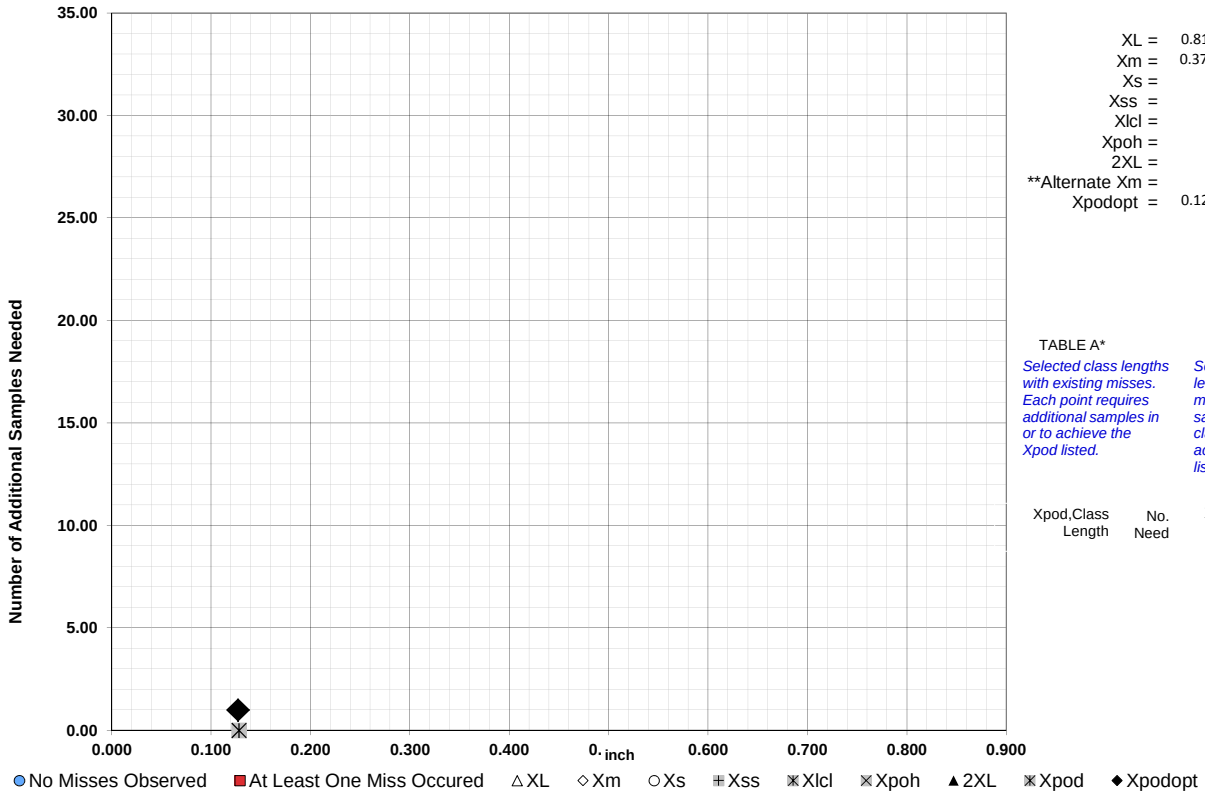



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.127 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

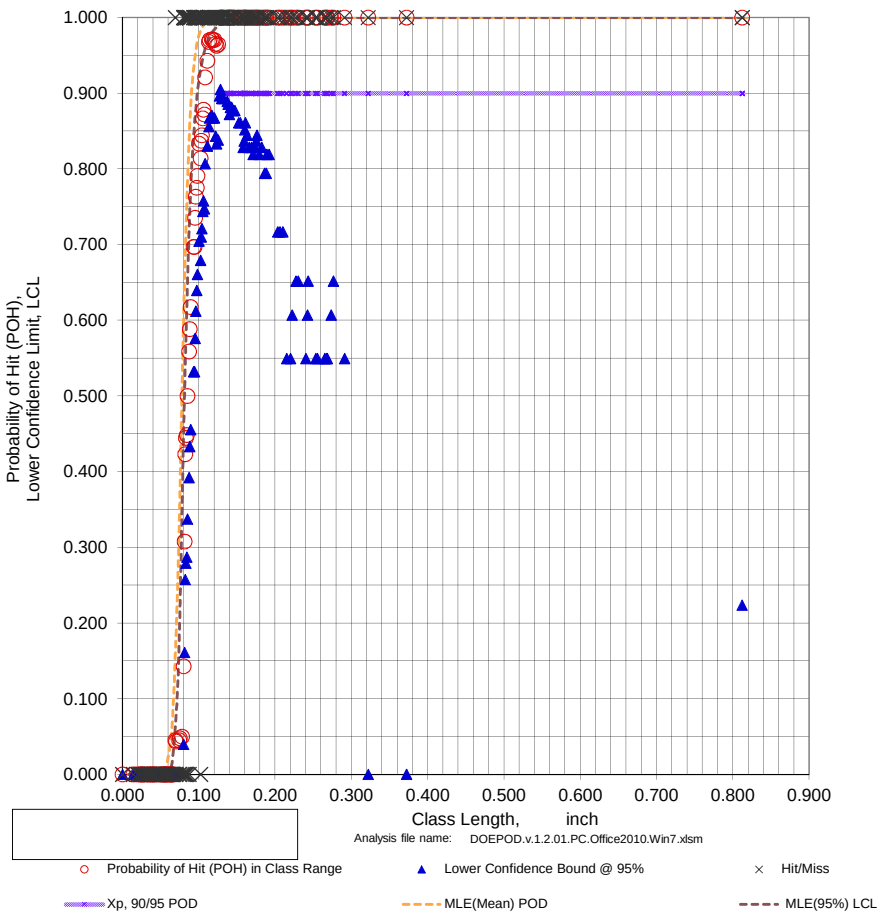
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6001E.XLS**

Data Set Name = **A6001E(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:05 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0240 | inch |
| Classlength @ 90/95 Xpod = | 0.1280 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1040 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.950 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.916 | @ | 0.100 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.127 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.1280 | inch |

File Name = A6001E.XLS
Data Set Name = A6001E(SITE CODE)

## Directed DOE Options

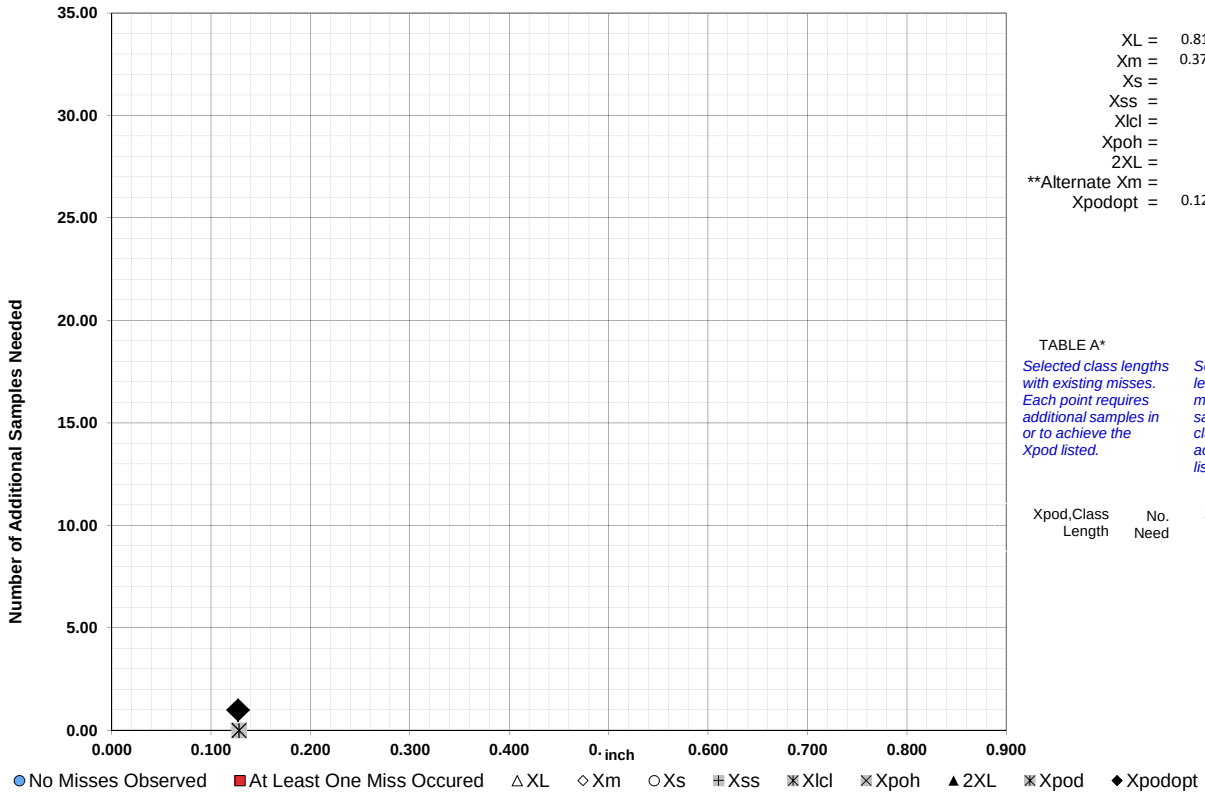



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.127 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

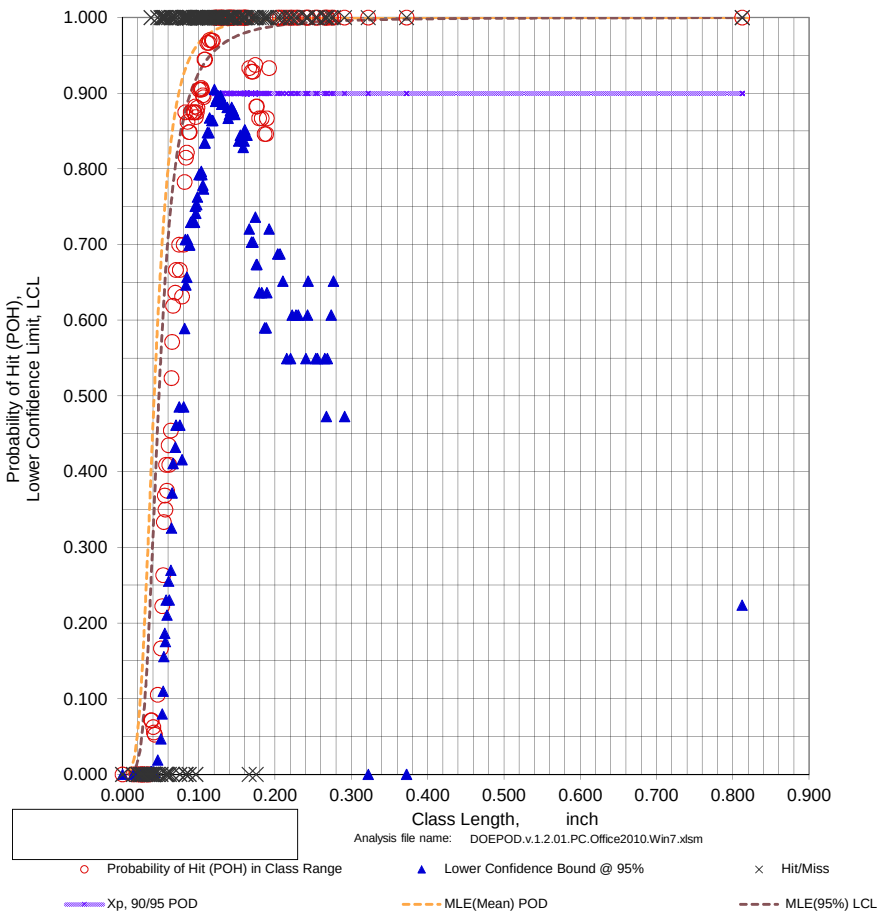
**Any highlighted Misses are RED and shown in Column A of this data sheet**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6001F.XLS**

Data Set Name = **A6001F(SITE CODE)**




| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:06 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0230 | inch |
| Classlength @ 90/95 Xpod = | 0.1200 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1200 | inch |

File Name = A6001F.XLS
Data Set Name = A6001F(SITE CODE)

## Directed DOE Options

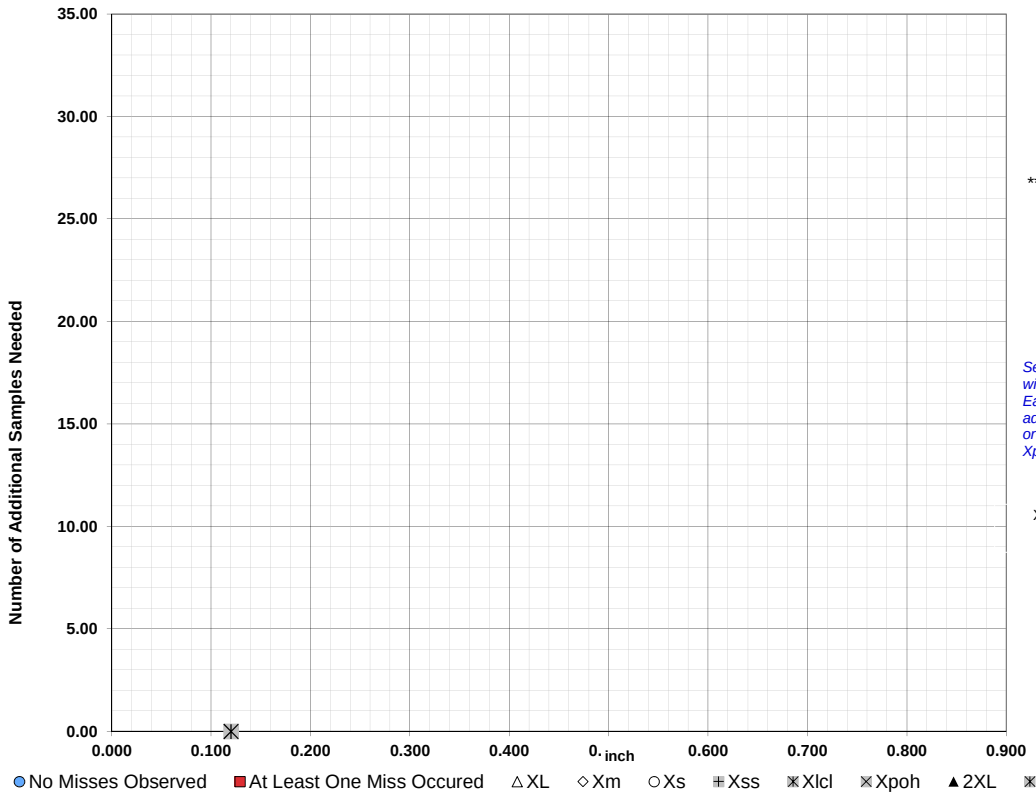



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

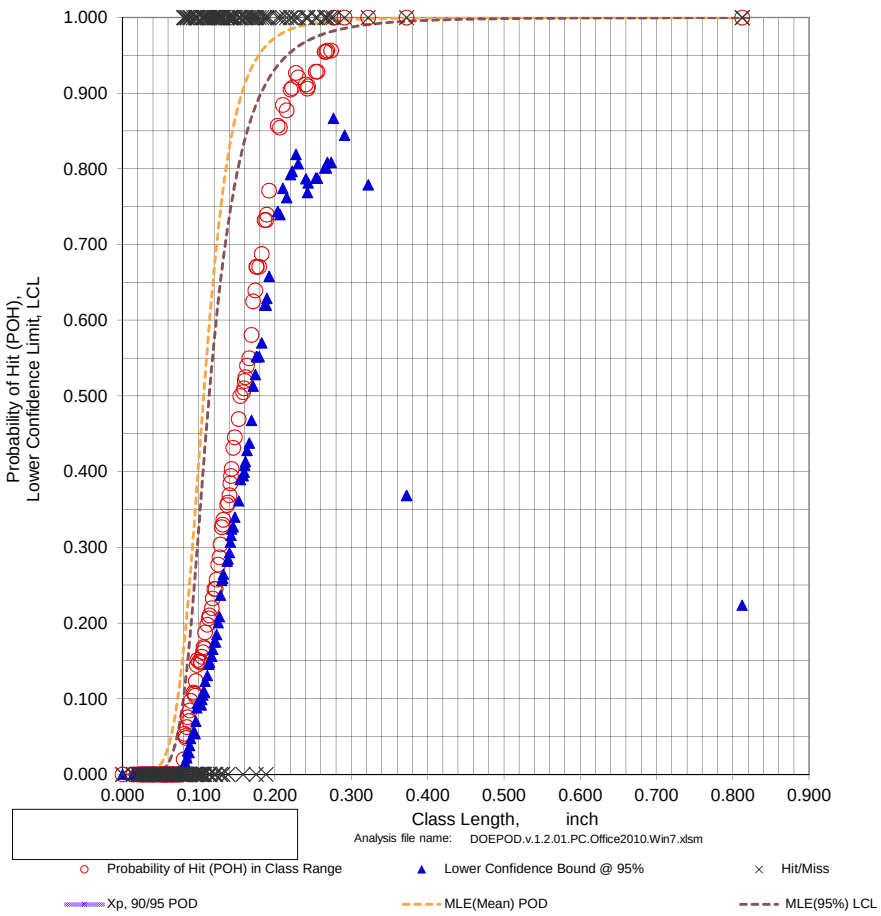
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A6001G.XLS
Data Set Name = A6001G(SITE CODE)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:07 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0870 | inch |
| Classlength @ Best LCL = | 0.2760 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1920 -0.003 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.911 | @ | 0.160 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.185 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.276 | inch |
| Samples Needed @ Xlcl = | 8 | |
| POH Classlength, Xpoh = | 0.276 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6001G.XLS
Data Set Name = A6001G(SITE CODE)

## Directed DOE Options

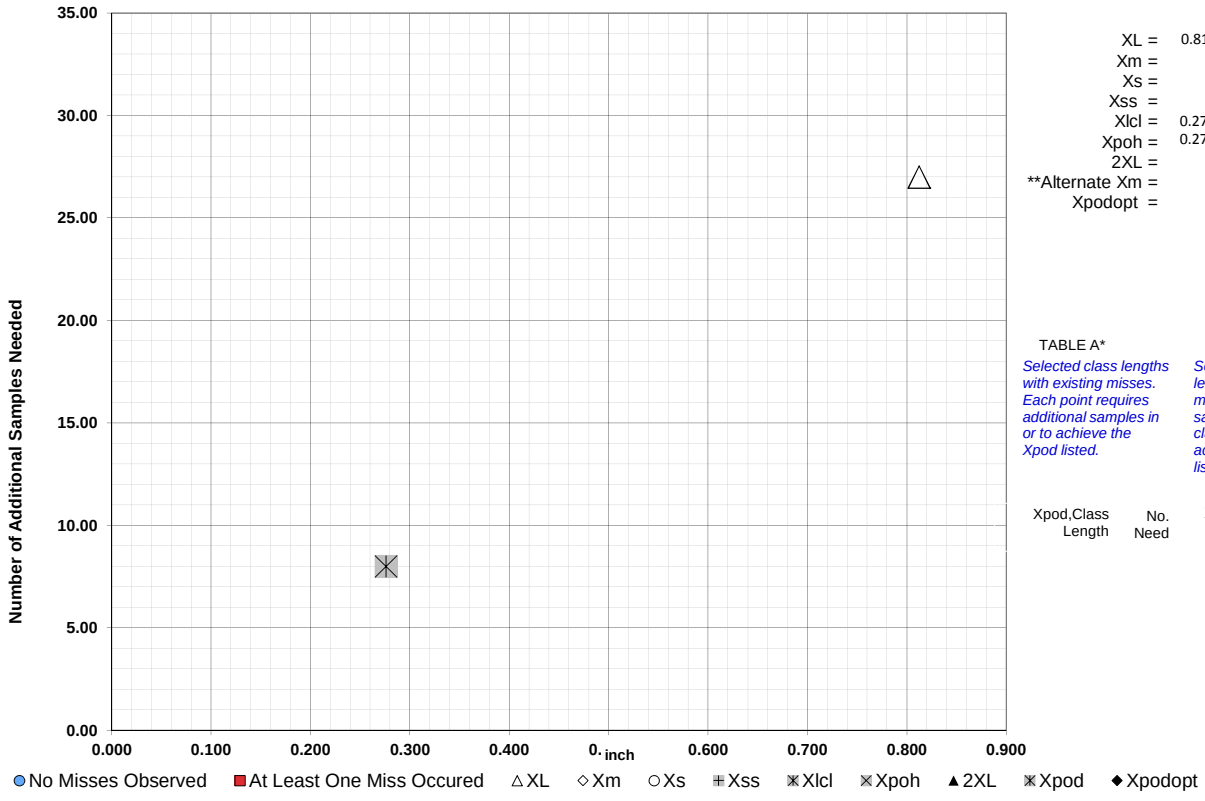



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.276 | 8 |
| Xpoh = | 0.276 | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

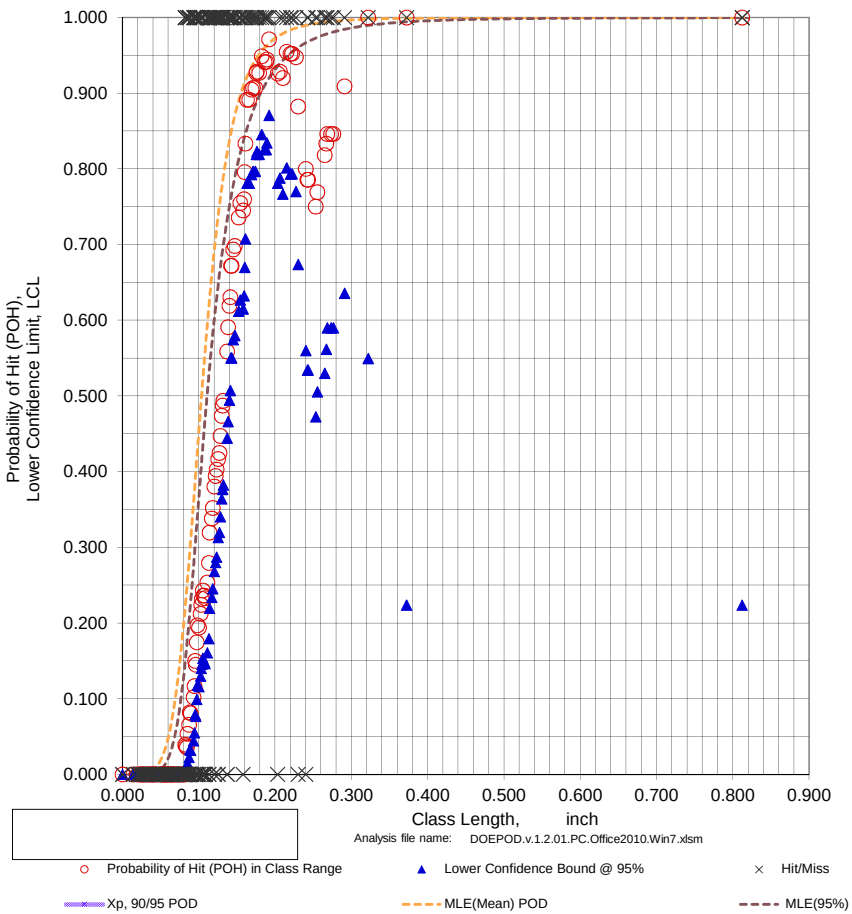
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A6001GR.XLS
Data Set Name = A6001GR(SITE CODE)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:09 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8707 | |
| Classwidth @ Best LCL = | 0.0540 | inch |
| Classlength @ Best LCL = | 0.1920 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2420 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.914 | @ | 0.160 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.185 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.322 | inch |
| Samples Needed @ Xpoh = | 24 | |
| New Largest Classlength , 2XL = | 1.624 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6001GR.XLS
Data Set Name = A6001GR(SITE CODE)

## Directed DOE Options

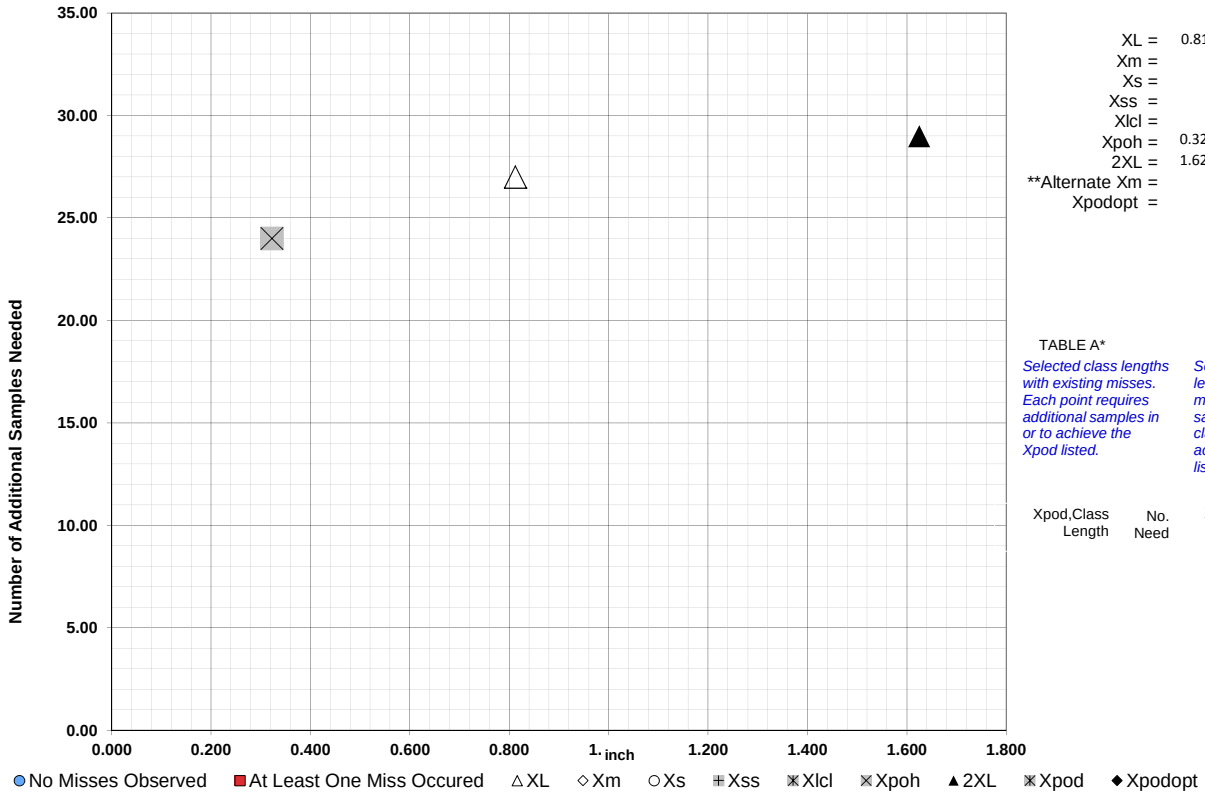



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.322 | 24 |
| 2XL = | 1.624 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6001H.XLS**

Data Set Name = **A6001H(SITE CODE)**

Date & Time = 6/4/15 6:11 PM

Xpod 90/95 Reached Anywhere? REACHED

Classwidth @ 90/95 Xpod = 0.0250 inch

Classlength @ 90/95 Xpod = 0.1310 inch

Lower Confidence Bound = 0.9001

Best LCL =

Classwidth @ Best LCL = inch

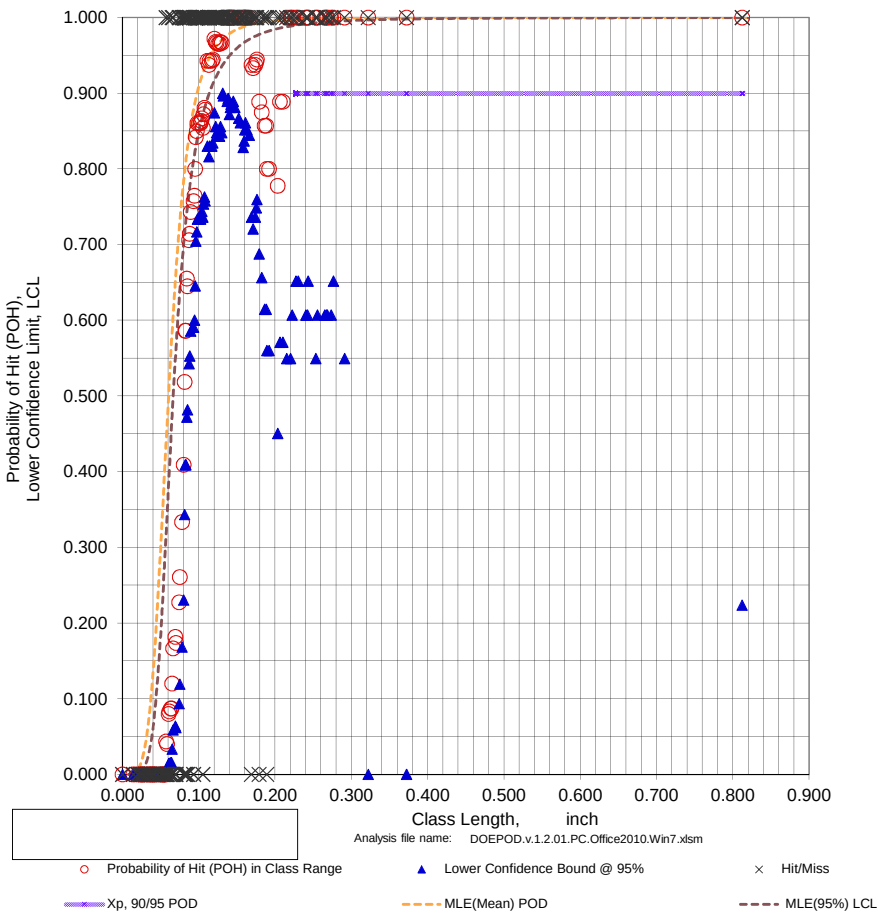
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.903 @ 0.105 inch

NTIAC 90/95 POD = 0.902 @ 0.120 inch

**False Call Rate = with UCL @ 95% =**

Largest Classlength , XL = 0.812 inch

Samples Needed @ XL =

Classlength Mid-point , Xm = 0.372 inch

Samples Needed @ Xm =

Smallest Classlength, Xs = inch

Samples Needed @ Xs =

New Smaller Classlength, Xss = inch

BestLCL Classlength, Xlcl = inch

Samples Needed @ Xlcl =

POH Classlength, Xpoh = inch

Samples Needed @ Xpoh =

New Largest Classlength , 2XL = inch

Xm is Near Verification Point = inch

Opt. POD classlength, Xpodopt = inch

Samples Needed @Xpodopt =

Xp = 0.2270 inch

File Name = A6001H.XLS
Data Set Name = A6001H(SITE CODE)

## Directed DOE Options

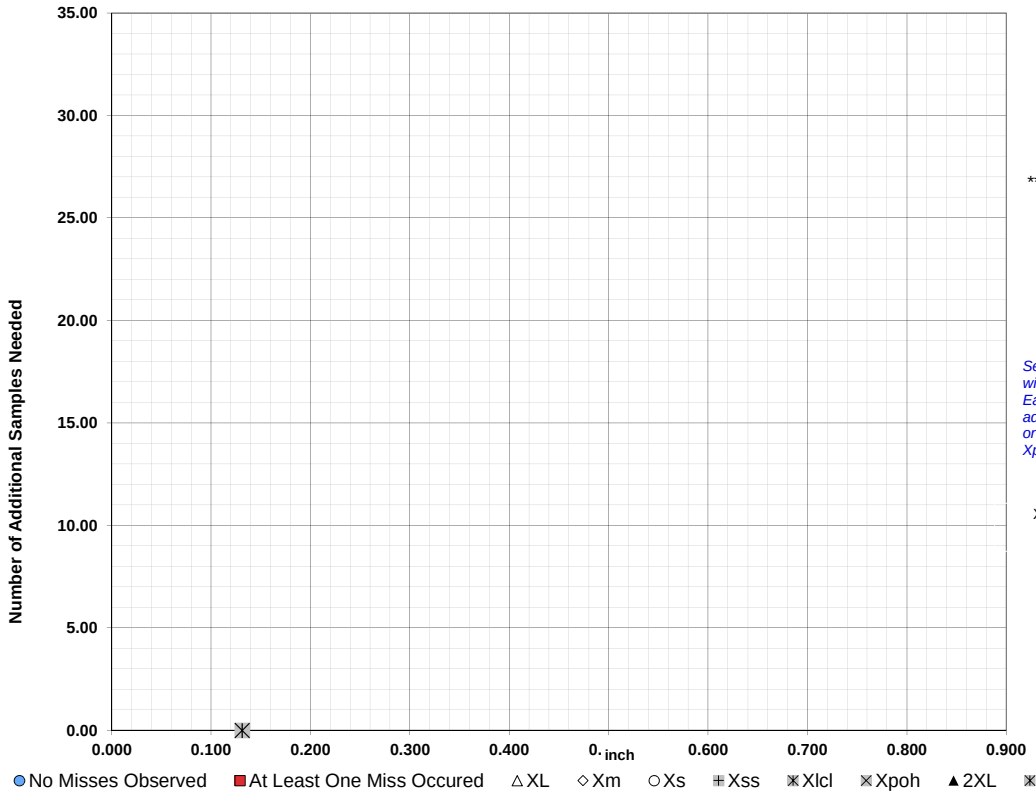



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

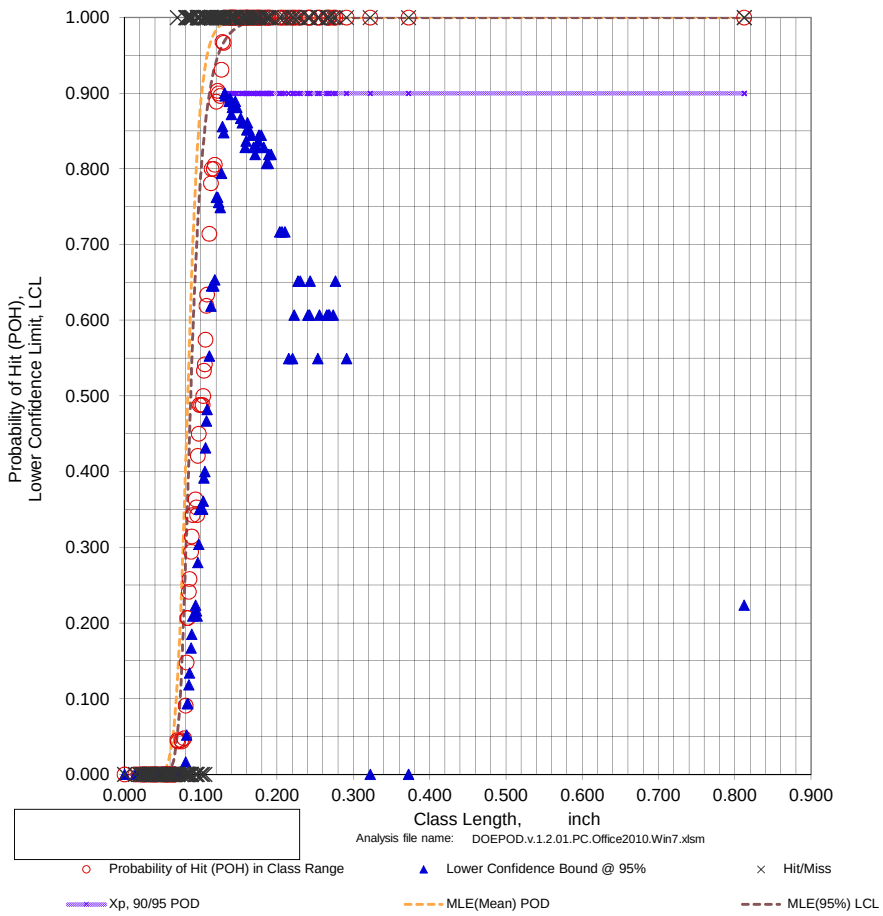
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6001J.XLS**

Data Set Name = **A6001J(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:12 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0250 | inch |
| Classlength @ 90/95 Xpod = | 0.1310 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1070 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.932 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.921 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.131 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1310 | inch |

File Name = A6001J.XLS
Data Set Name = A6001J(SITE CODE)

## Directed DOE Options

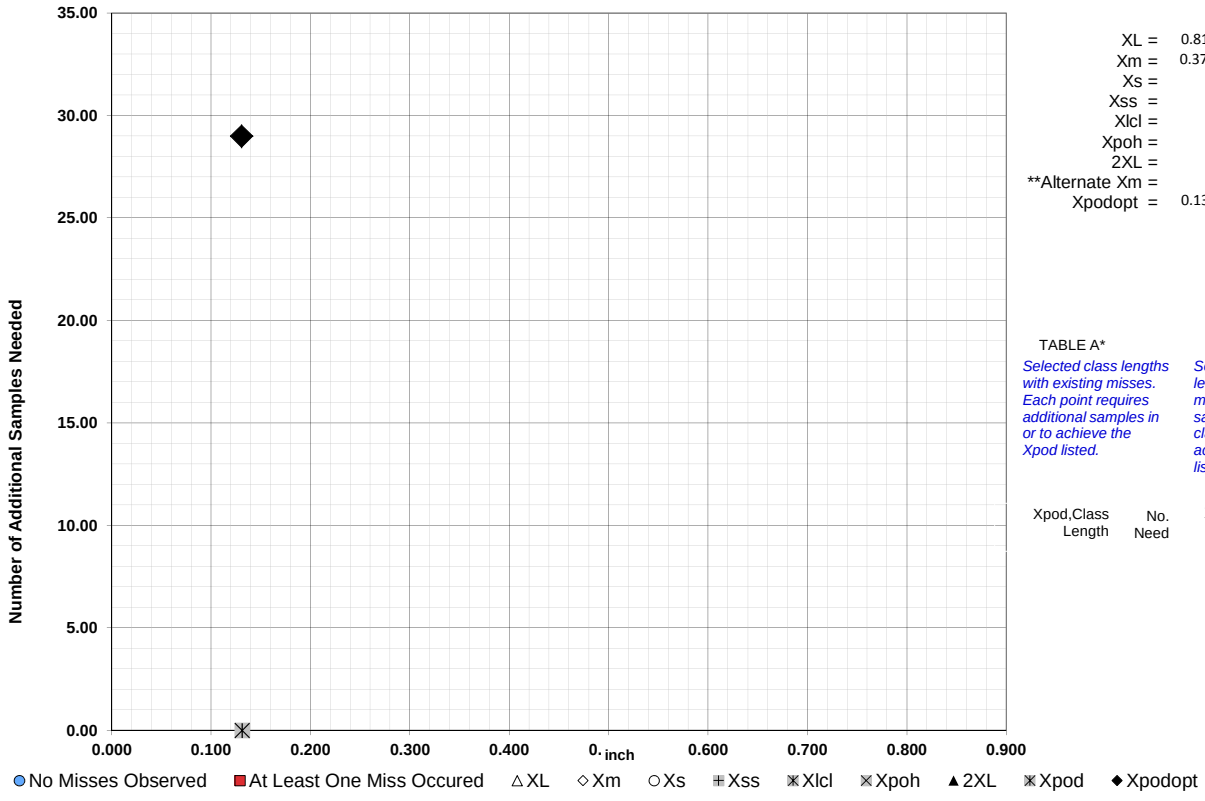



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.131 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

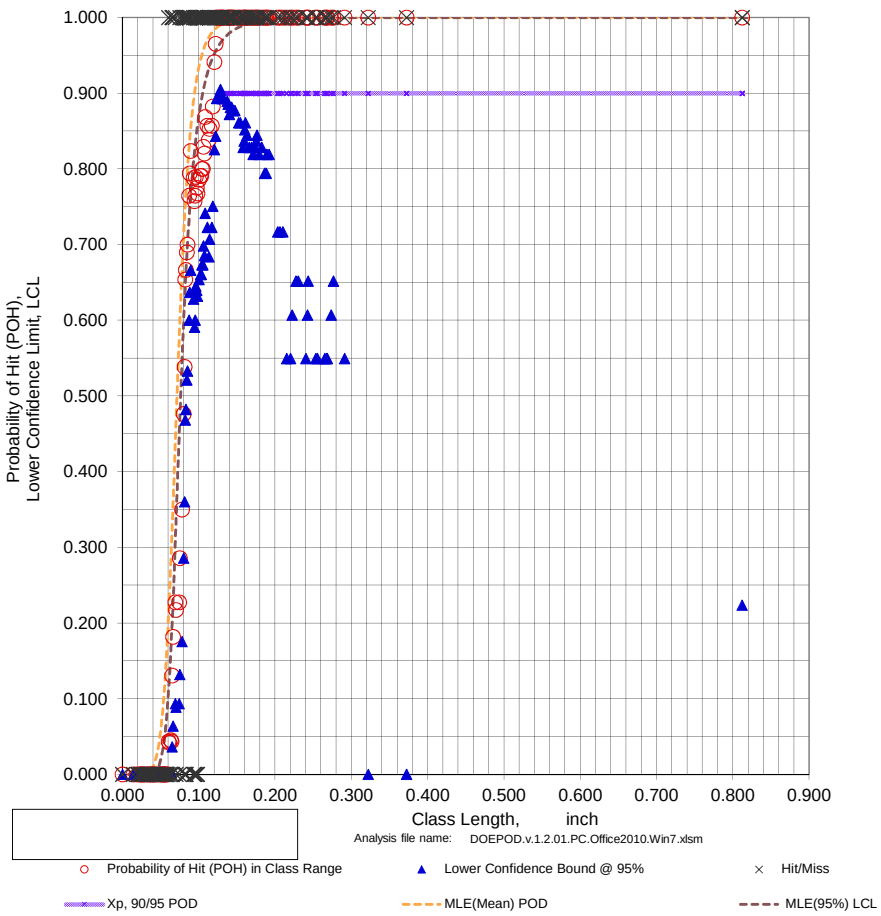
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6001JR.XLS**

Data Set Name = **A6001JR(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:13 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0240 | inch |
| Classlength @ 90/95 Xpod = | 0.1280 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1000 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.922 | @ | 0.110 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.123 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.1280 | inch |

File Name = A6001JR.XLS
Data Set Name = A6001JR(SITE CODE)

## Directed DOE Options

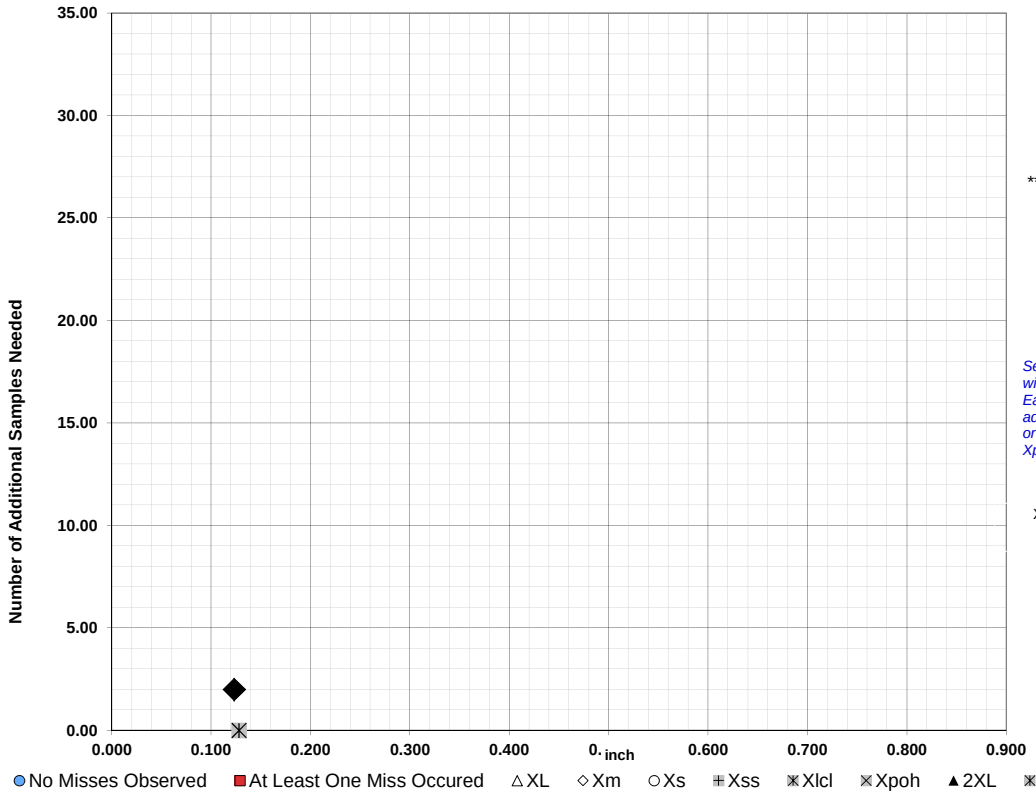



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.123 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

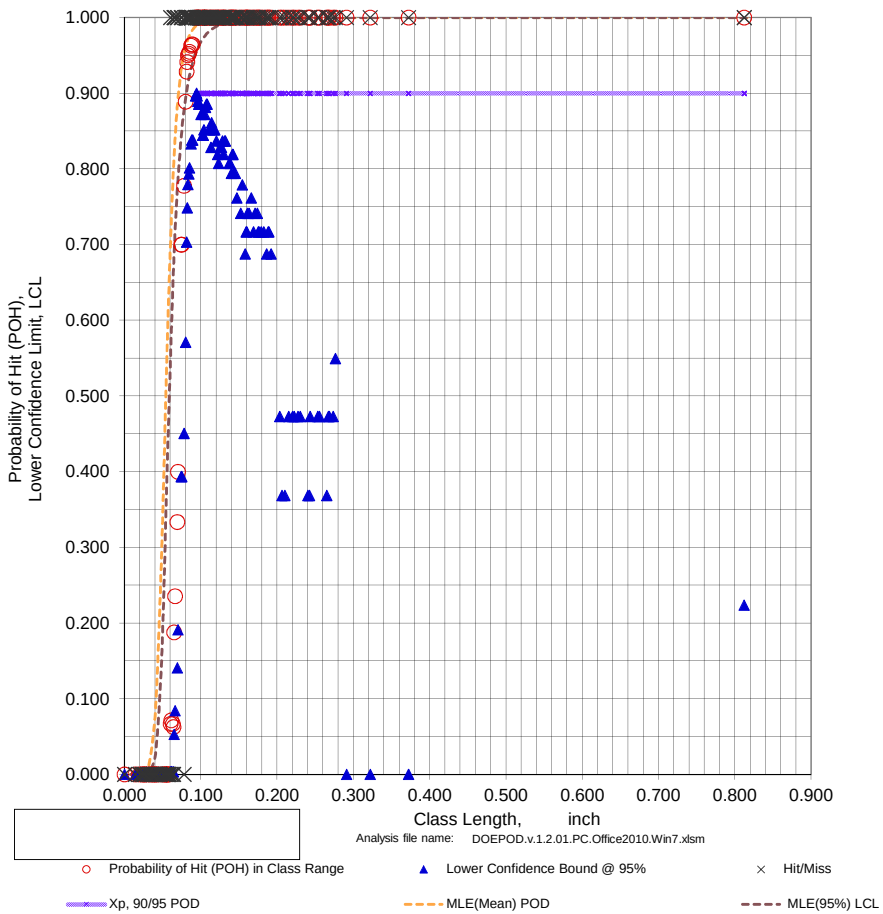
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6002A.XLS**

Data Set Name = **A6002A(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:14 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0140 | inch |
| Classlength @ 90/95 Xpod = | 0.0940 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0800 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.936 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.923 | @ | 0.085 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.276 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.093 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.0940 | inch |

File Name = A6002A.XLS
Data Set Name = A6002A(SITE CODE)

## Directed DOE Options

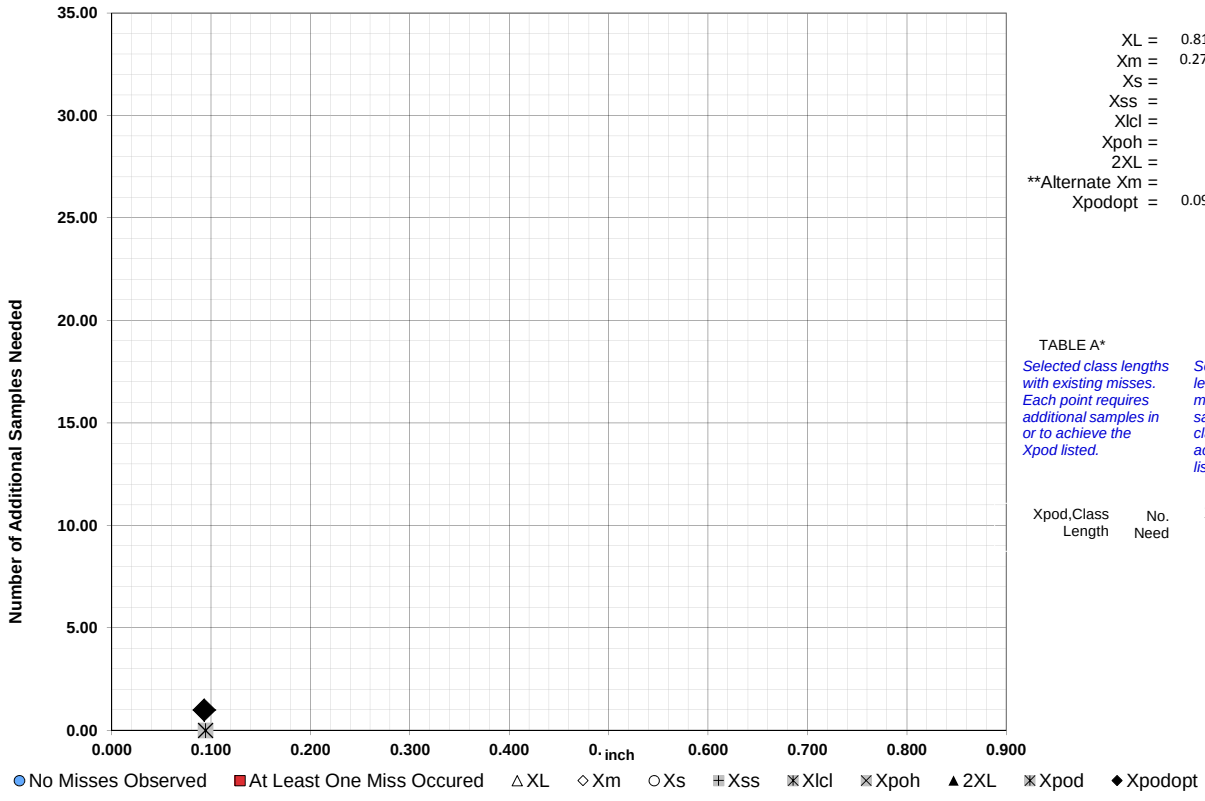



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.276 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.093 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

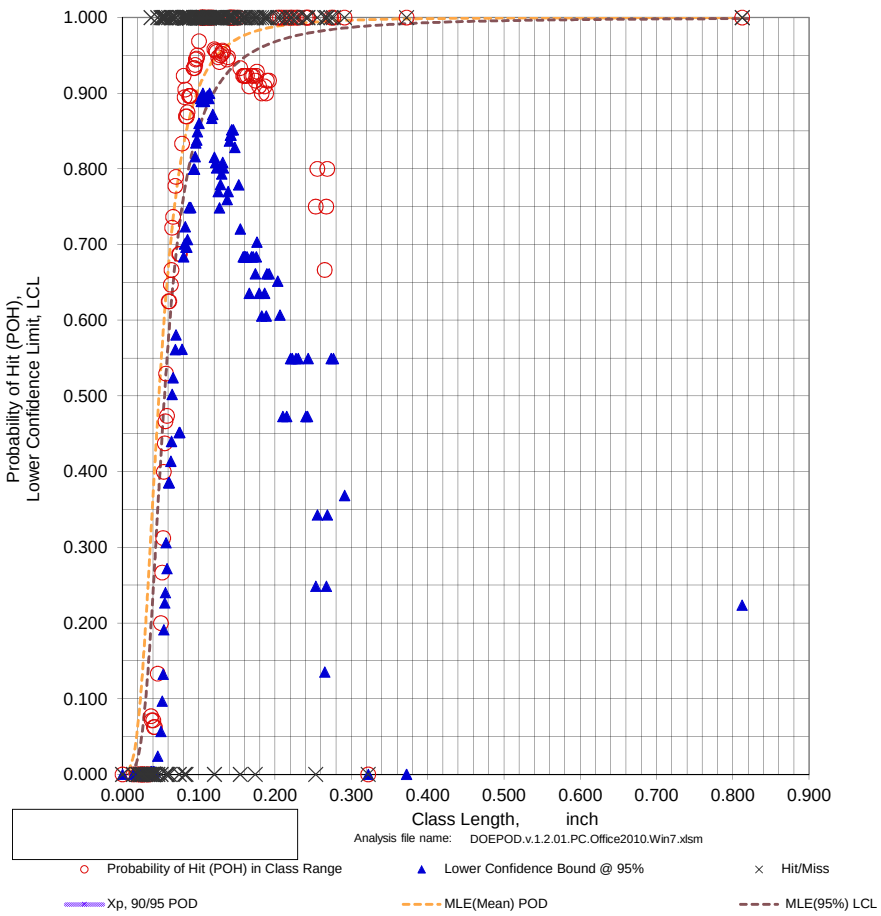
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Warning: No false call analysis.**




File Name = **A6002B.XLS**

Data Set Name = **A6002B(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:15 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1050 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.908 | @ | 0.100 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.120 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | 26 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6002B.XLS
Data Set Name = A6002B(SITE CODE)

## Directed DOE Options

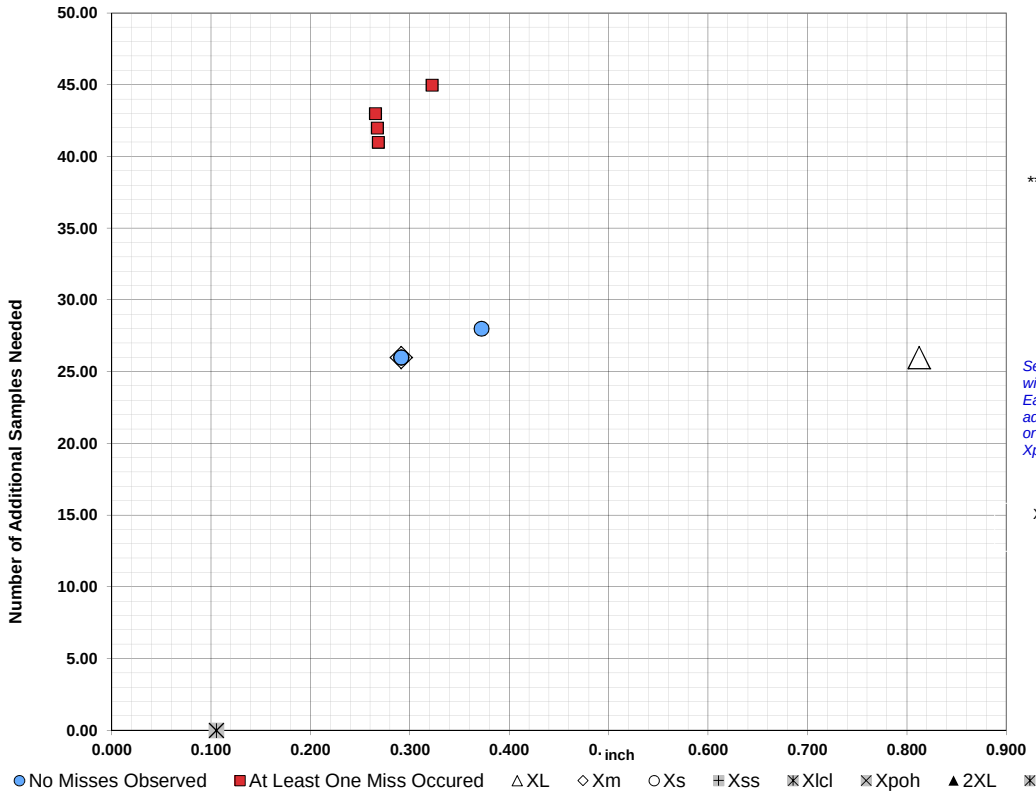



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 26 |
| Xm = | 0.291 | 26 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3220 | 45 |
| 0.2680 | 41 |
| 0.2670 | 42 |
| 0.2650 | 43 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3720 | 28 |
| 0.2910 | 26 |
| 0.2910 | 26 |
| 0.2910 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

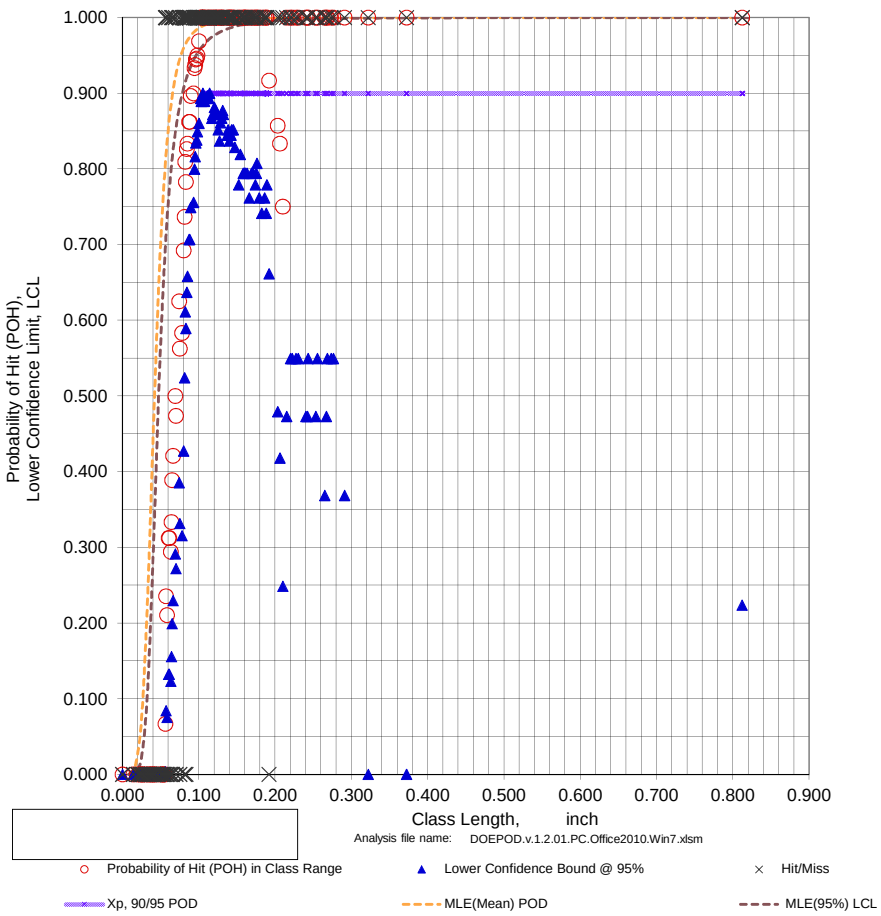
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6002C.XLS**

Data Set Name = **A6002C(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:17 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1050 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.926 | @ | 0.070 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.080 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1050 | inch |

File Name = A6002C.XLS
Data Set Name = A6002C(SITE CODE)

## Directed DOE Options

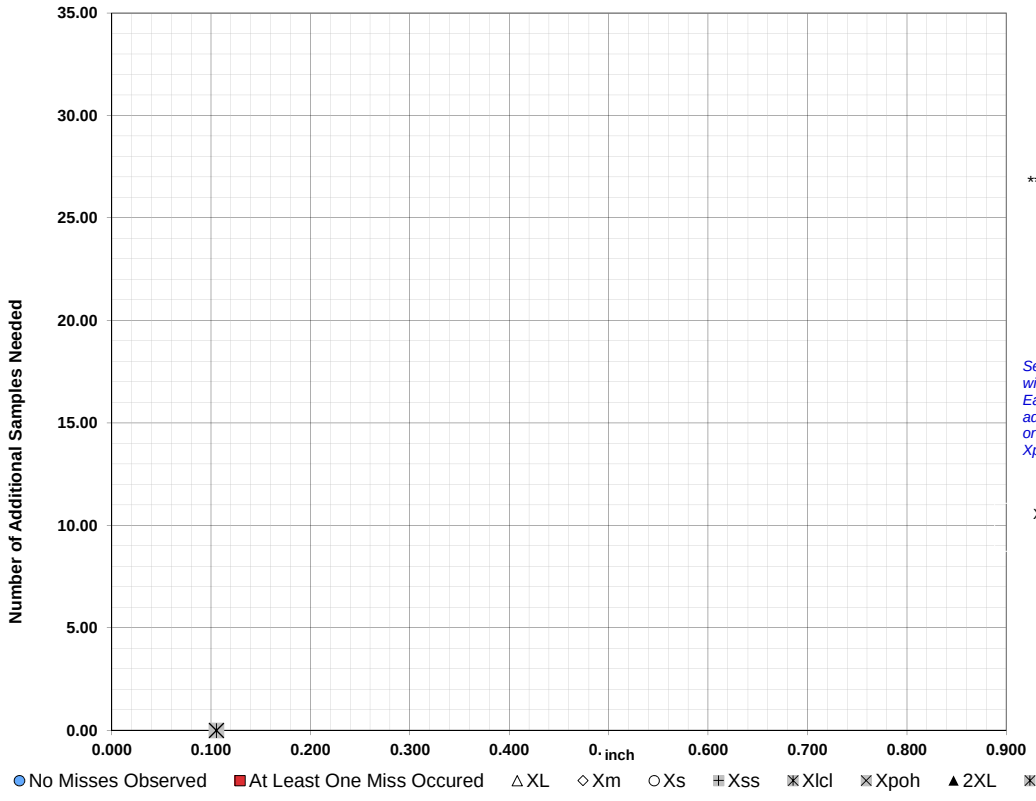



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

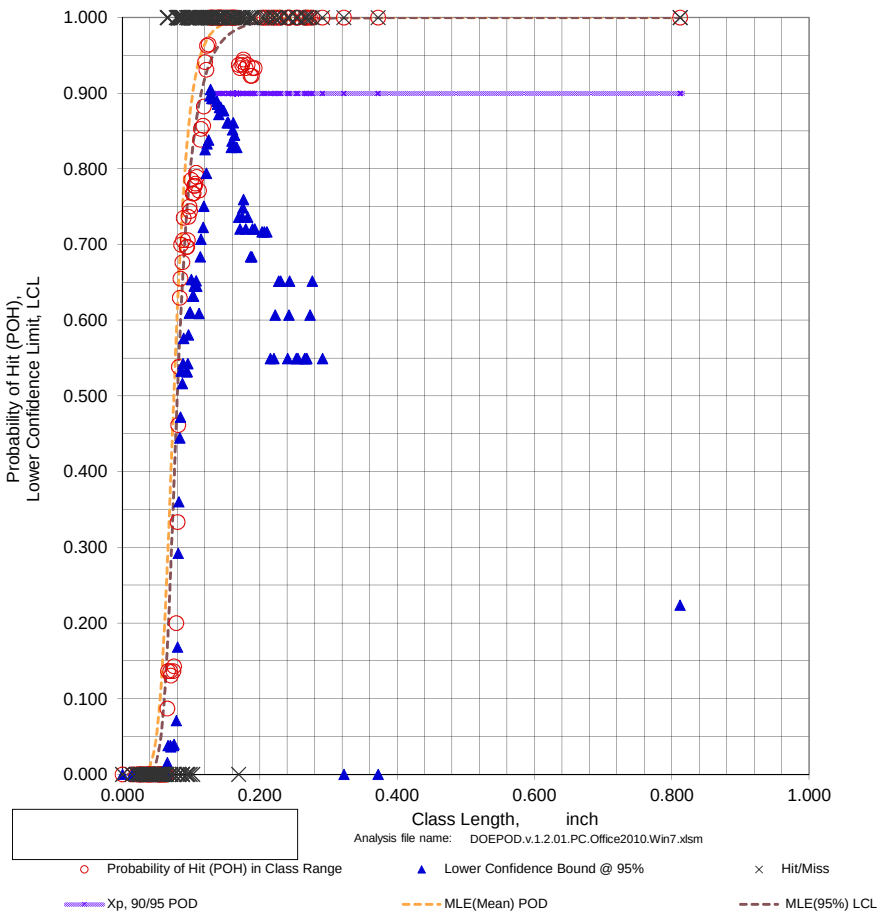
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6002D.XLS**

Data Set Name = **A6002D(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:18 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0240 | inch |
| Classlength @ 90/95 Xpod = | 0.1280 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.917 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1280 | inch |

File Name = A6002D.XLS
Data Set Name = A6002D(SITE CODE)

## Directed DOE Options

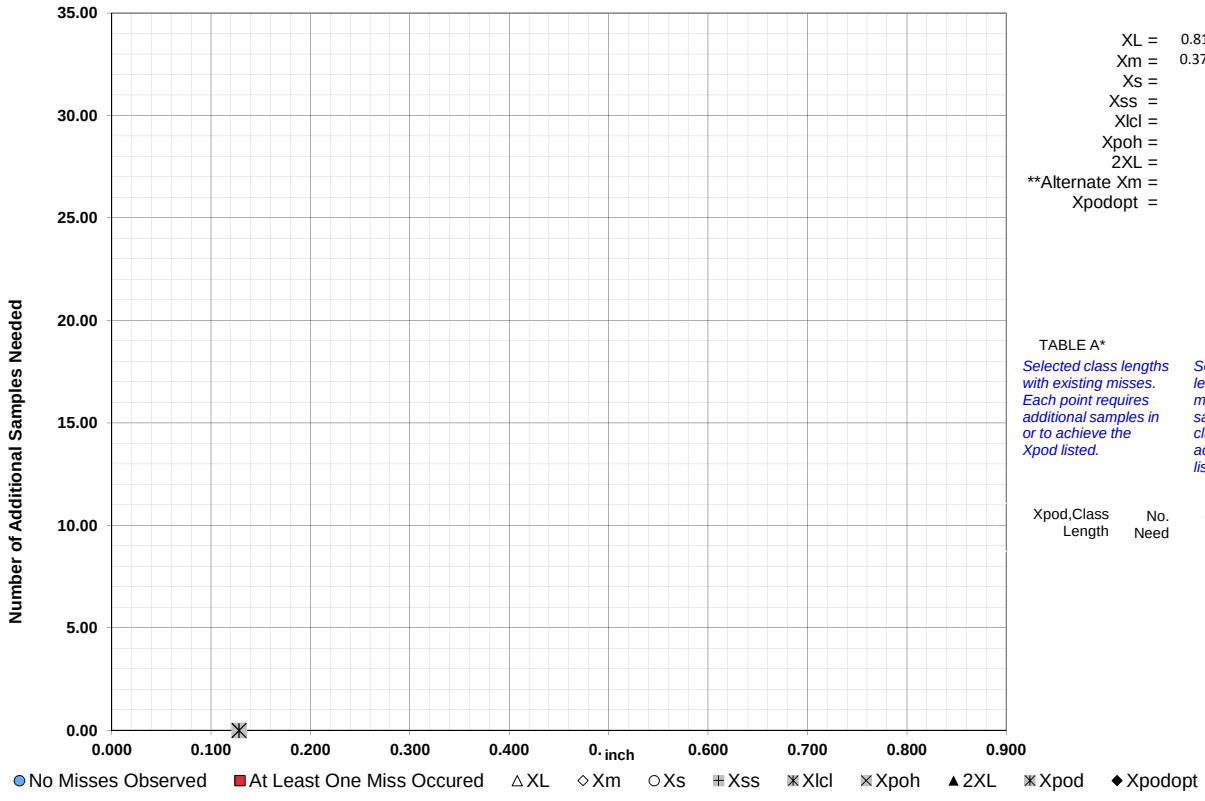



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

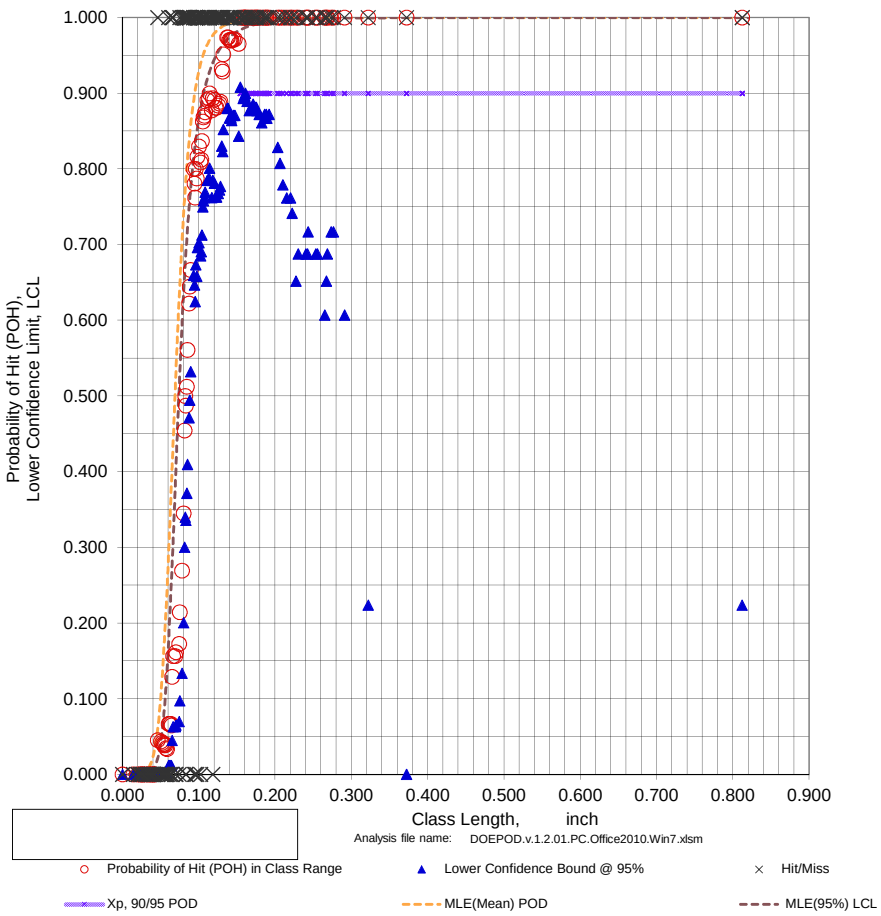
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 17 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6002DR.XLS**

Data Set Name = **A6002DR(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:19 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0340 | inch |
| Classlength @ 90/95 Xpod = | 0.1540 | inch |
| Lower Confidence Bound = | 0.9077 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1200 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.915 | @ | 0.110 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.322 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.153 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1540 | inch |

File Name = A6002DR.XLS
Data Set Name = A6002DR(SITE CODE)

## Directed DOE Options

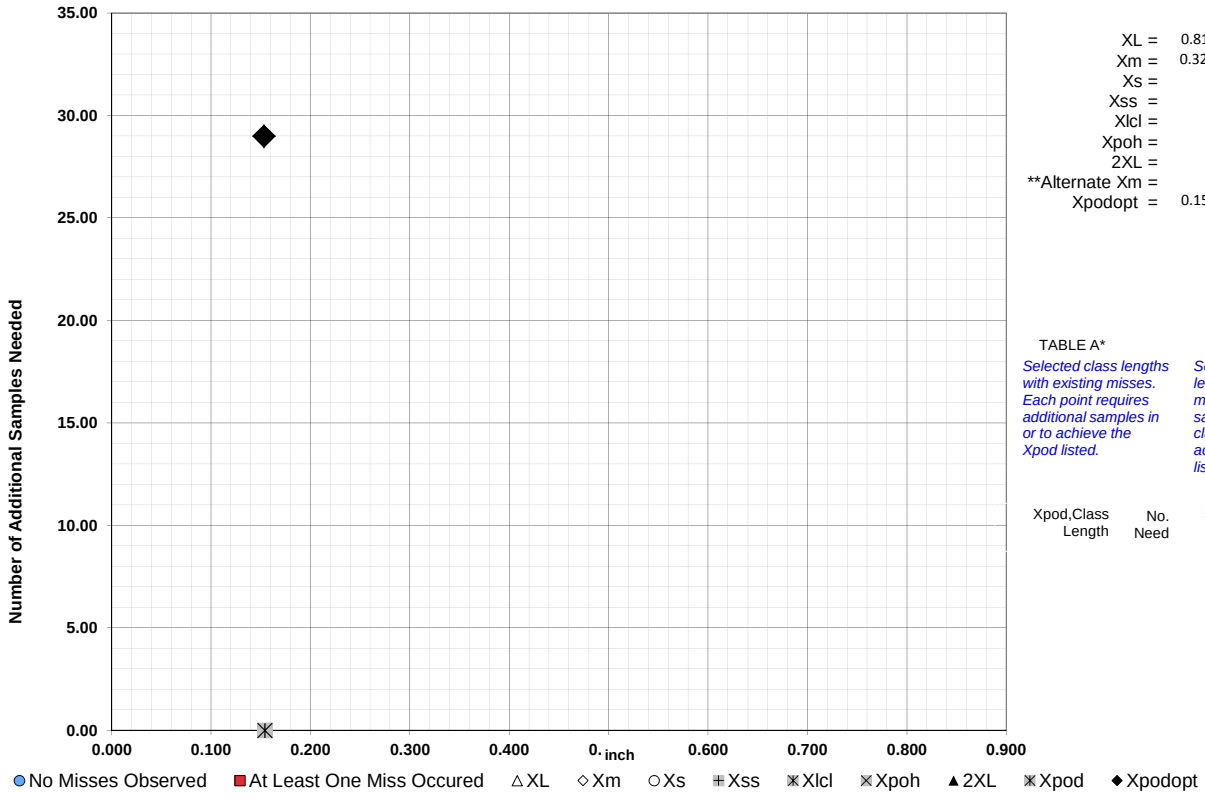



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.322 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.153 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

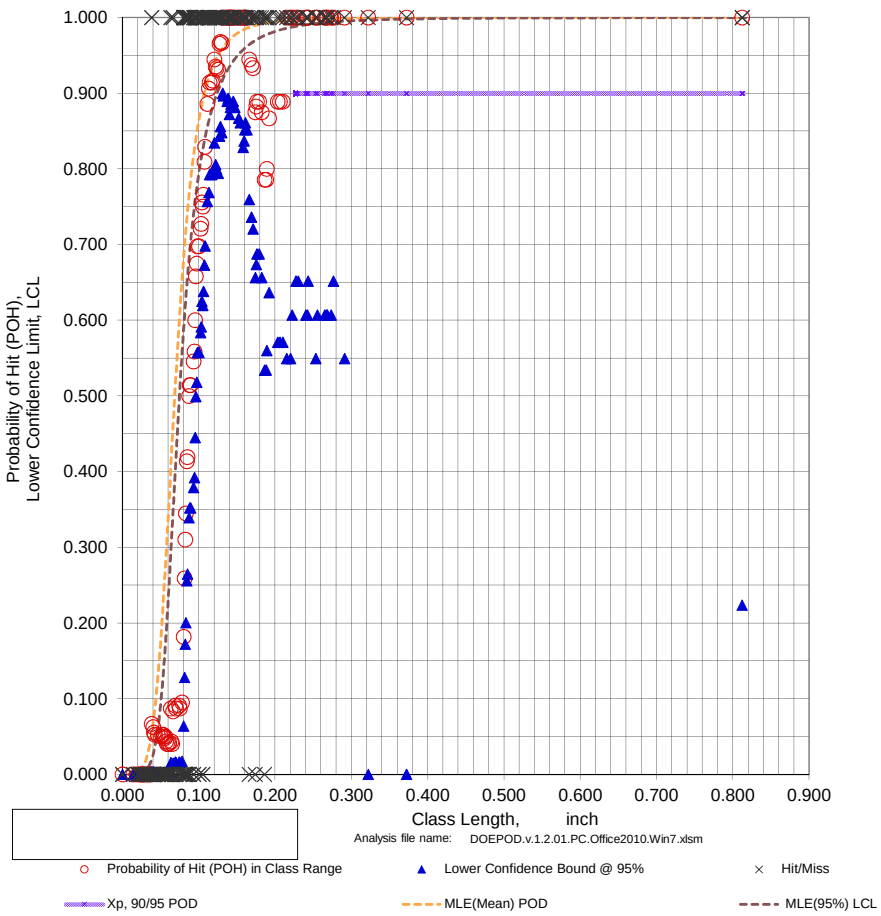
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6002E.XLS**

Data Set Name = **A6002E(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:20 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0250 | inch |
| Classlength @ 90/95 Xpod = | 0.1310 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.911 | @ | 0.130 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2270 | inch |

File Name = A6002E.XLS
Data Set Name = A6002E(SITE CODE)

## Directed DOE Options

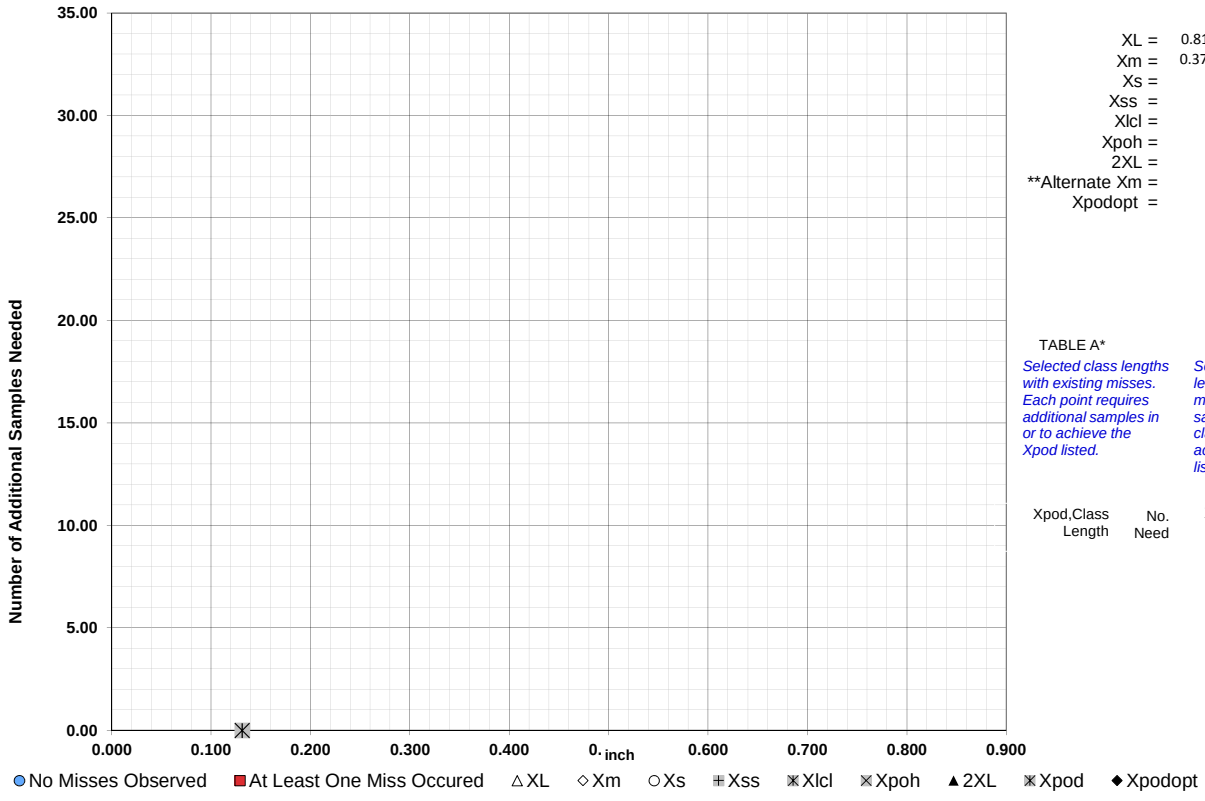



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

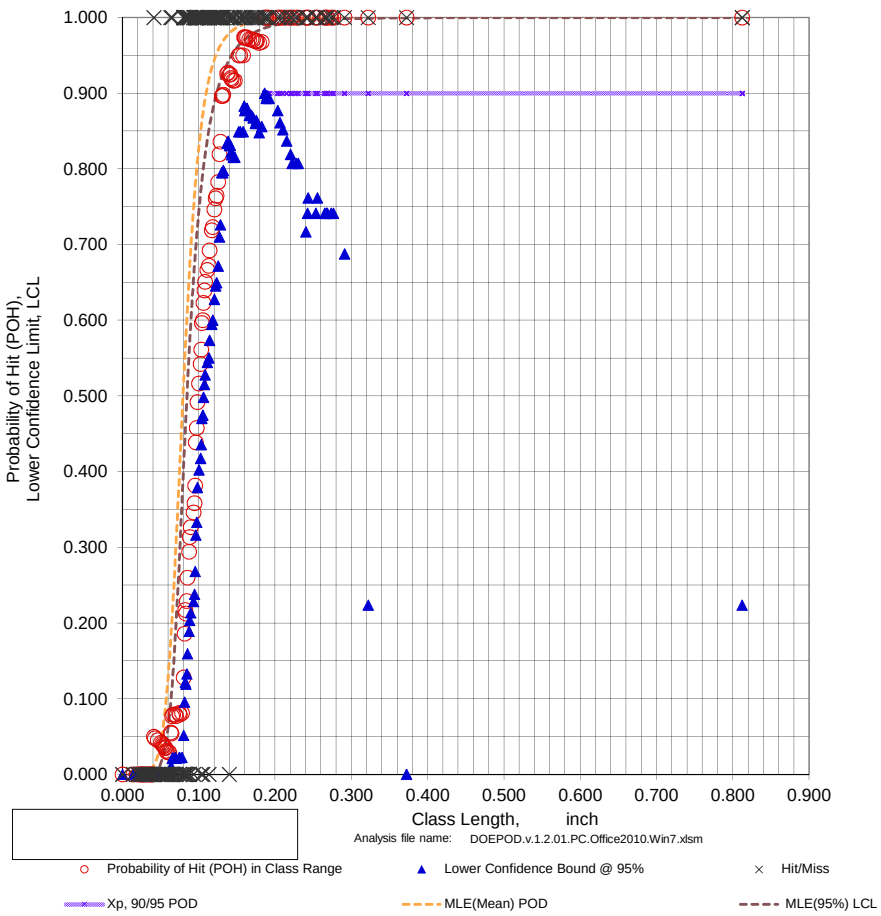
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 18 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6002ER.XLS**

Data Set Name = **A6002ER(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:21 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0450 | inch |
| Classlength @ 90/95 Xpod = | 0.1860 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1420 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.125 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.184 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1860 | inch |

File Name = A6002ER.XLS
Data Set Name = A6002ER(SITE CODE)

## Directed DOE Options

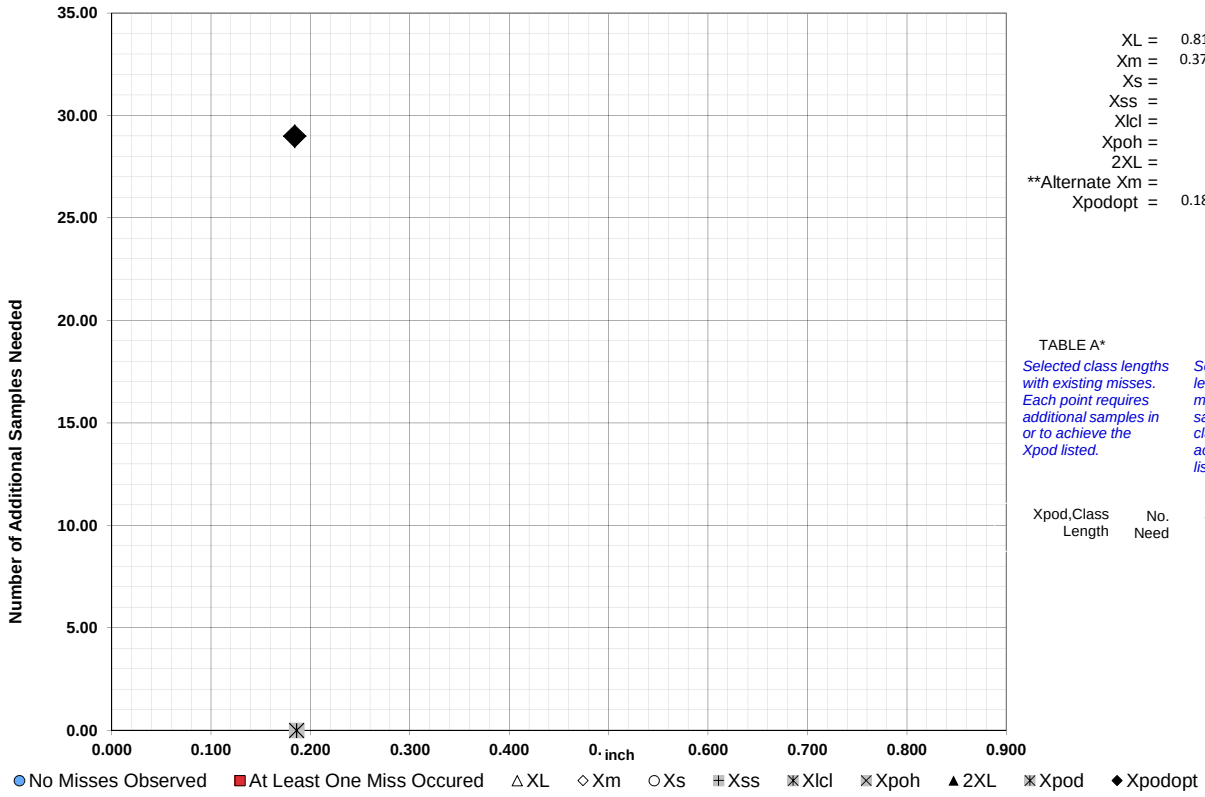



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.184 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

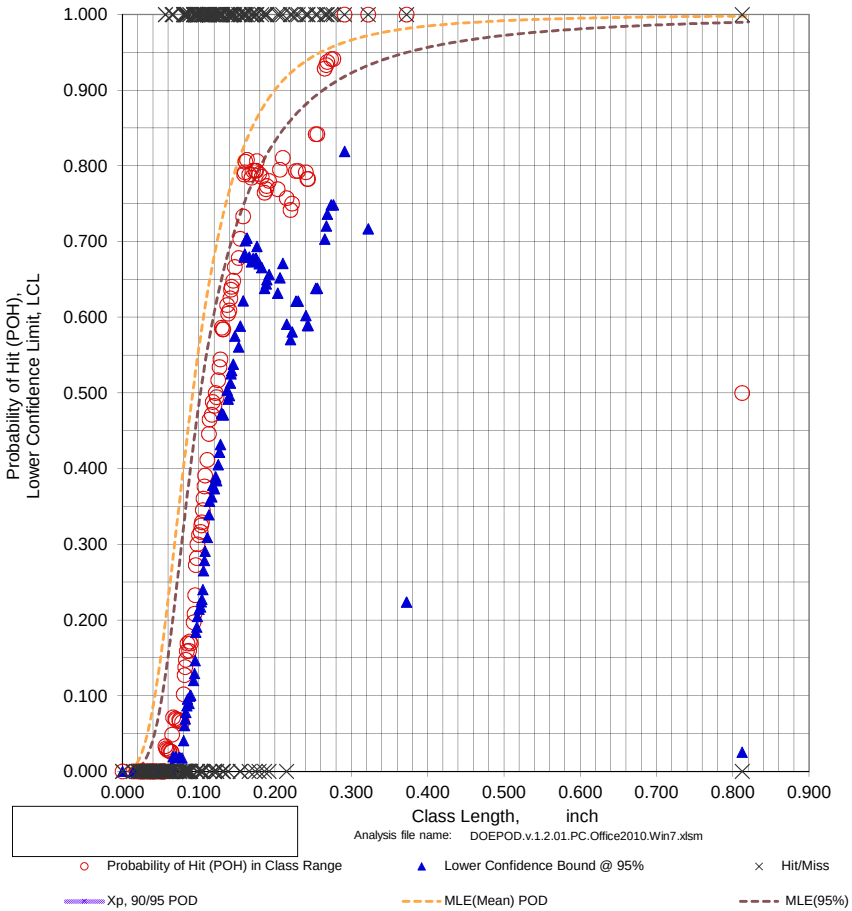
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A6002F.XLS
Data Set Name = A6002F(SITE CODE)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:22 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.0710 | inch |
| Classlength @ Best LCL = | 0.2910 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.200 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.265 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.624 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6002F.XLS
Data Set Name = A6002F(SITE CODE)

## Directed DOE Options

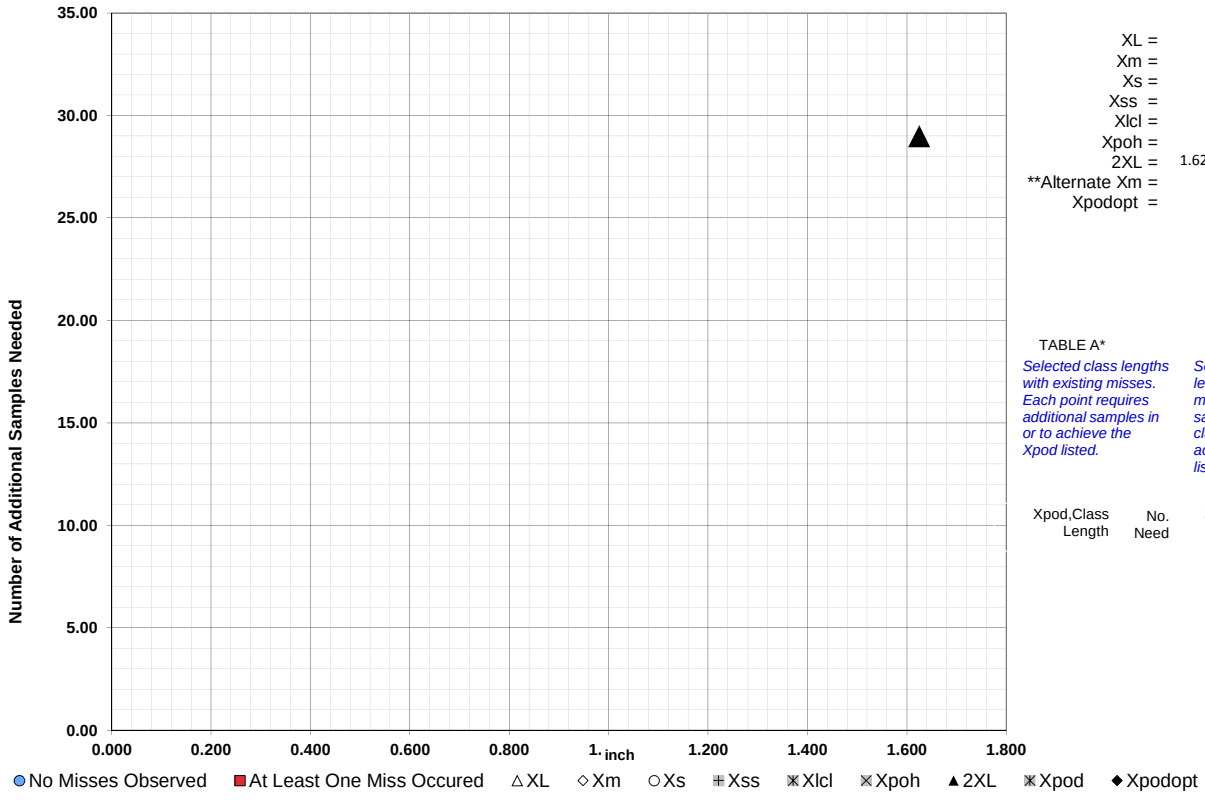



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.624 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

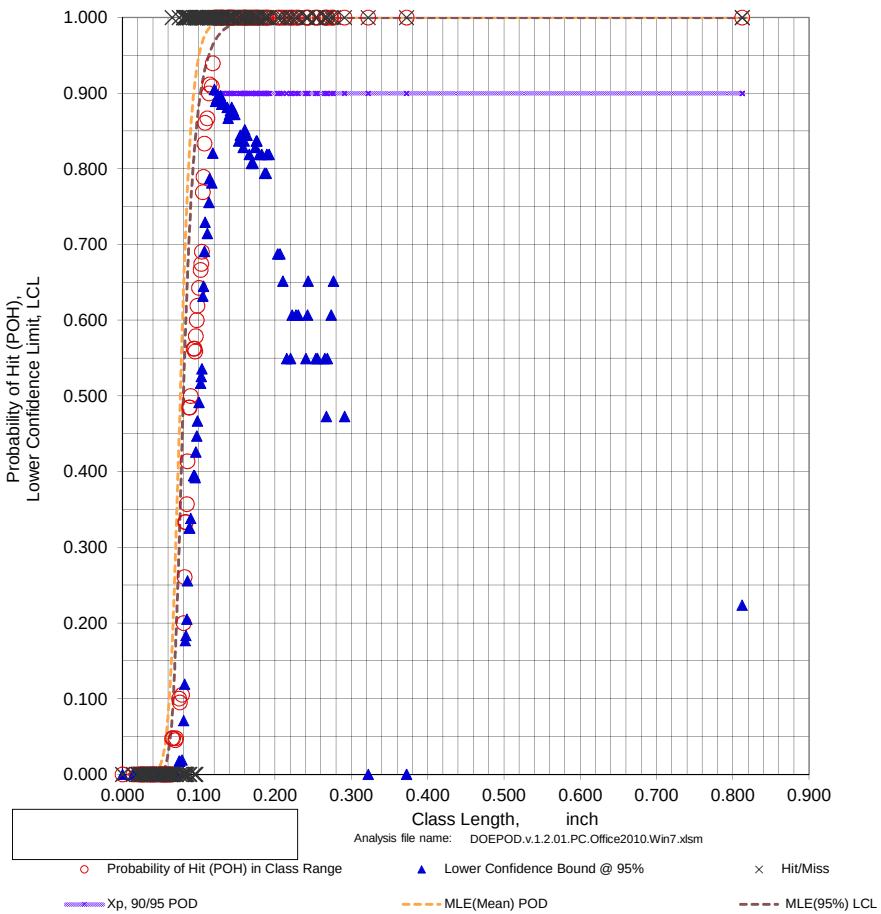
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6002G.XLS**

Data Set Name = **A6002G(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:24 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0230 | inch |
| Classlength @ 90/95 Xpod = | 0.1200 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0980 -0.001 inch 24 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.916 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.917 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.119 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1200 | inch |

File Name = A6002G.XLS
Data Set Name = A6002G(SITE CODE)

## Directed DOE Options

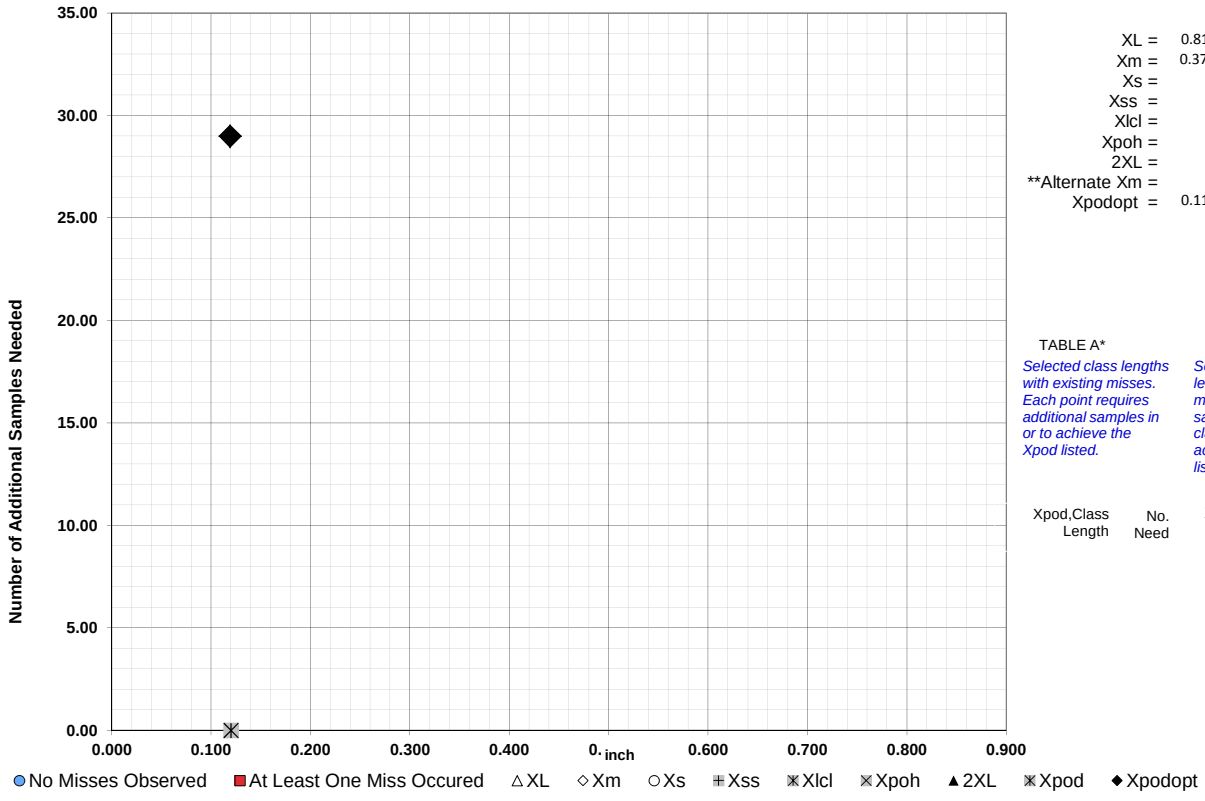



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.119 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

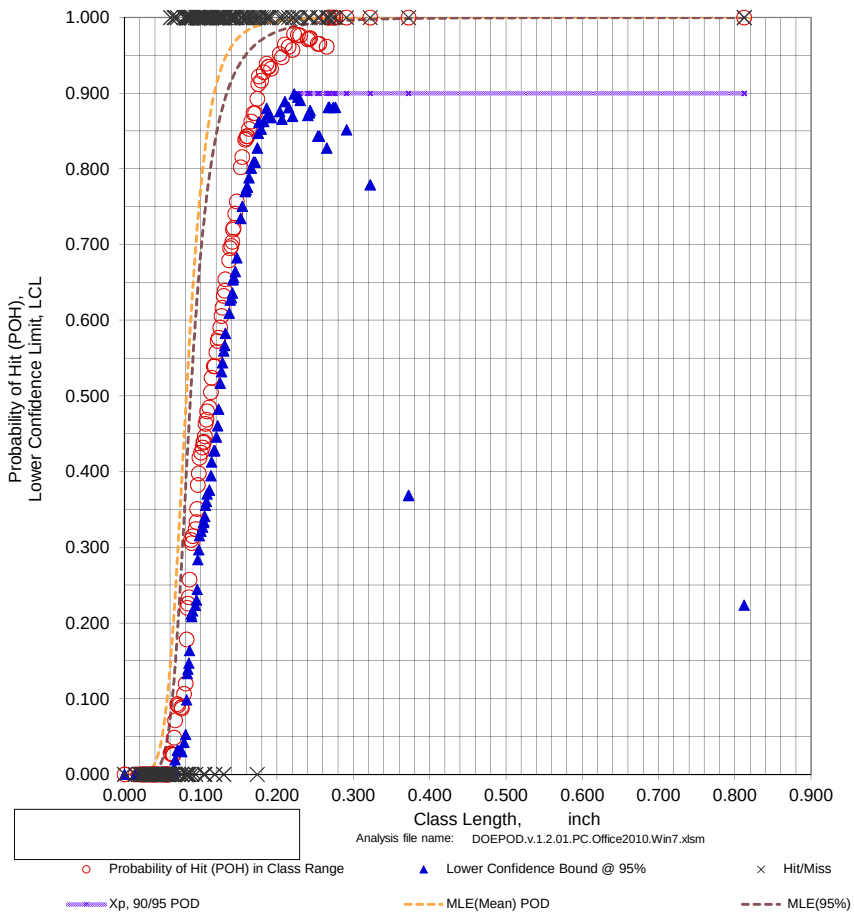
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6002H.XLS**

Data Set Name = **A6002H(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:25 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0910 | inch |
| Classlength @ 90/95 Xpod = | 0.2220 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.1760 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.120 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.135 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2220 | inch |

File Name = A6002H.XLS
Data Set Name = A6002H(SITE CODE)

## Directed DOE Options

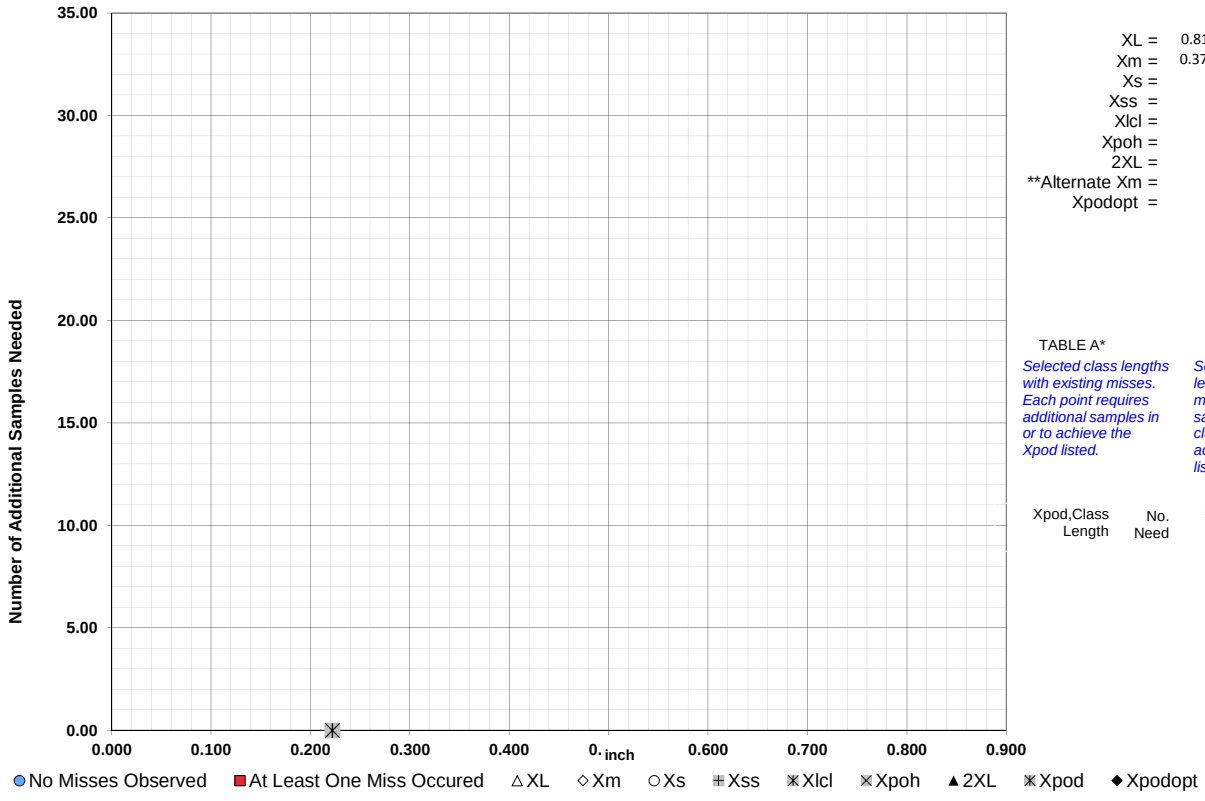



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

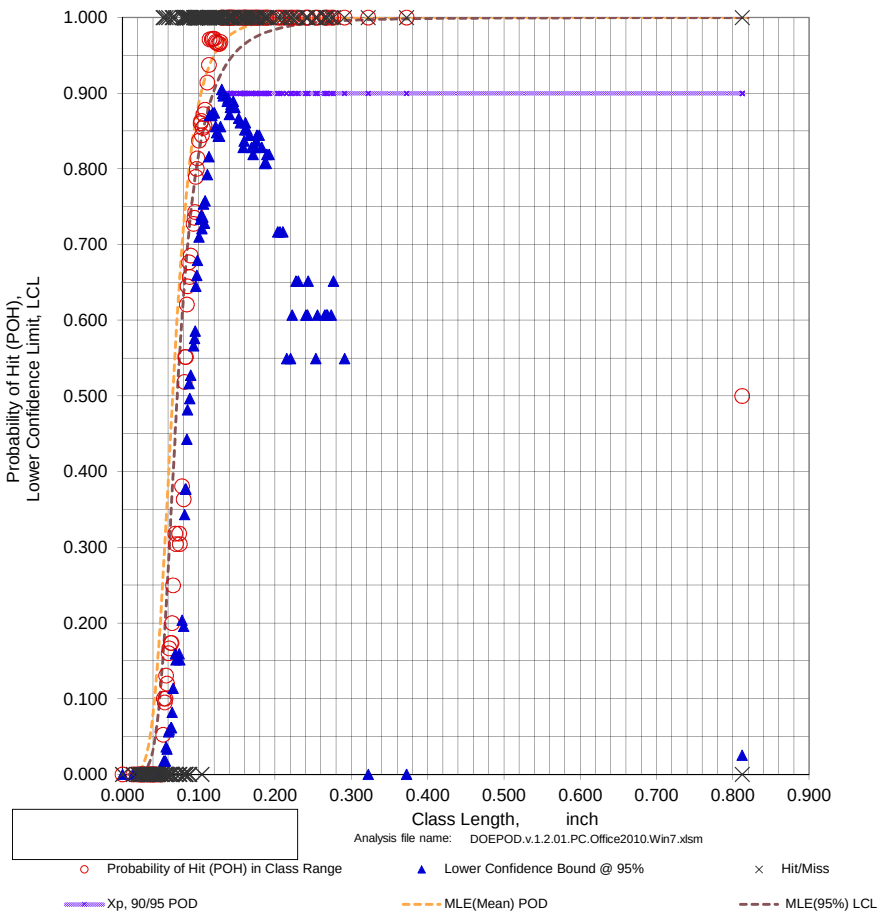
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6002HR.XLS**

Data Set Name = **A6002HR(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:27 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0250 | inch |
| Classlength @ 90/95 Xpod = | 0.1300 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.909 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.120 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1300 | inch |

File Name = A6002HR.XLS
Data Set Name = A6002HR(SITE CODE)

## Directed DOE Options

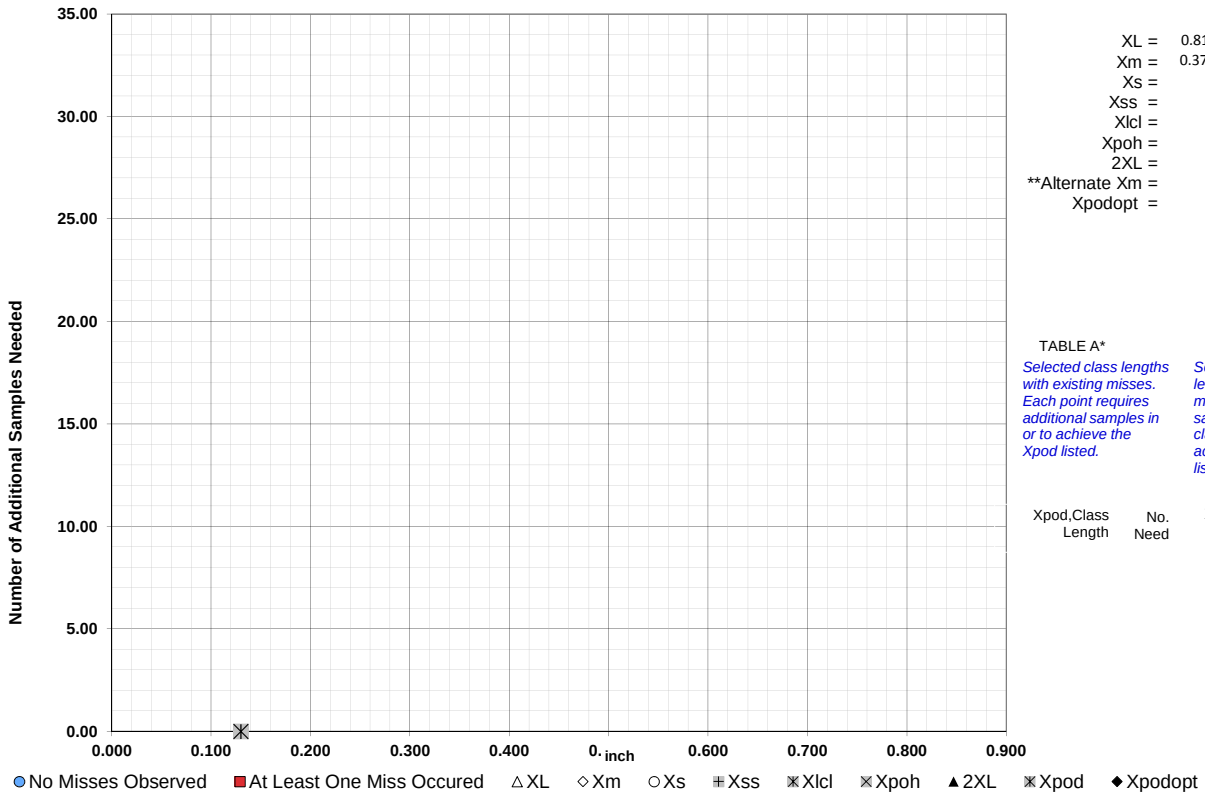



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

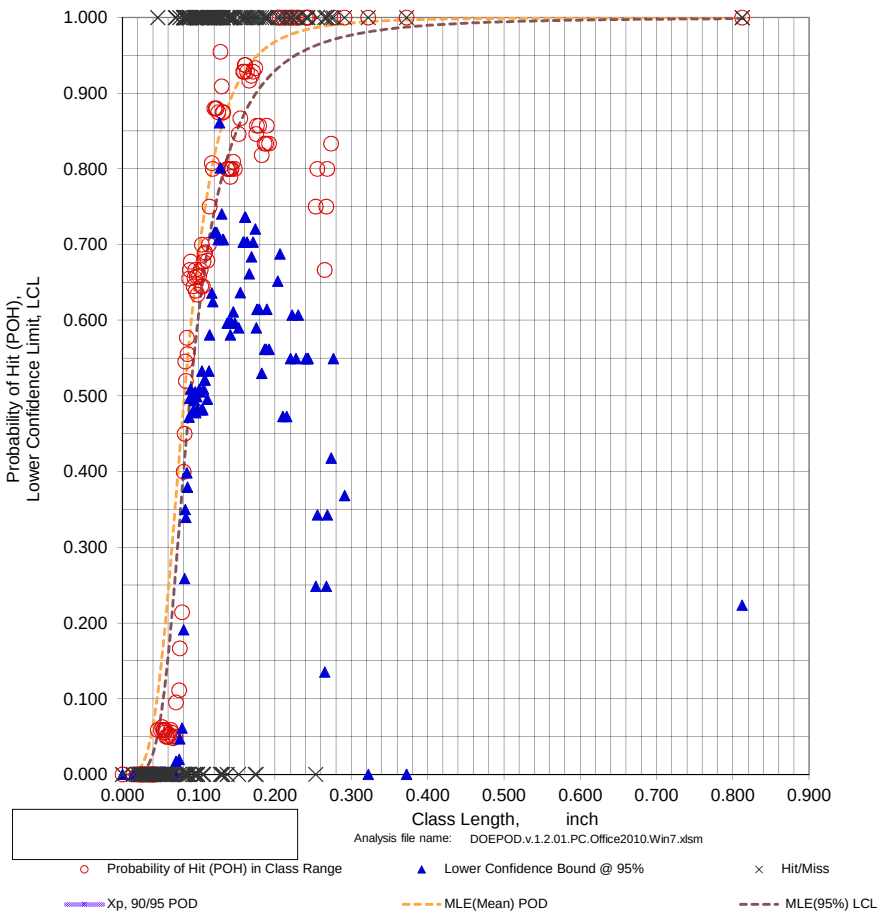
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A6002J.XLS
Data Set Name = A6002J(SITE CODE)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:28 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8609 | |
| Classwidth @ Best LCL = | 0.0200 | inch |
| Classlength @ Best LCL = | 0.1270 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2550 -0.001 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.145 inch
NTIAC 90/95 POD = 0.900 @ 0.175 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.276 | inch |
| Samples Needed @ Xpoh = | 24 | |
| New Largest Classlength , 2XL = | 1.624 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6002J.XLS
Data Set Name = A6002J(SITE CODE)

## Directed DOE Options

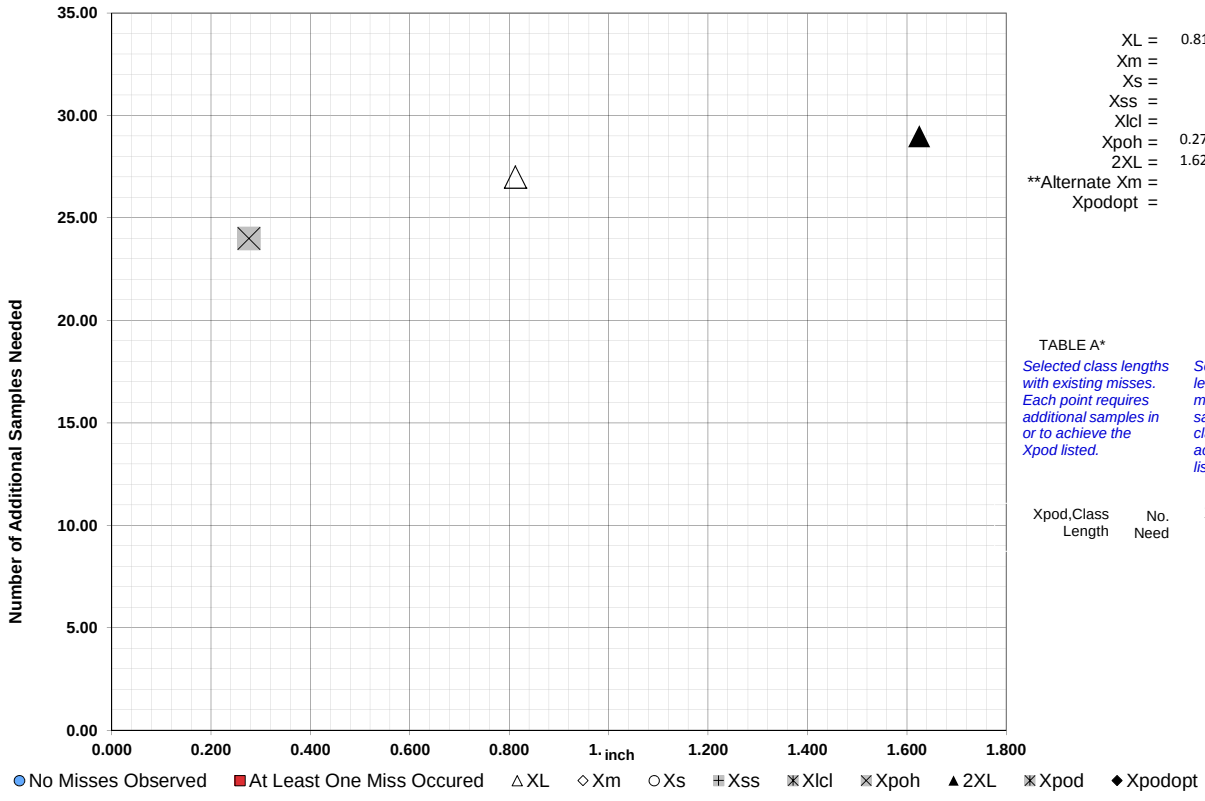



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.276 | 24 |
| 2XL = | 1.624 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

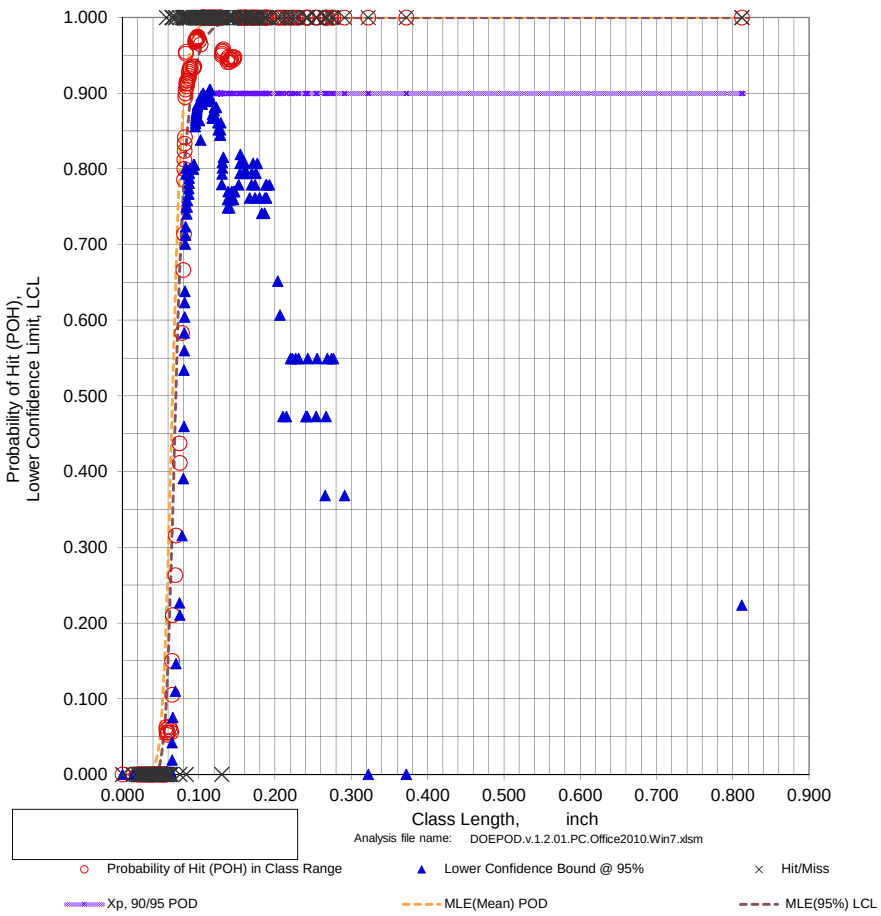
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6003A.XLS**

Data Set Name = **A6003A(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:30 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.1054 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.936 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.930 | @ | 0.095 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1054 | inch |

File Name = A6003A.XLS
Data Set Name = A6003A(SITE CODE)

## Directed DOE Options

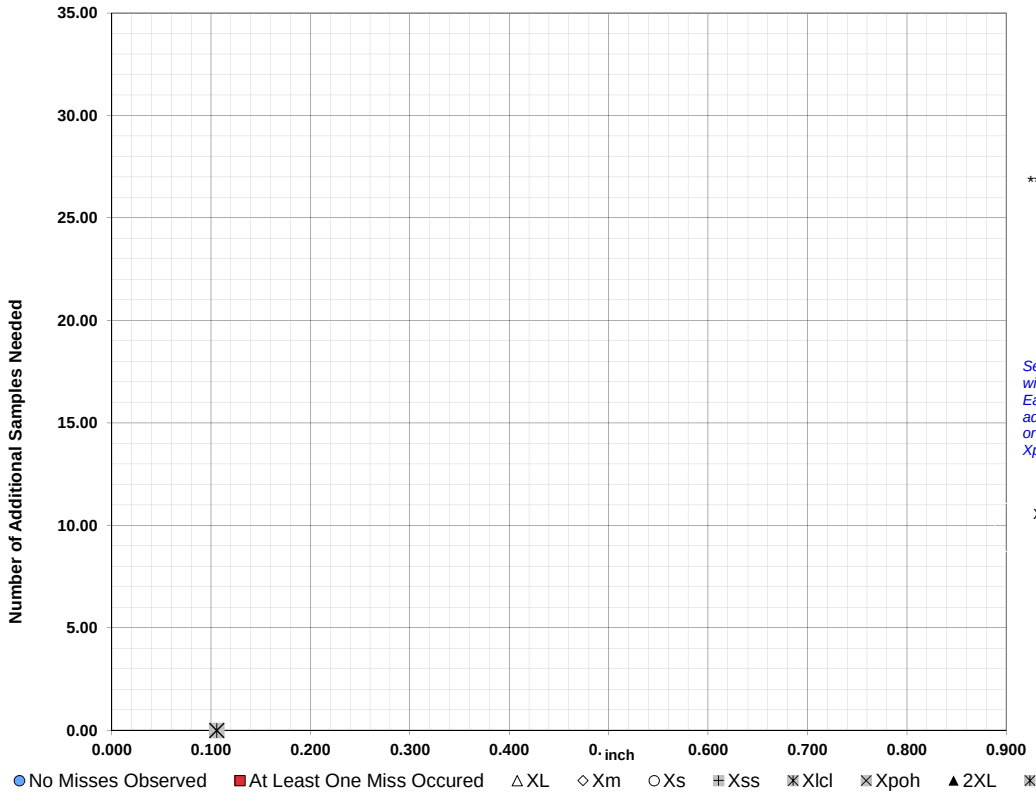



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

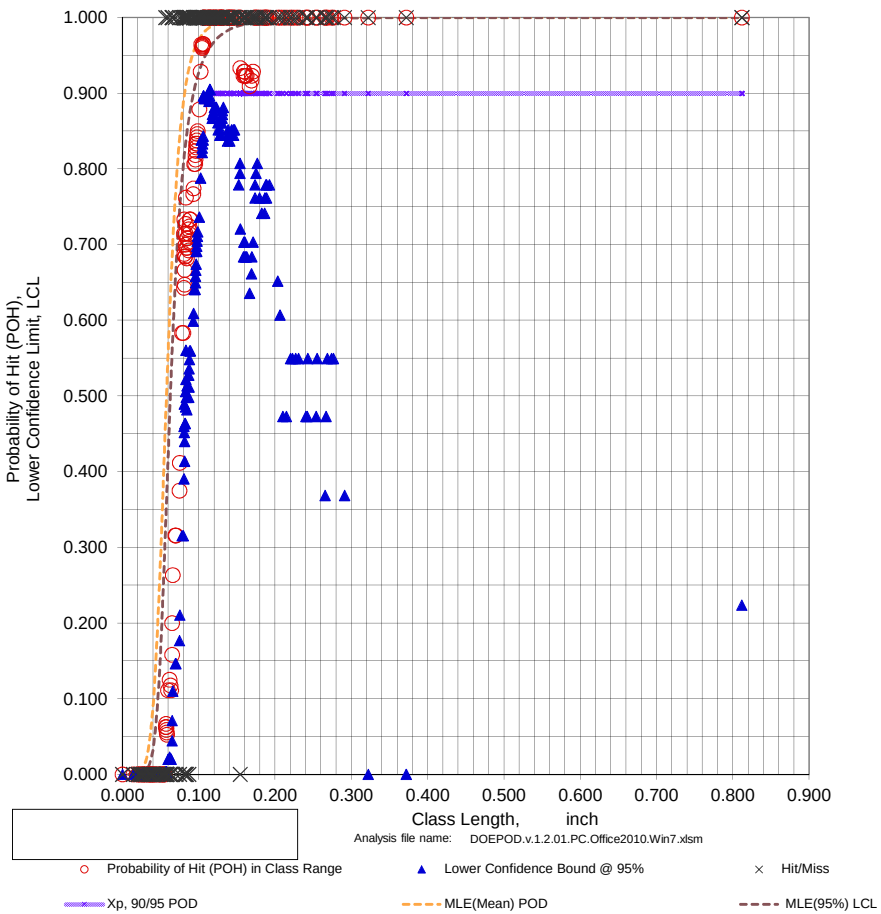
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6003B.XLS**

Data Set Name = **A6003B(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:31 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.1141 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

| | | | | |
|---|---|---|---|---|
| Survey/Optimum Xpoh = | 0.000 | inch | | Samples |
| NTIAC 90% POD = | 0.923 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.909 | @ | 0.095 | inch |
| **False Call Rate =** | **with UCL @ 95% =** | | | |

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1141 | inch |

File Name = A6003B.XLS
Data Set Name = A6003B(SITE CODE)

## Directed DOE Options

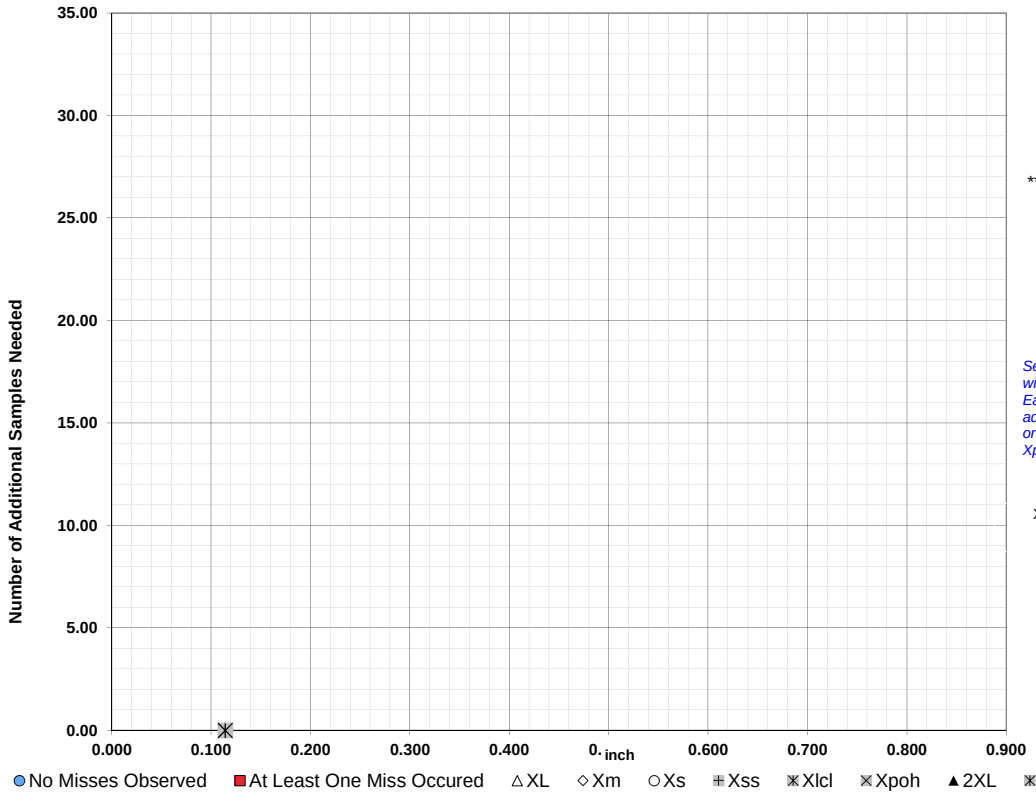



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

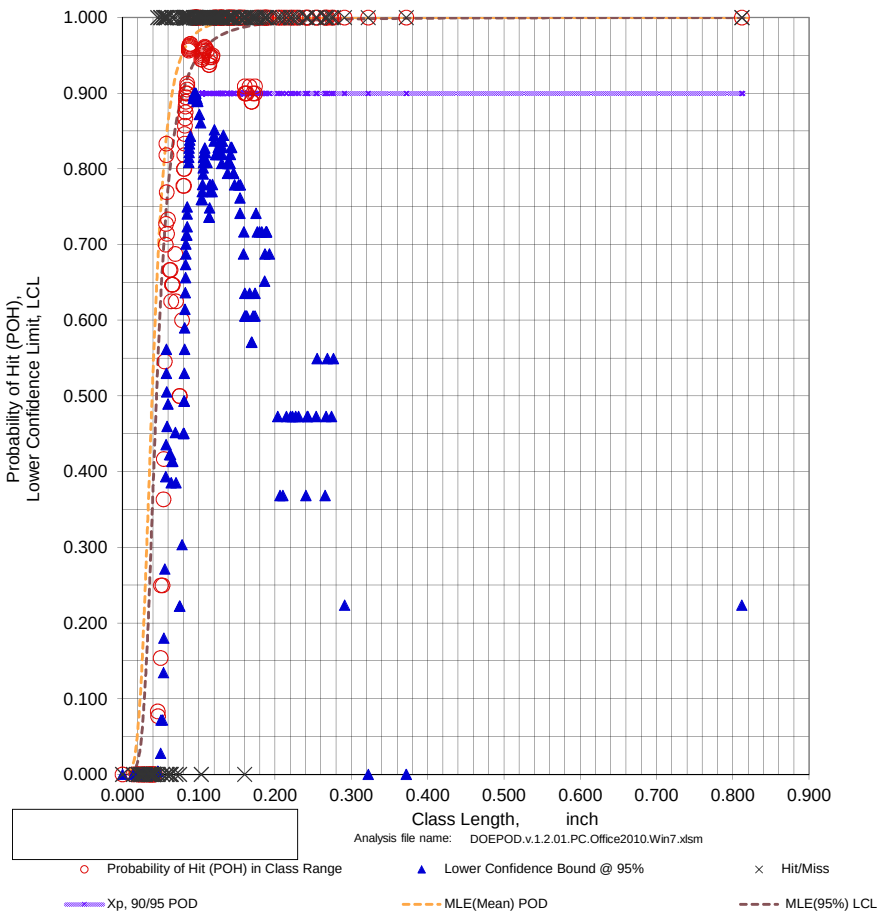
**Any highlighted Misses are RED and shown in Column A of this data sheet**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6003C.XLS**

Data Set Name = **A6003C(SITE CODE)**




| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:32 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0150 | inch |
| Classlength @ 90/95 Xpod = | 0.0936 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.065 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.080 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.276 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1041 | inch |

File Name = A6003C.XLS
Data Set Name = A6003C(SITE CODE)

## Directed DOE Options

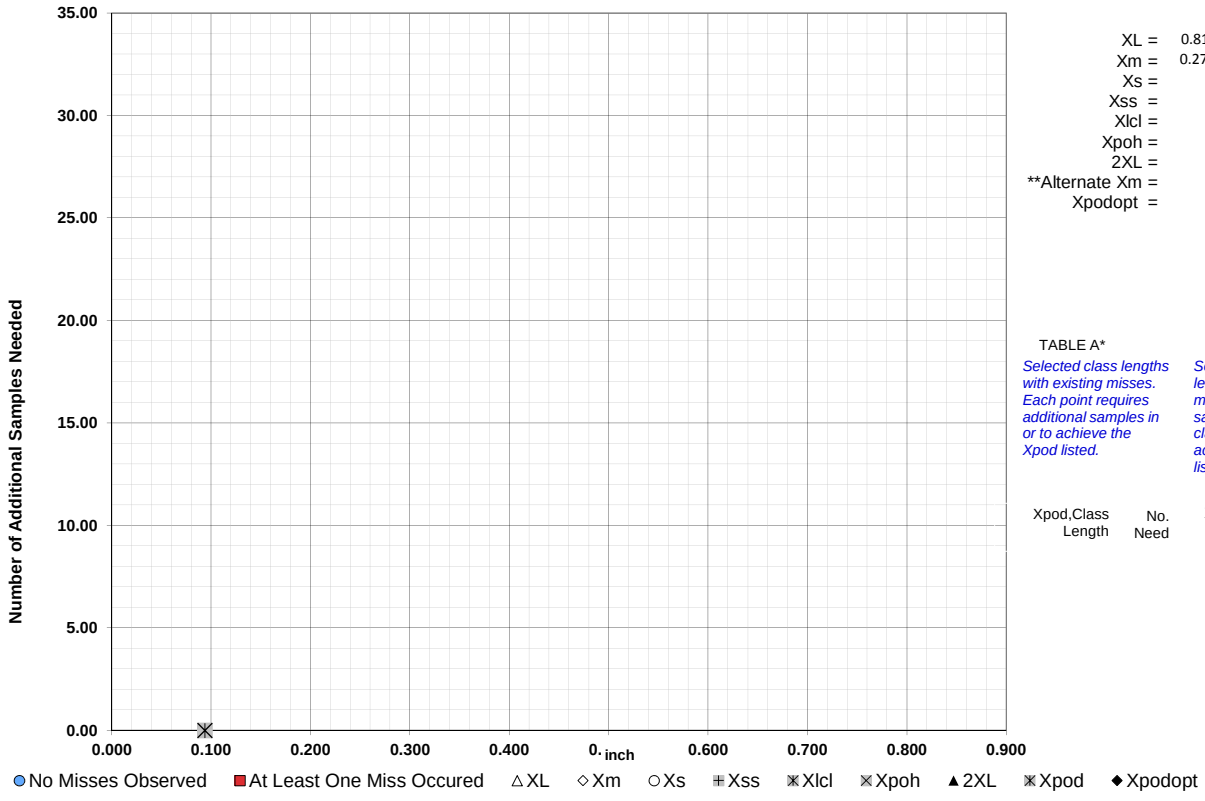



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.276 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

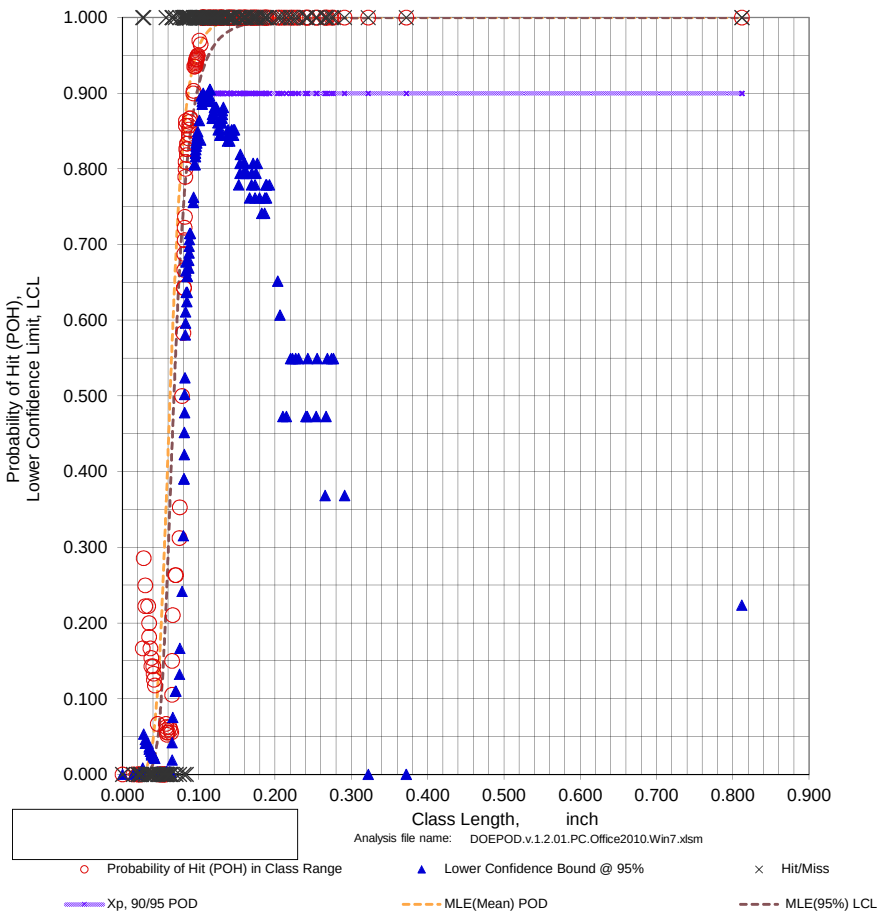
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6003D.XLS**

Data Set Name = **A6003D(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:34 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.1054 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0844 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.924 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.912 | @ | 0.100 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.103 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.1054 | inch |

File Name = A6003D.XLS
Data Set Name = A6003D(SITE CODE)

## Directed DOE Options

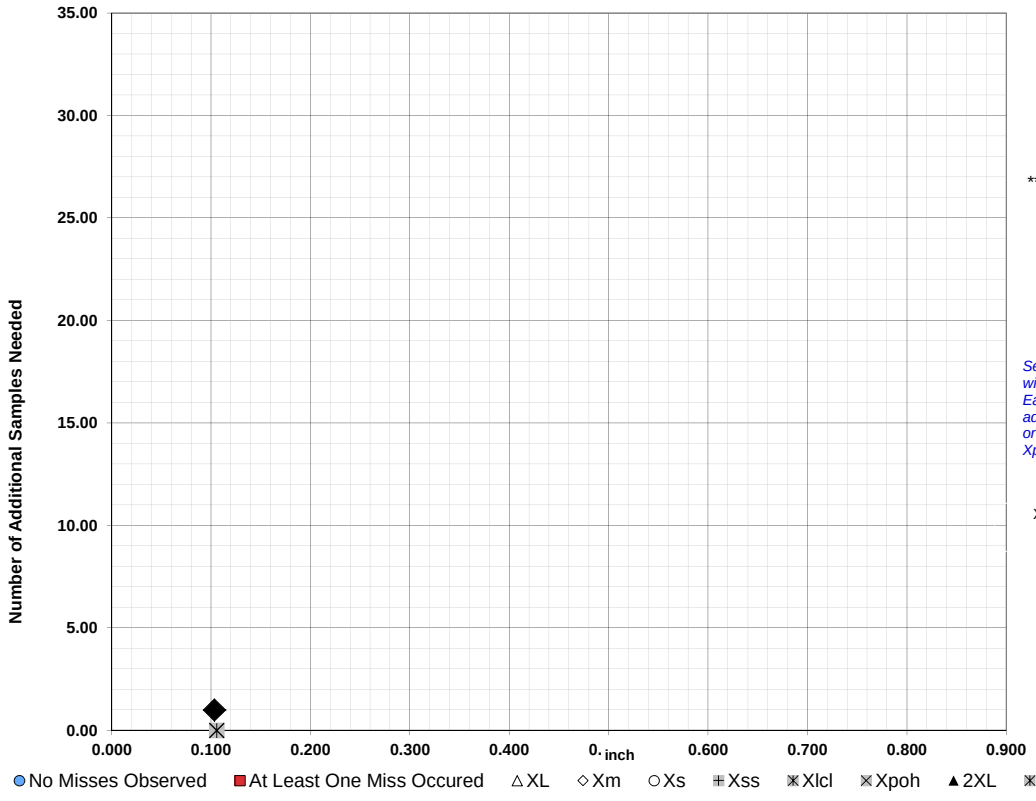



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.103 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

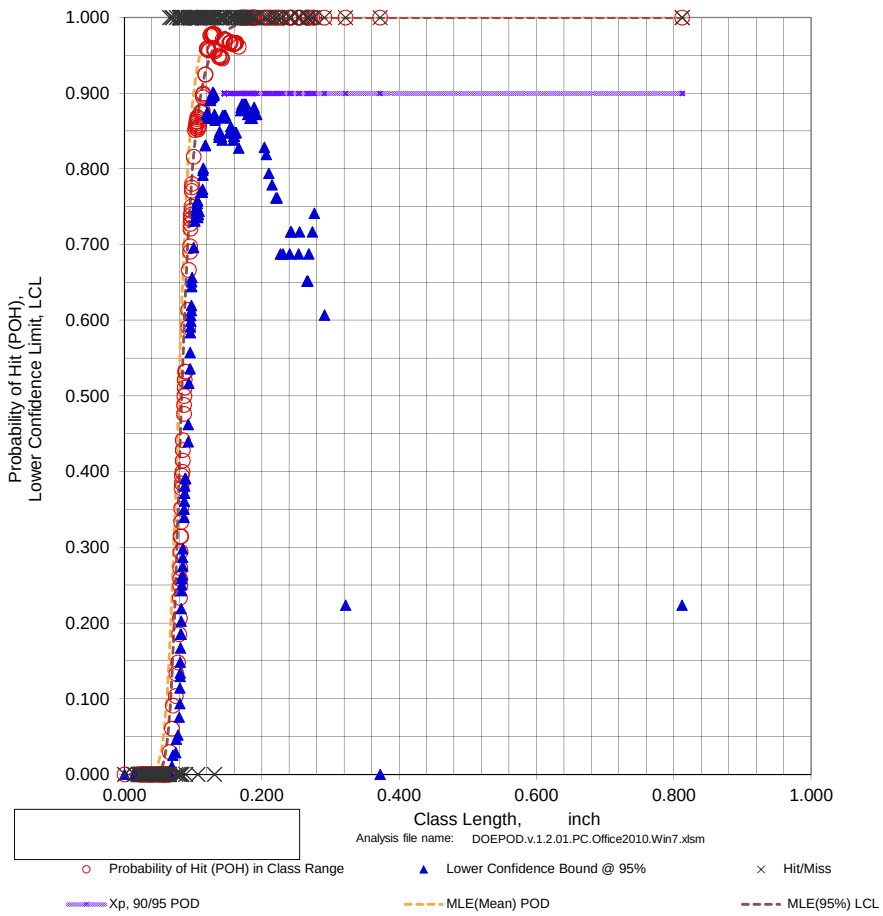
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6003E.XLS**

Data Set Name = **A6003E(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:35 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0360 | inch |
| Classlength @ 90/95 Xpod = | 0.1283 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.929 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.917 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.322 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1453 | inch |

File Name = A6003E.XLS
Data Set Name = A6003E(SITE CODE)

## Directed DOE Options

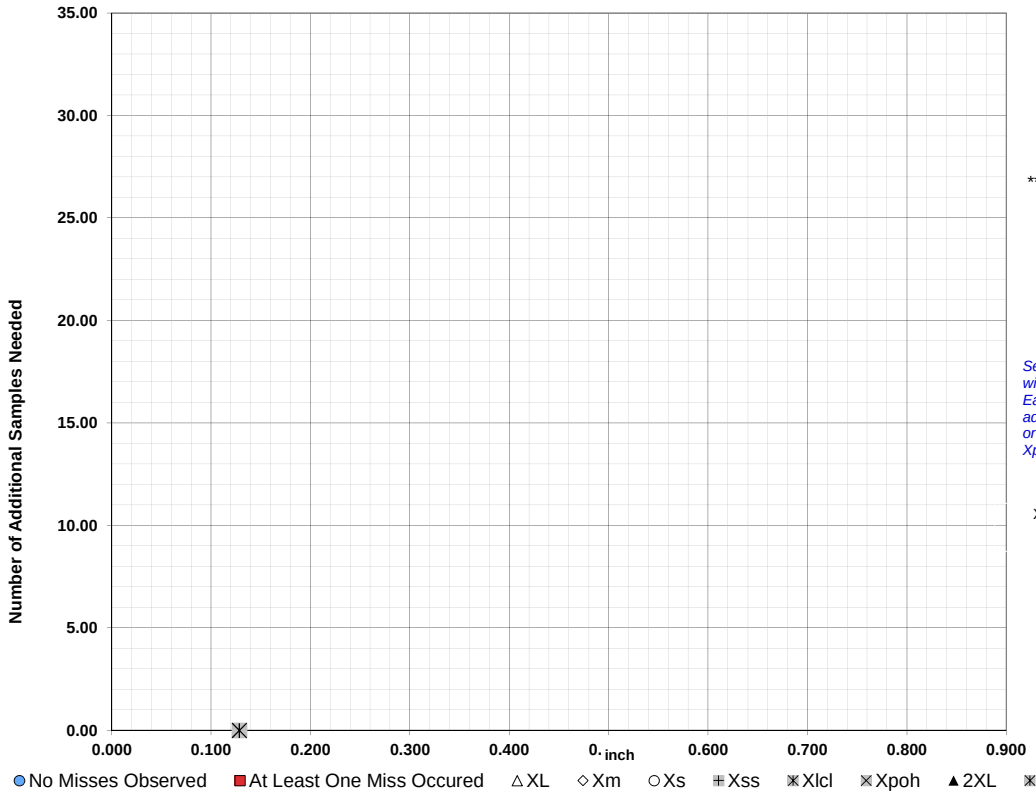



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.322 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

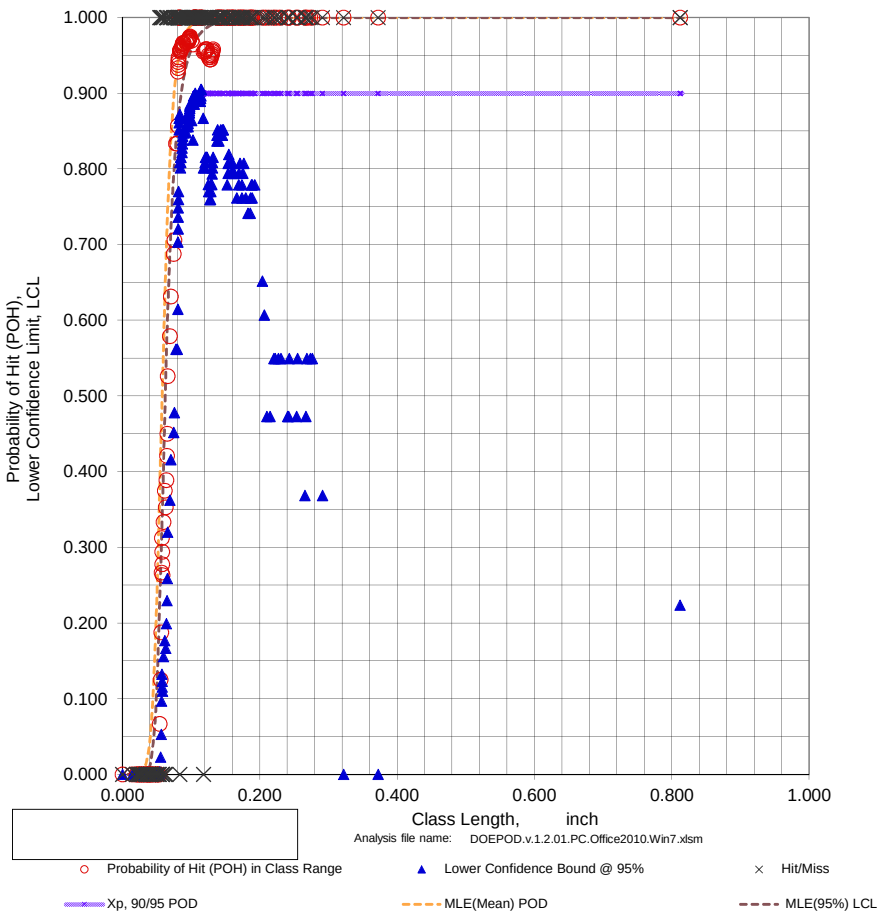
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6003F.XLS**

Data Set Name = **A6003F(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:37 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.1054 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.938 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.925 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1054 | inch |

File Name = A6003F.XLS
Data Set Name = A6003F(SITE CODE)

## Directed DOE Options

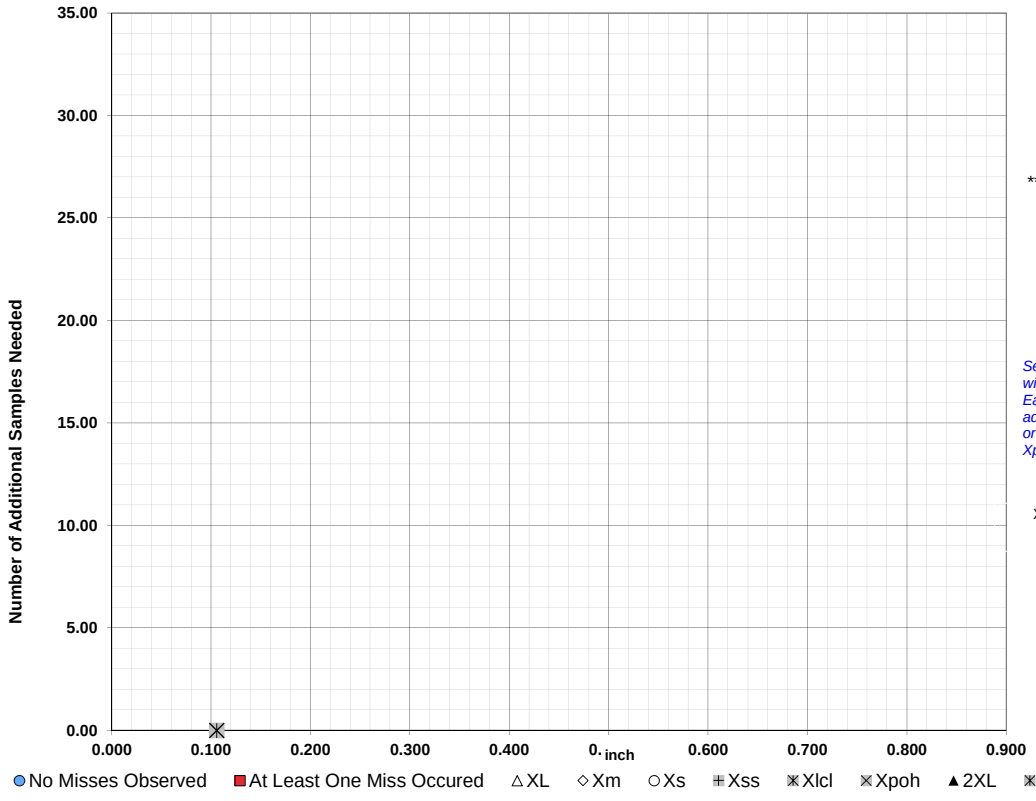



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

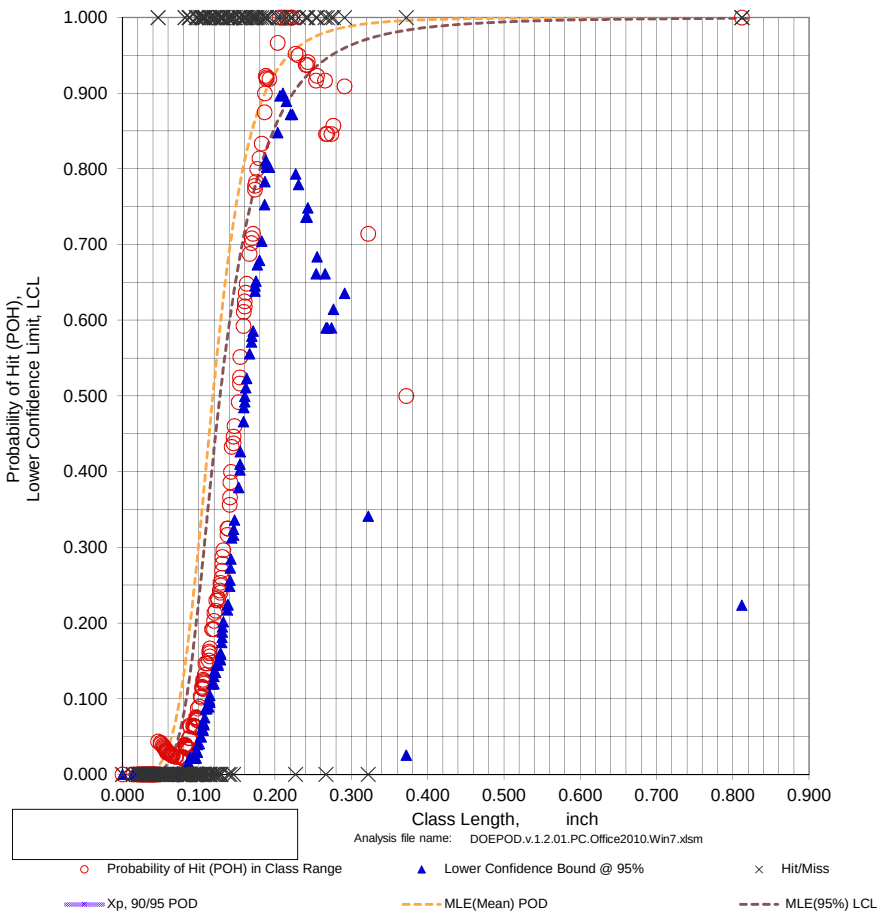
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Warning: No false call analysis.**




File Name = **A6003G.XLS**

Data Set Name = **A6003G(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:38 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0580 | inch |
| Classlength @ 90/95 Xpod = | 0.2100 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.908 | @ | 0.190 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.225 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 0.511 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6003G.XLS
Data Set Name = A6003G(SITE CODE)

## Directed DOE Options

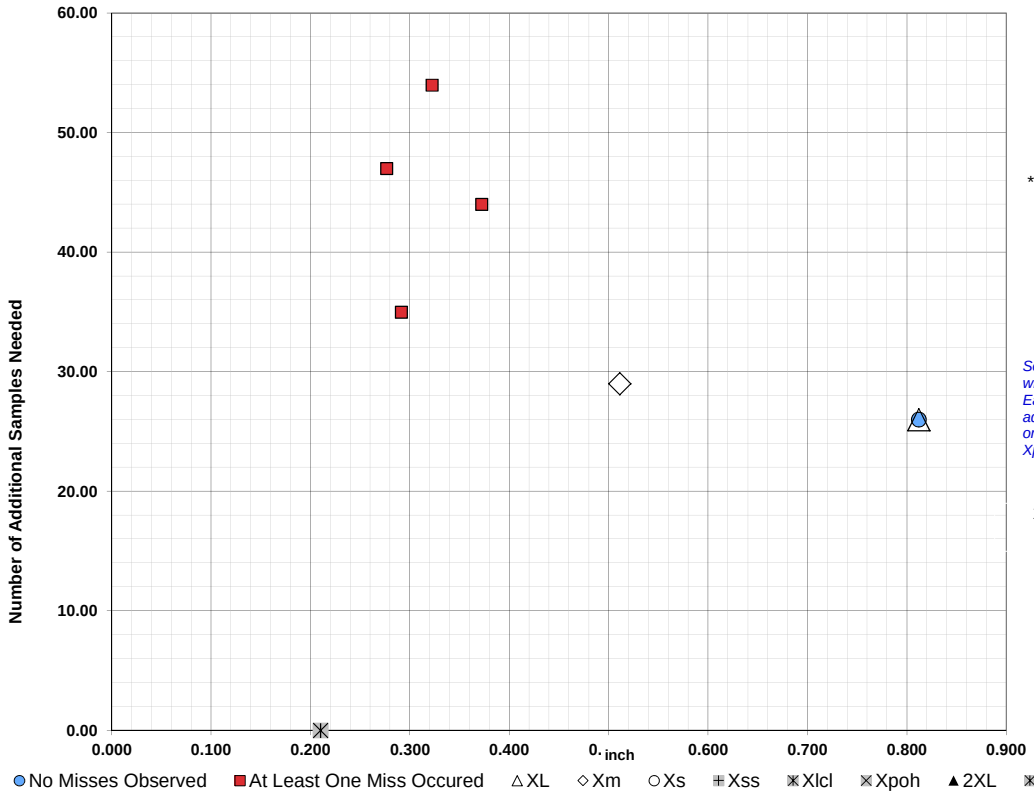



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 26 |
| Xm = | 0.511 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3719 | 44 |
| 0.3219 | 54 |
| 0.2910 | 35 |
| 0.2762 | 47 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

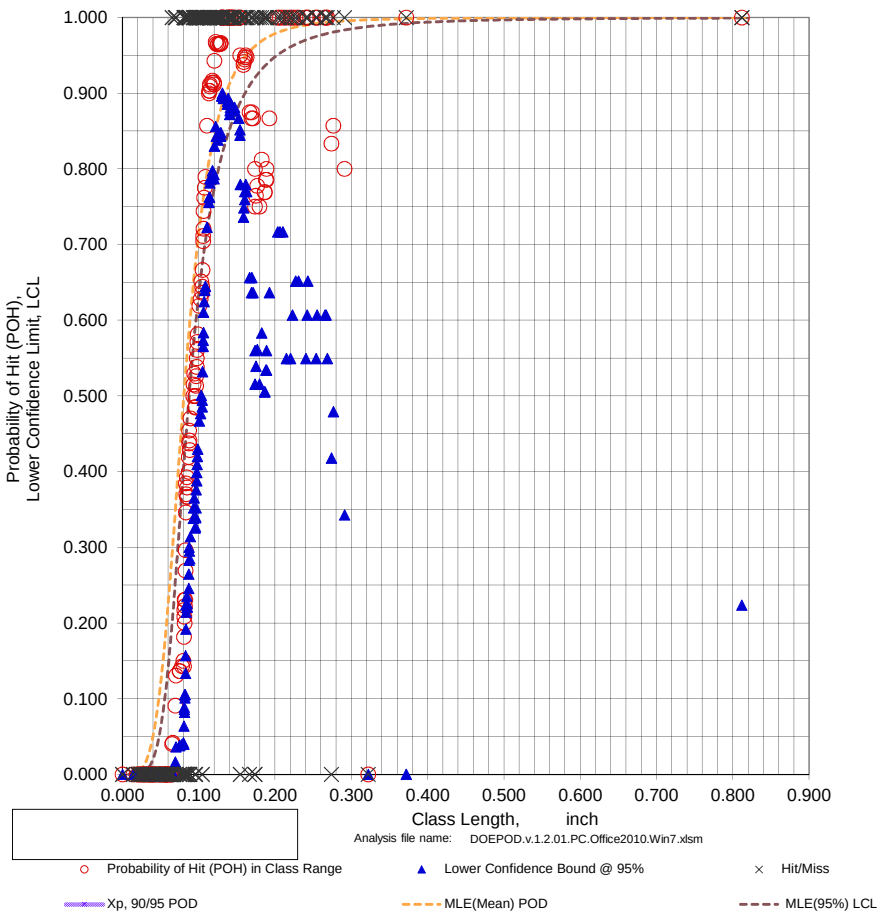
| Xpod,Class Length | No. Need |
|---|---|
| 0.8117 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Warning: No false call analysis.**




File Name = **A6003H.XLS**

Data Set Name = **A6003H(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:39 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0250 | inch |
| Classlength @ 90/95 Xpod = | 0.1308 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.140 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.165 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6003H.XLS
Data Set Name = A6003H(SITE CODE)

## Directed DOE Options

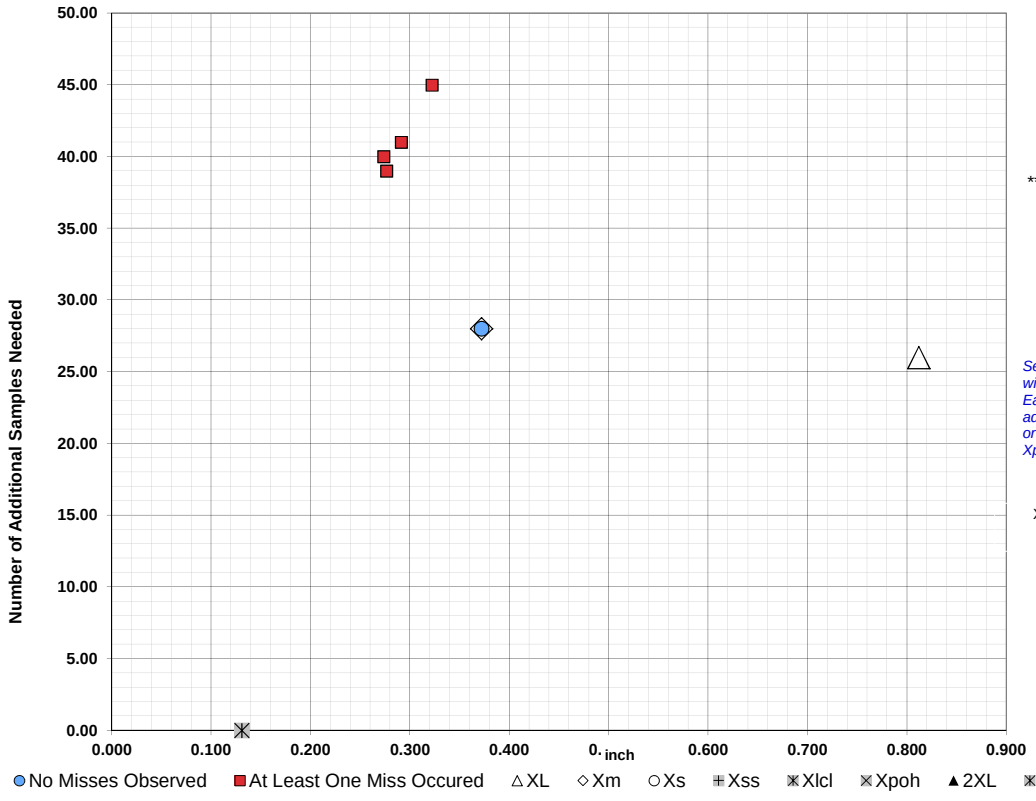



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 26 |
| Xm = | 0.372 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3219 | 45 |
| 0.2910 | 41 |
| 0.2762 | 39 |
| 0.2735 | 40 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3719 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

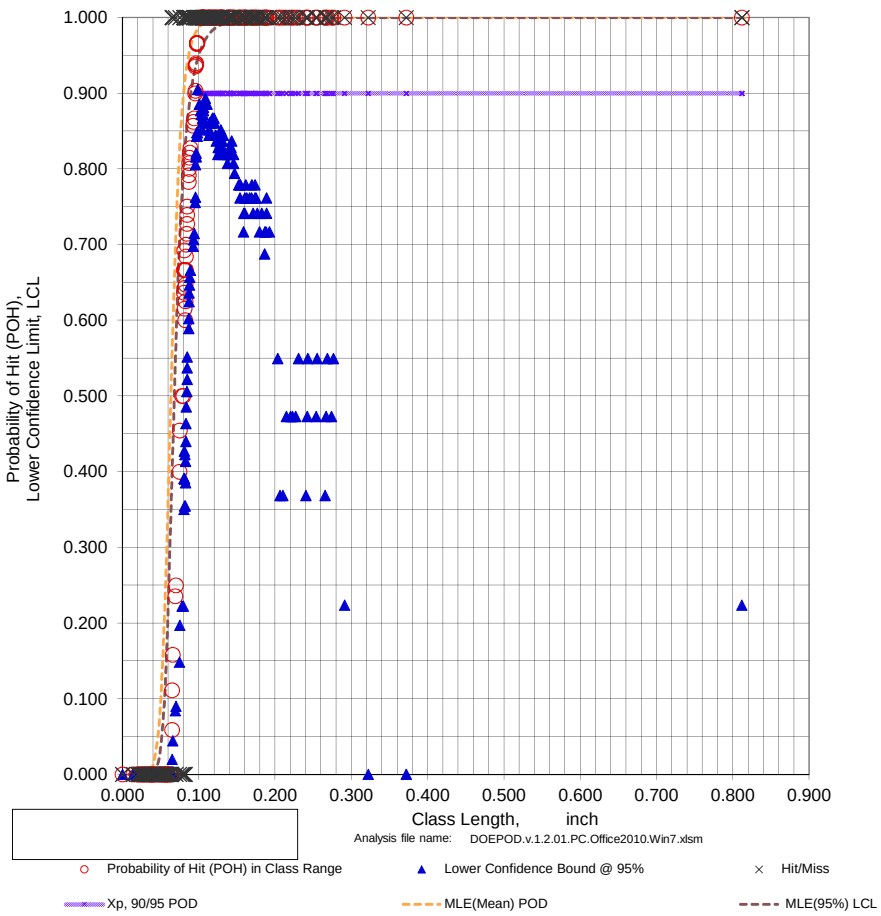
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6003J.XLS**

Data Set Name = **A6003J(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:40 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0160 | inch |
| Classlength @ 90/95 Xpod = | 0.0982 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0833 -0.001 inch 24 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.098 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0982 | inch |

File Name = A6003J.XLS
Data Set Name = A6003J(SITE CODE)

## Directed DOE Options

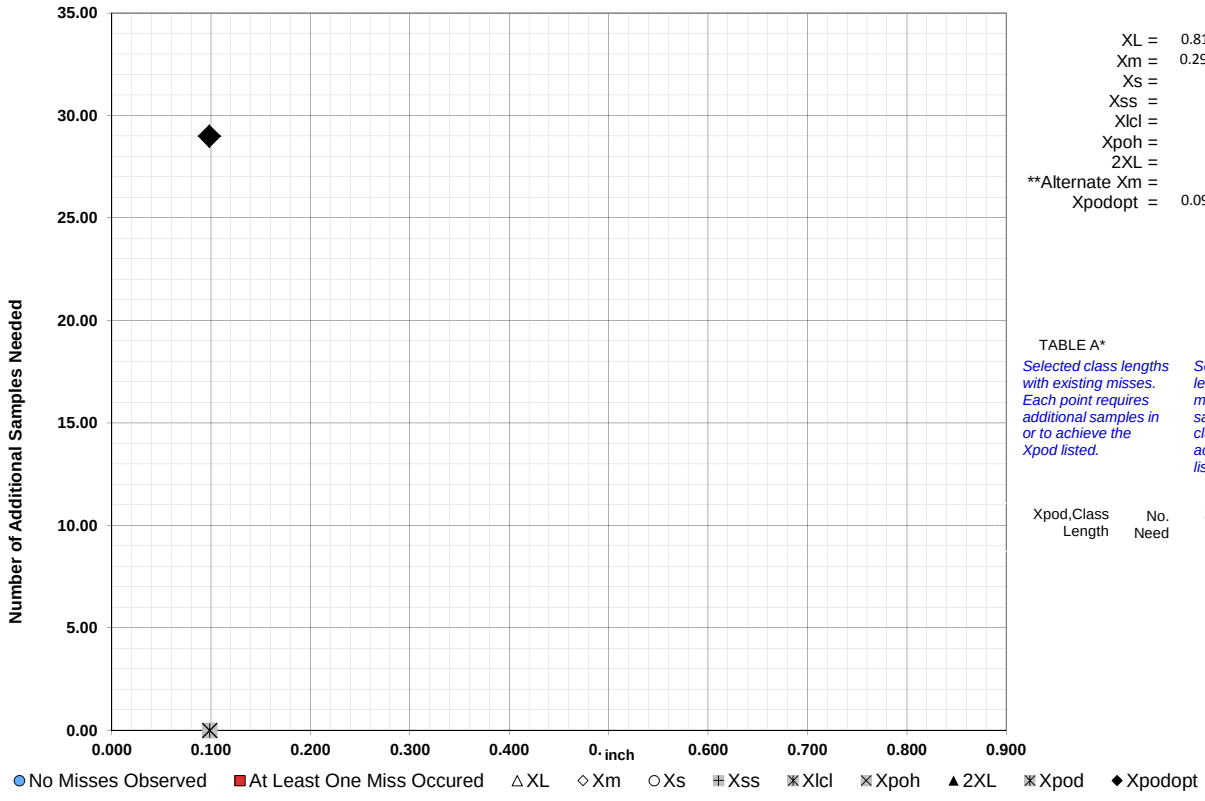



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.098 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

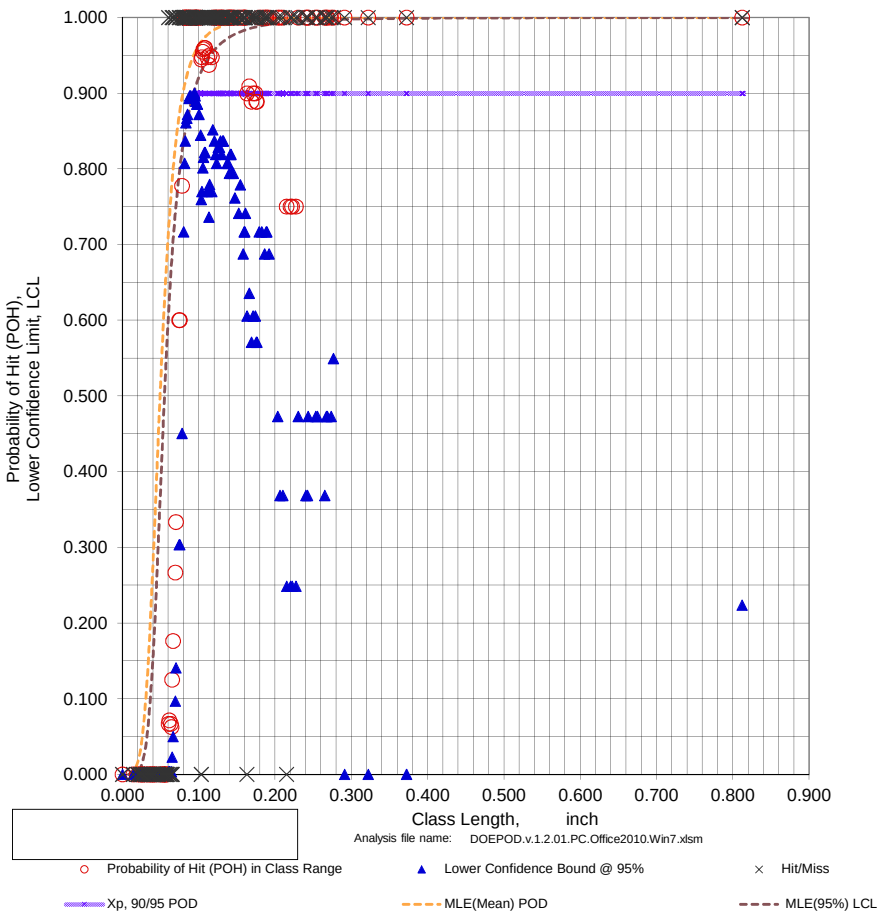
**Any highlighted Misses are RED and shown in Column A of this data sheet**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6004A.XLS**

Data Set Name = **A6004A(SITE CODE)**




| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:42 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0140 | inch |
| Classlength @ 90/95 Xpod = | 0.0940 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.095 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.276 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0940 | inch |

File Name = A6004A.XLS
Data Set Name = A6004A(SITE CODE)

## Directed DOE Options

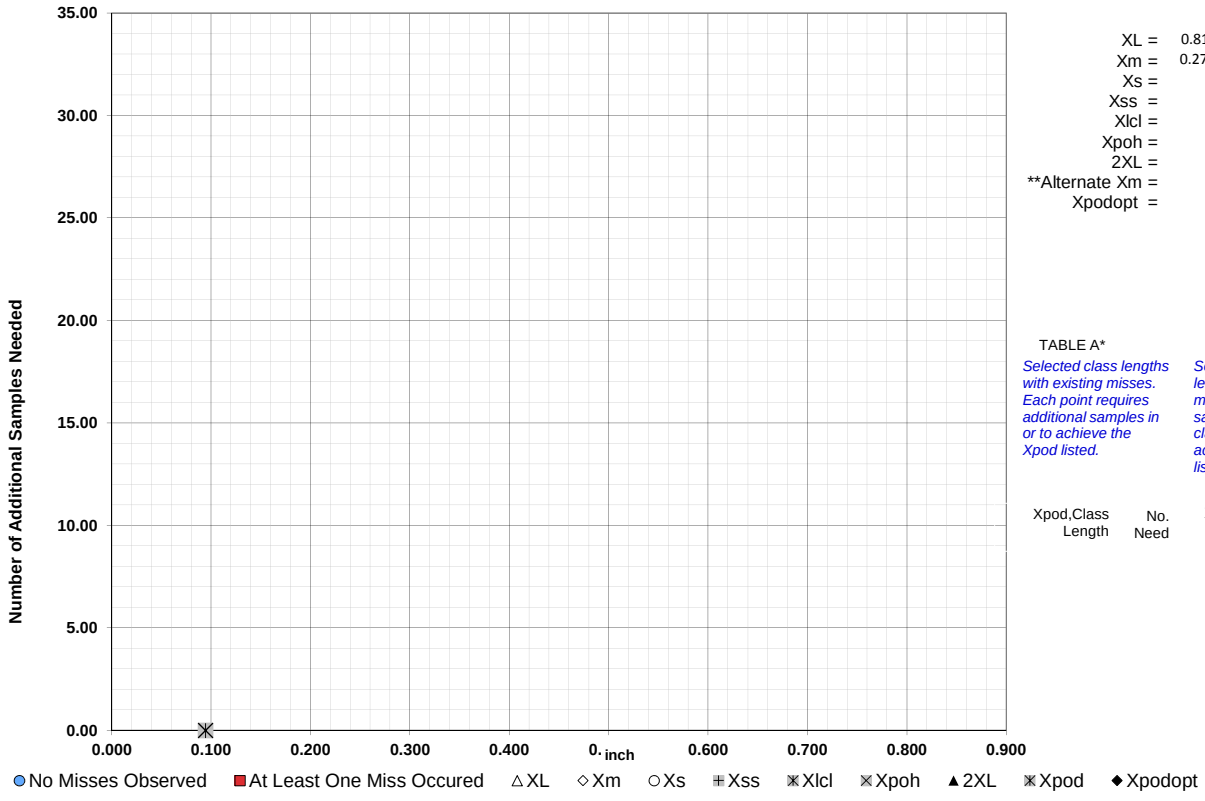



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.276 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

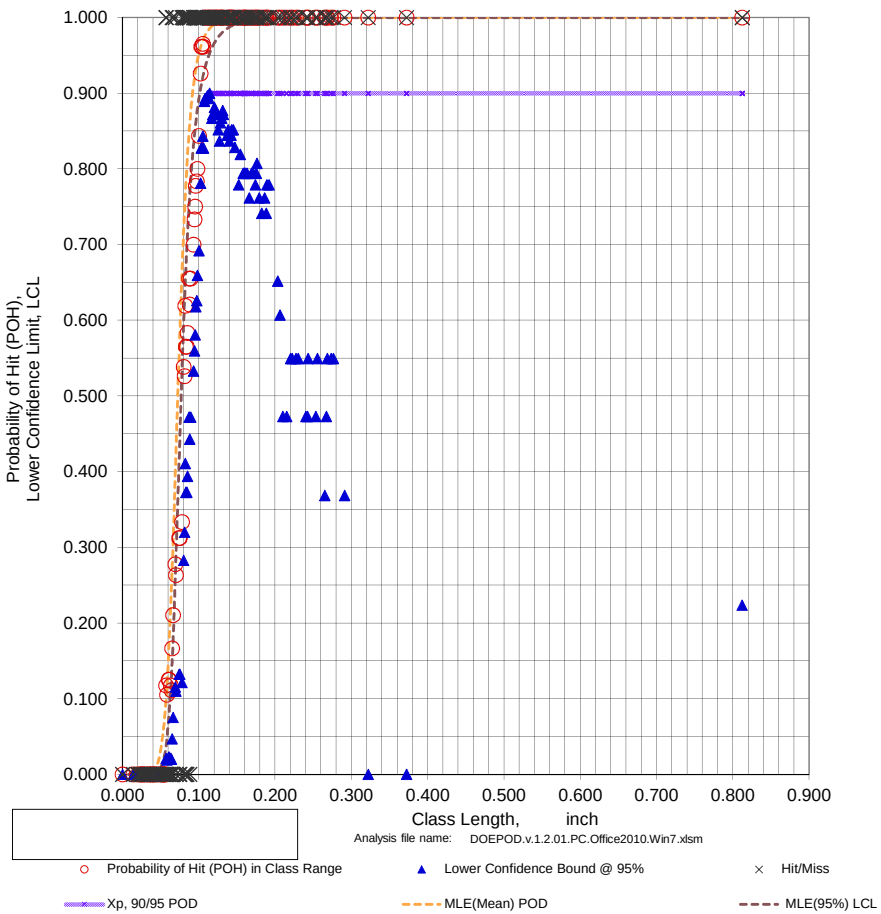
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6004B.XLS**

Data Set Name = **A6004B(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:43 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1140 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0930 -0.004 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.926 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.920 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.107 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.1140 | inch |

File Name = A6004B.XLS
Data Set Name = A6004B(SITE CODE)

## Directed DOE Options

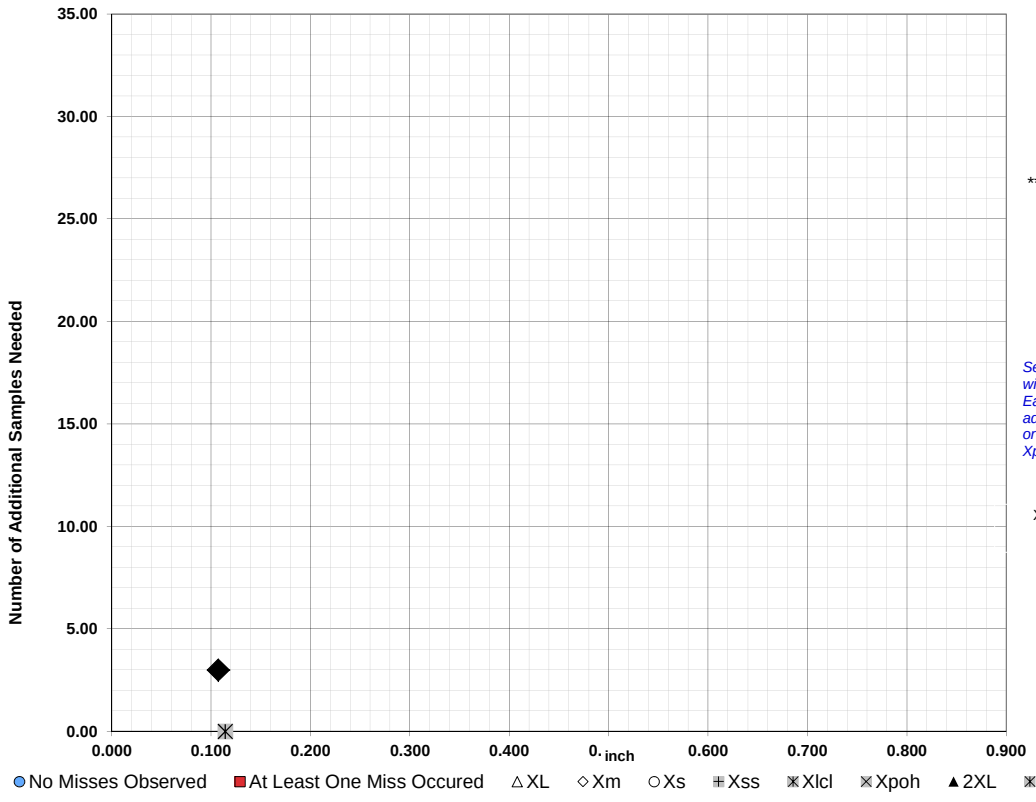



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.107 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

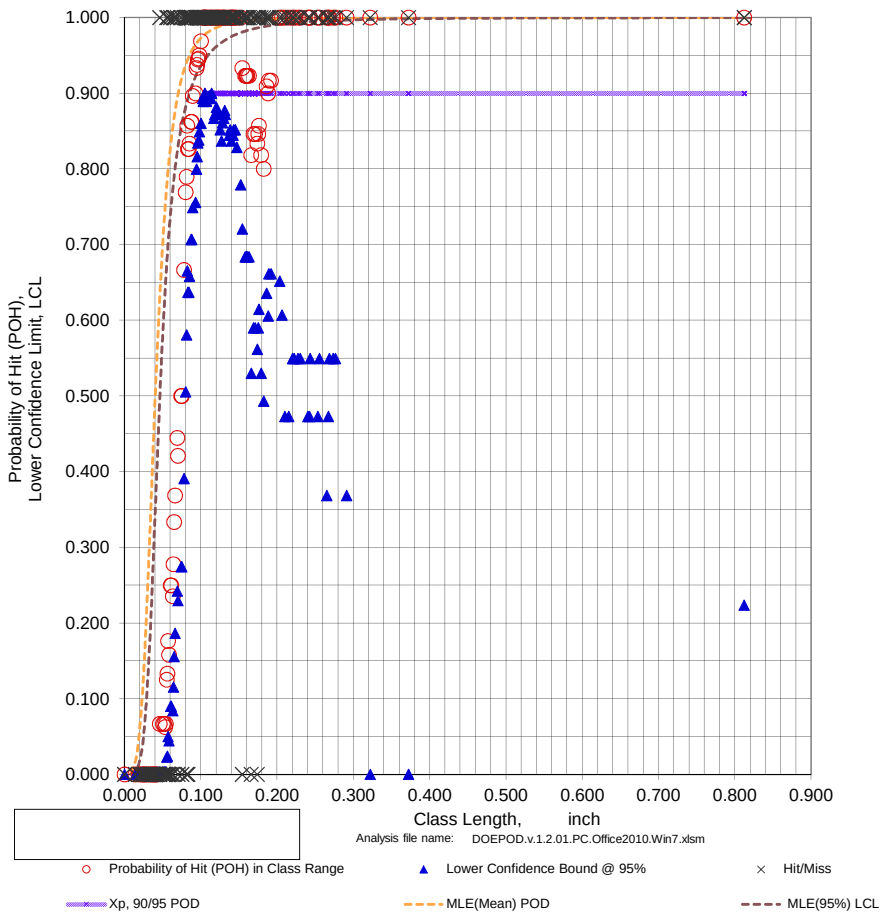
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6004BR.XLS**

Data Set Name = **A6004BR(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:44 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1050 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.070 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.085 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1050 | inch |

File Name = A6004BR.XLS
Data Set Name = A6004BR(SITE CODE)

## Directed DOE Options

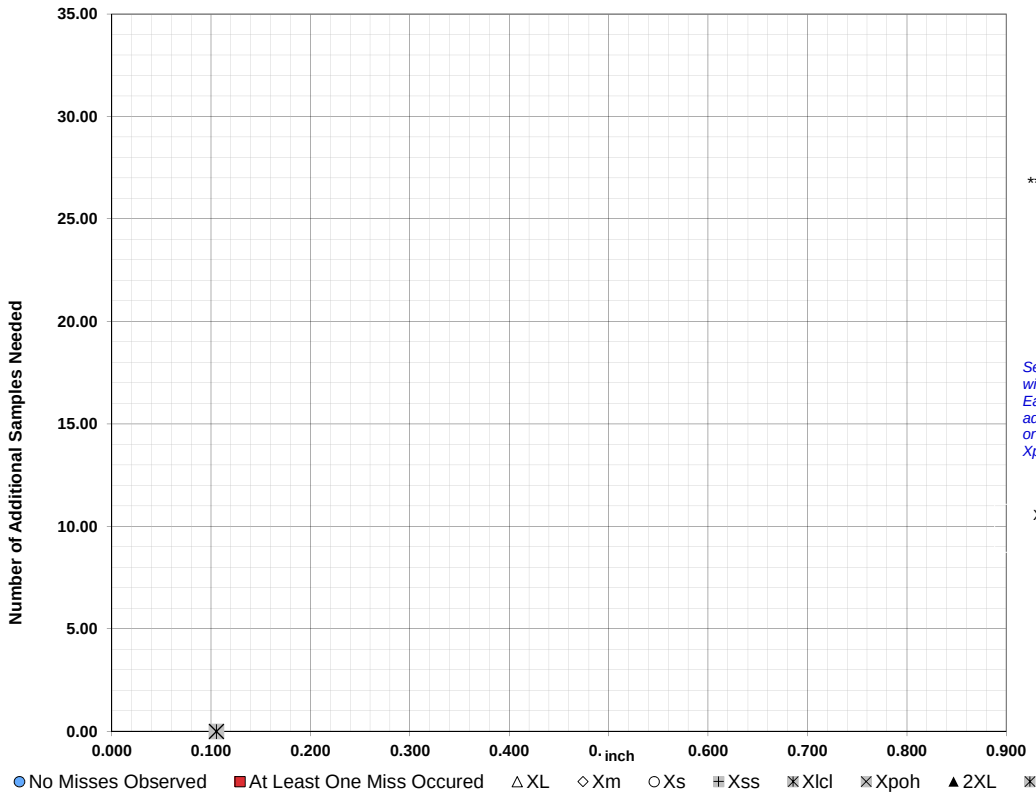



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

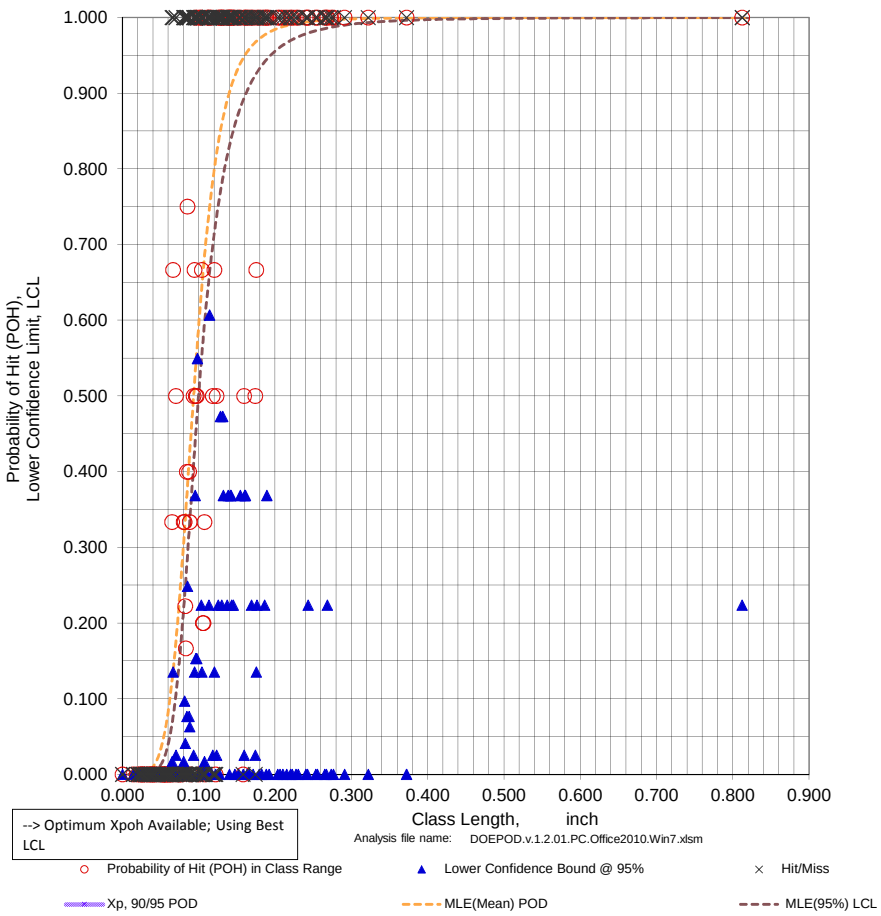
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A6004C.XLS
Data Set Name = A6004C(SITE CODE)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:46 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.1140 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.1760 -0.001 inch 27 Samples

NTIAC 90% POD = 0.901 @ 0.140 inch
NTIAC 90/95 POD = 0.907 @ 0.165 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.176 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6004C.XLS
Data Set Name = A6004C(SITE CODE)

## Directed DOE Options

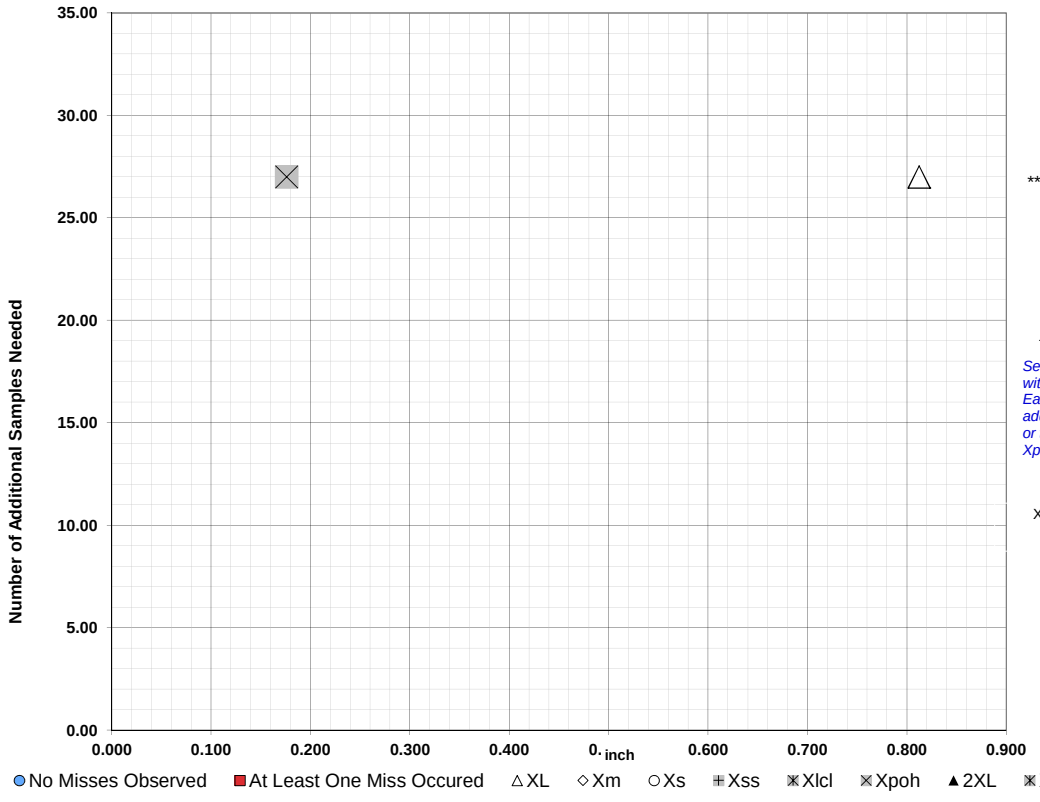



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.176 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

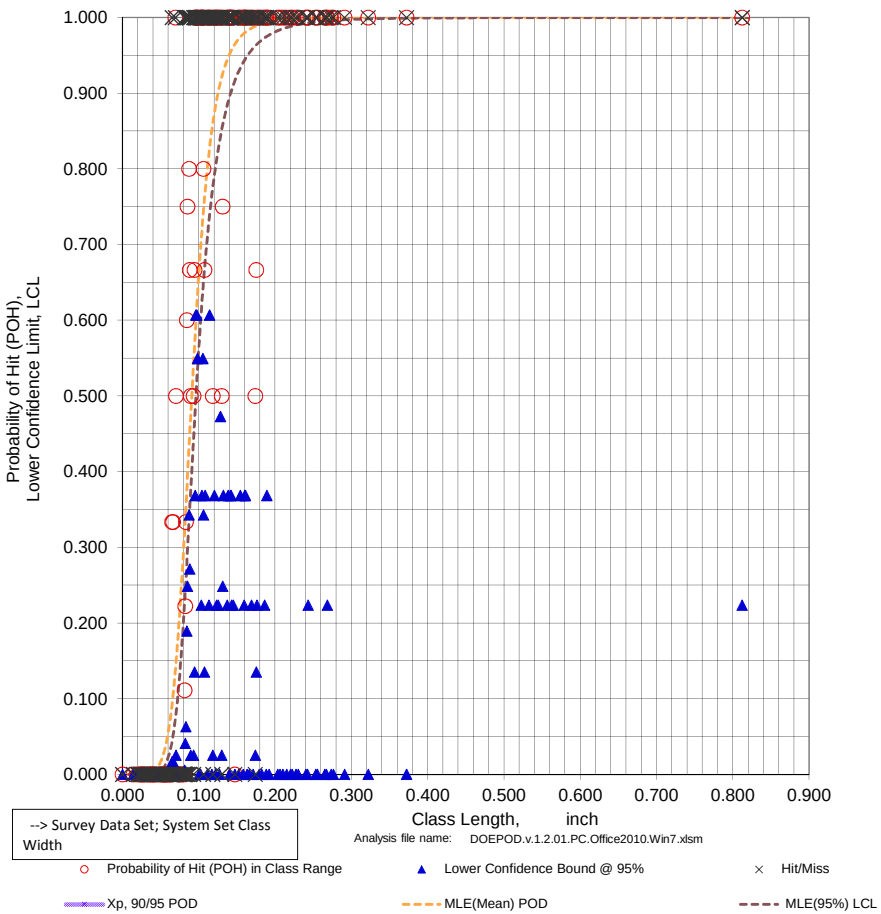
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = A6004CR.XLS

Data Set Name = A6004CR(SITE CODE)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:48 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0960 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - This is a survey data set. 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Survey Xpoh (if listed)

Survey/Optimum Xpoh = 0.1760 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.917 | @ | 0.130 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.145 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.176 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A6004CR.XLS
Data Set Name = A6004CR(SITE CODE)

## Directed DOE Options

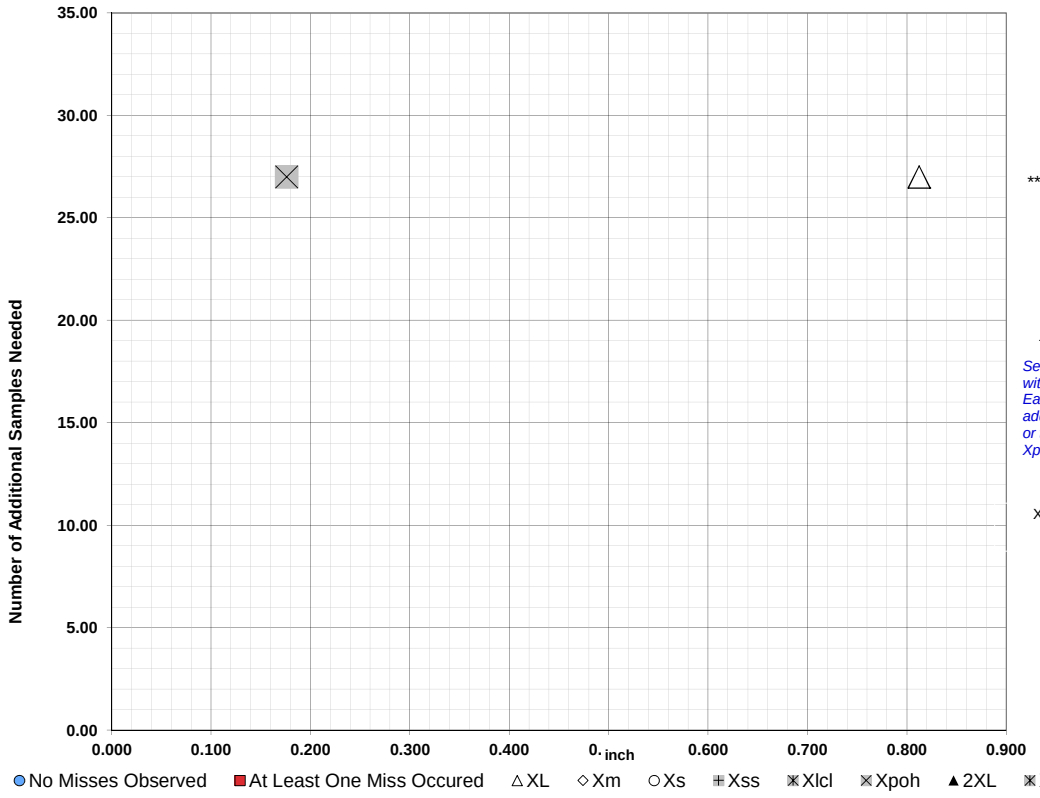



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.176 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

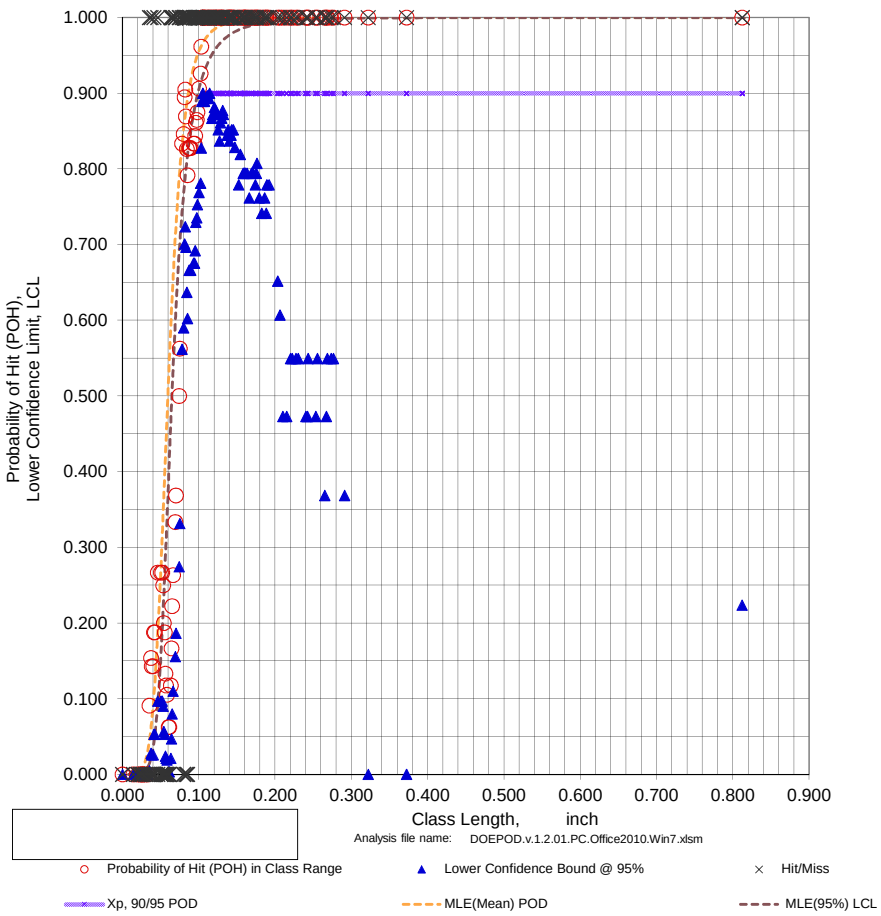
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6004D.XLS**

Data Set Name = **A6004D(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:49 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1050 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0870 -0.001 inch 24 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.920 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.100 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.104 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.1050 | inch |

File Name = A6004D.XLS
Data Set Name = A6004D(SITE CODE)

## Directed DOE Options

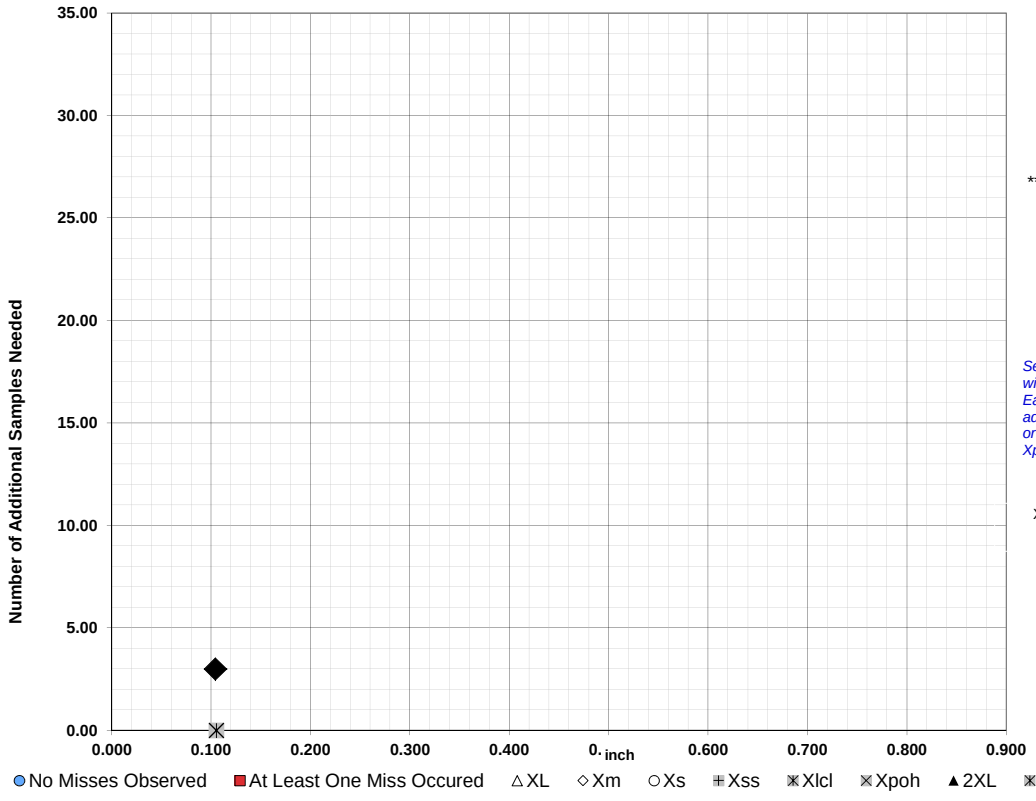



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.104 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

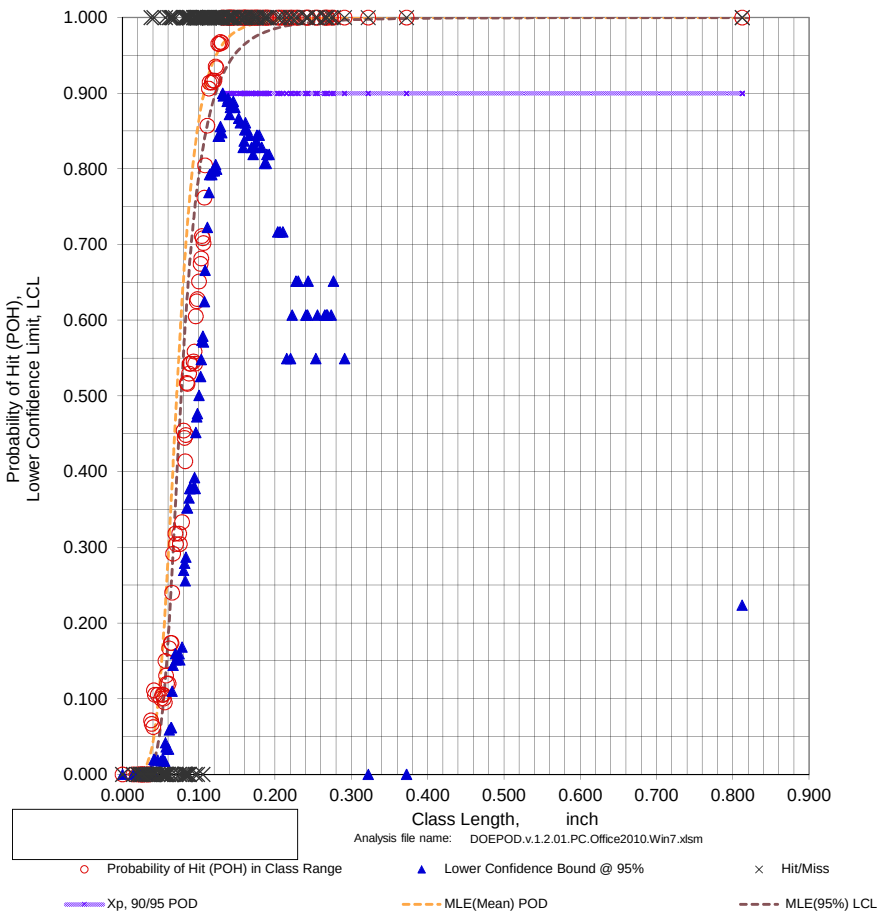
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6004E.XLS**

Data Set Name = **A6004E(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:50 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0250 | inch |
| Classlength @ 90/95 Xpod = | 0.1310 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1070 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.914 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.909 | @ | 0.125 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.131 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1310 | inch |

File Name = A6004E.XLS
Data Set Name = A6004E(SITE CODE)

## Directed DOE Options

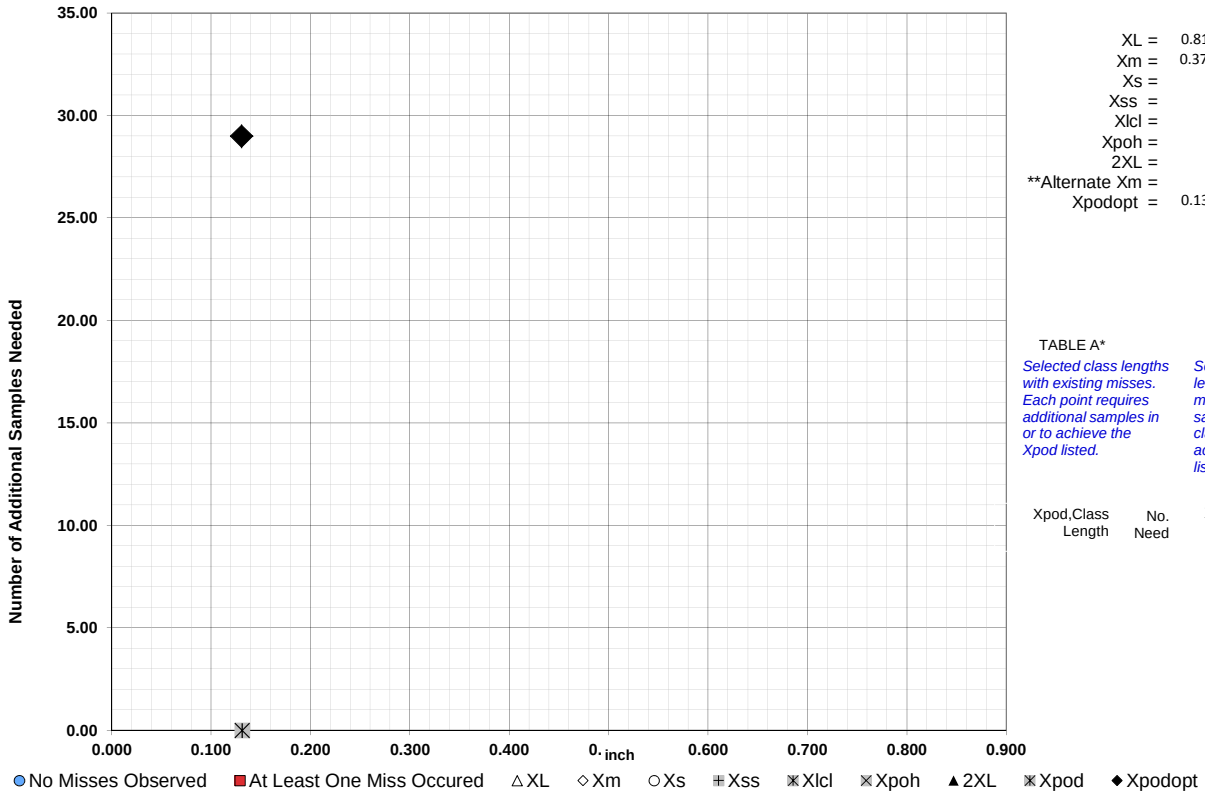



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.131 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

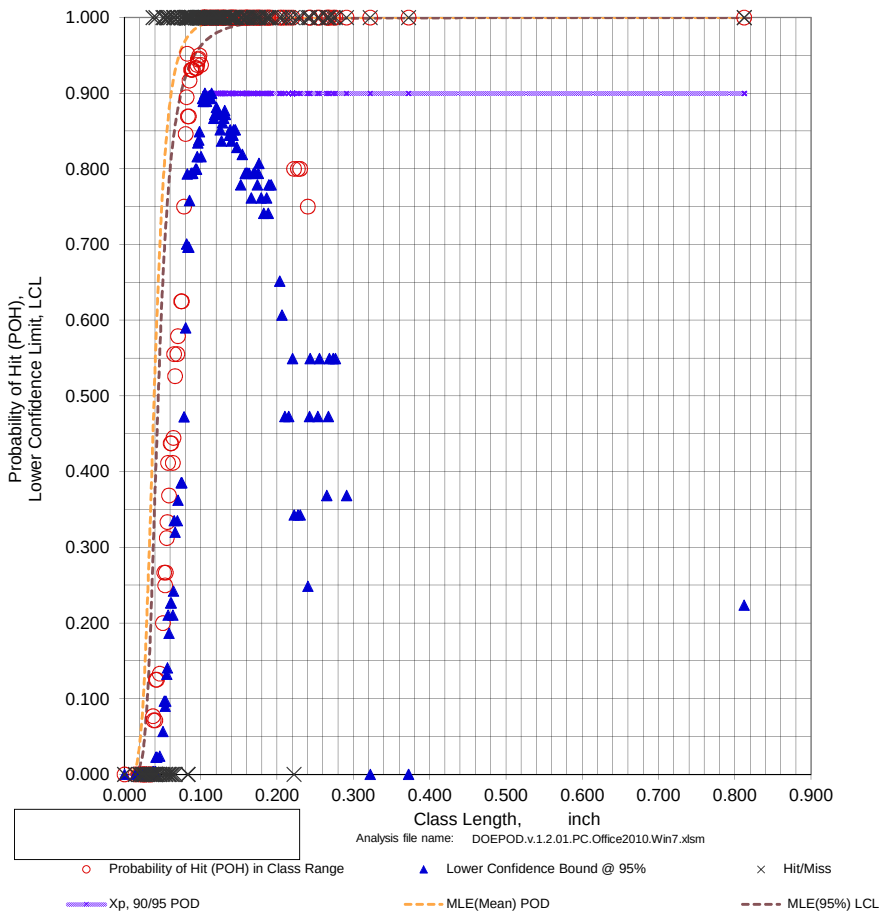
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6004F.XLS**

Data Set Name = **A6004F(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:52 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1050 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.926 | @ | 0.065 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.075 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1050 | inch |

File Name = A6004F.XLS
Data Set Name = A6004F(SITE CODE)

## Directed DOE Options

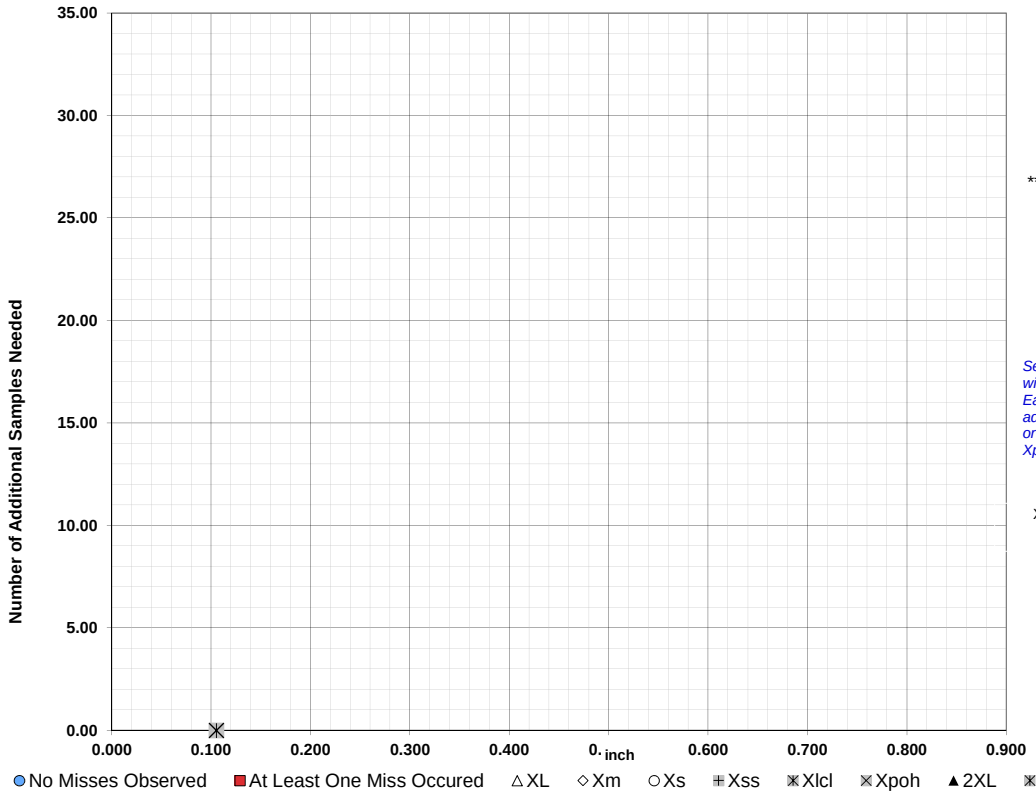



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.291 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

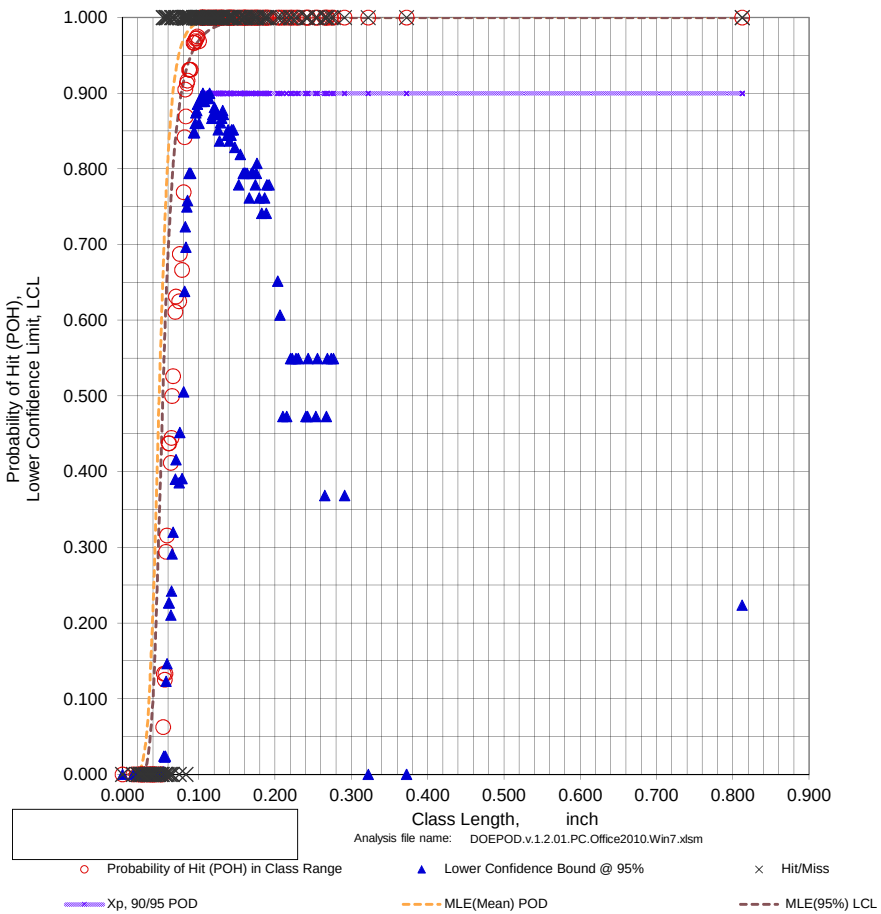
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A6004FR.XLS**

Data Set Name = **A6004FR(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:53 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.1050 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0850 -0.001 inch 25 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.931 | @ | 0.070 | inch |
| NTIAC 90/95 POD = | 0.916 | @ | 0.080 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.291 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.102 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.1050 | inch |

File Name = A6004FR.XLS
Data Set Name = A6004FR(SITE CODE)

## Directed DOE Options

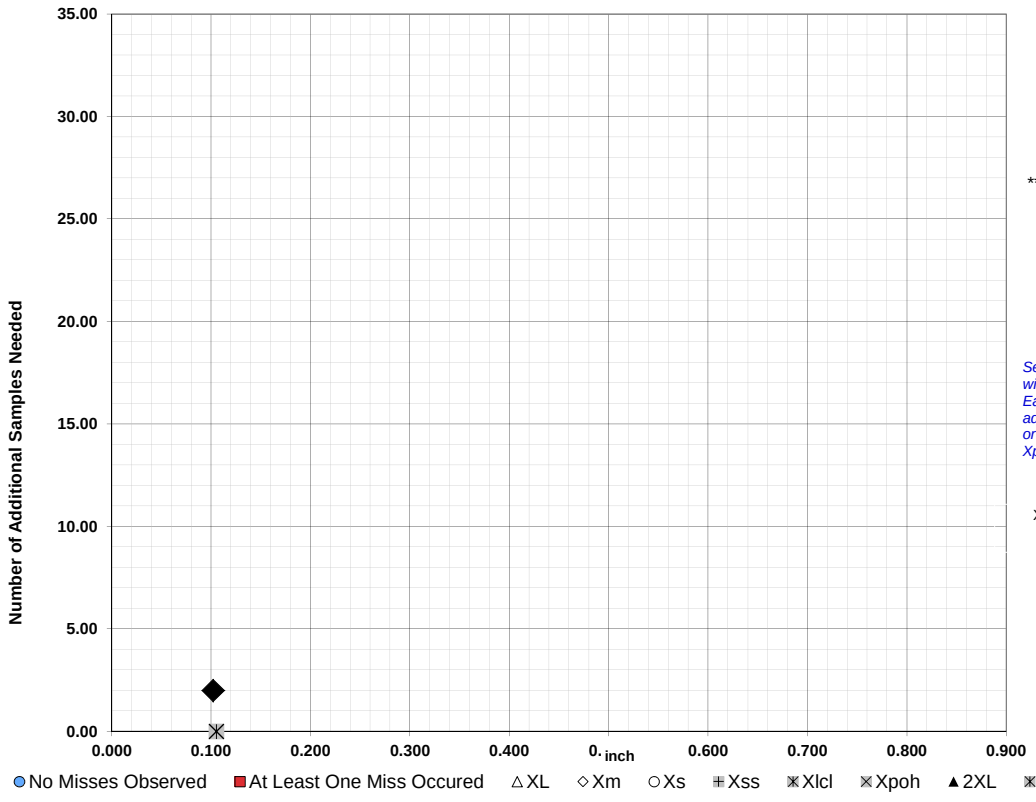



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.291 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.102 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

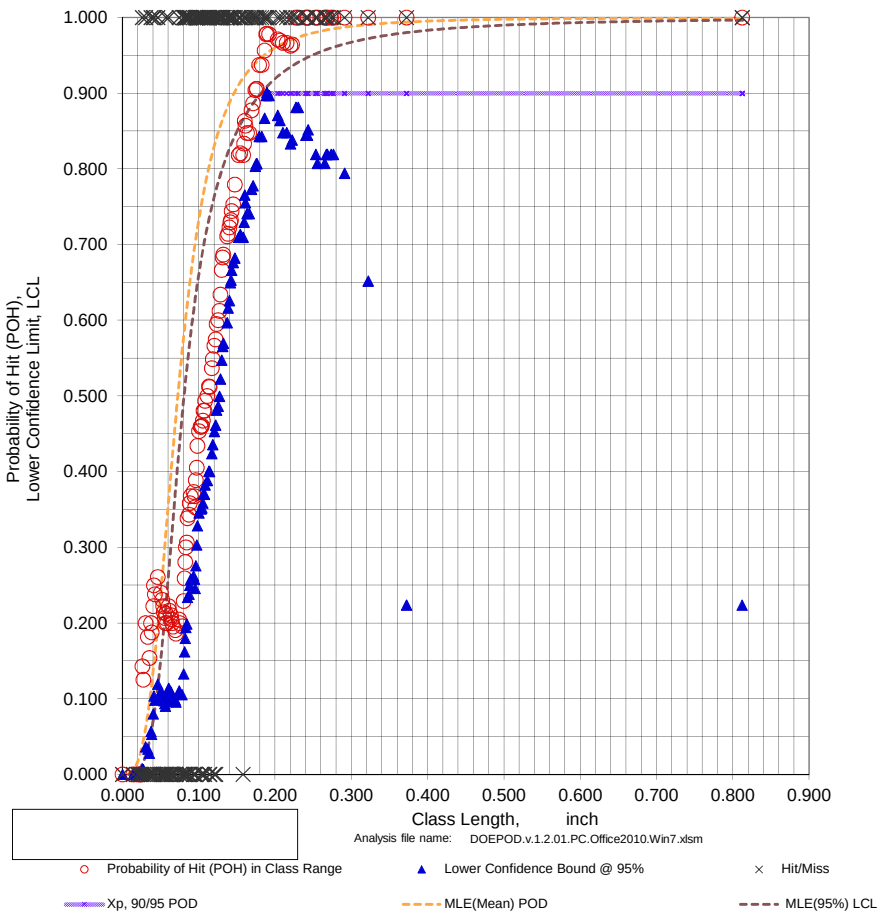
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 18 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6004G.XLS**

Data Set Name = **A6004G(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:54 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0640 | inch |
| Classlength @ 90/95 Xpod = | 0.1890 | inch |
| Lower Confidence Bound = | 0.9011 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9787 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.1600 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.150 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.185 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1890 | inch |

File Name = A6004G.XLS
Data Set Name = A6004G(SITE CODE)

## Directed DOE Options

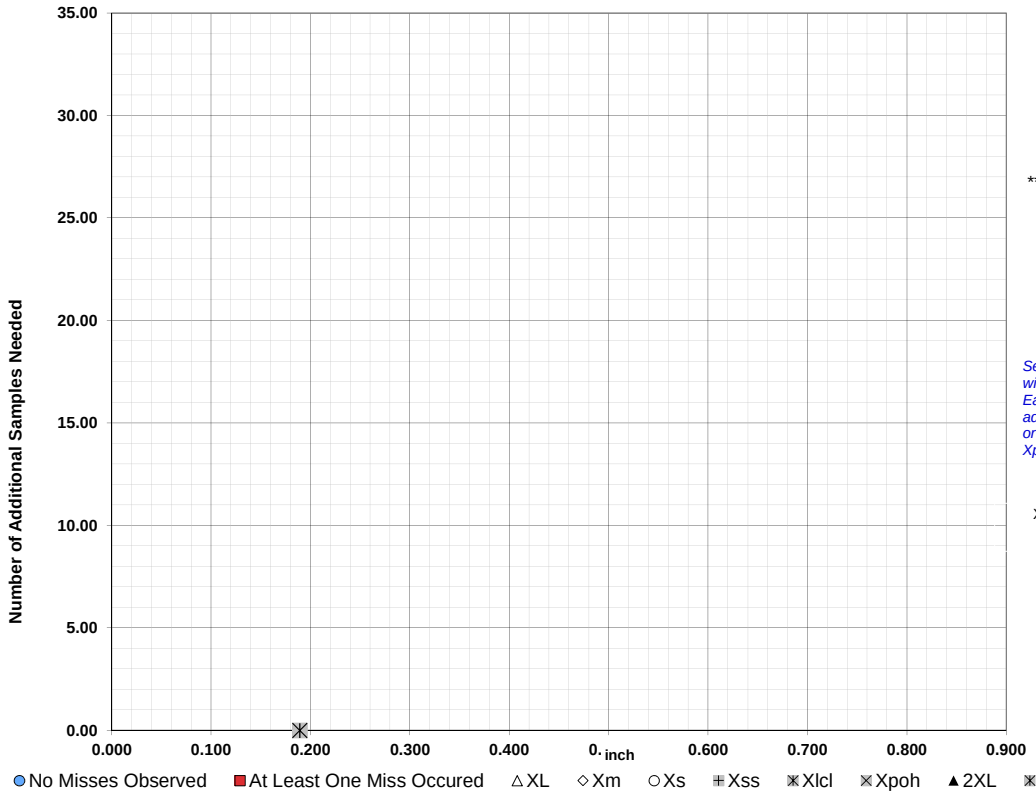



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

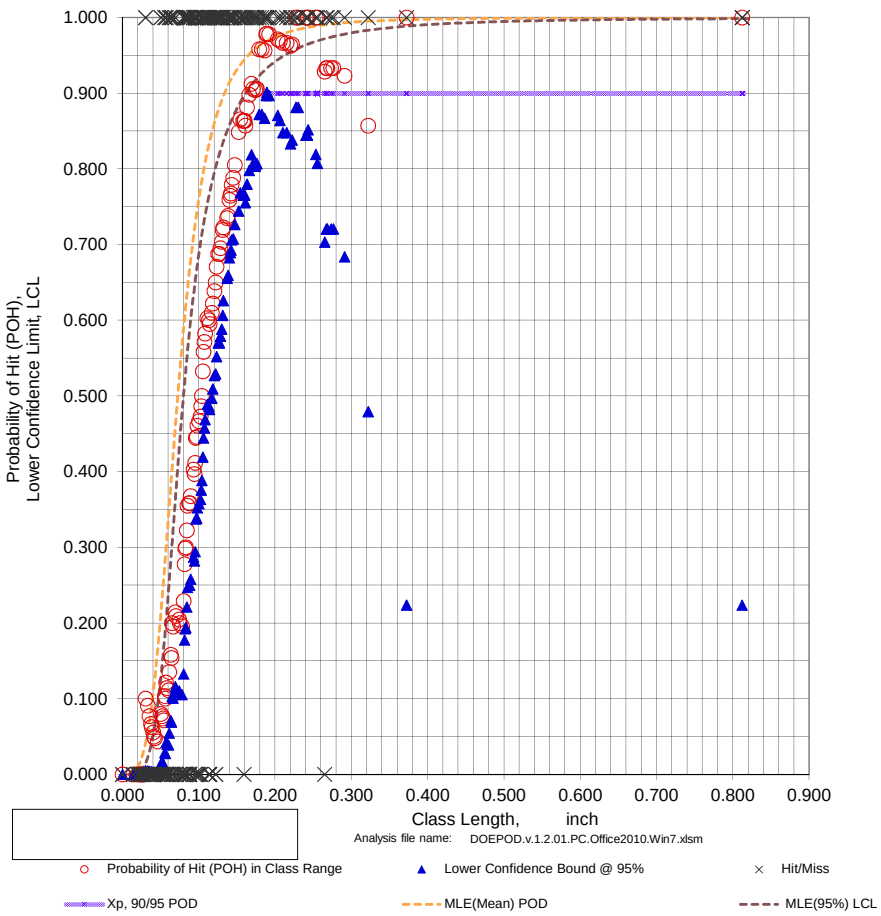
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 18 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A6004H.XLS**

Data Set Name = **A6004H(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:56 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0640 | inch |
| Classlength @ 90/95 Xpod = | 0.1890 | inch |
| Lower Confidence Bound = | 0.9011 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9787 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.135 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.165 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1890 | inch |

File Name = A6004H.XLS
Data Set Name = A6004H(SITE CODE)

## Directed DOE Options

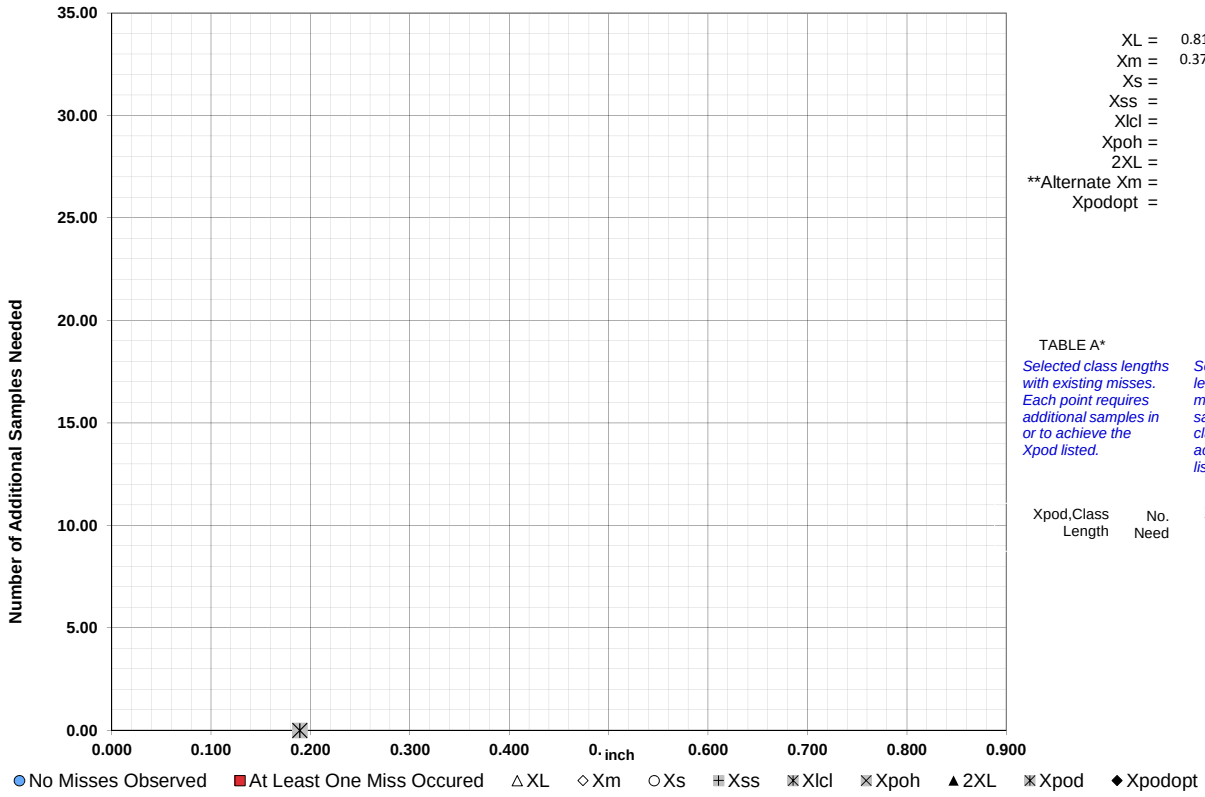



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.812 |
| Xm = | 0.372 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

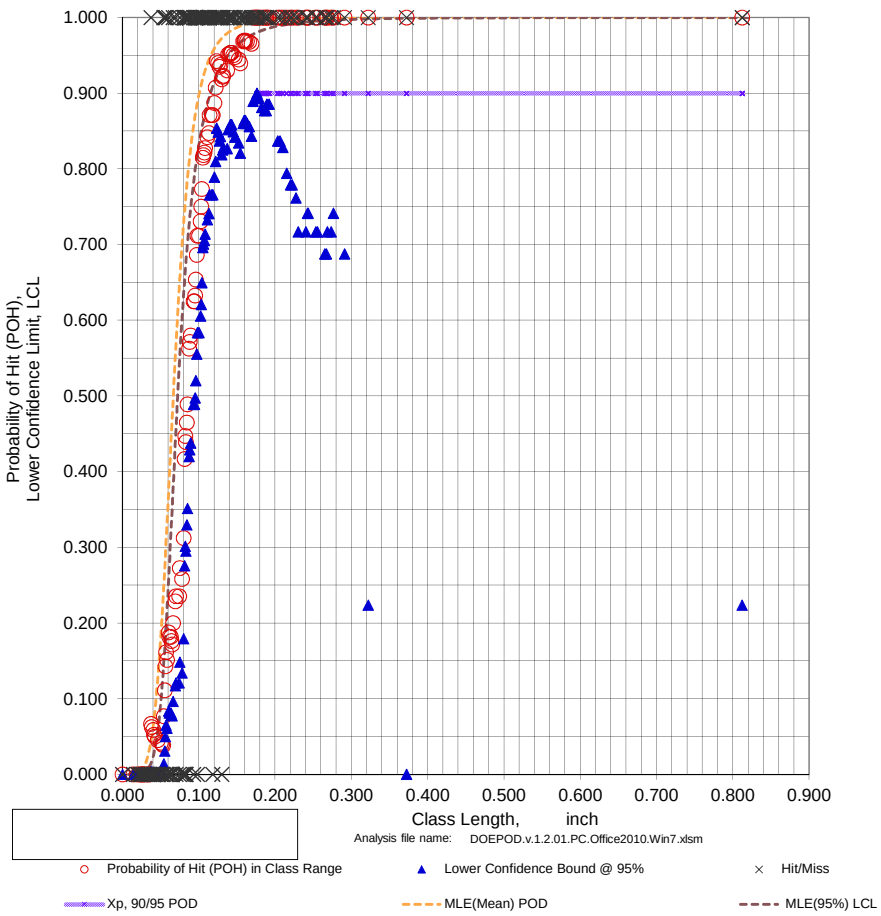
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 17 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A6004J.XLS**

Data Set Name = **A6004J(SITE CODE)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:57 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0390 | inch |
| Classlength @ 90/95 Xpod = | 0.1760 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1320 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.919 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.915 | @ | 0.120 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.812 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.372 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.171 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.1760 | inch |

File Name = A6004J.XLS
Data Set Name = A6004J(SITE CODE)

## Directed DOE Options

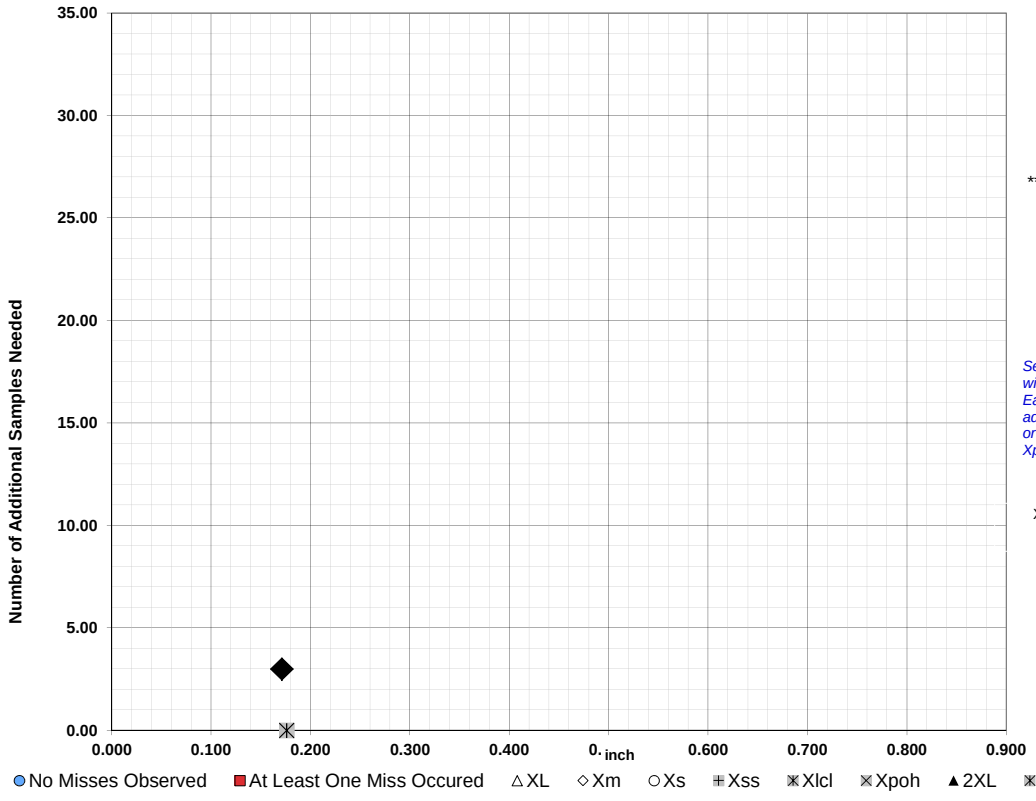



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.812 | |
| Xm = | 0.372 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.171 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

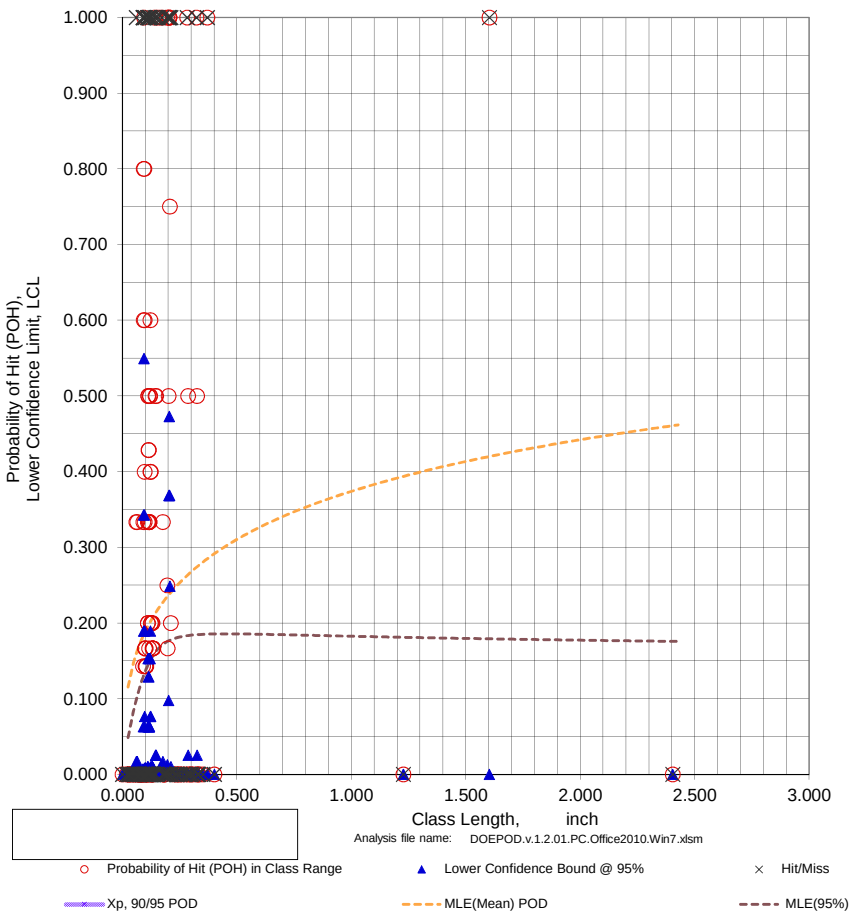
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A7001AL.XLS
Data Set Name = A7001AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 6:58 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.0933 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A7001AL.XLS
Data Set Name = A7001AL(CRK #)

## Directed DOE Options

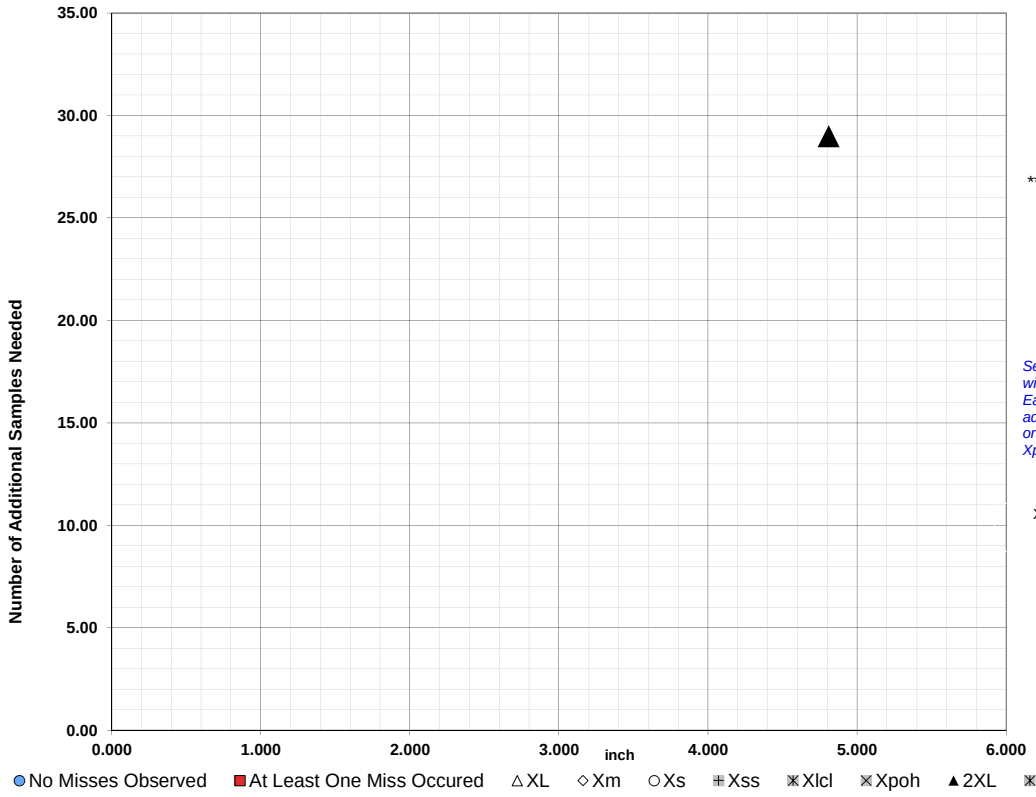



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

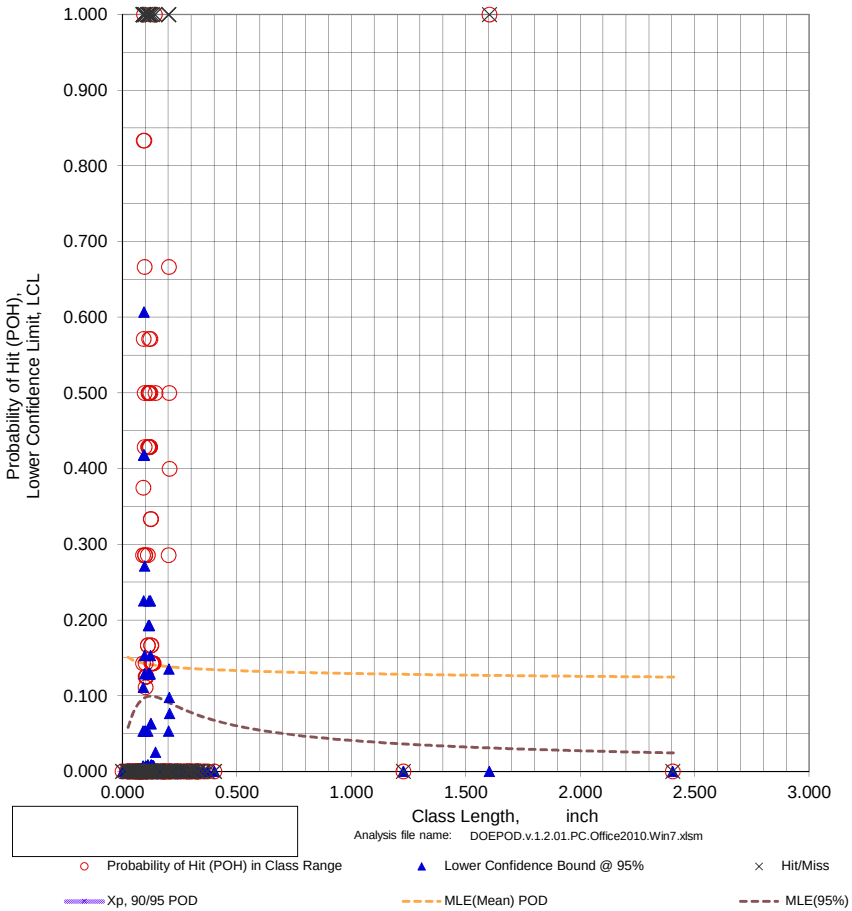
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A7001BL.XLS
Data Set Name = A7001BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:00 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.0933 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A7001BL.XLS
Data Set Name = A7001BL(CRK #)

## Directed DOE Options

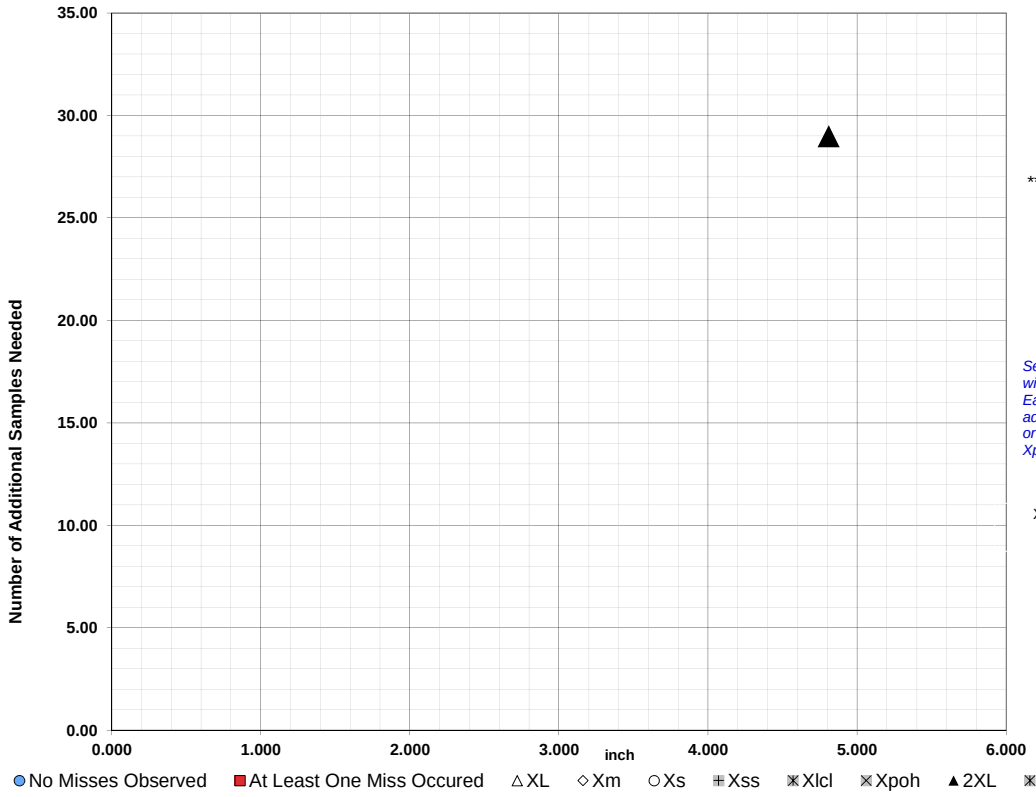



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

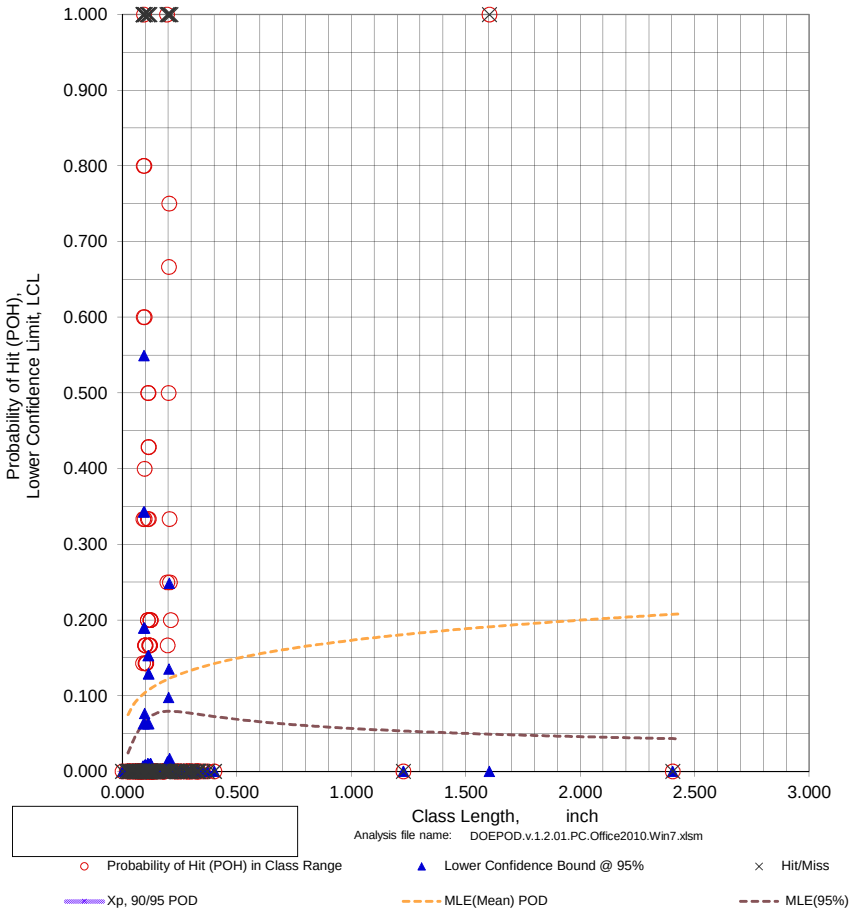
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A7001CL.XLS
Data Set Name = A7001CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:03 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.0933 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A7001CL.XLS
Data Set Name = A7001CL(CRK #)

## Directed DOE Options

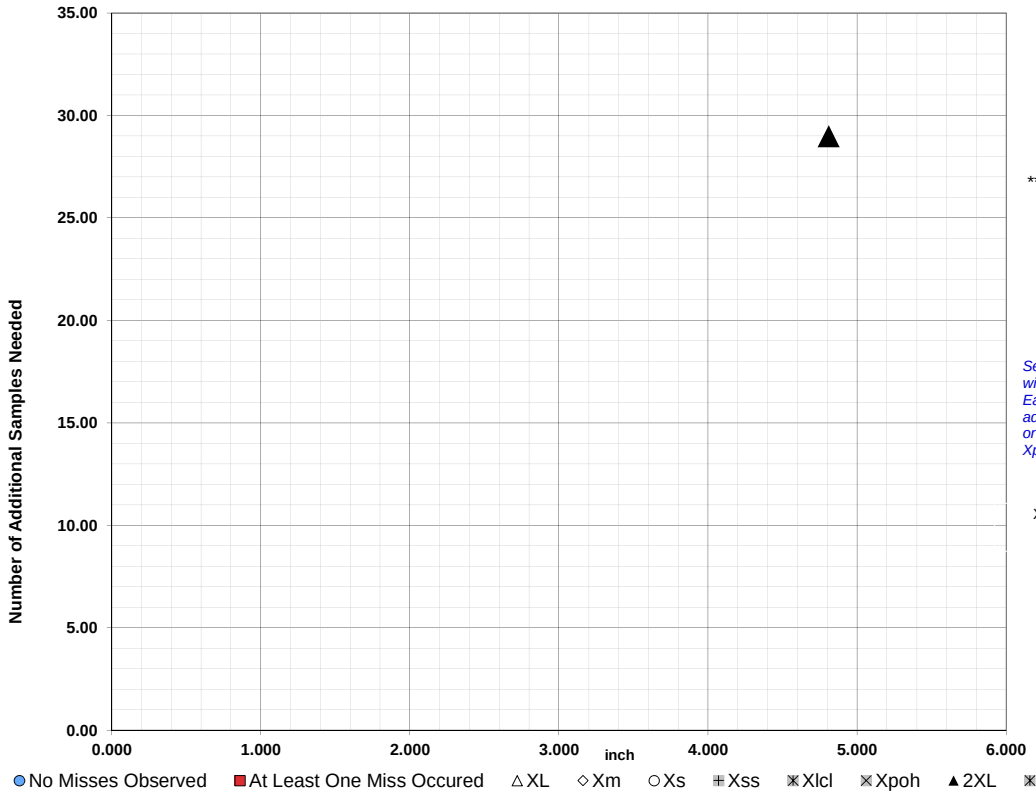



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

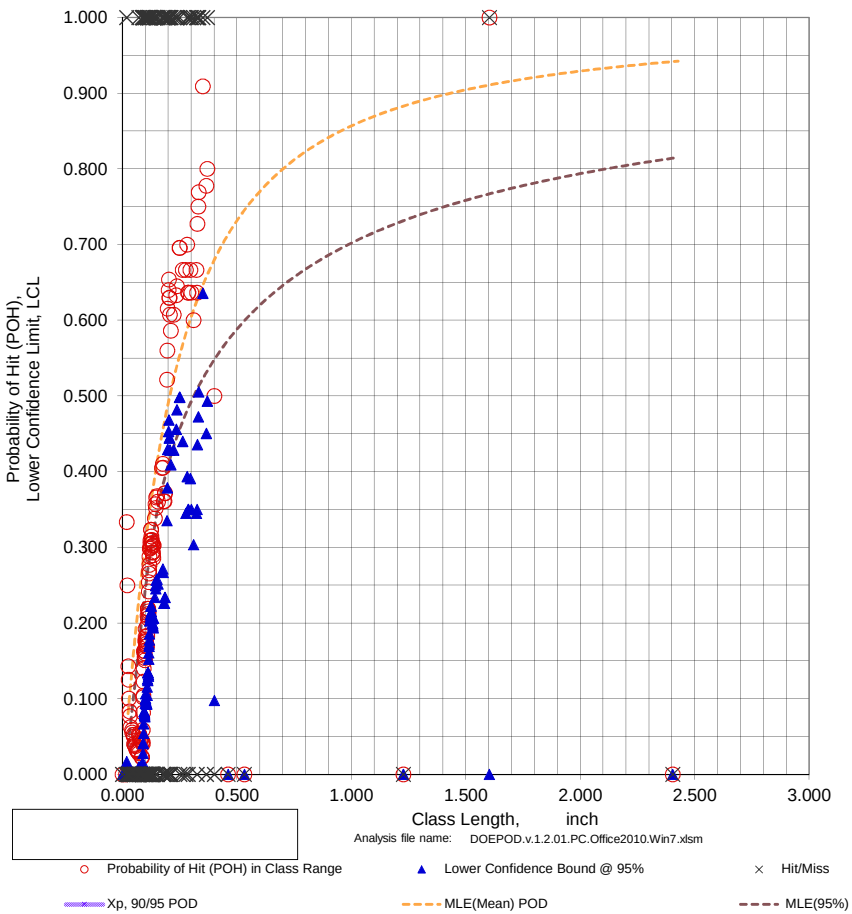
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A7003AL.XLS
Data Set Name = A7003AL(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:05 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6356 | |
| Classwidth @ Best LCL = | 0.0630 | inch |
| Classlength @ Best LCL = | 0.3500 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A7003AL.XLS
Data Set Name = A7003AL(CRK # )

## Directed DOE Options

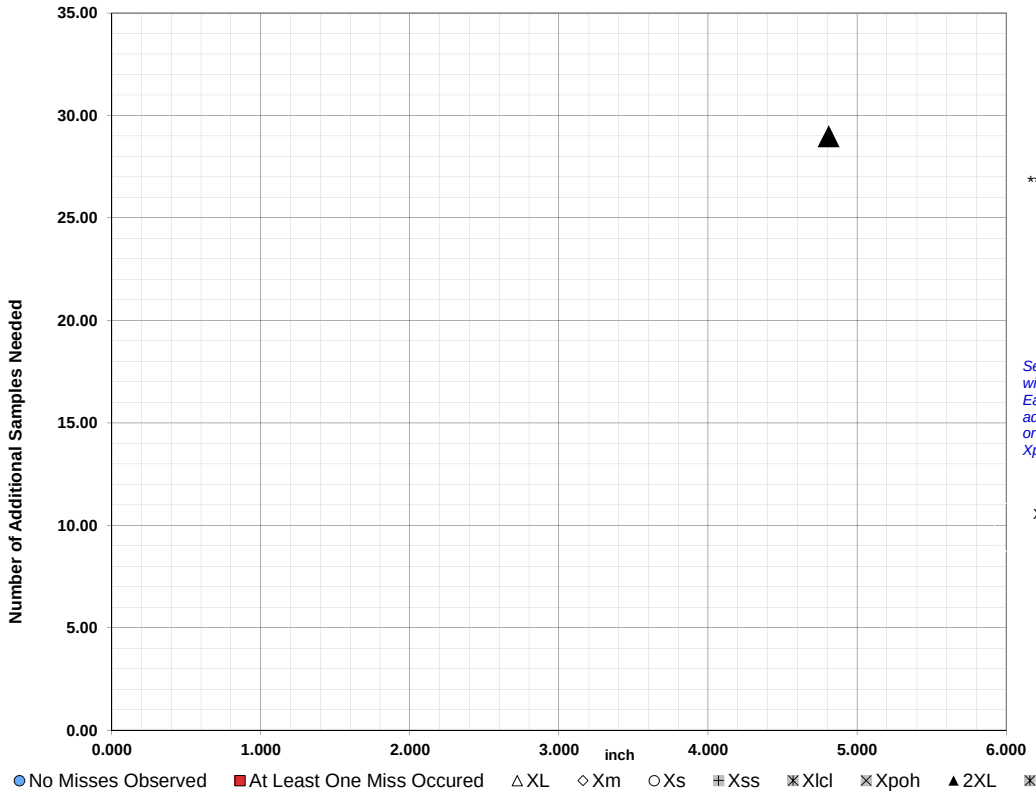



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

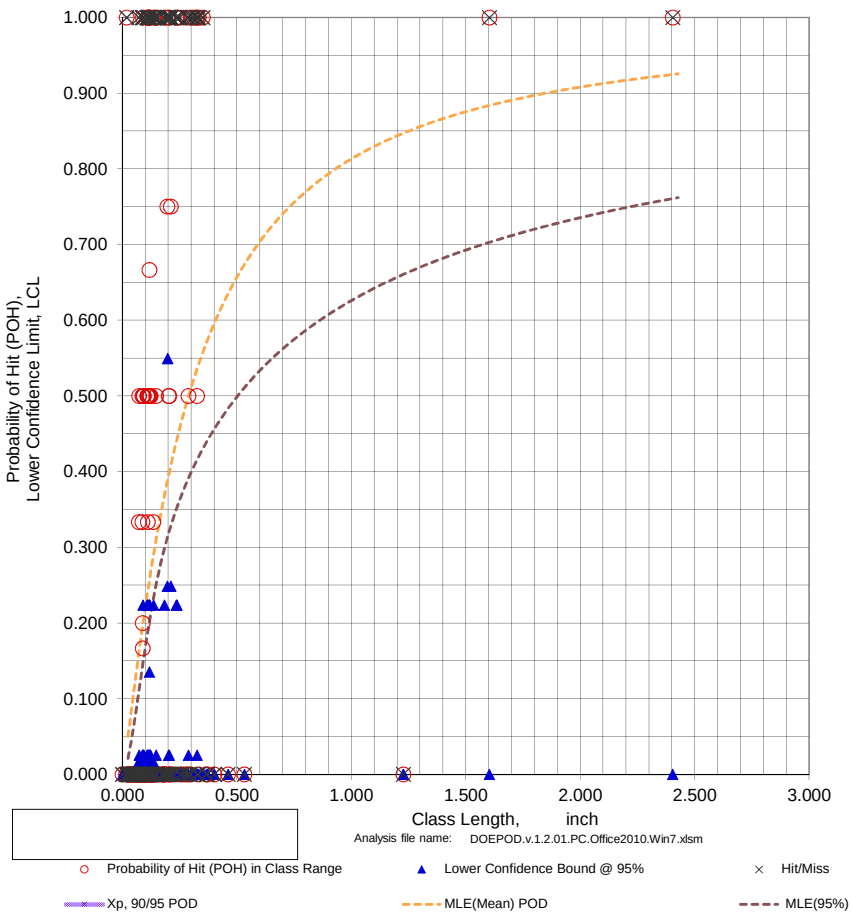
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A7003BL.XLS
Data Set Name = A7003BL(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:07 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.1960 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 2.403 | | inch |
| Samples Needed @ XL = | 28 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 1.603 | | inch |
| Samples Needed @ Xpoh = | 28 | | |
| New Largest Classlength , 2XL = | 4.806 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = A7003BL.XLS
Data Set Name = A7003BL(CRK # )

## Directed DOE Options

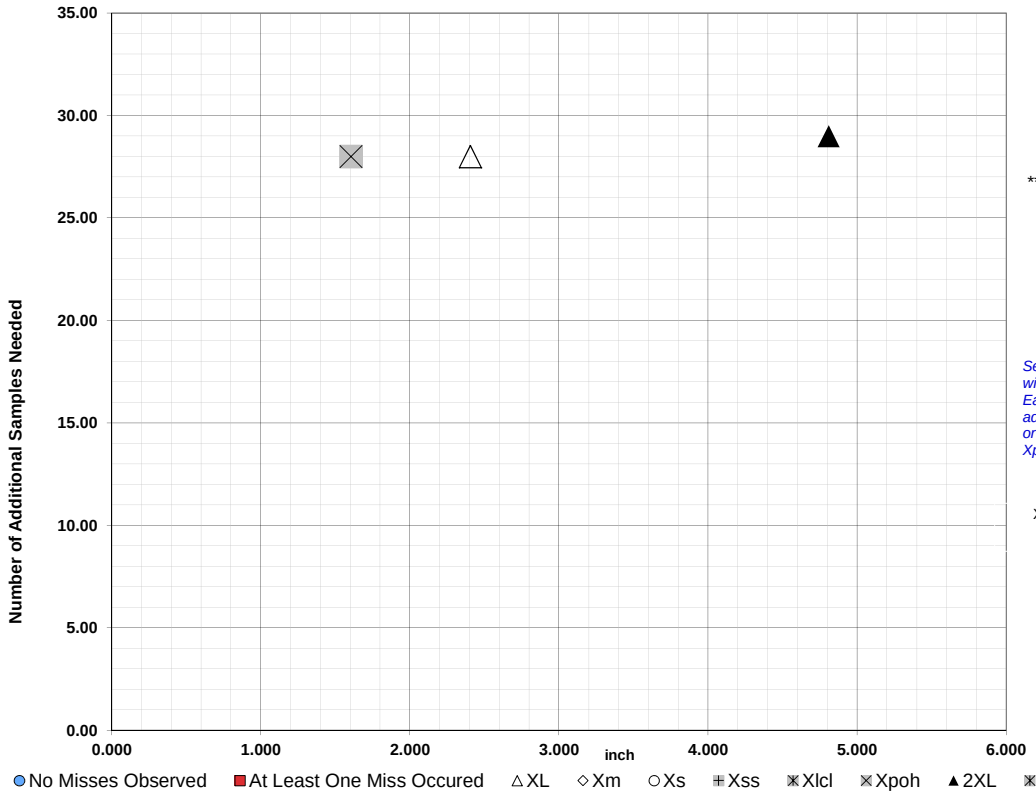



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

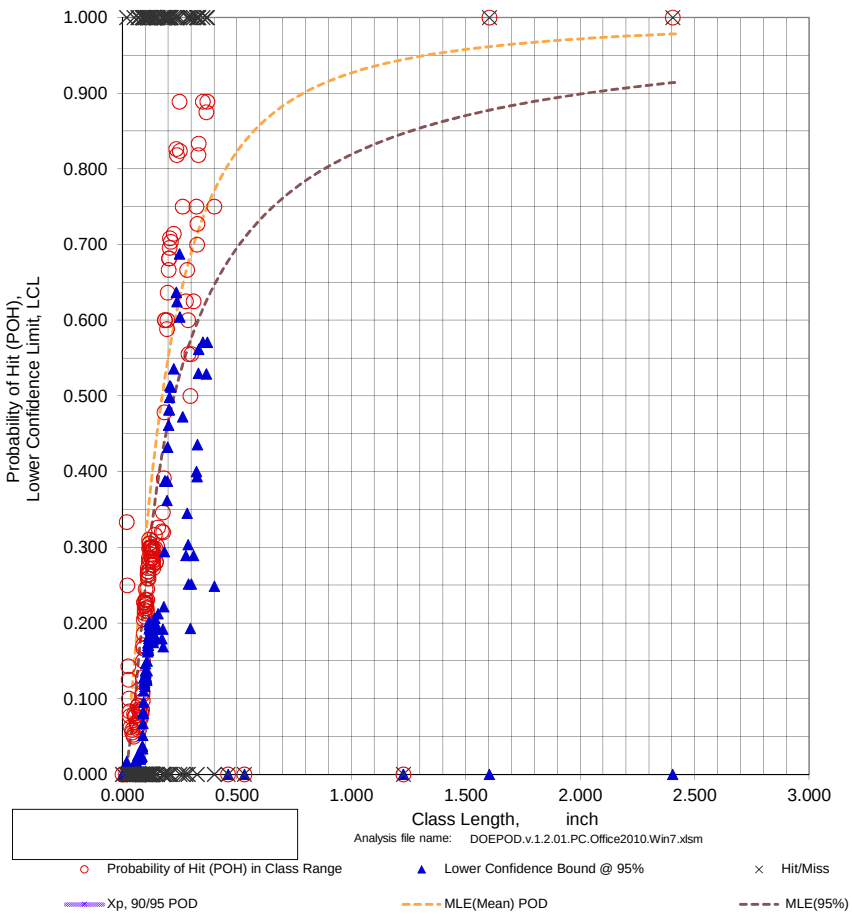
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A7003CL.XLS
Data Set Name = A7003CL(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:09 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6878 | |
| Classwidth @ Best LCL = | 0.0520 | inch |
| Classlength @ Best LCL = | 0.2480 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A7003CL.XLS
Data Set Name = A7003CL(CRK # )

## Directed DOE Options

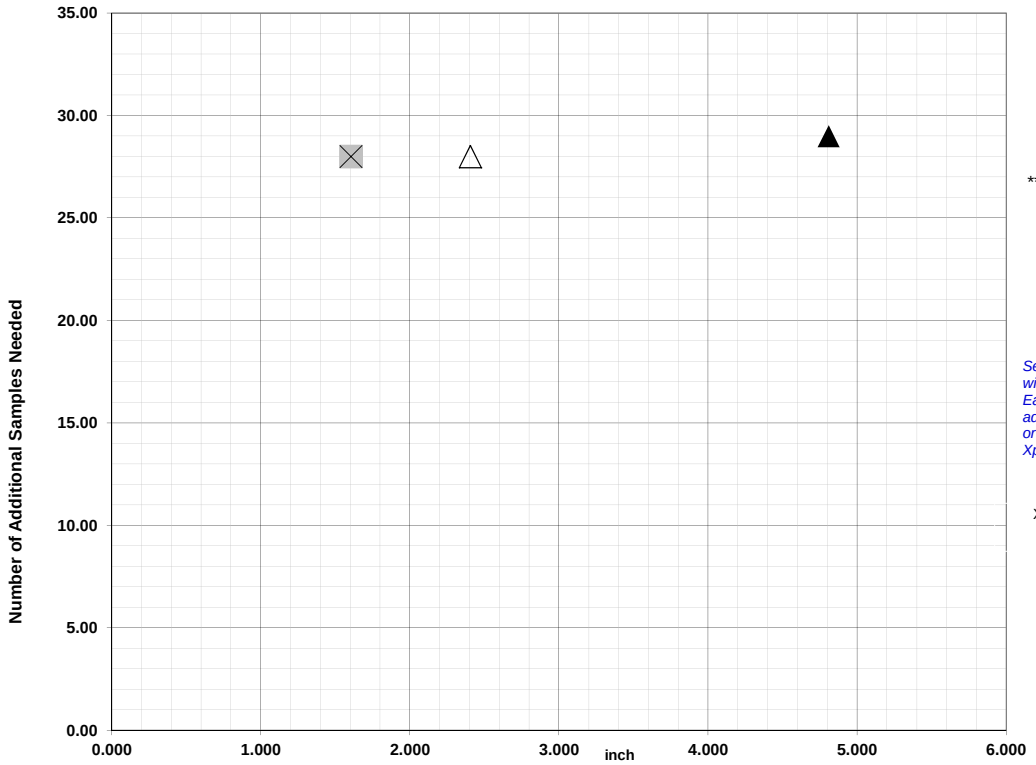



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

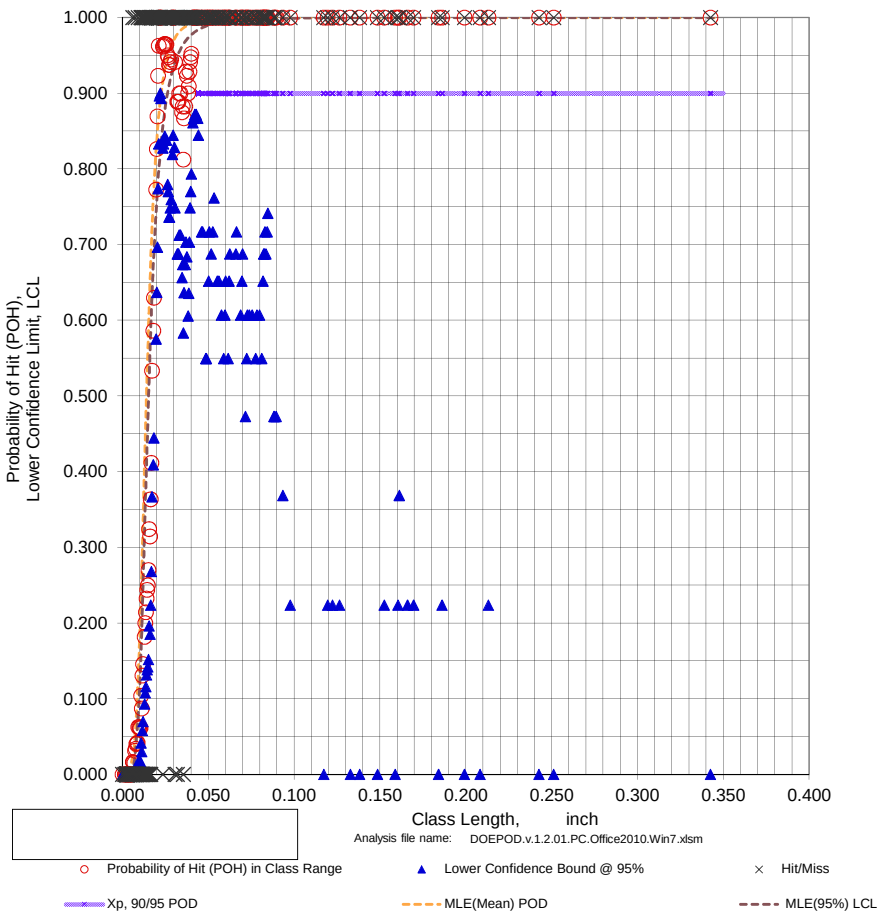
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **A8001L.XLS**

Data Set Name = **A8001L(Eci-a-a)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:11 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0050 | inch |
| Classlength @ 90/95 Xpod = | 0.0218 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.936 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.937 | @ | 0.030 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.161 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0440 | inch |

File Name = A8001L.XLS
Data Set Name = A8001L(Eci-a-a)

## Directed DOE Options

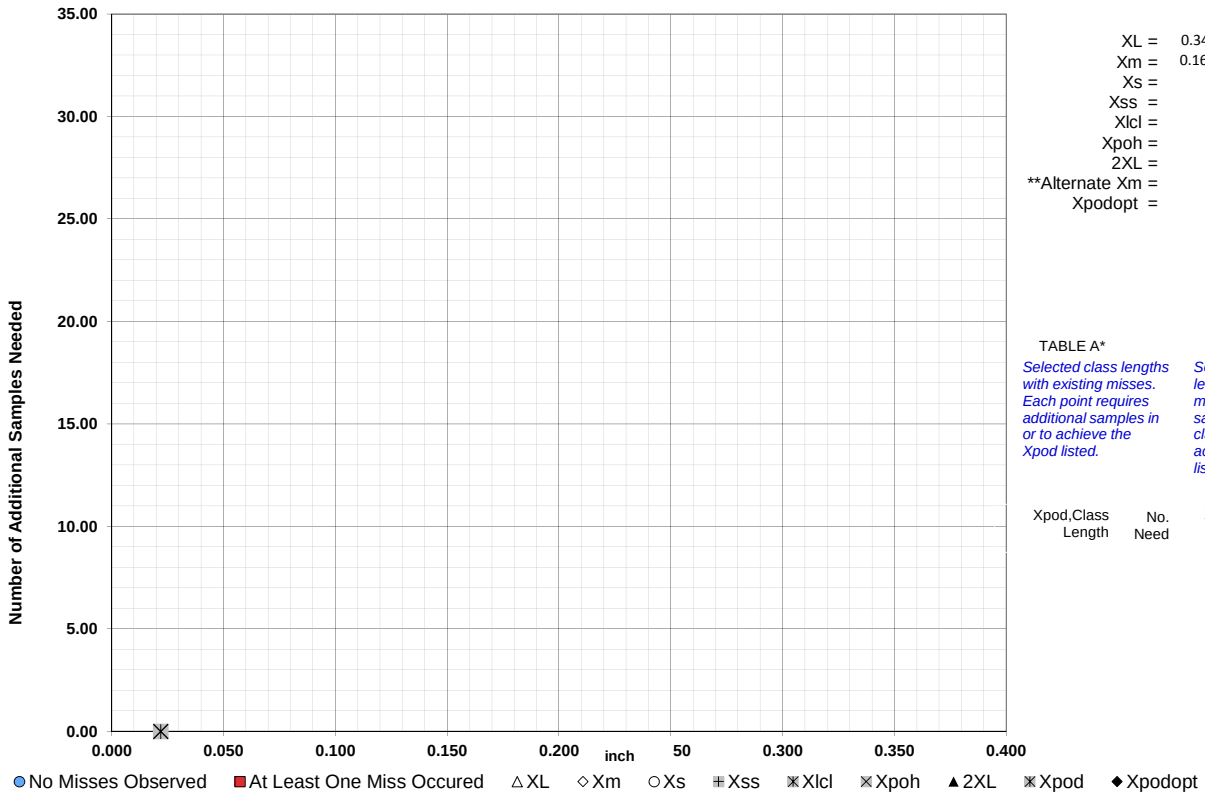



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.161 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

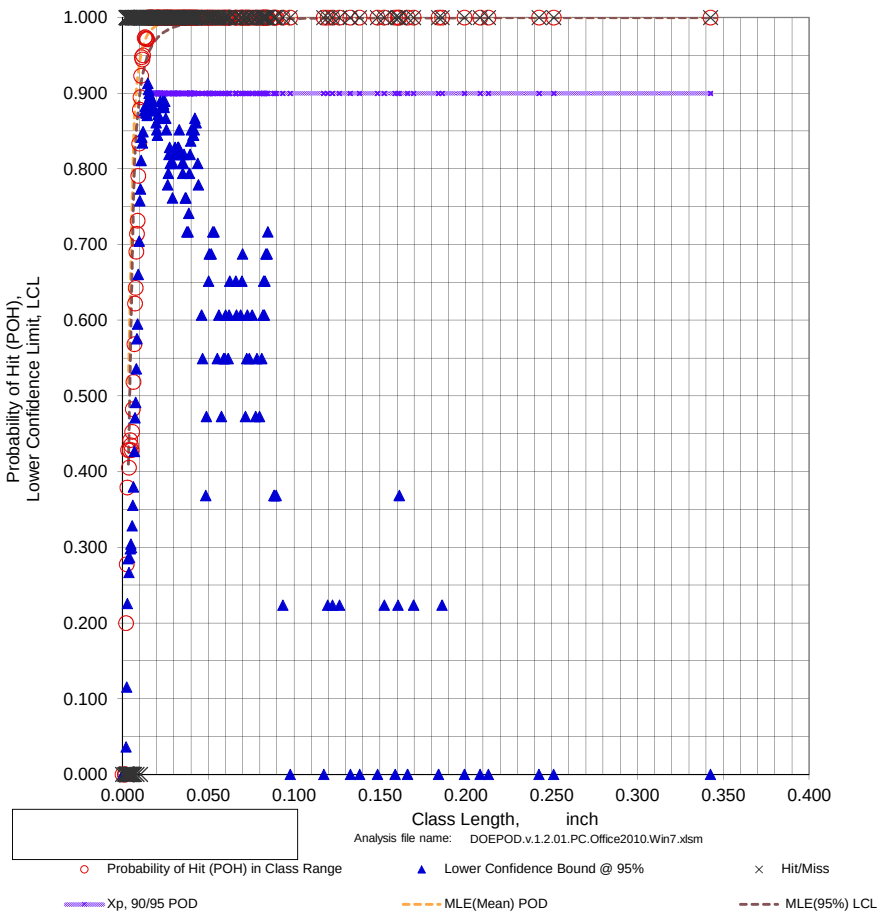
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 8 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A8002L.XLS**

Data Set Name = **A8002L(Eci-a-b5)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:12 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0040 | inch |
| Classlength @ 90/95 Xpod = | 0.0147 | inch |
| Lower Confidence Bound = | 0.9129 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0115 -0.001 inch 18 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.942 | @ | 0.010 | inch |
| NTIAC 90/95 POD = | 0.952 | @ | 0.015 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.161 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.014 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0147 | inch |

File Name = A8002L.XLS
Data Set Name = A8002L(Eci-a-b5)

## Directed DOE Options

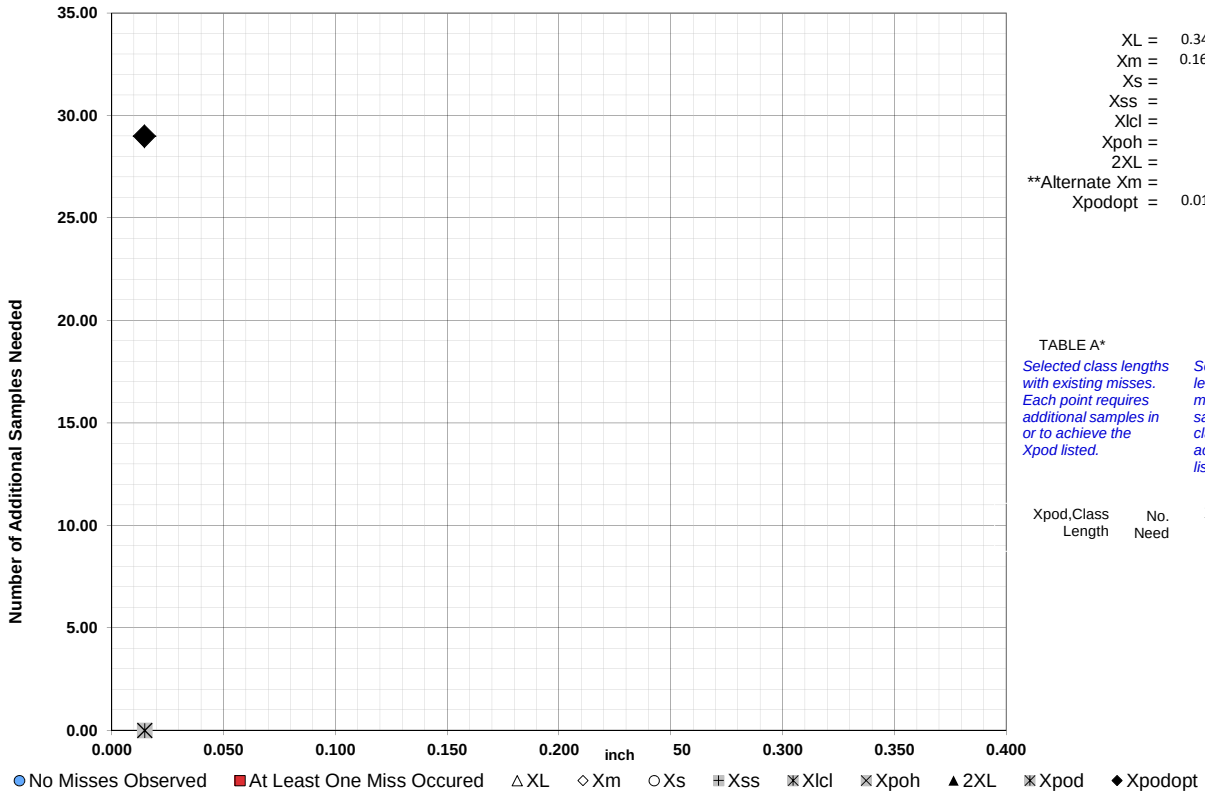



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.161 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.014 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 8 more large flaws.

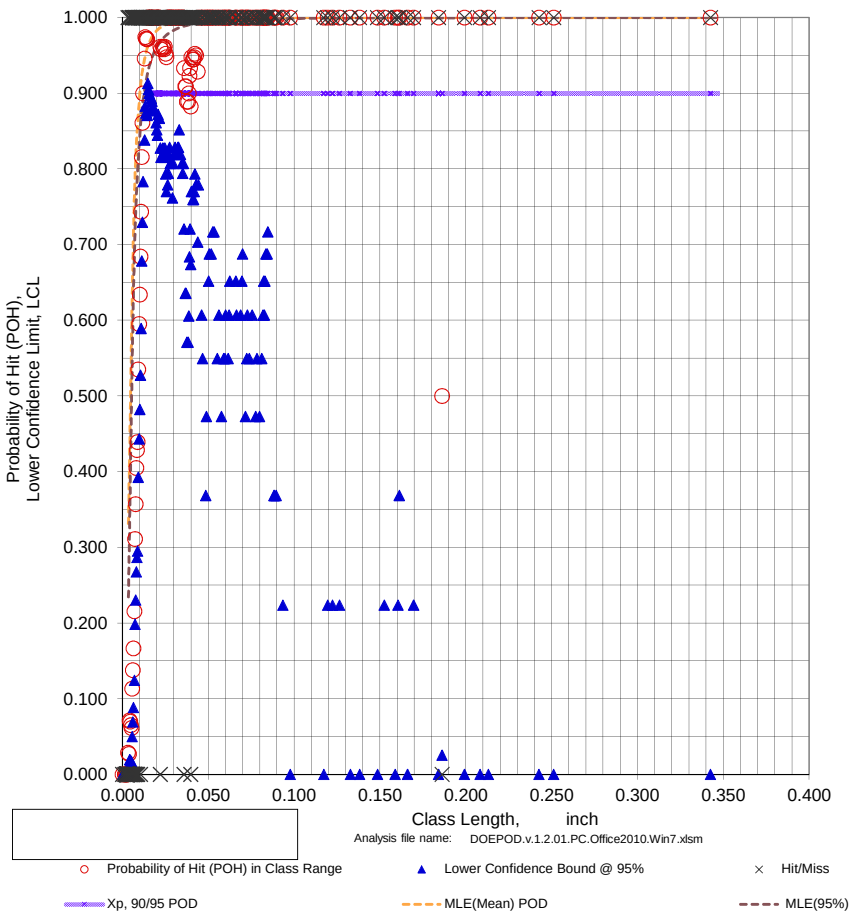
Any highlighted Misses are RED and shown in Column A of this data sheet

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = A8003L.XLS

Data Set Name = A8003L(Eci-a-b8)




| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:16 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0040 | inch |
| Classlength @ 90/95 Xpod = | 0.0147 | inch |
| Lower Confidence Bound = | 0.9129 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.010 | inch |
| NTIAC 90/95 POD = | 0.933 | @ | 0.015 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.161 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0147 | inch |

File Name = A8003L.XLS
Data Set Name = A8003L(Eci-a-b8)

## Directed DOE Options

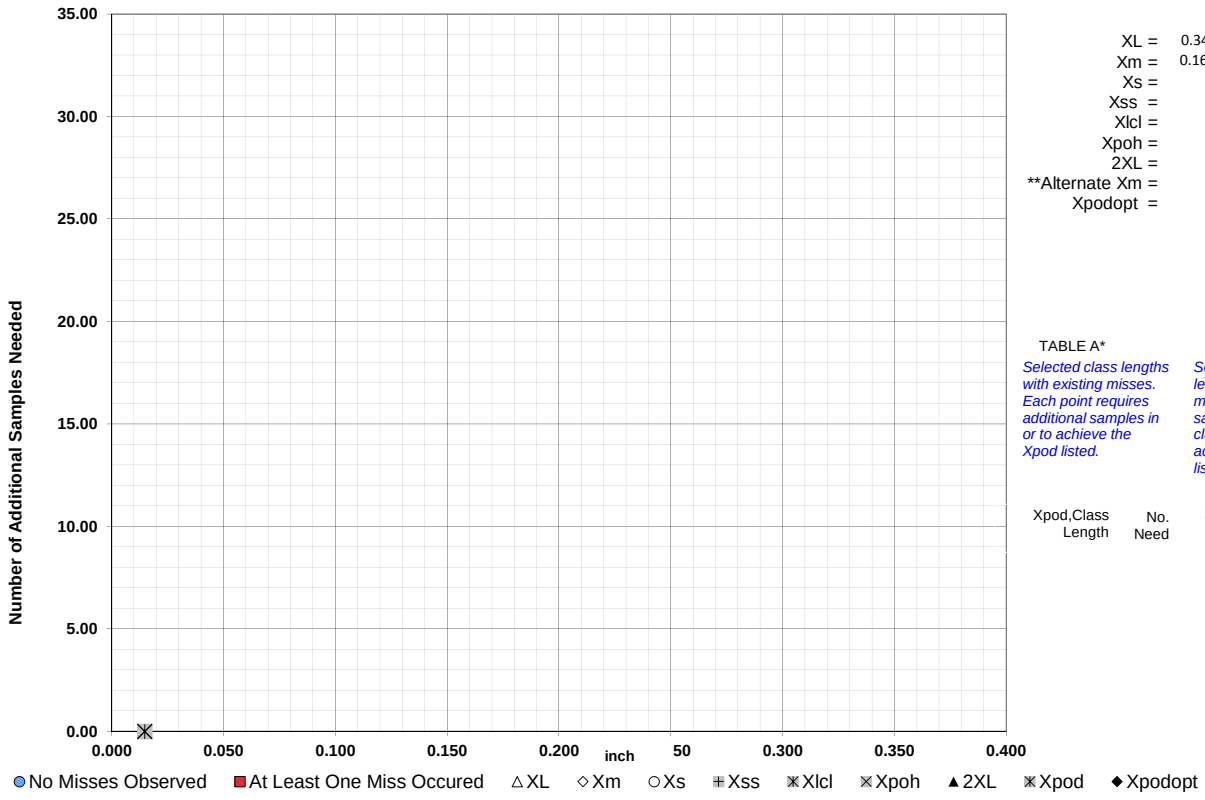



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.342 |
| Xm = | 0.161 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

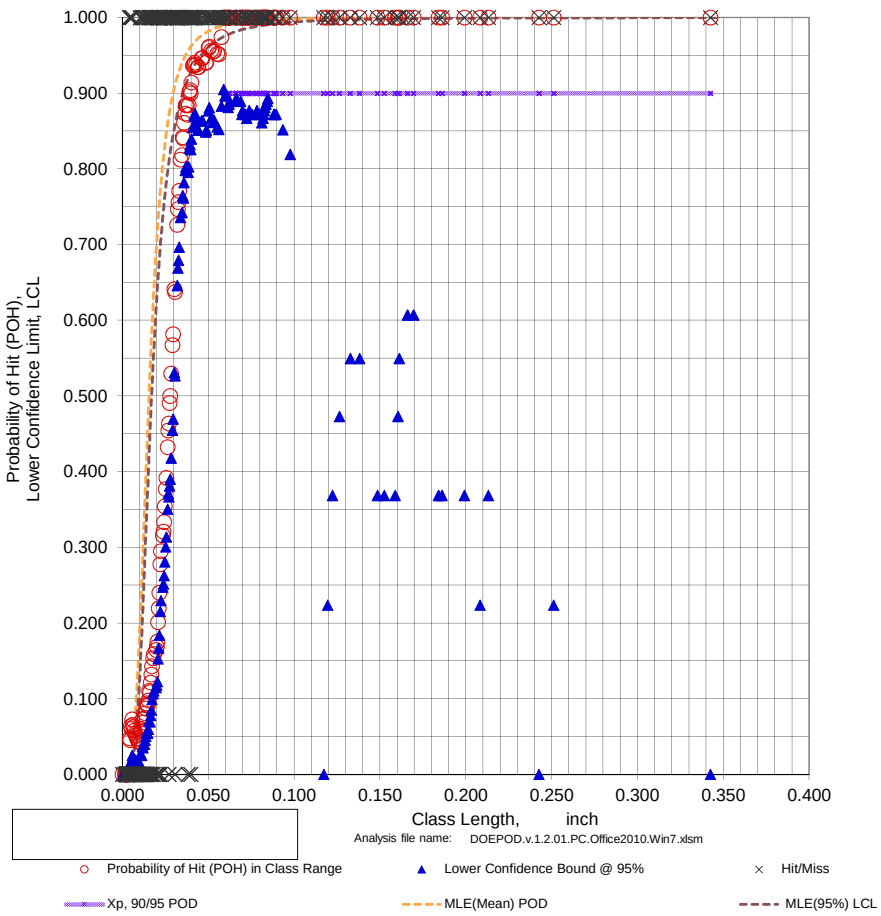
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 9 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A8004L.XLS**

Data Set Name = **A8004L(Eci-a-p)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:22 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.0587 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0409 -0.001 inch 25 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.929 | @ | 0.040 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.058 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0587 | inch |

File Name = A8004L.XLS
Data Set Name = A8004L(Eci-a-p)

## Directed DOE Options

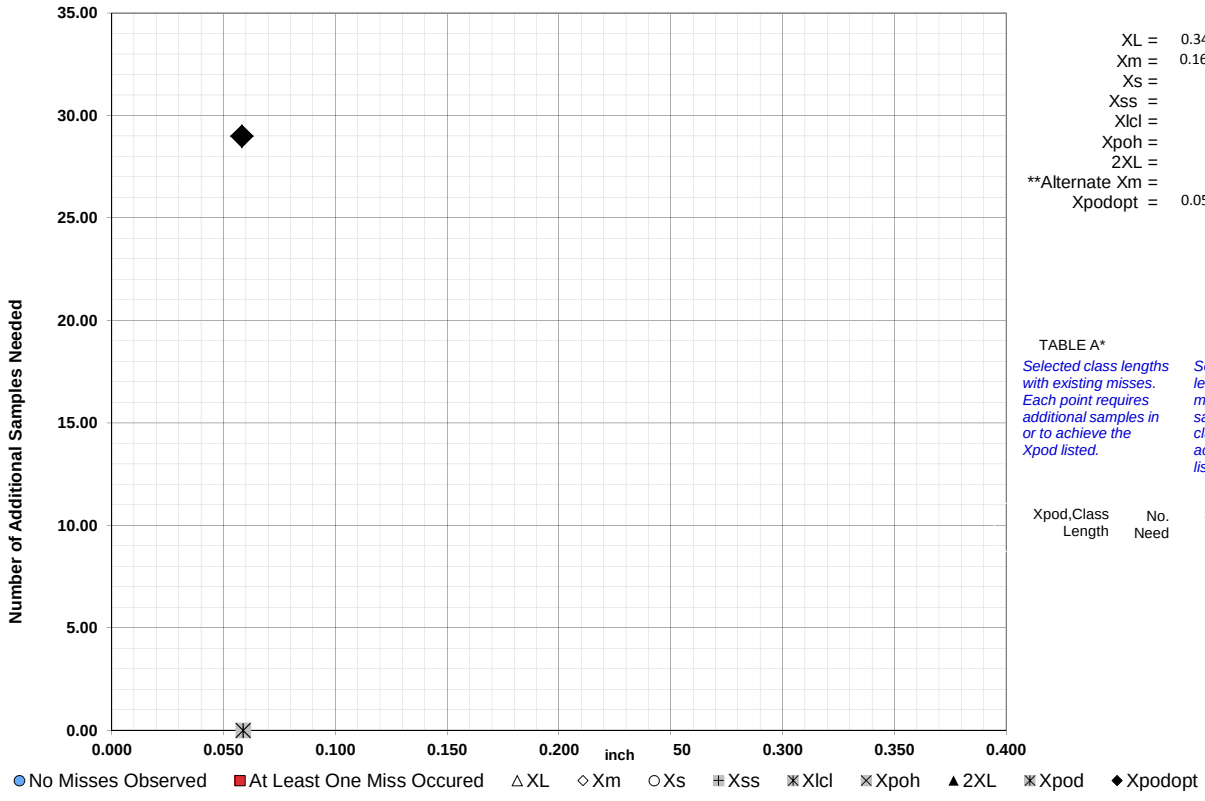



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.058 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

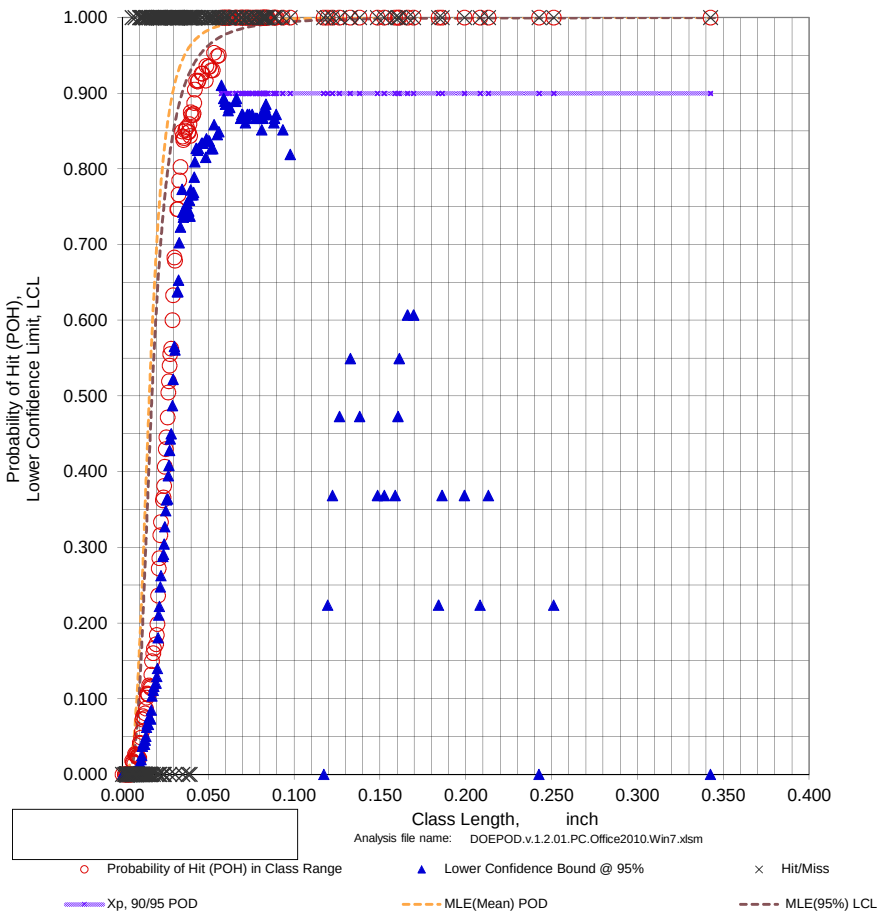
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 8 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **A8005L.XLS**

Data Set Name = **A8005L(Eci-m-a)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:23 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.0575 | inch |
| Lower Confidence Bound = | 0.9104 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0409 -0.001 inch 25 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.909 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.035 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.057 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0575 | inch |

File Name = A8005L.XLS
Data Set Name = A8005L(Eci-m-a)

## Directed DOE Options

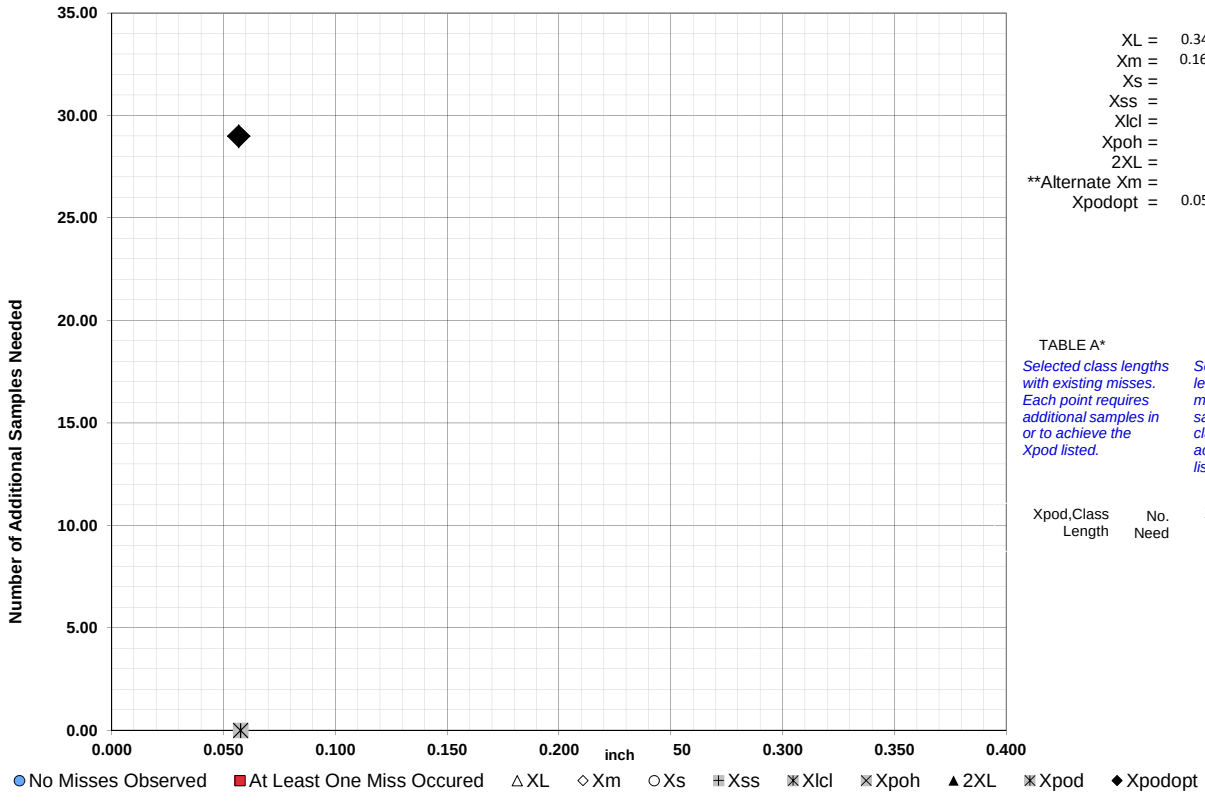



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.057 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 9 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

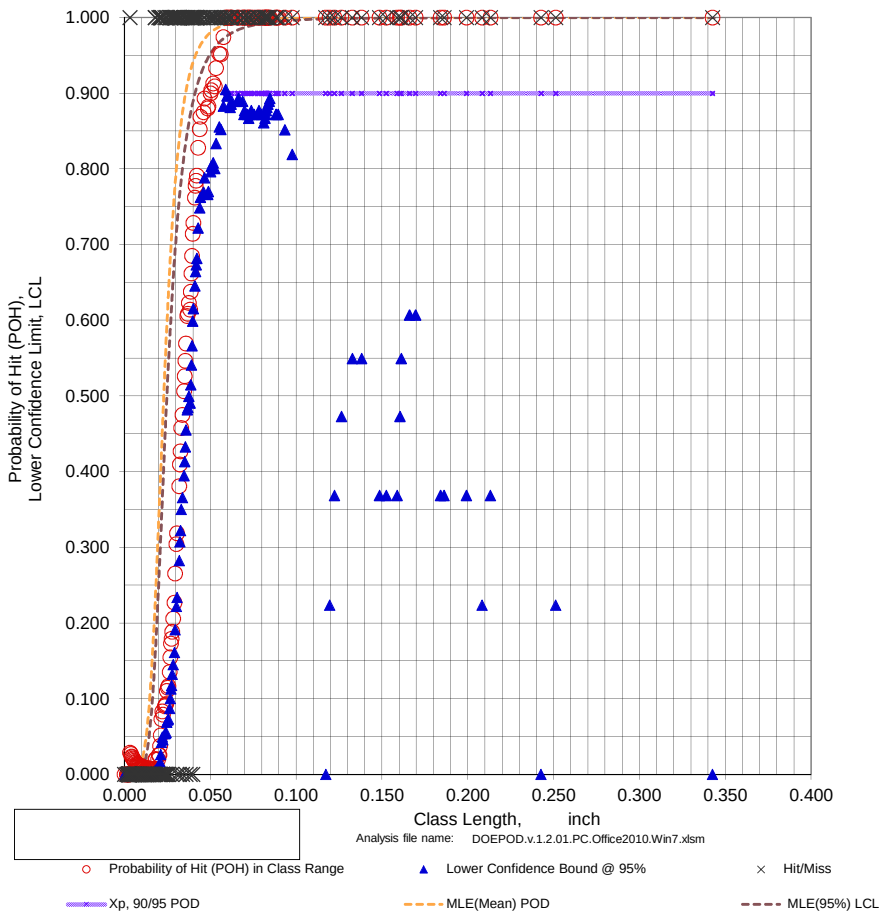
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **A8006L.XLS**

Data Set Name = **A8006L(Eci-m-c)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:24 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.0587 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0409 -0.001 inch 25 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.939 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.926 | @ | 0.045 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.058 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0587 | inch |

File Name = A8006L.XLS
Data Set Name = A8006L(Eci-m-c)

## Directed DOE Options

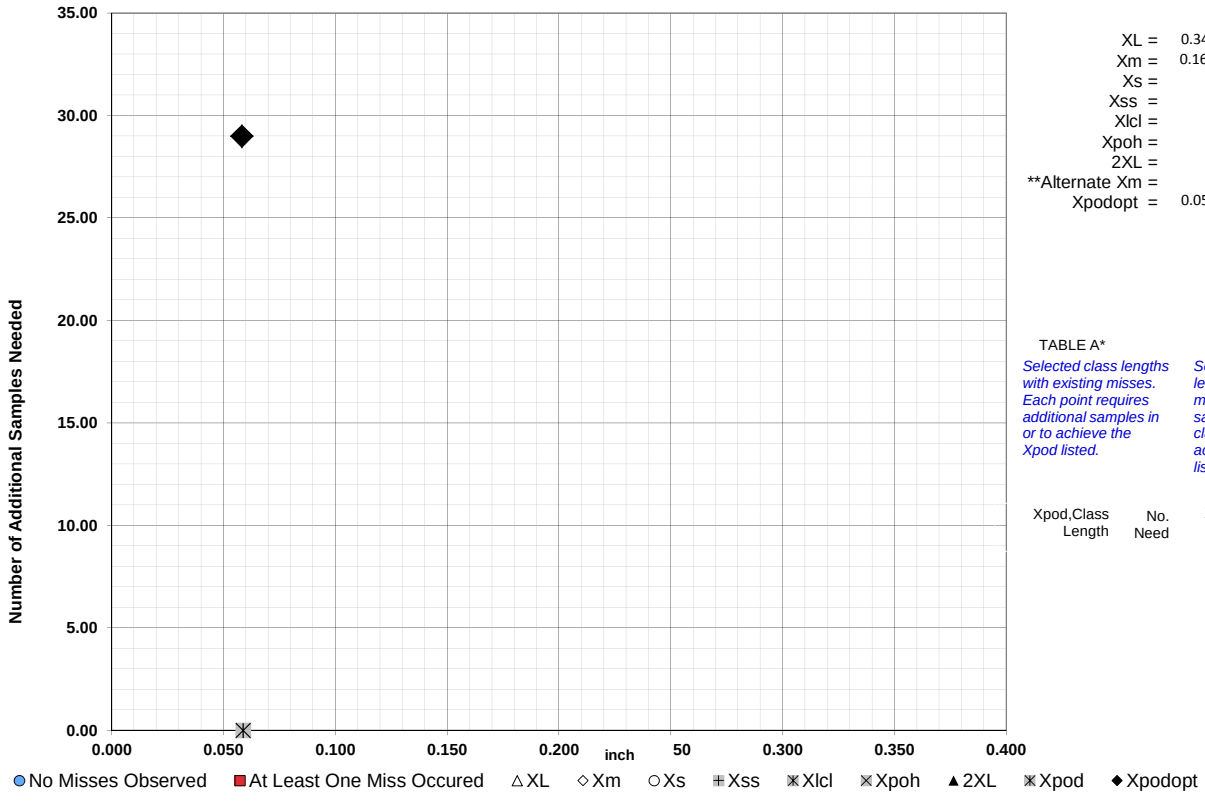



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.058 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

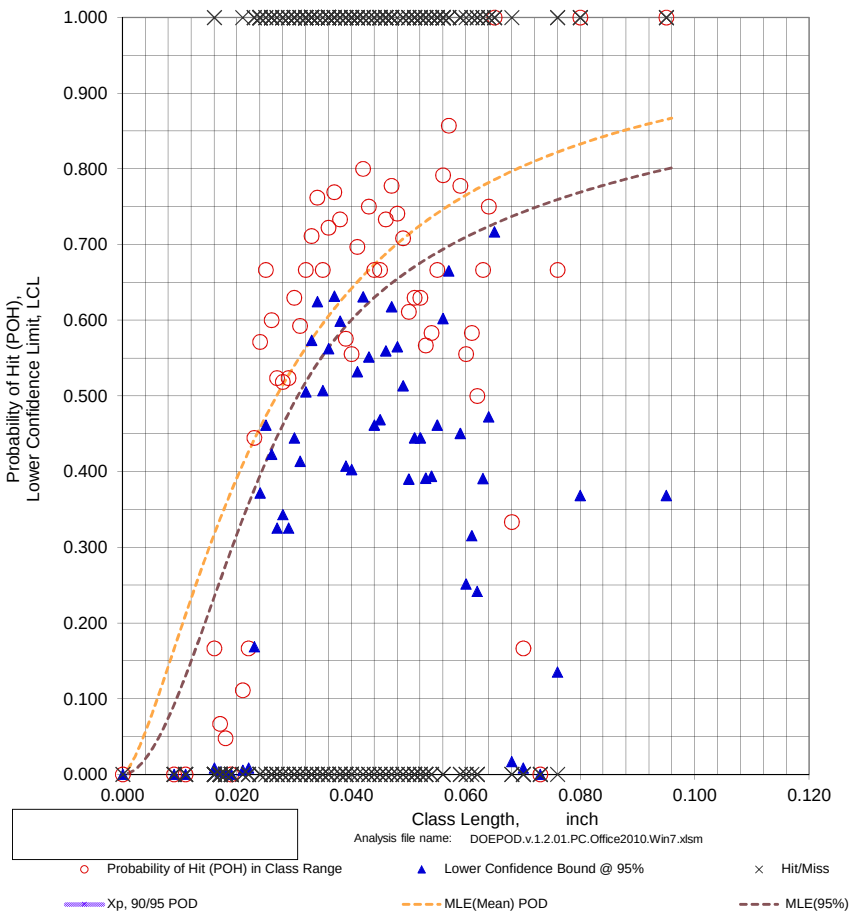
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A9001(3)D.xls
Data Set Name = A9001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:26 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.0650 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0800 -0.003 inch 26 Samples

NTIAC 90% POD = 0.901 @ 0.120 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.095 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.080 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.190 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A9001(3)D.xls
Data Set Name = A9001(3)D(CK. NO.)

## Directed DOE Options

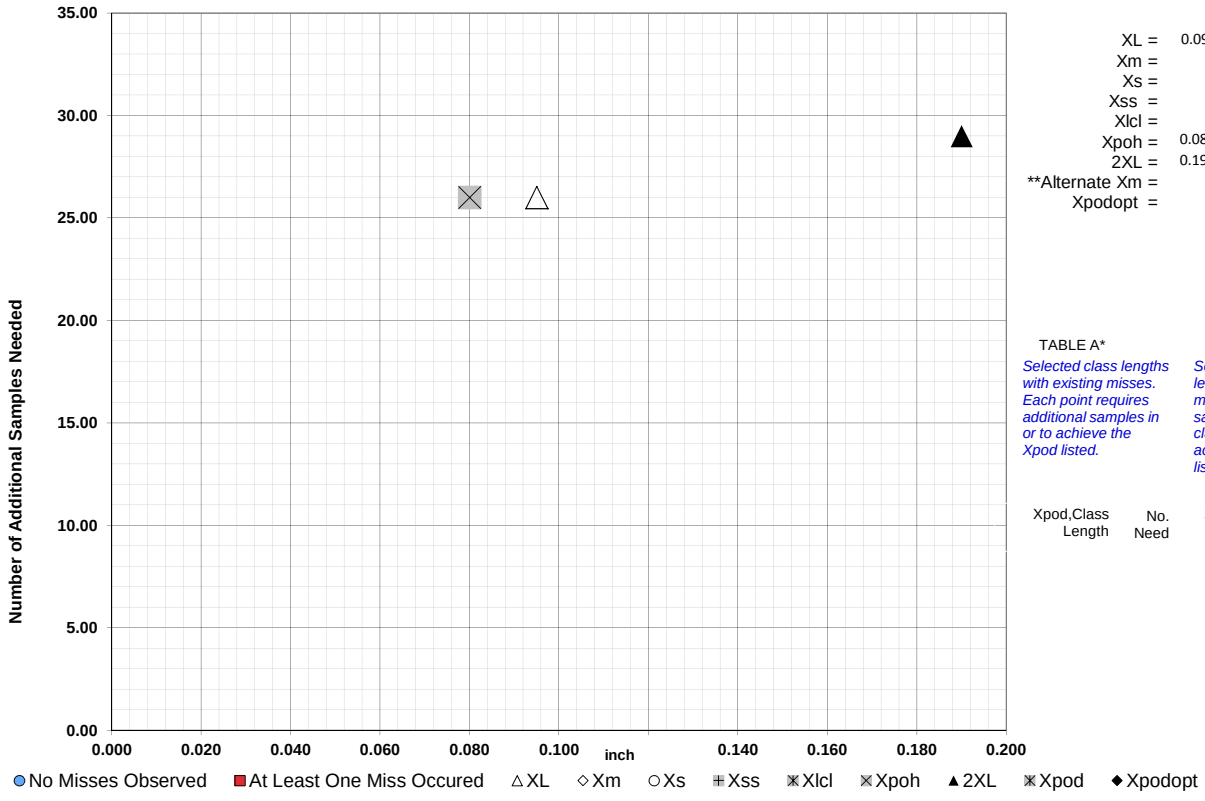



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.080 | 26 |
| 2XL = | 0.190 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

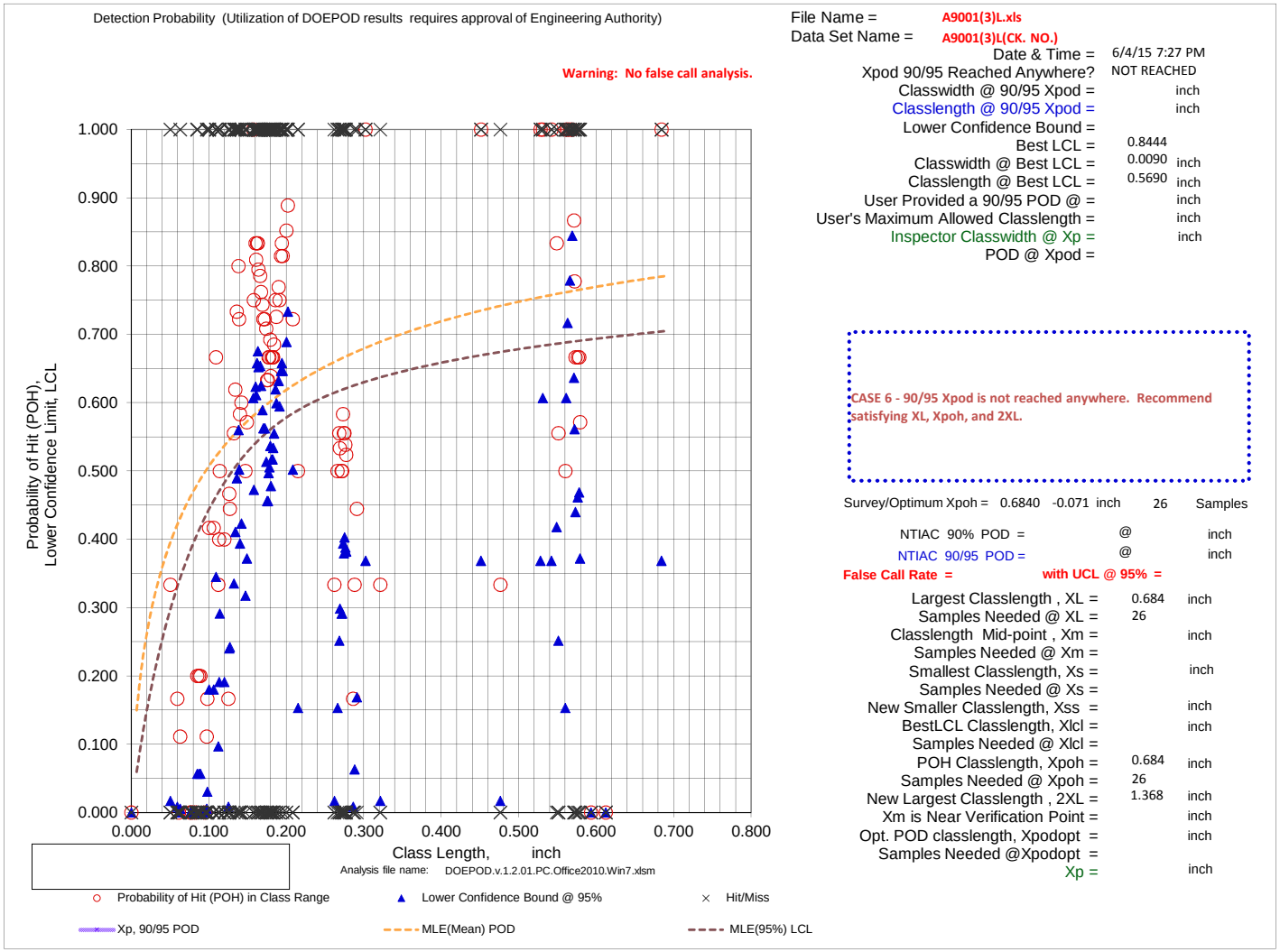
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
Warning: No false call analysis.
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000
0.100
0.200
0.300
0.400
0.500
0.600
0.700
0.800
Class Length, inch
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL
File Name = A9001(3)L.xls
Data Set Name = A9001(3)L(CK. NO.)
Date & Time = 6/4/15 7:27 PM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.8444
Classwidth @ Best LCL = 0.0090 inch
Classlength @ Best LCL = 0.5690 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.
Survey/Optimum Xpoh = 0.6840 -0.071 inch 26 Samples
NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = 0.684 inch
Samples Needed @ XL = 26
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = 0.684 inch
Samples Needed @ Xpoh = 26
New Largest Classlength , 2XL = 1.368 inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch

File Name = A9001(3)L.xls
Data Set Name = A9001(3)L(CK. NO.)

## Directed DOE Options

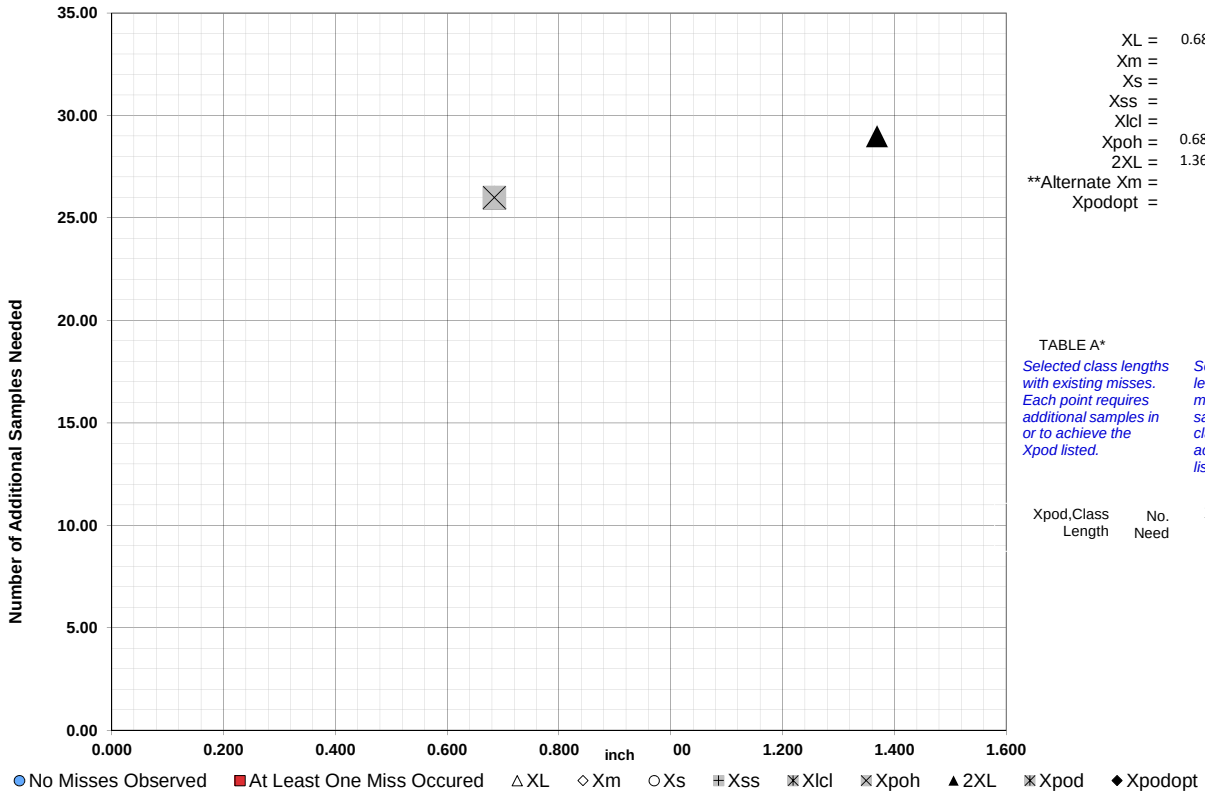



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.684 | 26 |
| 2XL = | 1.368 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

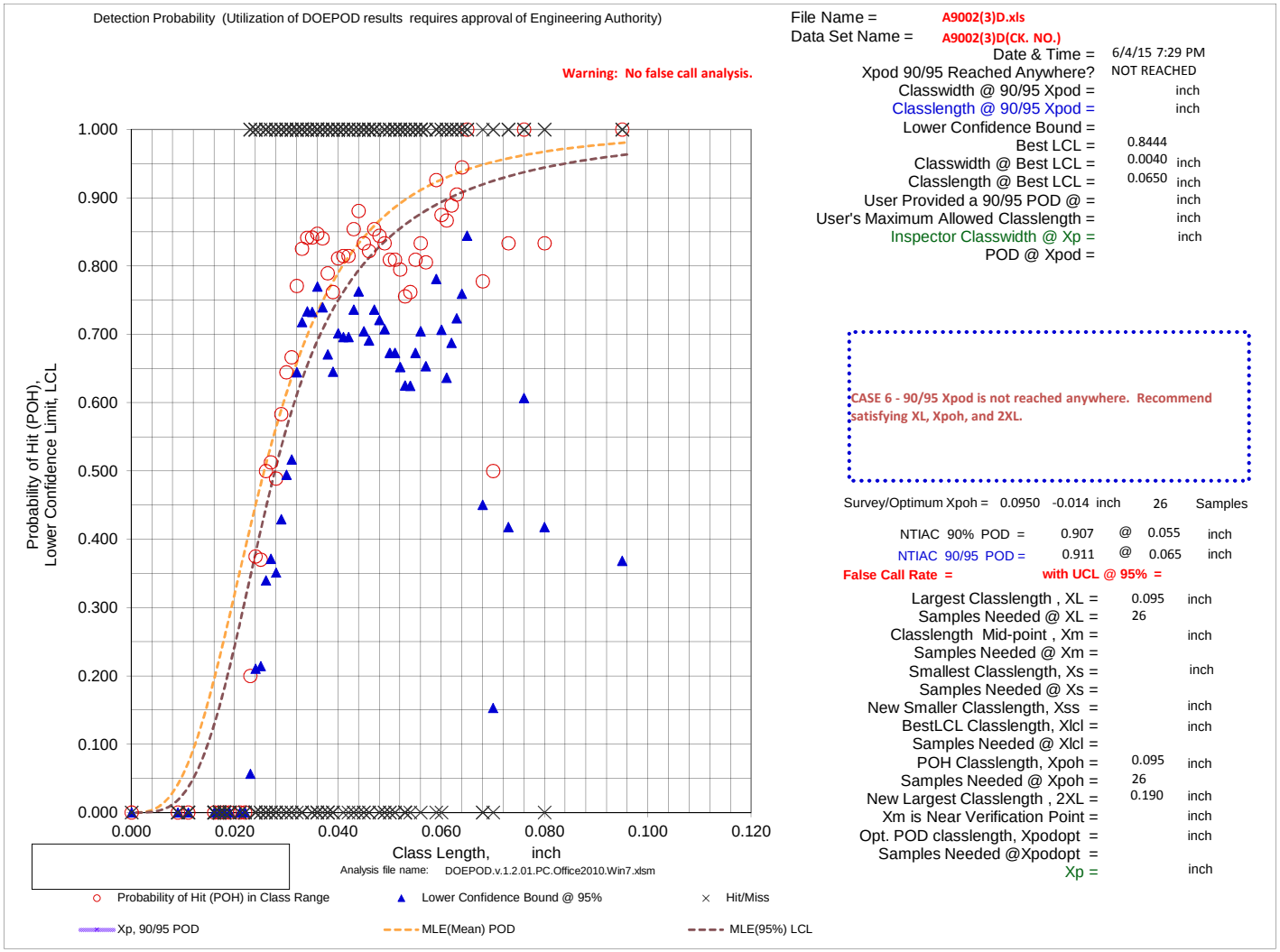
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
Warning: No false call analysis.
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000
0.020
0.040
0.060
0.080
0.100
0.120
Class Length, inch
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL
File Name = A9002(3)D.xls
Data Set Name = A9002(3)D(CK. NO.)
Date & Time = 6/4/15 7:29 PM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.8444
Classwidth @ Best LCL = 0.0040 inch
Classlength @ Best LCL = 0.0650 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.
Survey/Optimum Xpoh = 0.0950 -0.014 inch 26 Samples
NTIAC 90% POD = 0.907 @ 0.055 inch
NTIAC 90/95 POD = 0.911 @ 0.065 inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = 0.095 inch
Samples Needed @ XL = 26
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = 0.095 inch
Samples Needed @ Xpoh = 26
New Largest Classlength , 2XL = 0.190 inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch

File Name = A9002(3)D.xls
Data Set Name = A9002(3)D(CK. NO.)

## Directed DOE Options

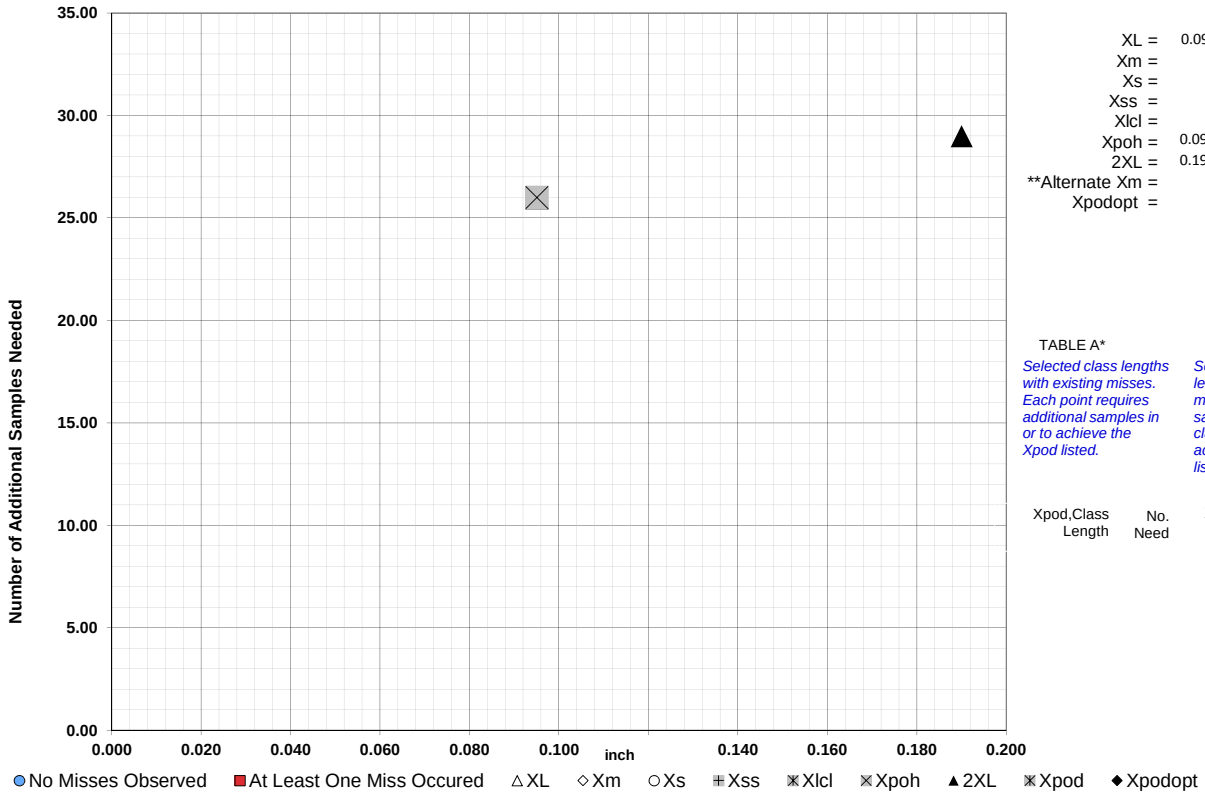



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.095 | 26 |
| 2XL = | 0.190 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

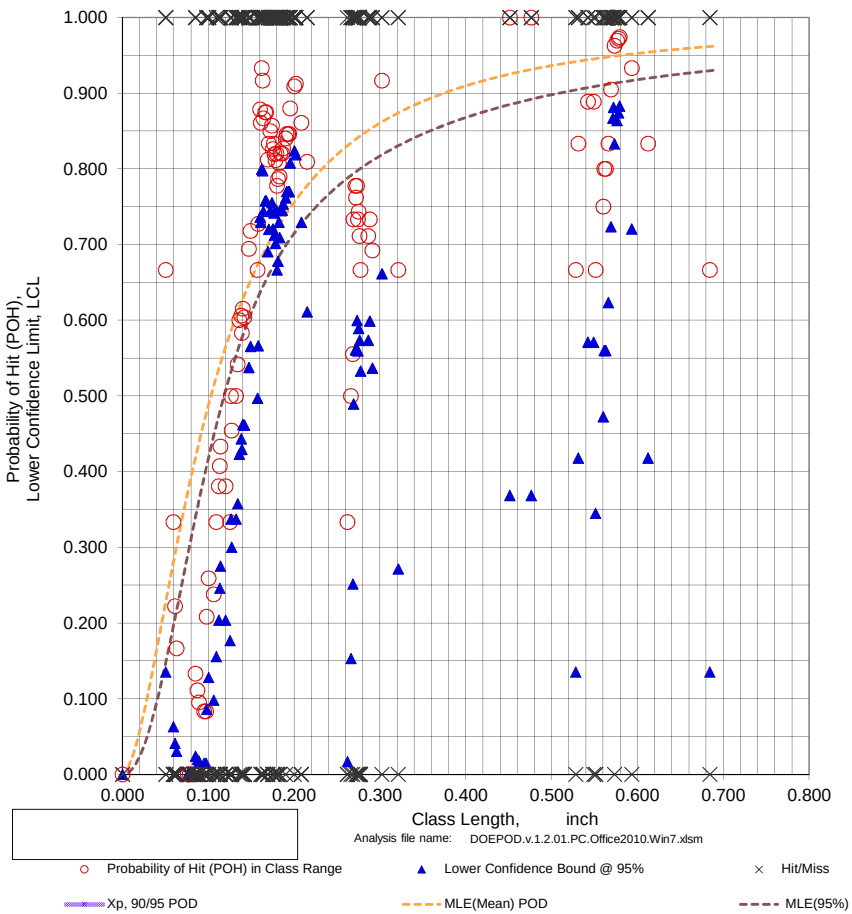
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = A9002(3)L.xls
Data Set Name = A9002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:31 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8827 | |
| Classwidth @ Best LCL = | 0.0190 | inch |
| Classlength @ Best LCL = | 0.5790 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.375 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.510 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.368 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A9002(3)L.xls
Data Set Name = A9002(3)L(CK. NO.)

## Directed DOE Options

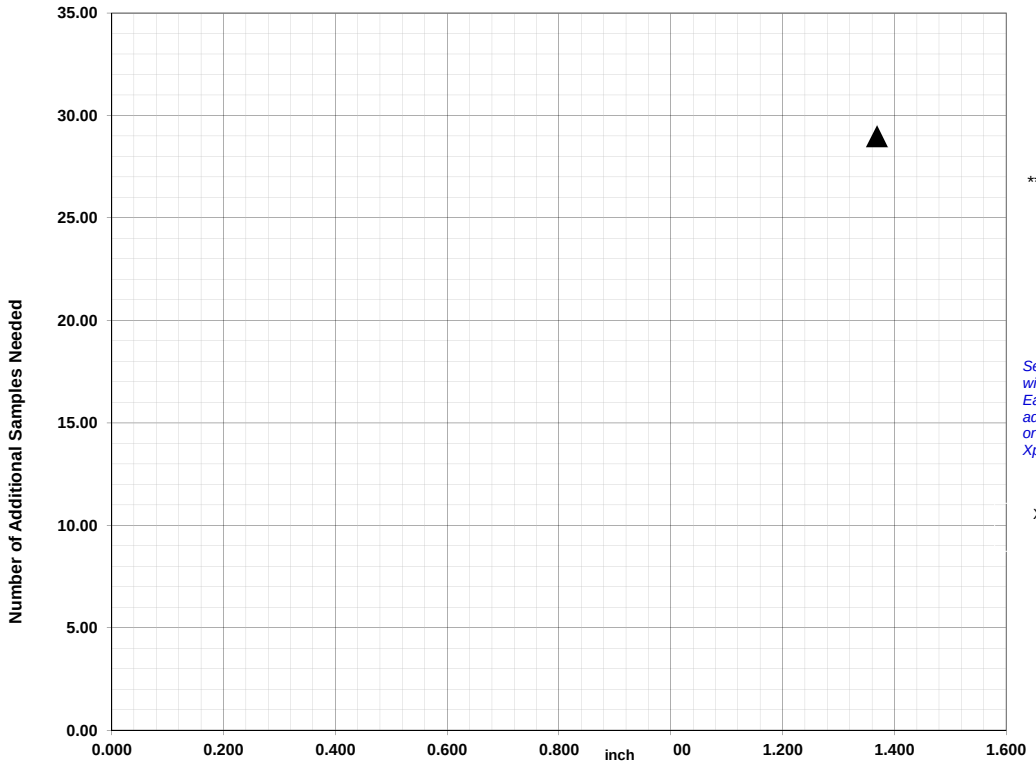



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.368 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

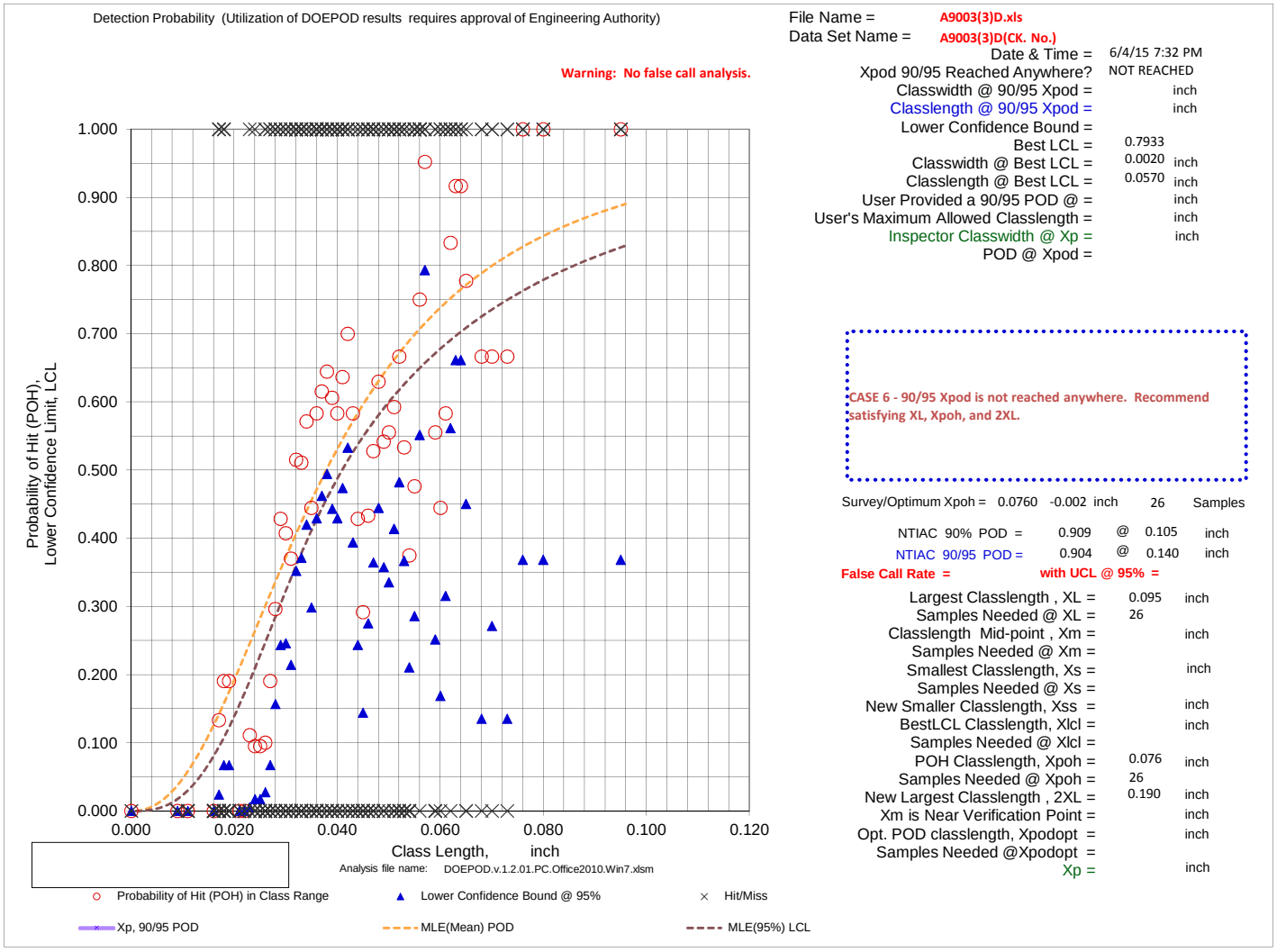
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
Warning: No false call analysis.
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000
0.020
0.040
0.060
0.080
0.100
0.120
Class Length, inch
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL
File Name = A9003(3)D.xls
Data Set Name = A9003(3)D(CK. No.)
Date & Time = 6/4/15 7:32 PM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.7933
Classwidth @ Best LCL = 0.0020 inch
Classlength @ Best LCL = 0.0570 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.
Survey/Optimum Xpoh = 0.0760 -0.002 inch 26 Samples
NTIAC 90% POD = 0.909 @ 0.105 inch
NTIAC 90/95 POD = 0.904 @ 0.140 inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = 0.095 inch
Samples Needed @ XL = 26
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = 0.076 inch
Samples Needed @ Xpoh = 26
New Largest Classlength , 2XL = 0.190 inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch

File Name = A9003(3)D.xls
Data Set Name = A9003(3)D(CK. No.)

## Directed DOE Options

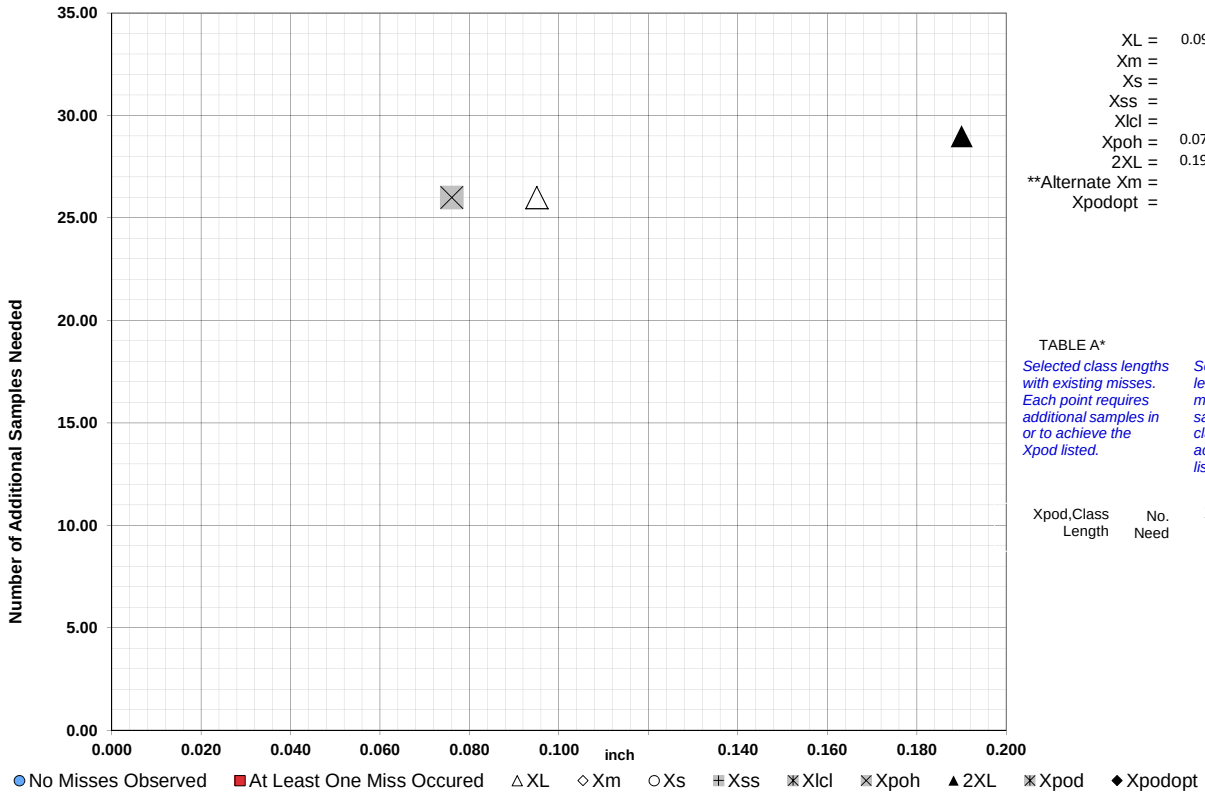



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.076 | 26 |
| 2XL = | 0.190 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

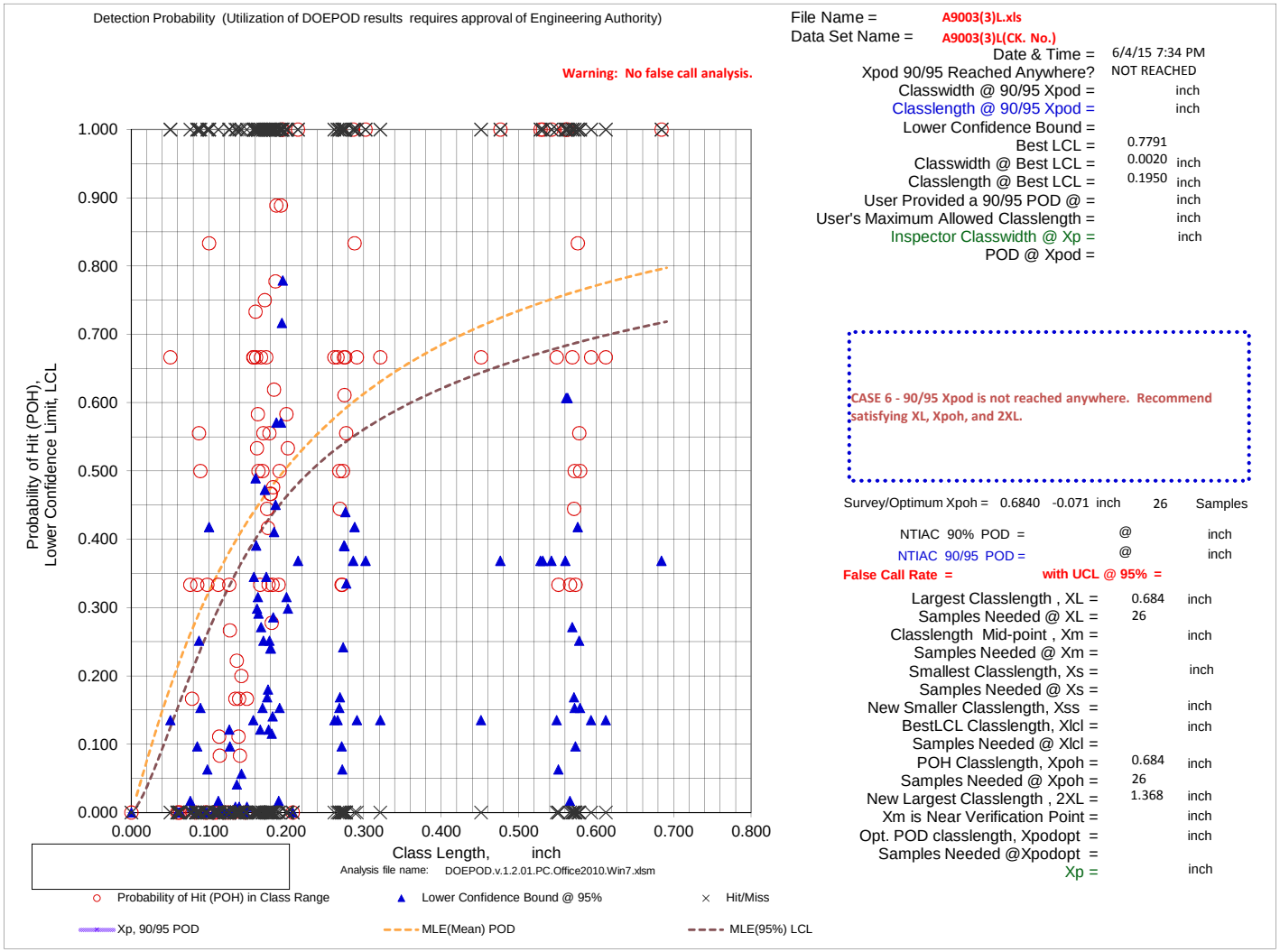
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = A9003(3)L.xls
Data Set Name = A9003(3)L(CK. No.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:34 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.1950 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.6840 -0.071 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.684 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 1.368 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = A9003(3)L.xls
Data Set Name = A9003(3)L(CK. No.)

## Directed DOE Options

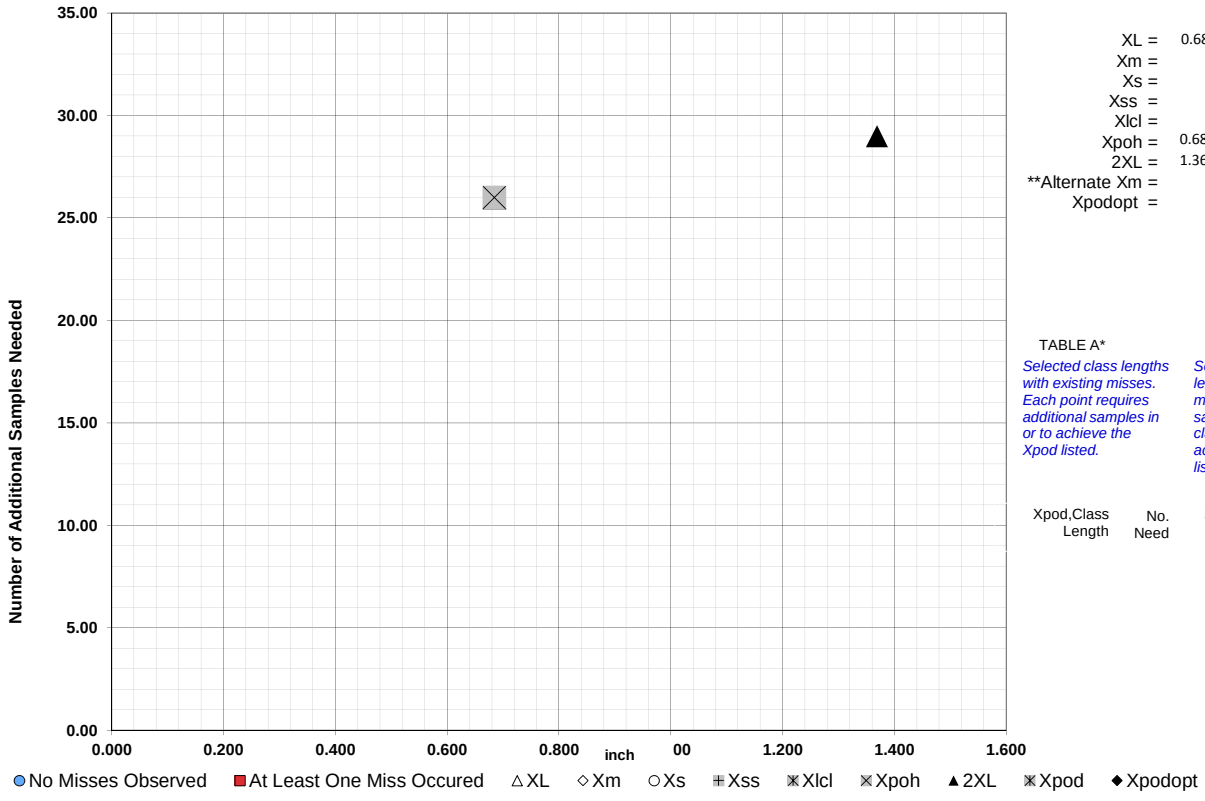



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.684 | 26 |
| 2XL = | 1.368 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

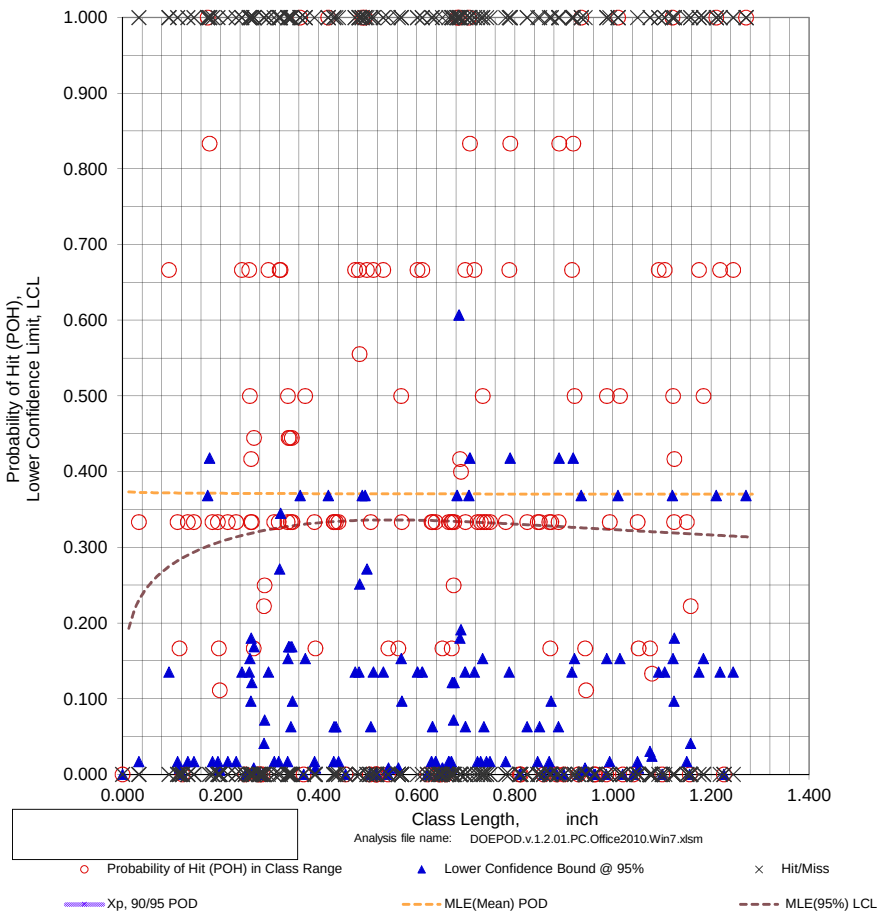
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = AA001(3)L.xls
Data Set Name = AA001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:35 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.6860 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.2710 -0.025 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 1.271 | | inch |
| Samples Needed @ XL = | 26 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 1.271 | | inch |
| Samples Needed @ Xpoh = | 26 | | |
| New Largest Classlength , 2XL = | 2.542 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = AA001(3)L.xls
Data Set Name = AA001(3)L(CK. NO.)

## Directed DOE Options

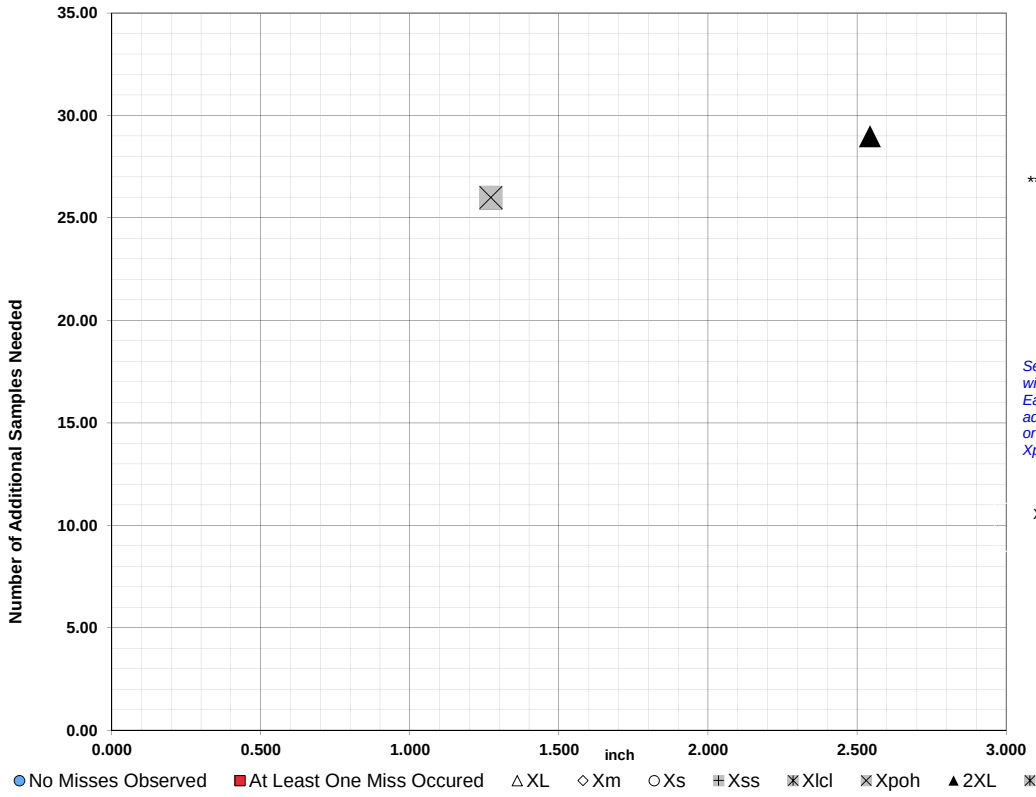



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.271 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.271 | 26 |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

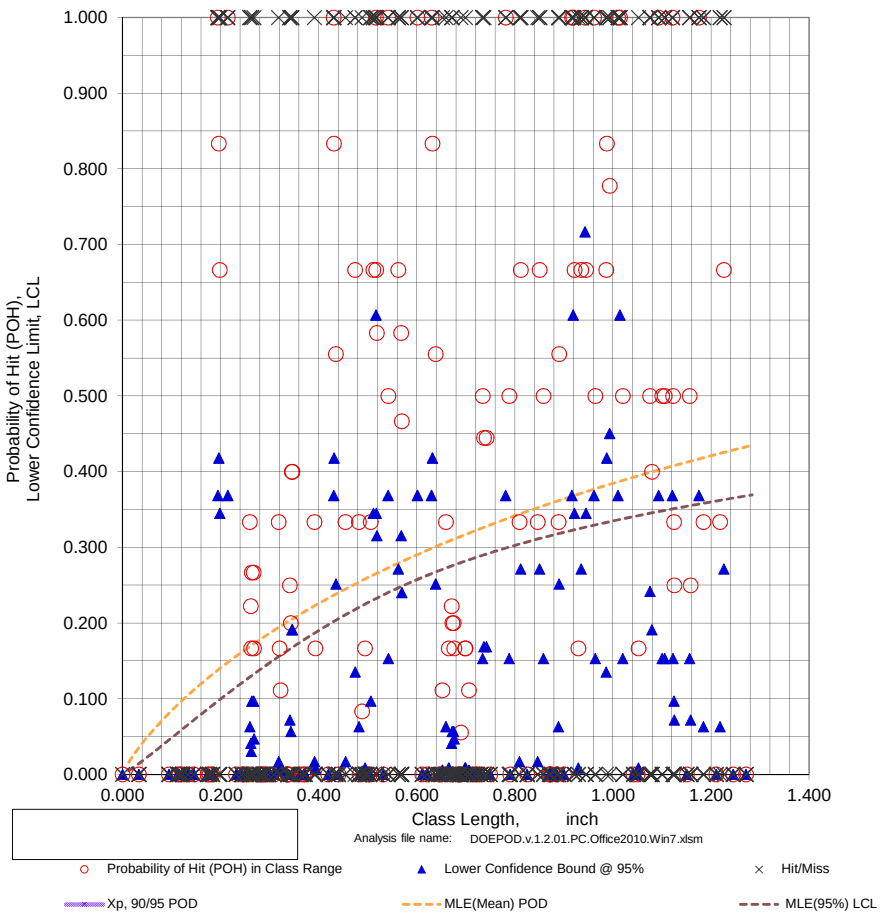
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = AA002(3)L.xls
Data Set Name = AA002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:37 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0080 | inch |
| Classlength @ Best LCL = | 0.9430 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AA002(3)L.xls
Data Set Name = AA002(3)L(CK. NO.)

## Directed DOE Options

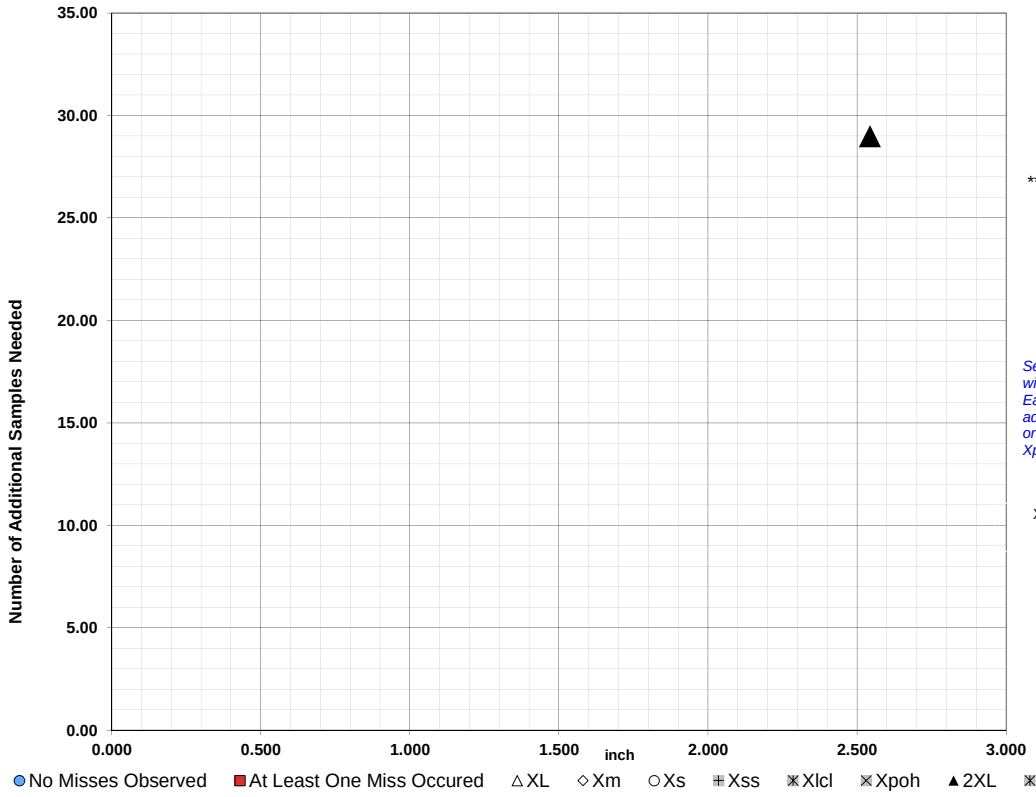



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

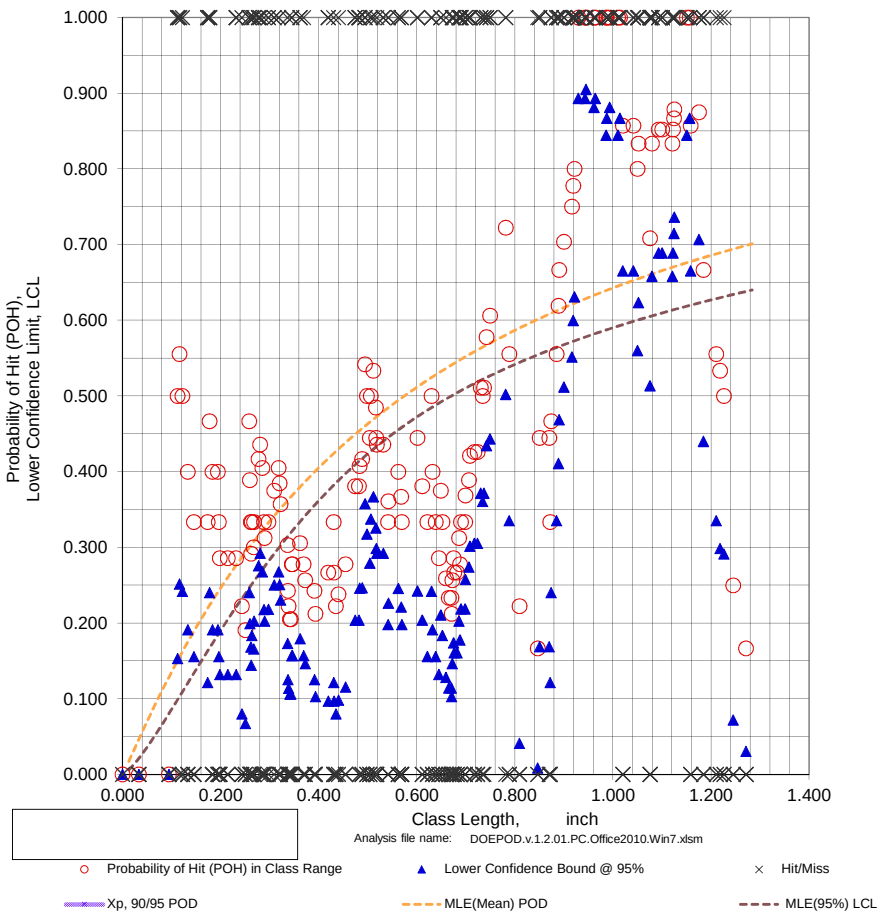
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 2.835.**

**Warning: No false call analysis.**




File Name = **AA003(3)L.xls**

Data Set Name = **AA003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:40 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0560 | inch |
| Classlength @ 90/95 Xpod = | 0.9450 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.271 | inch |
| Samples Needed @ XL = | 155 | |
| Classlength Mid-point , Xm = | 1.156 | inch |
| Samples Needed @ Xm = | 8 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AA003(3)L.xls
Data Set Name = AA003(3)L(CK. NO.)

## Directed DOE Options

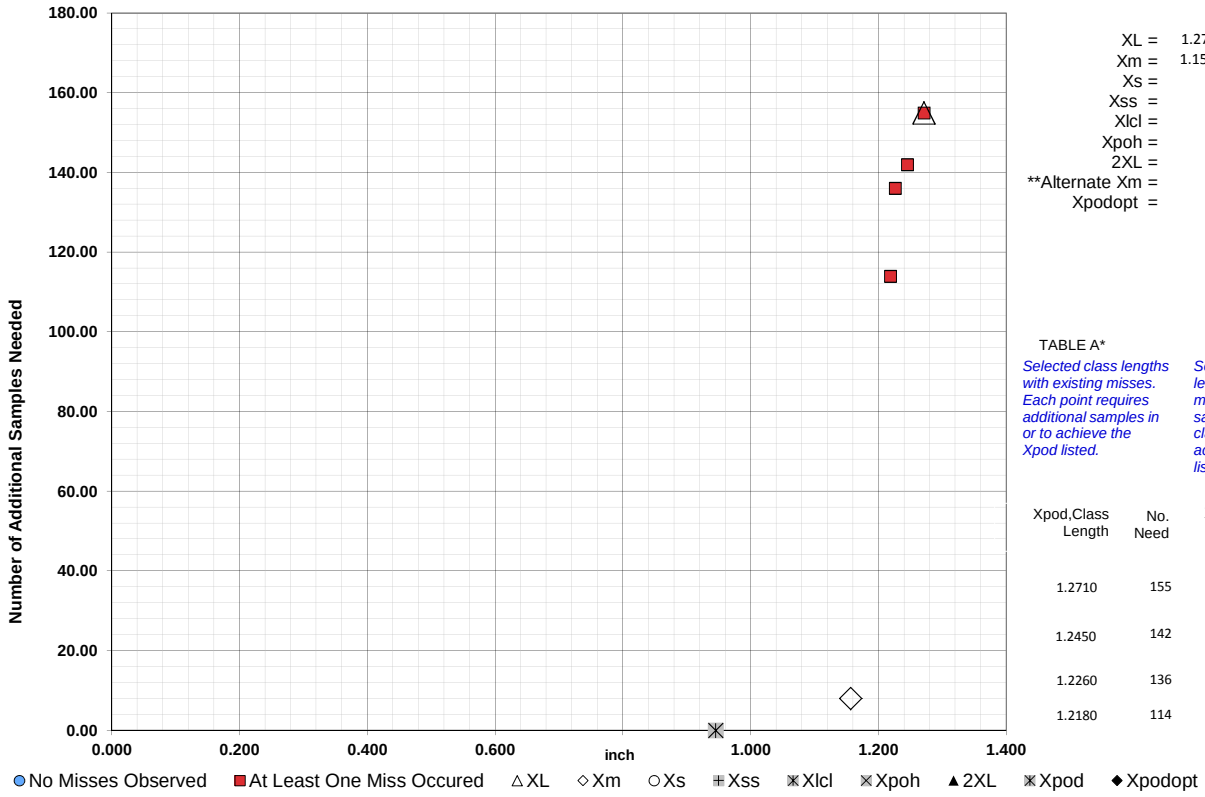



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.271 | 155 |
| Xm = | 1.156 | 8 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2710 | 155 |
| 1.2450 | 142 |
| 1.2260 | 136 |
| 1.2180 | 114 |

TABLE B*

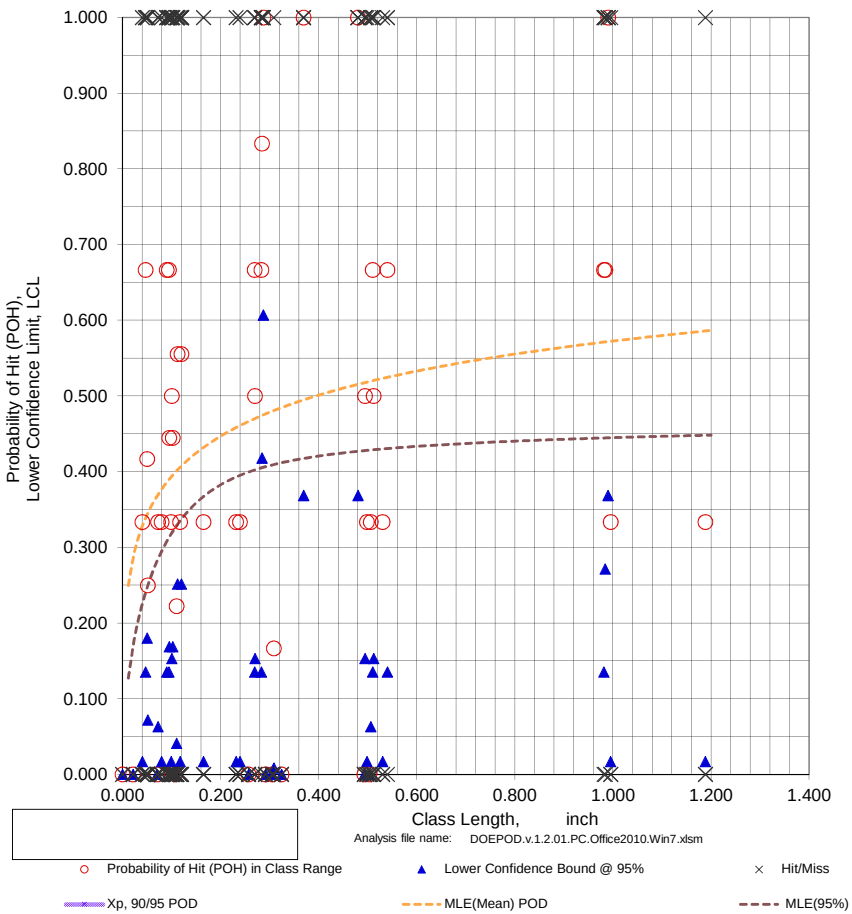
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




| | | |
|---|---|---|
| File Name = | AB001(3)L.xls | |
| Data Set Name = | AB001(3)L(CK. NO.) | |
| Date & Time = | 6/4/15 7:43 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.2870 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

| | | | |
|---|---|---|---|
| Survey/Optimum Xpoh = | 0.000 | inch | Samples |
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | | | inch |
| Samples Needed @ XL = | | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | | | inch |
| Samples Needed @ Xpoh = | | | |
| New Largest Classlength , 2XL = | 2.376 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = AB001(3)L.xls
Data Set Name = AB001(3)L(CK. NO.)

## Directed DOE Options

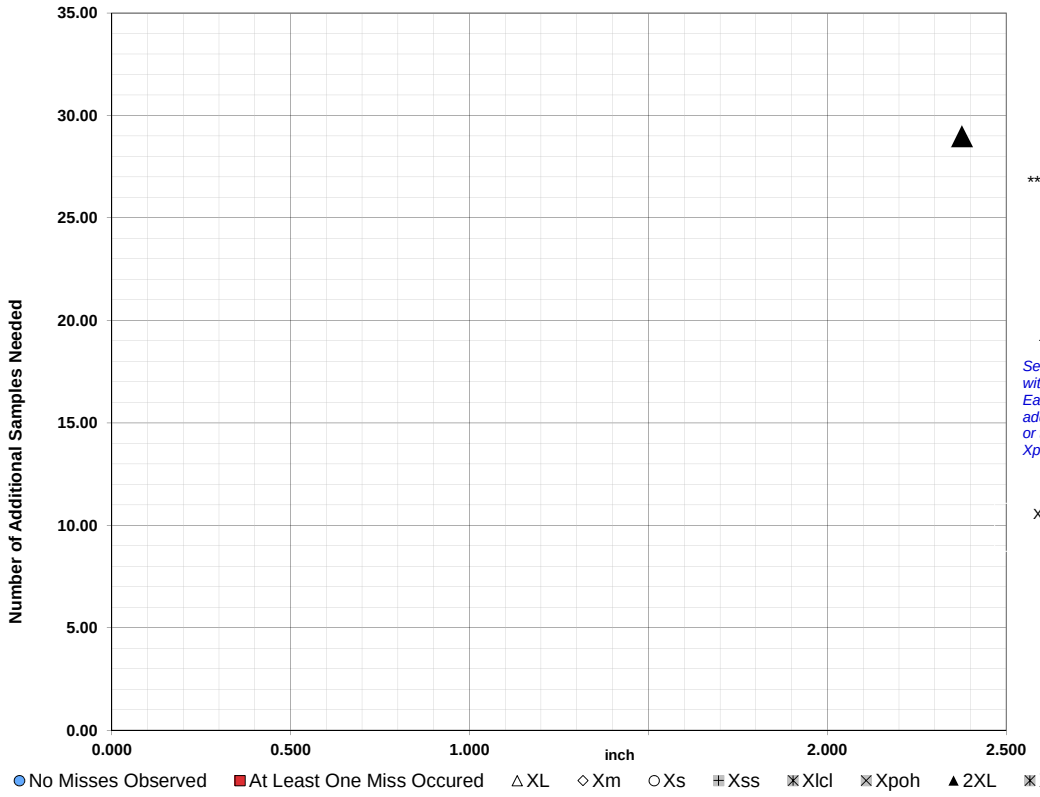



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

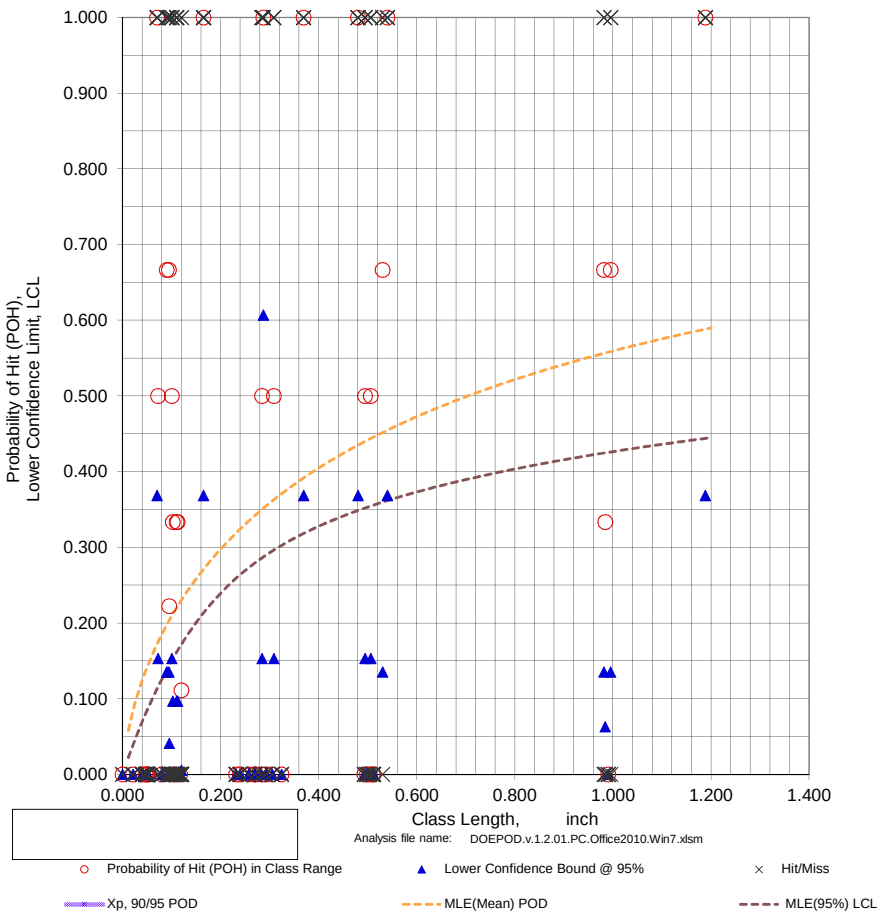
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = AB002(3)L.xls
Data Set Name = AB002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:44 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.2870 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.1880 -0.100 inch 26 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.188 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.188 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.376 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AB002(3)L.xls
Data Set Name = AB002(3)L(CK. NO.)

## Directed DOE Options

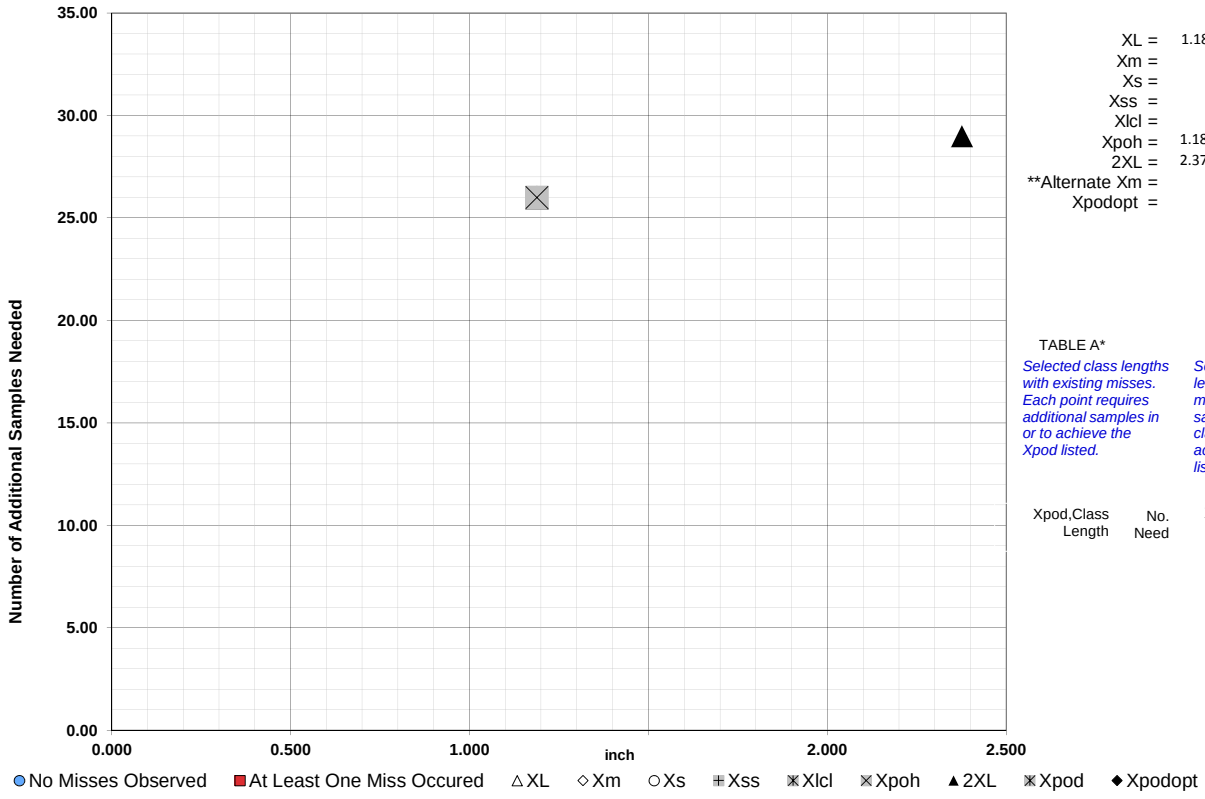



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.188 | 26 |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

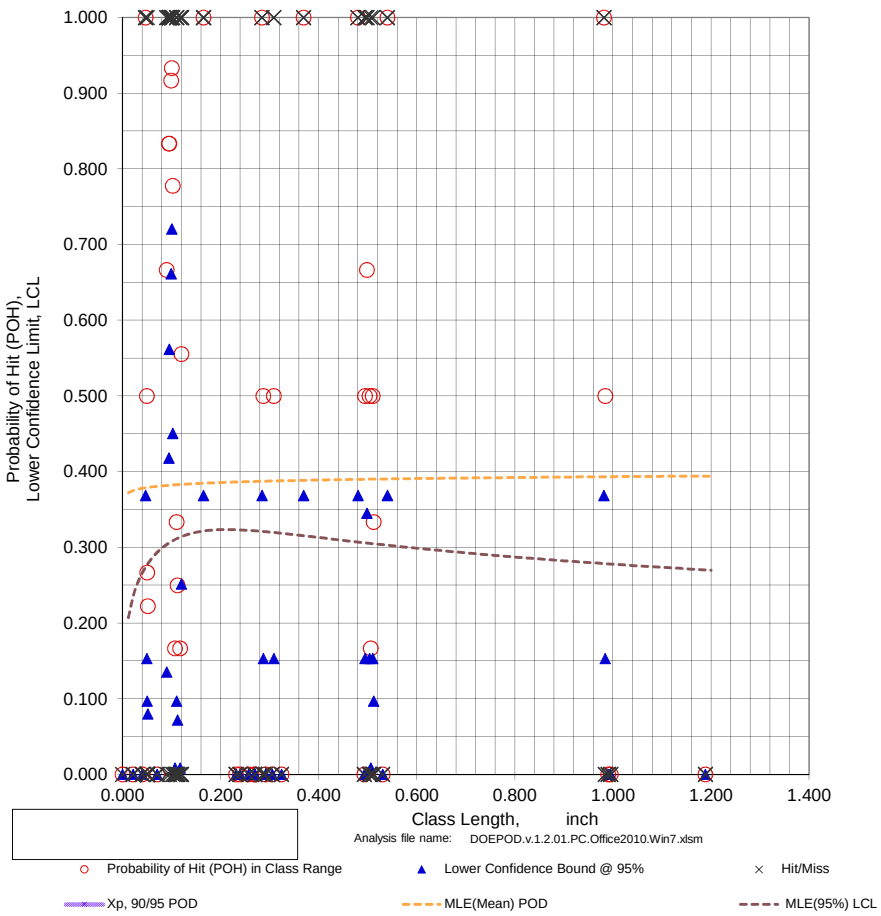
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = AB003(3)L.xls
Data Set Name = AB003(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:46 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7206 | |
| Classwidth @ Best LCL = | 0.0060 | inch |
| Classlength @ Best LCL = | 0.1000 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.376 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AB003(3)L.xls
Data Set Name = AB003(3)L(CK. NO.)

## Directed DOE Options

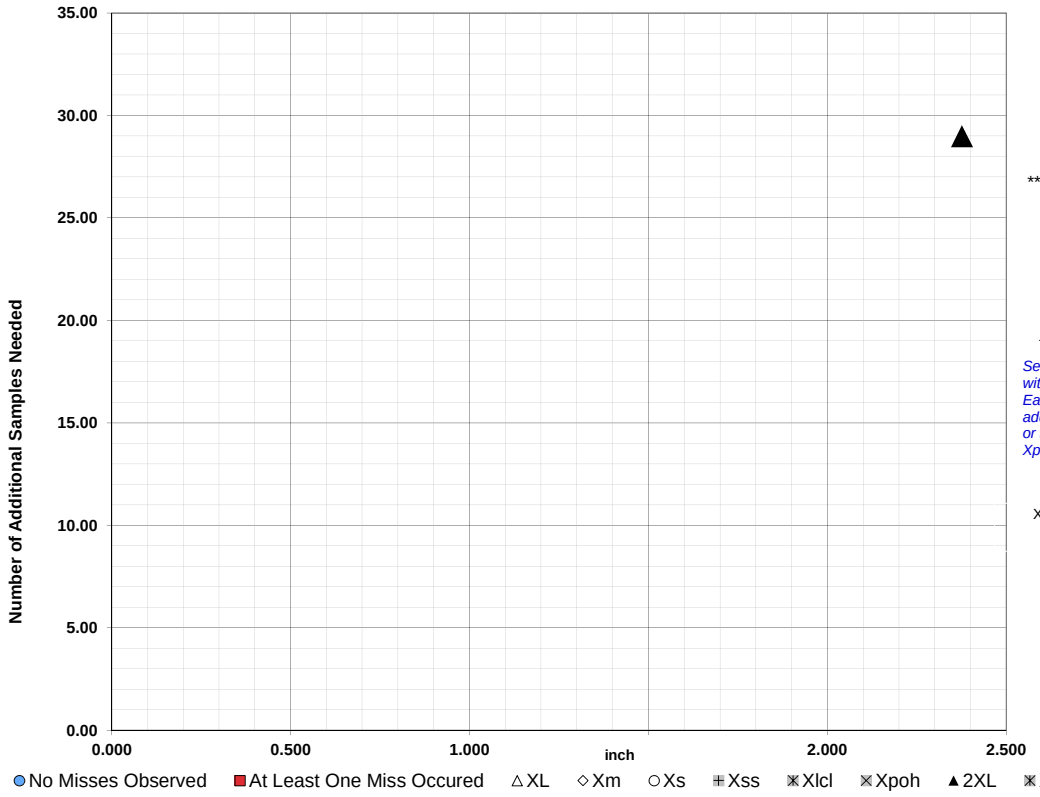



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

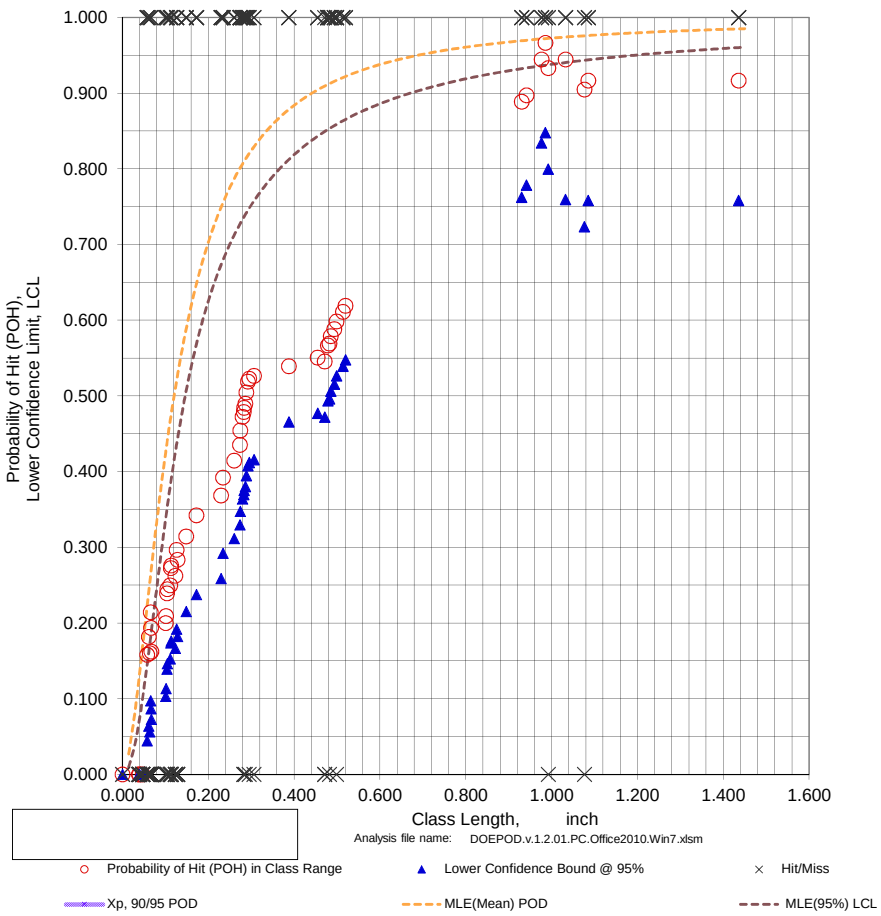
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = AC001(3)L.xls
Data Set Name = AC001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:48 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8477 | |
| Classwidth @ Best LCL = | 0.5000 | inch |
| Classlength @ Best LCL = | 0.9850 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 1.0850 -0.008 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.445 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.670 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AC001(3)L.xls
Data Set Name = AC001(3)L(CK. NO.)

## Directed DOE Options

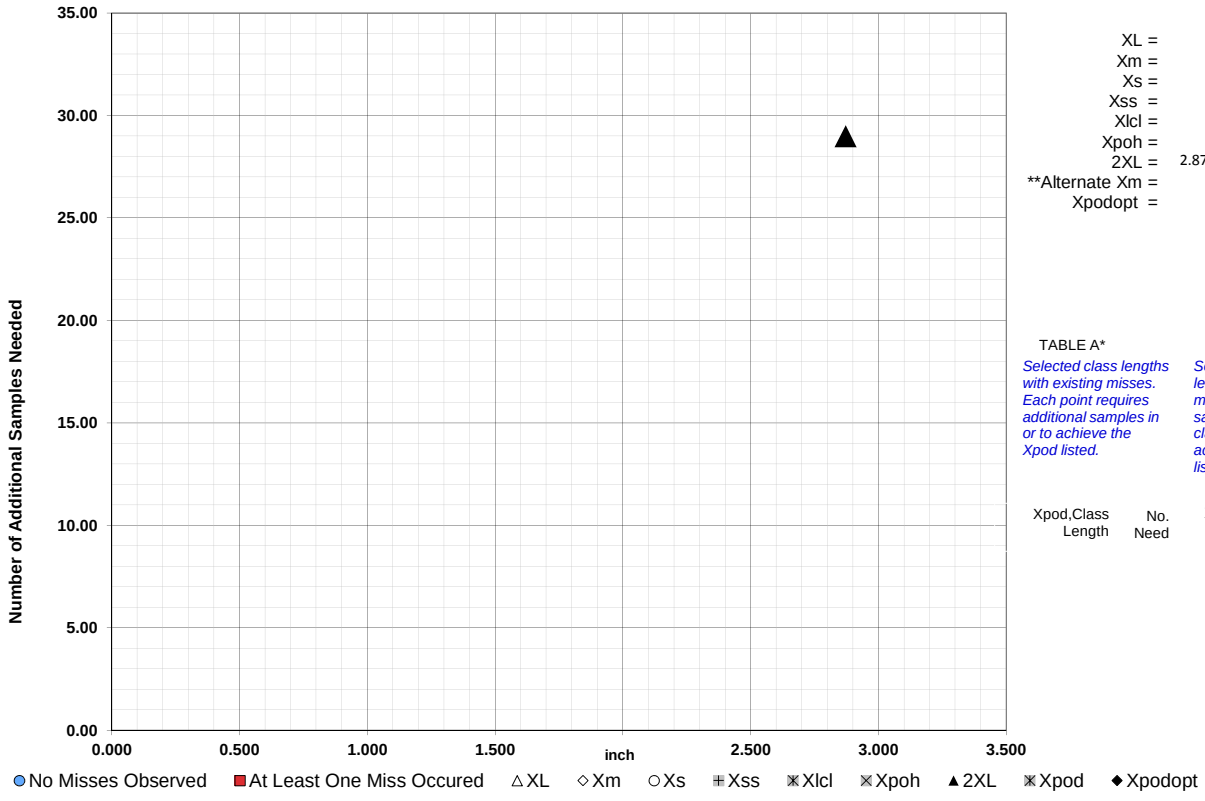



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

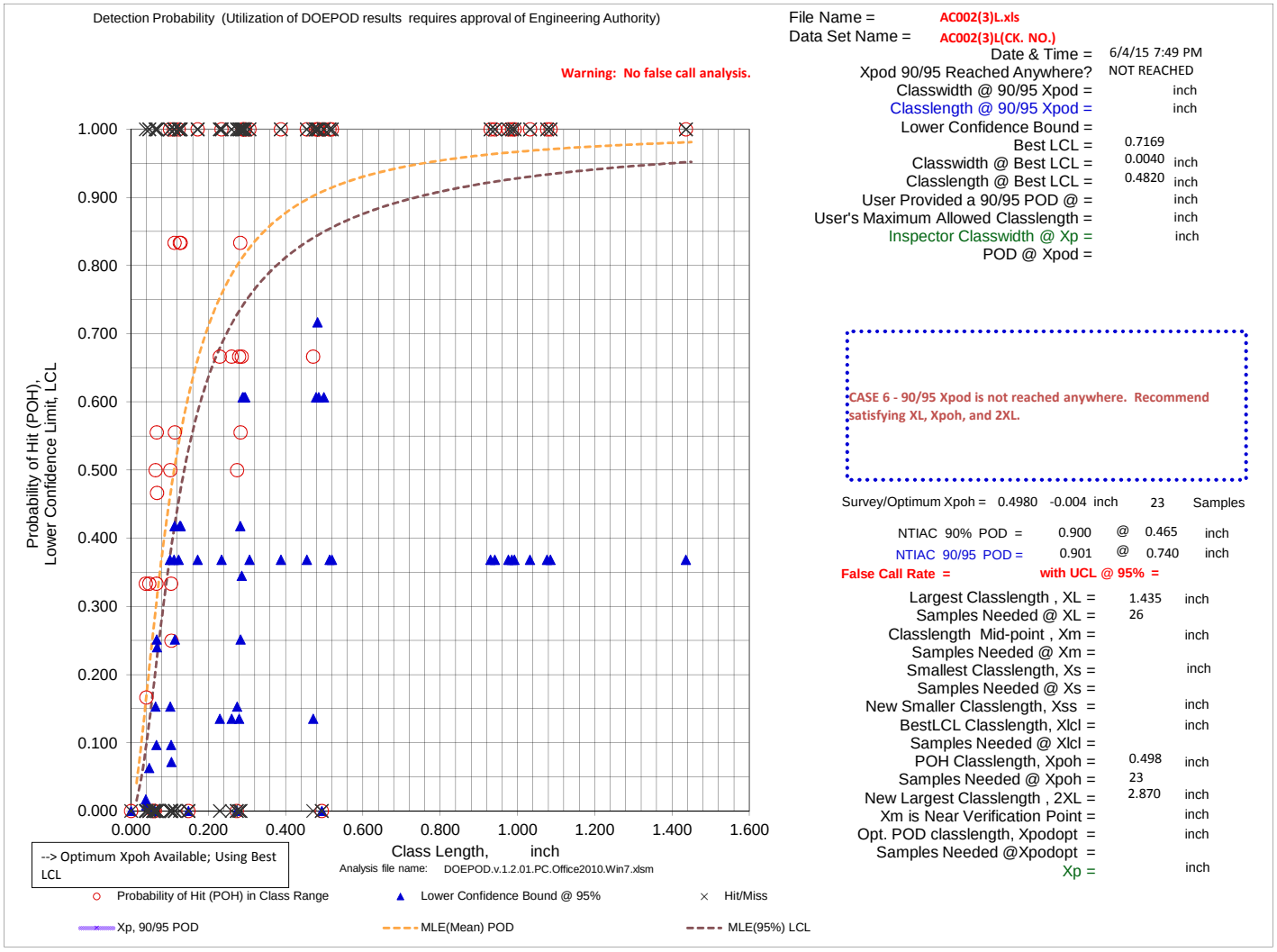
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = AC002(3)L.xls
Data Set Name = AC002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:49 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.4820 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.4980 -0.004 inch 23 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.465 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.740 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.498 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AC002(3)L.xls
Data Set Name = AC002(3)L(CK. NO.)

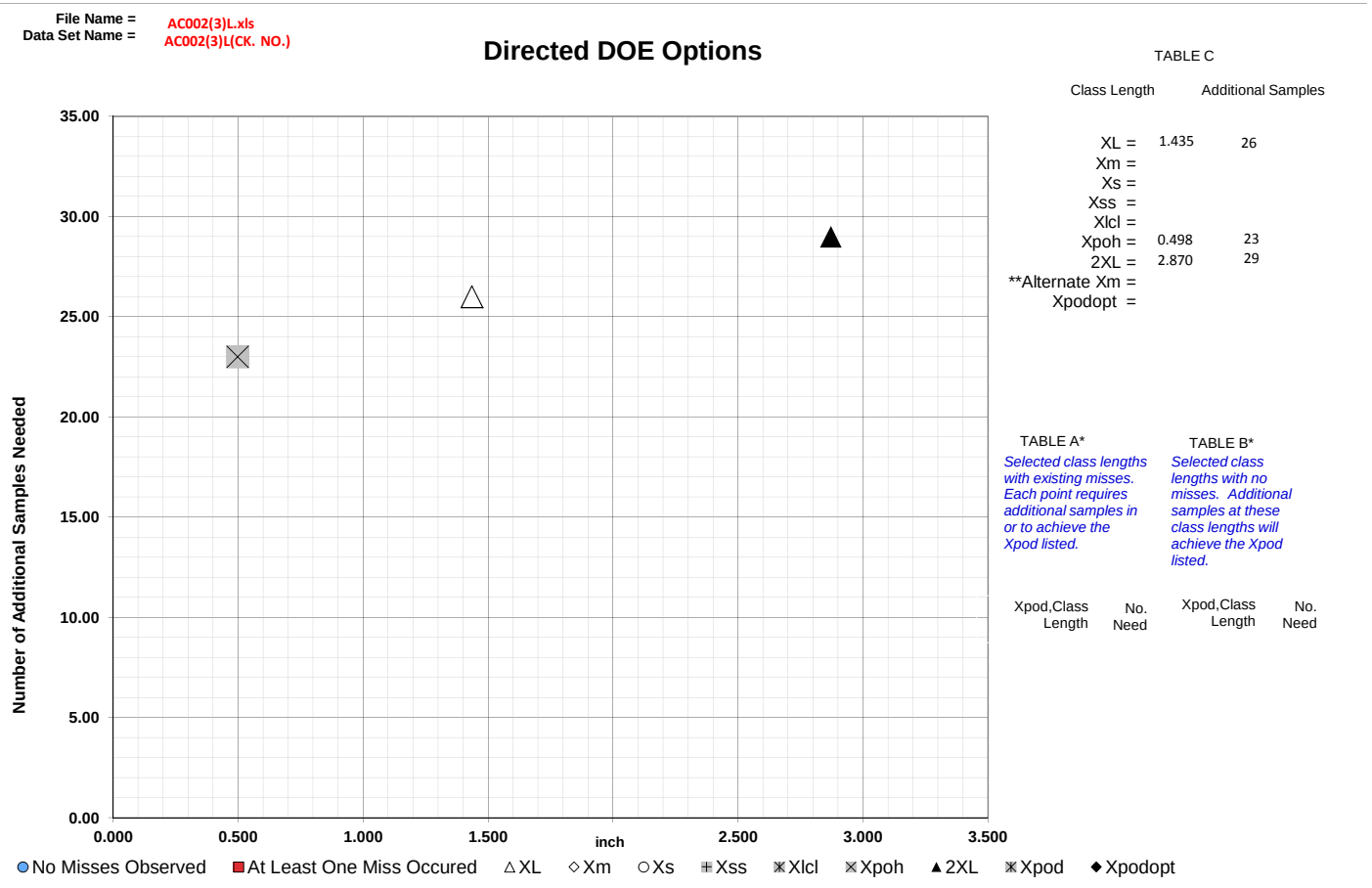



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.498 | 23 |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

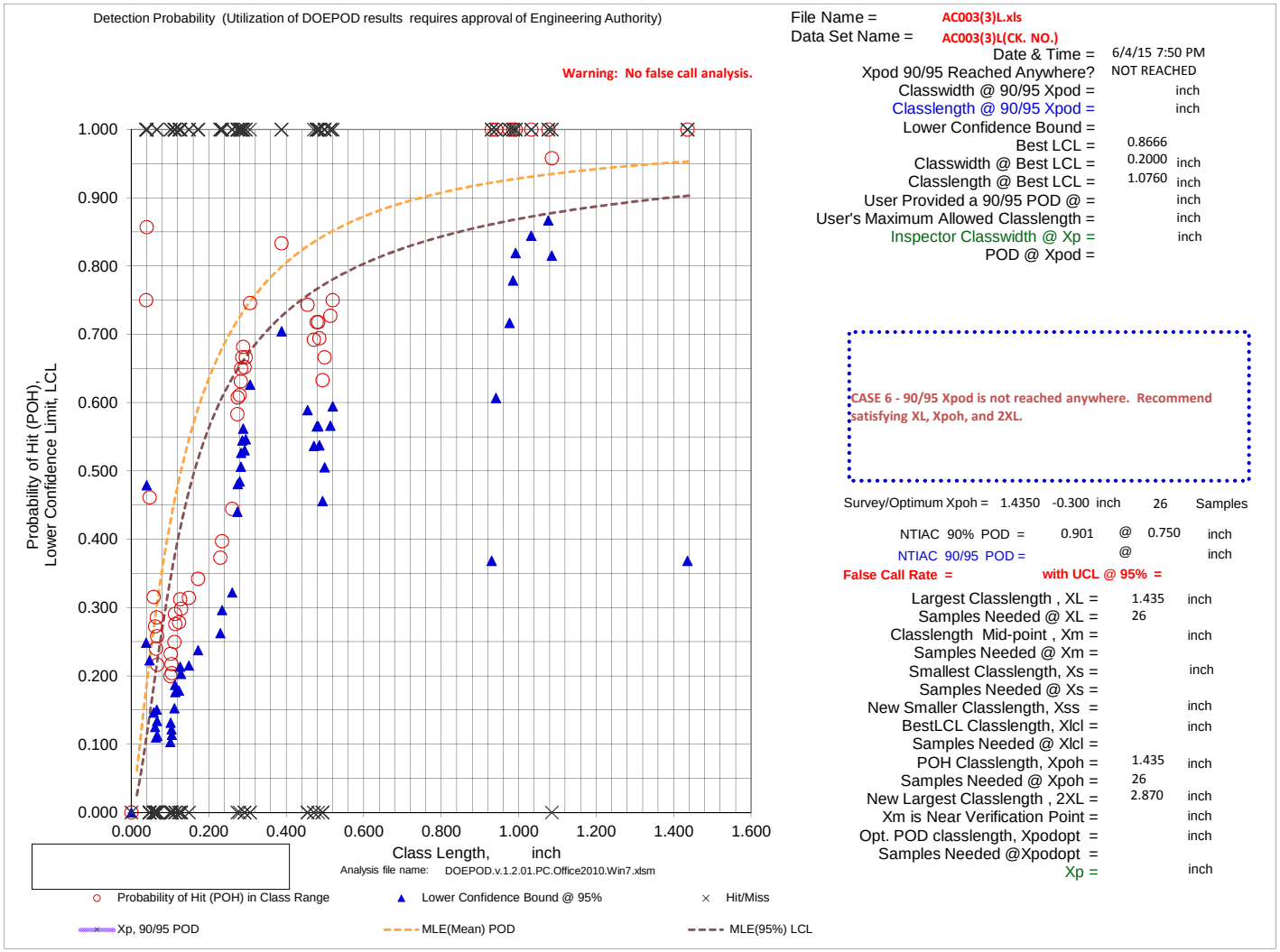
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = AC003(3)L.xls
Data Set Name = AC003(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:50 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 1.0760 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.4350 -0.300 inch 26 Samples

NTIAC 90% POD = 0.901 @ 0.750 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.435 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = AC003(3)L.xls
Data Set Name = AC003(3)L(CK. NO.)

## Directed DOE Options

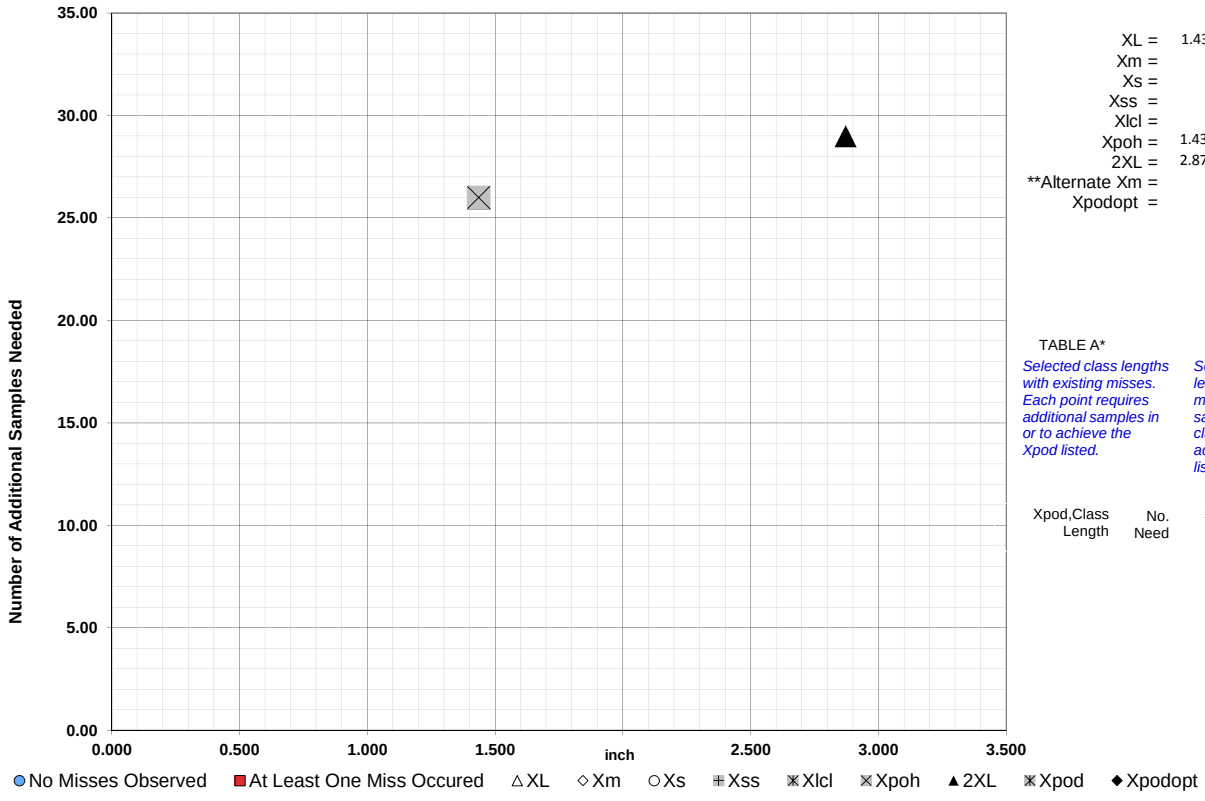



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.435 | 26 |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **AD001(3)L.xls**

Data Set Name = **AD001(3)L(CK. NO.)**

Date & Time = 6/4/15 7:52 PM

Xpod 90/95 Reached Anywhere? REACHED

Classwidth @ 90/95 Xpod = 0.0290 inch

Classlength @ 90/95 Xpod = 0.3480 inch

Lower Confidence Bound = 0.9050

Best LCL =

Classwidth @ Best LCL = inch

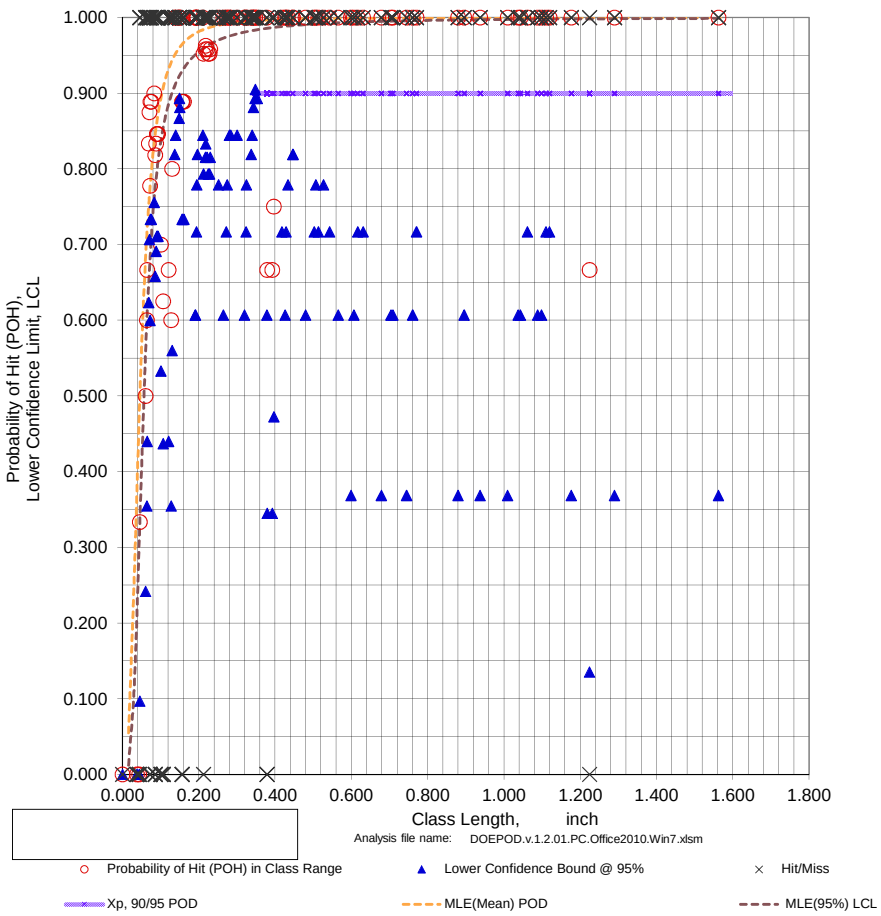
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.911 @ 0.105 inch

NTIAC 90/95 POD = 0.905 @ 0.130 inch

**False Call Rate = with UCL @ 95% =**

Largest Classlength , XL = 1.562 inch

Samples Needed @ XL =

Classlength Mid-point , Xm = 1.119 inch

Samples Needed @ Xm =

Smallest Classlength, Xs = inch

Samples Needed @ Xs =

New Smaller Classlength, Xss = inch

BestLCL Classlength, Xlcl = inch

Samples Needed @ Xlcl =

POH Classlength, Xpoh = inch

Samples Needed @ Xpoh =

New Largest Classlength , 2XL = inch

Xm is Near Verification Point = inch

Opt. POD classlength, Xpodopt = inch

Samples Needed @Xpodopt =

Xp = 0.3480 inch

File Name = AD001(3)L.xls
Data Set Name = AD001(3)L(CK. NO.)

## Directed DOE Options

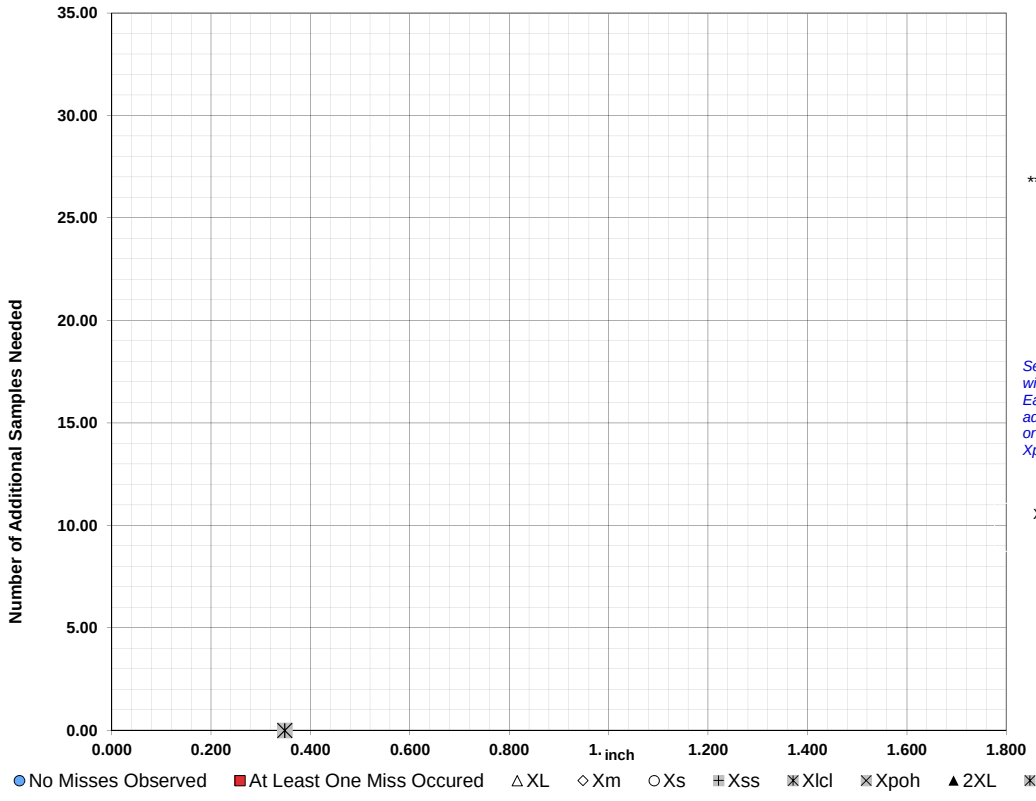



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | |
| Xm = | 1.119 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

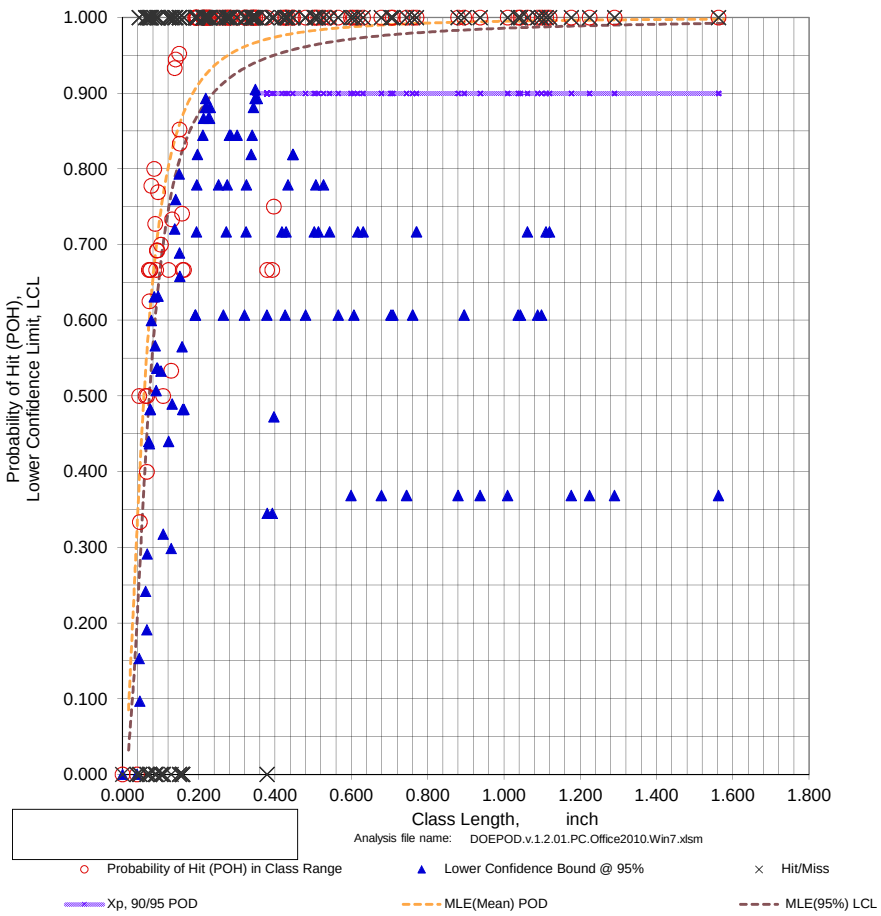
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **AD002(3)L.xls**

Data Set Name = **AD002(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 7:58 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0290 | inch |
| Classlength @ 90/95 Xpod = | 0.3480 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.240 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3480 | inch |

File Name = AD002(3)L.xls
Data Set Name = AD002(3)L(CK. NO.)

## Directed DOE Options

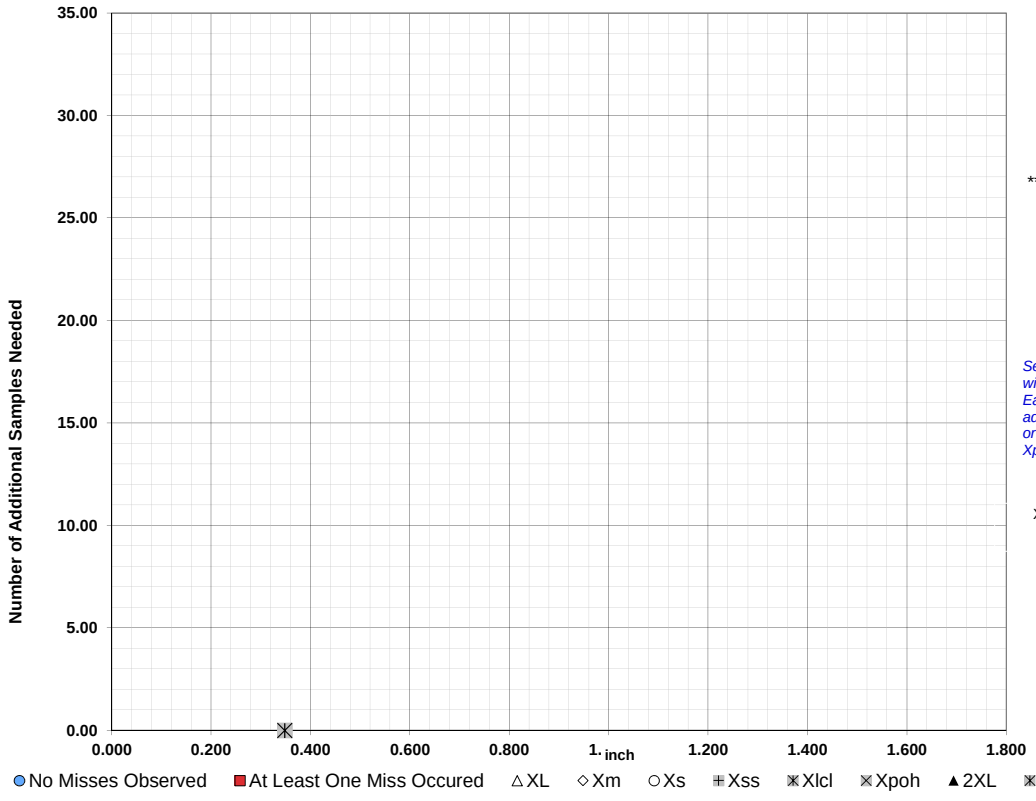



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | |
| Xm = | 1.119 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

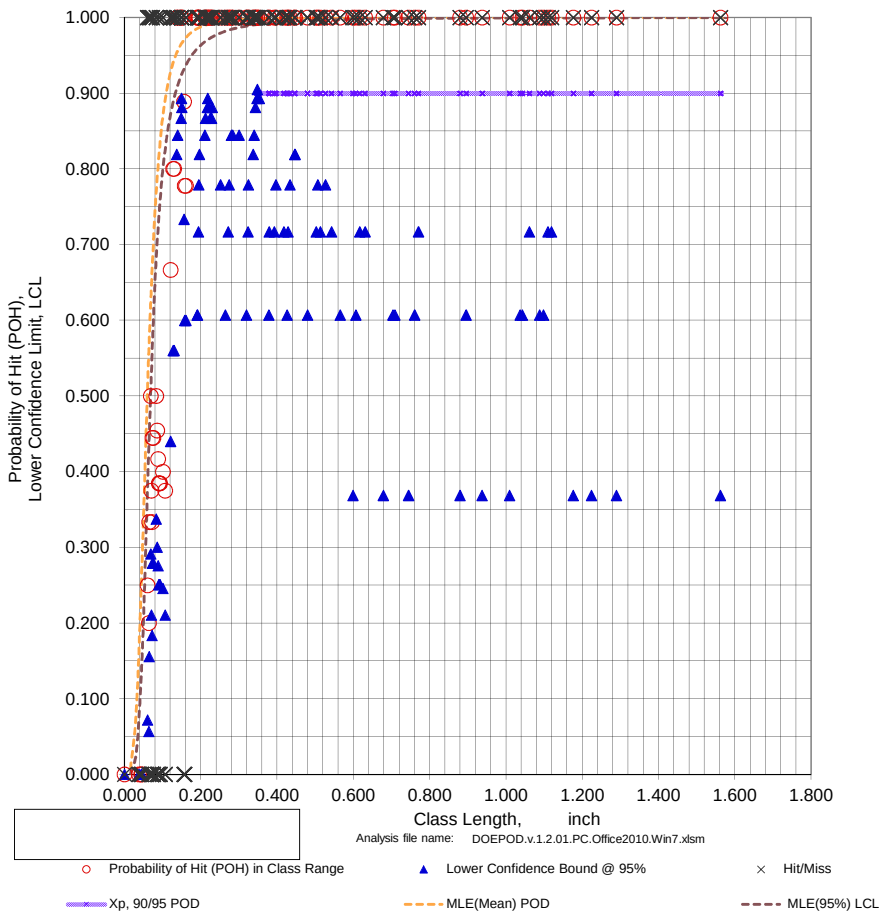
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **AD003(3)L.xls**

Data Set Name = **AD003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:06 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0290 | inch |
| Classlength @ 90/95 Xpod = | 0.3480 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1610 -0.003 inch 26 Samples

NTIAC 90% POD = 0.903 @ 0.110 inch

NTIAC 90/95 POD = 0.903 @ 0.135 inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.190 | inch |
| Samples Needed @Xpodopt = | 23 | |
| Xp = | 0.3480 | inch |

File Name = AD003(3)L.xls
Data Set Name = AD003(3)L(CK. NO.)

## Directed DOE Options

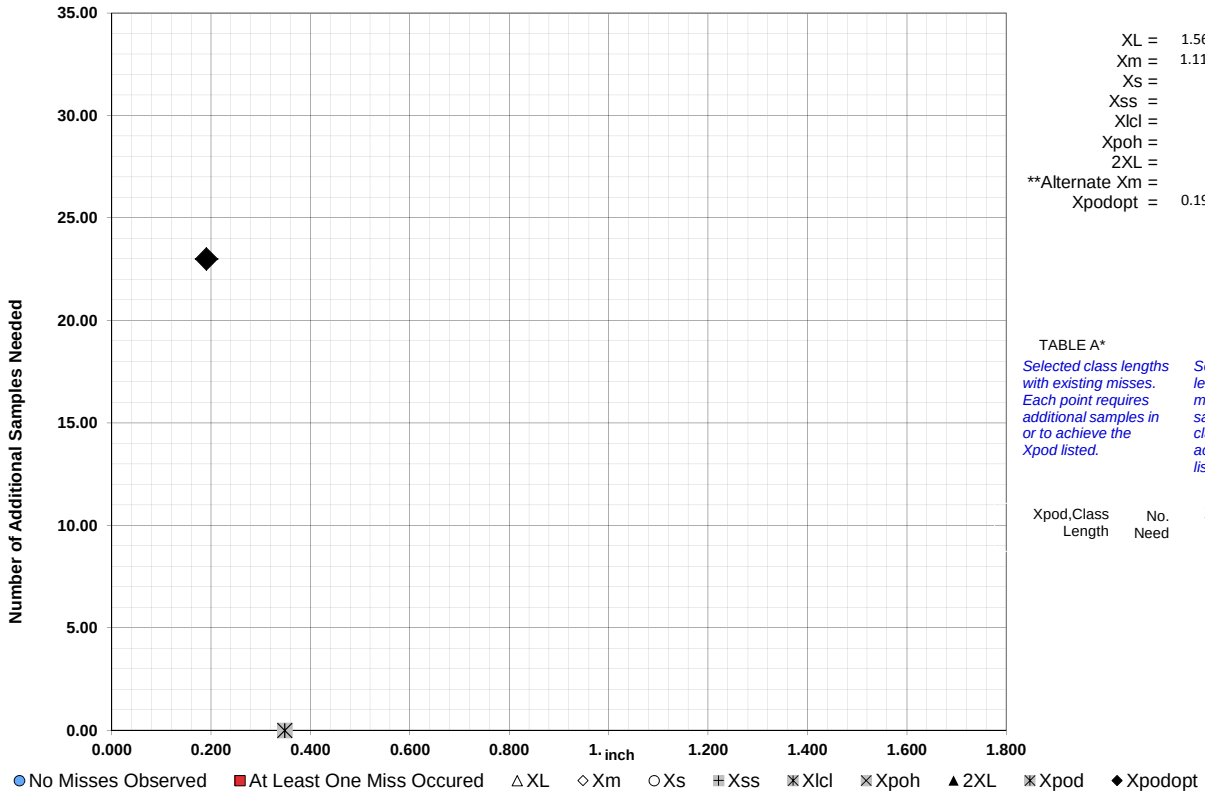



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | |
| Xm = | 1.119 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.190 | 23 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

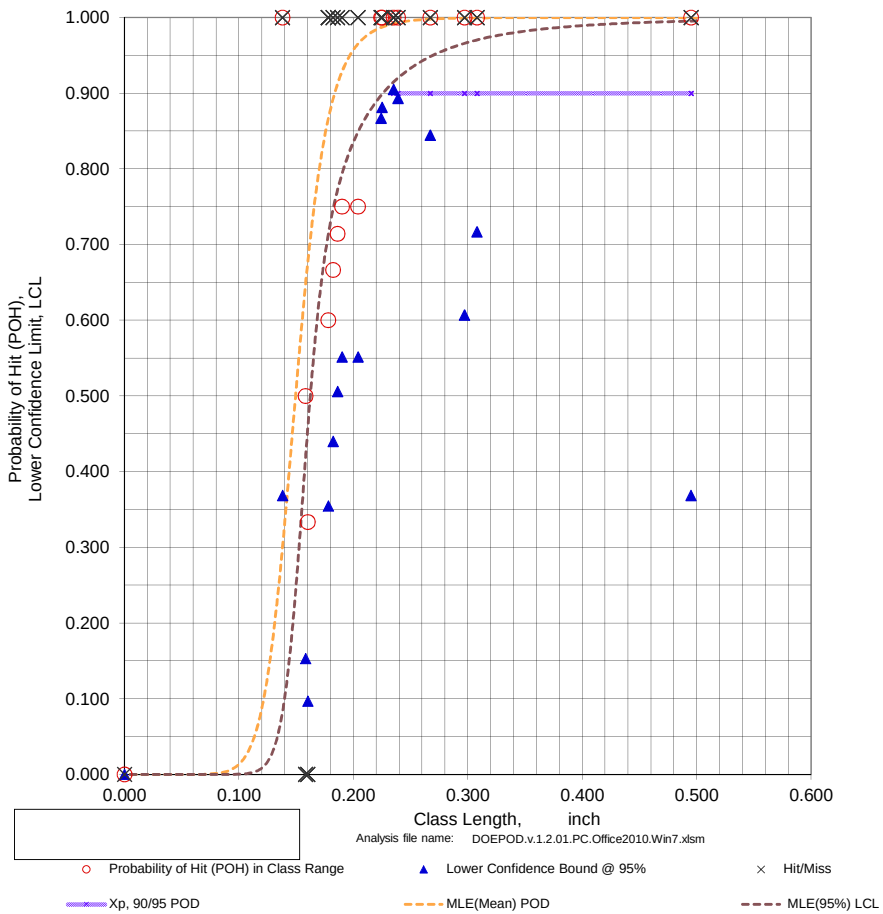
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.705.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **AE001(3)L.xls**

Data Set Name = **AE001(3)L(CK. NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:10 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0570 | inch |
| Classlength @ 90/95 Xpod = | 0.2350 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1780 -0.017 inch 23 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.230 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.308 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.224 | inch |
| Samples Needed @Xpodopt = | 8 | |
| Xp = | 0.2350 | inch |

File Name = AE001(3)L.xls
Data Set Name = AE001(3)L(CK. NO. )

## Directed DOE Options

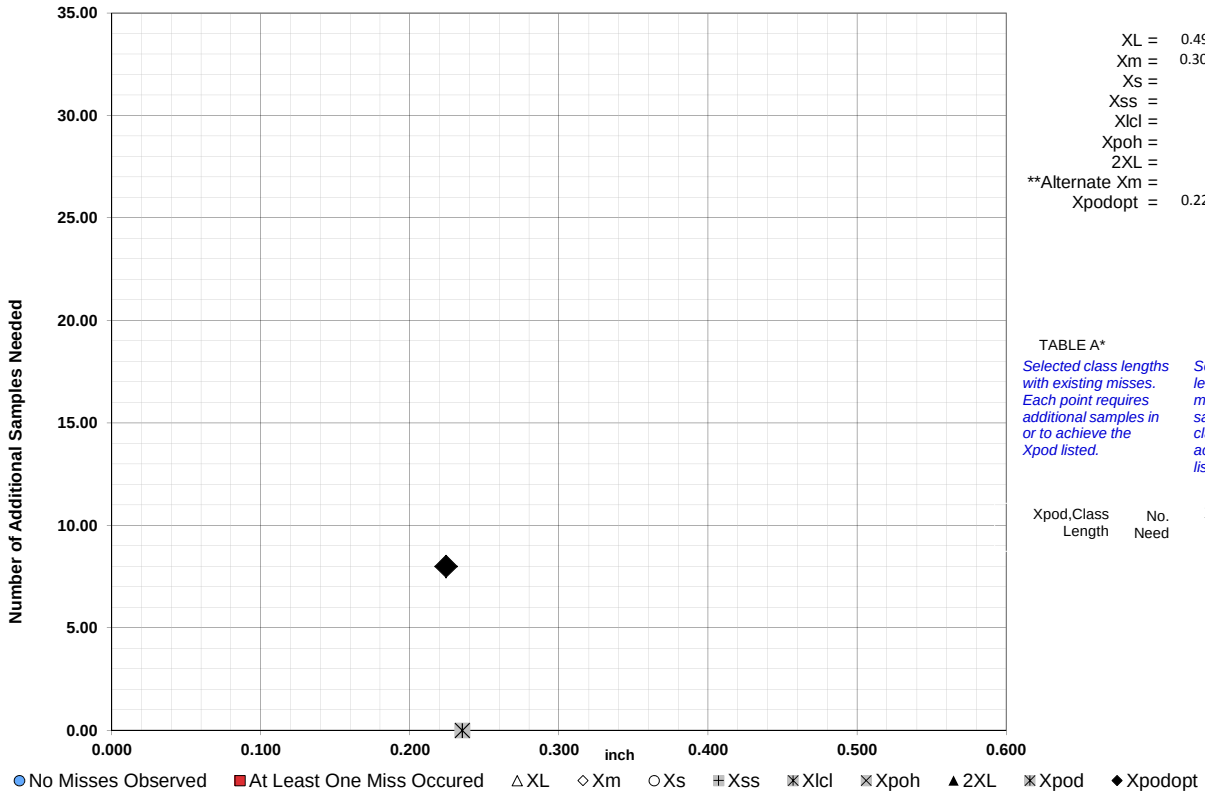



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | |
| Xm = | 0.308 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.224 | 8 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

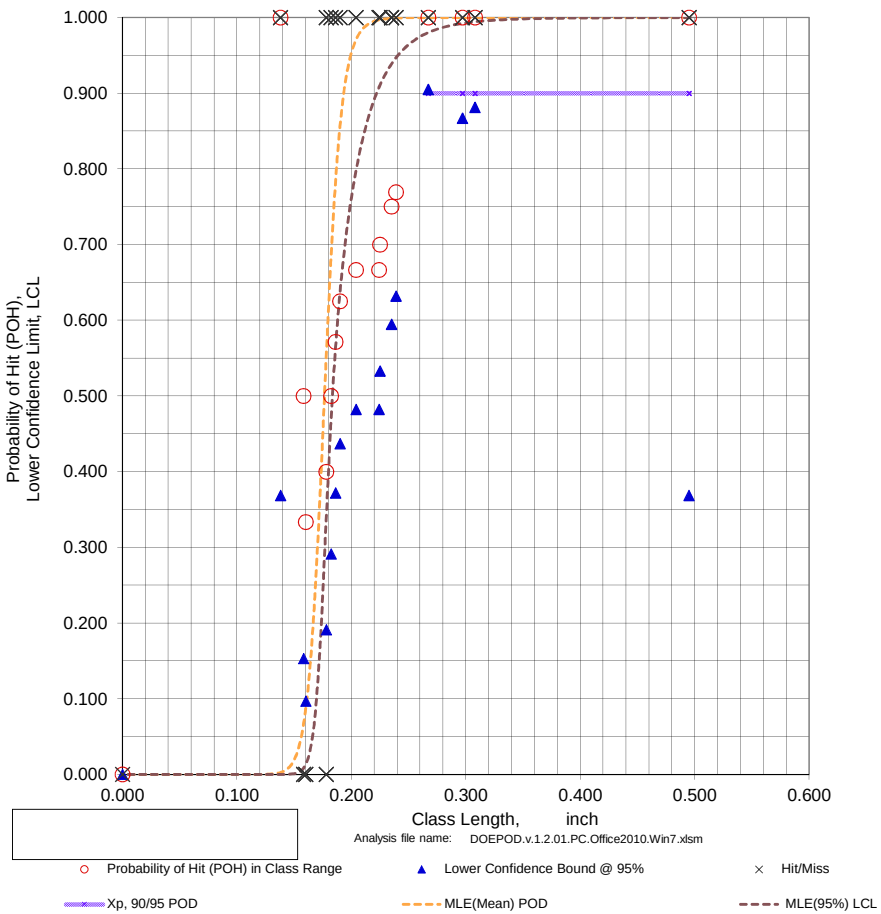
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.801.**

**Note: Xpodopt is within one class width of Xpod.**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**




File Name = **AE002(3)L.xls**

Data Set Name = **AE002(3)L(CK. NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:11 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0850 | inch |
| Classlength @ 90/95 Xpod = | 0.2670 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL when Xm is satisfied. Xp used to satisfy XL requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1820 -0.003 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.943 | @ | 0.200 | inch |
| NTIAC 90/95 POD = | 0.912 | @ | 0.230 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.381 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.253 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.2670 | inch |

File Name = AE002(3)L.xls
Data Set Name = AE002(3)L(CK. NO. )

## Directed DOE Options

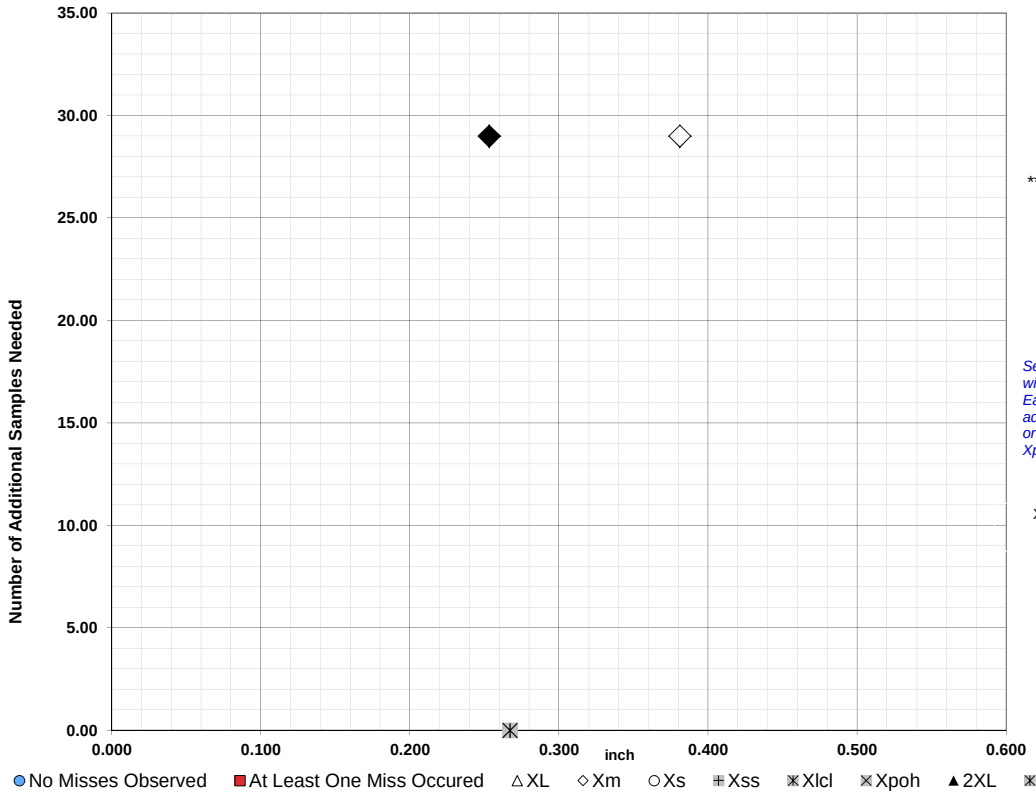



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | |
| Xm = | 0.381 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.253 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.705.**

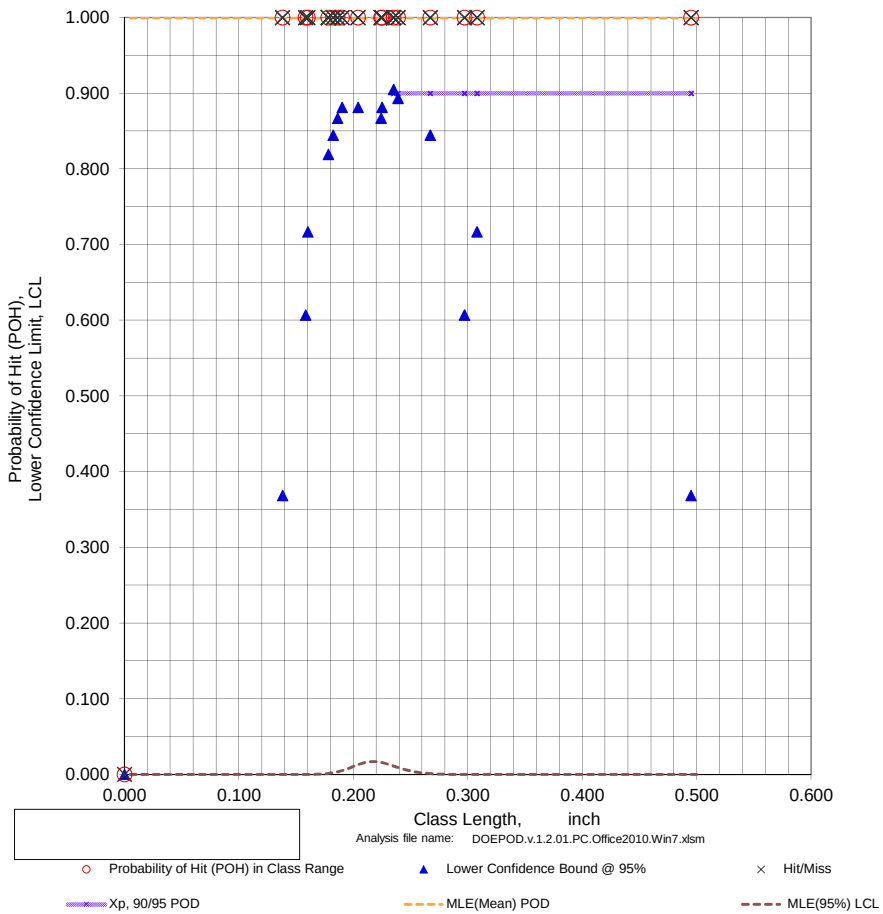
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **AE003(3)L.xls**

Data Set Name = **AE003(3)L(CK. NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:11 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0570 | inch |
| Classlength @ 90/95 Xpod = | 0.2350 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1380 -0.057 inch 26 Samples

NTIAC 90% POD = 1.000 @ 0.005 inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.308 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.138 | inch |
| Samples Needed @Xpodopt = | 26 | |
| Xp = | 0.2350 | inch |

File Name = AE003(3)L.xls
Data Set Name = AE003(3)L(CK. NO. )

## Directed DOE Options

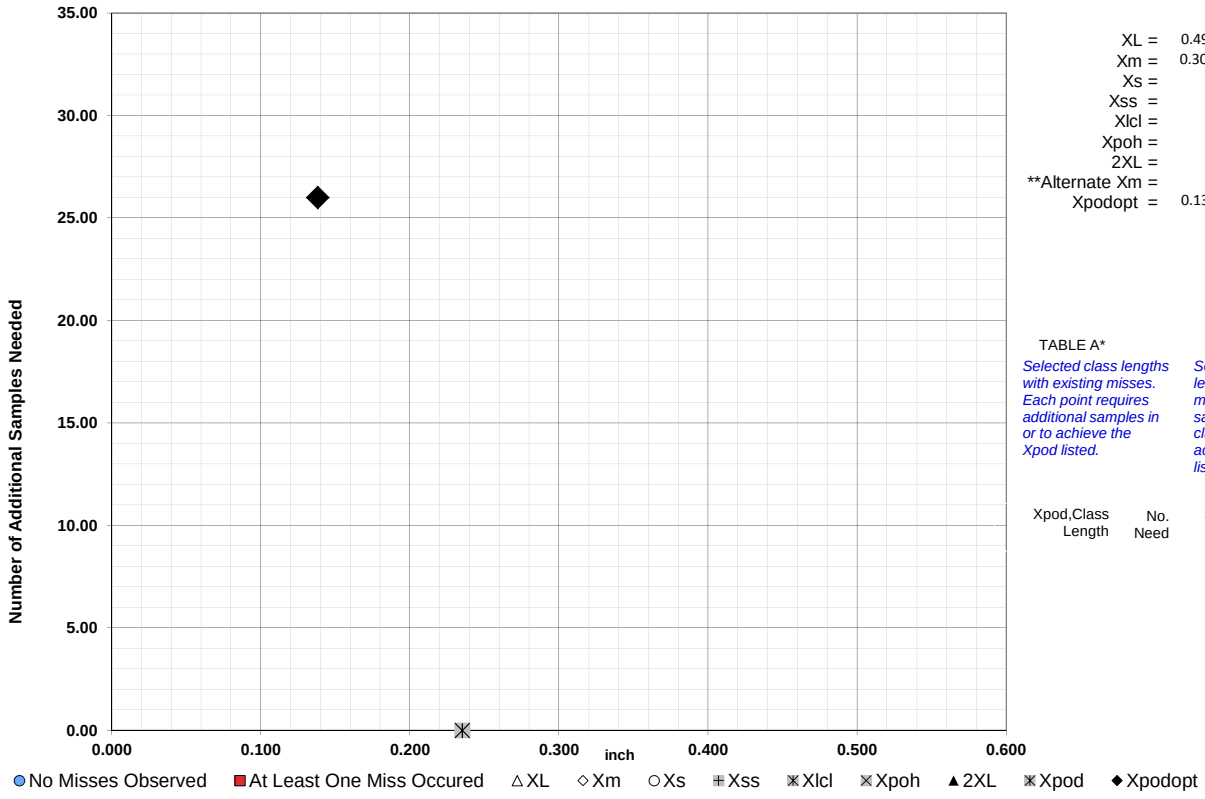



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | |
| Xm = | 0.308 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.138 | 26 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

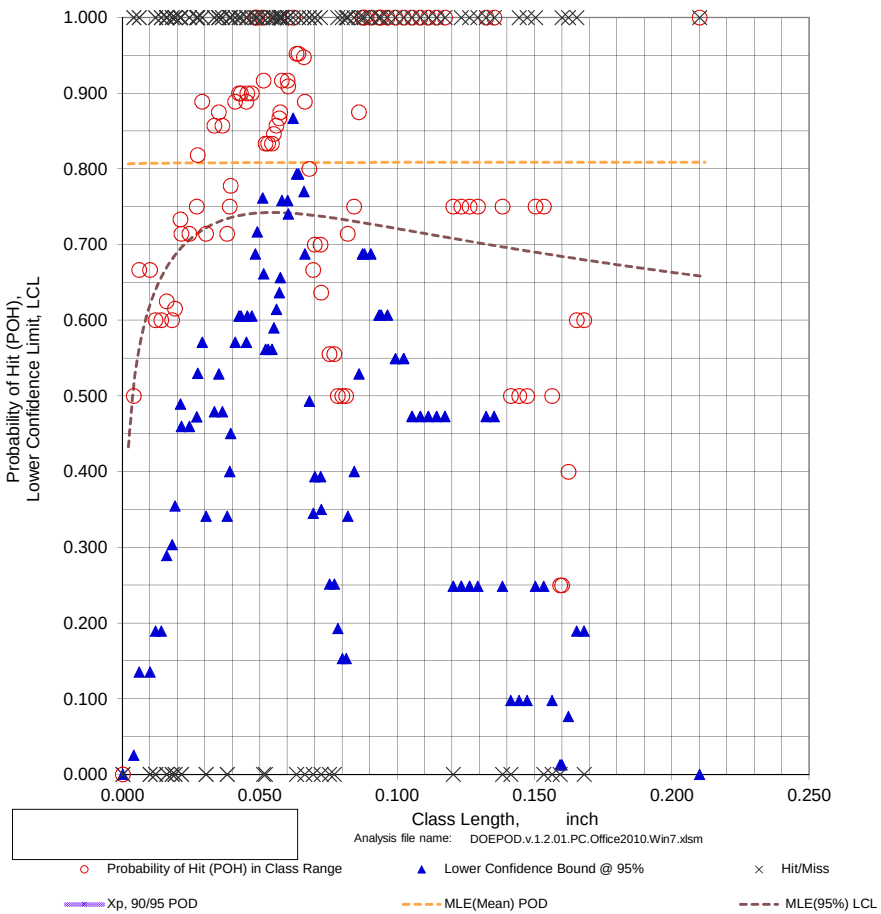
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1001AD.XLS
Data Set Name = B1001AD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:12 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0090 | inch |
| Classlength @ Best LCL = | 0.0620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2100 -0.041 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 0.210 | | inch |
| Samples Needed @ XL = | 28 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 0.210 | | inch |
| Samples Needed @ Xpoh = | 28 | | |
| New Largest Classlength , 2XL = | 0.420 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = B1001AD.XLS
Data Set Name = B1001AD(CRK #)

## Directed DOE Options

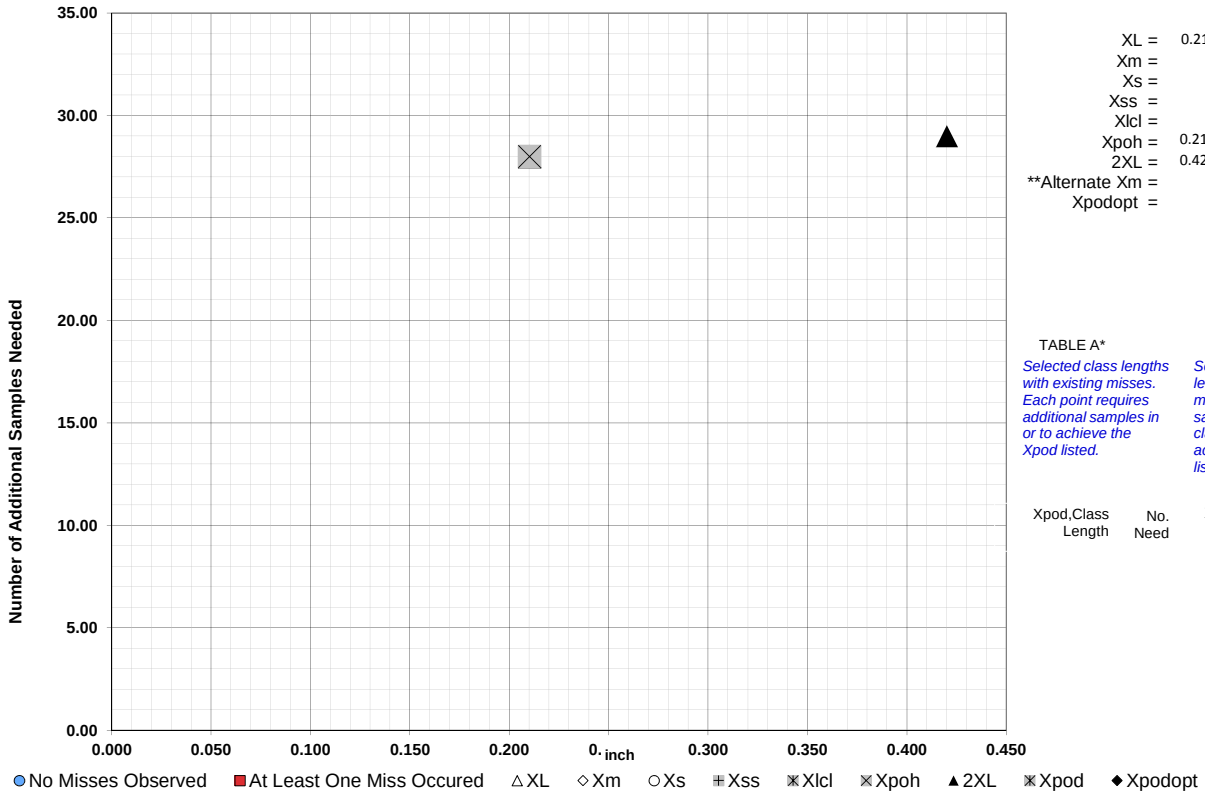



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.210 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.210 | 28 |
| 2XL = | 0.420 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

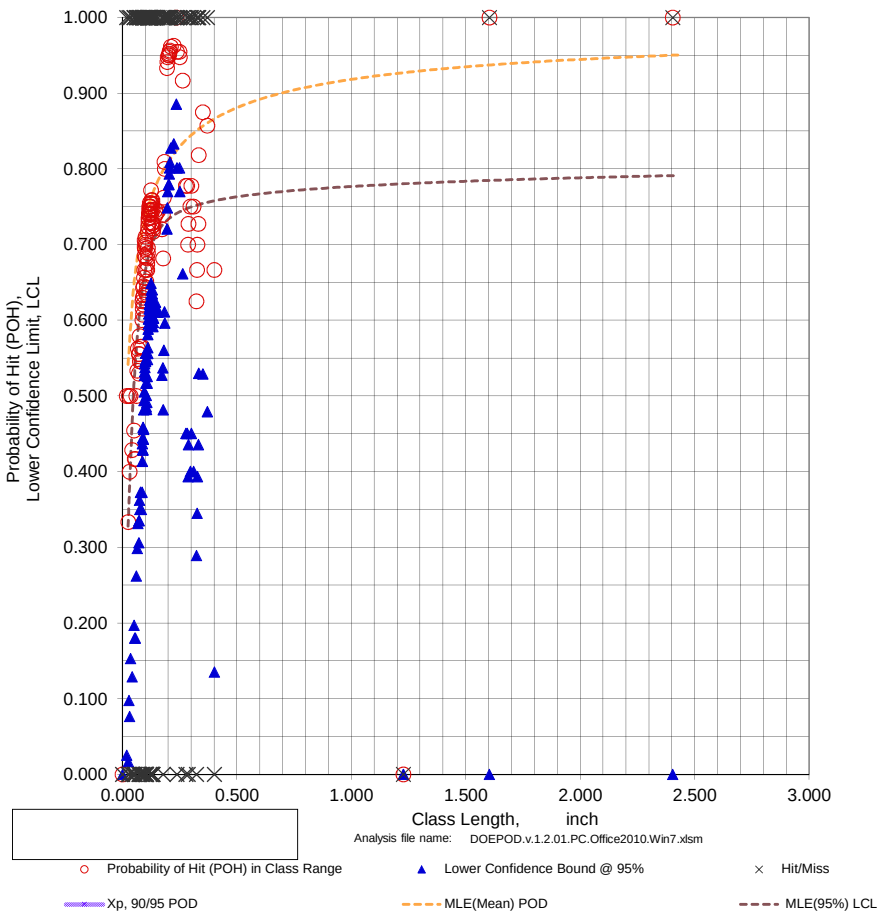
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1001AL.XLS
Data Set Name = B1001AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:14 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0540 | inch |
| Classlength @ Best LCL = | 0.2340 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.695 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1001AL.XLS
Data Set Name = B1001AL(CRK #)

## Directed DOE Options

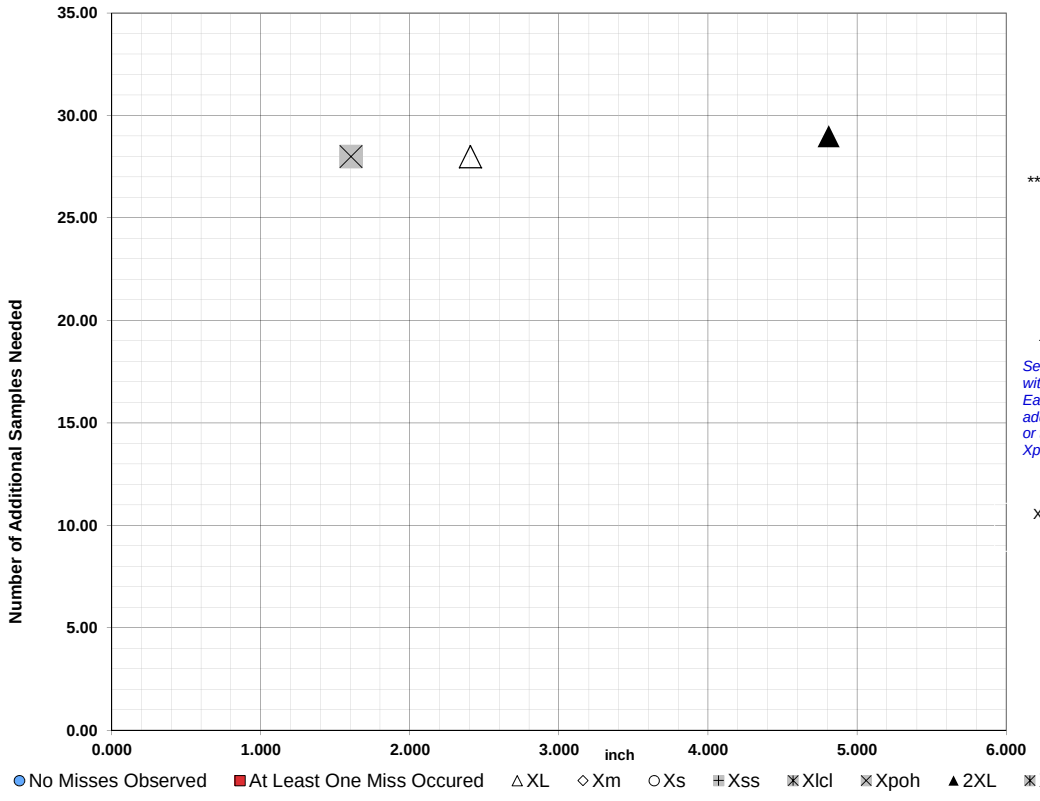



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

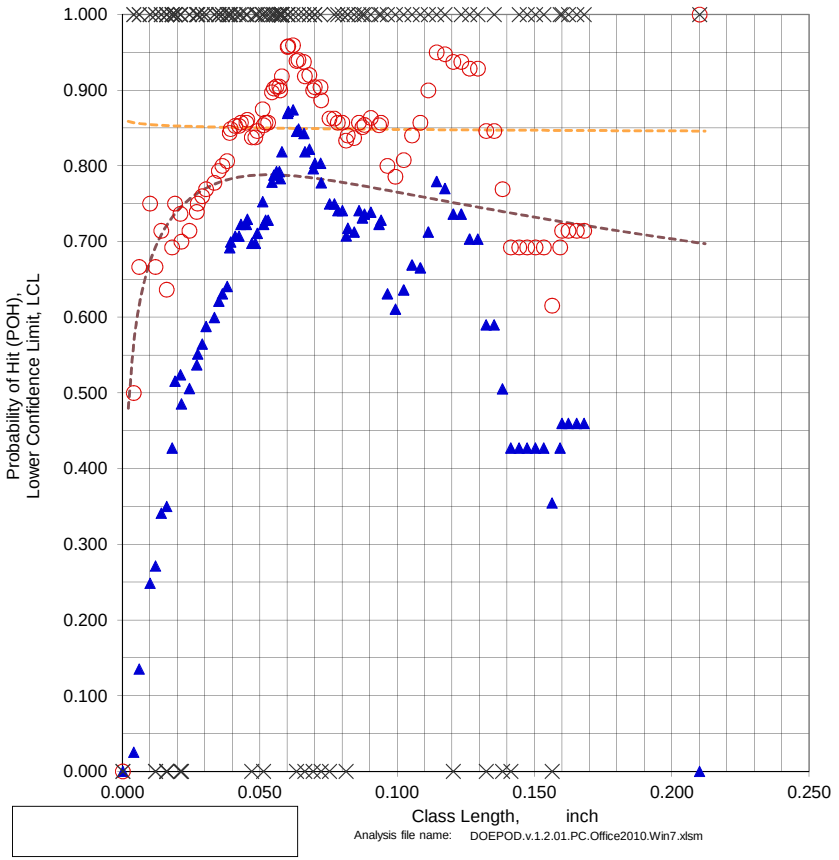
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1001BD.XLS
Data Set Name = B1001BD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:15 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8742 | |
| Classwidth @ Best LCL = | 0.0380 | inch |
| Classlength @ Best LCL = | 0.0620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1593 -0.002 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.210 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.210 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.420 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1001BD.XLS
Data Set Name = B1001BD(CRK #)

## Directed DOE Options

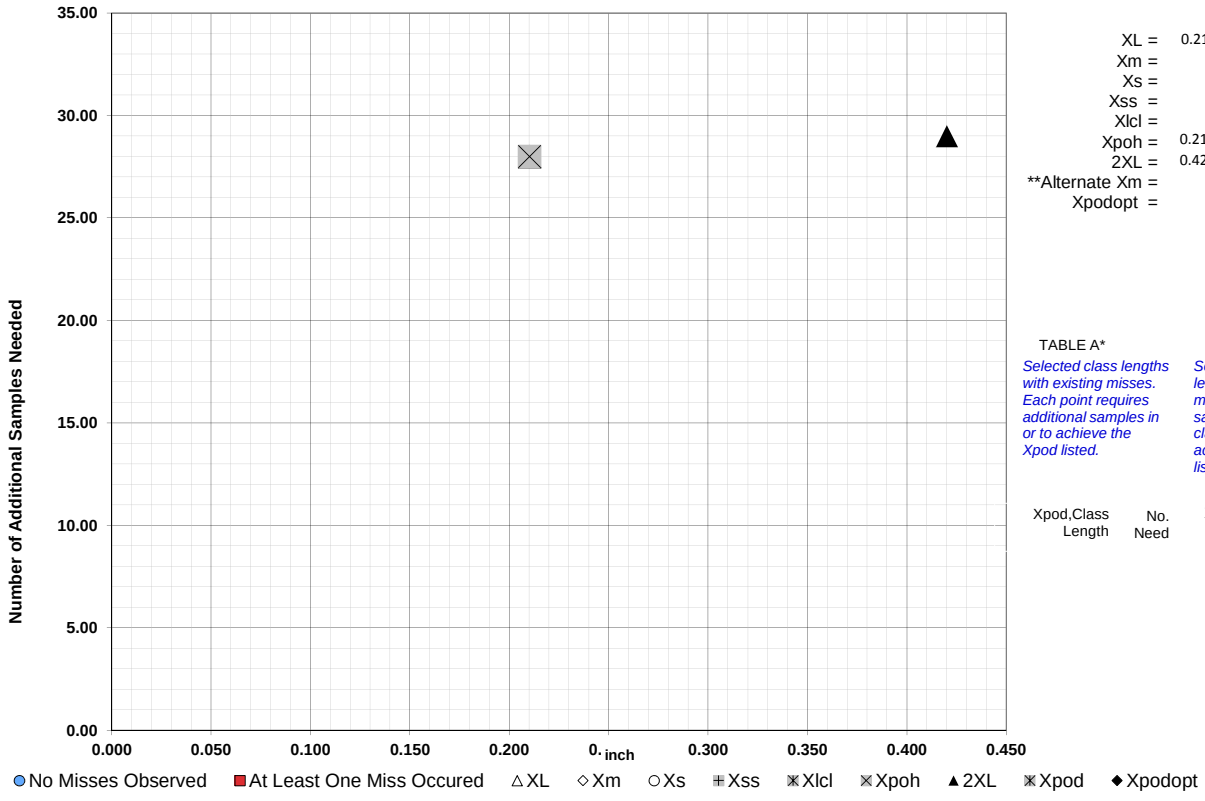



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.210 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.210 | 28 |
| 2XL = | 0.420 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

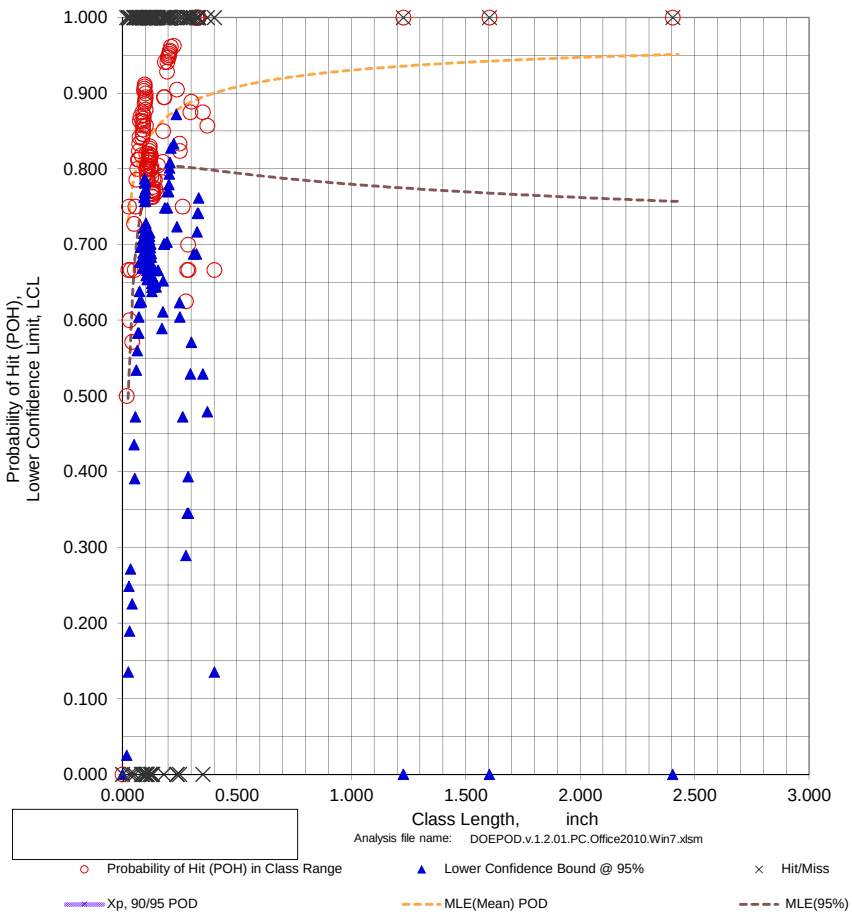
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1001BL.XLS
Data Set Name = B1001BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:17 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8719 | |
| Classwidth @ Best LCL = | 0.0520 | inch |
| Classlength @ Best LCL = | 0.2340 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3700 -0.019 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.400 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.227 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1001BL.XLS
Data Set Name = B1001BL(CRK #)

## Directed DOE Options

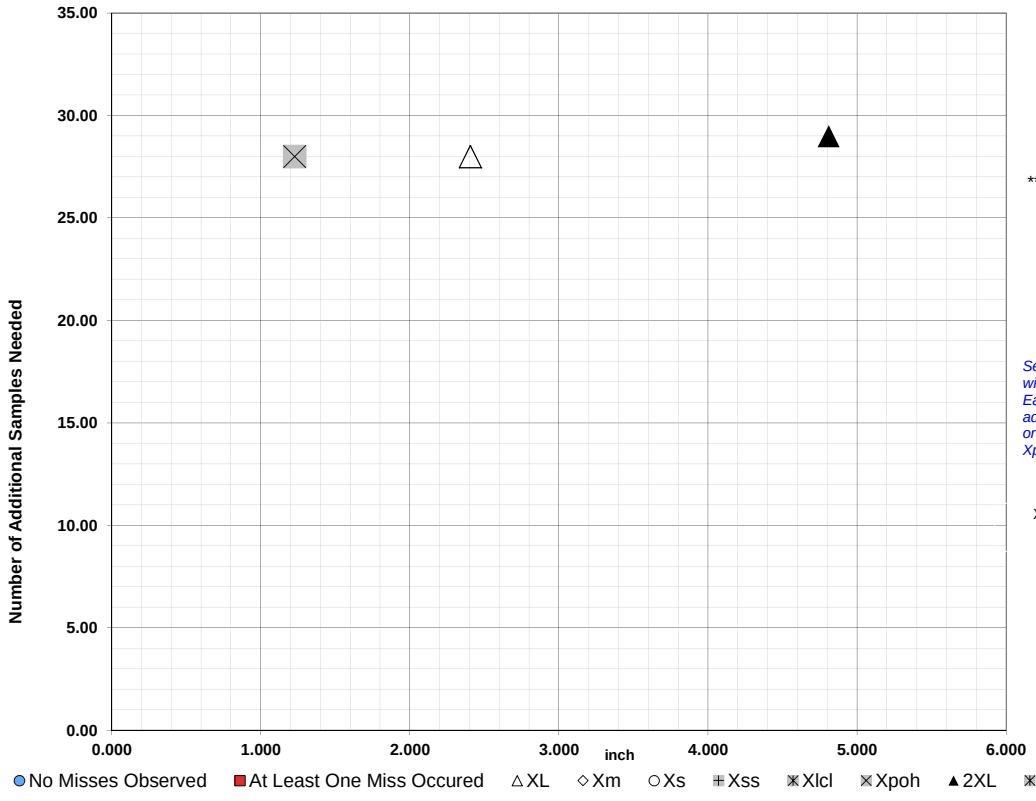



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.227 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

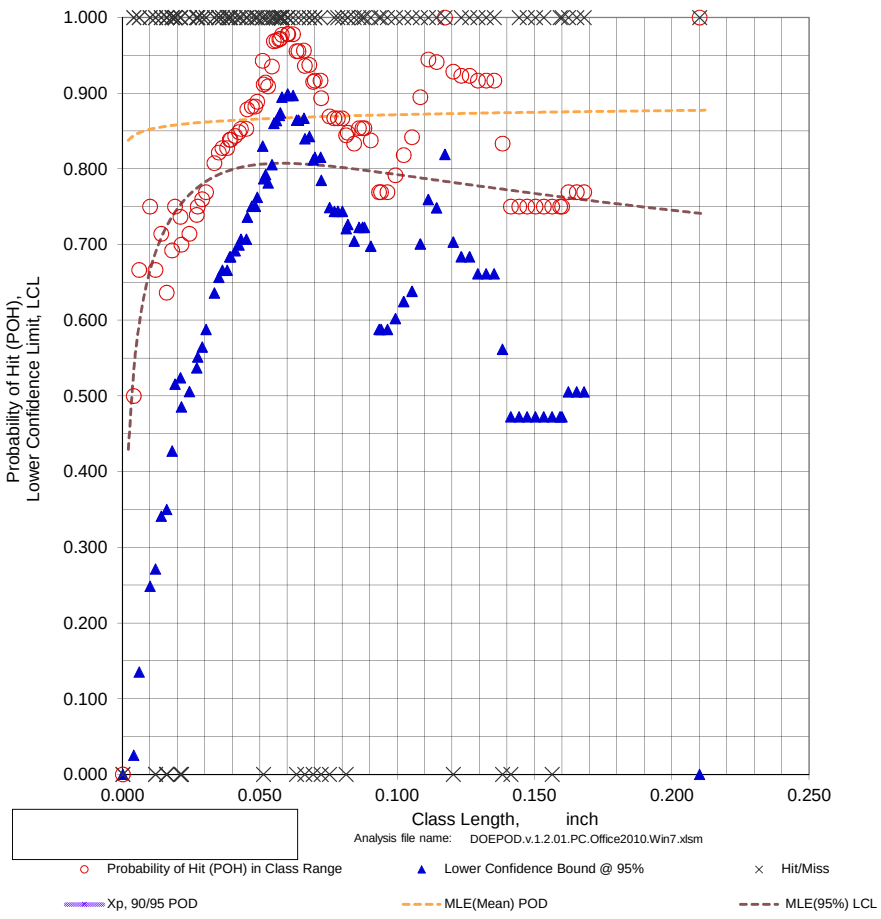
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 6 more large flaws.**

**Warning: No false call analysis.**




File Name = **B1001CD.XLS**

Data Set Name = **B1001CD(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:19 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0330 | inch |
| Classlength @ 90/95 Xpod = | 0.0600 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.210 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | 0.117 | inch |
| Samples Needed @ Xm = | 14 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1001CD.XLS
Data Set Name = B1001CD(CRK #)

## Directed DOE Options

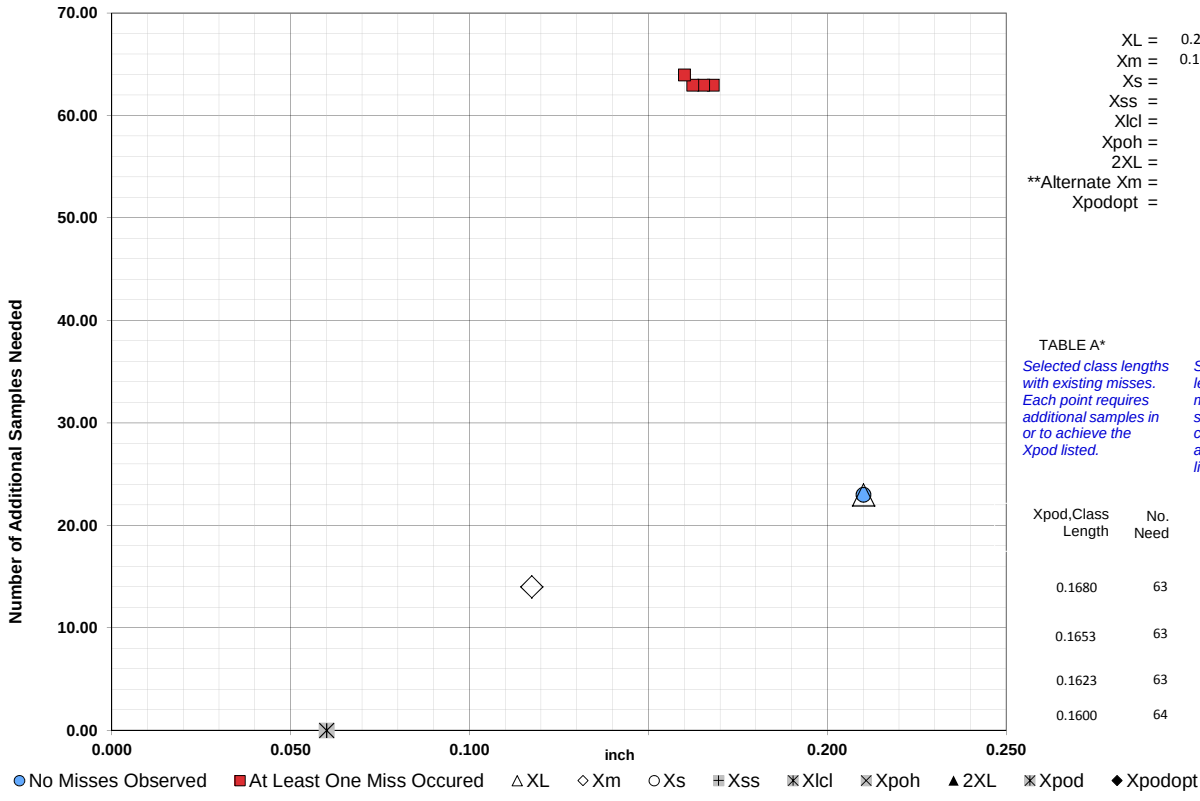



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.210 | 23 |
| Xm = | 0.117 | 14 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1680 | 63 |
| 0.1653 | 63 |
| 0.1623 | 63 |
| 0.1600 | 64 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

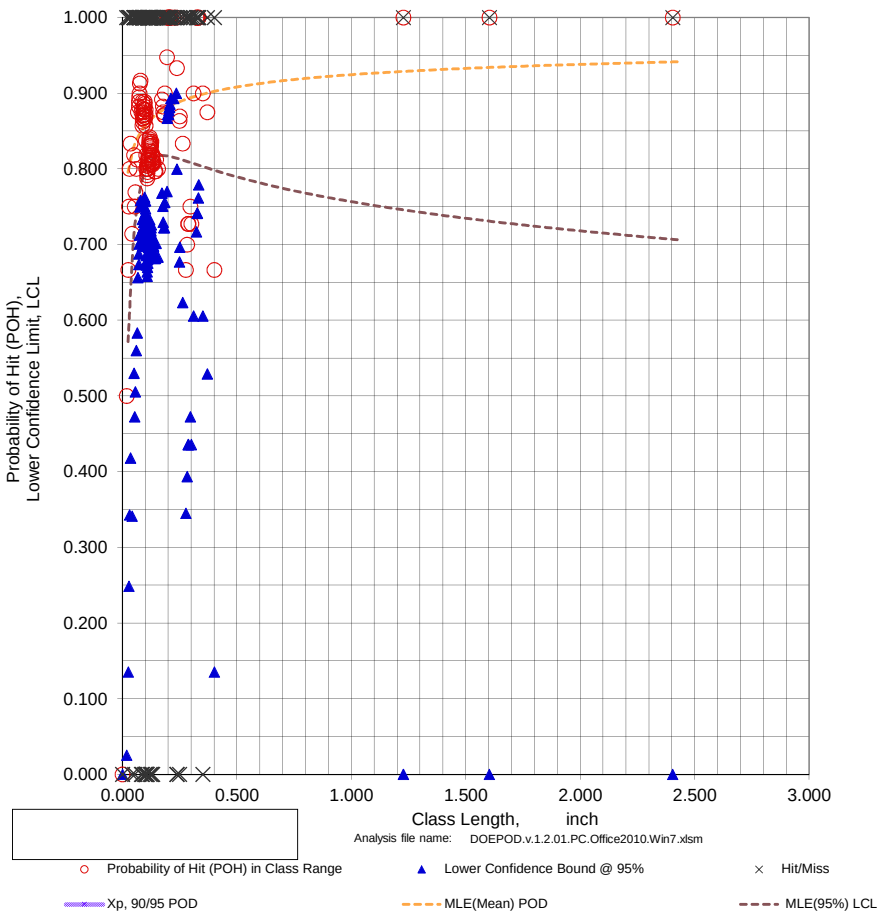
| Xpod,Class Length | No. Need |
|---|---|
| 0.2100 | 23 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 20 more large flaws.**

**Warning: No false call analysis.**




File Name = **B1001CL.XLS**

Data Set Name = **B1001CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:19 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0630 | inch |
| Classlength @ 90/95 Xpod = | 0.2340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.370 | inch |
| NTIAC 90/95 POD = | | @ | | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1001CL.XLS
Data Set Name = B1001CL(CRK #)

## Directed DOE Options

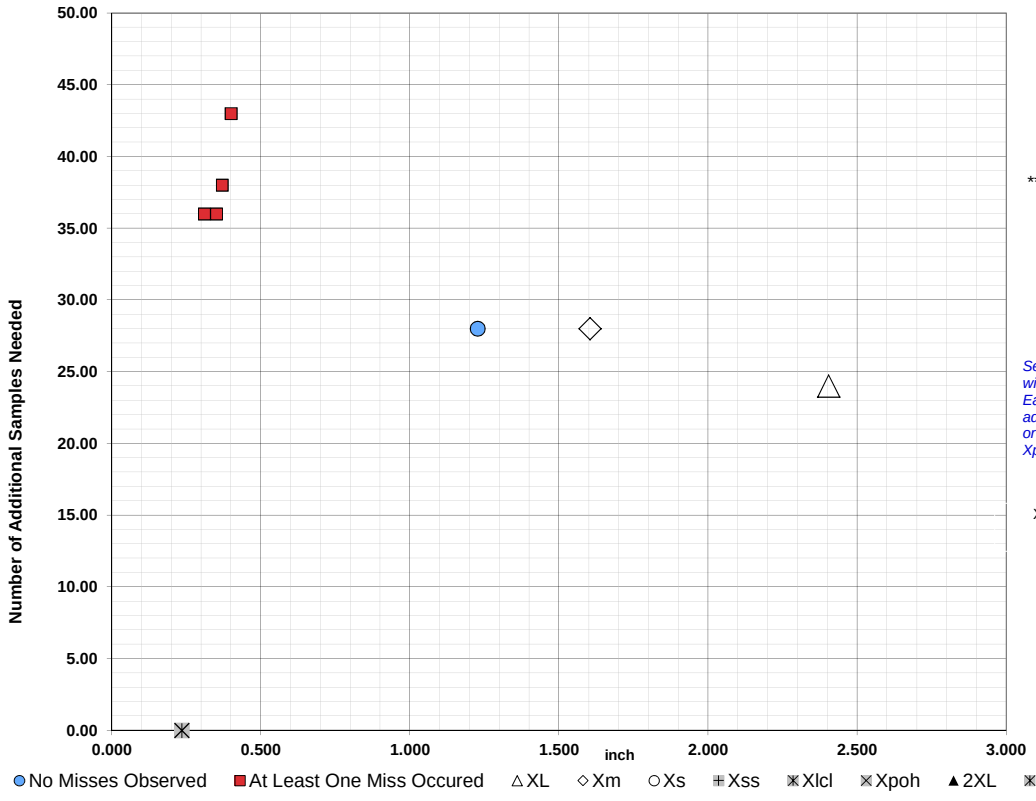



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 24 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4000 | 43 |
| 0.3700 | 38 |
| 0.3500 | 36 |
| 0.3090 | 36 |

TABLE B*

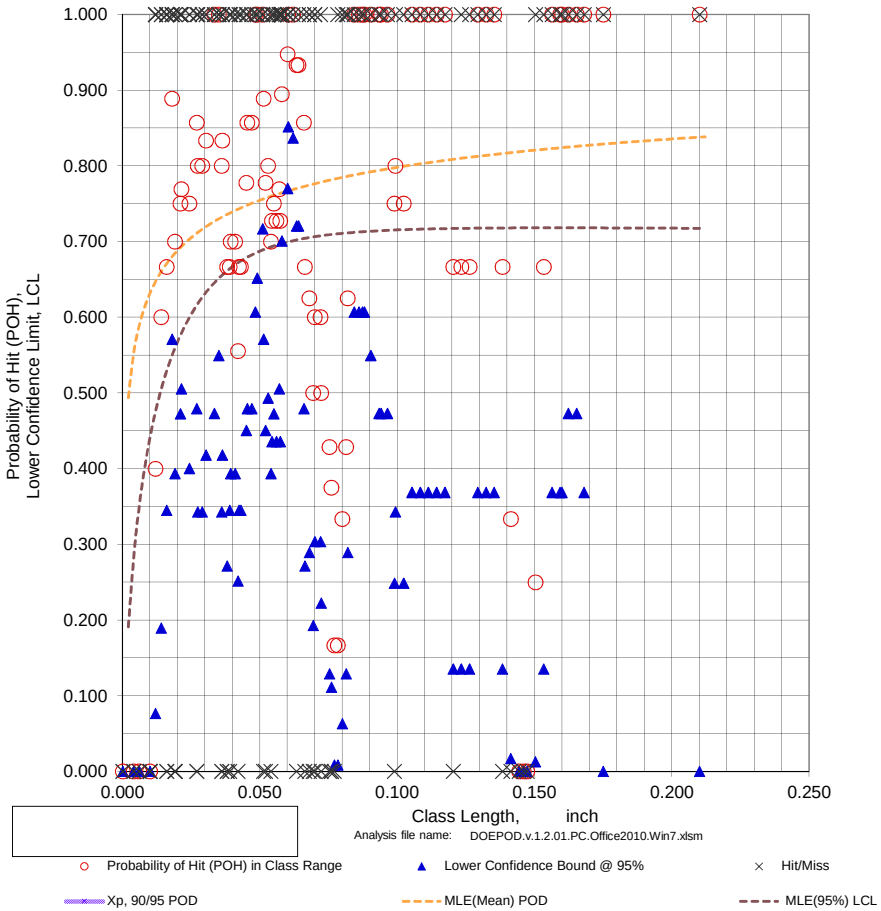
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2270 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1003AD.XLS
Data Set Name = B1003AD(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:20 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8514 | |
| Classwidth @ Best LCL = | 0.0060 | inch |
| Classlength @ Best LCL = | 0.0603 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1503 -0.002 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.210 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.156 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.420 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1003AD.XLS
Data Set Name = B1003AD(CRK # )

## Directed DOE Options

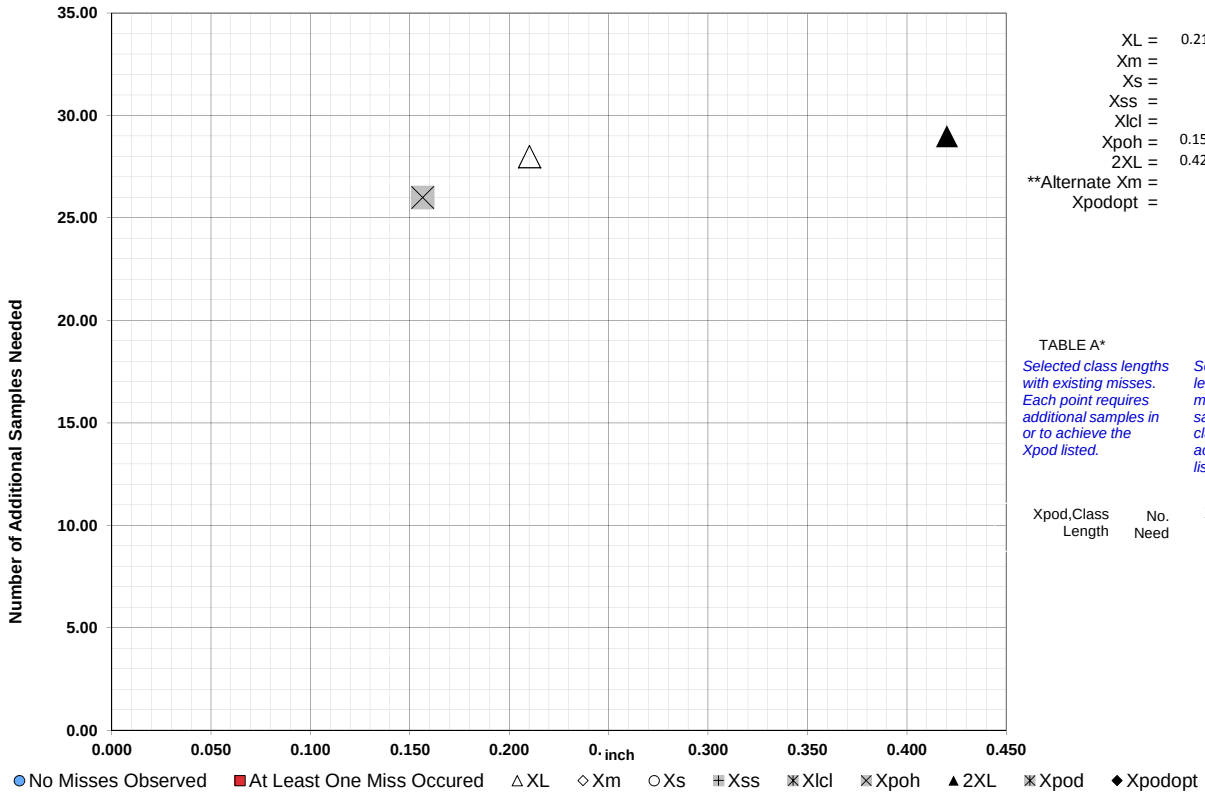



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.210 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.156 | 26 |
| 2XL = | 0.420 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

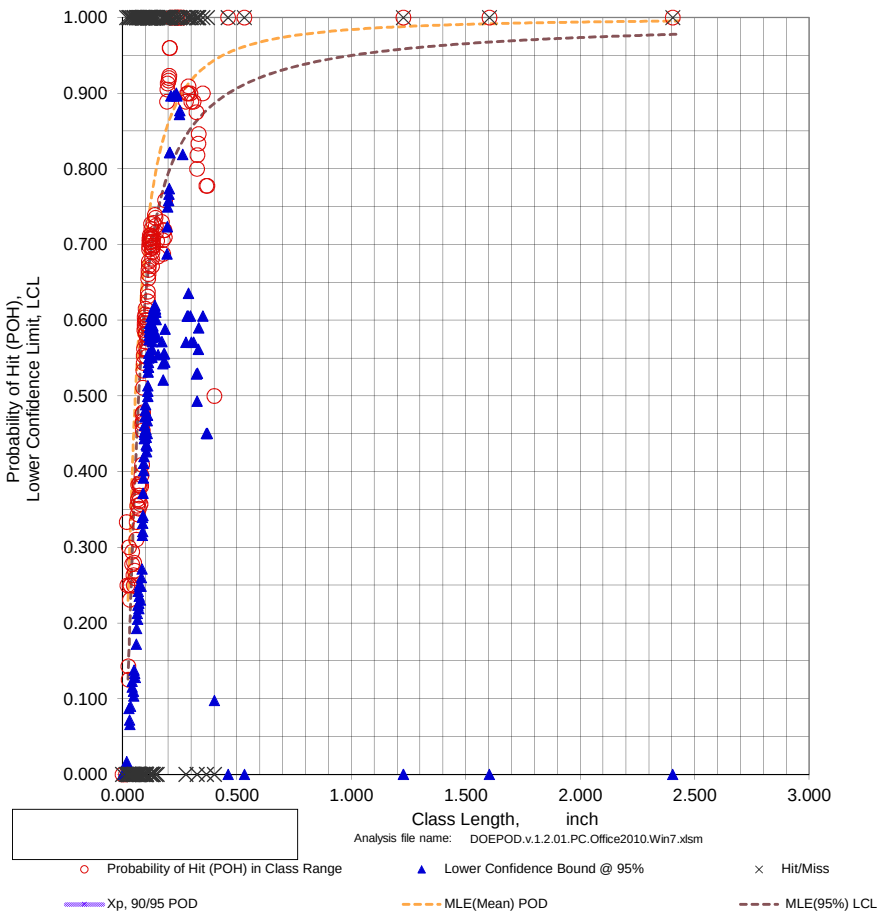
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Warning: No false call analysis.**




File Name = **B1003AL.XLS**

Data Set Name = **B1003AL(CRK # )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:22 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0590 | inch |
| Classlength @ 90/95 Xpod = | 0.2340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.260 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.465 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1003AL.XLS
Data Set Name = B1003AL(CRK # )

## Directed DOE Options

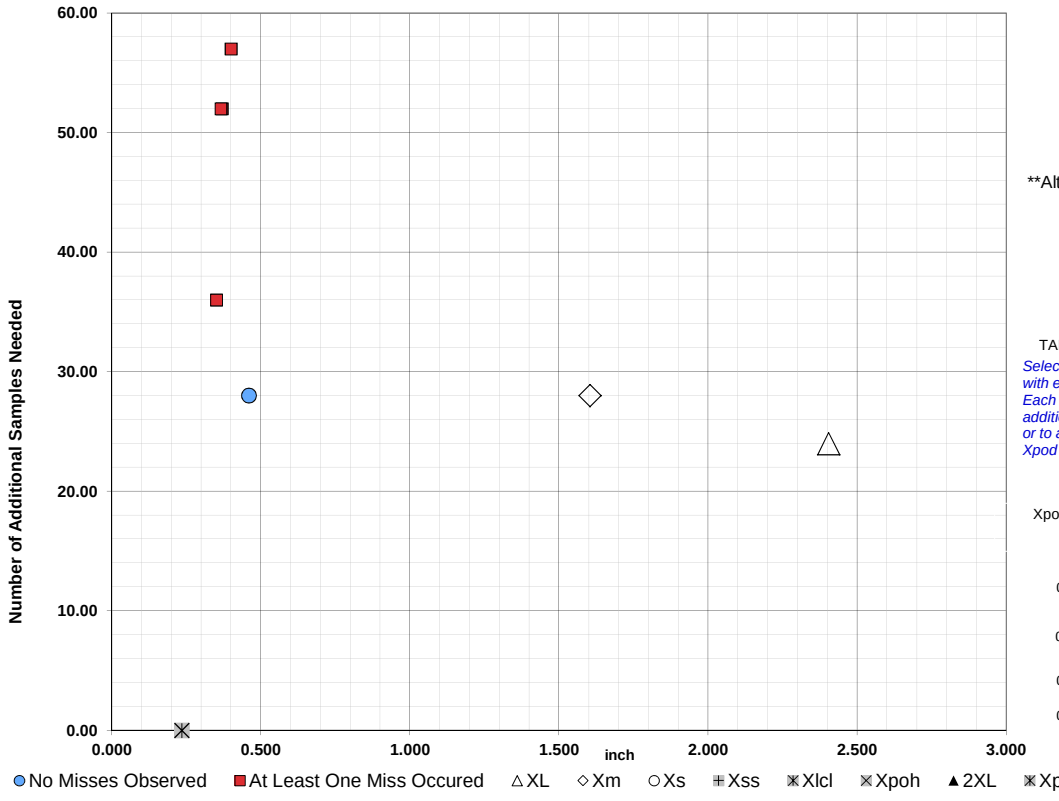



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 24 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4000 | 57 |
| 0.3700 | 52 |
| 0.3650 | 52 |
| 0.3500 | 36 |

TABLE B*

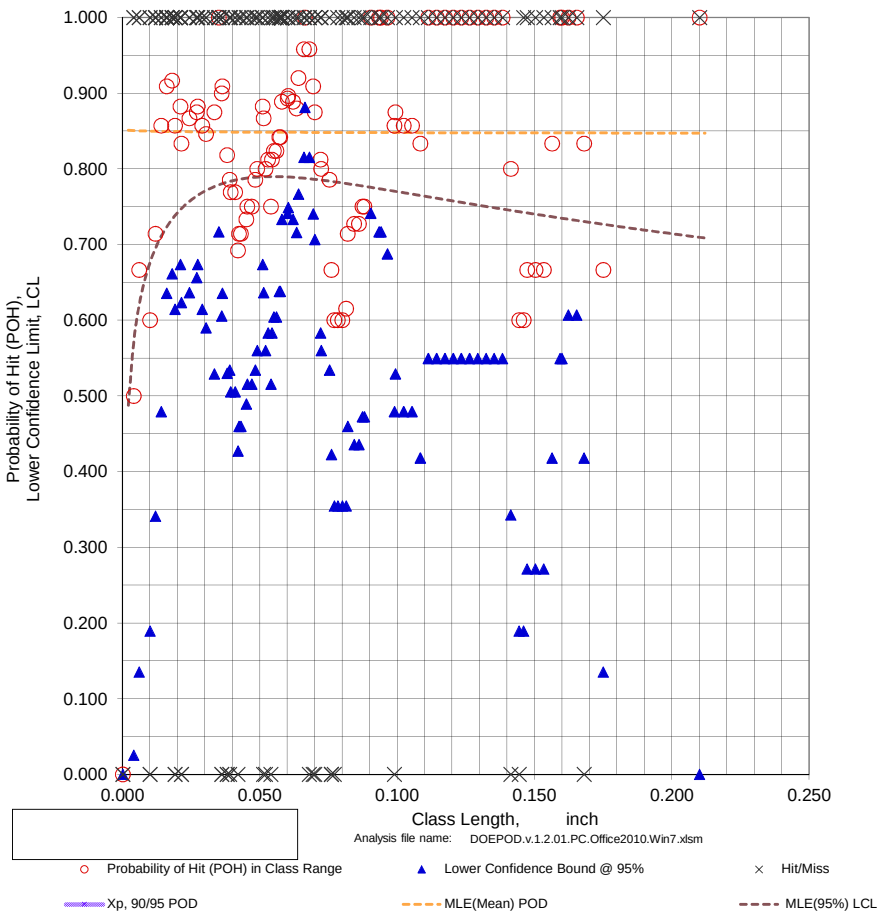
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4600 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1003BD.XLS
Data Set Name = B1003BD(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:23 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.0663 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1750 -0.006 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.210 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.210 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.420 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1003BD.XLS
Data Set Name = B1003BD(CRK # )

## Directed DOE Options

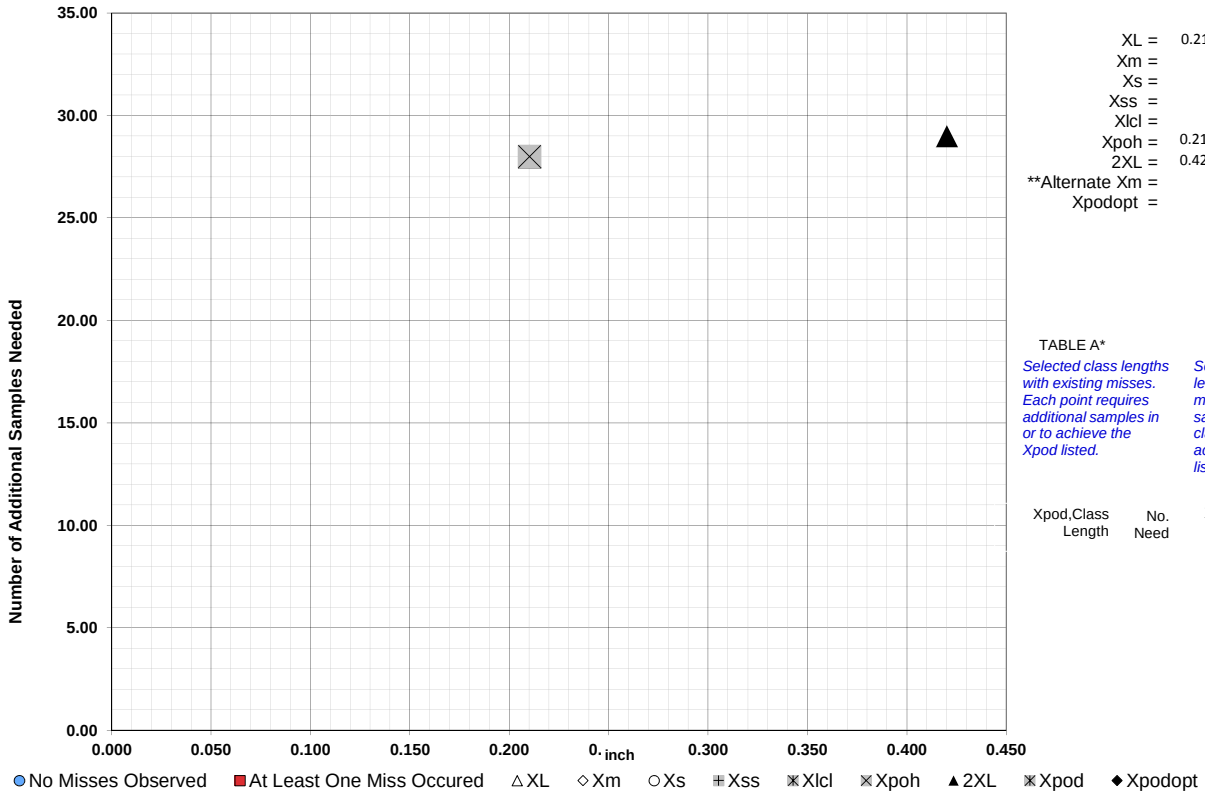



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.210 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.210 | 28 |
| 2XL = | 0.420 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

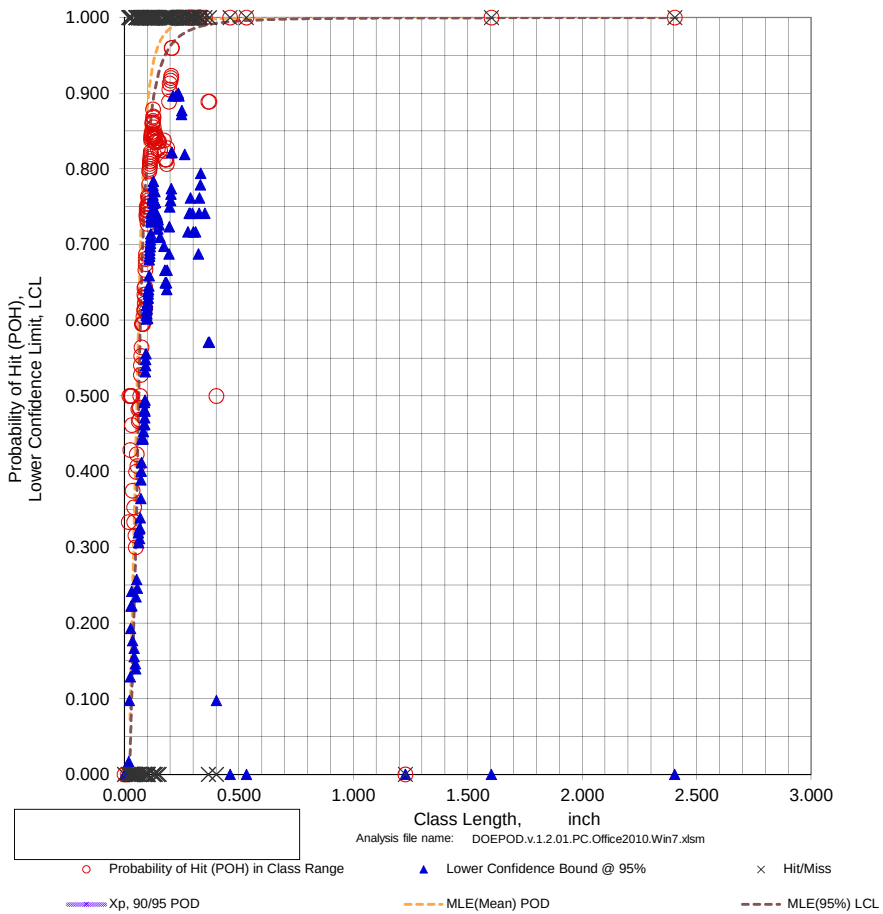
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **B1003BL.XLS**

Data Set Name = **B1003BL(CRK # )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:25 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0590 | inch |
| Classlength @ 90/95 Xpod = | 0.2340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.911 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.135 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1003BL.XLS
Data Set Name = B1003BL(CRK # )

## Directed DOE Options

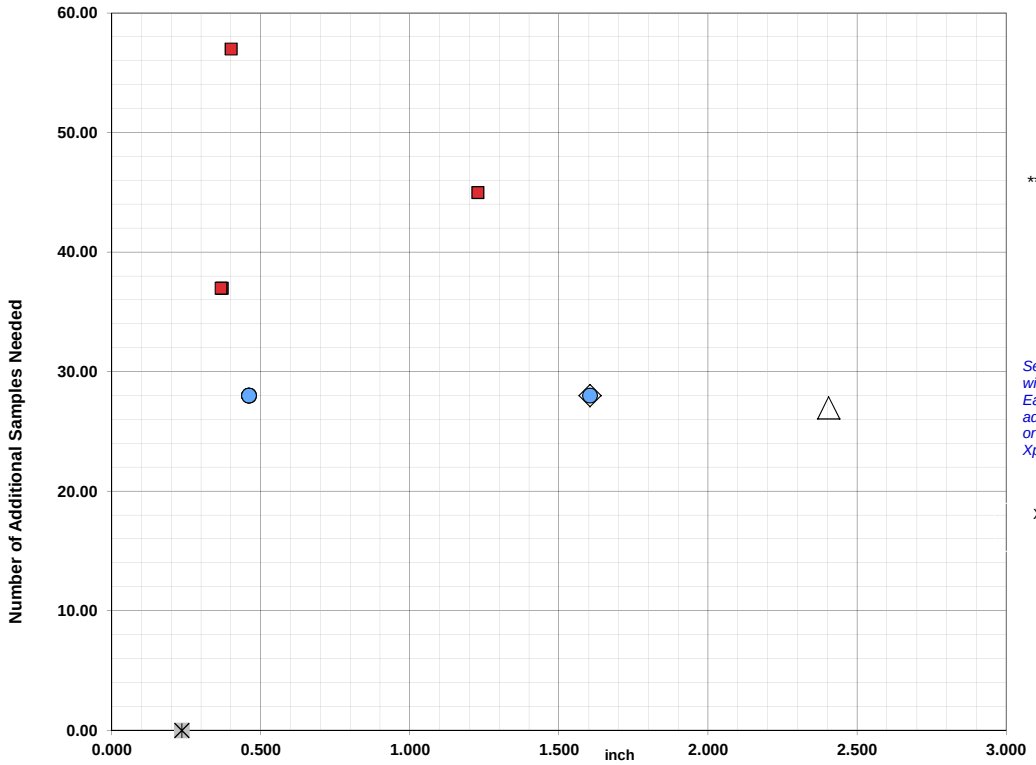



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 27 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2270 | 45 |
| 0.4000 | 57 |
| 0.3700 | 37 |
| 0.3650 | 37 |

TABLE B*

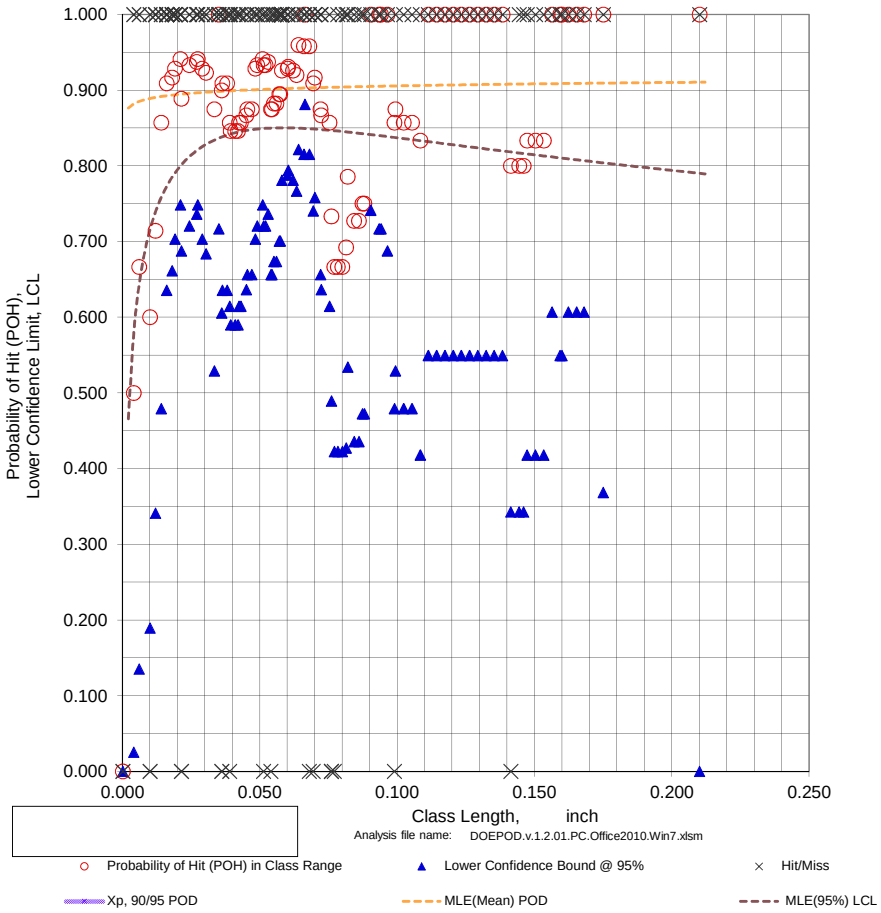
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.6030 | 28 |
| 0.4600 | 28 |
| 0.4600 | 28 |
| 0.4600 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B1003CD.XLS
Data Set Name = B1003CD(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:26 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.0663 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1443 -0.002 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.045 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.210 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.156 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 0.420 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B1003CD.XLS
Data Set Name = B1003CD(CRK # )

## Directed DOE Options

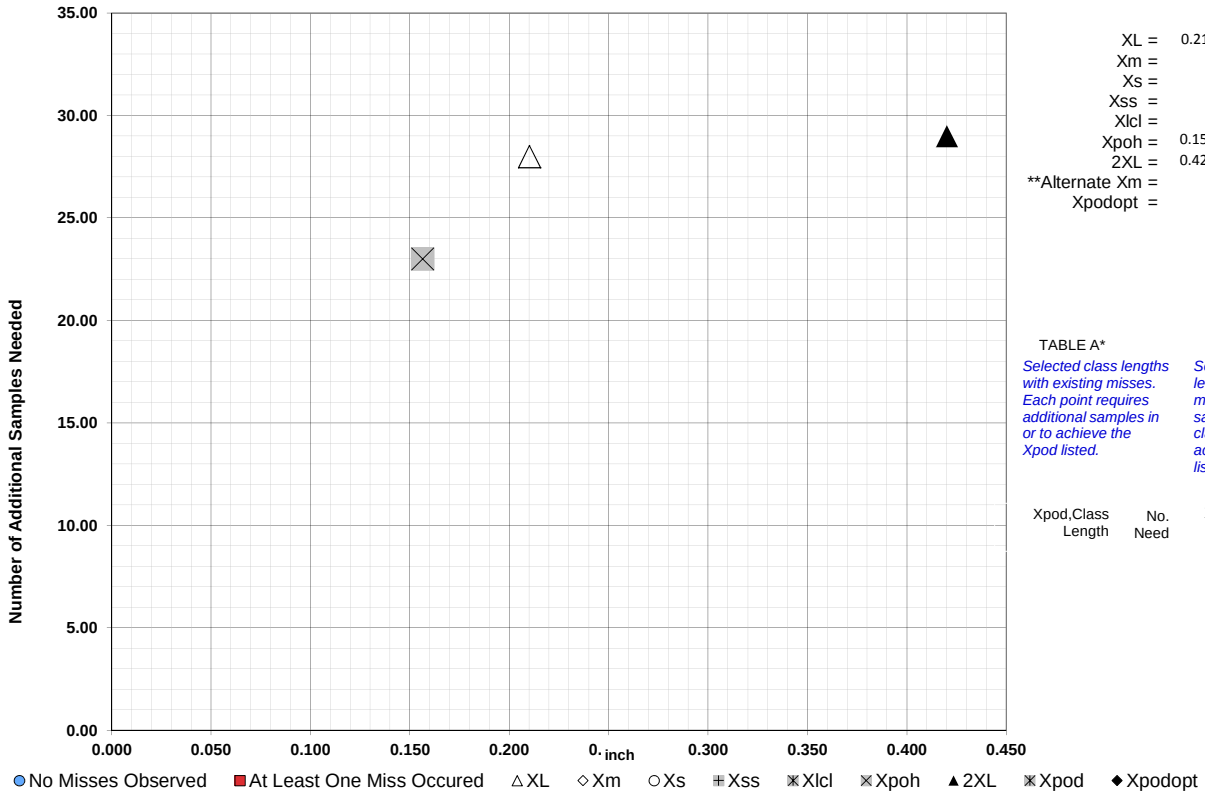



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.210 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.156 | 23 |
| 2XL = | 0.420 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

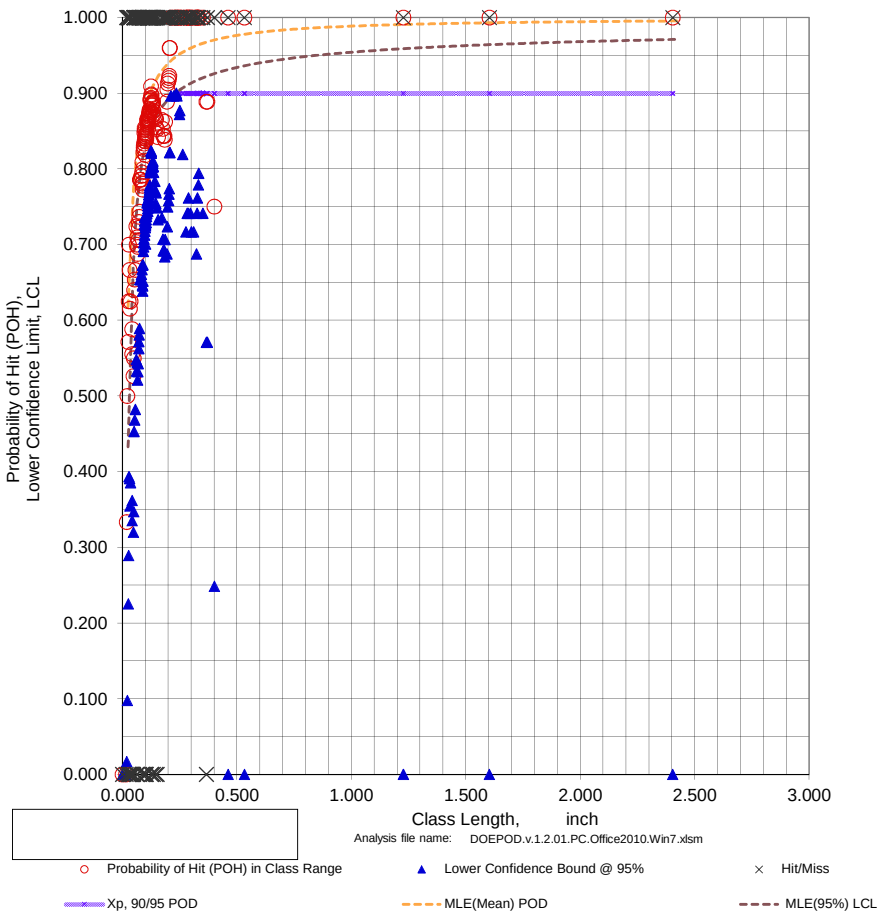
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **B1003CL.XLS**

Data Set Name = **B1003CL(CRK # )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:27 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0590 | inch |
| Classlength @ 90/95 Xpod = | 0.2340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.120 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.235 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2340 | inch |

File Name = B1003CL.XLS
Data Set Name = B1003CL(CRK # )

## Directed DOE Options

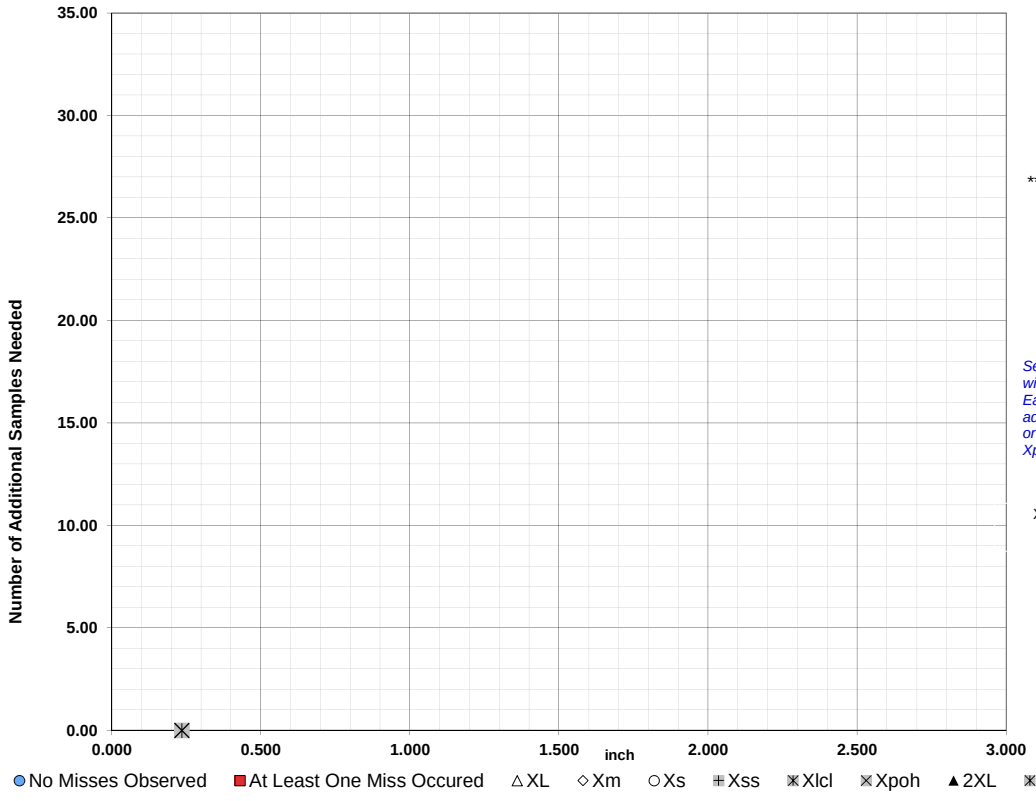



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 2.403 |
| Xm = | 1.603 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

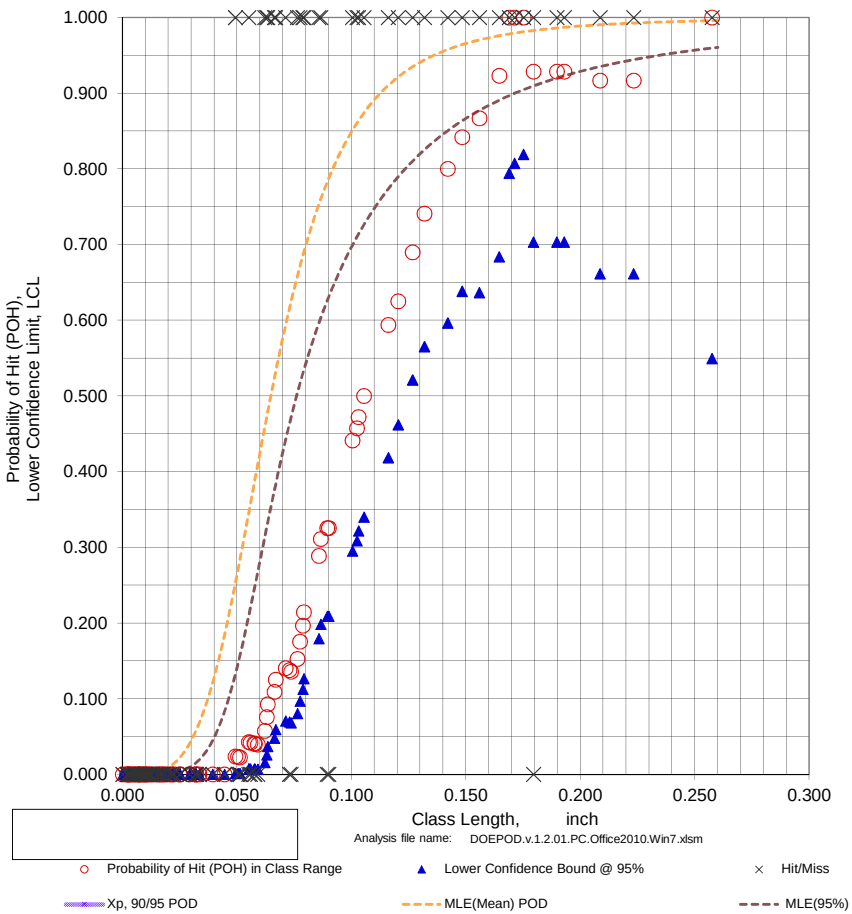
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B2001.XLS
Data Set Name = B2001(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:29 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.0750 | inch |
| Classlength @ Best LCL = | 0.1752 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1898 -0.010 inch 28 Samples

NTIAC 90% POD = 0.907 @ 0.115 inch
NTIAC 90/95 POD = 0.905 @ 0.175 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.257 | inch |
| Samples Needed @ Xpoh = | 24 | |
| New Largest Classlength , 2XL = | 0.515 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B2001.XLS
Data Set Name = B2001(HOLE #)

## Directed DOE Options

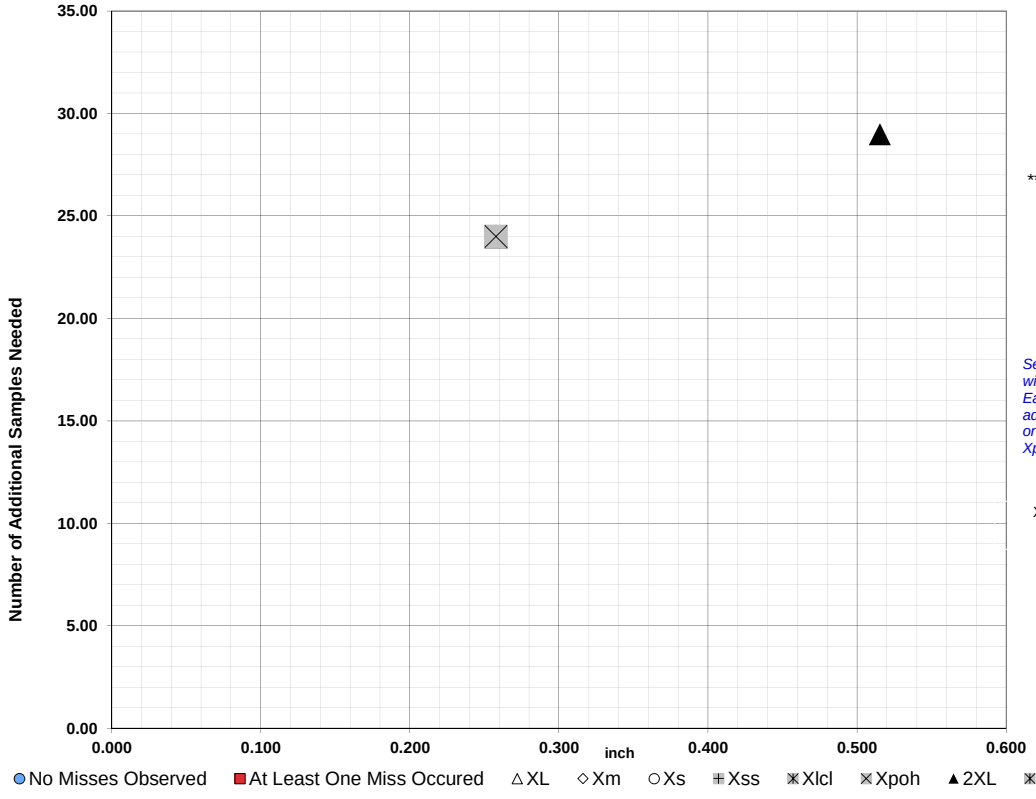



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 24 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.257 | 24 |
| 2XL = | 0.515 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

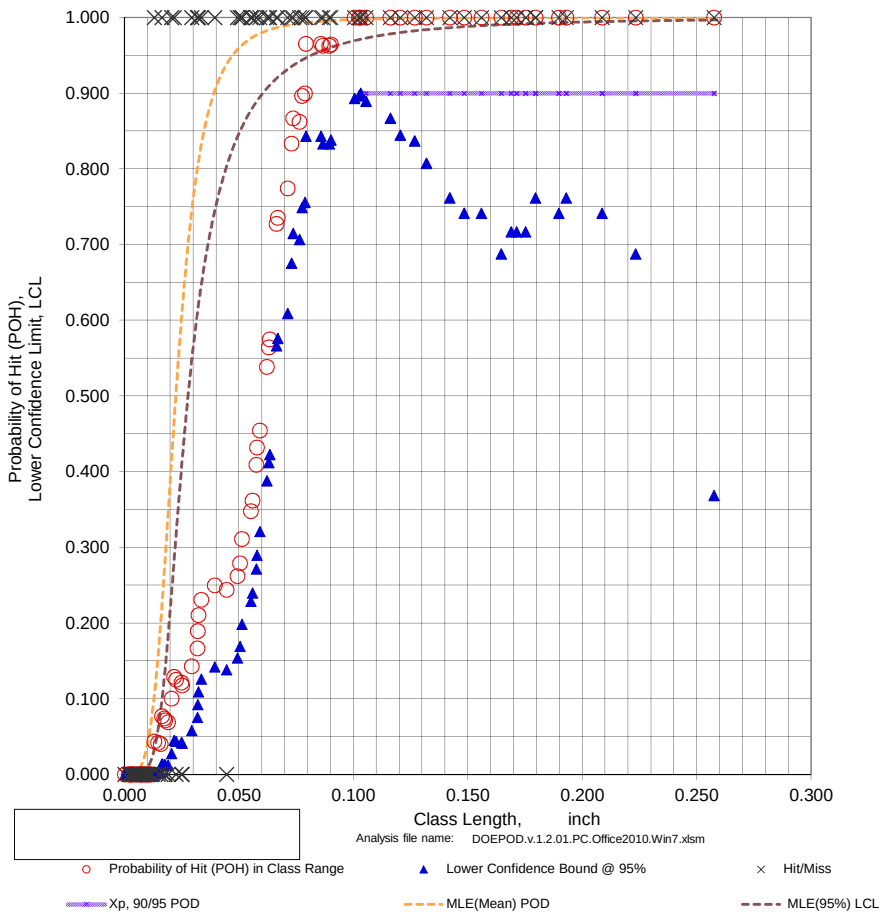
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.30942.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **B2002.XLS**
Data Set Name = **B2002(HOLE #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:30 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0540 | inch |
| Classlength @ 90/95 Xpod = | 0.1031 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0492 -0.004 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.909 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.916 | @ | 0.065 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.193 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.100 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.1031 | inch |

File Name = B2002.XLS
Data Set Name = B2002(HOLE #)

## Directed DOE Options

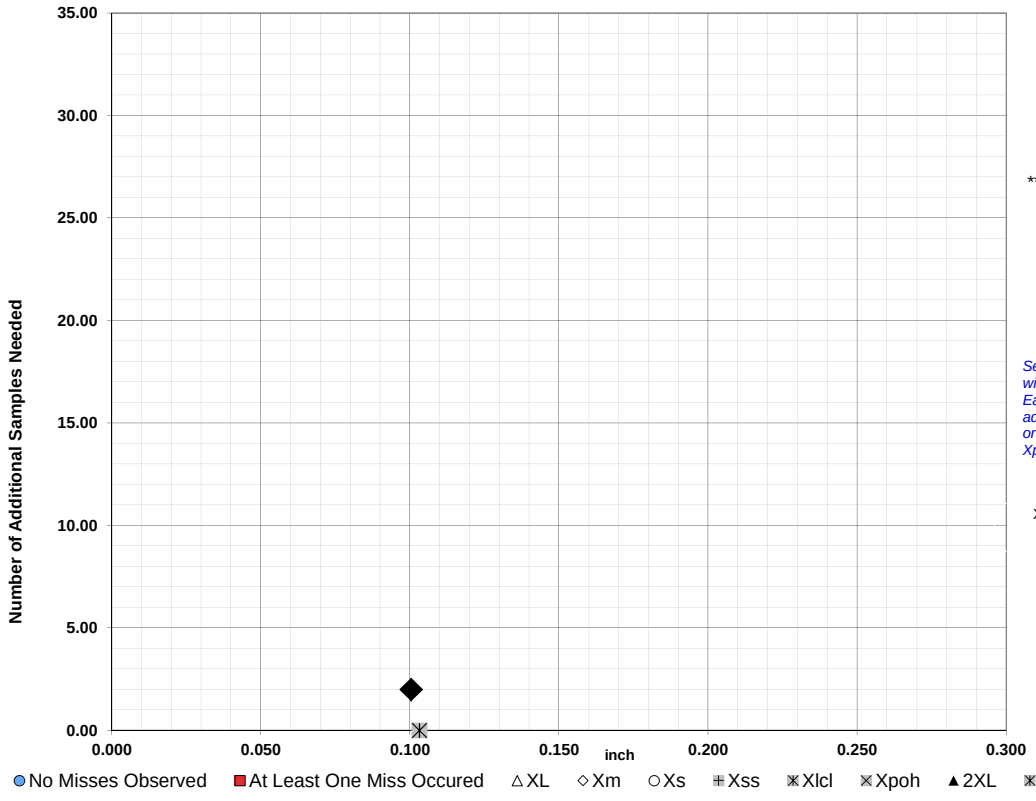



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | |
| Xm = | 0.193 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.100 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

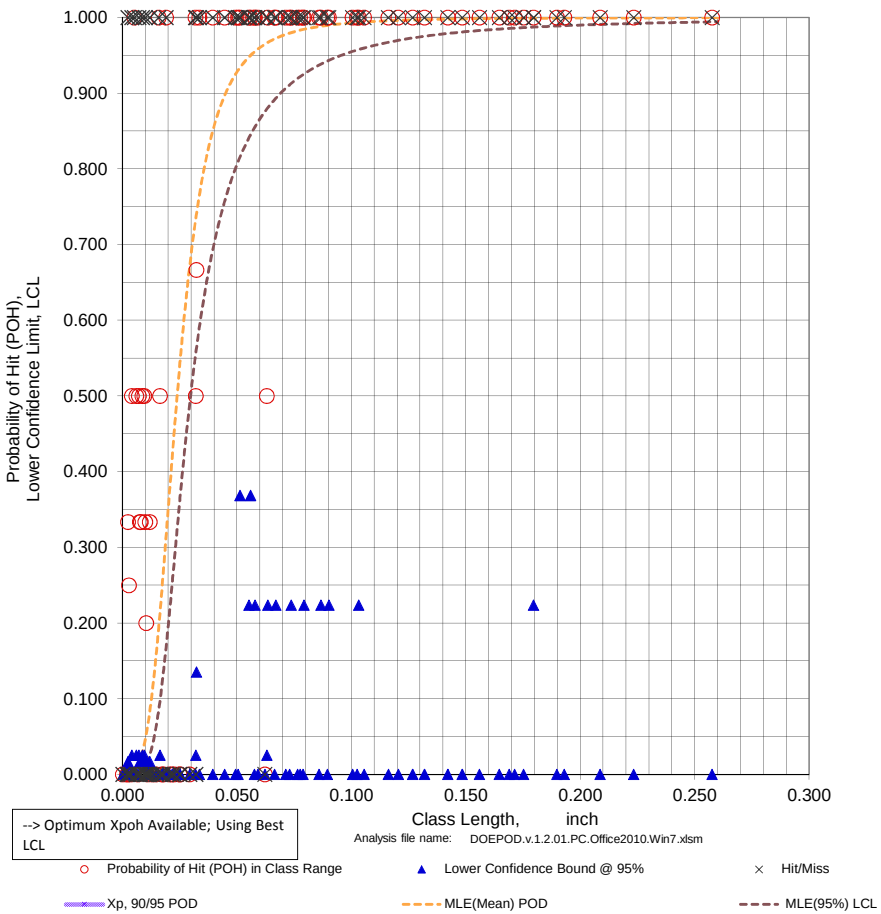
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = B2003.XLS
Data Set Name = B2003(HOLE #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:31 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0512 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.0634 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.045 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.070 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.063 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B2003.XLS
Data Set Name = B2003(HOLE #)

## Directed DOE Options

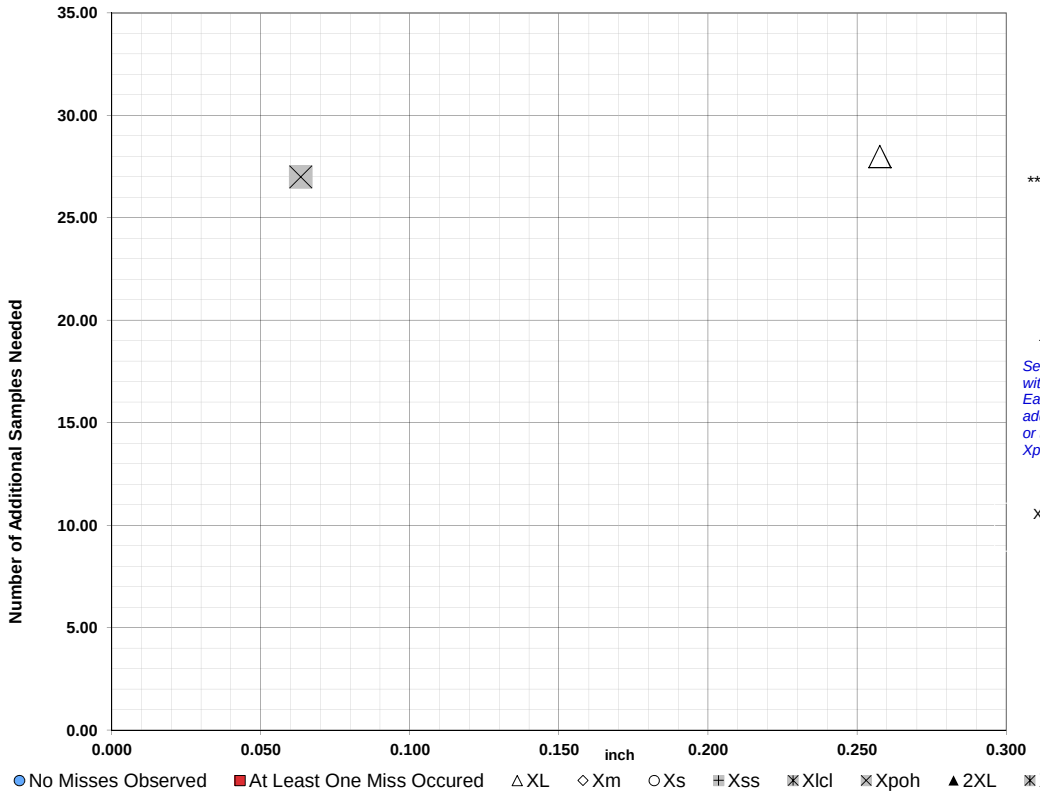



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.063 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

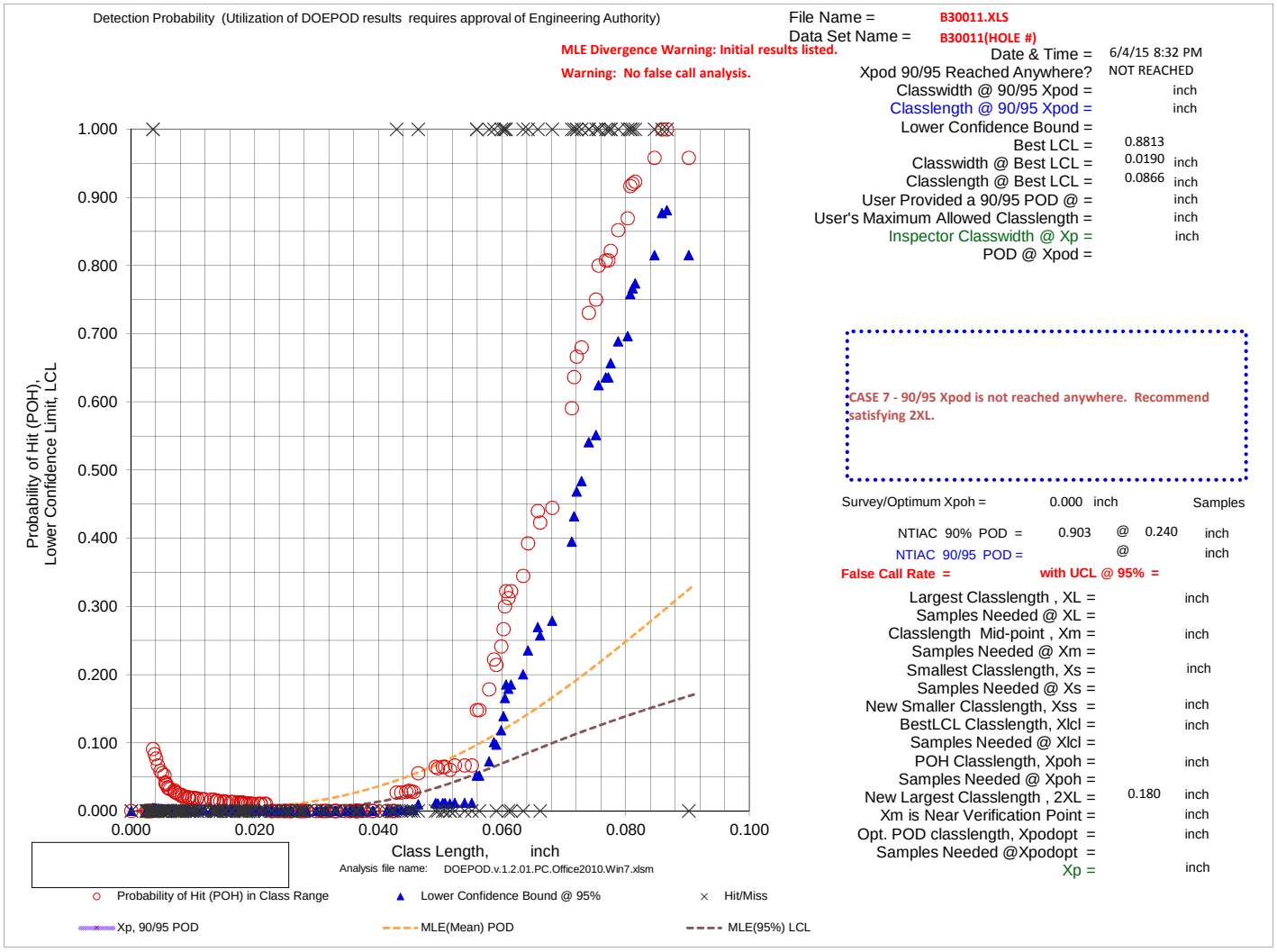
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
File Name = B30011.XLS
Data Set Name = B30011(HOLE #)
MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.
Date & Time = 6/4/15 8:32 PM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.8813
Classwidth @ Best LCL = 0.0190 inch
Classlength @ Best LCL = 0.0866 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.
Survey/Optimum Xpoh = 0.000 inch Samples
NTIAC 90% POD = 0.903 @ 0.240 inch
NTIAC 90/95 POD = @ inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = inch
Samples Needed @ XL =
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = inch
Samples Needed @ Xpoh =
New Largest Classlength , 2XL = 0.180 inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000
0.020
0.040
0.060
0.080
0.100
Class Length, inch
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL

File Name = B30011.XLS
Data Set Name = B30011(HOLE #)

## Directed DOE Options

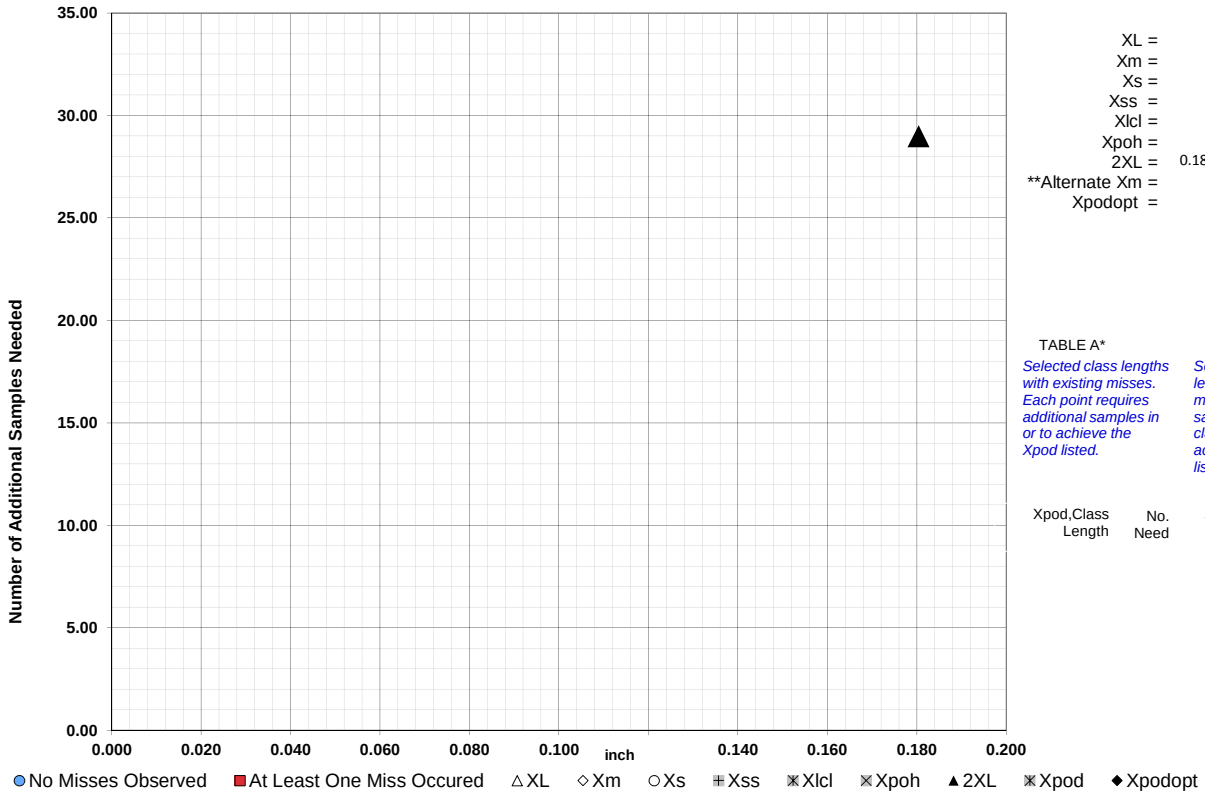



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

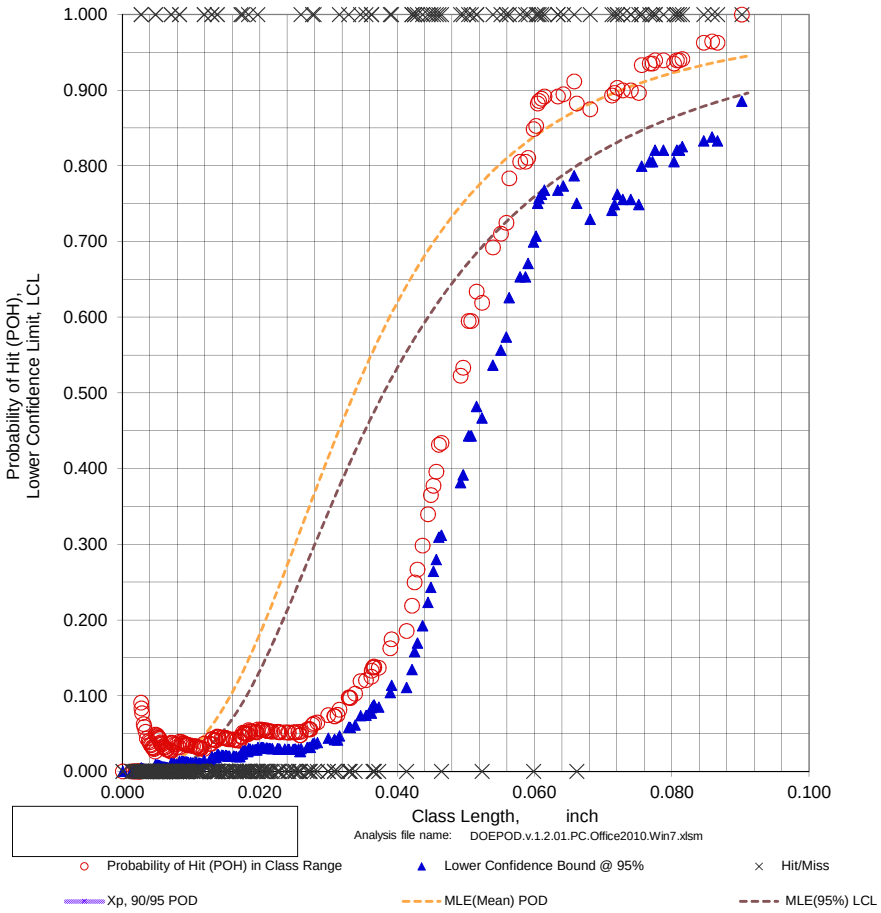
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B30012.XLS
Data Set Name = B30012(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:34 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0230 | inch |
| Classlength @ Best LCL = | 0.0902 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0681 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.908 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.095 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | 4 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.090 | inch |
| Samples Needed @ Xlcl = | 4 | |
| POH Classlength, Xpoh = | 0.090 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.180 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B30012.XLS
Data Set Name = B30012(HOLE #)

## Directed DOE Options

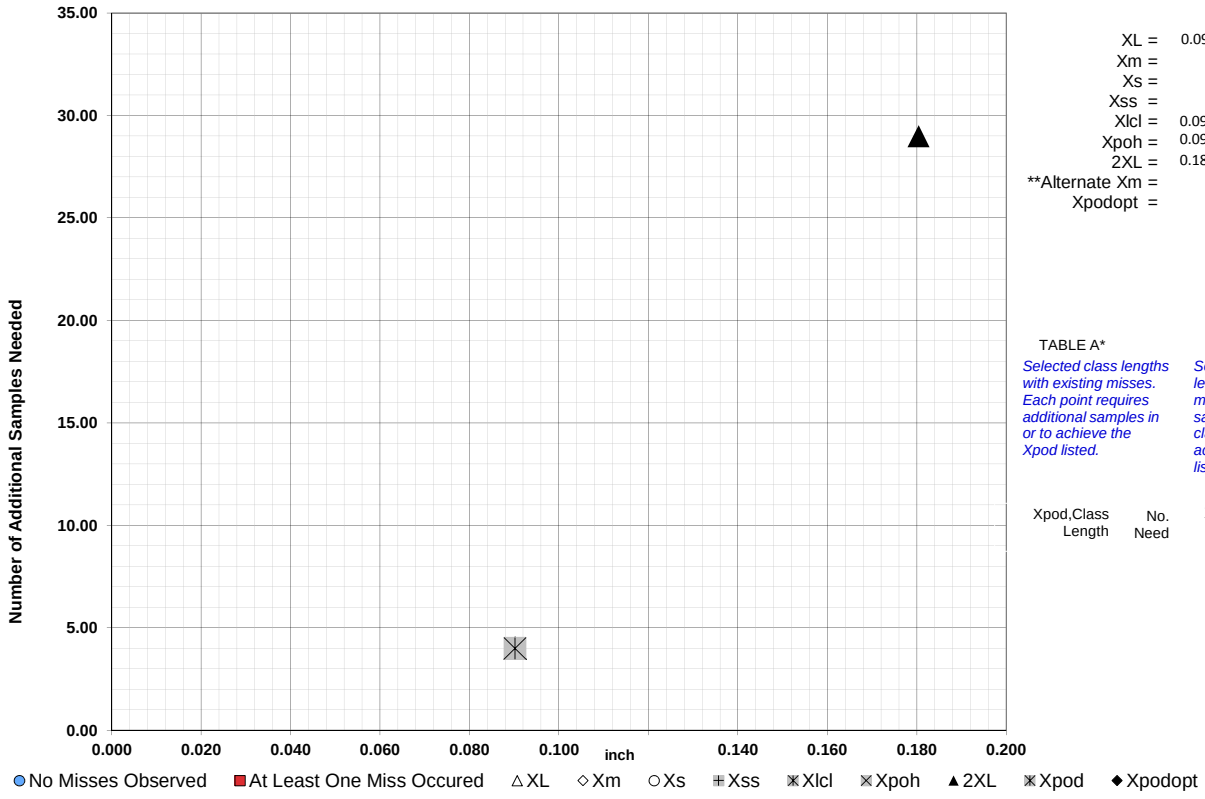



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | 4 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.090 | 4 |
| Xpoh = | 0.090 | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

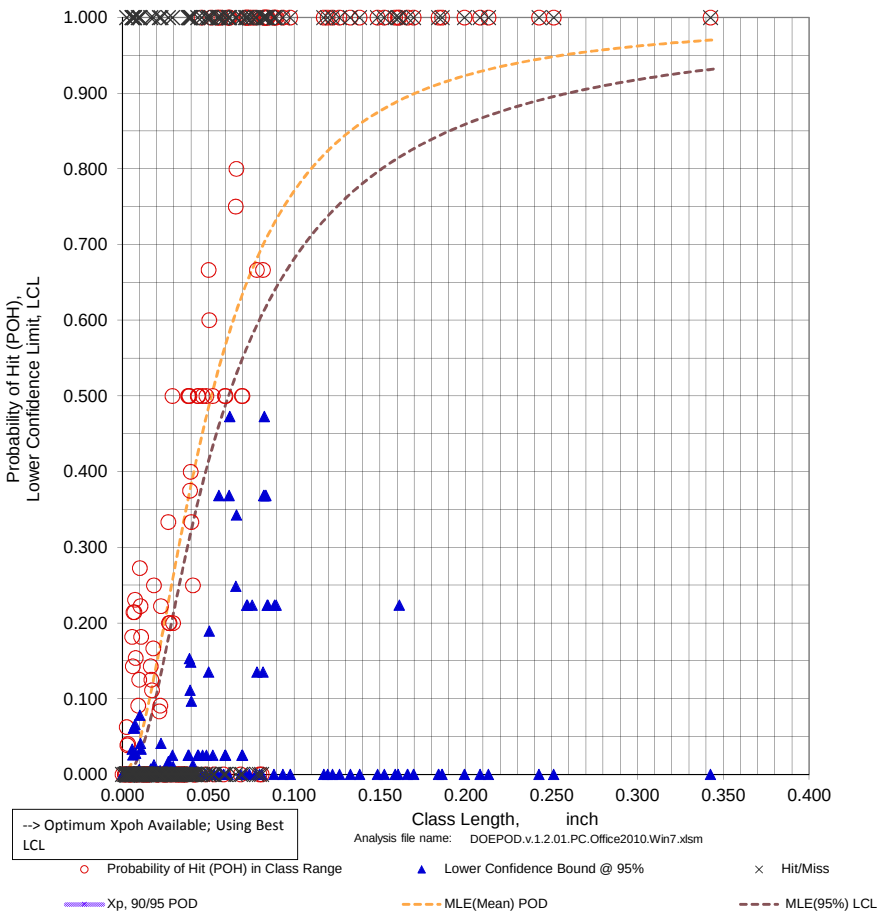
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = B4001L.XLS
Data Set Name = B4001L(Mpi-d)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:36 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4729 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0623 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.0821 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.175 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.260 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.082 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = B4001L.XLS
Data Set Name = B4001L(Mpi-d)

## Directed DOE Options

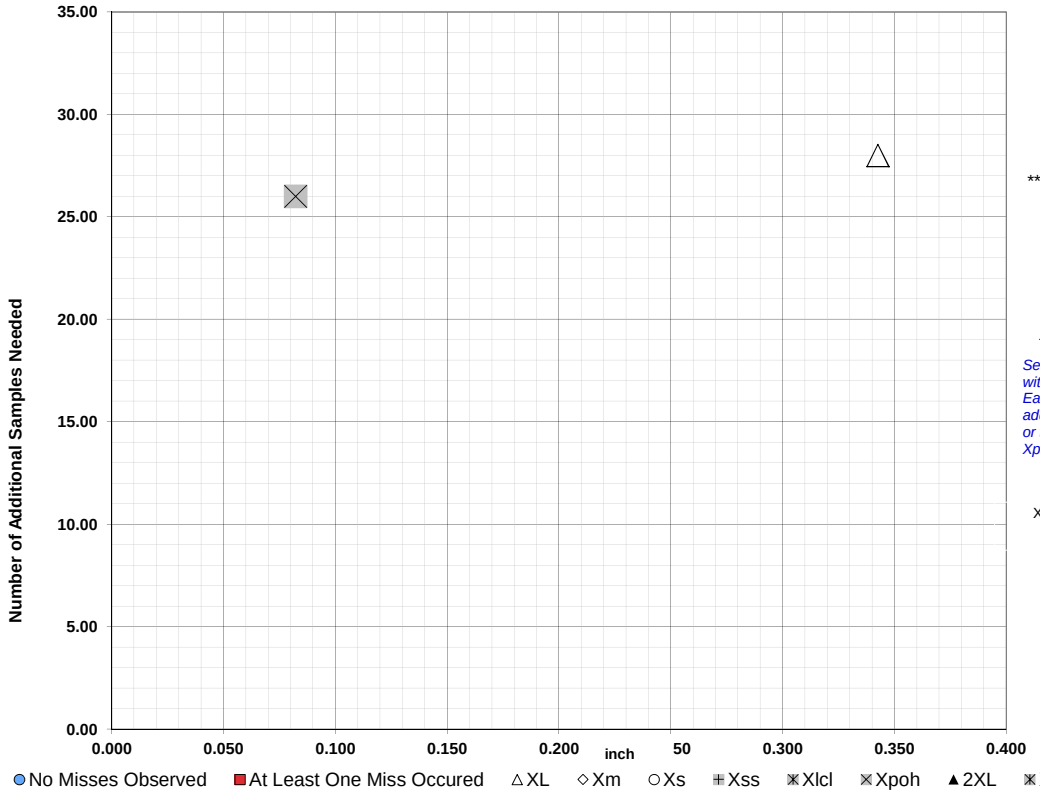



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.082 | 26 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

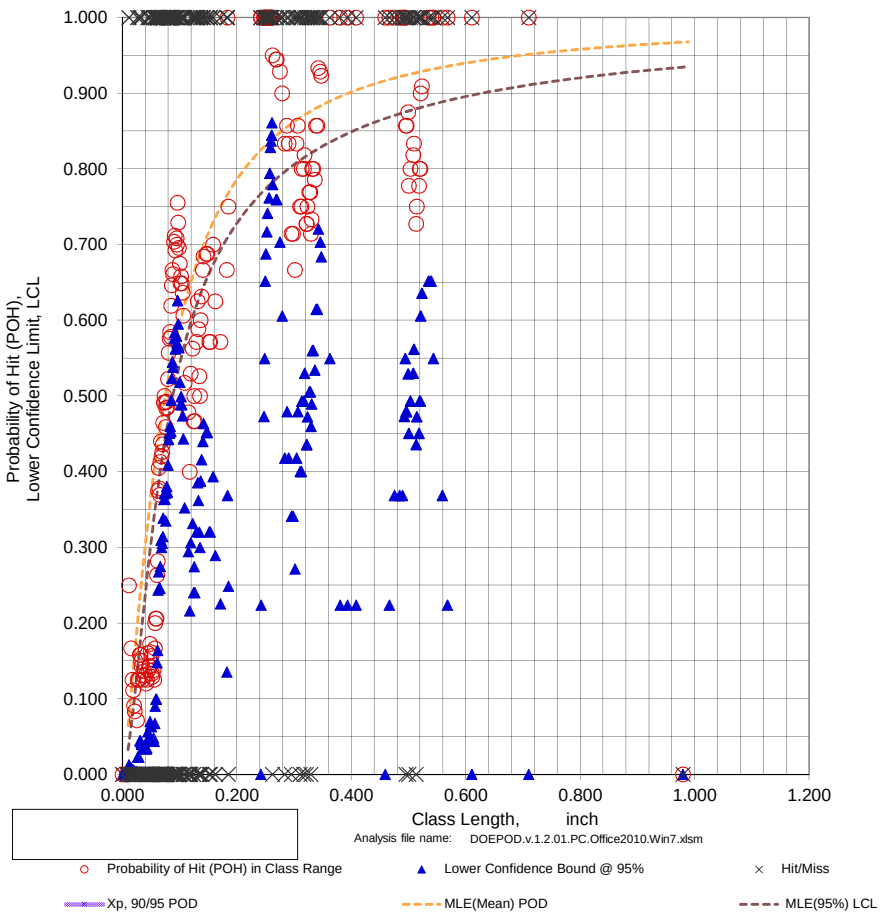
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C1001AL.XLS
Data Set Name = C1001AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:38 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8609 | |
| Classwidth @ Best LCL = | 0.0200 | inch |
| Classlength @ Best LCL = | 0.2610 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.395 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.630 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.958 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C1001AL.XLS
Data Set Name = C1001AL(CRACK #)

## Directed DOE Options

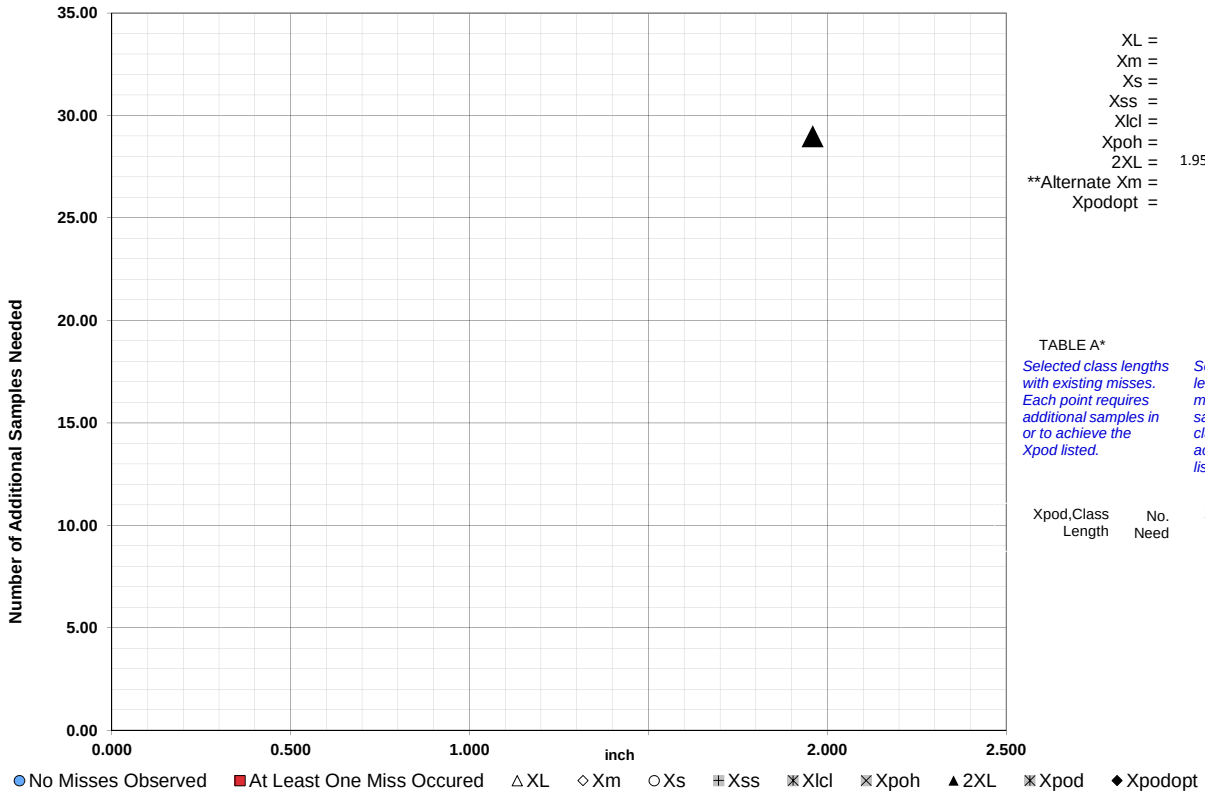



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.958 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

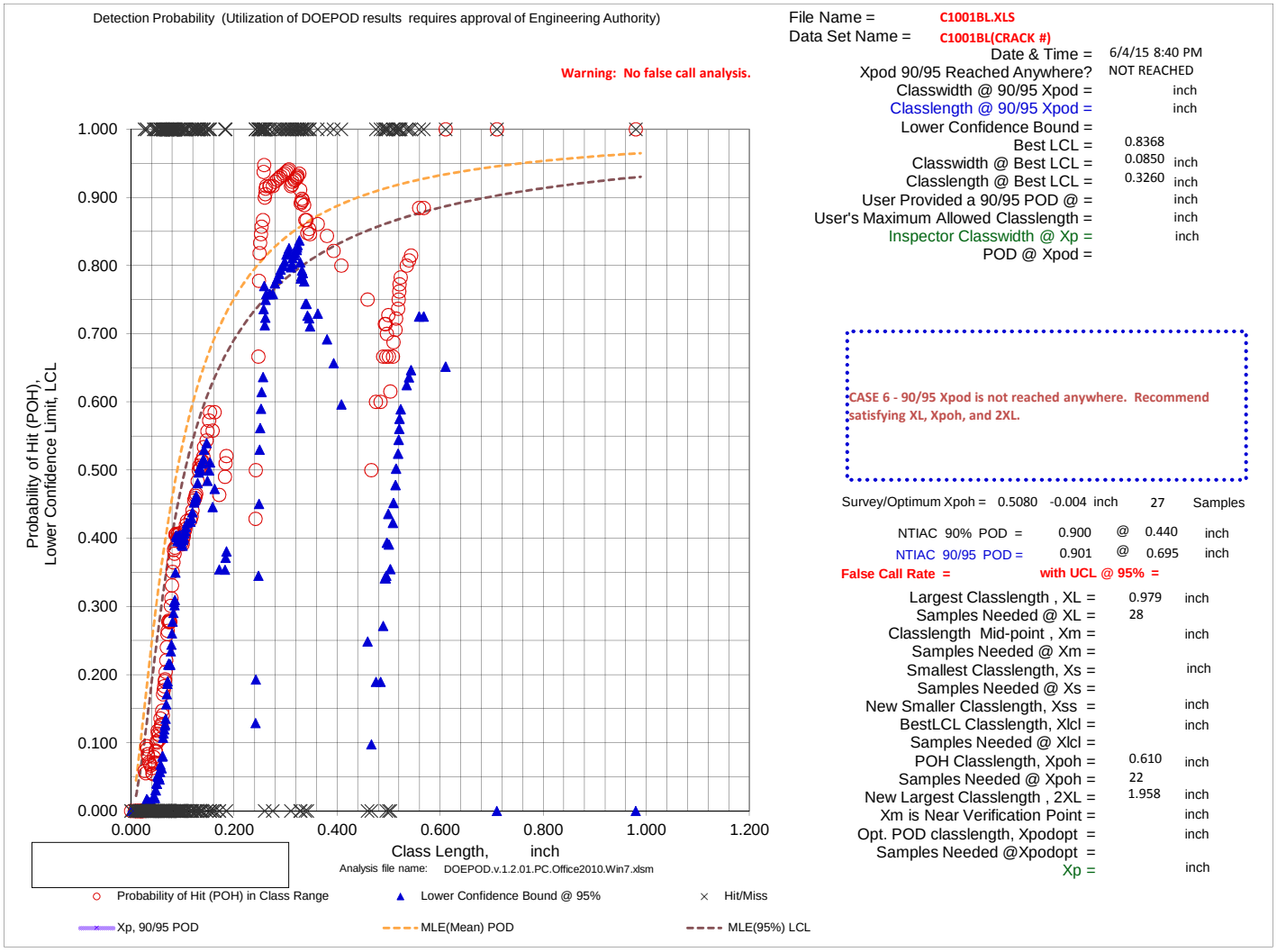
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = C1001BL.XLS
Data Set Name = C1001BL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:40 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8368 | |
| Classwidth @ Best LCL = | 0.0850 | inch |
| Classlength @ Best LCL = | 0.3260 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.5080 -0.004 inch 27 Samples

NTIAC 90% POD = 0.900 @ 0.440 inch
NTIAC 90/95 POD = 0.901 @ 0.695 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.610 | inch |
| Samples Needed @ Xpoh = | 22 | |
| New Largest Classlength , 2XL = | 1.958 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C1001BL.XLS
Data Set Name = C1001BL(CRACK #)

## Directed DOE Options

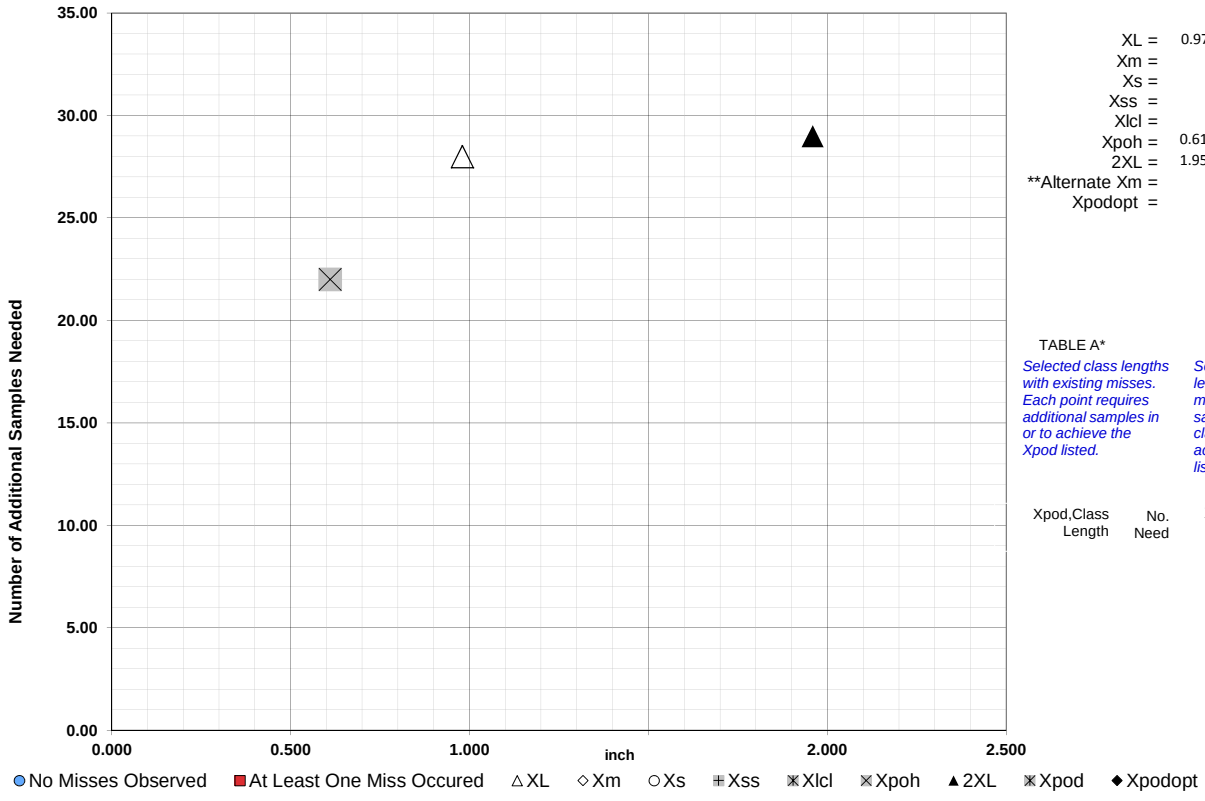



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.610 | 22 |
| 2XL = | 1.958 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

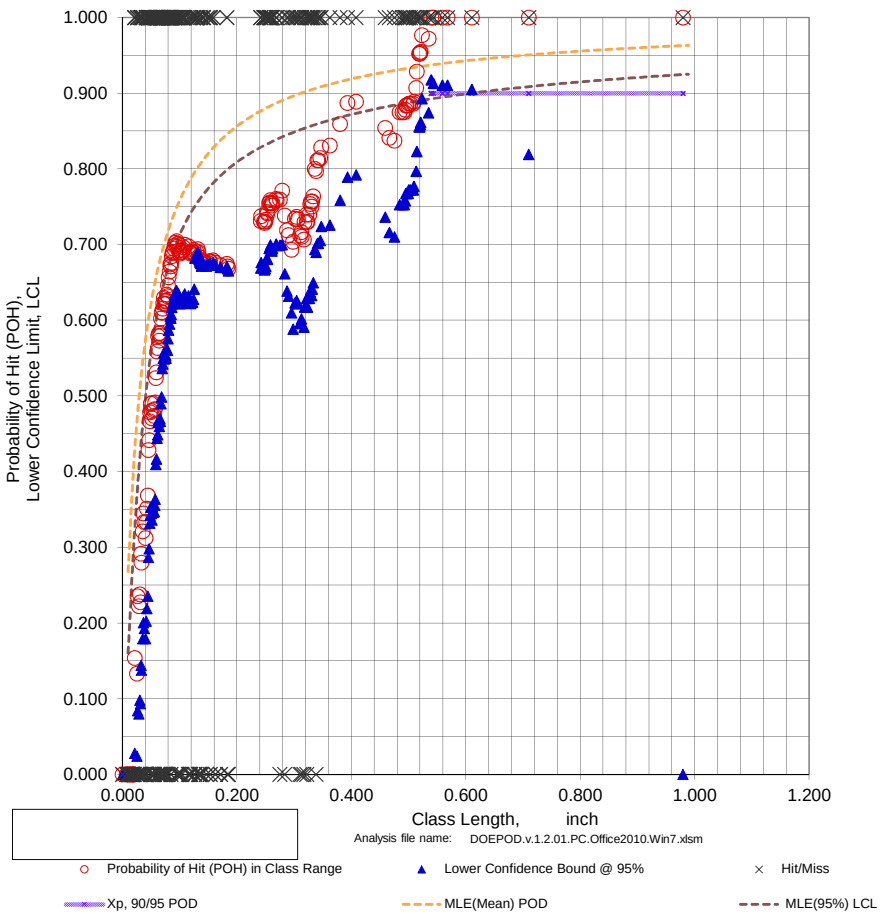
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.617.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **C1001CL.XLS**

Data Set Name = **C1001CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:42 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.5390 | inch |
| Lower Confidence Bound = | 0.9174 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.3400 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.315 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.610 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.710 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.537 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.5390 | inch |

File Name = C1001CL.XLS
Data Set Name = C1001CL(CRACK #)

## Directed DOE Options

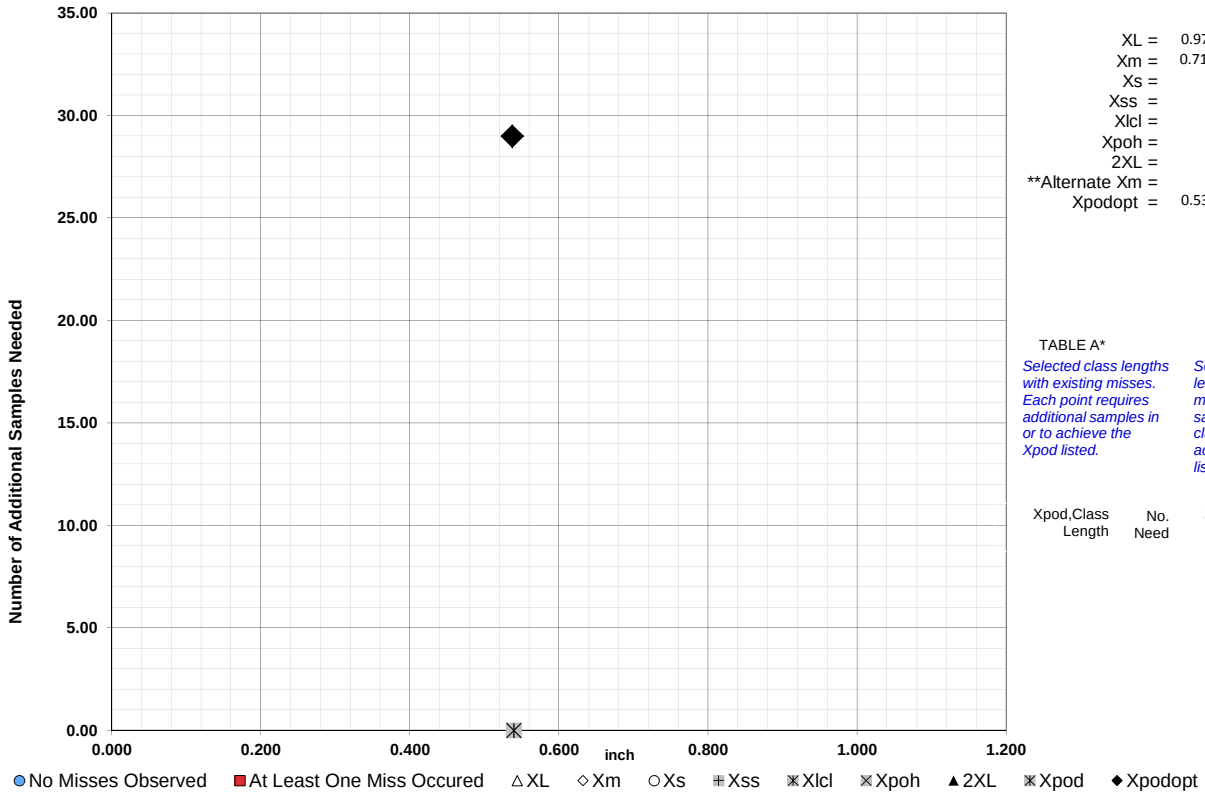



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | |
| Xm = | 0.710 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.537 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

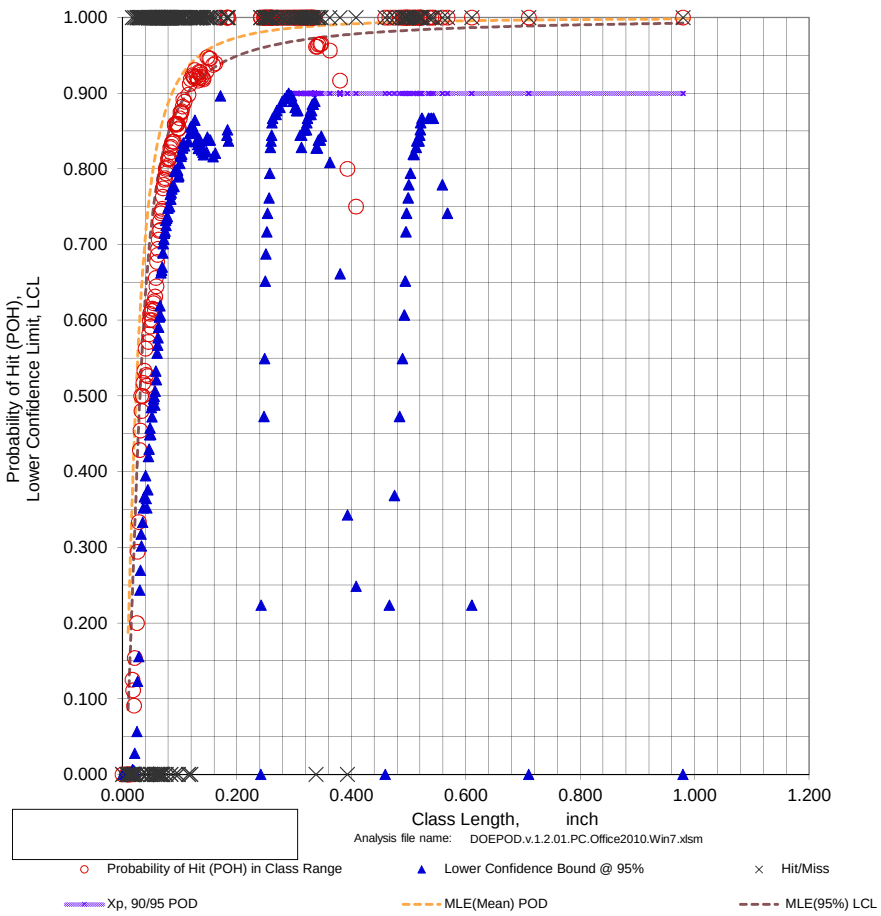
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 13 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C1002AL.XLS**

Data Set Name = **C1002AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:45 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0490 | inch |
| Classlength @ 90/95 Xpod = | 0.2900 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.543 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2900 | inch |

File Name = C1002AL.XLS
Data Set Name = C1002AL(CRACK #)

## Directed DOE Options

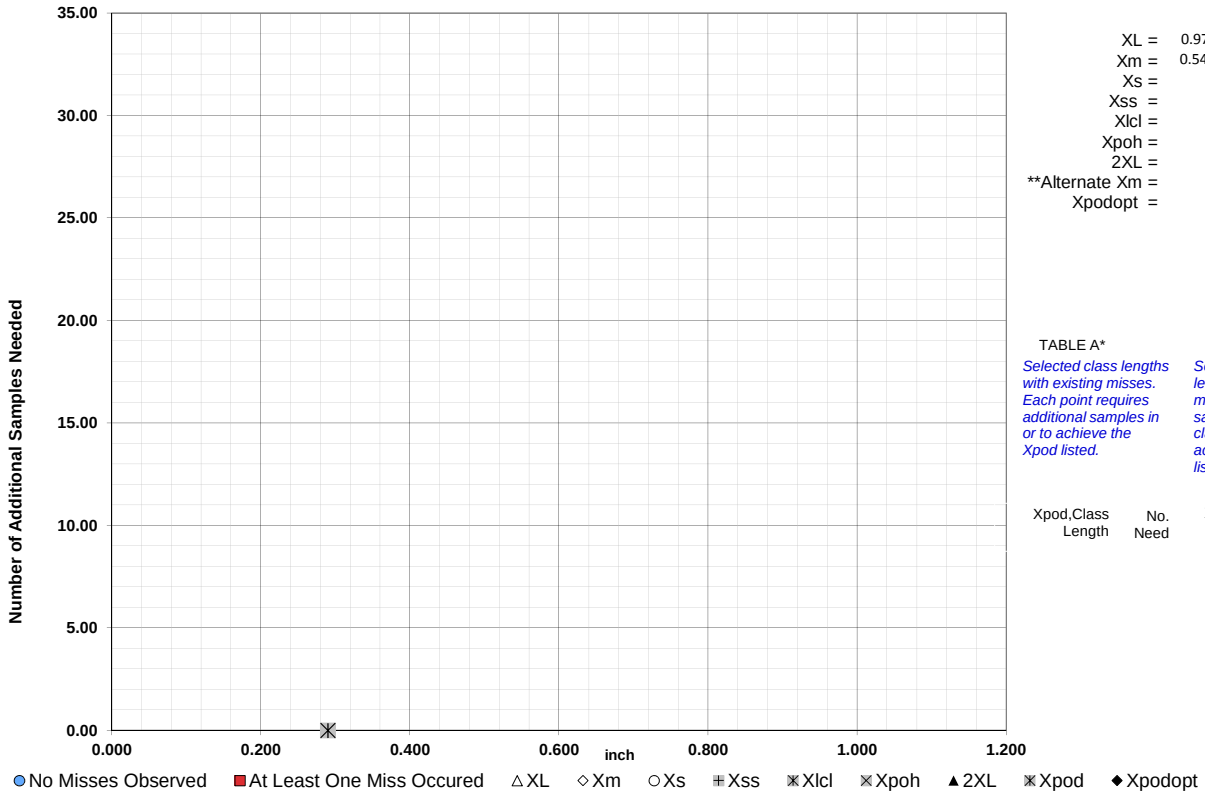



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.543 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

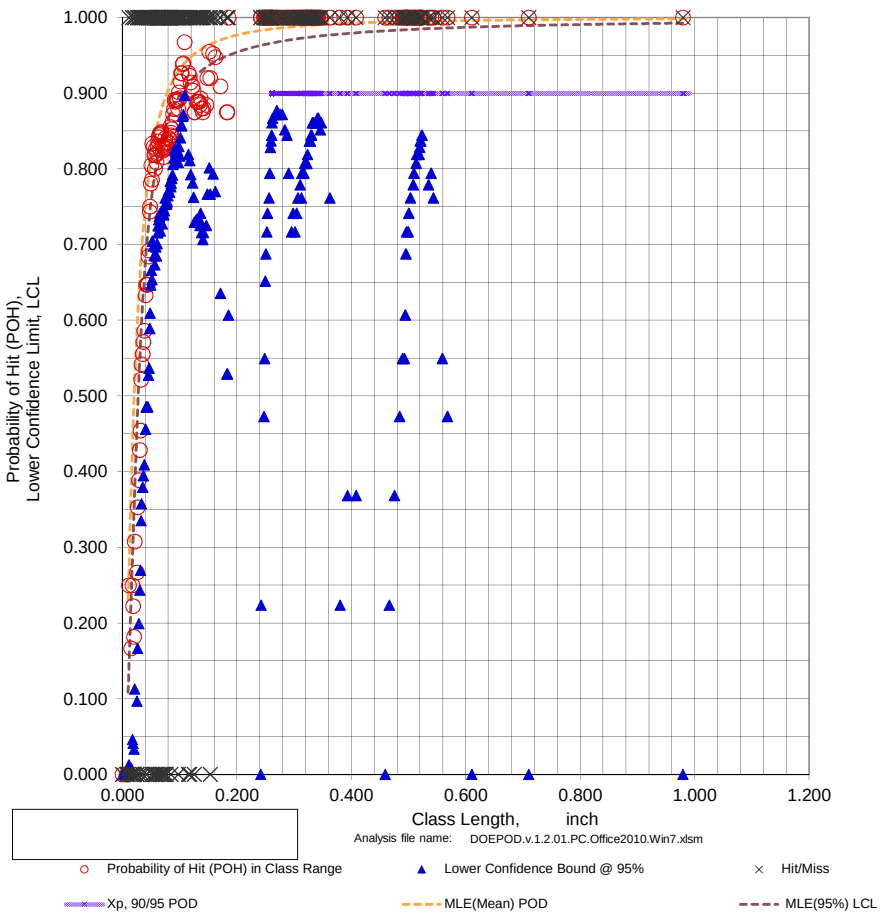
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C1002BL.XLS**

Data Set Name = **C1002BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:47 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0310 | inch |
| Classlength @ 90/95 Xpod = | 0.1080 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9672 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.342 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2610 | inch |

File Name = C1002BL.XLS
Data Set Name = C1002BL(CRACK #)

## Directed DOE Options

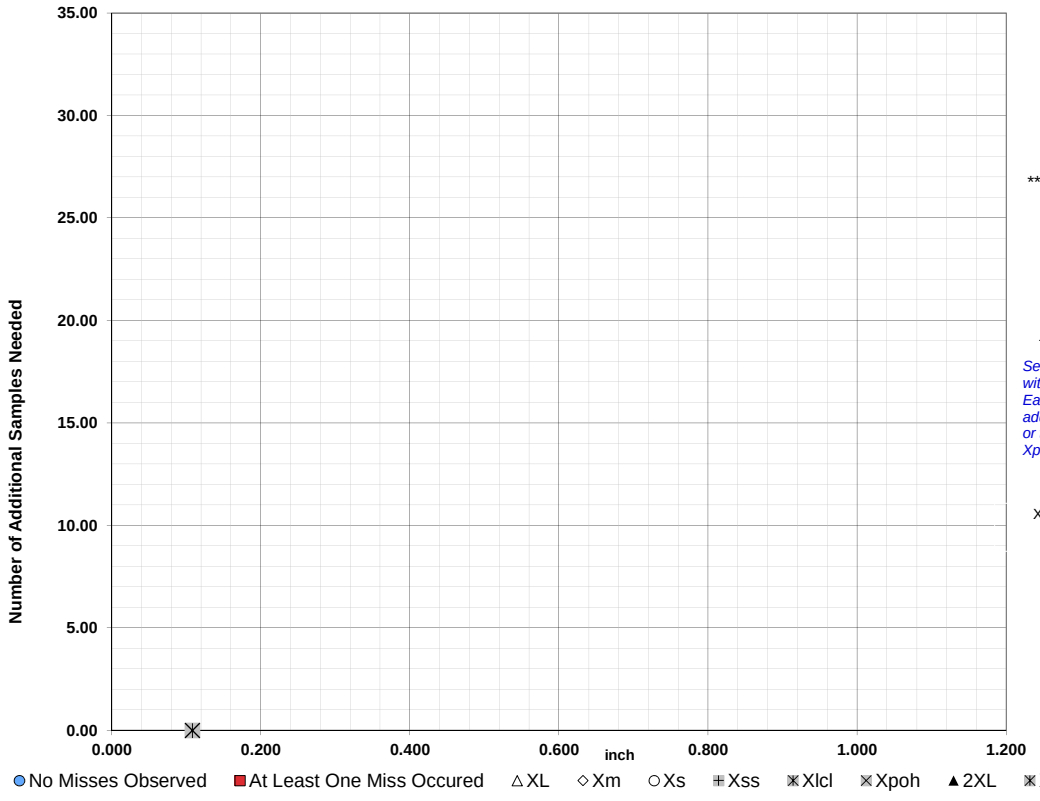



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.342 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 13 more large flaws.

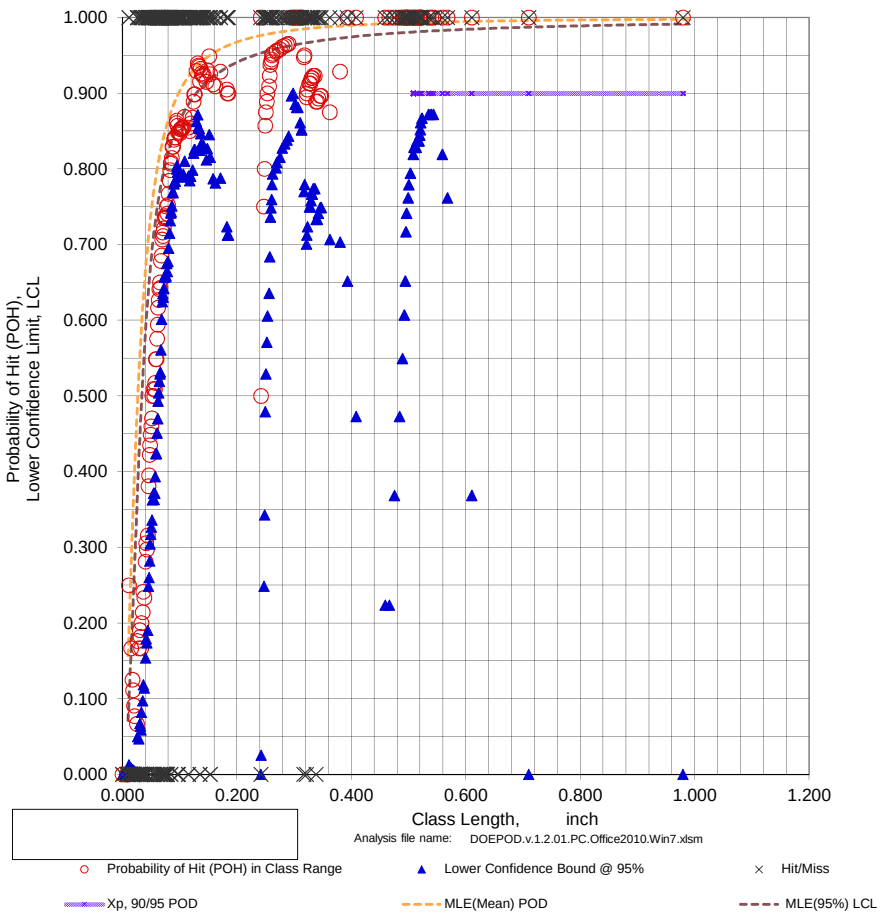
Any highlighted Misses are RED and shown in Column A of this data sheet

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = C1002CL.XLS

Data Set Name = C1002CL(CRACK #)




| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:49 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0510 | inch |
| Classlength @ 90/95 Xpod = | 0.2980 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.145 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.543 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.5080 | inch |

File Name = C1002CL.XLS
Data Set Name = C1002CL(CRACK #)

## Directed DOE Options

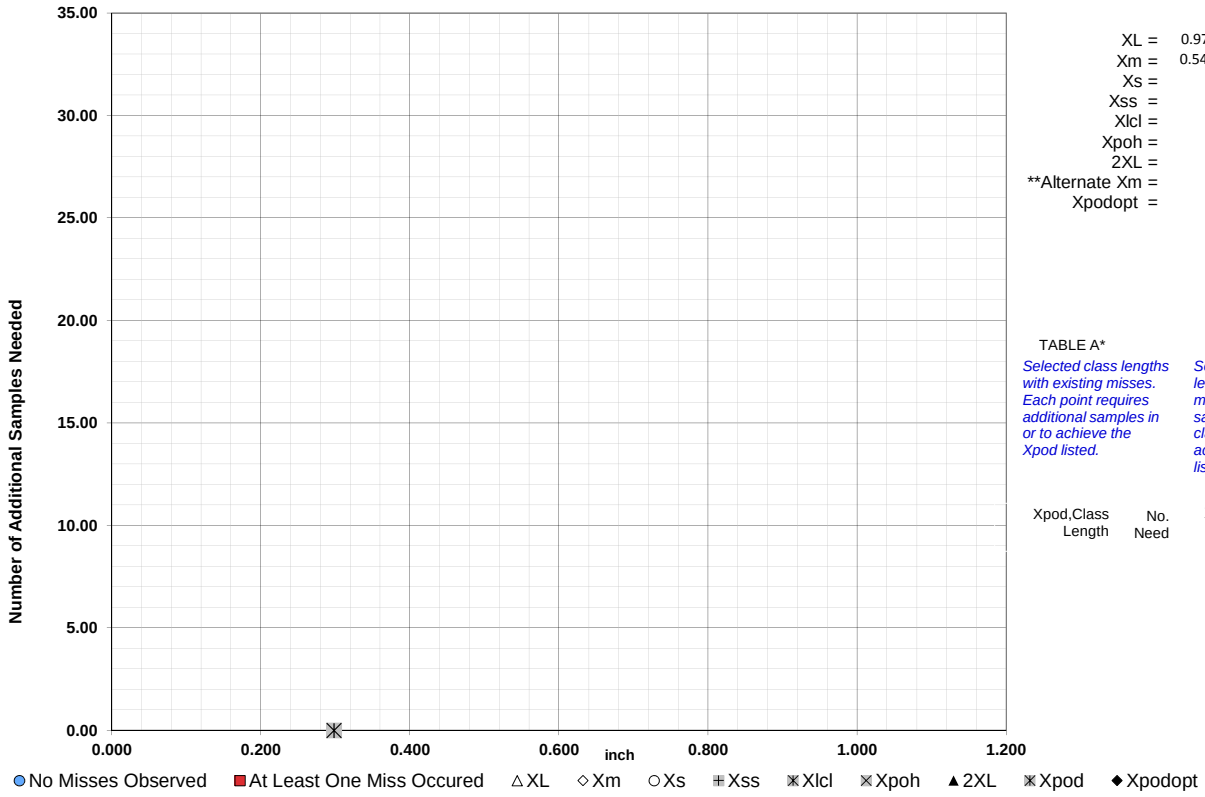



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.543 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 4 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

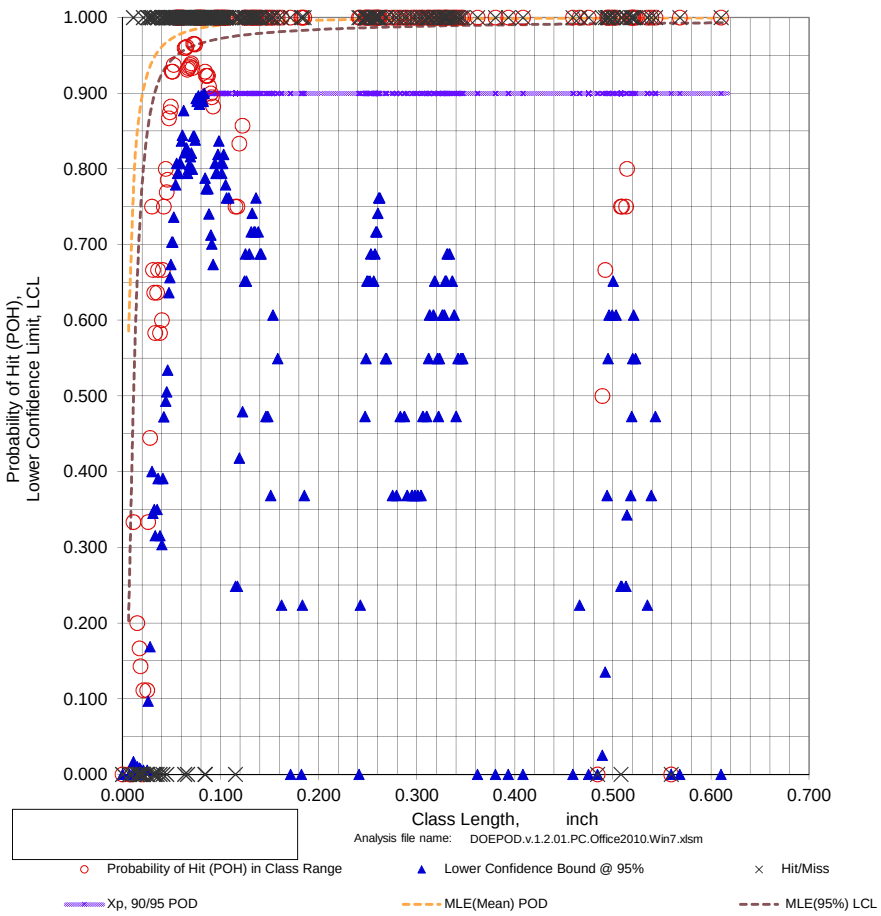
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **C1003AL.XLS**

Data Set Name = **C1003AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:51 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0080 | inch |
| Classlength @ 90/95 Xpod = | 0.0830 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.913 | @ | 0.020 | inch |
| NTIAC 90/95 POD = | 0.918 | @ | 0.035 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0860 | inch |

File Name = C1003AL.XLS
Data Set Name = C1003AL(CRACK #)

## Directed DOE Options

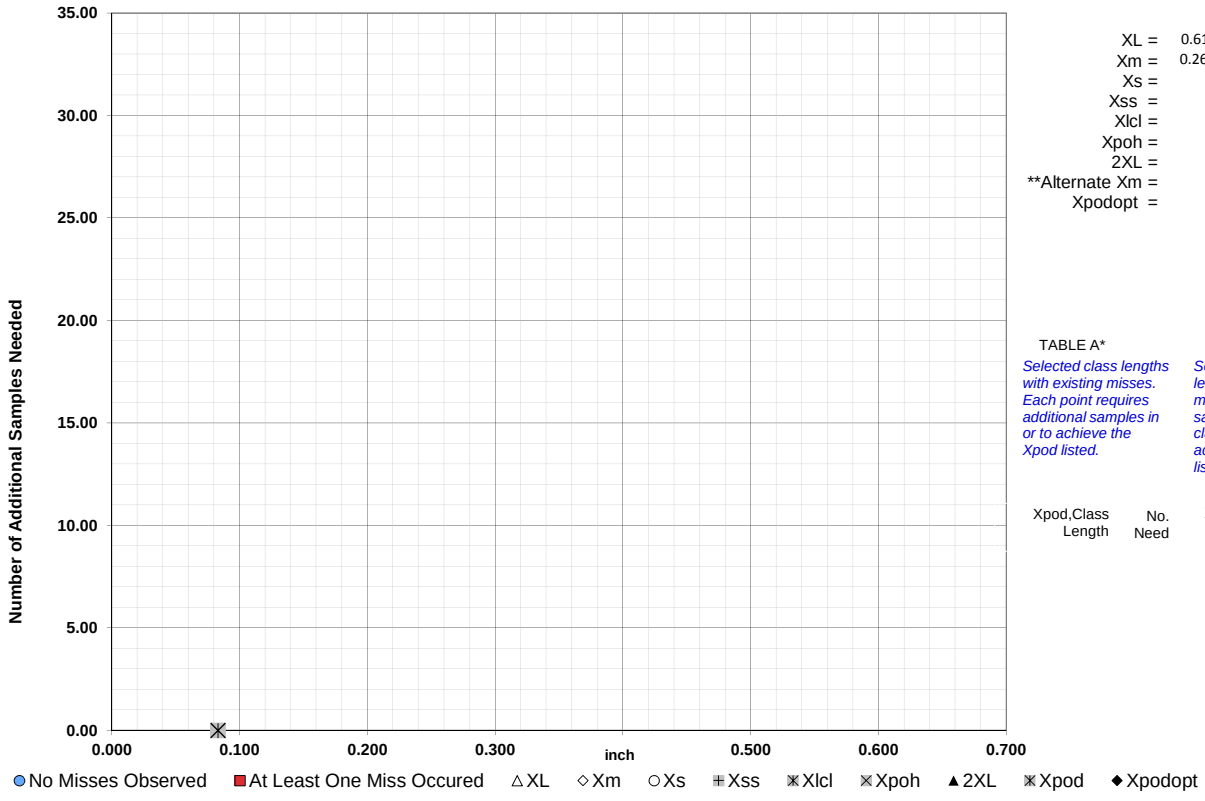



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.262 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

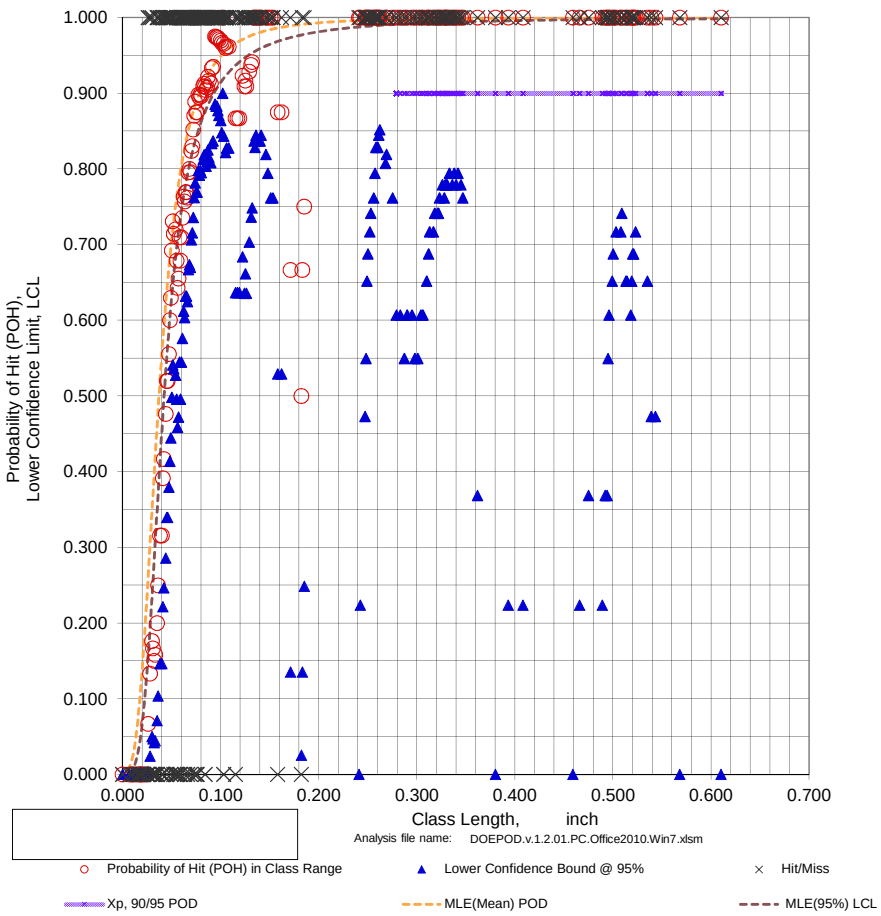
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 5 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C1003BL.XLS**

Data Set Name = **C1003BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:56 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0170 | inch |
| Classlength @ 90/95 Xpod = | 0.1020 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to satisfy XL requirements. Further VALIDATION is required. Recommend satisfying Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in T**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.095 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | 10 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2790 | inch |

File Name = C1003BL.XLS
Data Set Name = C1003BL(CRACK #)

## Directed DOE Options

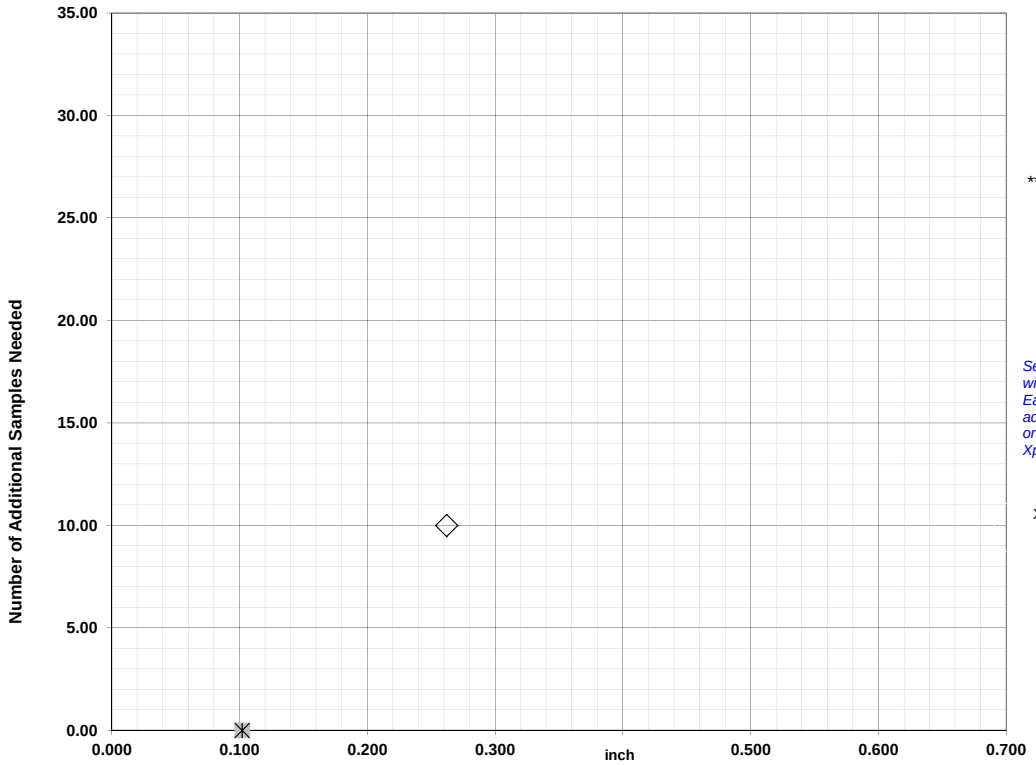



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.610 | |
| Xm = | 0.262 | 10 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

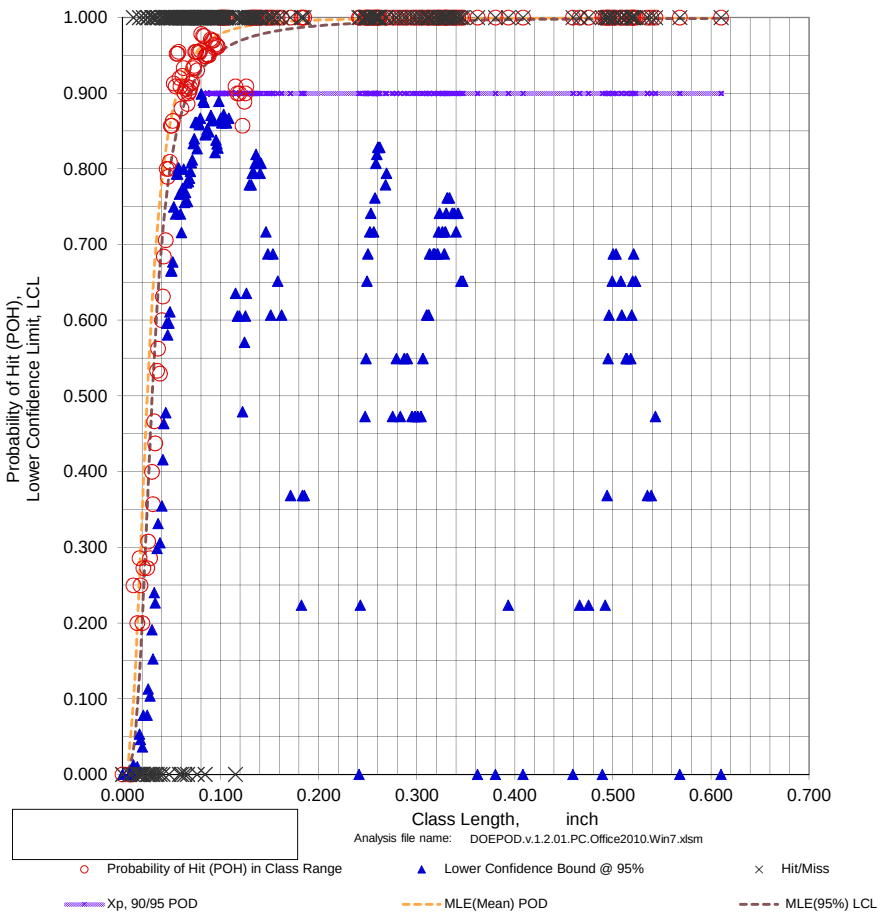
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 5 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C1003CL.XLS**

Data Set Name = **C1003CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 8:57 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0130 | inch |
| Classlength @ 90/95 Xpod = | 0.0800 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.918 | @ | 0.060 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.070 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0860 | inch |

File Name = C1003CL.XLS
Data Set Name = C1003CL(CRACK #)

## Directed DOE Options

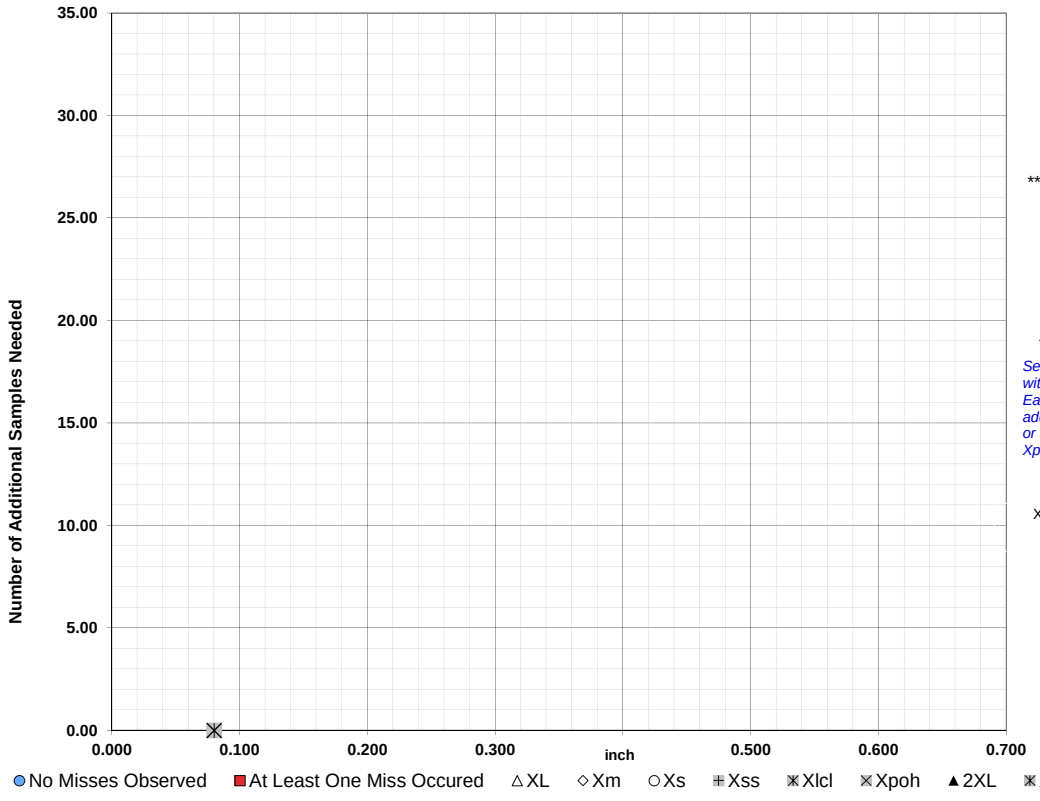



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.262 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

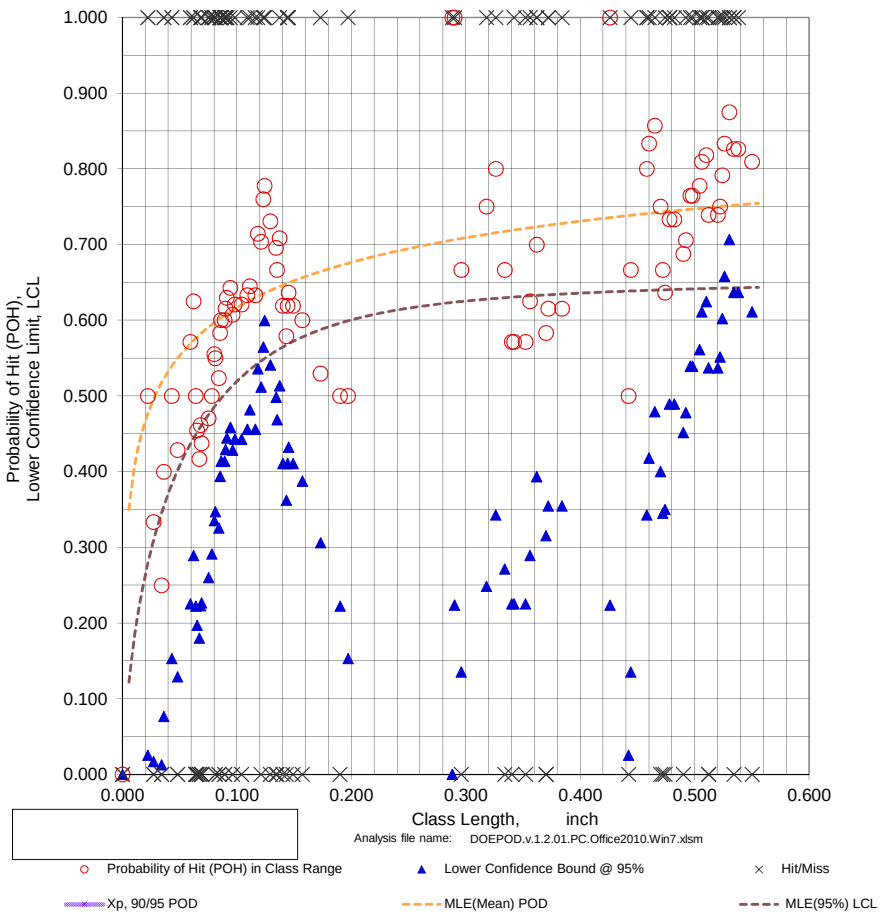
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C2002AL.XLS
Data Set Name = C2002AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:01 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7066 | |
| Classwidth @ Best LCL = | 0.0520 | inch |
| Classlength @ Best LCL = | 0.5300 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.100 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C2002AL.XLS
Data Set Name = C2002AL(CRACK #)

## Directed DOE Options

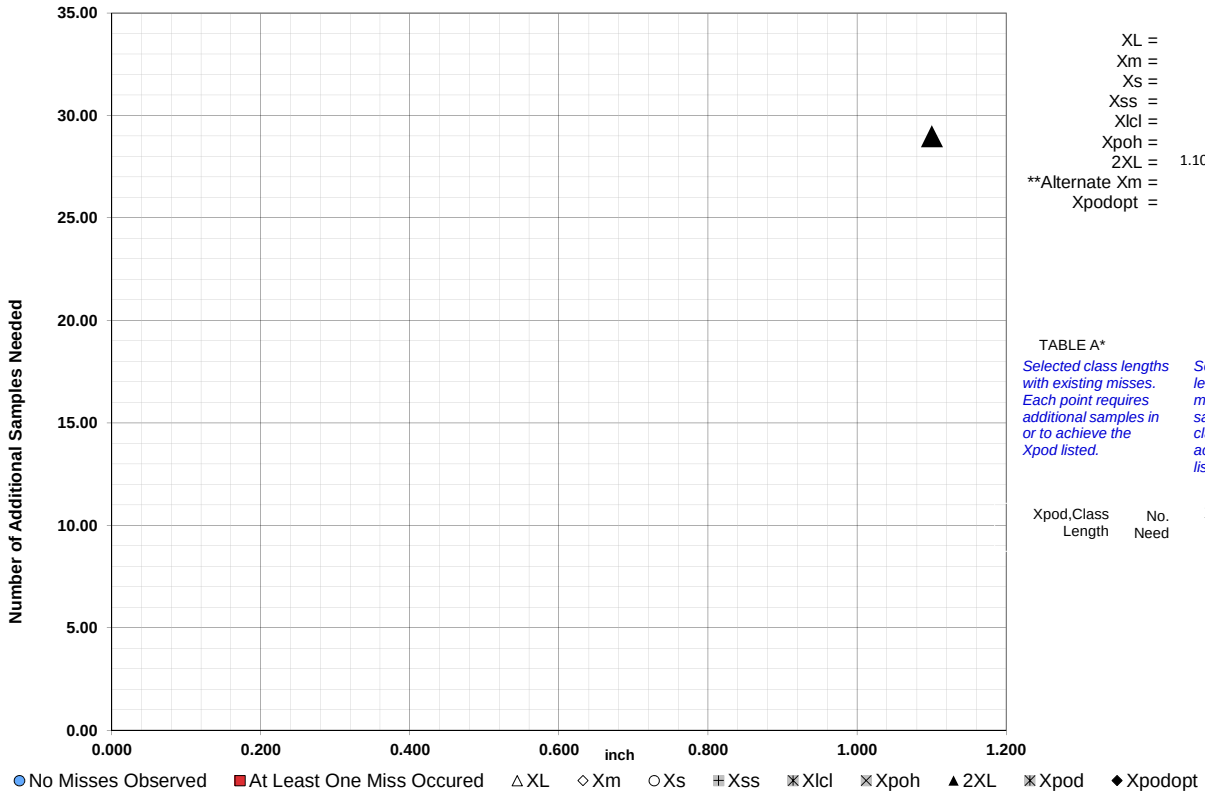



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.100 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

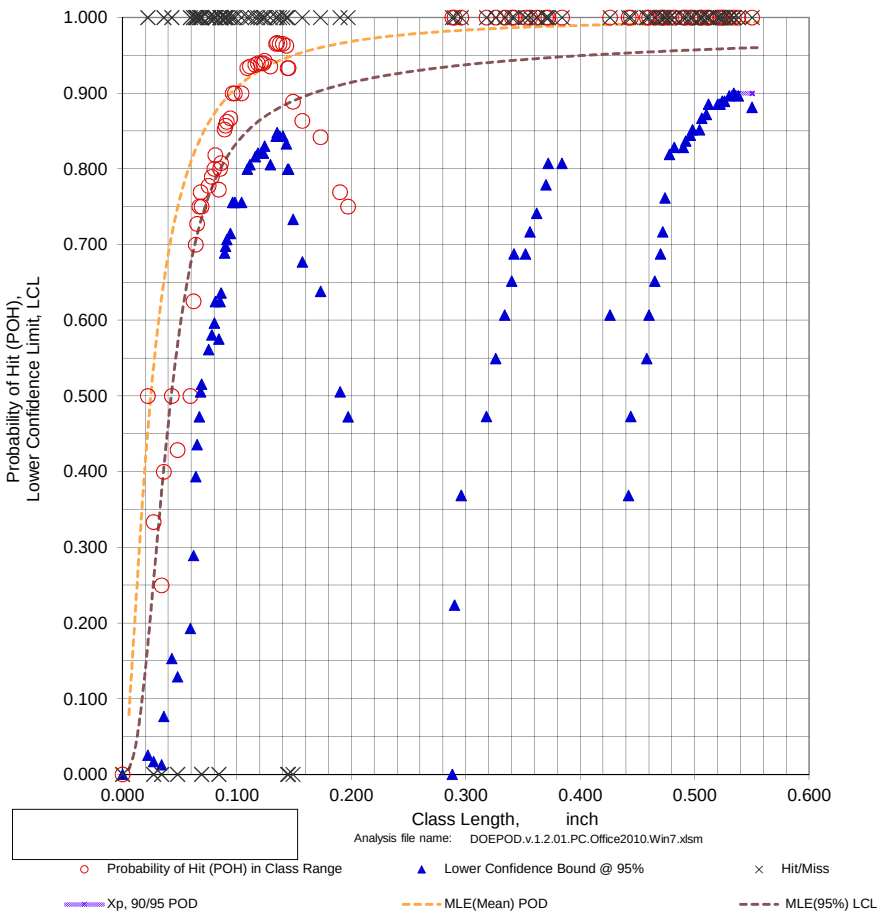
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.602.**

**Warning: No false call analysis.**




File Name = **C2002BL.XLS**

Data Set Name = **C2002BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:02 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0600 | inch |
| Classlength @ 90/95 Xpod = | 0.5340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1570 -0.007 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.170 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.538 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.288 | inch |
| Samples Needed @Xpodopt = | 28 | |
| Xp = | 0.5340 | inch |

File Name = C2002BL.XLS
Data Set Name = C2002BL(CRACK #)

## Directed DOE Options

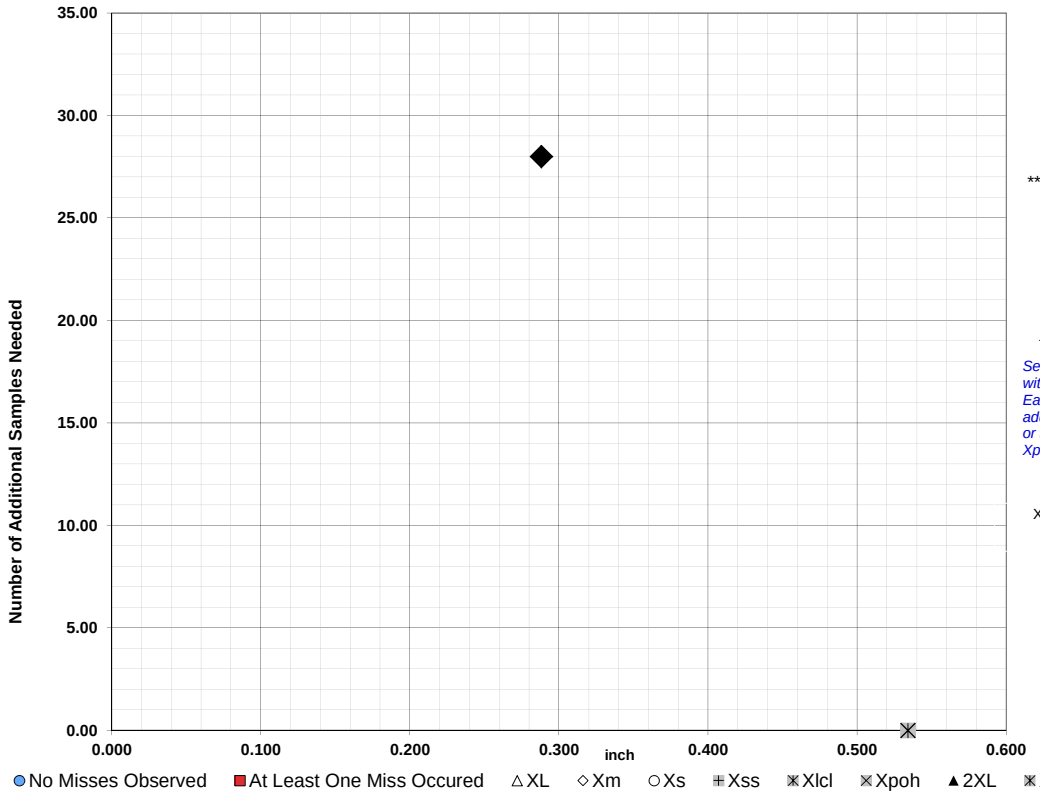



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | |
| Xm = | 0.538 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.288 | 28 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

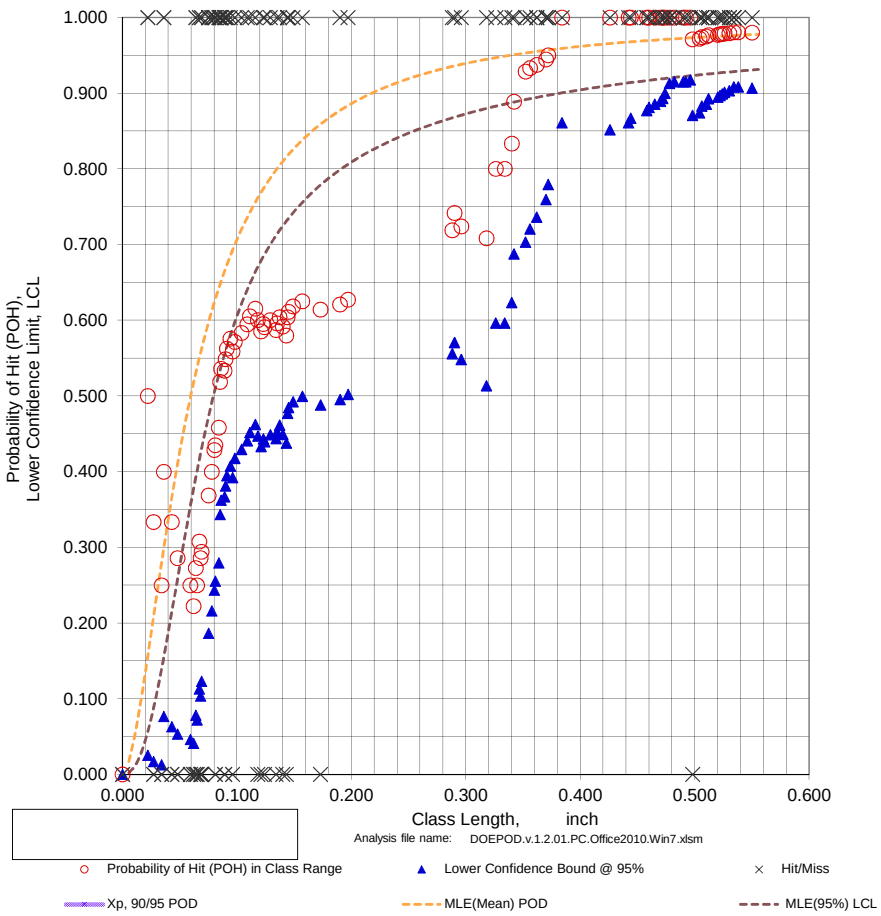
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.422.**

**Warning: No false call analysis.**




File Name = **C2002CL.XLS**

Data Set Name = **C2002CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:03 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.4740 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.220 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.385 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | 0 | |
| Classlength Mid-point , Xm = | 0.496 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C2002CL.XLS
Data Set Name = C2002CL(CRACK #)

## Directed DOE Options

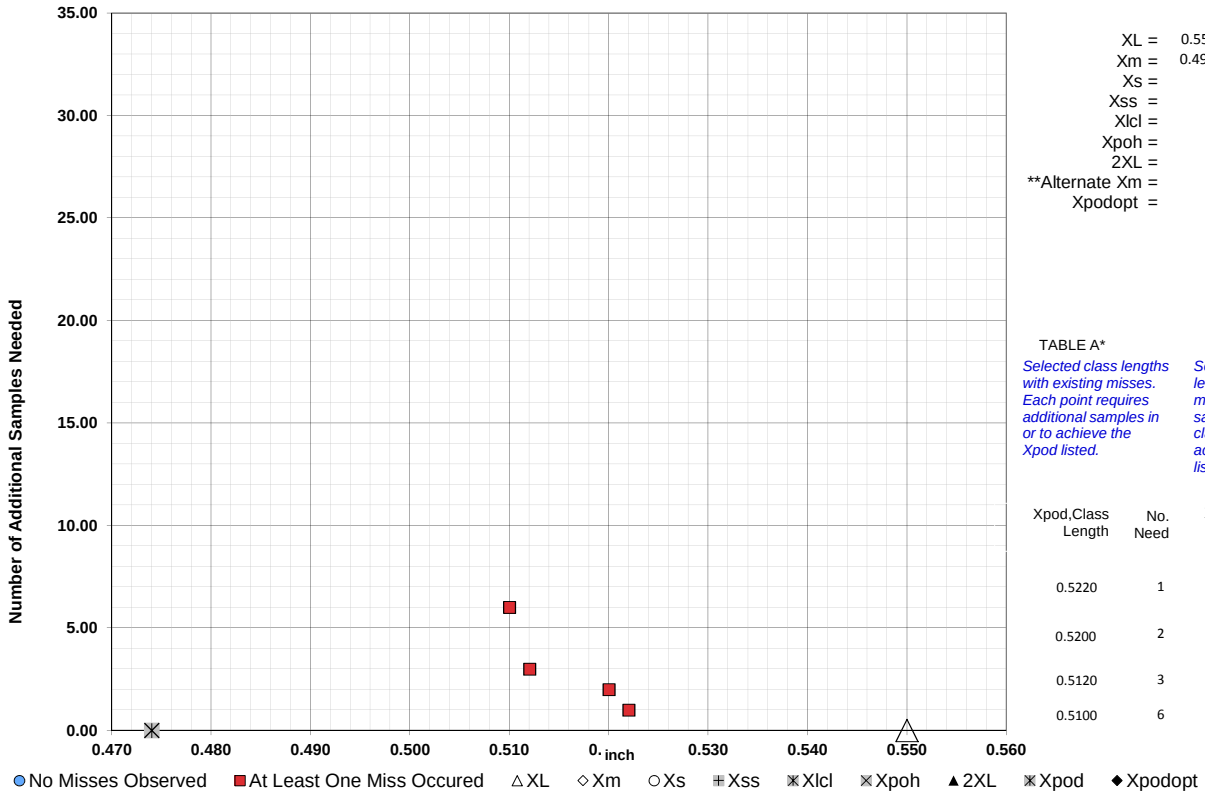



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | 0 |
| Xm = | 0.496 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5220 | 1 |
| 0.5200 | 2 |
| 0.5120 | 3 |
| 0.5100 | 6 |

TABLE B*

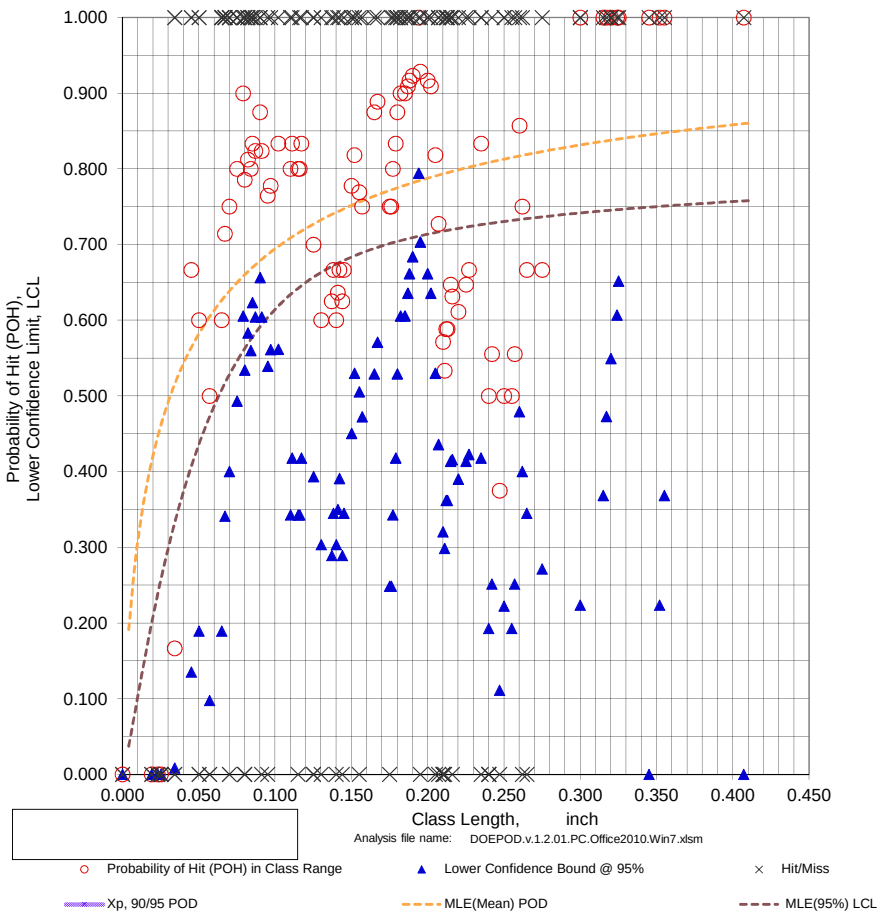
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C3001AL.XLS
Data Set Name = C3001AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:04 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0180 | inch |
| Classlength @ Best LCL = | 0.1940 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2750 -0.009 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.705 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.300 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C3001AL.XLS
Data Set Name = C3001AL(CRK #)

## Directed DOE Options

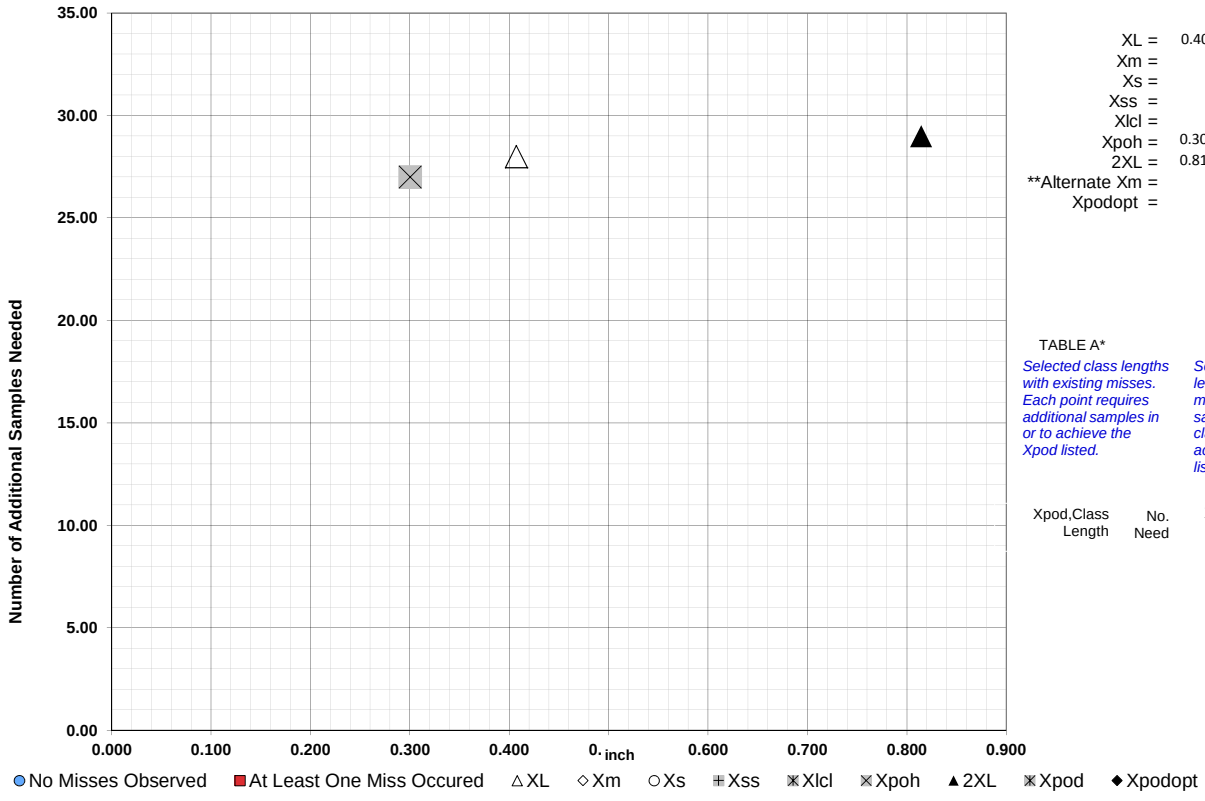



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.300 | 27 |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

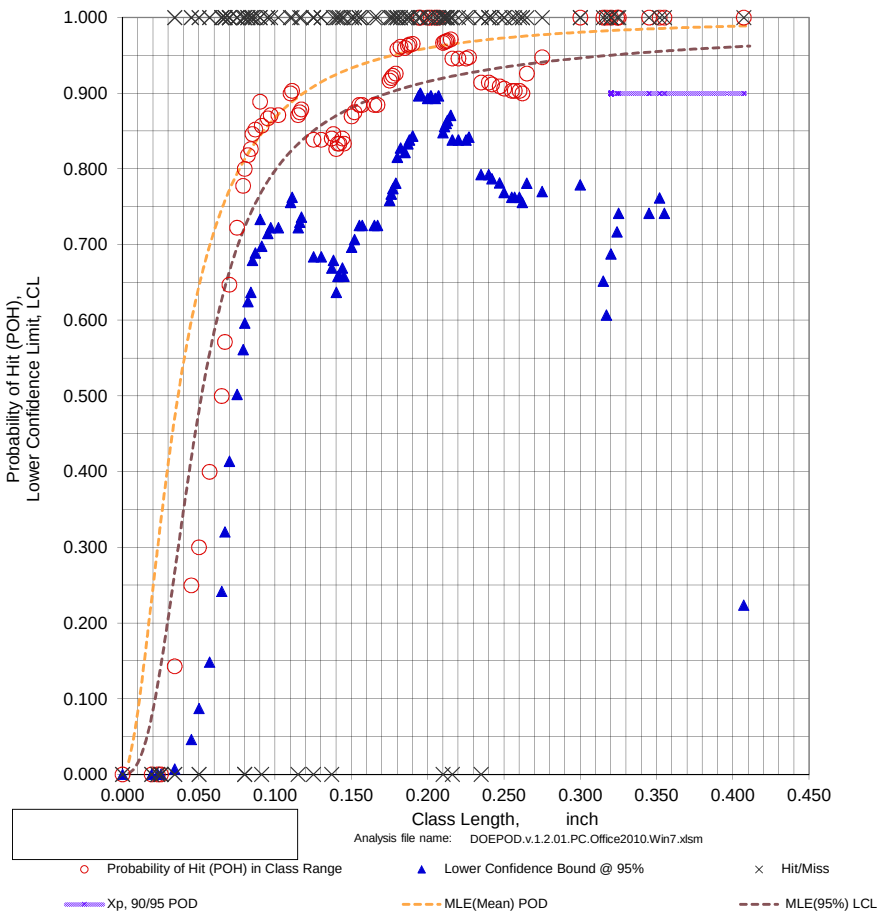
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.585.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C3001BL.XLS**

Data Set Name = **C3001BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:06 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0540 | inch |
| Classlength @ 90/95 Xpod = | 0.1950 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to satisfy XL requirements. Further VALIDATION is required. Recommend satisfying Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in T**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.120 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.175 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.300 | inch |
| Samples Needed @ Xm = | 17 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3200 | inch |

File Name = C3001BL.XLS
Data Set Name = C3001BL(CRK #)

## Directed DOE Options

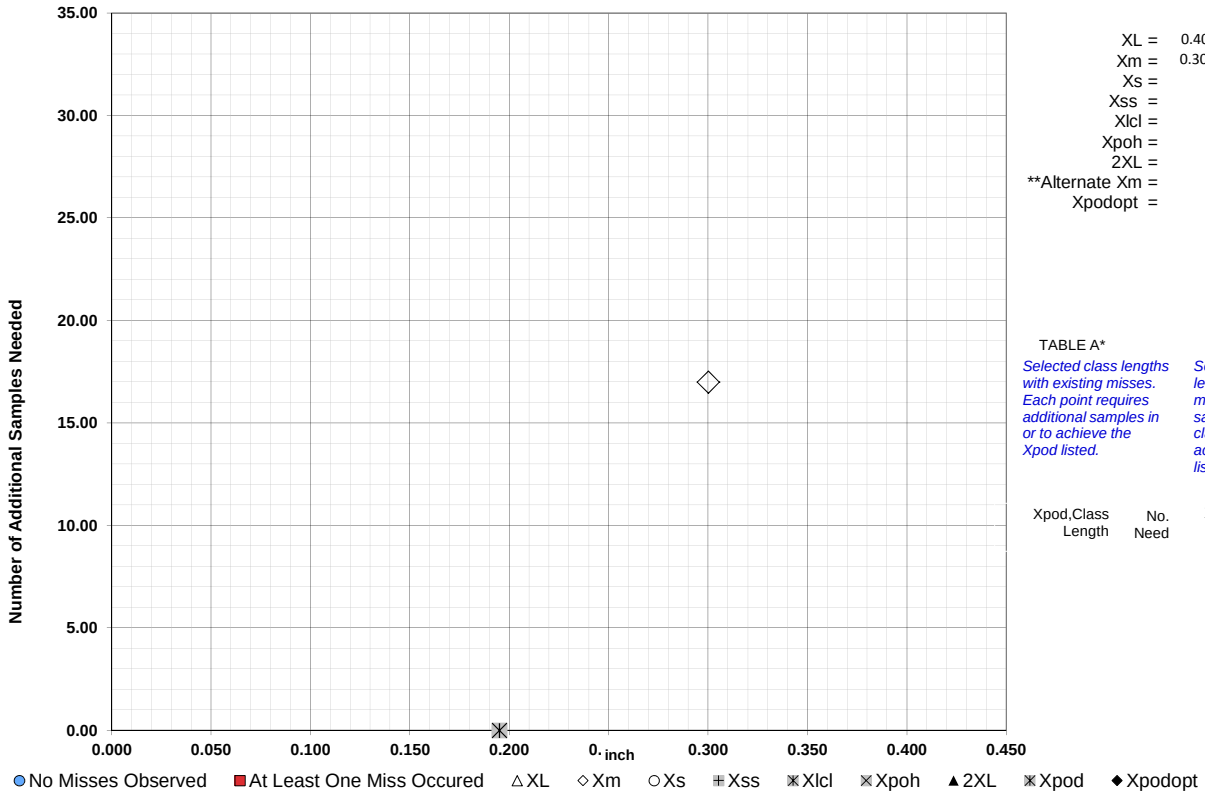



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.300 | 17 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

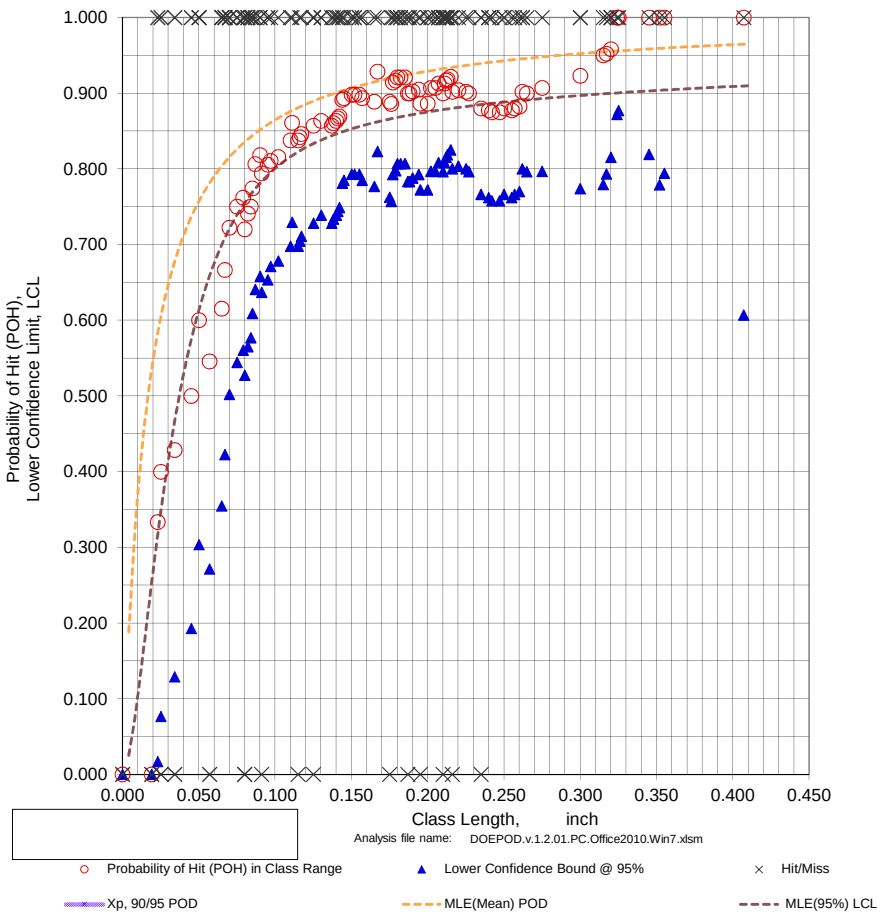
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C3001CL.XLS
Data Set Name = C3001CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:07 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8768 | |
| Classwidth @ Best LCL = | 0.0850 | inch |
| Classlength @ Best LCL = | 0.3250 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2400 -0.004 inch 26 Samples

NTIAC 90% POD = 0.901 @ 0.140 inch
NTIAC 90/95 POD = 0.901 @ 0.325 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.325 | inch |
| Samples Needed @ Xlcl = | 6 | |
| POH Classlength, Xpoh = | 0.324 | inch |
| Samples Needed @ Xpoh = | 7 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C3001CL.XLS
Data Set Name = C3001CL(CRK #)

## Directed DOE Options

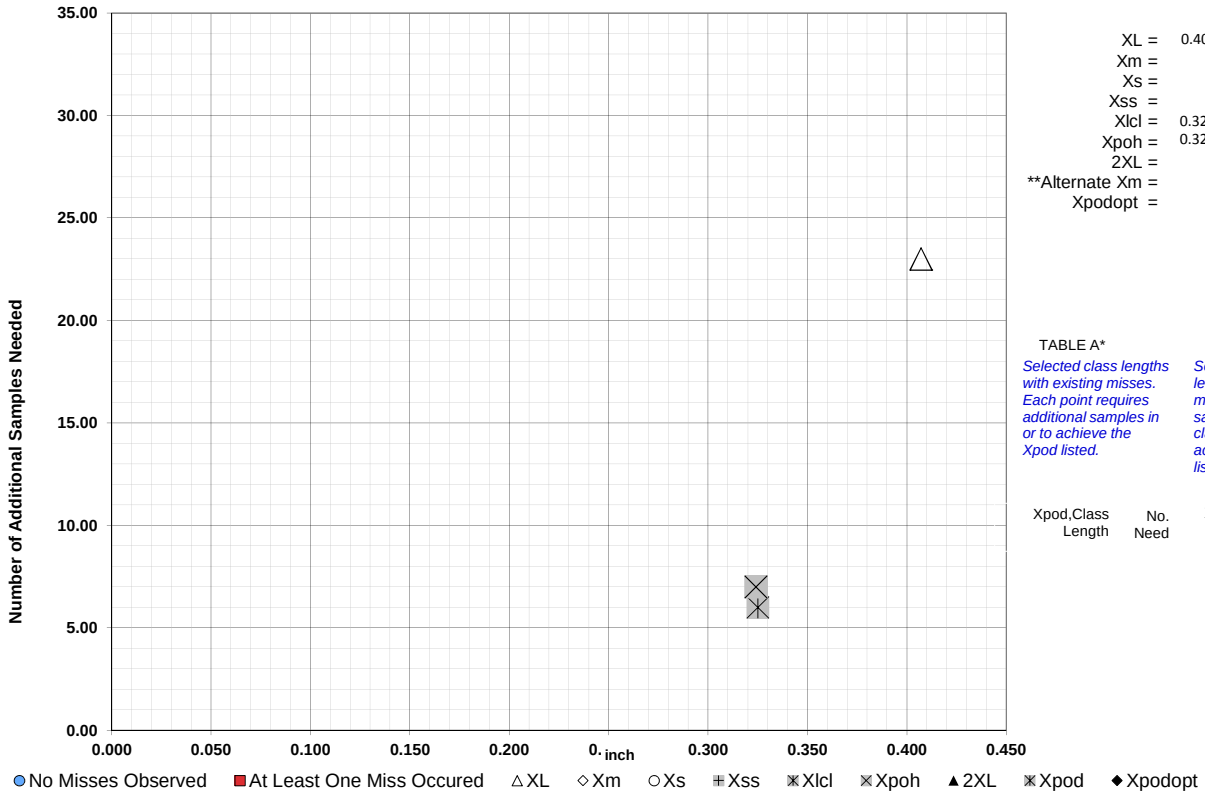



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | 23 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.325 | 6 |
| Xpoh = | 0.324 | 7 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

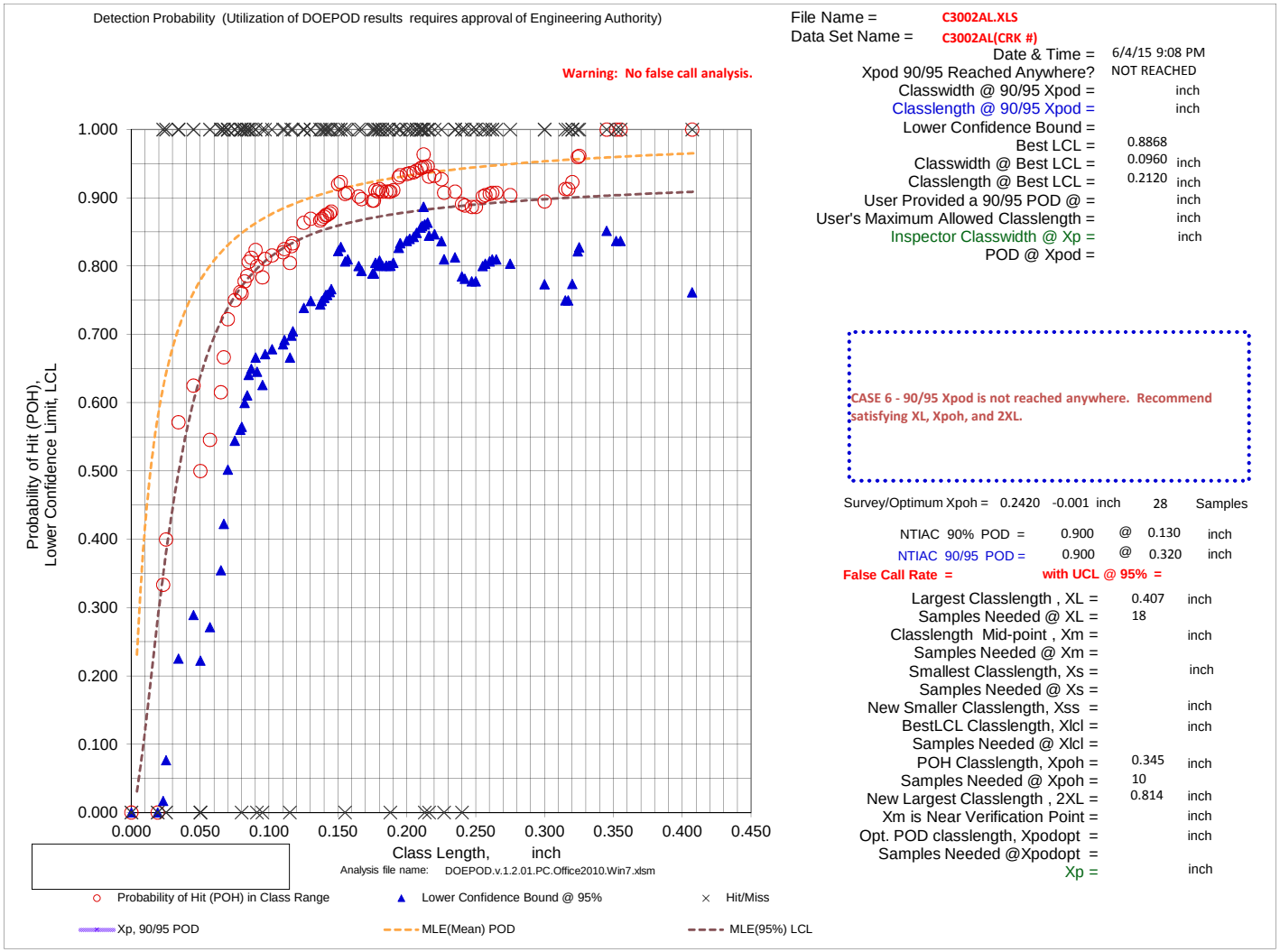
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = C3002AL.XLS
Data Set Name = C3002AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:08 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8868 | |
| Classwidth @ Best LCL = | 0.0960 | inch |
| Classlength @ Best LCL = | 0.2120 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2420 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.130 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.320 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | 18 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.345 | inch |
| Samples Needed @ Xpoh = | 10 | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C3002AL.XLS
Data Set Name = C3002AL(CRK #)

## Directed DOE Options

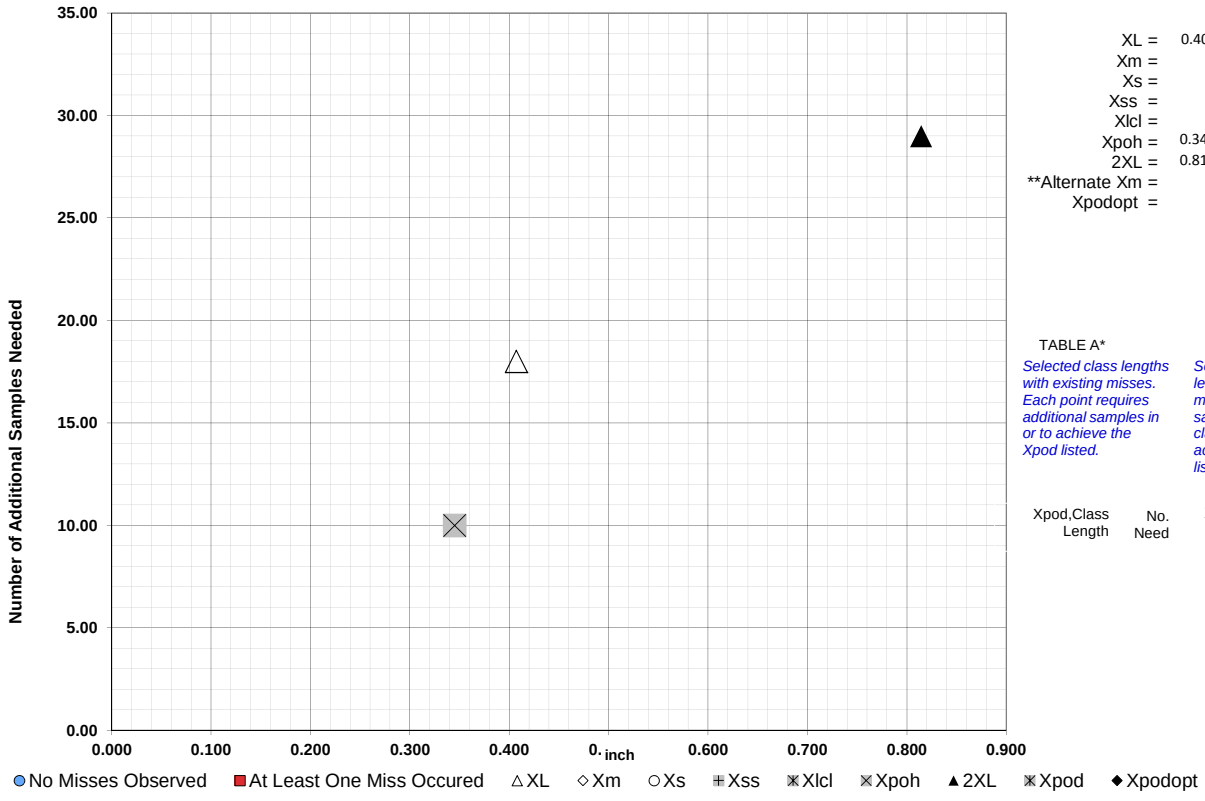



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | 18 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.345 | 10 |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

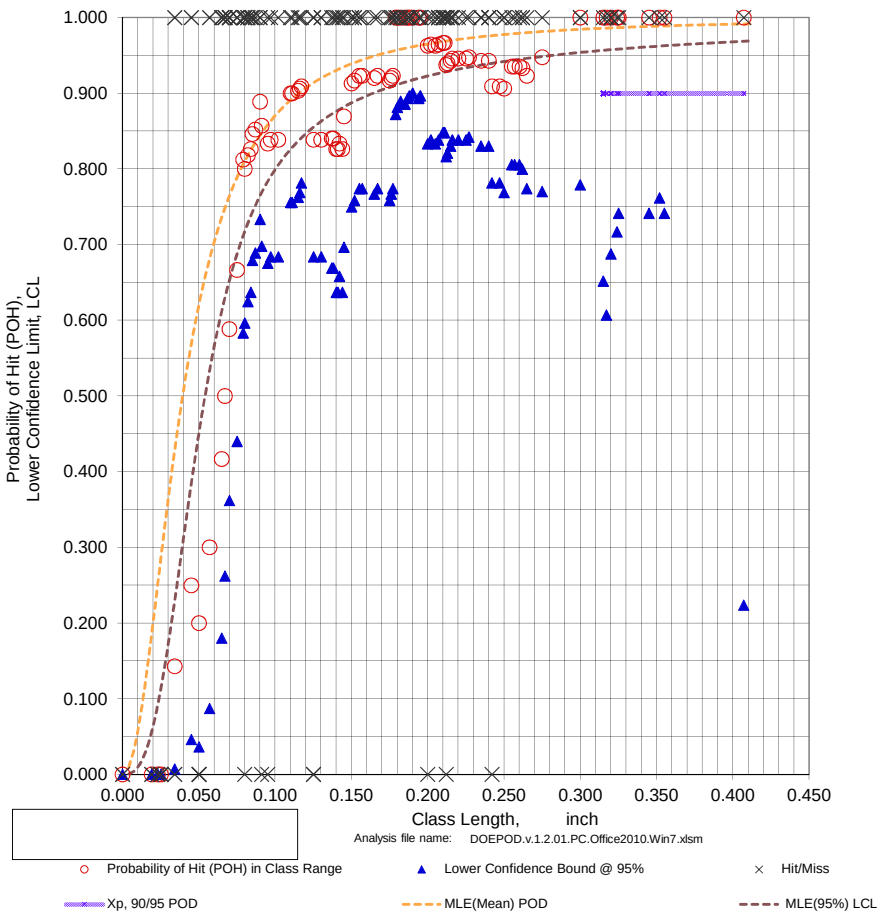
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.57.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C3002BL.XLS**

Data Set Name = **C3002BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:10 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0530 | inch |
| Classlength @ 90/95 Xpod = | 0.1900 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to satisfy XL requirements. Further VALIDATION is required. Recommend satisfying Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in T**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.120 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.165 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.300 | inch |
| Samples Needed @ Xm = | 17 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3150 | inch |

File Name = C3002BL.XLS
Data Set Name = C3002BL(CRK #)

## Directed DOE Options

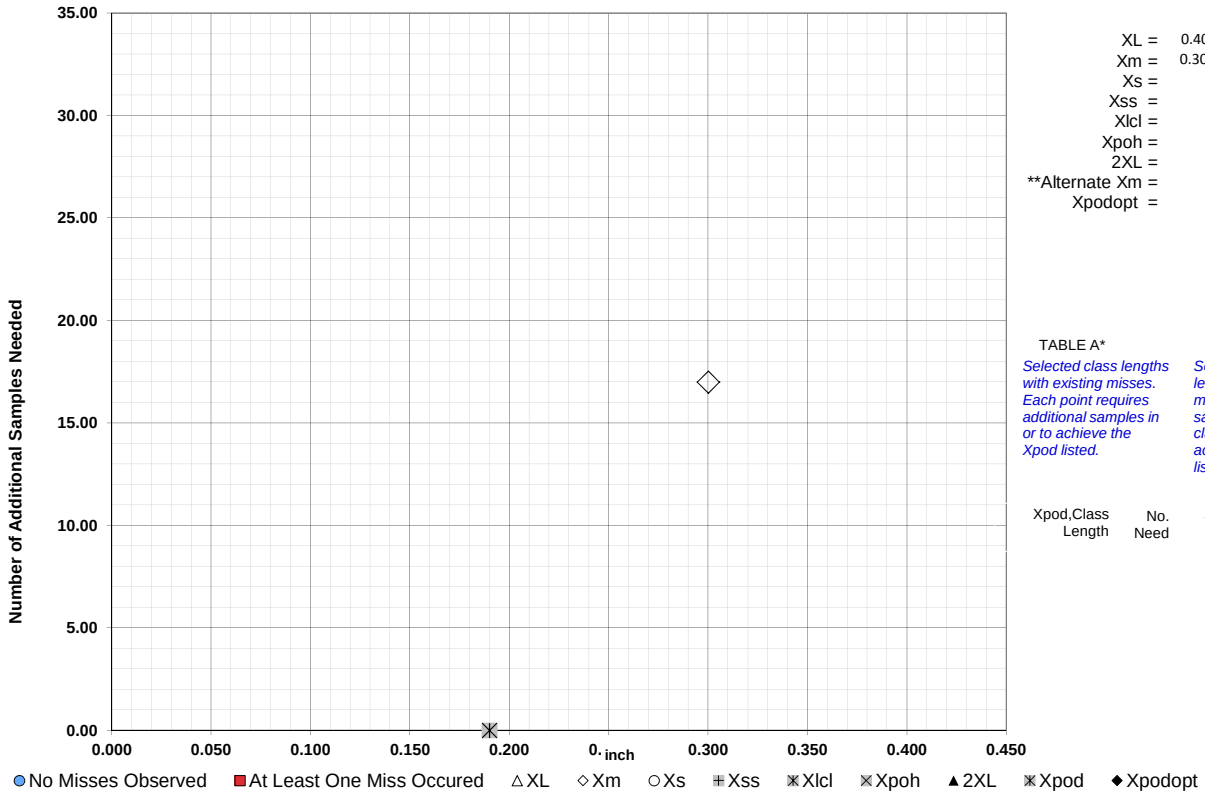



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.300 | 17 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.648.**

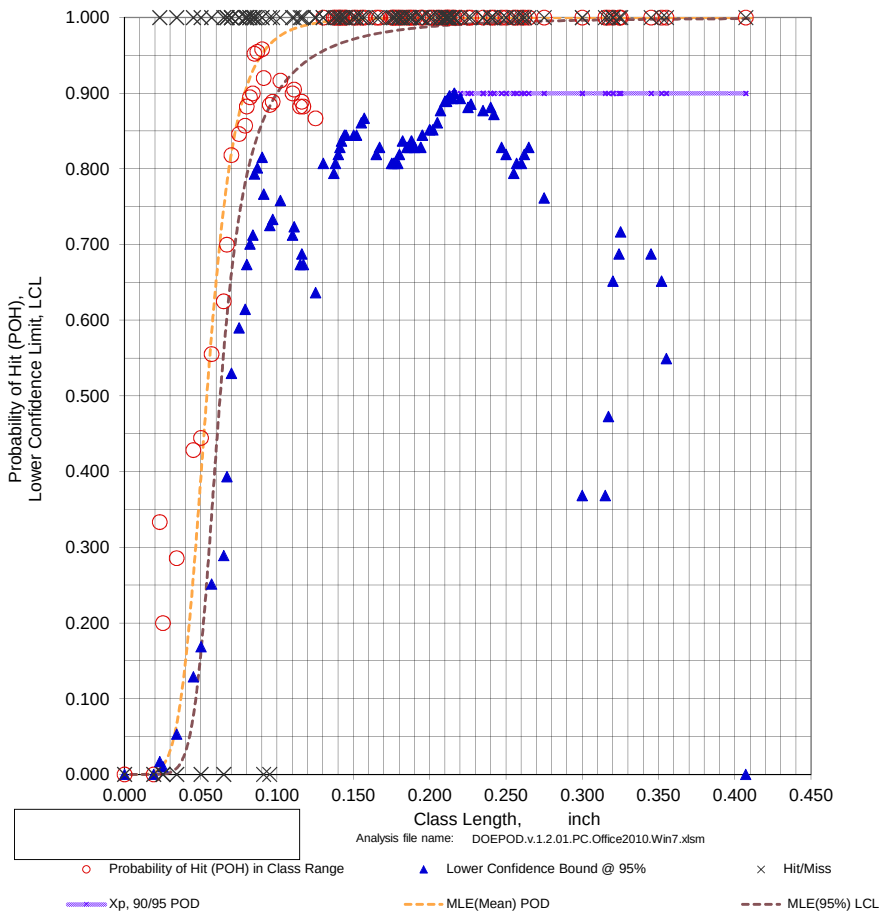
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **C3002CL.XLS**

Data Set Name = **C3002CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:11 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0340 | inch |
| Classlength @ 90/95 Xpod = | 0.2160 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0970 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.916 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.100 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.265 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.130 | inch |
| Samples Needed @Xpodopt = | 15 | |
| Xp = | 0.2160 | inch |

File Name = C3002CL.XLS
Data Set Name = C3002CL(CRK #)

## Directed DOE Options

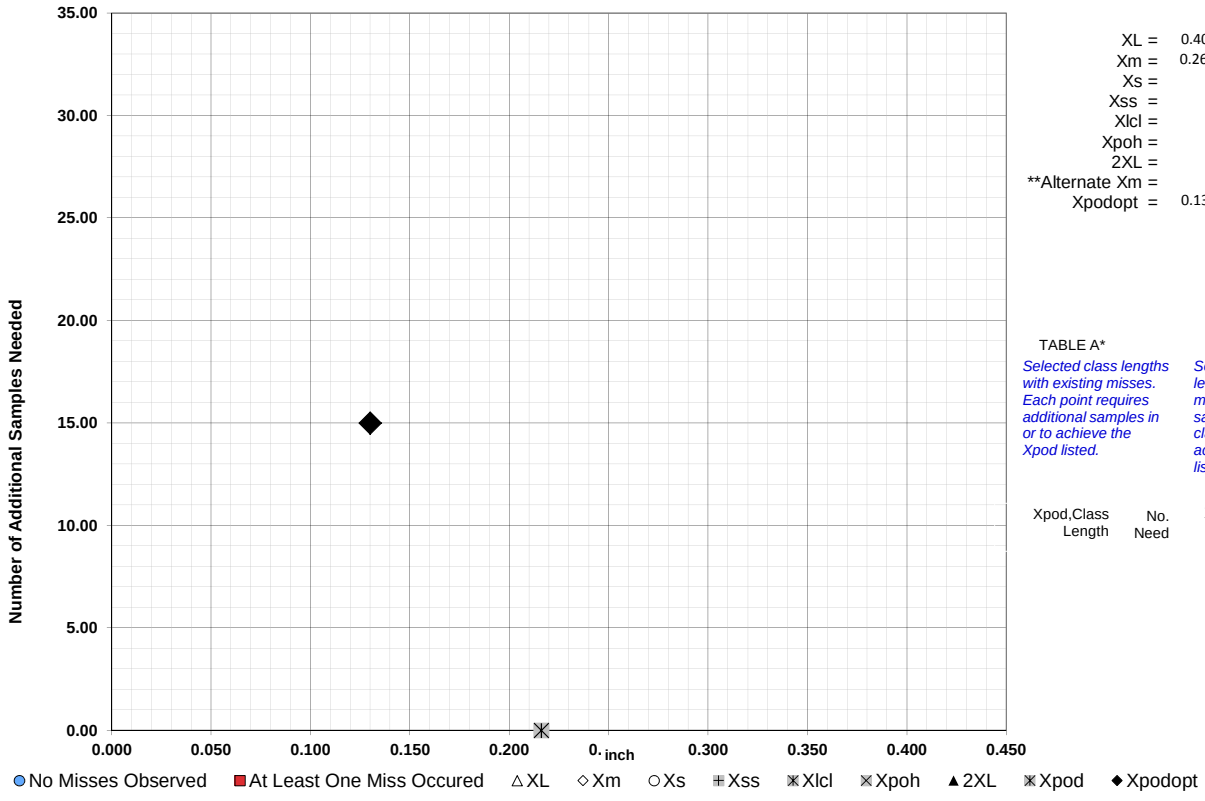



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.265 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.130 | 15 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

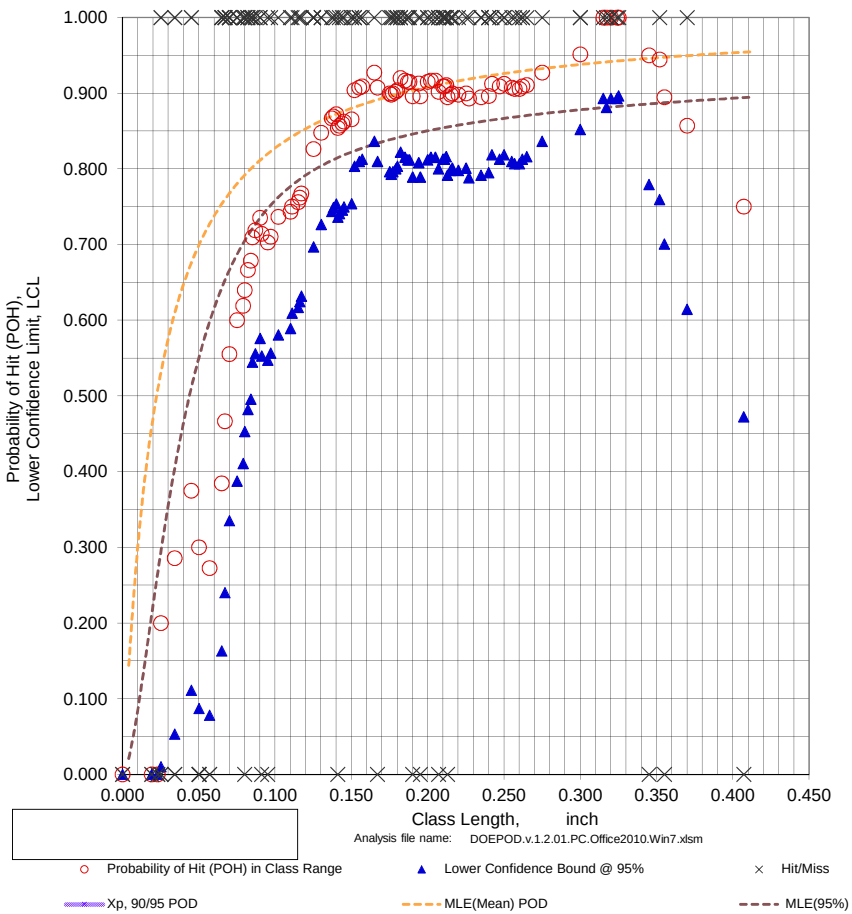
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C3003AL.XLS
Data Set Name = C3003AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:12 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8965 | |
| Classwidth @ Best LCL = | 0.1000 | inch |
| Classlength @ Best LCL = | 0.3250 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.465 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C3003AL.XLS
Data Set Name = C3003AL(CRK #)

## Directed DOE Options

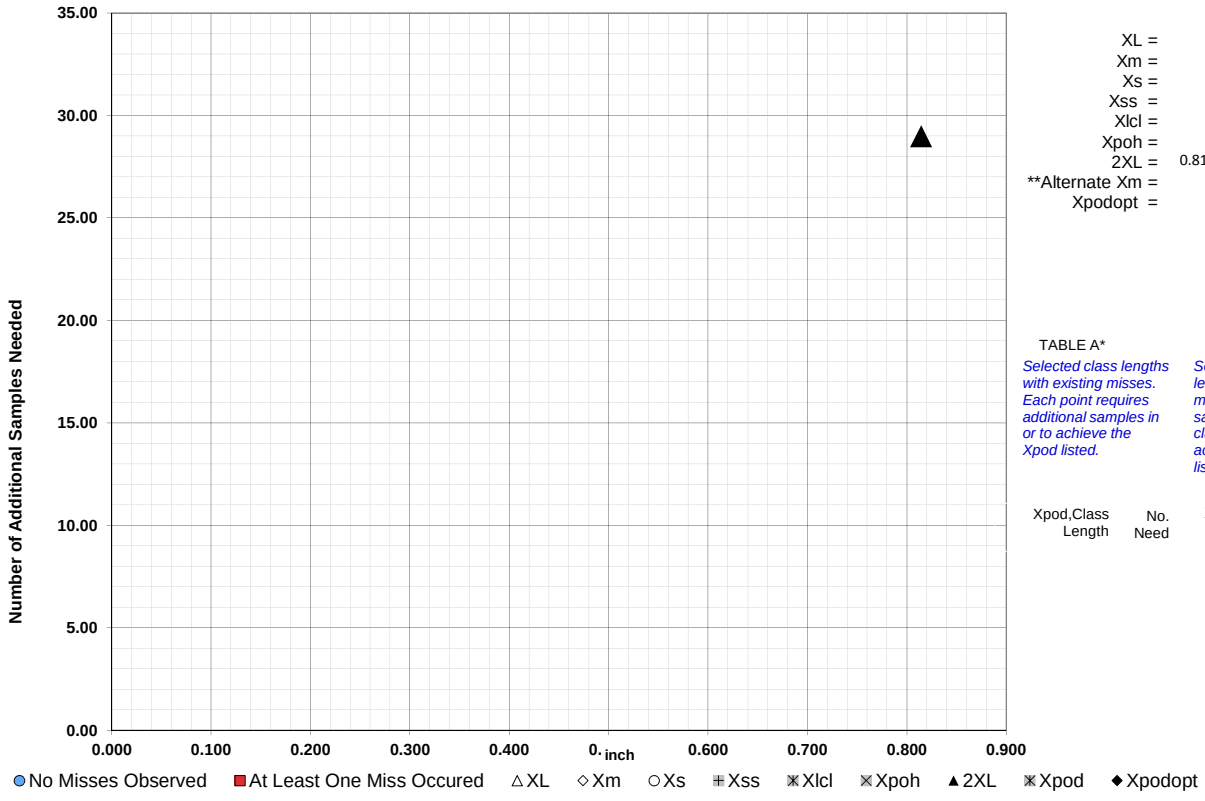



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

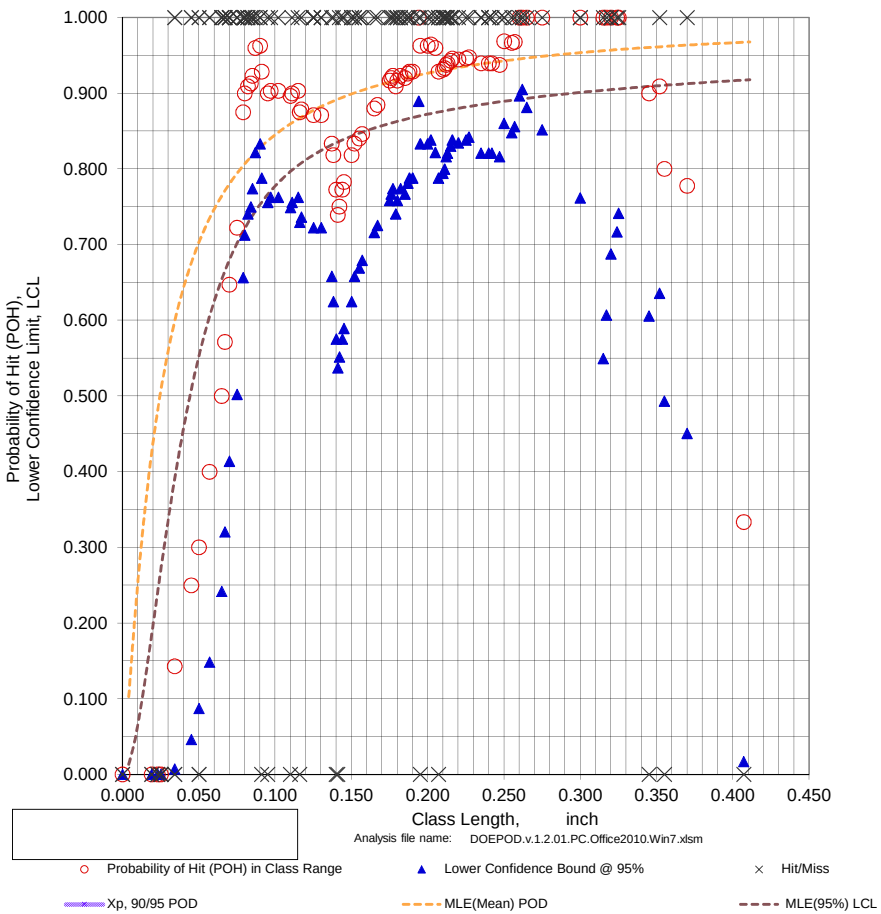
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.786.**

**Warning: No false call analysis.**




File Name = **C3003BL.XLS**

Data Set Name = **C3003BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:13 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0520 | inch |
| Classlength @ 90/95 Xpod = | 0.2620 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.155 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.295 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | 58 | |
| Classlength Mid-point , Xm = | 0.300 | inch |
| Samples Needed @ Xm = | 18 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C3003BL.XLS
Data Set Name = C3003BL(CRK #)

## Directed DOE Options

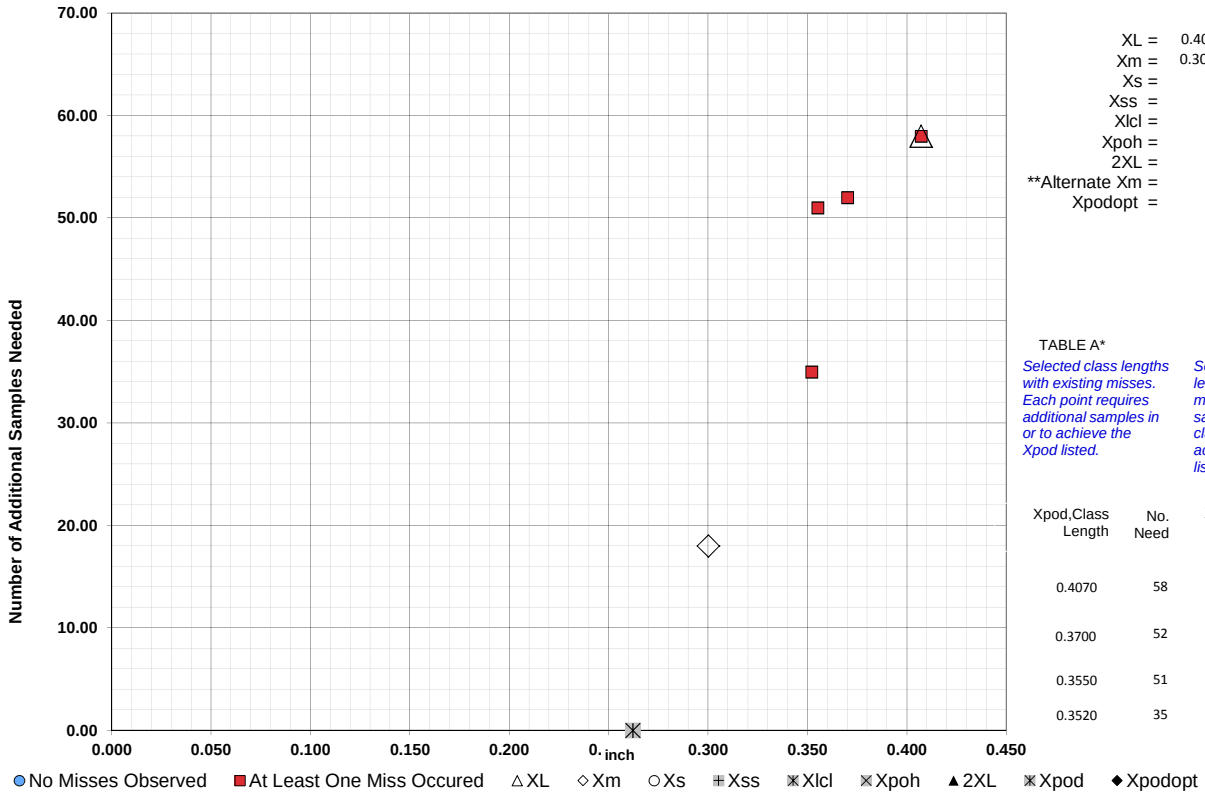



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | 58 |
| Xm = | 0.300 | 18 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4070 | 58 |
| 0.3700 | 52 |
| 0.3550 | 51 |
| 0.3520 | 35 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

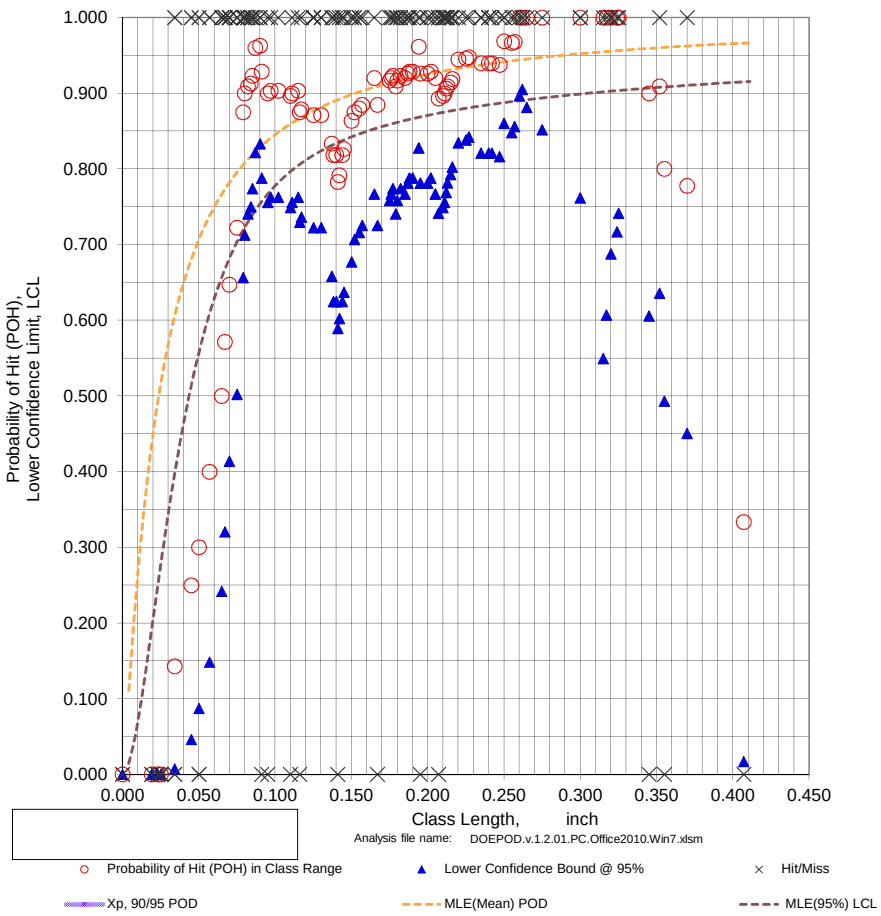
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.786.**

**Warning: No false call analysis.**




File Name = **C3003CL.XLS**

Data Set Name = **C3003CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:14 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0520 | inch |
| Classlength @ 90/95 Xpod = | 0.2620 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.155 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.305 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | 58 | |
| Classlength Mid-point , Xm = | 0.300 | inch |
| Samples Needed @ Xm = | 18 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C3003CL.XLS
Data Set Name = C3003CL(CRK #)

## Directed DOE Options

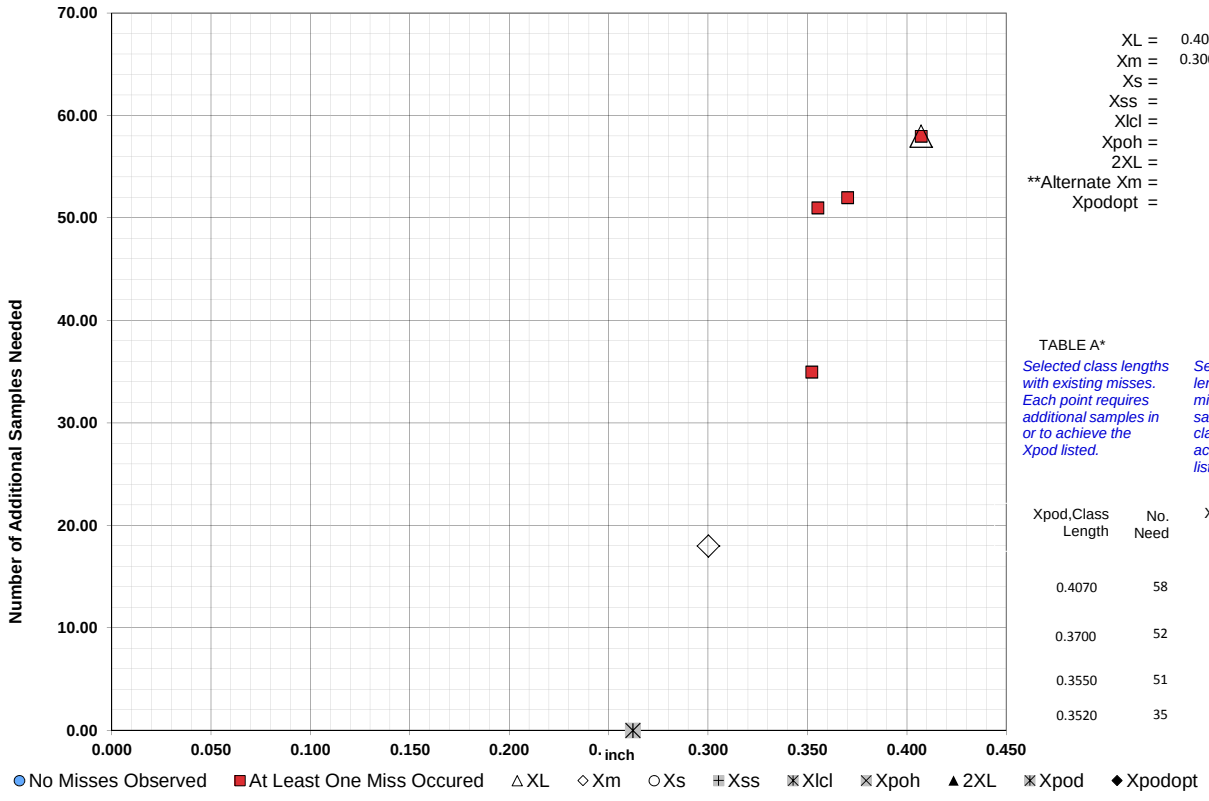



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | 58 |
| Xm = | 0.300 | 18 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4070 | 58 |
| 0.3700 | 52 |
| 0.3550 | 51 |
| 0.3520 | 35 |

TABLE B*

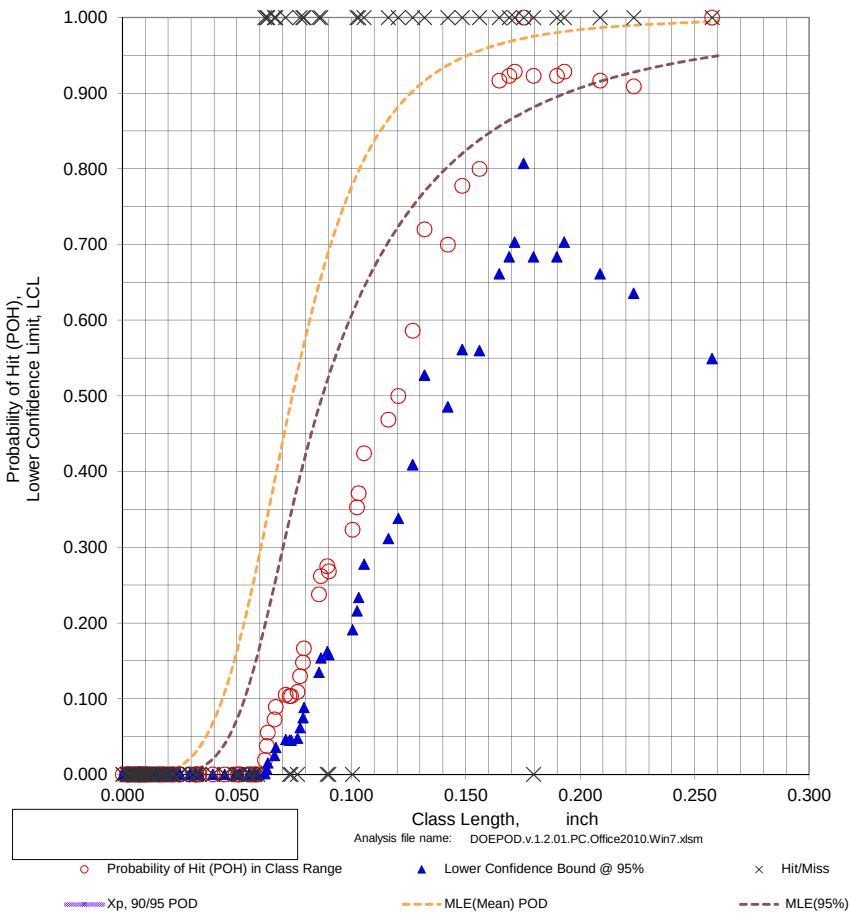
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C400011.XLS
Data Set Name = C400011(hole no.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:15 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8074 | |
| Classwidth @ Best LCL = | 0.0730 | inch |
| Classlength @ Best LCL = | 0.1752 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1898 -0.010 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.130 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.195 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.257 | inch |
| Samples Needed @ Xpoh = | 24 | |
| New Largest Classlength , 2XL = | 0.515 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C400011.XLS
Data Set Name = C400011(hole no.)

## Directed DOE Options

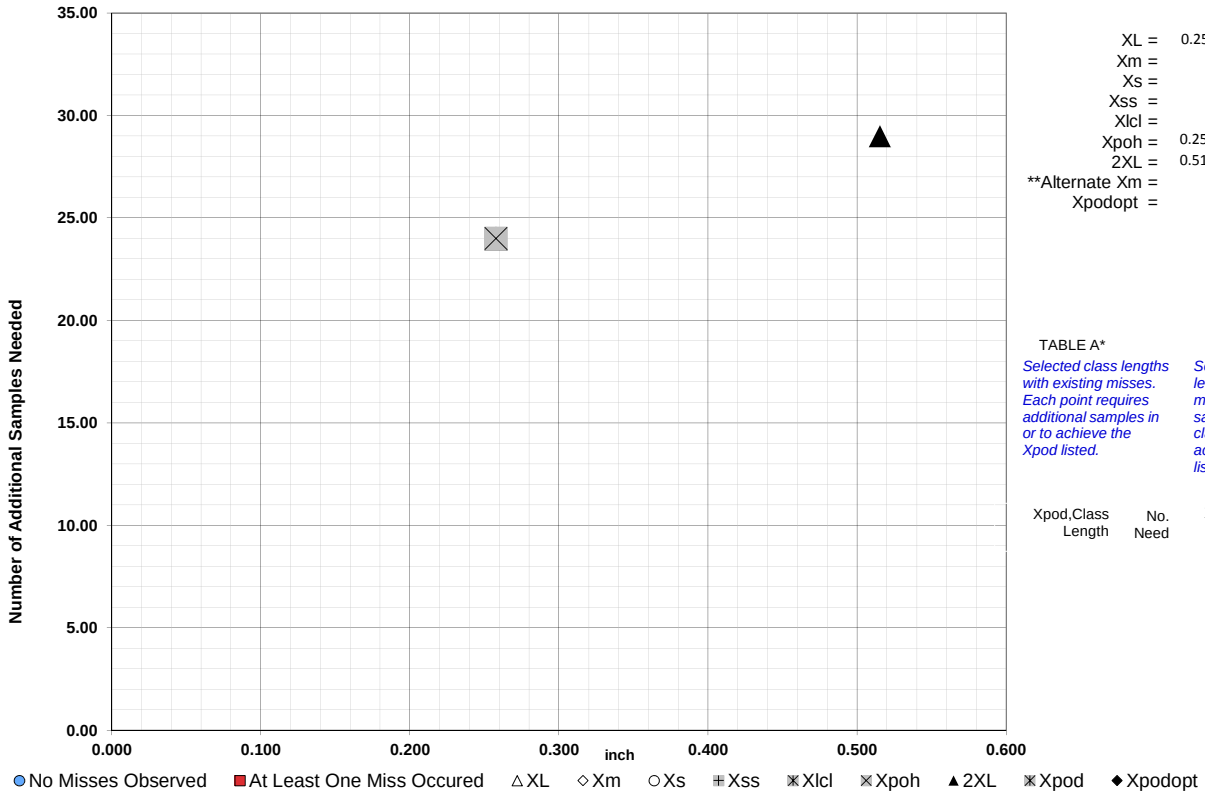



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 24 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.257 | 24 |
| 2XL = | 0.515 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

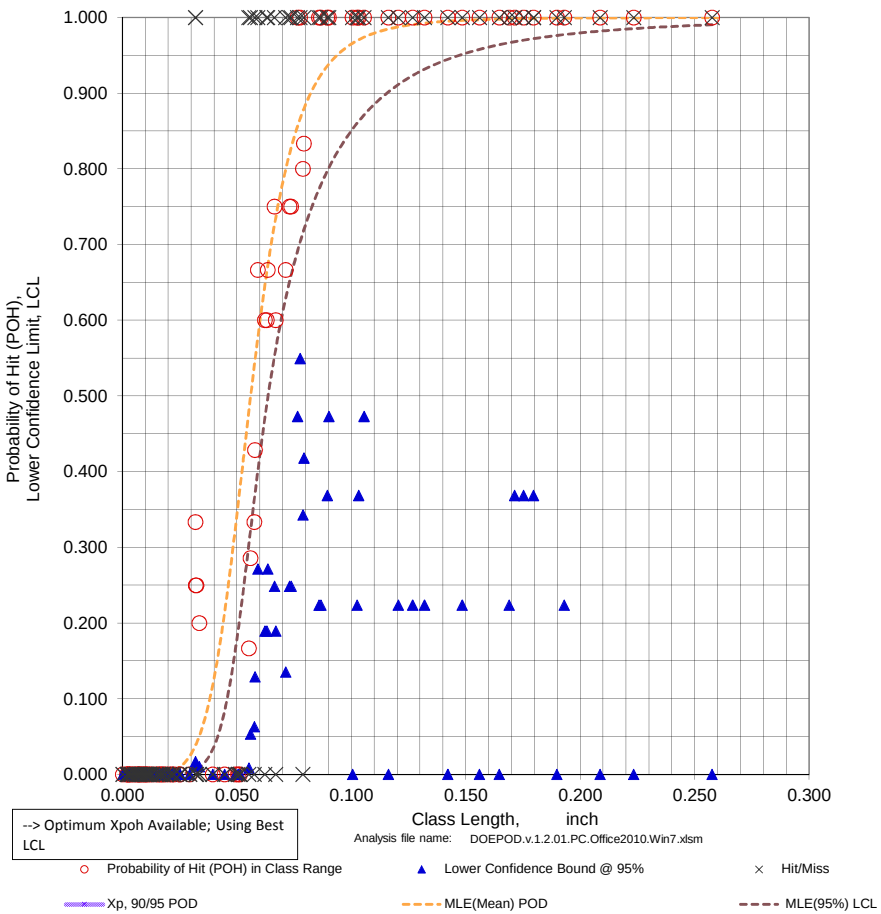
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C400012.XLS
Data Set Name = C400012(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:16 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0776 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.0858 -0.007 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.916 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.910 | @ | 0.120 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.086 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C400012.XLS
Data Set Name = C400012(HOLE #)

## Directed DOE Options

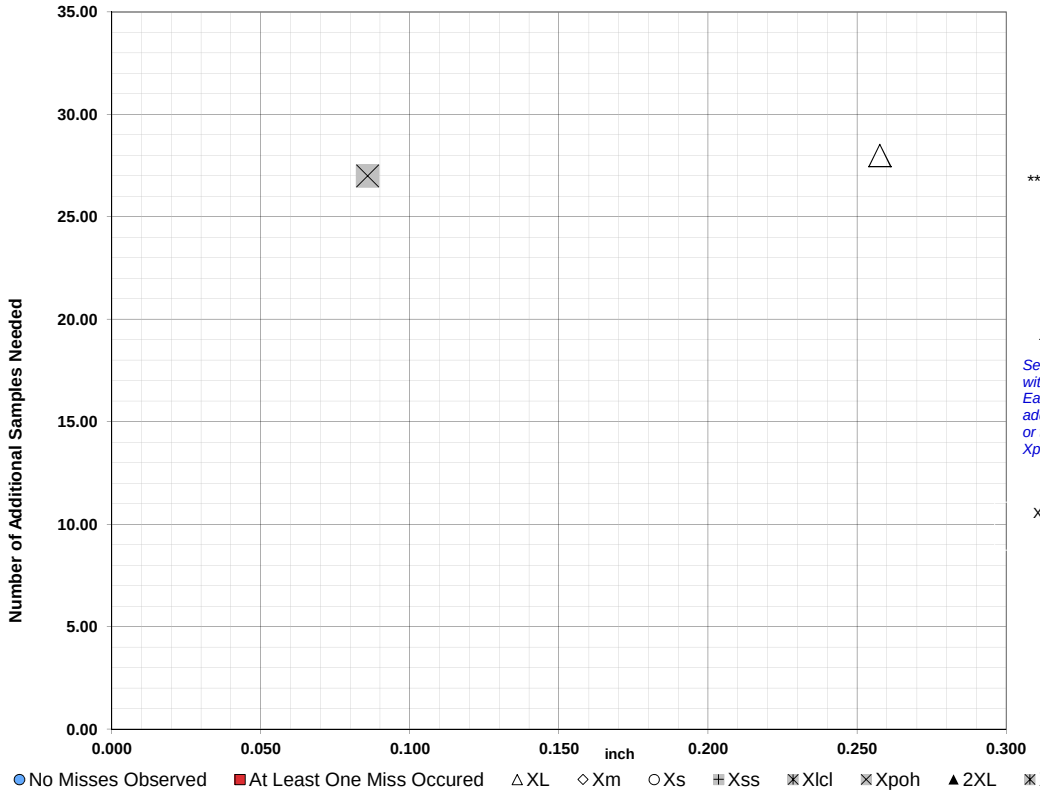



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.086 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

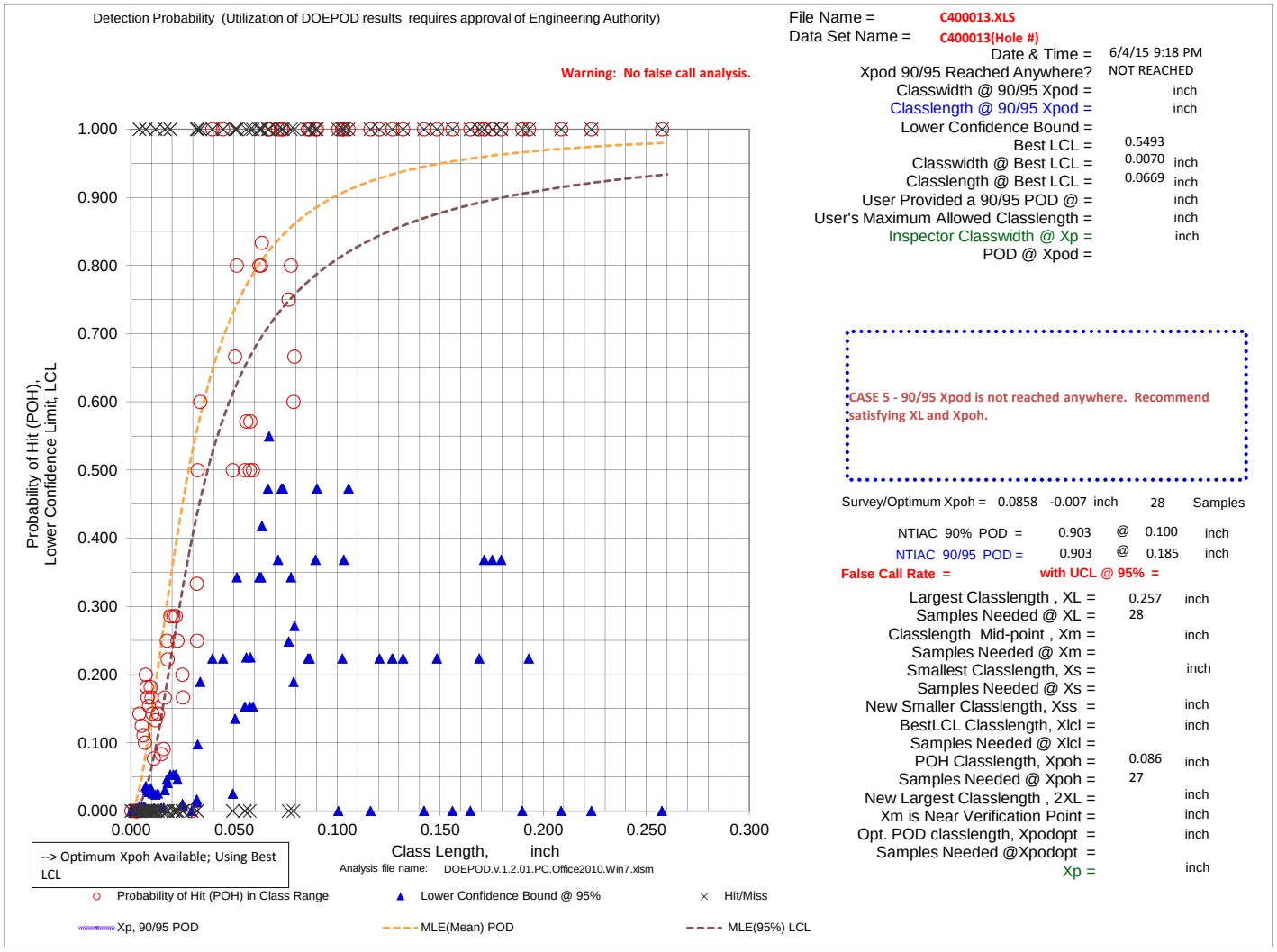
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = C400013.XLS
Data Set Name = C400013(Hole #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:18 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0669 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.0858 -0.007 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.100 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.185 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.086 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C400013.XLS
Data Set Name = C400013(Hole #)

## Directed DOE Options

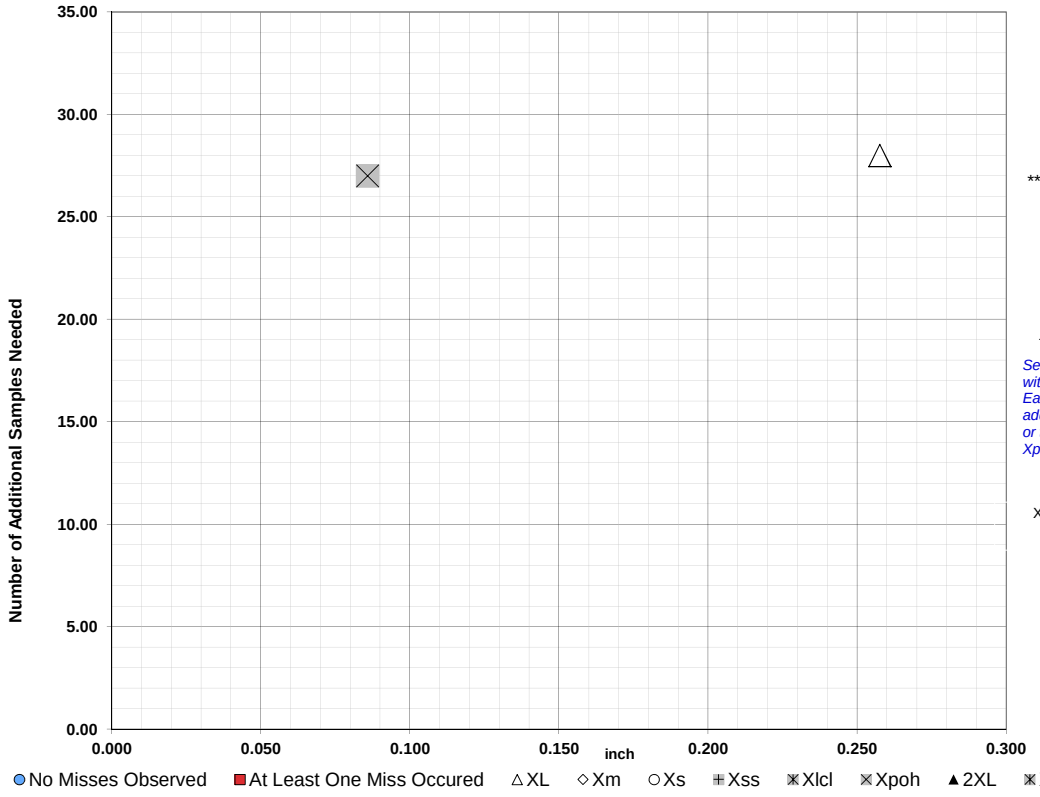



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.086 | 27 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

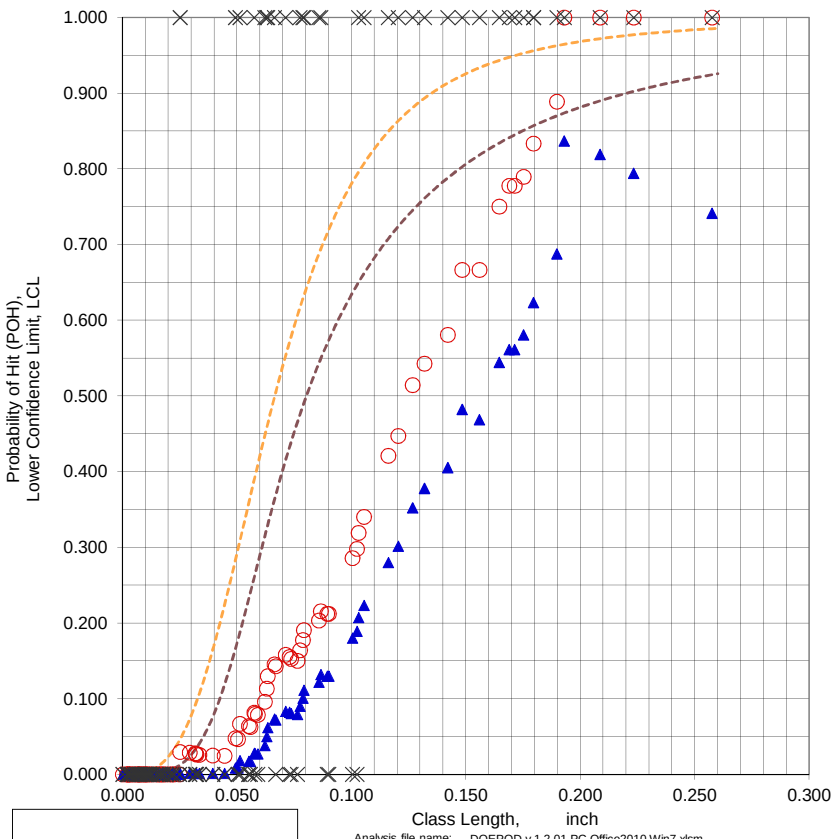
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




| | | |
|---|---|---|
| File Name = | C400014.XLS | |
| Data Set Name = | C400014(Hole #) | |
| Date & Time = | 6/4/15 9:19 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8368 | |
| Classwidth @ Best LCL = | 0.0900 | inch |
| Classlength @ Best LCL = | 0.1929 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1055 -0.003 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.135 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.225 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 19 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.193 | inch |
| Samples Needed @ Xlcl = | 12 | |
| POH Classlength, Xpoh = | 0.193 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C400014.XLS
Data Set Name = C400014(Hole #)

## Directed DOE Options

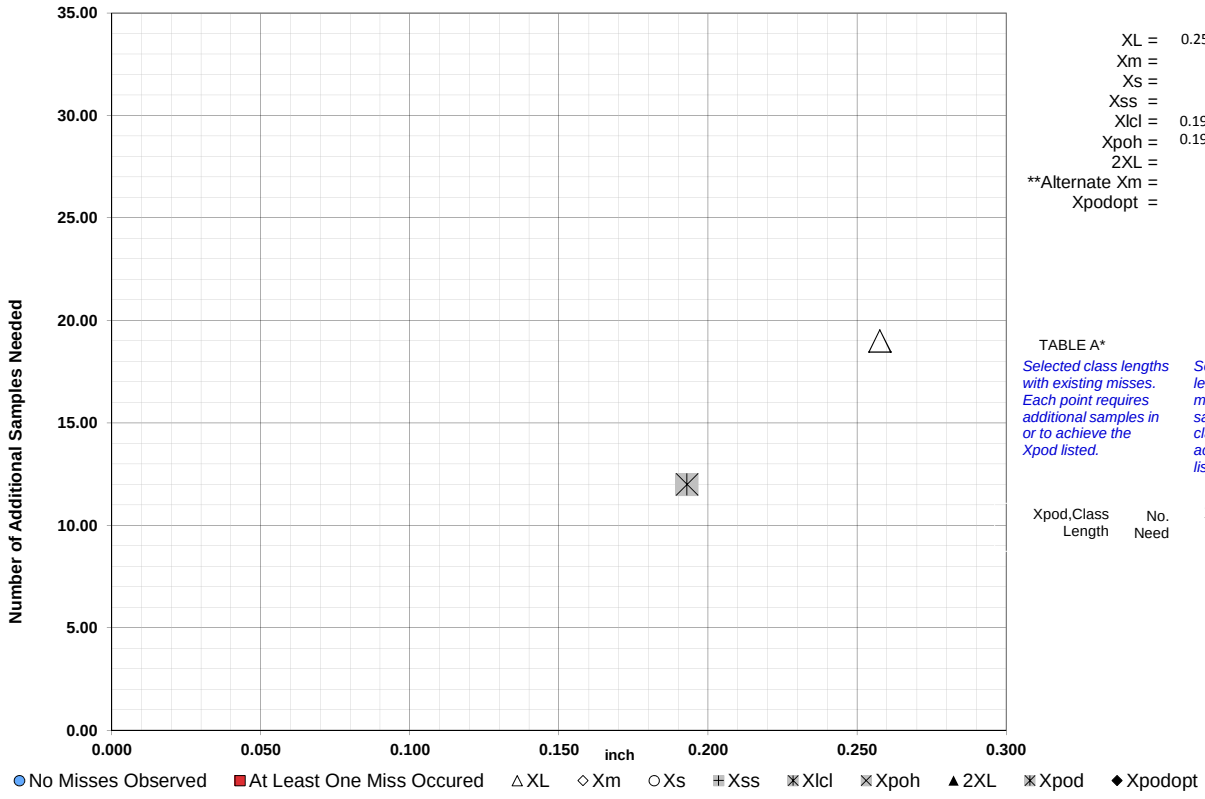



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 19 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.193 | 12 |
| Xpoh = | 0.193 | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

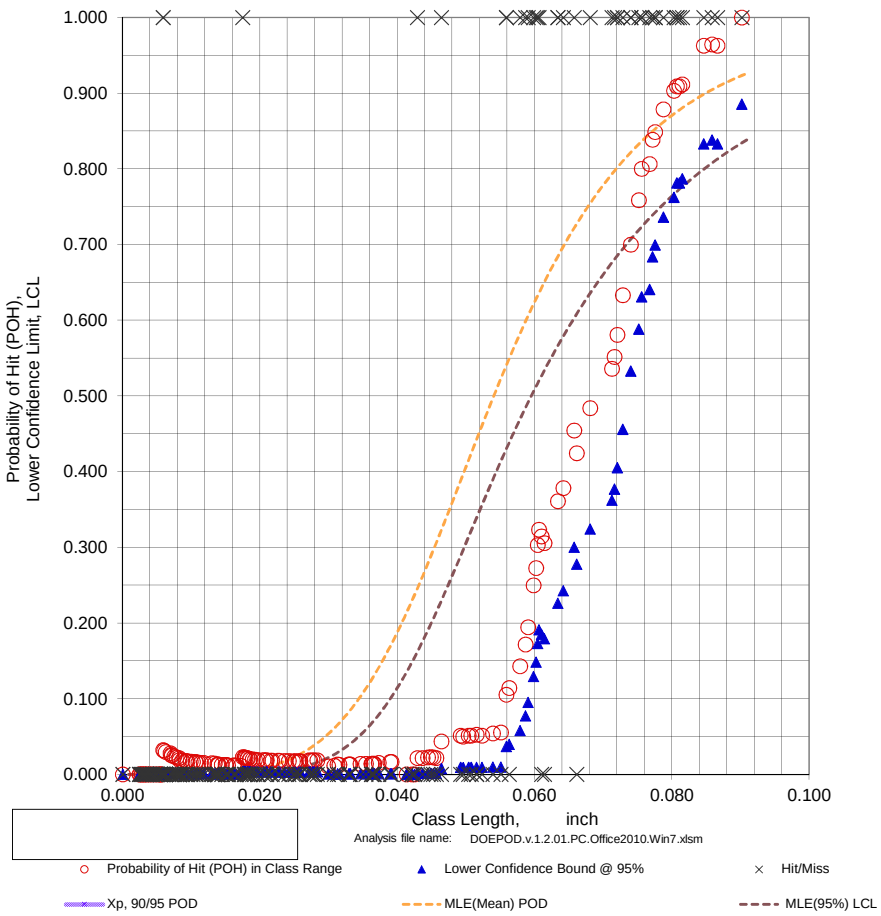
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = C500011.XLS
Data Set Name = C500011(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:20 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0230 | inch |
| Classlength @ Best LCL = | 0.0902 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0681 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.912 | @ | 0.110 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | 4 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.090 | inch |
| Samples Needed @ Xlcl = | 4 | |
| POH Classlength, Xpoh = | 0.090 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.180 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C500011.XLS
Data Set Name = C500011(CRK #)

## Directed DOE Options

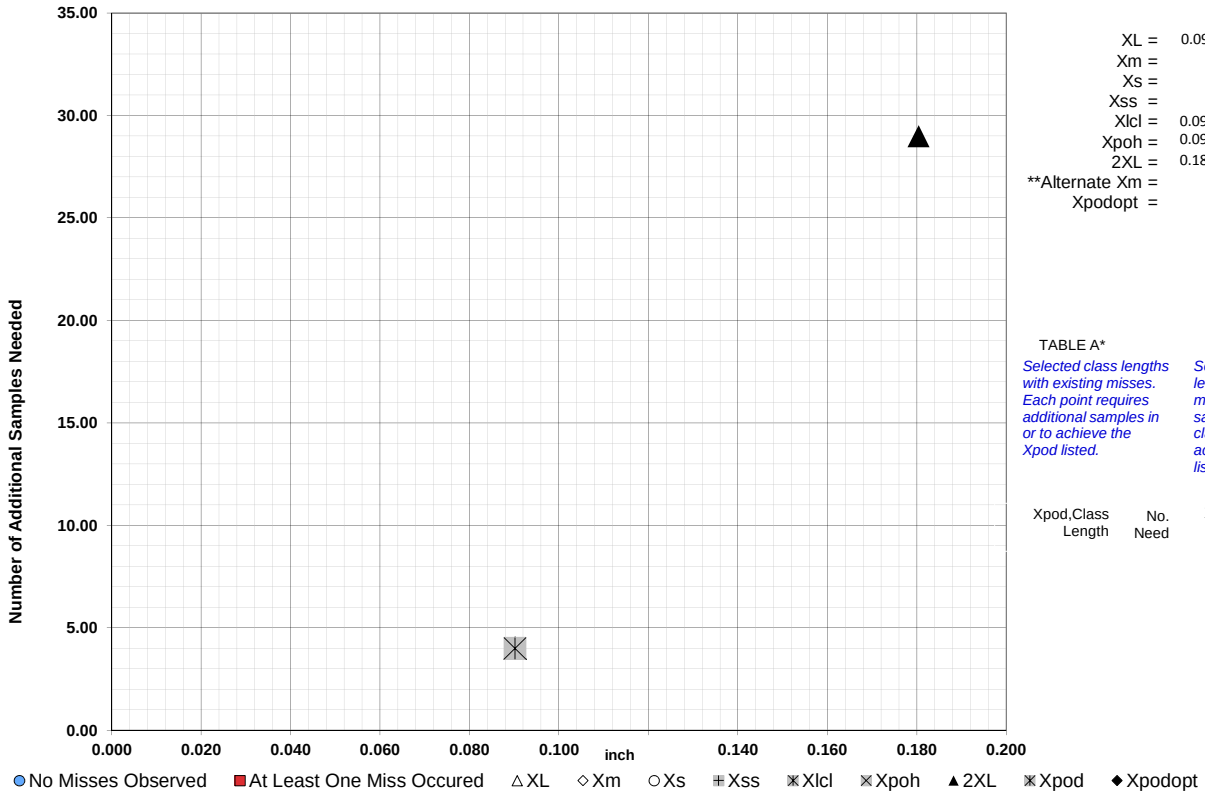



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | 4 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.090 | 4 |
| Xpoh = | 0.090 | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

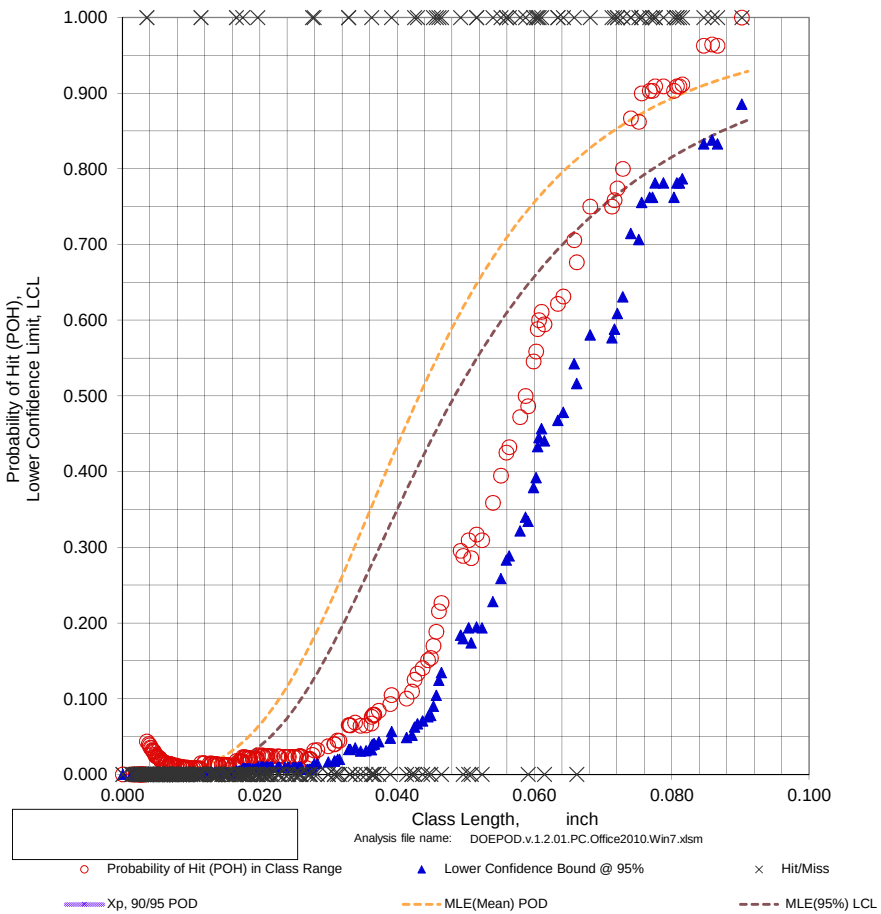
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = C500012.XLS
Data Set Name = C500012(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:22 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0230 | inch |
| Classlength @ Best LCL = | 0.0902 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0681 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.105 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | 4 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.090 | inch |
| Samples Needed @ Xlcl = | 4 | |
| POH Classlength, Xpoh = | 0.090 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.180 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C500012.XLS
Data Set Name = C500012(HOLE #)

## Directed DOE Options

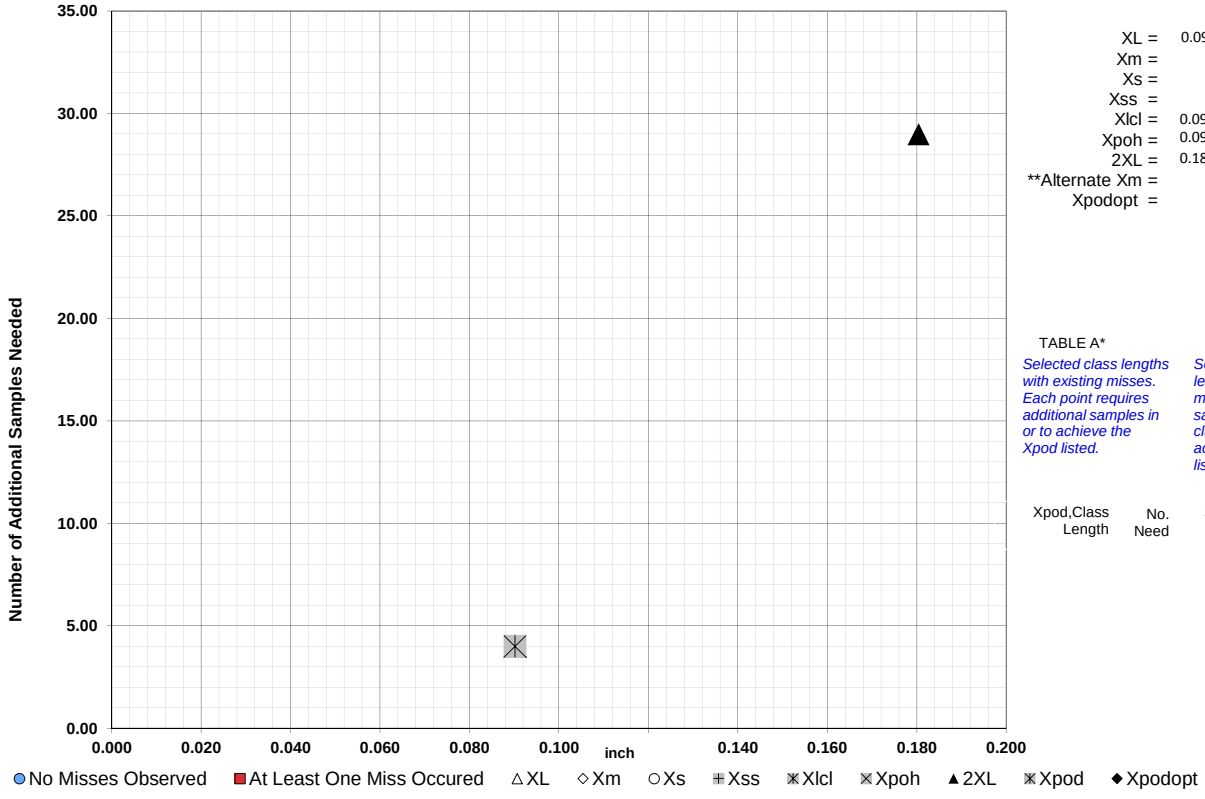



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | 4 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.090 | 4 |
| Xpoh = | 0.090 | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

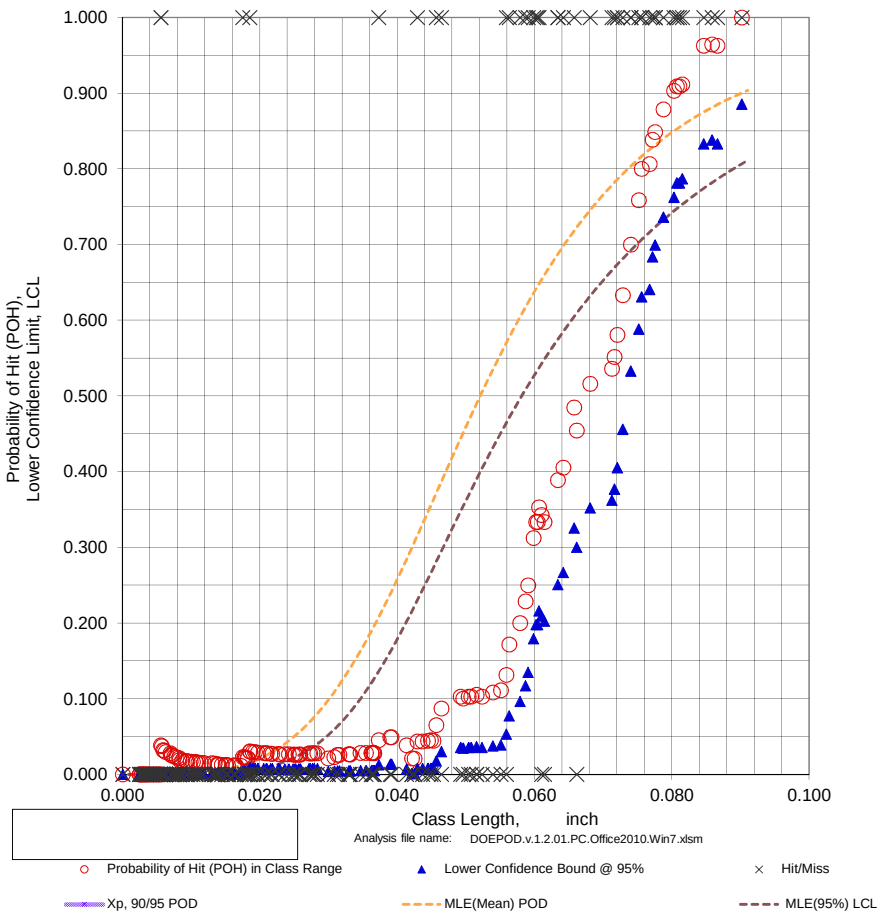
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = C500014.XLS
Data Set Name = C500014(Hole #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:24 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0230 | inch |
| Classlength @ Best LCL = | 0.0902 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0681 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.918 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.120 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | 4 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.090 | inch |
| Samples Needed @ Xlcl = | 4 | |
| POH Classlength, Xpoh = | 0.090 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.180 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C500014.XLS
Data Set Name = C500014(Hole #)

## Directed DOE Options

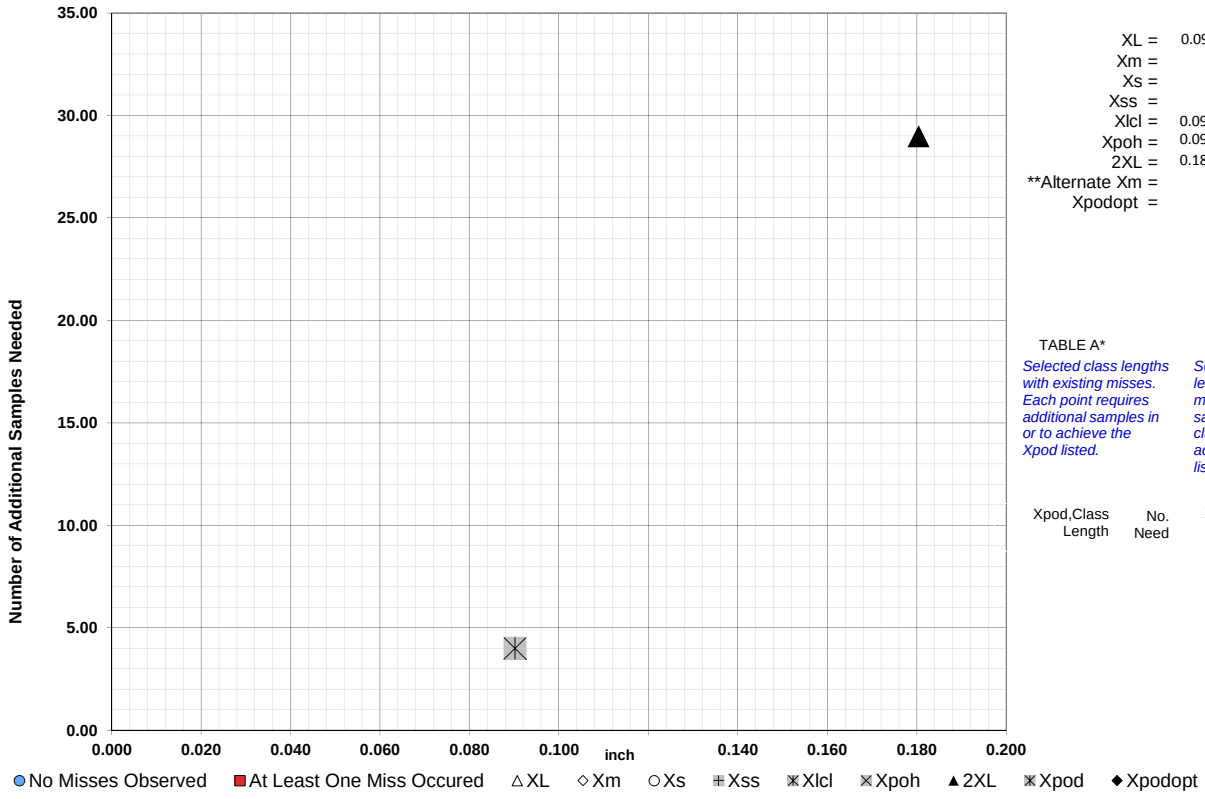



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | 4 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.090 | 4 |
| Xpoh = | 0.090 | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

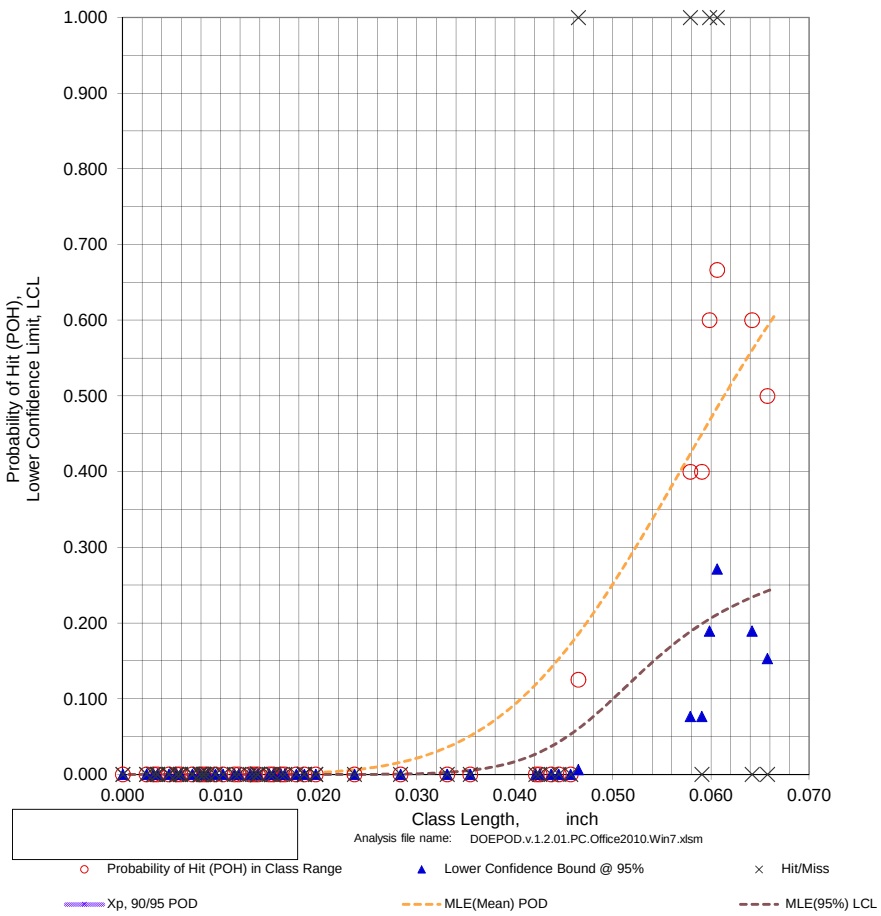
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C500016.XLS
Data Set Name = C500016(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:26 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2713 | |
| Classwidth @ Best LCL = | 0.0150 | inch |
| Classlength @ Best LCL = | 0.0606 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | | @ | | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.131 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C500016.XLS
Data Set Name = C500016(HOLE #)

## Directed DOE Options

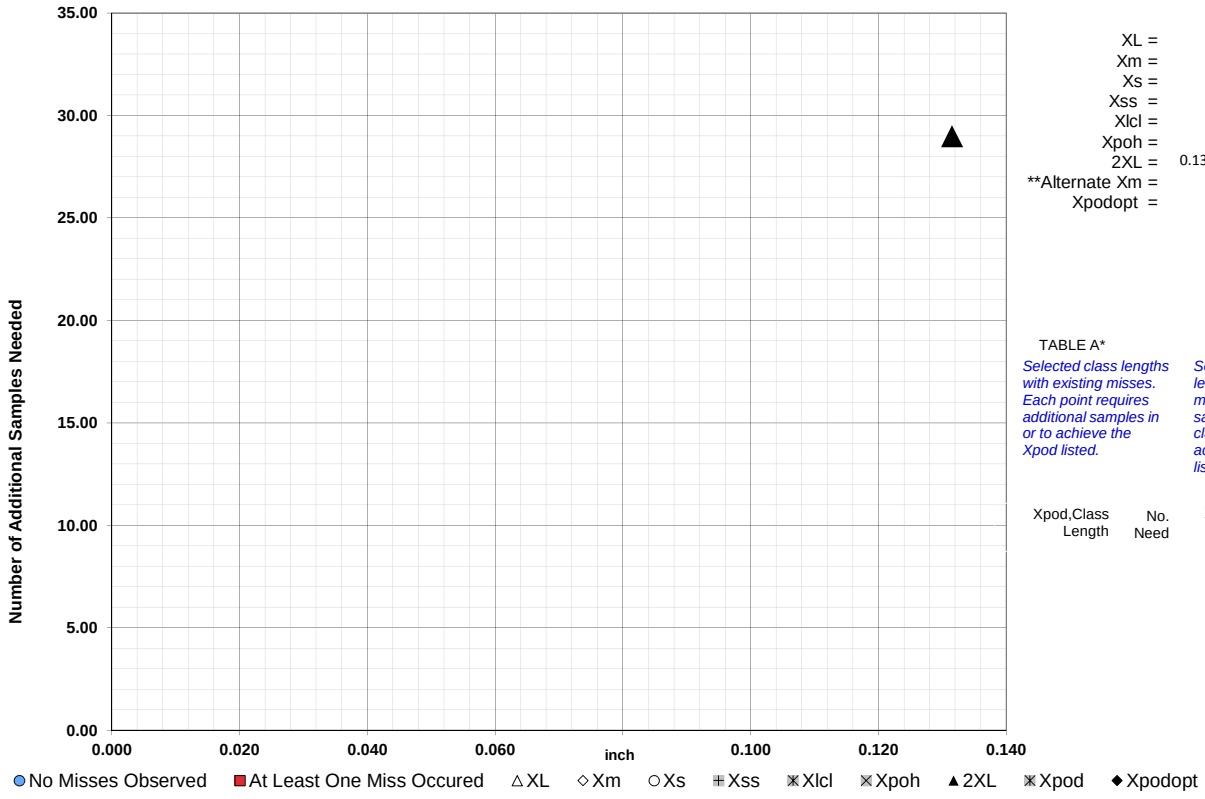



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | |
| Xm = | |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | 0.131 29 |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

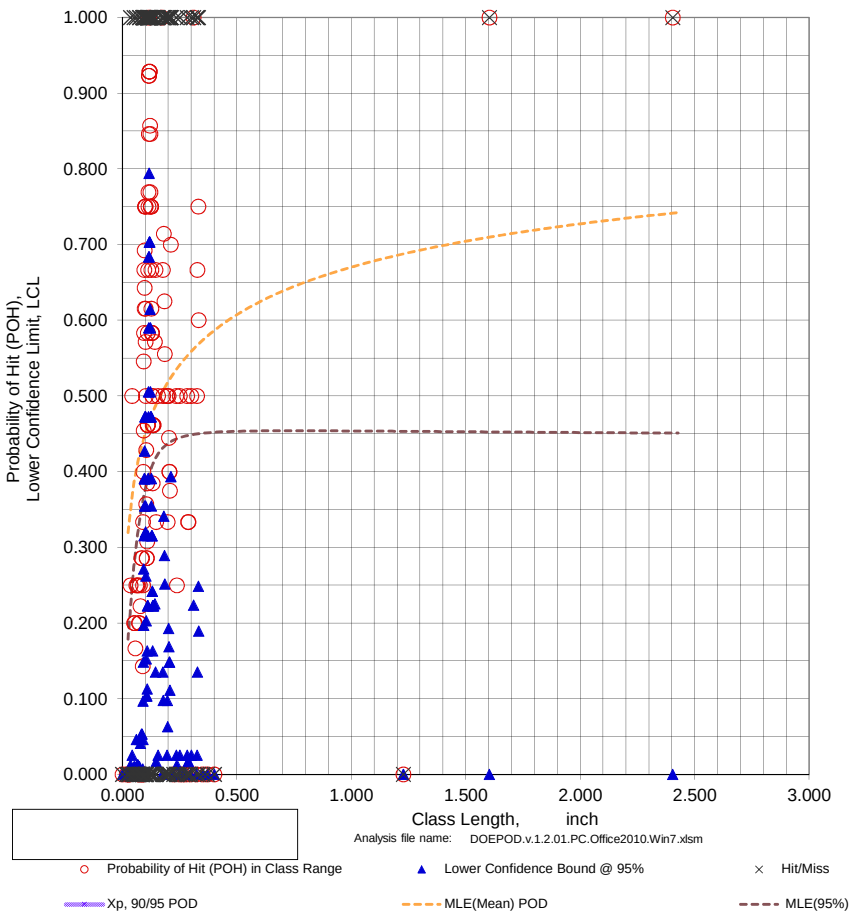
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C6001AL.XLS
Data Set Name = C6001AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:27 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0100 | inch |
| Classlength @ Best LCL = | 0.1153 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C6001AL.XLS
Data Set Name = C6001AL(CRK #)

## Directed DOE Options

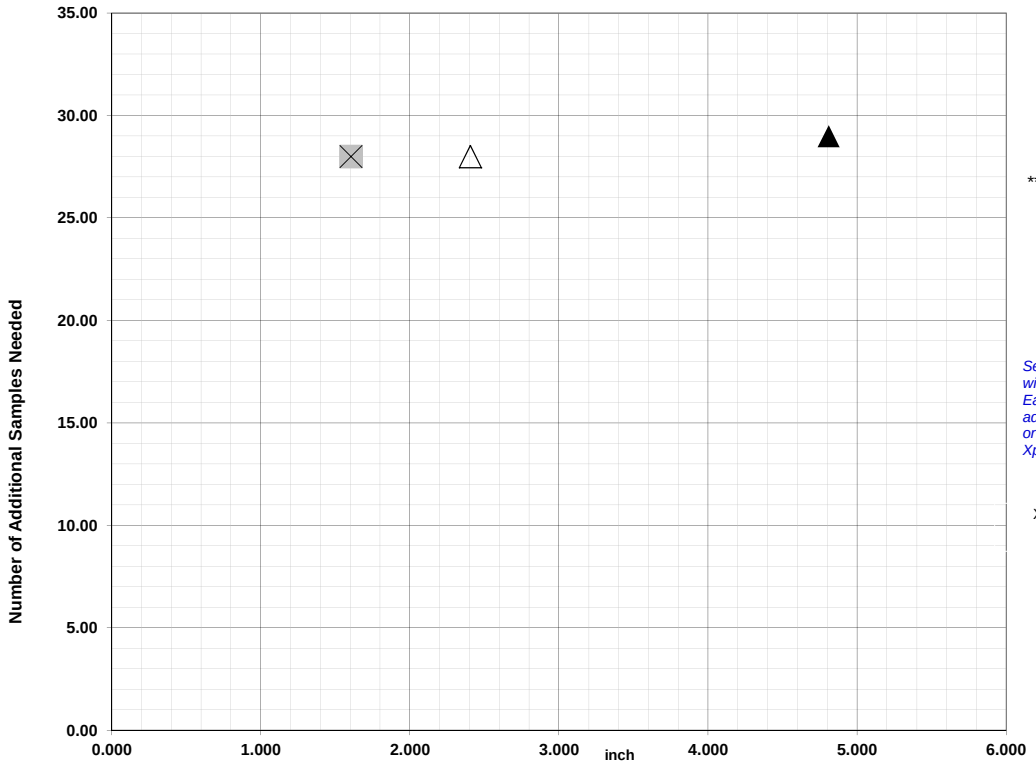



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

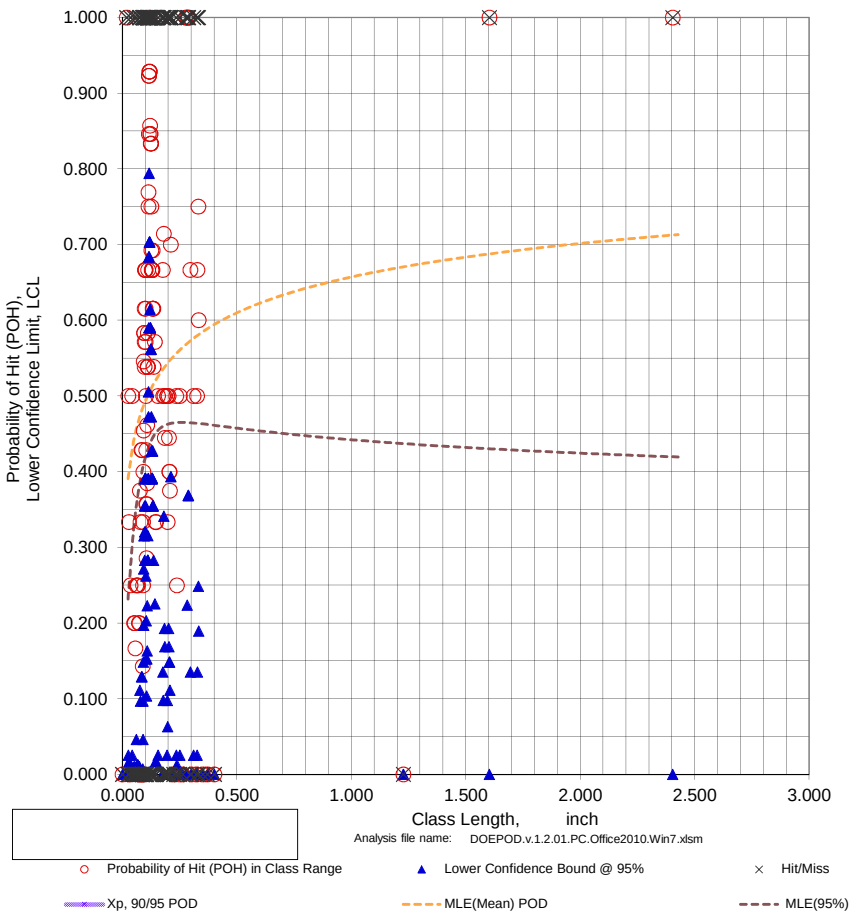
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C6001BL.XLS
Data Set Name = C6001BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:30 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0100 | inch |
| Classlength @ Best LCL = | 0.1153 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 2.403 | | inch |
| Samples Needed @ XL = | 28 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 1.603 | | inch |
| Samples Needed @ Xpoh = | 28 | | |
| New Largest Classlength , 2XL = | 4.806 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = C6001BL.XLS
Data Set Name = C6001BL(CRK #)

## Directed DOE Options

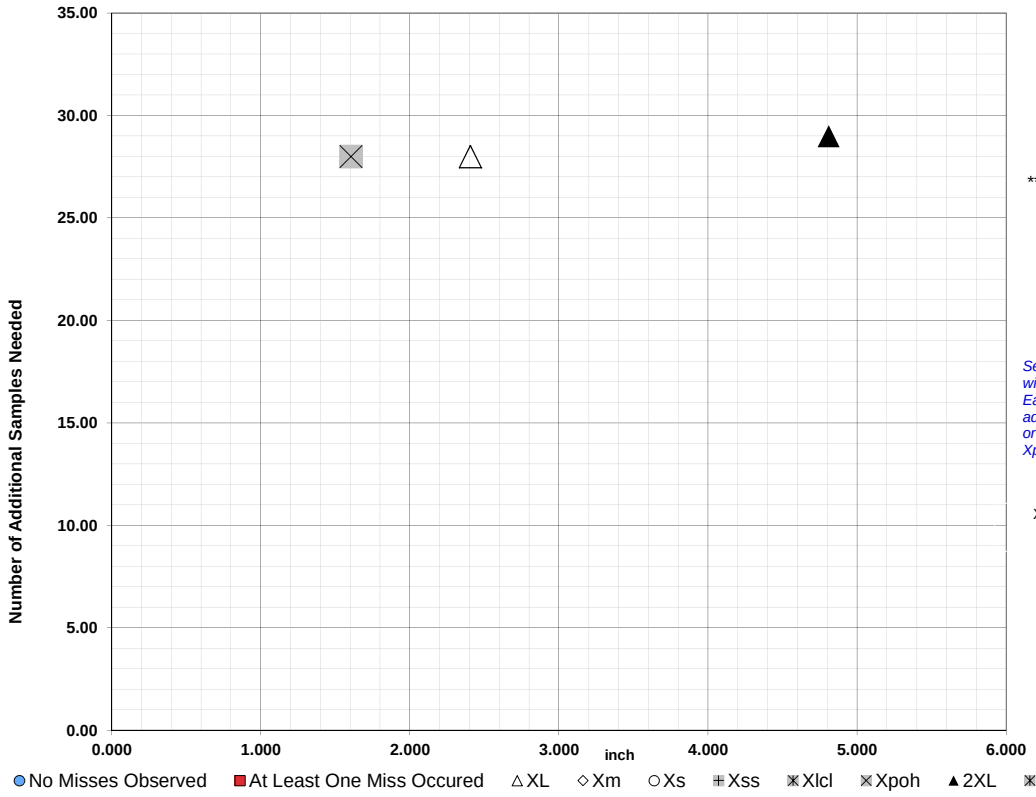



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

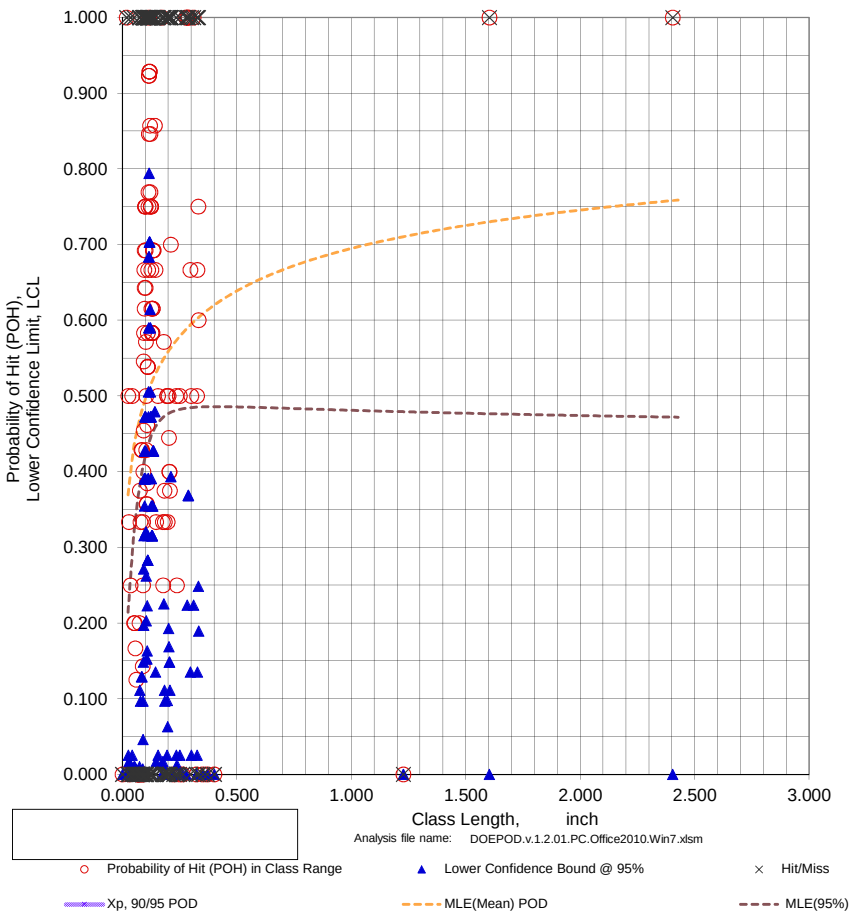
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C6001CL.XLS
Data Set Name = C6001CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:32 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0100 | inch |
| Classlength @ Best LCL = | 0.1153 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C6001CL.XLS
Data Set Name = C6001CL(CRK #)

## Directed DOE Options

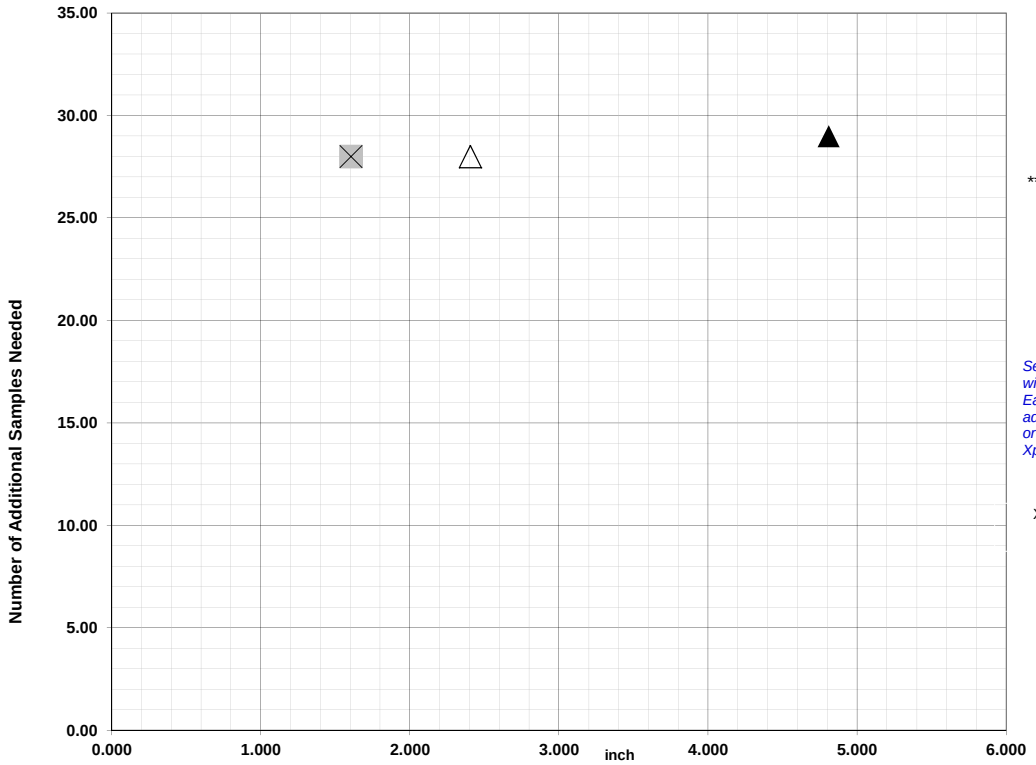



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

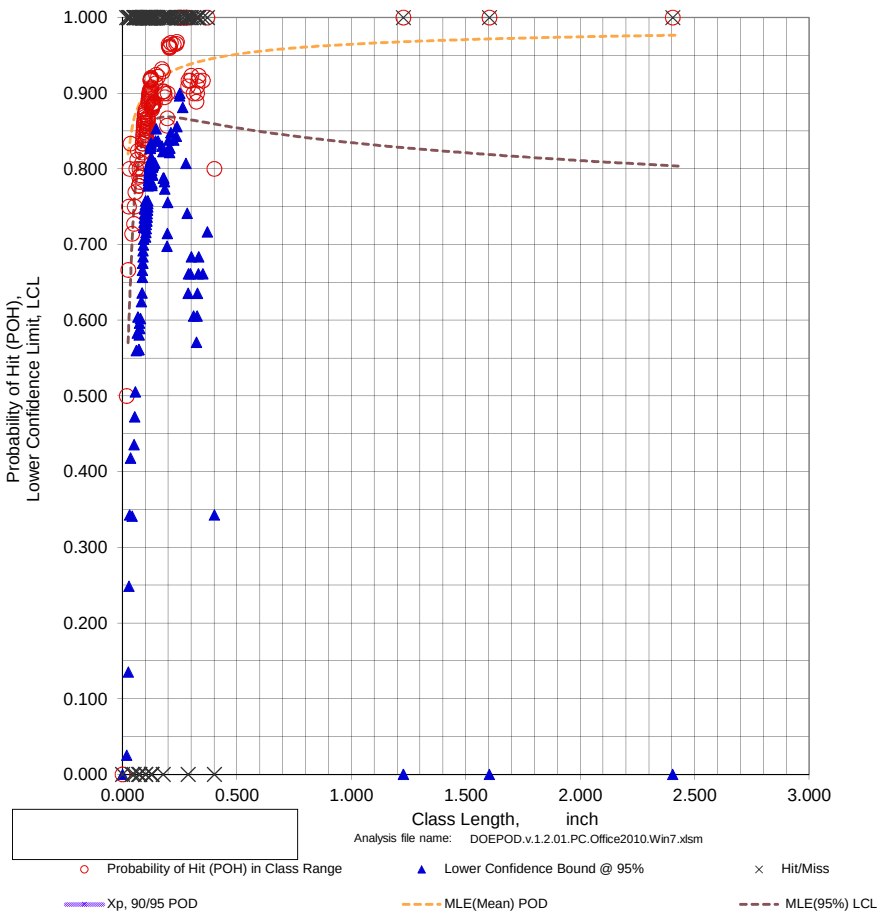
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 20 more large flaws.**

**Warning: No false call analysis.**




File Name = **C6002AL.XLS**

Data Set Name = **C6002AL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:33 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0700 | inch |
| Classlength @ 90/95 Xpod = | 0.2500 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.900 @ 0.100 inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C6002AL.XLS
Data Set Name = C6002AL(CRK #)

## Directed DOE Options

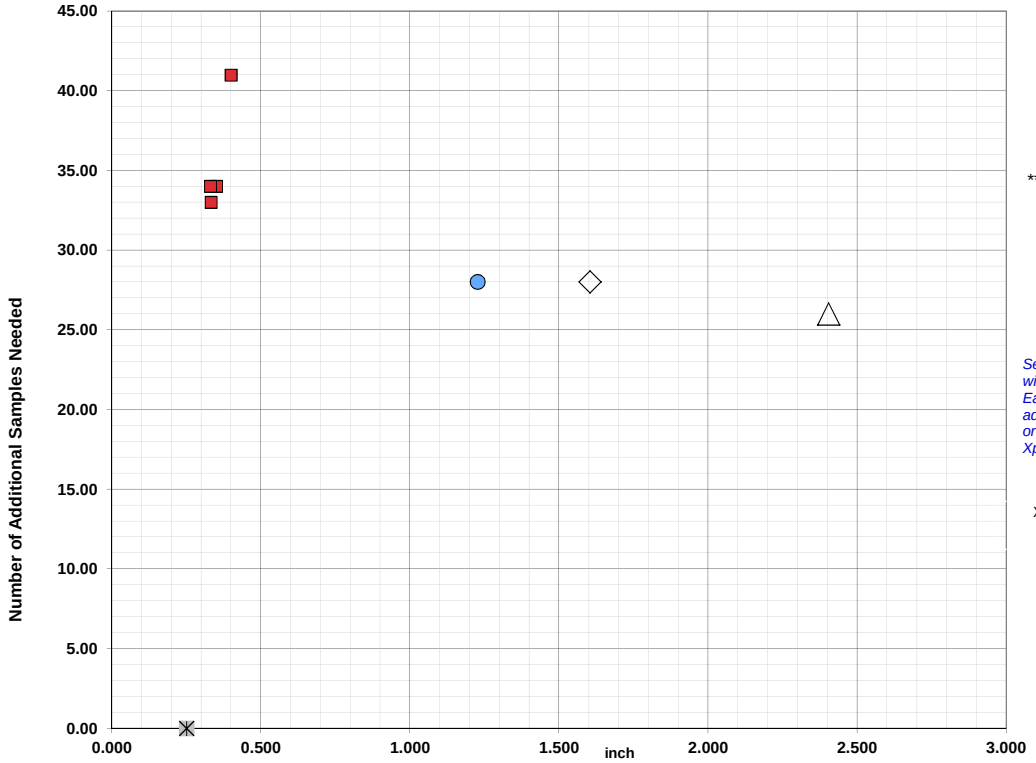



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 26 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4000 | 41 |
| 0.3500 | 34 |
| 0.3320 | 33 |
| 0.3300 | 34 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2270 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

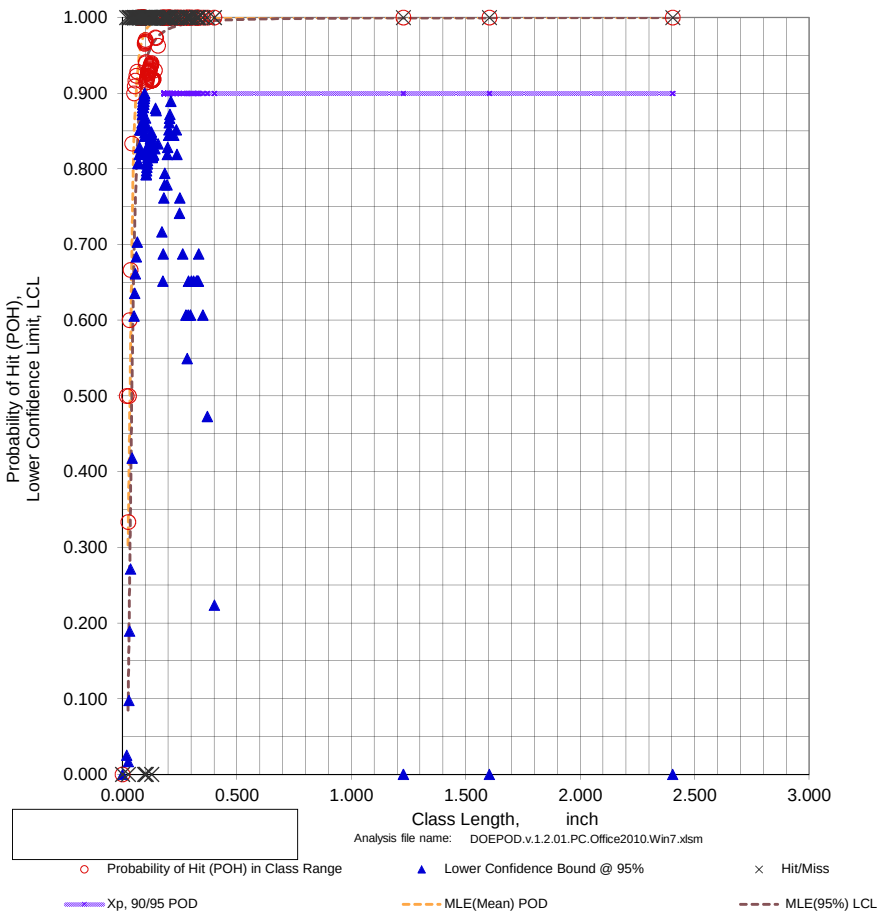
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **C6002BL.XLS**

Data Set Name = **C6002BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:35 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0400 | inch |
| Classlength @ 90/95 Xpod = | 0.0960 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.060 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.080 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1800 | inch |

File Name = C6002BL.XLS
Data Set Name = C6002BL(CRK #)

## Directed DOE Options

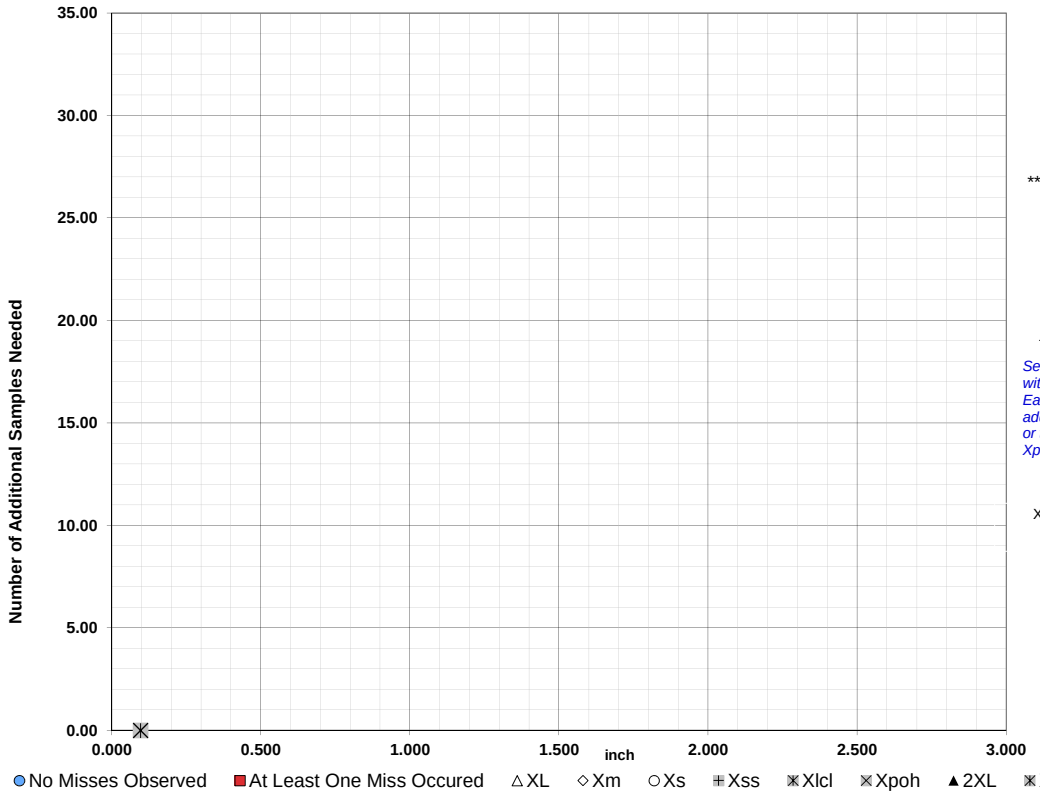



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 2.403 |
| Xm = | 1.603 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 20 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

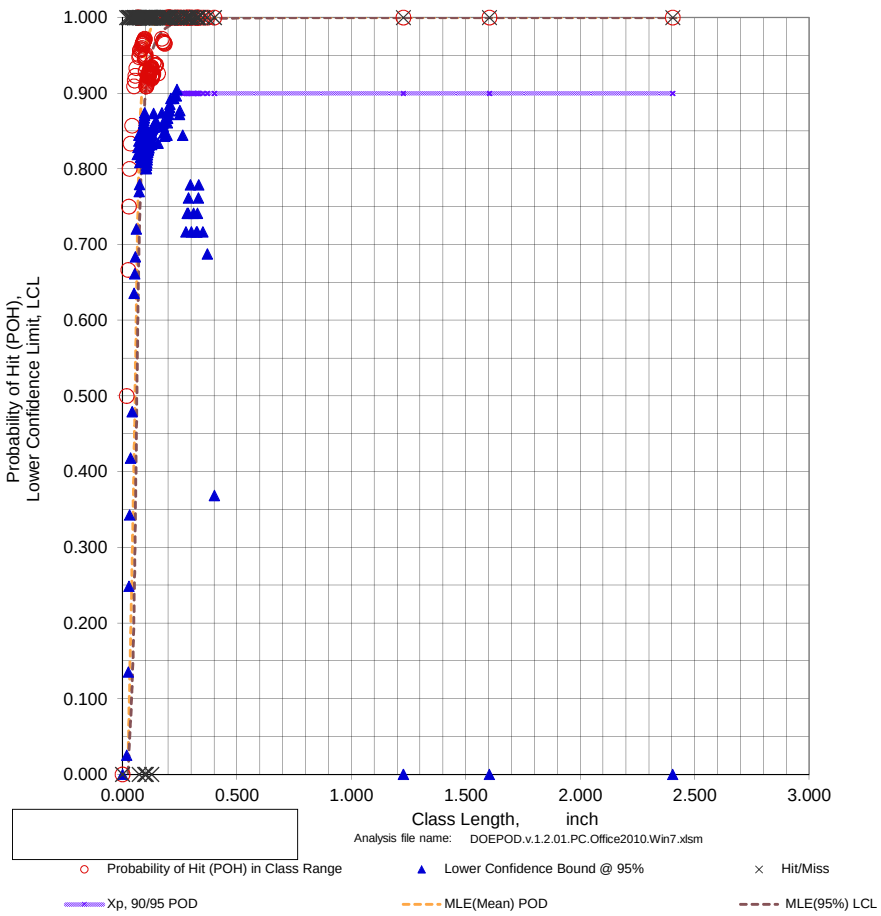
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **C6002CL.XLS**

Data Set Name = **C6002CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:36 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0620 | inch |
| Classlength @ 90/95 Xpod = | 0.2370 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1283 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.911 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.913 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.194 | inch |
| Samples Needed @Xpodopt = | 11 | |
| Xp = | 0.2370 | inch |

File Name = C6002CL.XLS
Data Set Name = C6002CL(CRK #)

## Directed DOE Options

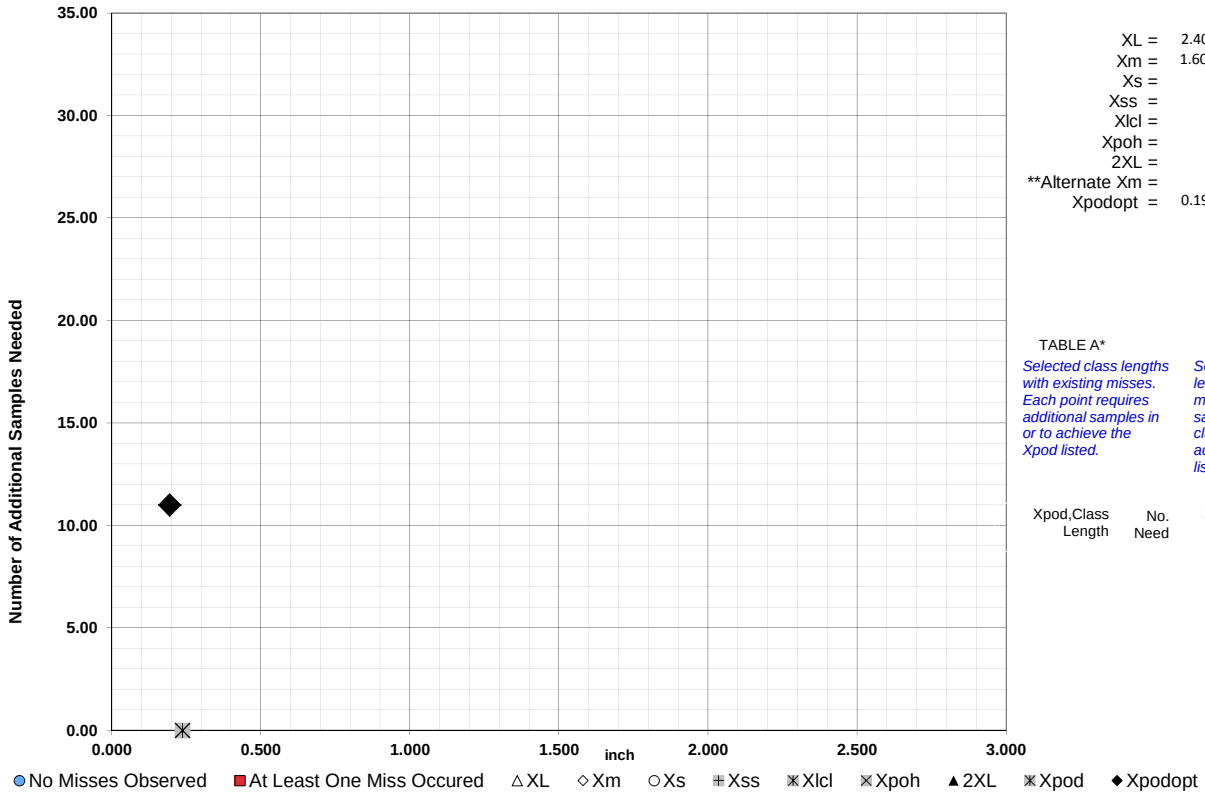



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | |
| Xm = | 1.603 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.194 | 11 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

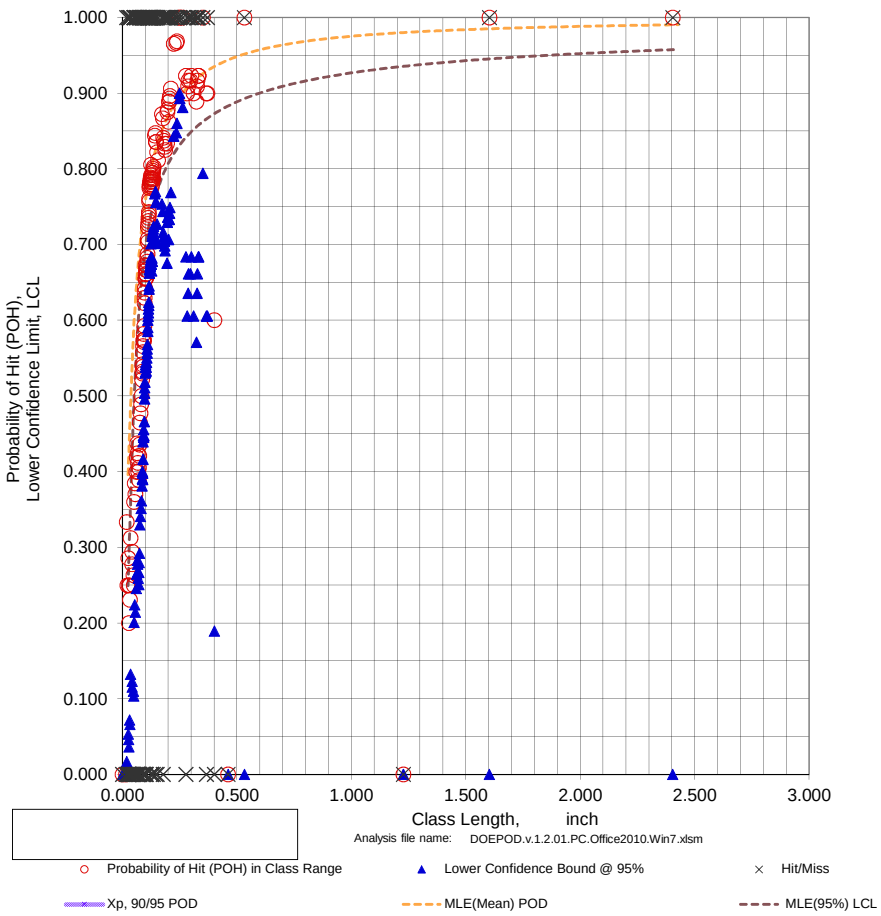
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Warning: No false call analysis.**




File Name = **C6003AL.XLS**

Data Set Name = **C6003AL(CRK # )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:37 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0680 | inch |
| Classlength @ 90/95 Xpod = | 0.2480 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.265 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.600 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C6003AL.XLS
Data Set Name = C6003AL(CRK # )

## Directed DOE Options

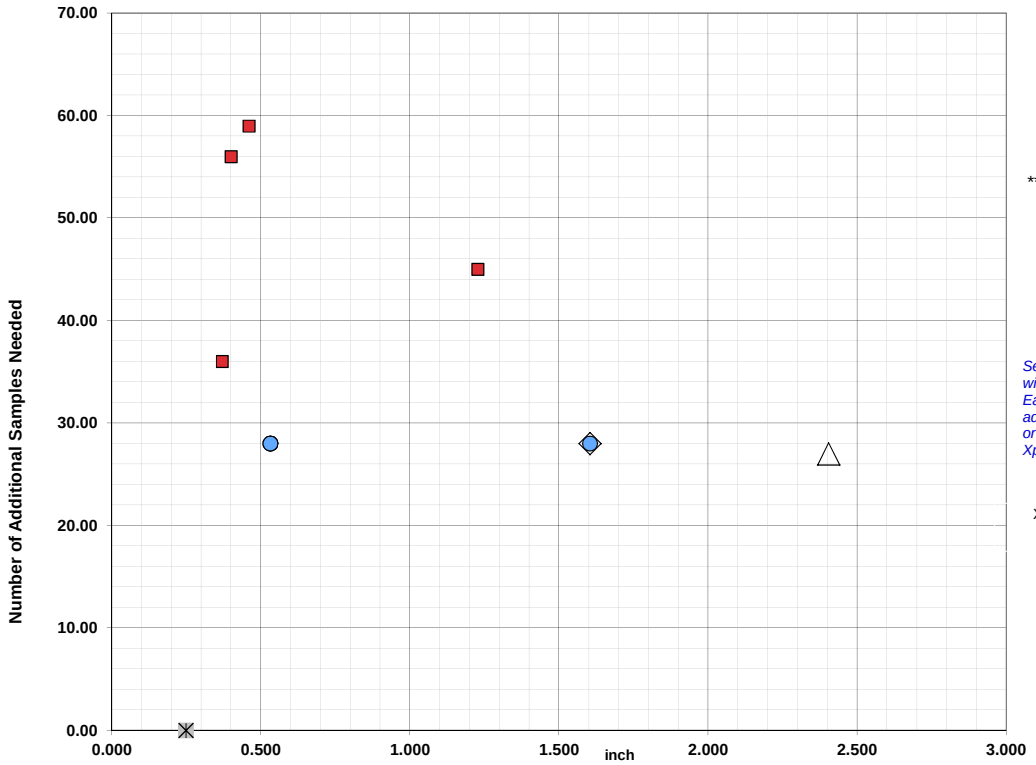



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 27 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2270 | 45 |
| 0.4600 | 59 |
| 0.4000 | 56 |
| 0.3700 | 36 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

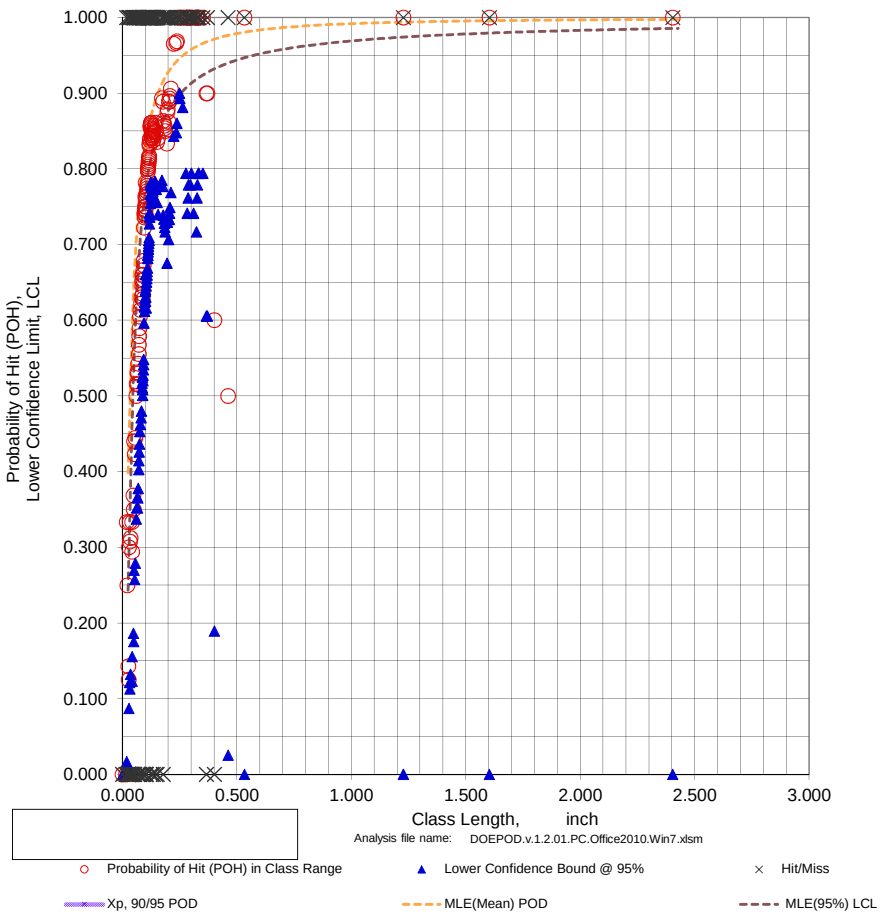
| Xpod,Class Length | No. Need |
|---|---|
| 1.6030 | 28 |
| 0.5320 | 28 |
| 0.5320 | 28 |
| 0.5320 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Warning: No false call analysis.**




File Name = **C6003BL.XLS**

Data Set Name = **C6003BL(CRK # )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:38 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0680 | inch |
| Classlength @ 90/95 Xpod = | 0.2480 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.155 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.255 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C6003BL.XLS
Data Set Name = C6003BL(CRK # )

## Directed DOE Options

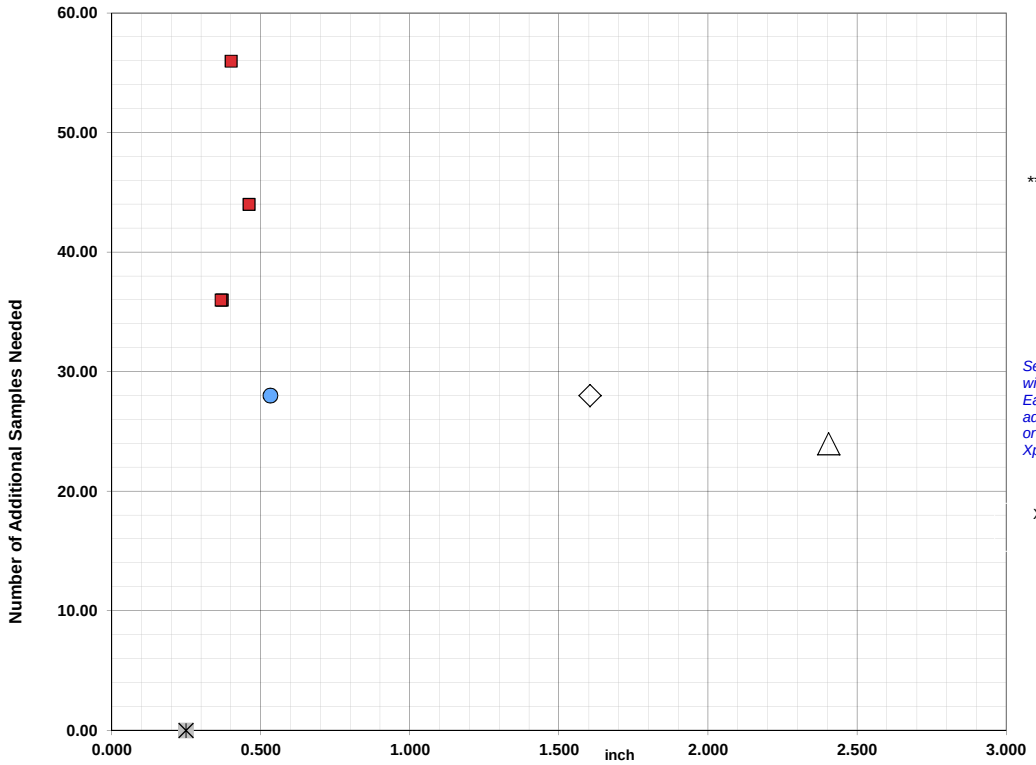



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 24 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.4600 | 44 |
| 0.4000 | 56 |
| 0.3700 | 36 |
| 0.3650 | 36 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5320 | 28 |

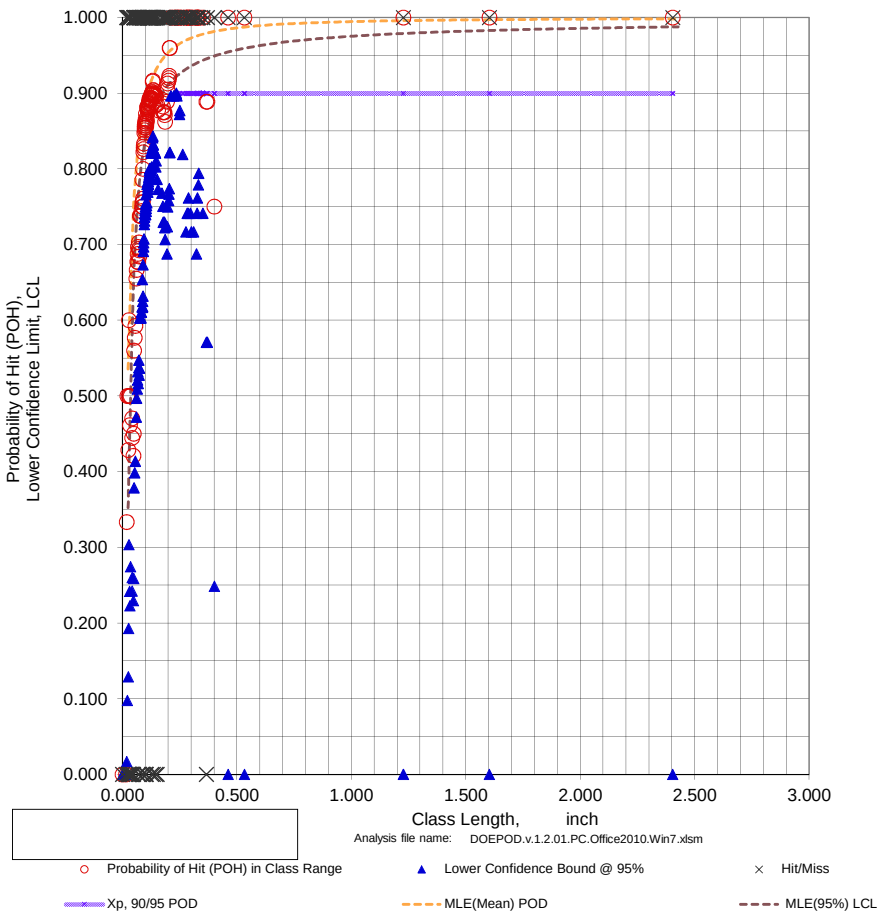
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 19 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **C6003CL.XLS**

Data Set Name = **C6003CL(CRK # )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:40 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0590 | inch |
| Classlength @ 90/95 Xpod = | 0.2340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.175 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2340 | inch |

File Name = C6003CL.XLS
Data Set Name = C6003CL(CRK # )

## Directed DOE Options

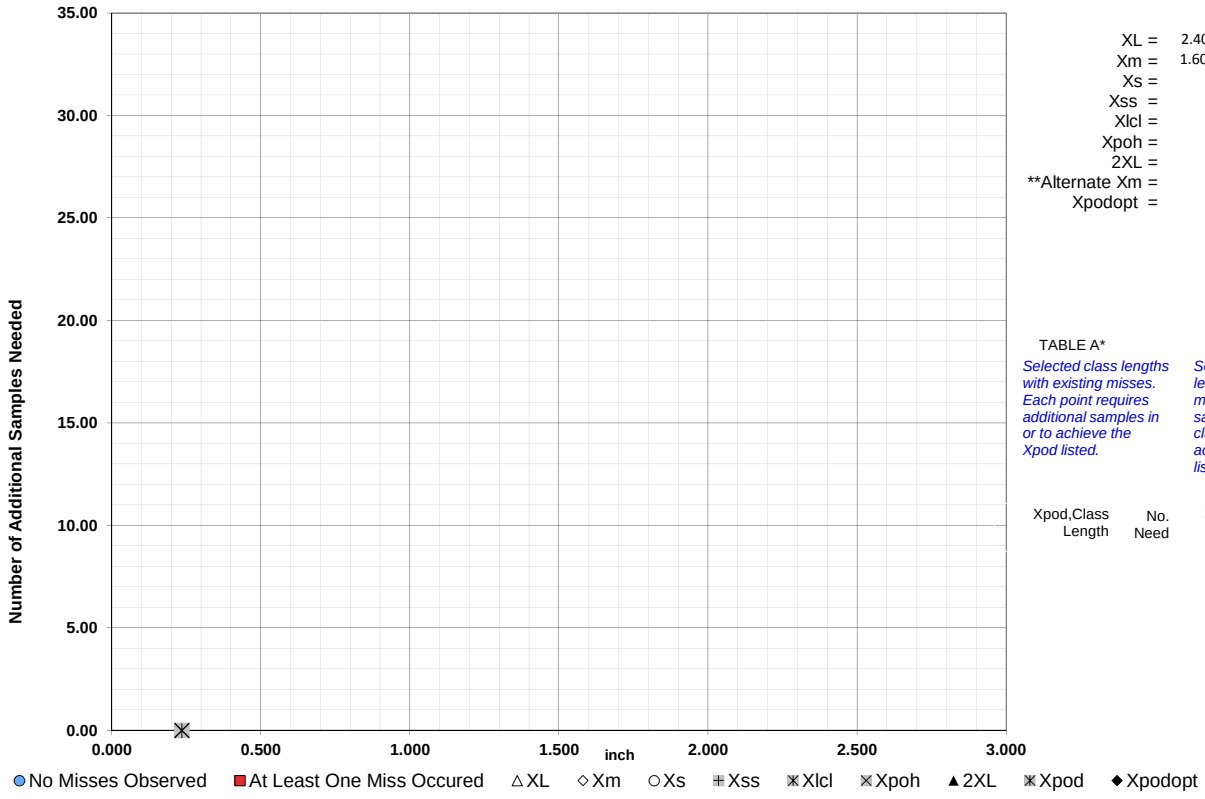



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 2.403 |
| Xm = | 1.603 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

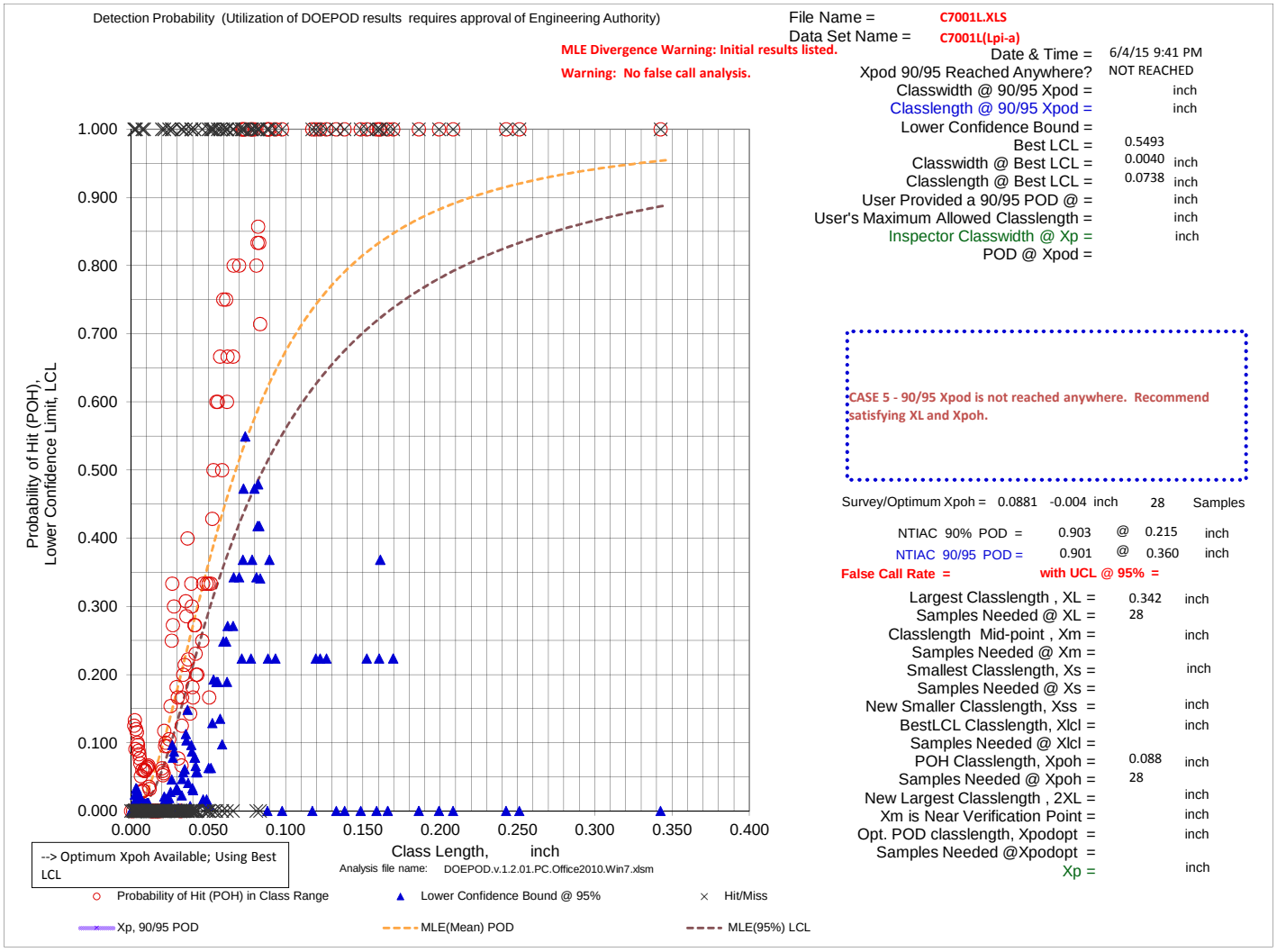
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
File Name = C7001L.XLS
Data Set Name = C7001L(Lpi-a)
MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.
Date & Time = 6/4/15 9:41 PM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.5493
Classwidth @ Best LCL = 0.0040 inch
Classlength @ Best LCL = 0.0738 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.
Survey/Optimum Xpoh = 0.0881 -0.004 inch 28 Samples
NTIAC 90% POD = 0.903 @ 0.215 inch
NTIAC 90/95 POD = 0.901 @ 0.360 inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = 0.342 inch
Samples Needed @ XL = 28
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = 0.088 inch
Samples Needed @ Xpoh = 28
New Largest Classlength , 2XL = inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000 0.050 0.100 0.150 0.200 0.250 0.300 0.350 0.400
Class Length, inch
--> Optimum Xpoh Available; Using Best LCL
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL

File Name = C7001L.XLS
Data Set Name = C7001L(Lpi-a)

## Directed DOE Options

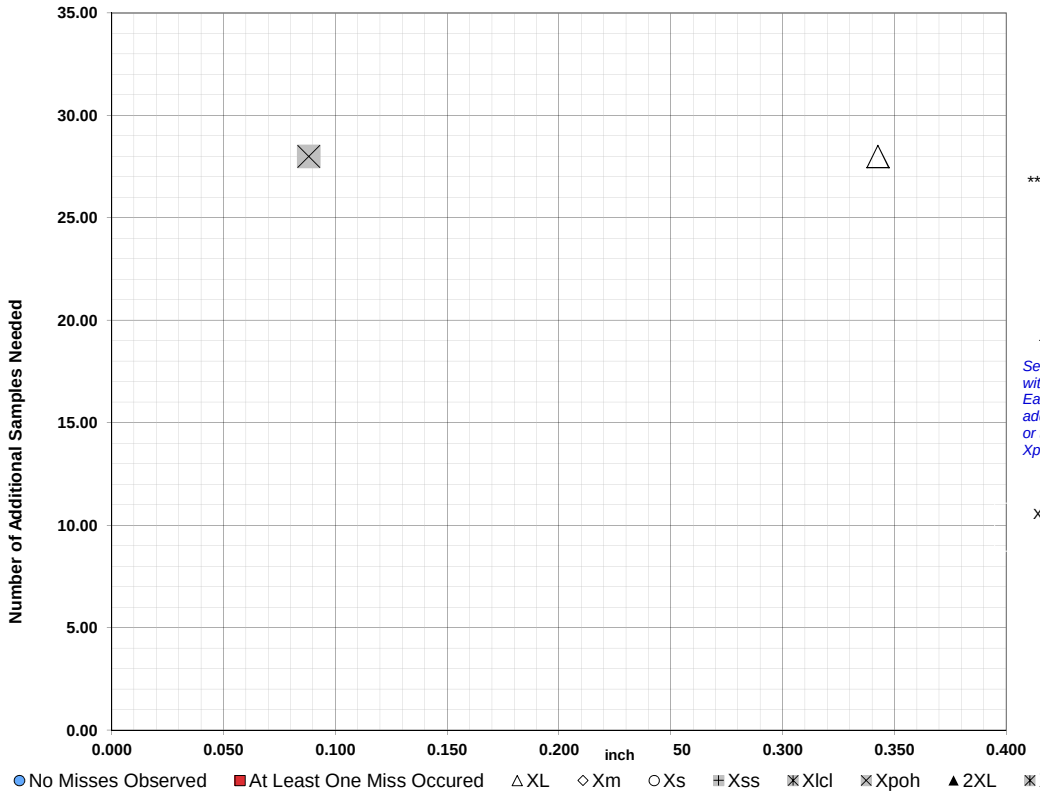



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.088 | 28 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

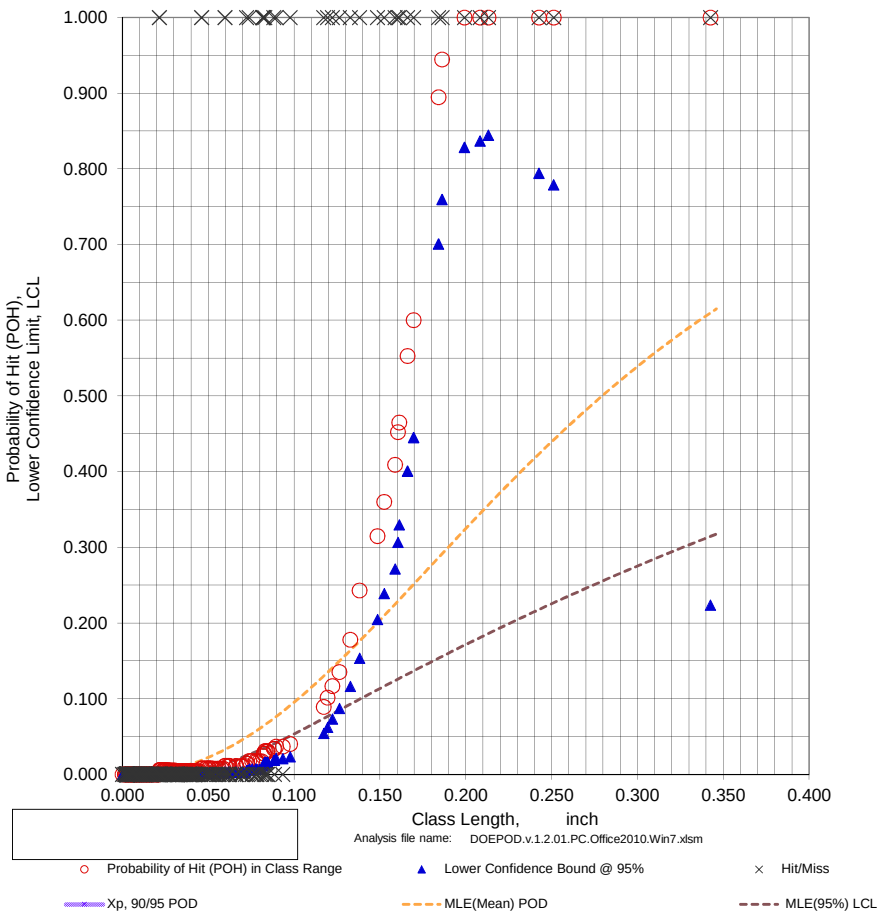
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = C7002L.XLS
Data Set Name = C7002L(Lpi-a)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:43 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8444 | |
| Classwidth @ Best LCL = | 0.0970 | inch |
| Classlength @ Best LCL = | 0.2131 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0976 -0.004 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.350 inch

NTIAC 90/95 POD = 0.901 @ 0.580 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.213 | inch |
| Samples Needed @ Xlcl = | 11 | |
| POH Classlength, Xpoh = | 0.199 | inch |
| Samples Needed @ Xpoh = | 13 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C7002L.XLS
Data Set Name = C7002L(Lpi-a)

## Directed DOE Options

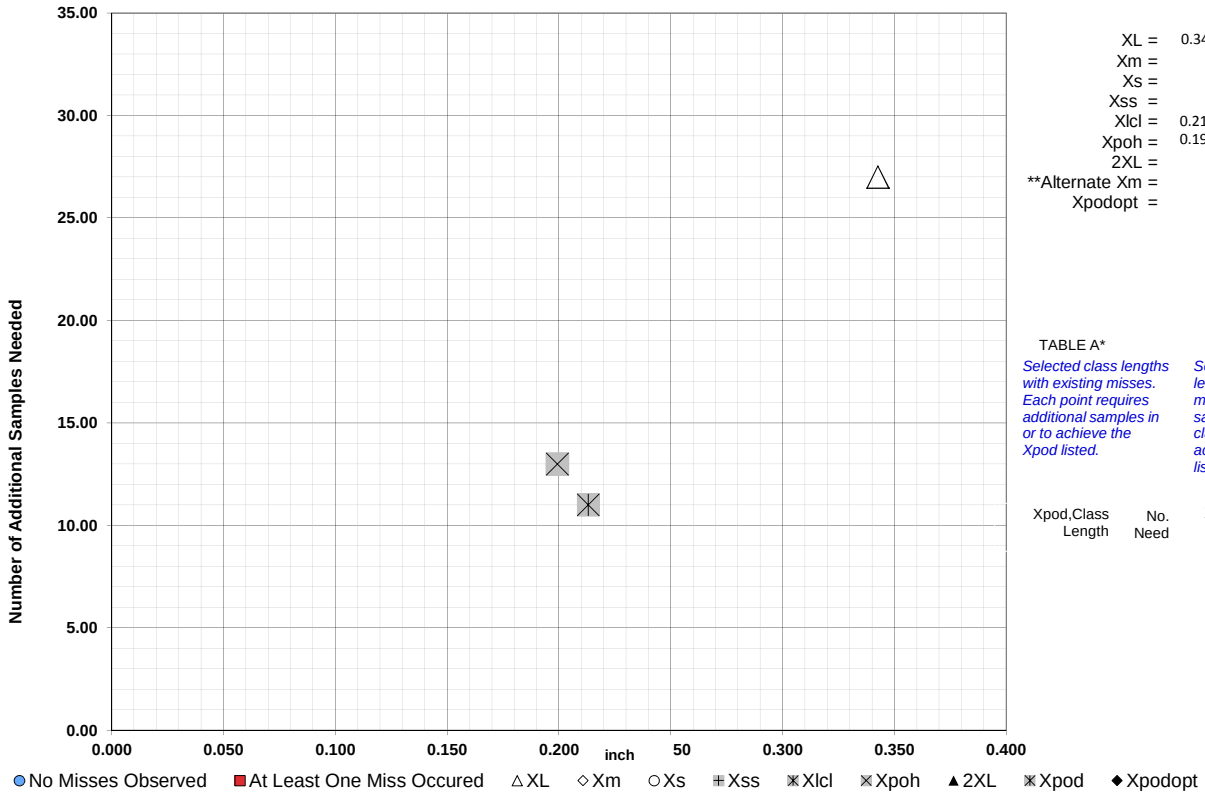



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.213 | 11 |
| Xpoh = | 0.199 | 13 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

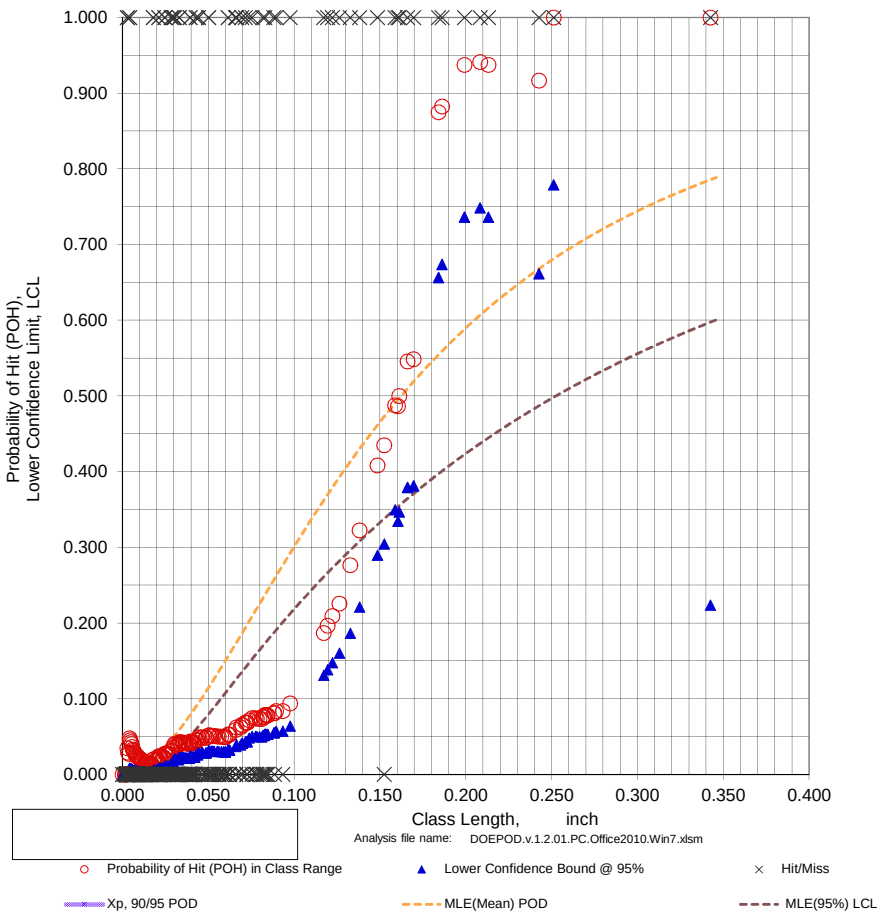
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = C7003L.XLS
Data Set Name = C7003L(Lpi-d)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:45 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0930 | inch |
| Classlength @ Best LCL = | 0.2512 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1587 -0.006 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.300 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.505 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.251 | inch |
| Samples Needed @ Xlcl = | 17 | |
| POH Classlength, Xpoh = | 0.251 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C7003L.XLS
Data Set Name = C7003L(Lpi-d)

## Directed DOE Options

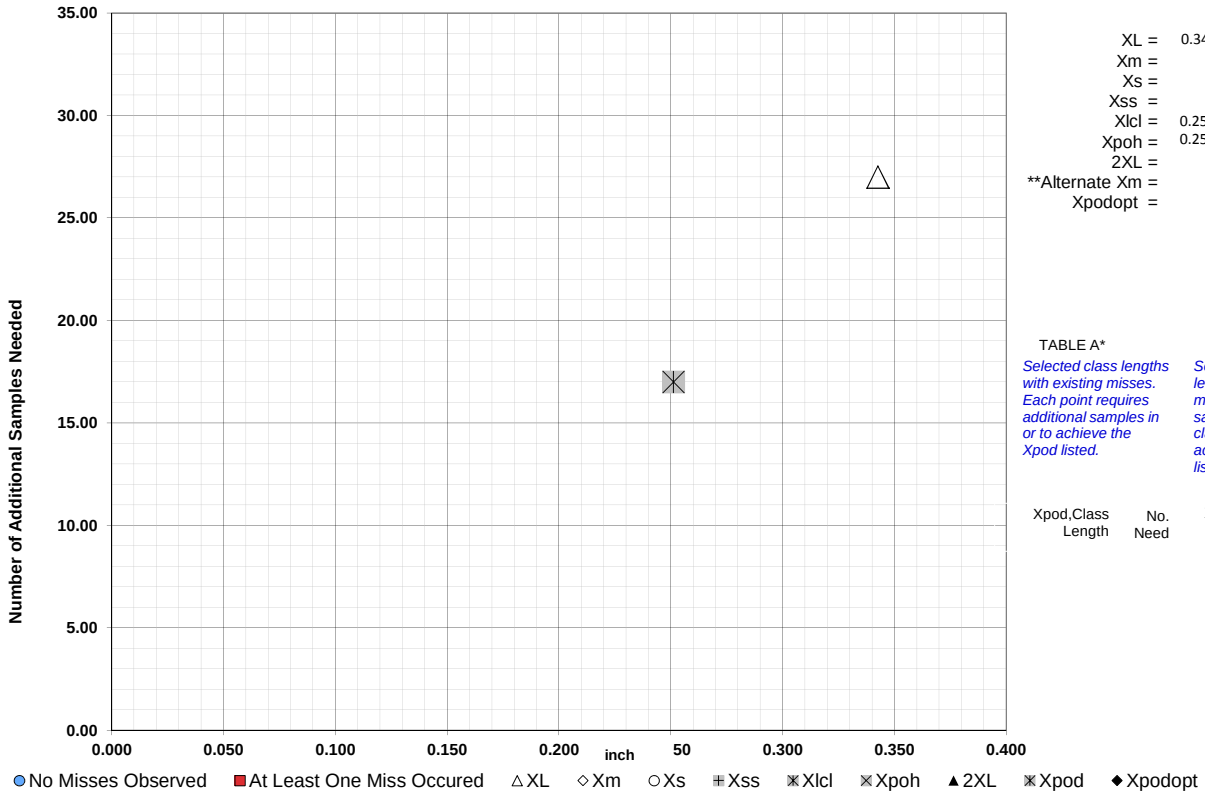



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.251 | 17 |
| Xpoh = | 0.251 | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

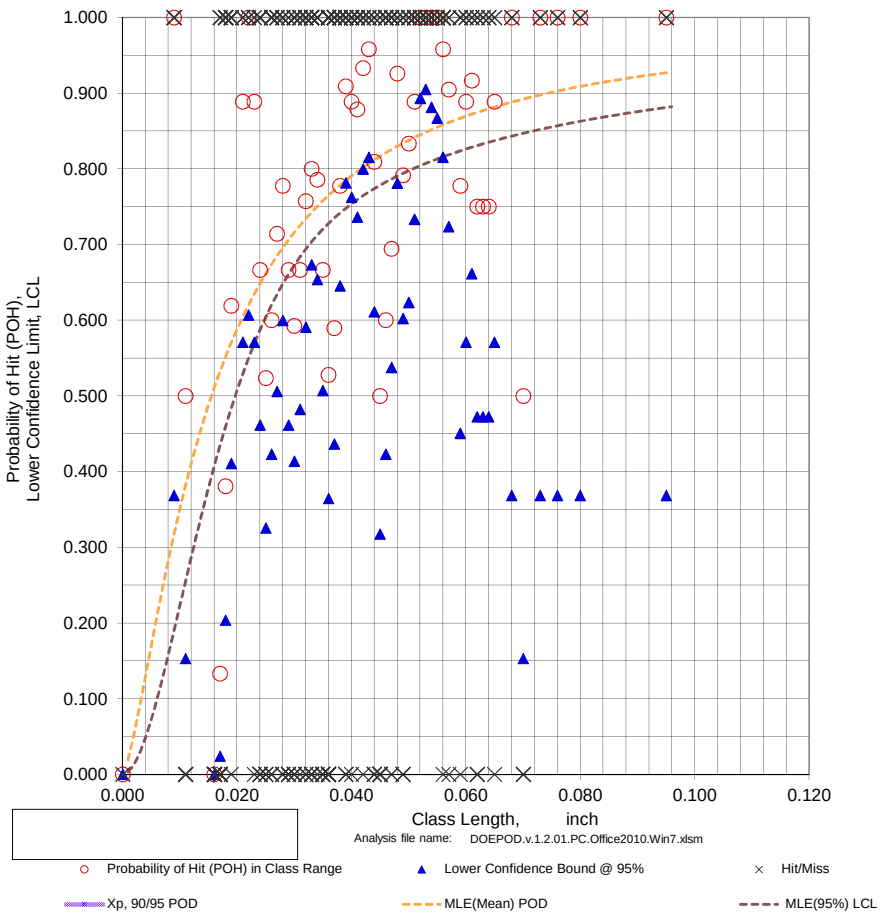
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.159.**

**Warning: No false call analysis.**




File Name = **C8001(3)D.xls**

Data Set Name = **C8001(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:47 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0530 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.120 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.095 | inch |
| Samples Needed @ XL = | 17 | |
| Classlength Mid-point , Xm = | 0.080 | inch |
| Samples Needed @ Xm = | 26 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C8001(3)D.xls
Data Set Name = C8001(3)D(CK. NO.)

## Directed DOE Options

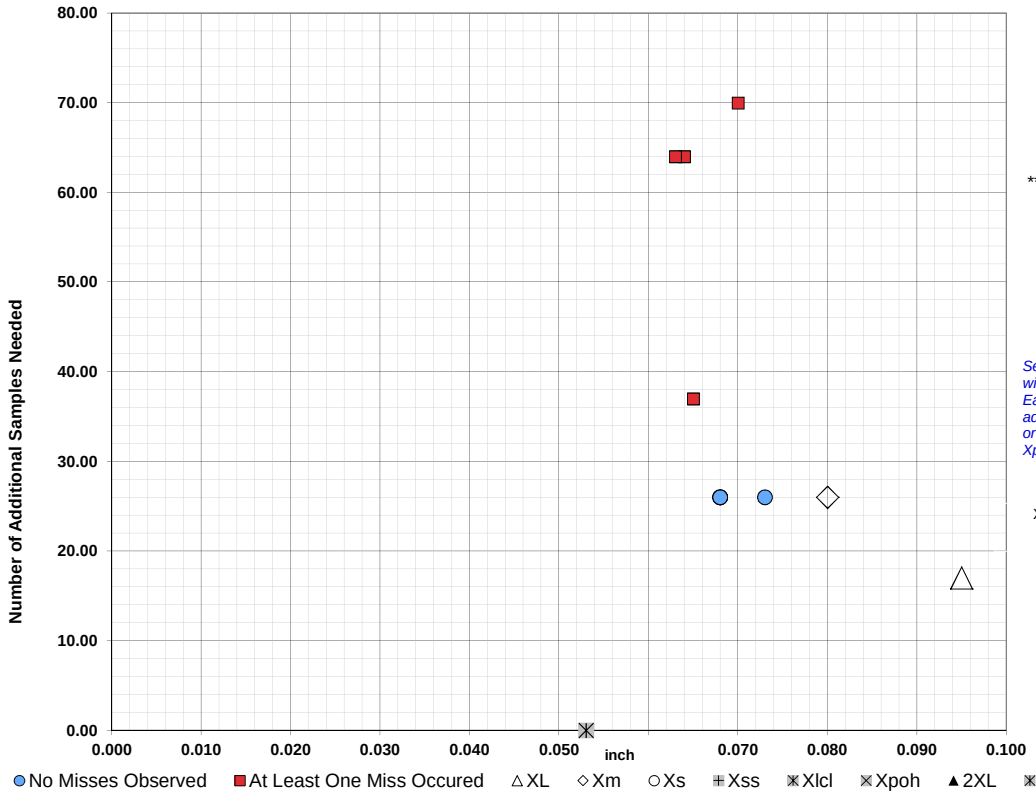



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | 17 |
| Xm = | 0.080 | 26 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.0700 | 70 |
| 0.0650 | 37 |
| 0.0640 | 64 |
| 0.0630 | 64 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

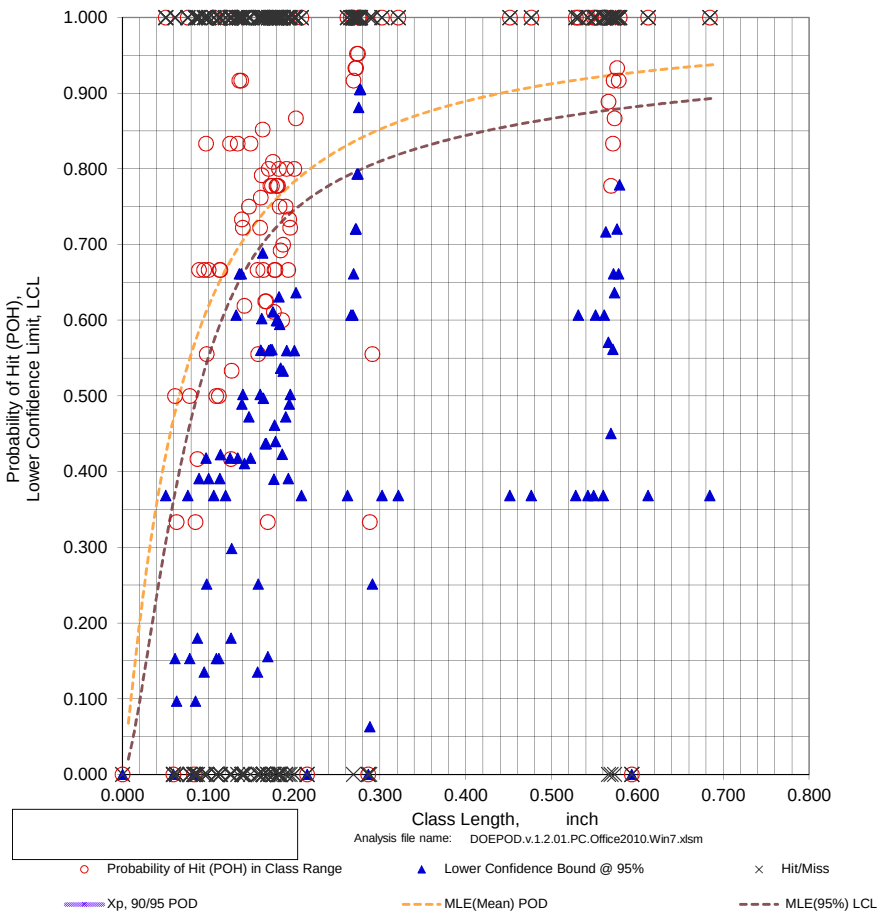
| Xpod,Class Length | No. Need |
|---|---|
| 0.0730 | 26 |
| 0.0680 | 26 |
| 0.0680 | 26 |
| 0.0680 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.828.**

**Warning: No false call analysis.**




File Name = **C8001(3)L.xls**

Data Set Name = **C8001(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:49 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0050 | inch |
| Classlength @ 90/95 Xpod = | 0.2760 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.445 | inch |
| NTIAC 90/95 POD = | | @ | | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | 0.579 | inch |
| Samples Needed @ Xm = | 17 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C8001(3)L.xls
Data Set Name = C8001(3)L(CK. NO.)

## Directed DOE Options

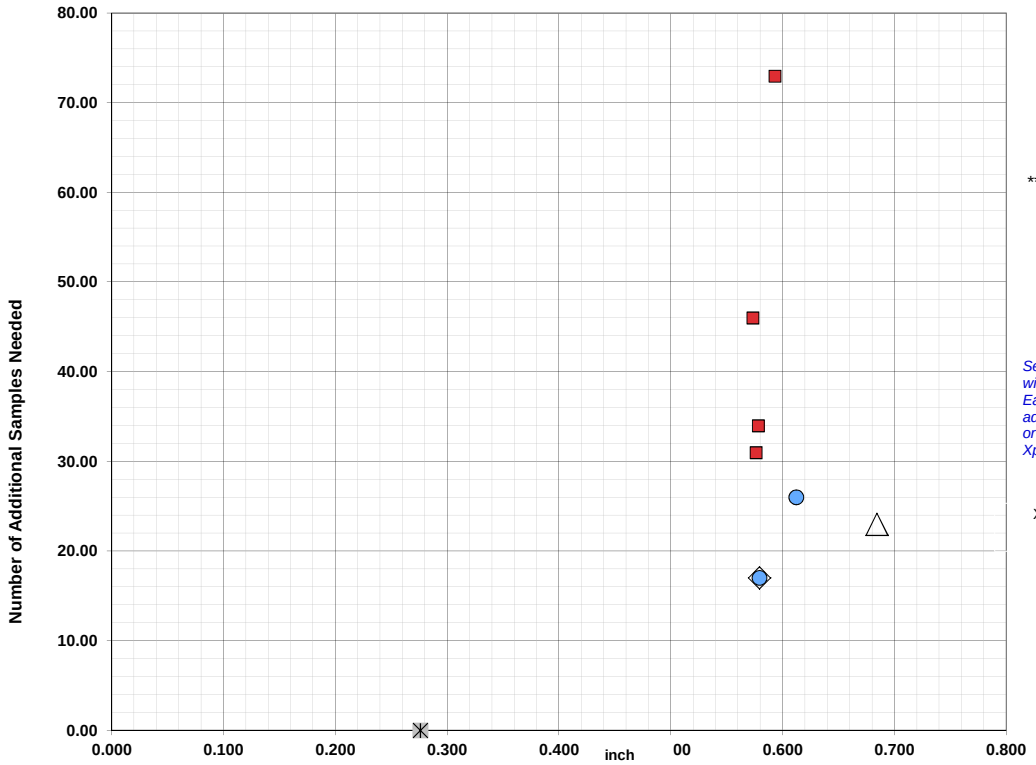



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | 23 |
| Xm = | 0.579 | 17 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5930 | 73 |
| 0.5780 | 34 |
| 0.5760 | 31 |
| 0.5730 | 46 |

TABLE B*

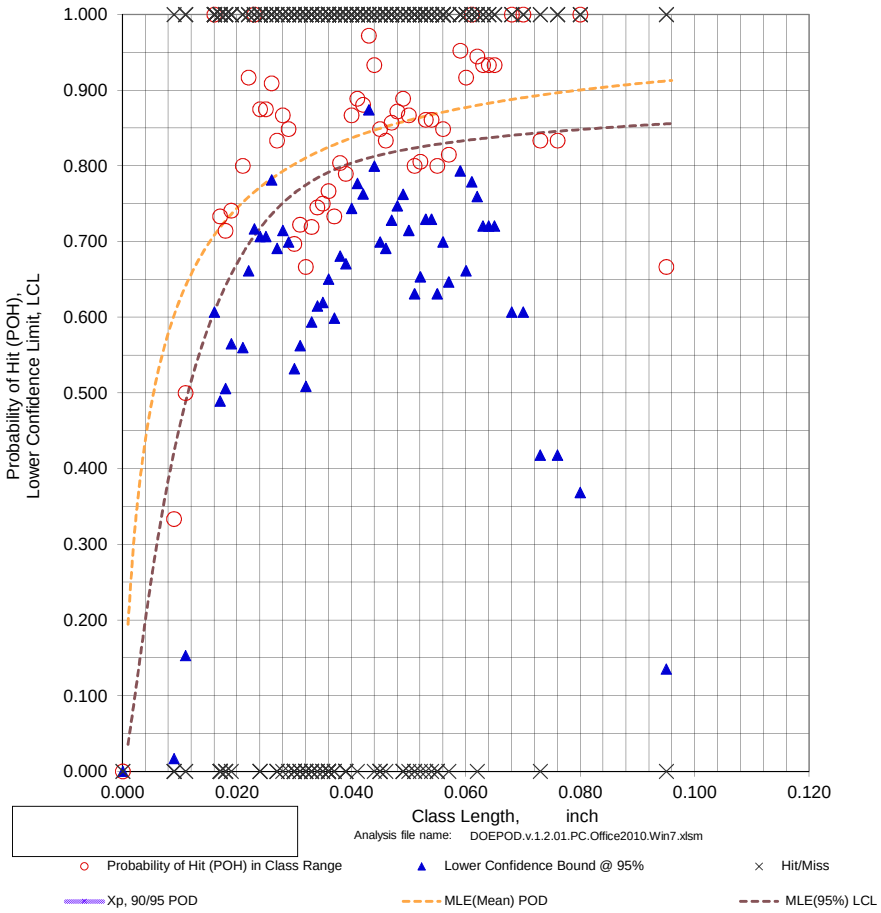
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.6120 | 26 |
| 0.5790 | 17 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C8002(3)D.xls
Data Set Name = C8002(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:50 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8739 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.0430 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.900 @ 0.080 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.190 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C8002(3)D.xls
Data Set Name = C8002(3)D(CK. NO.)

## Directed DOE Options

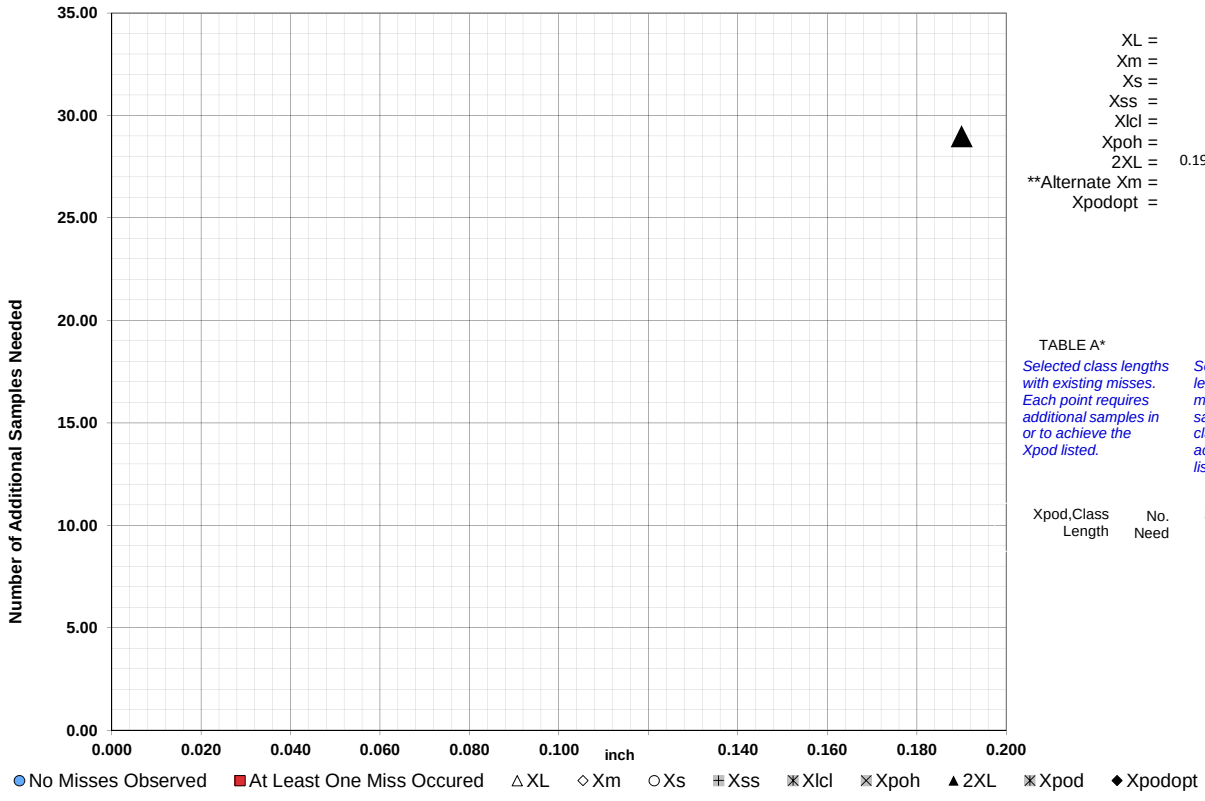



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.190 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

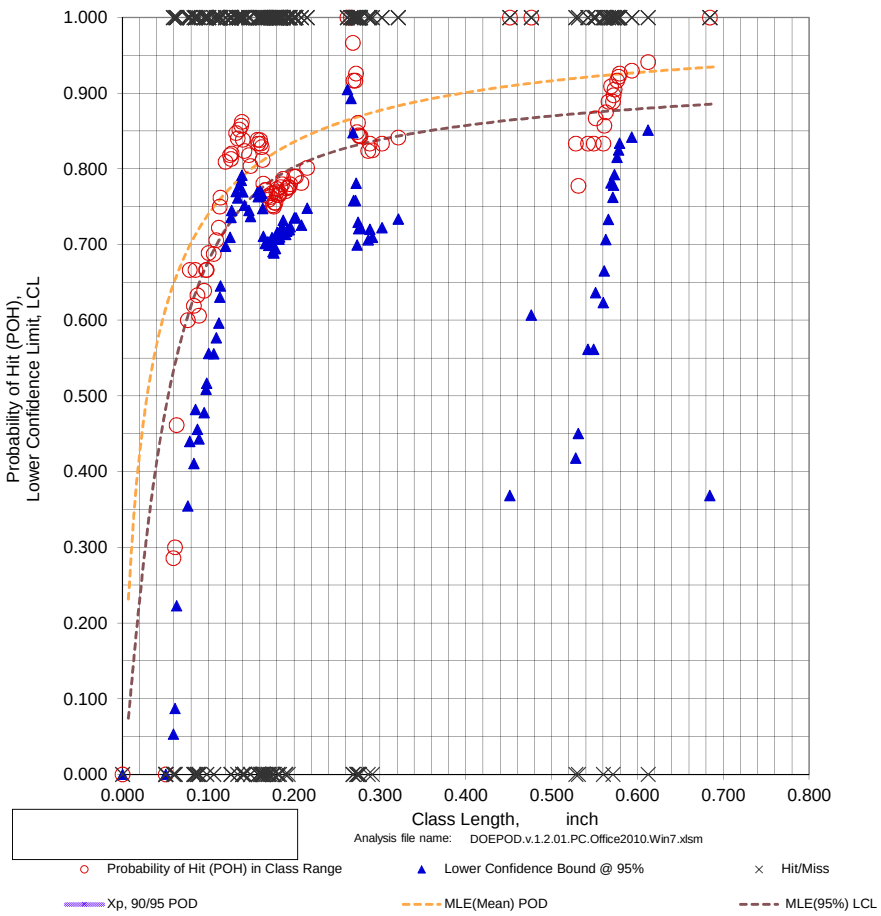
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.786.**

**Warning: No false call analysis.**




File Name = **C8002(3)L.xls**

Data Set Name = **C8002(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:51 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0680 | inch |
| Classlength @ 90/95 Xpod = | 0.2620 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.900 @ 0.395 inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 0.476 | inch |
| Samples Needed @ Xm = | 23 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C8002(3)L.xls
Data Set Name = C8002(3)L(CK. NO.)

## Directed DOE Options

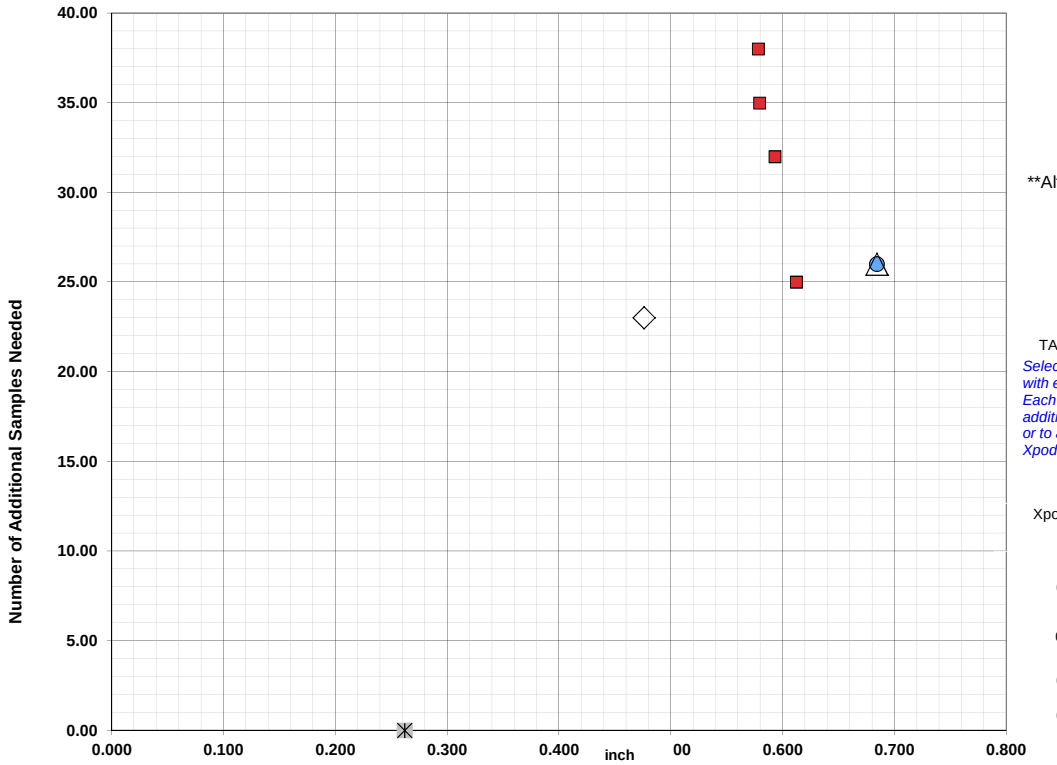



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | 26 |
| Xm = | 0.476 | 23 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.6120 | 25 |
| 0.5930 | 32 |
| 0.5790 | 35 |
| 0.5780 | 38 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

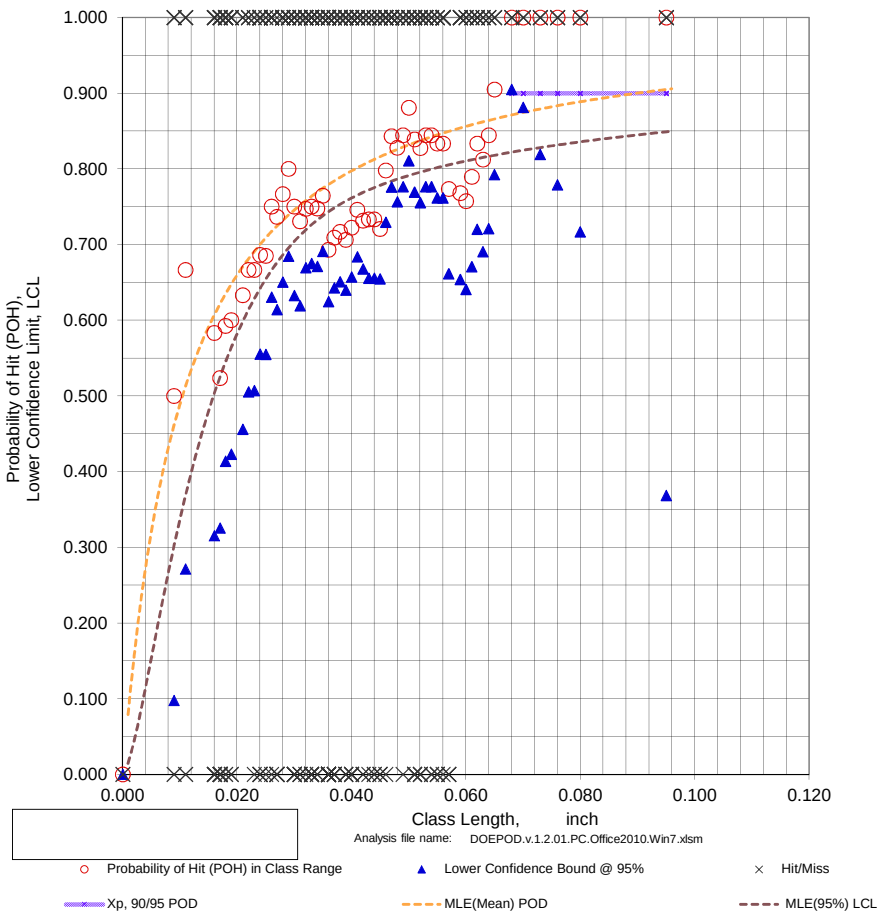
| Xpod,Class Length | No. Need |
|---|---|
| 0.6840 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.204.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **C8003(3)D.xls**
Data Set Name = **C8003(3)D(CK.NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:53 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0090 | inch |
| Classlength @ 90/95 Xpod = | 0.0680 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0590 -0.001 inch 23 Samples

NTIAC 90% POD = 0.900 @ 0.095 inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.095 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.076 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.067 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0680 | inch |

File Name = C8003(3)D.xls
Data Set Name = C8003(3)D(CK.NO.)

## Directed DOE Options

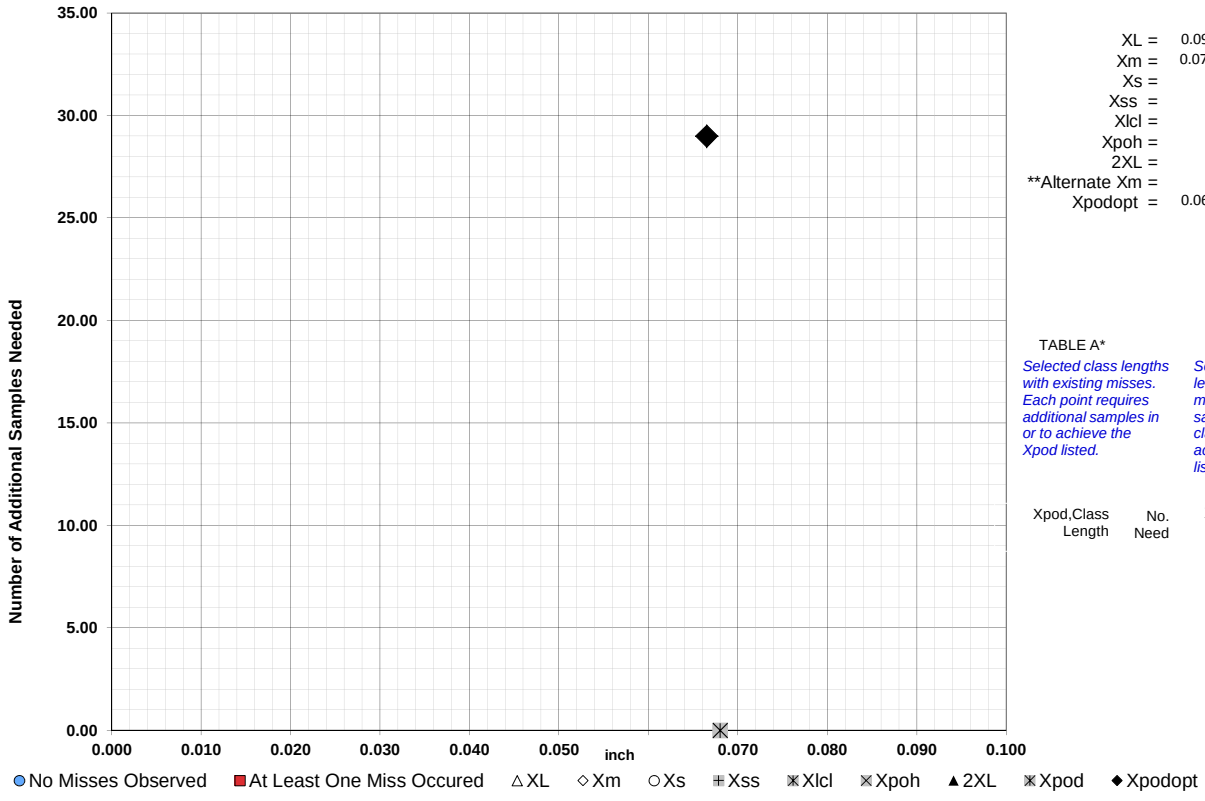



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | |
| Xm = | 0.076 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.067 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

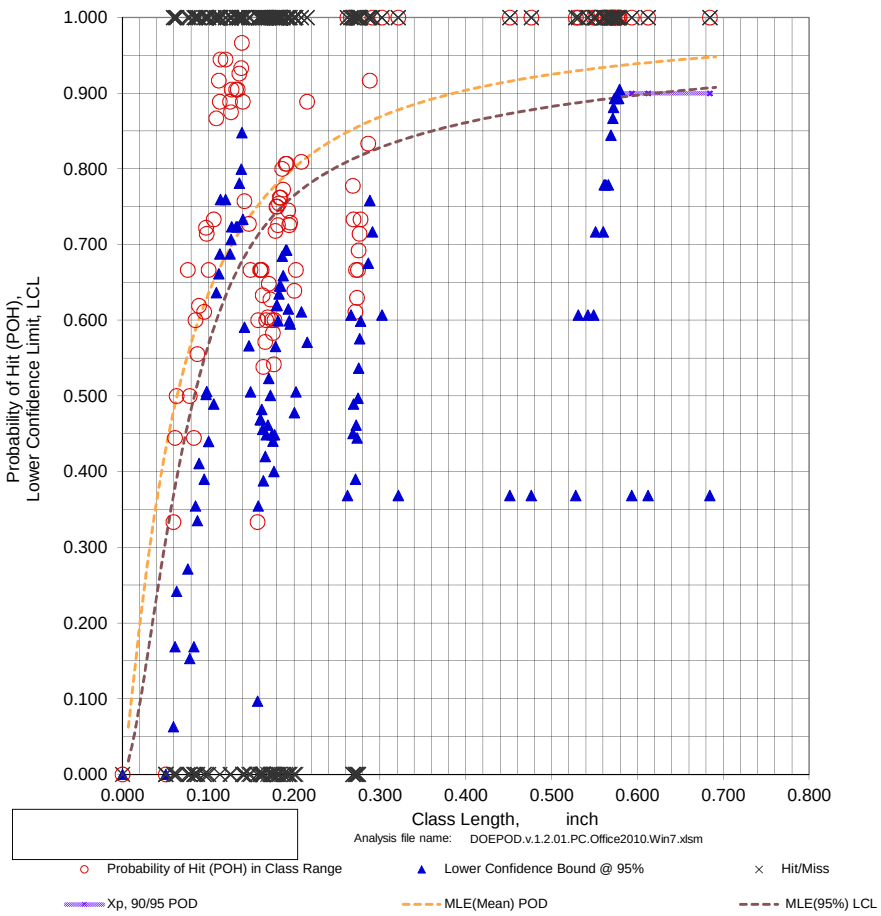
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.737.**

**Warning: No false call analysis.**




File Name = **C8003(3)L.xls**

Data Set Name = **C8003(3)L(CK.NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:54 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0130 | inch |
| Classlength @ 90/95 Xpod = | 0.5790 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.2770 -0.001 inch 20 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.405 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.665 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.612 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.291 | inch |
| Samples Needed @Xpodopt = | 20 | |
| Xp = | 0.5790 | inch |

File Name = C8003(3)L.xls
Data Set Name = C8003(3)L(CK.NO.)

## Directed DOE Options

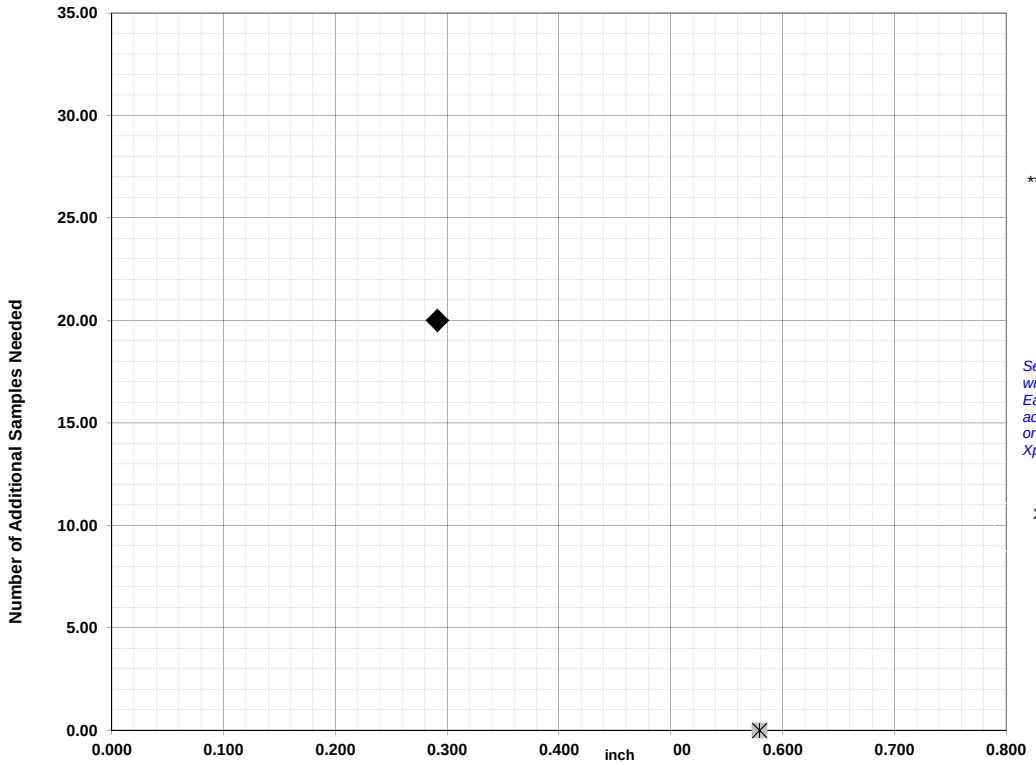



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | |
| Xm = | 0.612 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.291 | 20 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

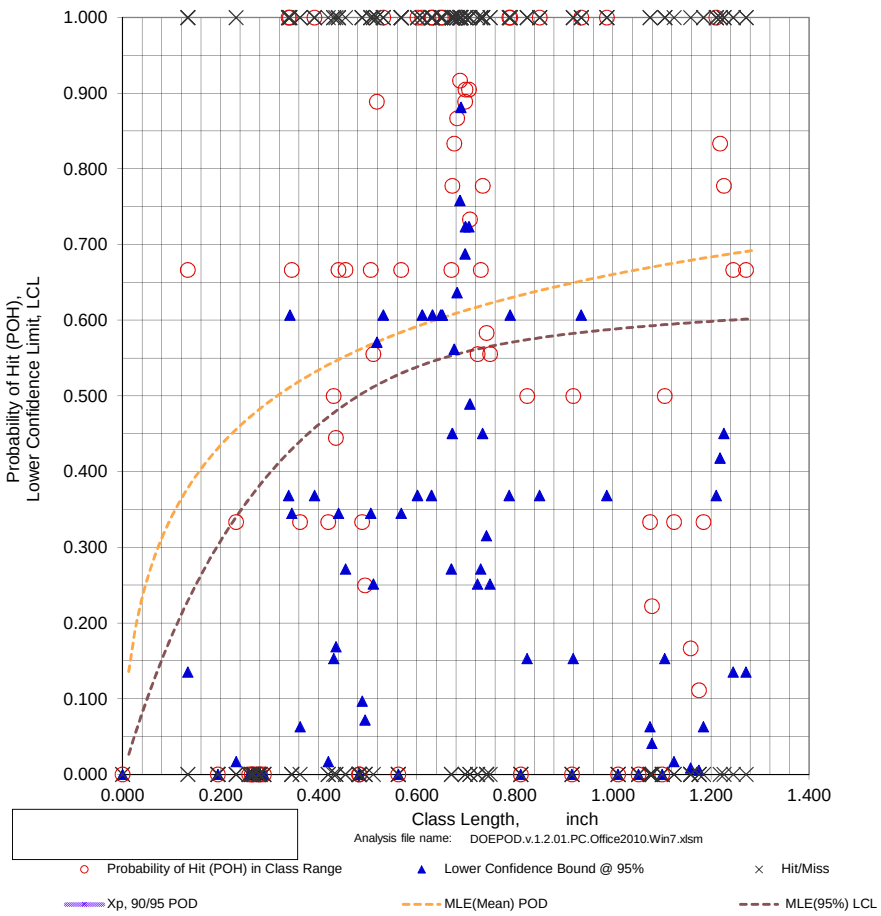
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C9001(3)L.xls
Data Set Name = C9001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:56 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0180 | inch |
| Classlength @ Best LCL = | 0.6900 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C9001(3)L.xls
Data Set Name = C9001(3)L(CK. NO.)

## Directed DOE Options

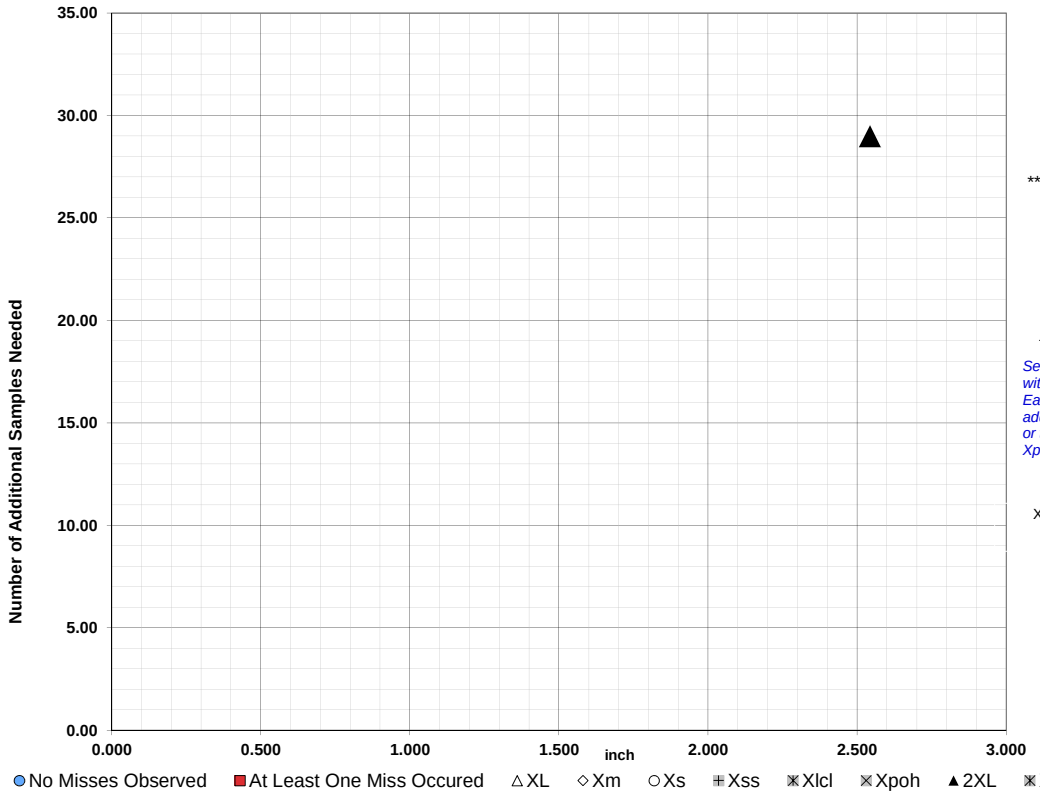



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

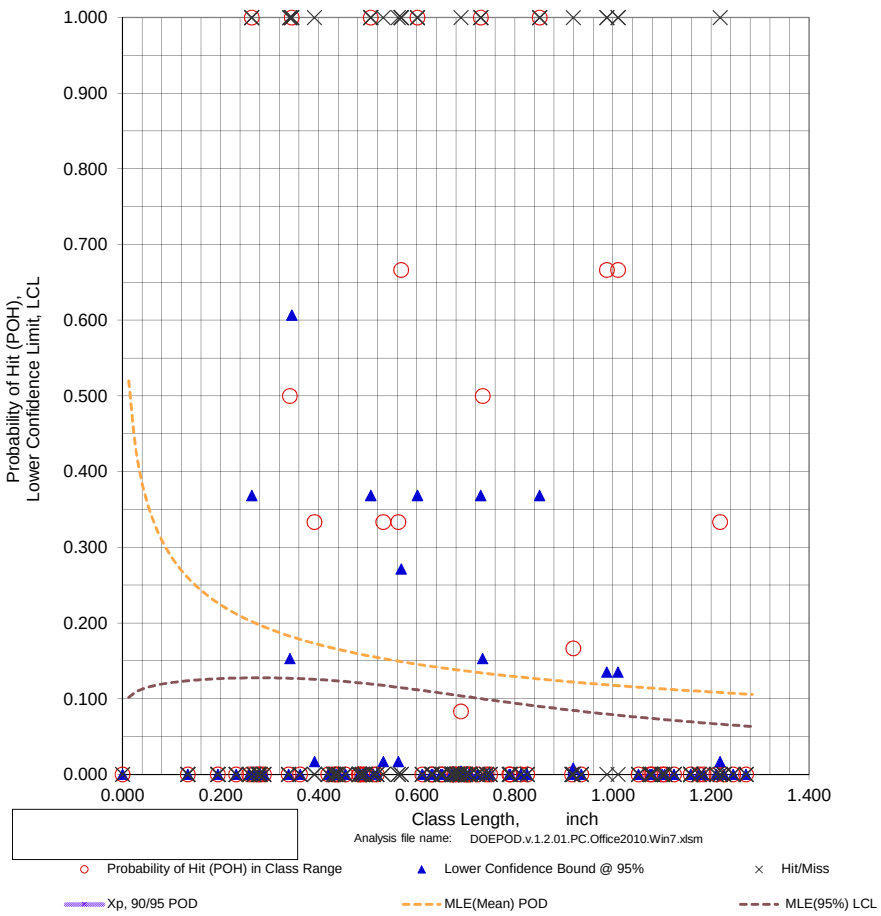
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C9002(3)L.xls
Data Set Name = C9002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 9:57 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.3450 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C9002(3)L.xls
Data Set Name = C9002(3)L(CK. NO.)

## Directed DOE Options

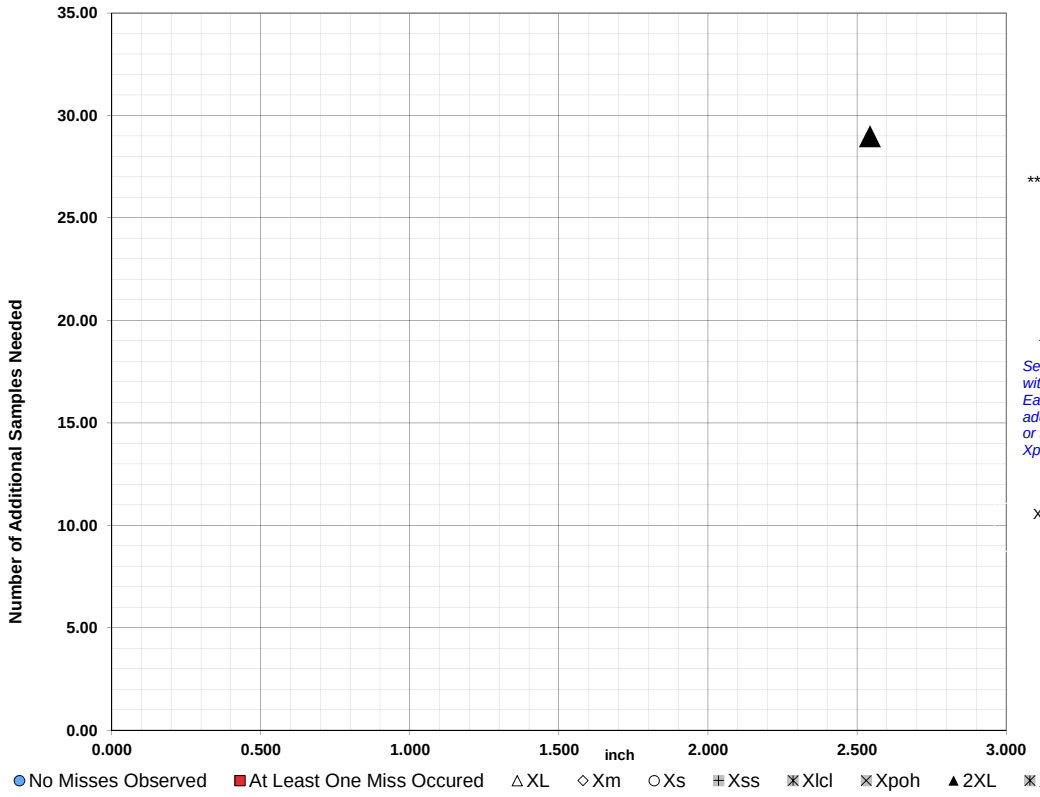



TABLE C

| Class Length | | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

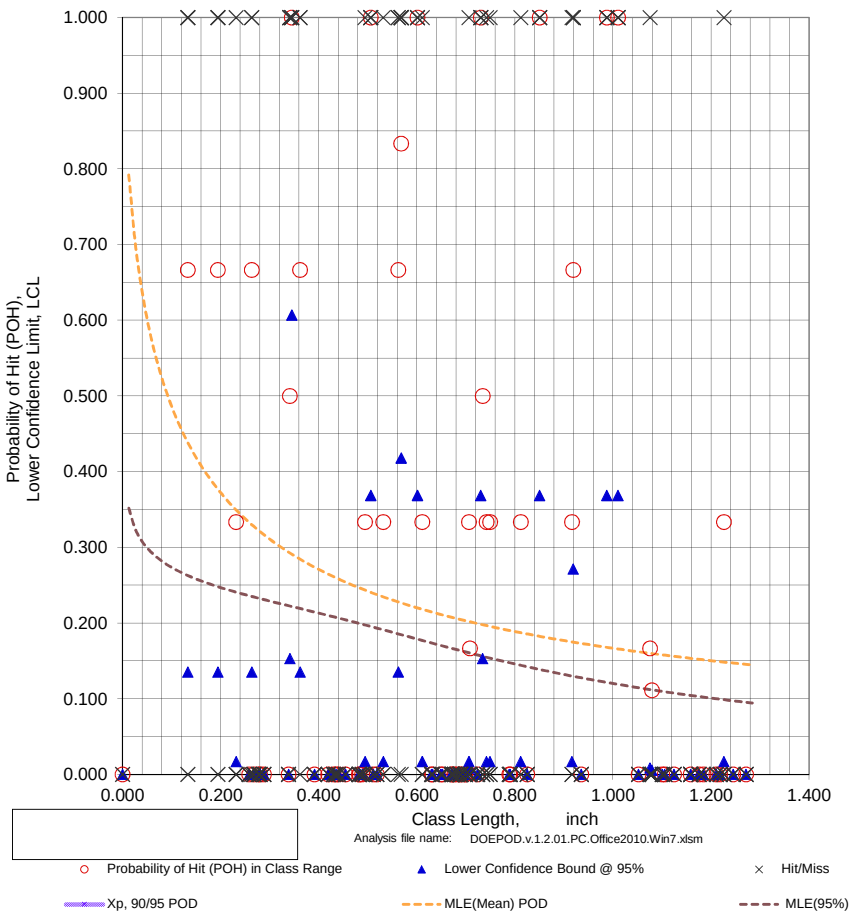
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = C9003(3)L.xls
Data Set Name = C9003(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:00 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.3450 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C9003(3)L.xls
Data Set Name = C9003(3)L(CK. NO.)

## Directed DOE Options

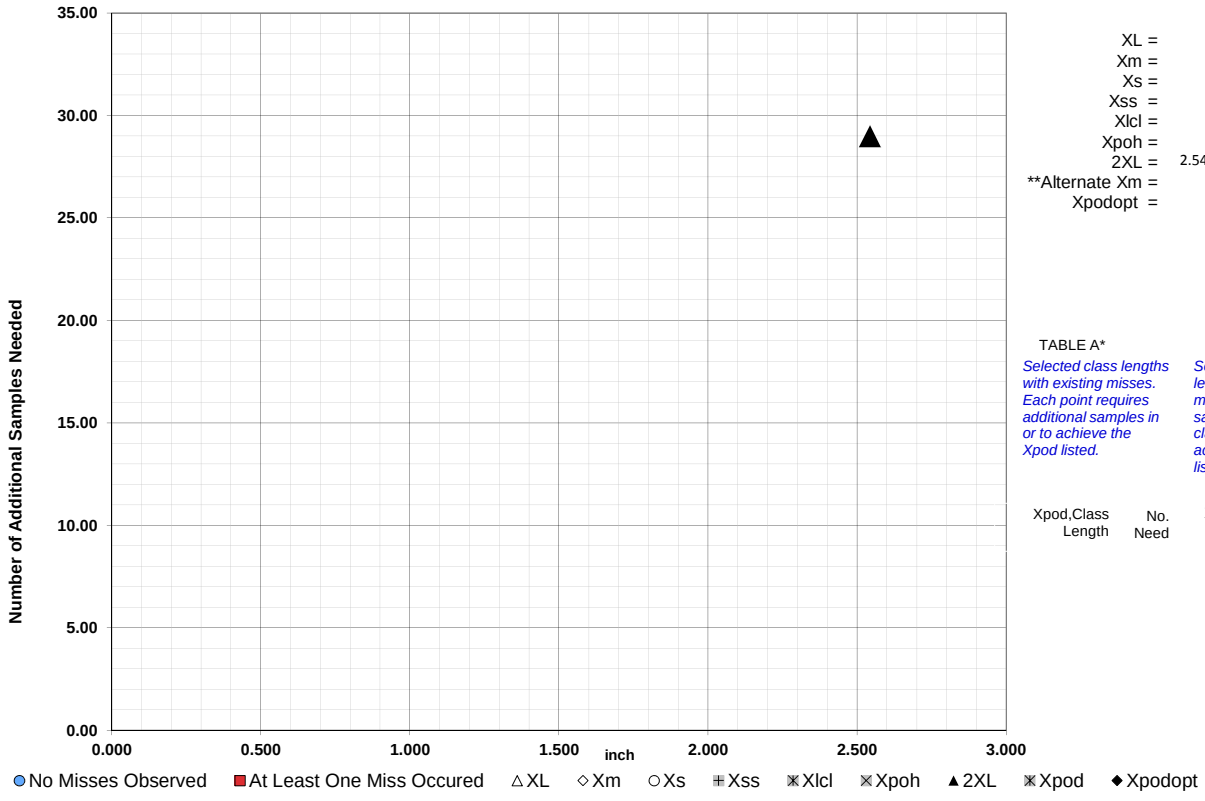



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

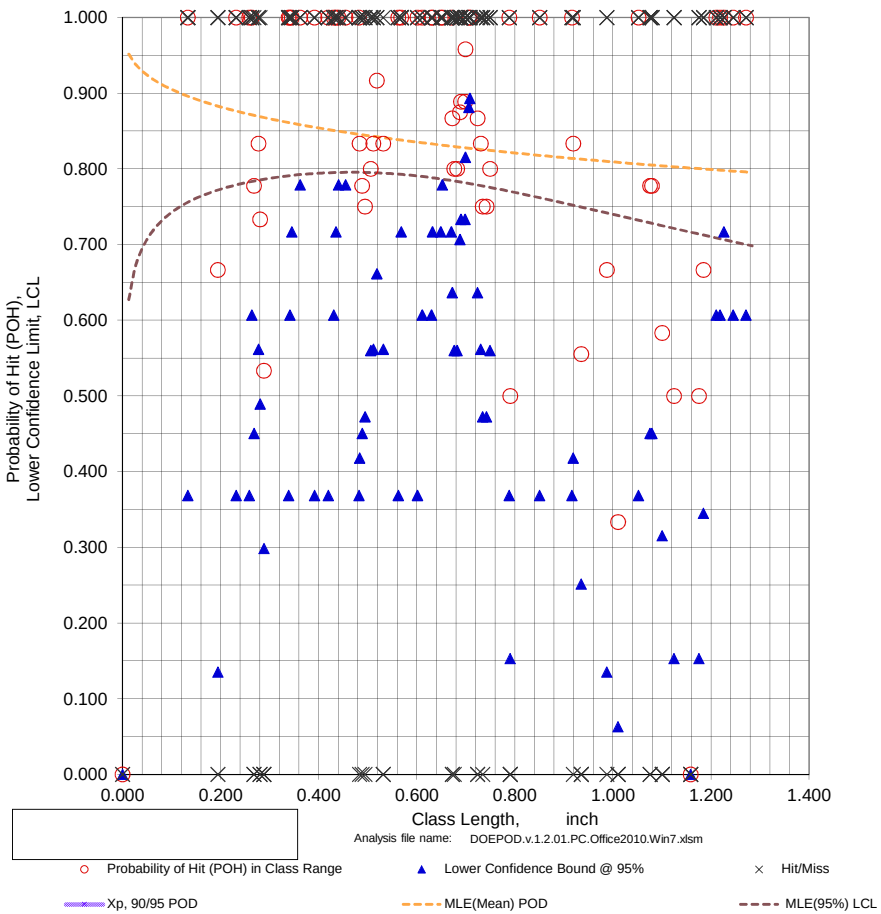
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = C9004(3)L.xls
Data Set Name = C9004(3)L(NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:03 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0260 | inch |
| Classlength @ Best LCL = | 0.7080 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.1750 -0.016 inch 26 Samples

NTIAC 90% POD = 0.965 @ 0.005 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.271 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.210 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = C9004(3)L.xls
Data Set Name = C9004(3)L(NO.)

## Directed DOE Options

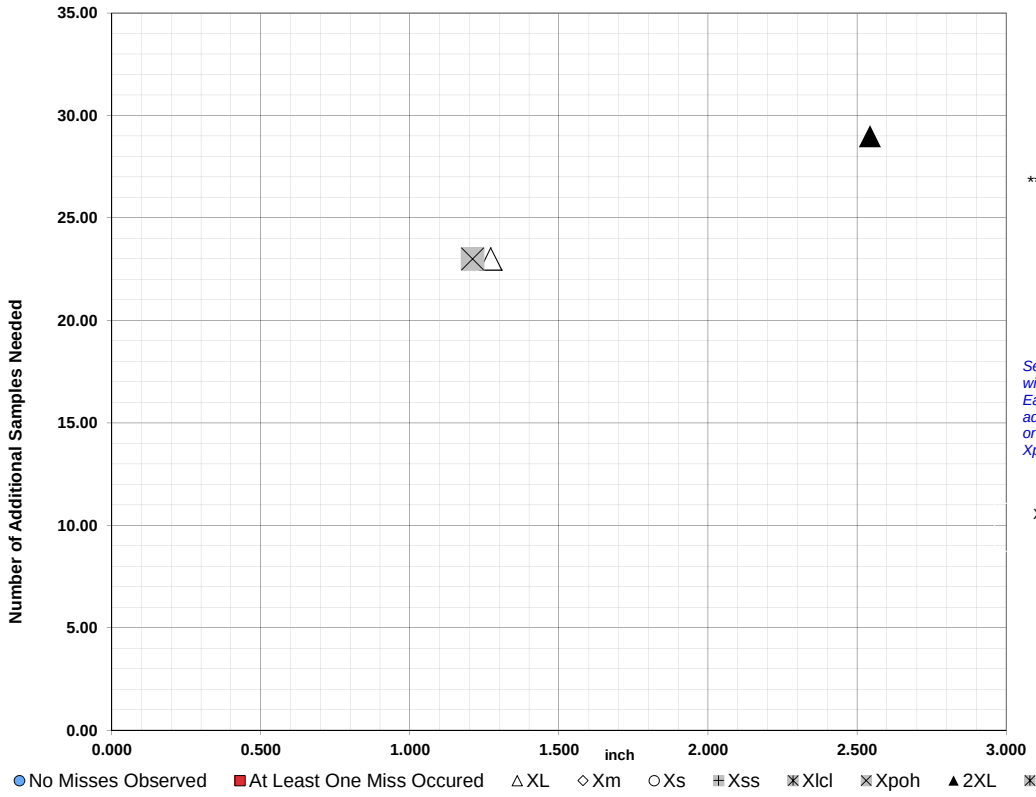



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.271 | 23 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.210 | 23 |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

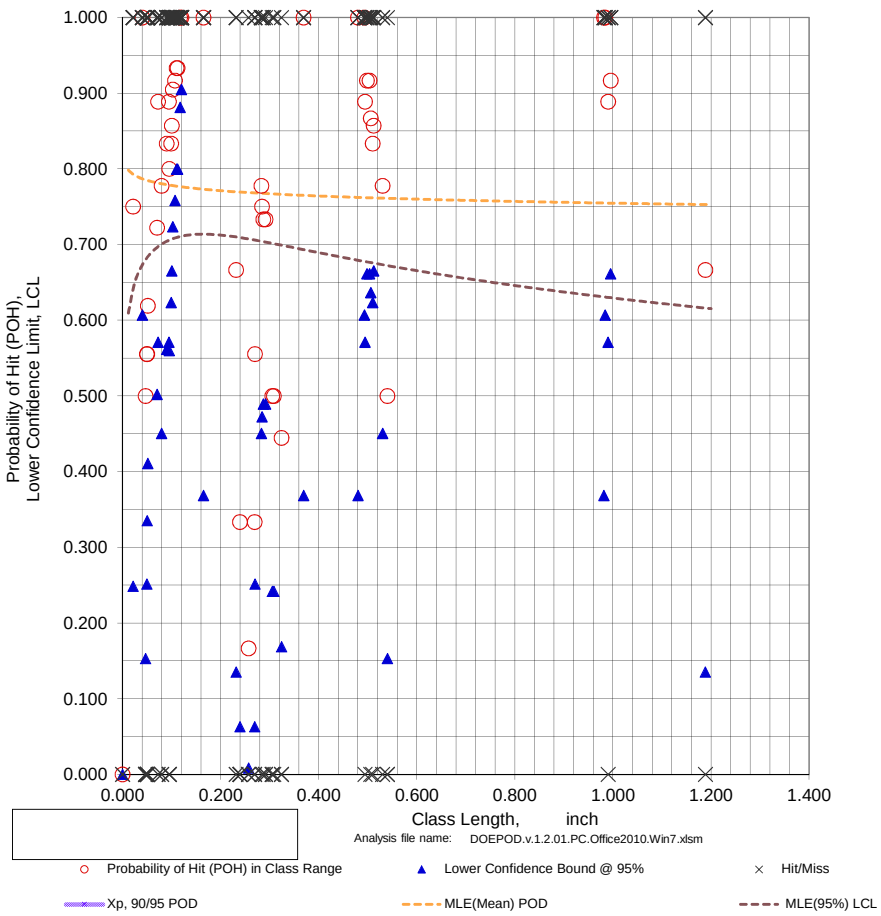
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

**Warning: No false call analysis.**




File Name = **CA001(3)L.xls**

Data Set Name = **CA001(3)L(CRACK)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:04 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0210 | inch |
| Classlength @ 90/95 Xpod = | 0.1200 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.188 | inch |
| Samples Needed @ XL = | 43 | |
| Classlength Mid-point , Xm = | 0.493 | inch |
| Samples Needed @ Xm = | 23 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CA001(3)L.xls
Data Set Name = CA001(3)L(CRACK)

## Directed DOE Options

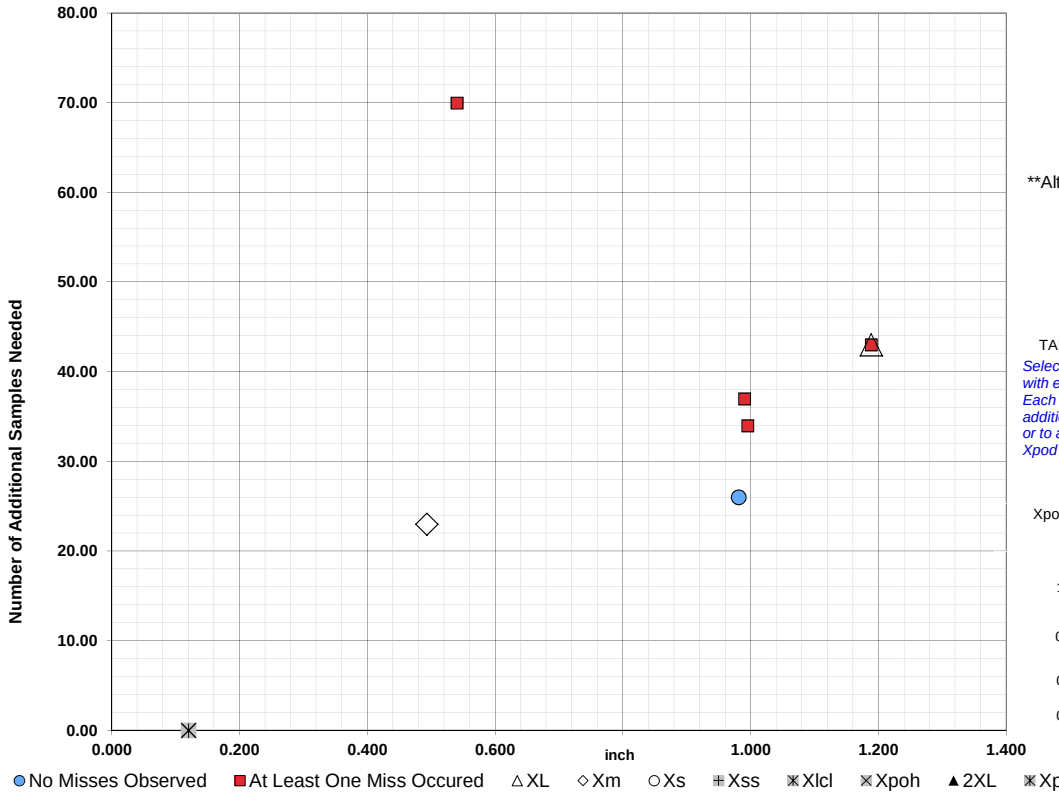



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | 43 |
| Xm = | 0.493 | 23 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.1880 | 43 |
| 0.9950 | 34 |
| 0.9900 | 37 |
| 0.5400 | 70 |

TABLE B*

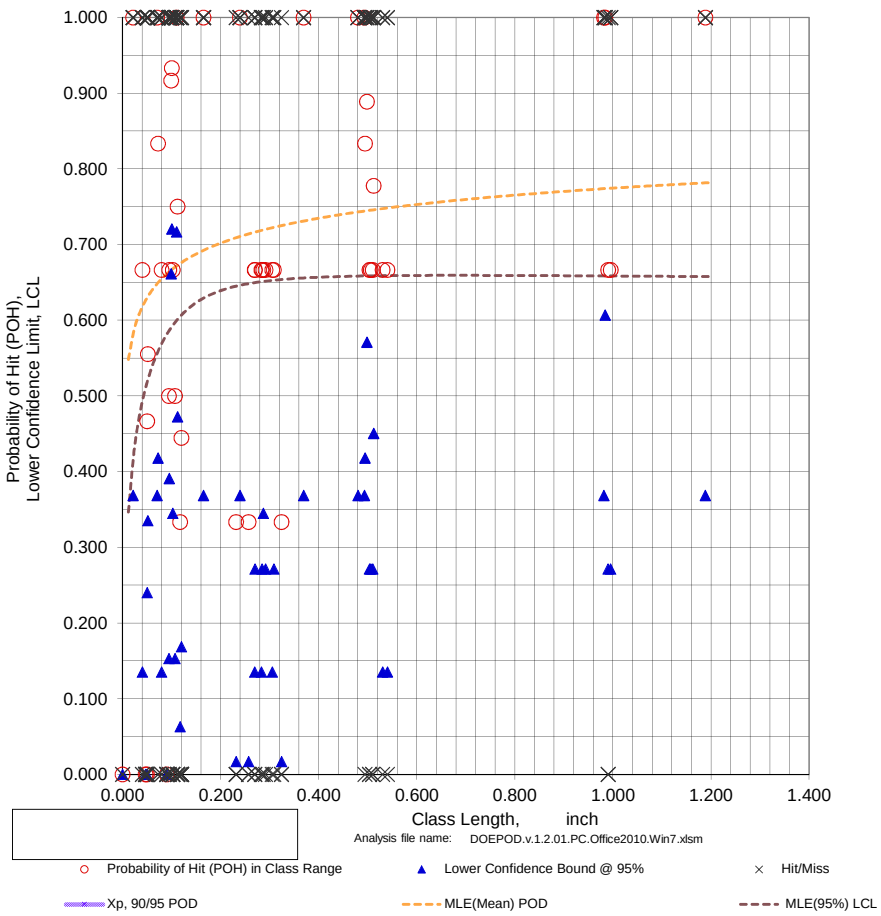
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.9810 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CA002(3)L.xls
Data Set Name = CA002(3)L(CRACK)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:05 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7206 | |
| Classwidth @ Best LCL = | 0.0060 | inch |
| Classlength @ Best LCL = | 0.1000 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.9950 -0.004 inch 26 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.188 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.188 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.376 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CA002(3)L.xls
Data Set Name = CA002(3)L(CRACK)

## Directed DOE Options

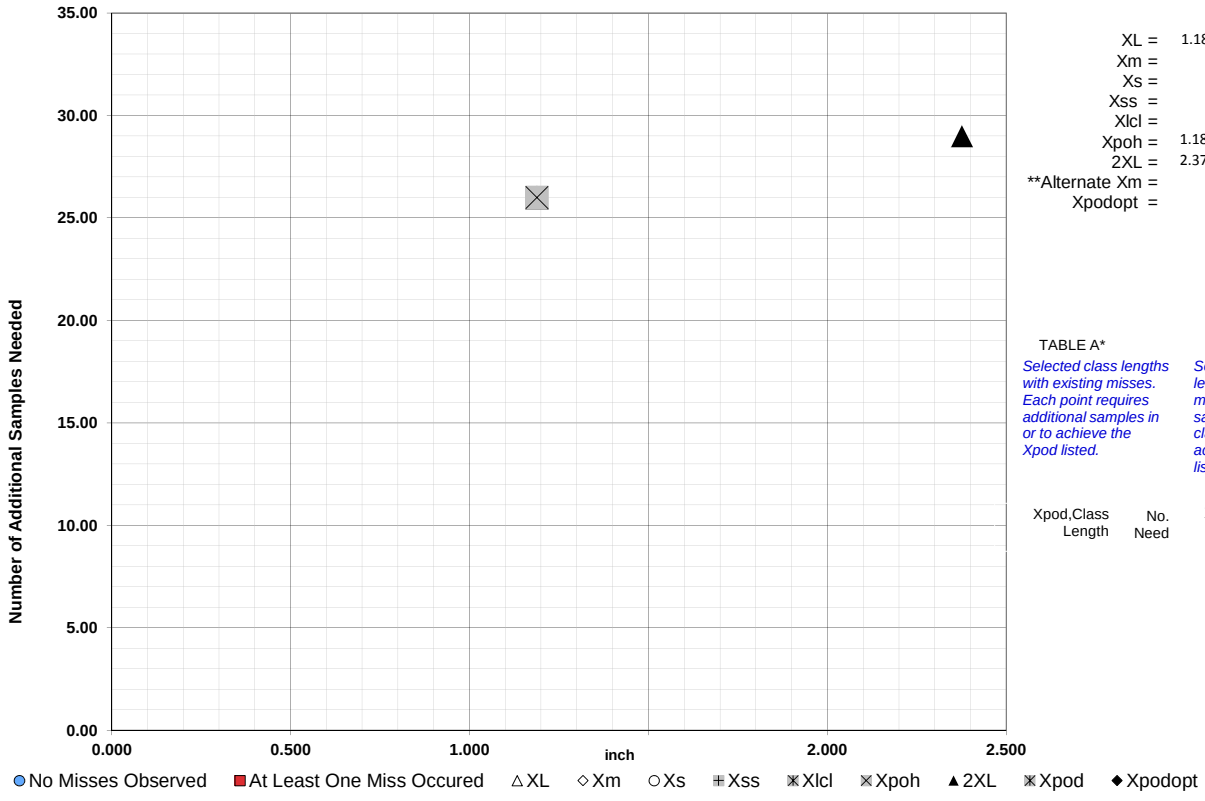



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.188 | 26 |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

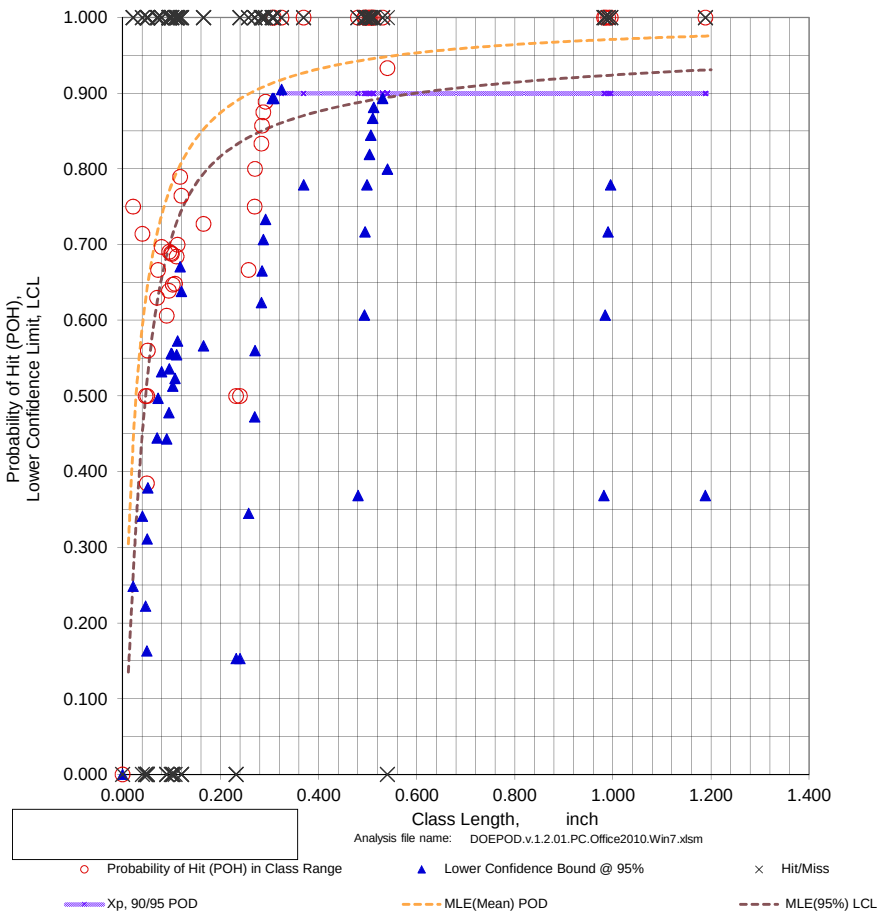
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 20 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CA003(3)L.xls**

Data Set Name = **CA003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:06 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0670 | inch |
| Classlength @ 90/95 Xpod = | 0.3240 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and alternate Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.260 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.600 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.188 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.540 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3240 | inch |

File Name = CA003(3)L.xls
Data Set Name = CA003(3)L(CK. NO.)

## Directed DOE Options

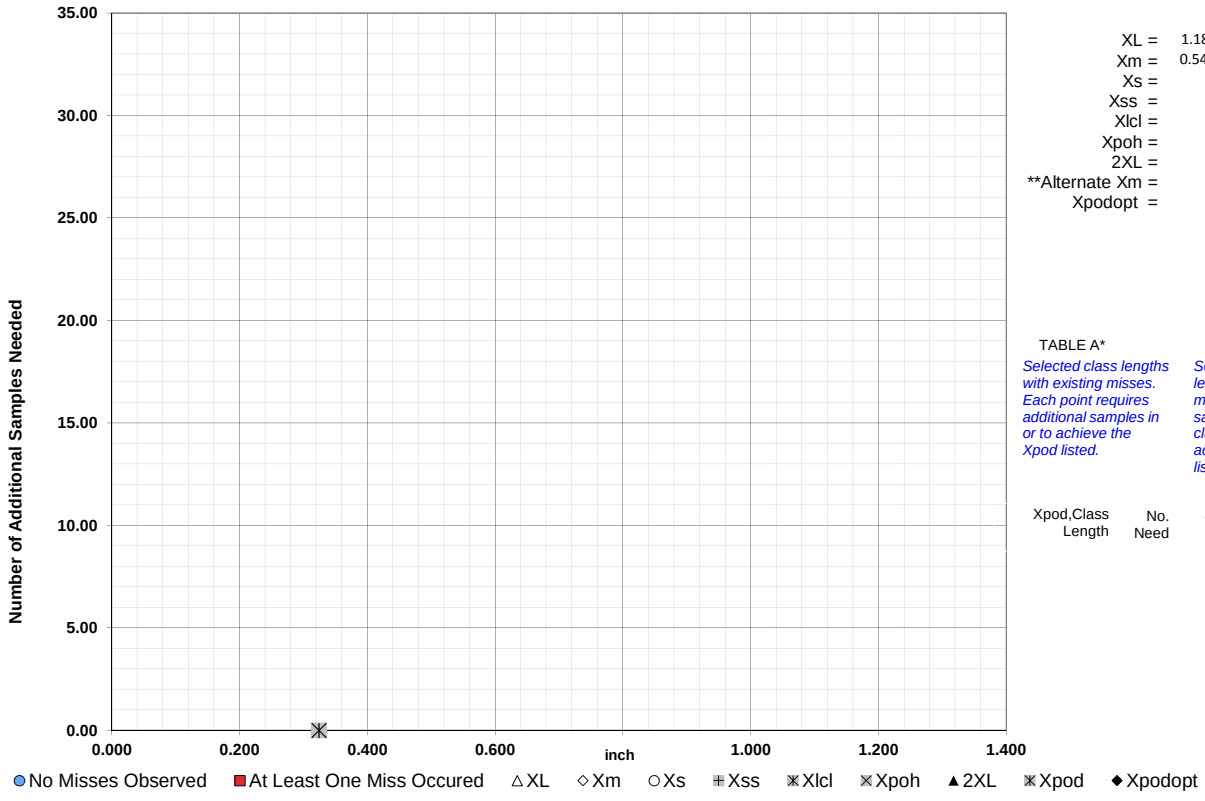



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | |
| Xm = | 0.540 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

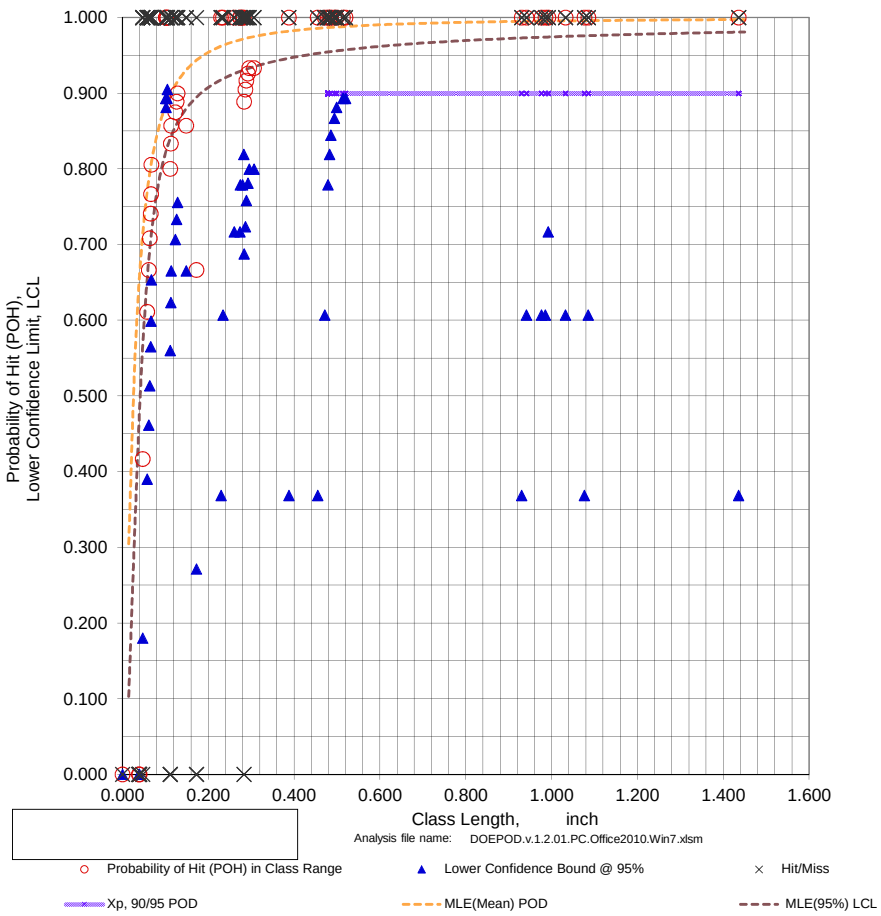
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 14 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CB001(3)L.xls**

Data Set Name = **CB001(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:07 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0430 | inch |
| Classlength @ 90/95 Xpod = | 0.1040 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.055 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.519 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.4780 | inch |

File Name = CB001(3)L.xls
Data Set Name = CB001(3)L(CK. NO.)

## Directed DOE Options

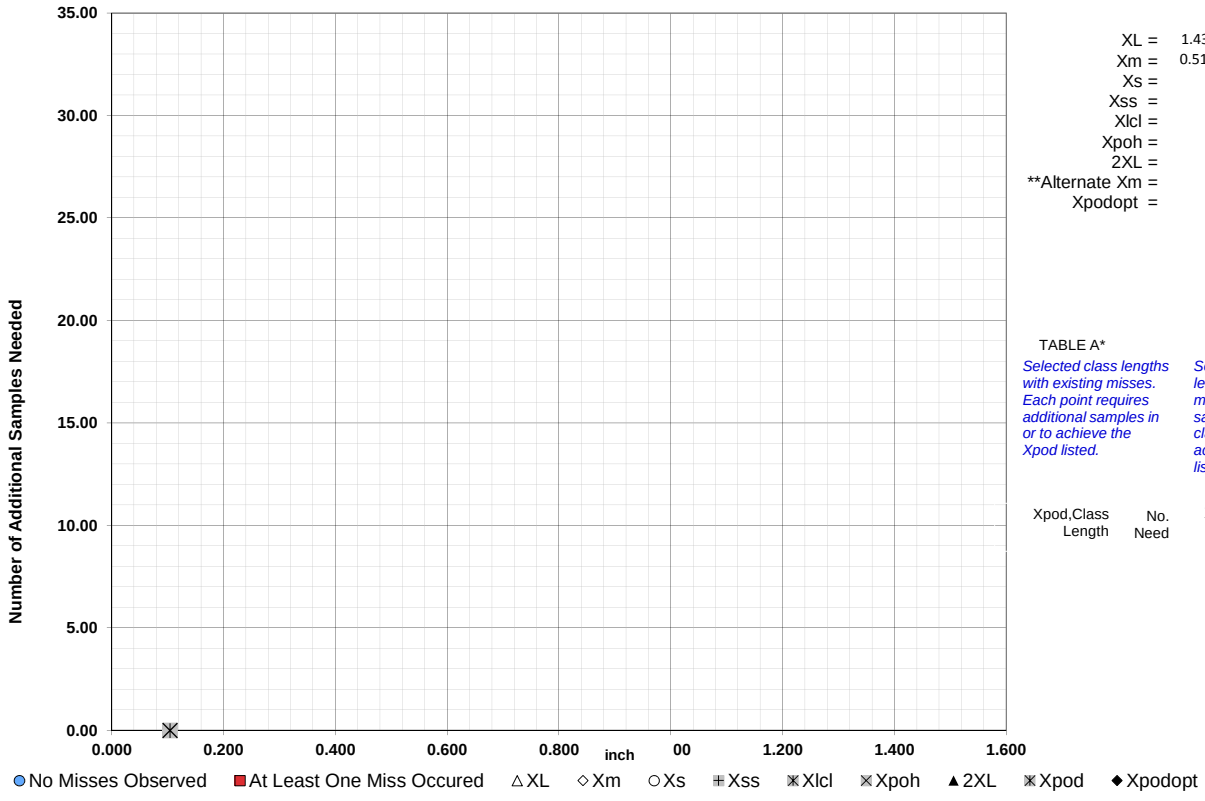



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.435 |
| Xm = | 0.519 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

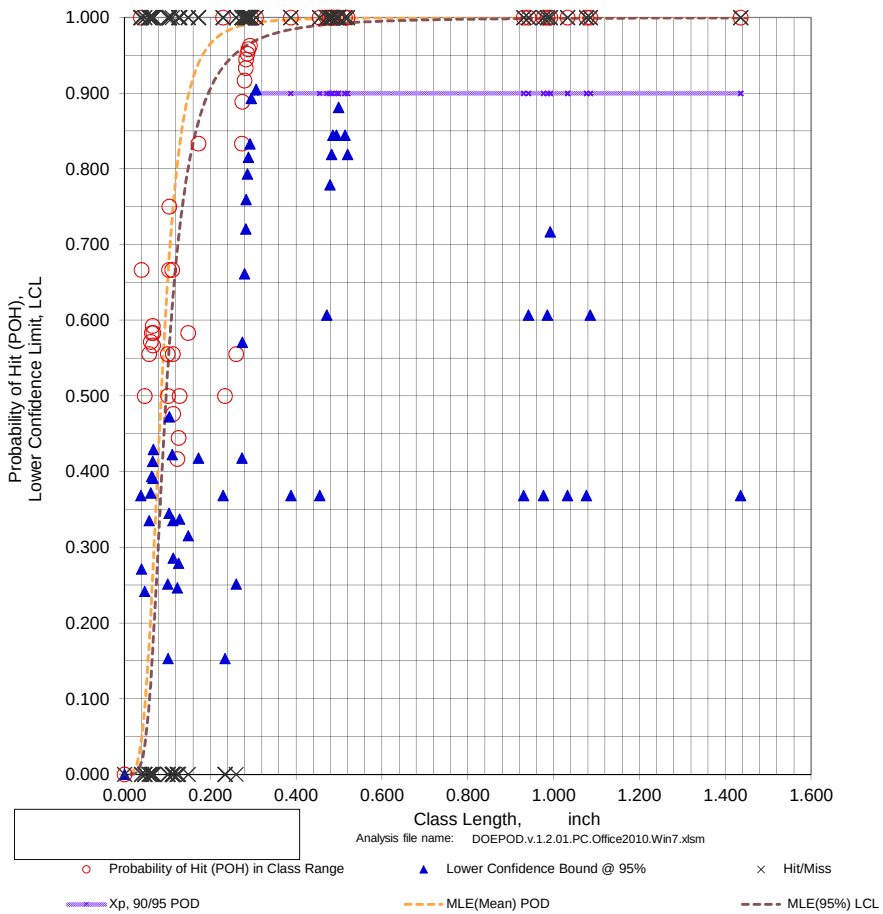
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **CB002(3)L.xls**

Data Set Name = **CB002(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:08 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0330 | inch |
| Classlength @ 90/95 Xpod = | 0.3060 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.2730 -0.012 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.150 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.195 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.992 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.295 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.3060 | inch |

File Name = CB002(3)L.xls
Data Set Name = CB002(3)L(CK. NO.)

## Directed DOE Options

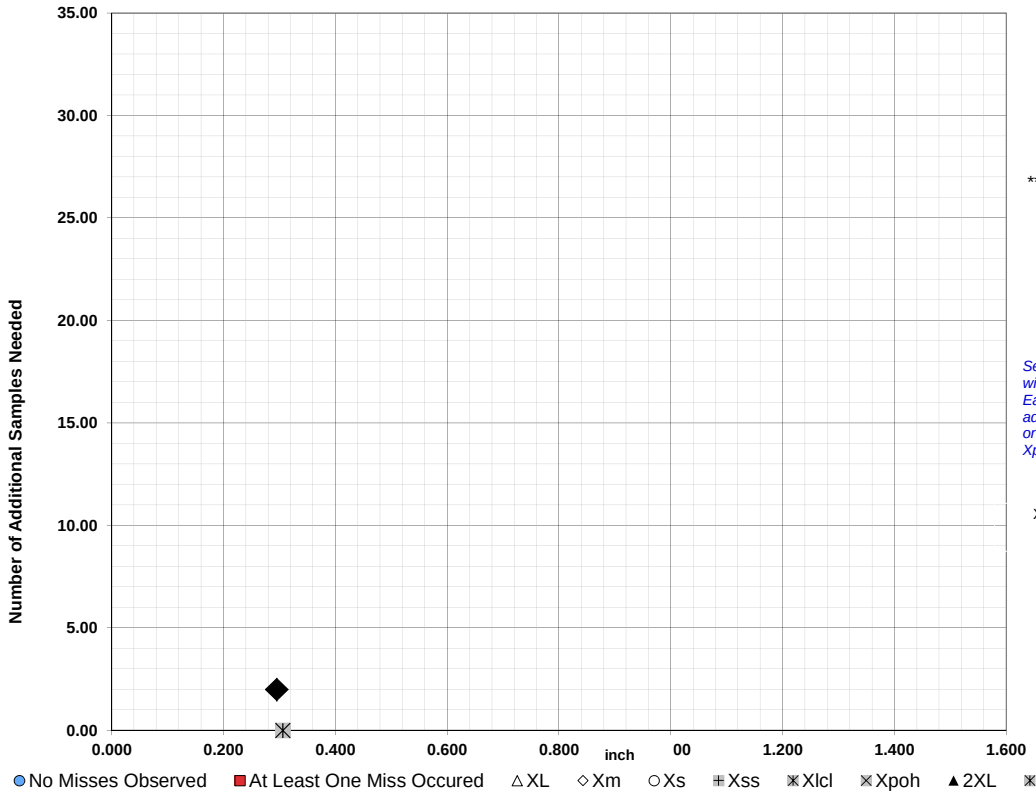



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | |
| Xm = | 0.992 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.295 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

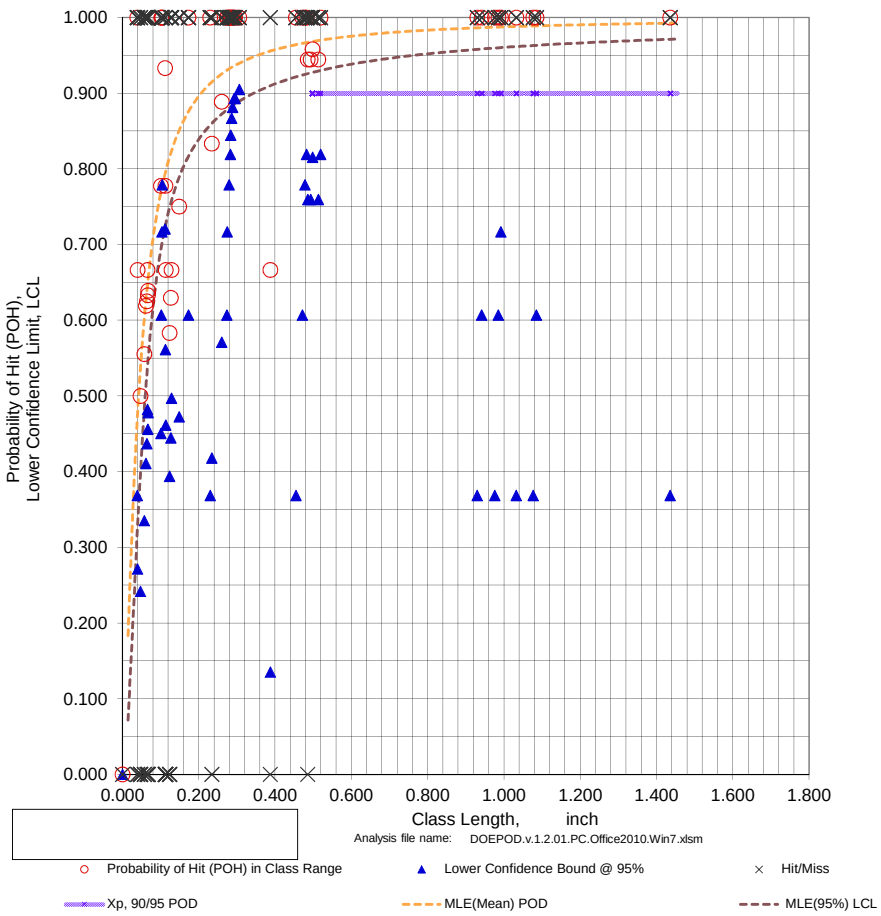
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CB003(3)L.xls**

Data Set Name = **CB003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:09 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0330 | inch |
| Classlength @ 90/95 Xpod = | 0.3060 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.210 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.345 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.992 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.4980 | inch |

File Name = CB003(3)L.xls
Data Set Name = CB003(3)L(CK. NO.)

## Directed DOE Options

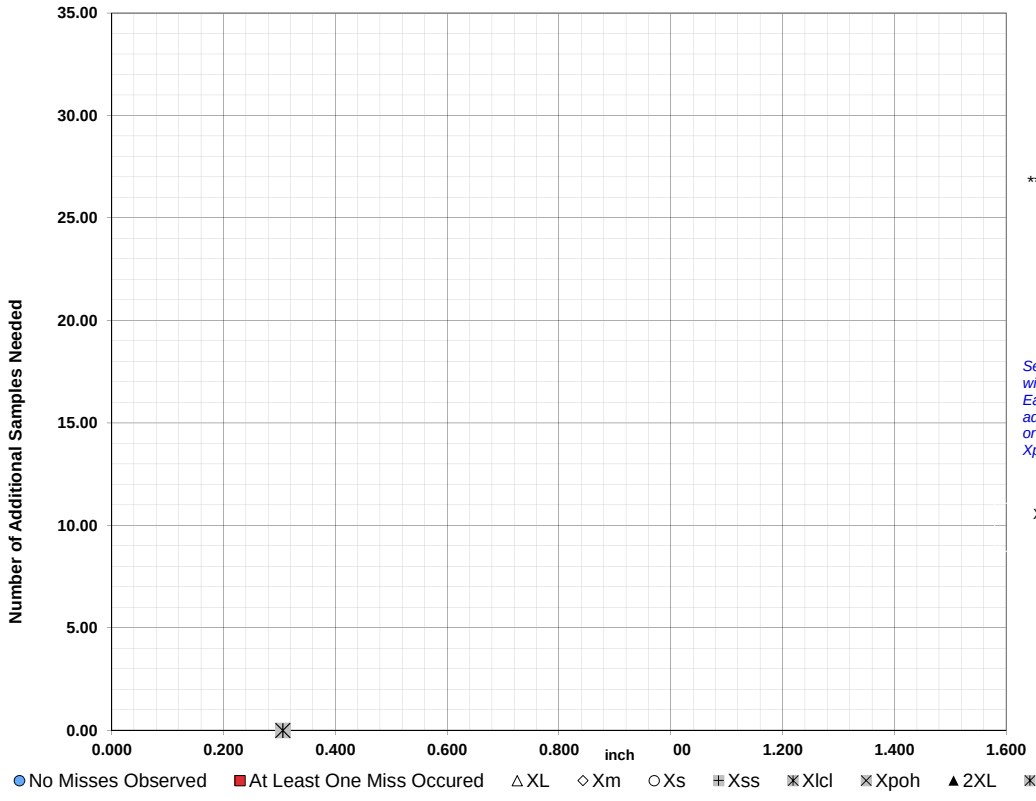



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.435 |
| Xm = | 0.992 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 5 more large flaws.**

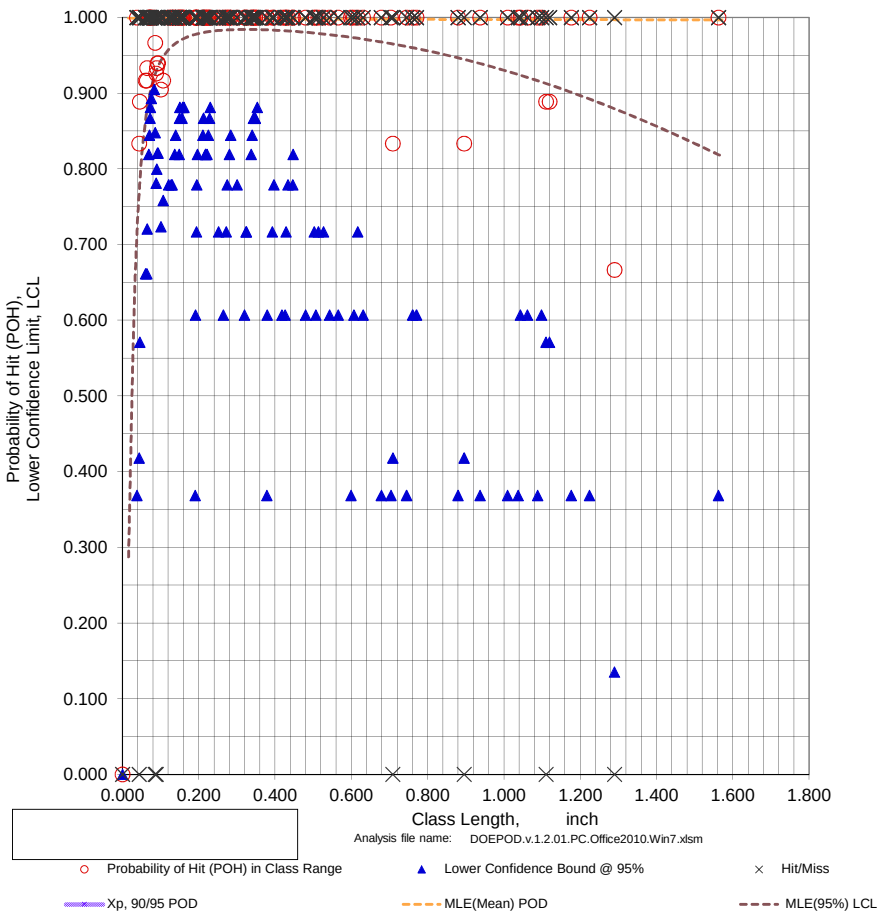
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **CC001(3)L.xls**

Data Set Name = **CC001(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:10 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0230 | inch |
| Classlength @ 90/95 Xpod = | 0.0830 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 1.000 | @ | 0.005 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.075 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 0.616 | inch |
| Samples Needed @ Xm = | 20 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CC001(3)L.xls
Data Set Name = CC001(3)L(CK. NO.)

## Directed DOE Options

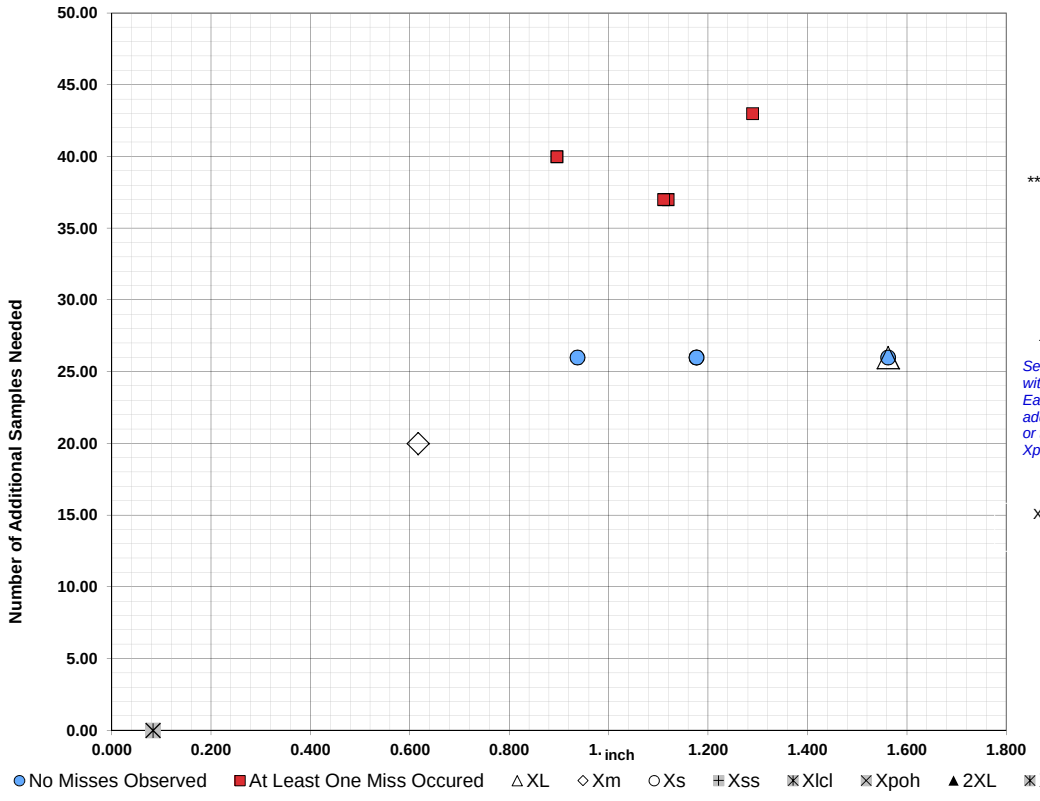



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | 26 |
| Xm = | 0.616 | 20 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2890 | 43 |
| 1.1190 | 37 |
| 1.1100 | 37 |
| 0.8950 | 40 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.5620 | 26 |
| 1.1760 | 26 |
| 1.1760 | 26 |
| 0.9370 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 5 more large flaws.

Any highlighted Misses are RED and shown in Column A of this data sheet

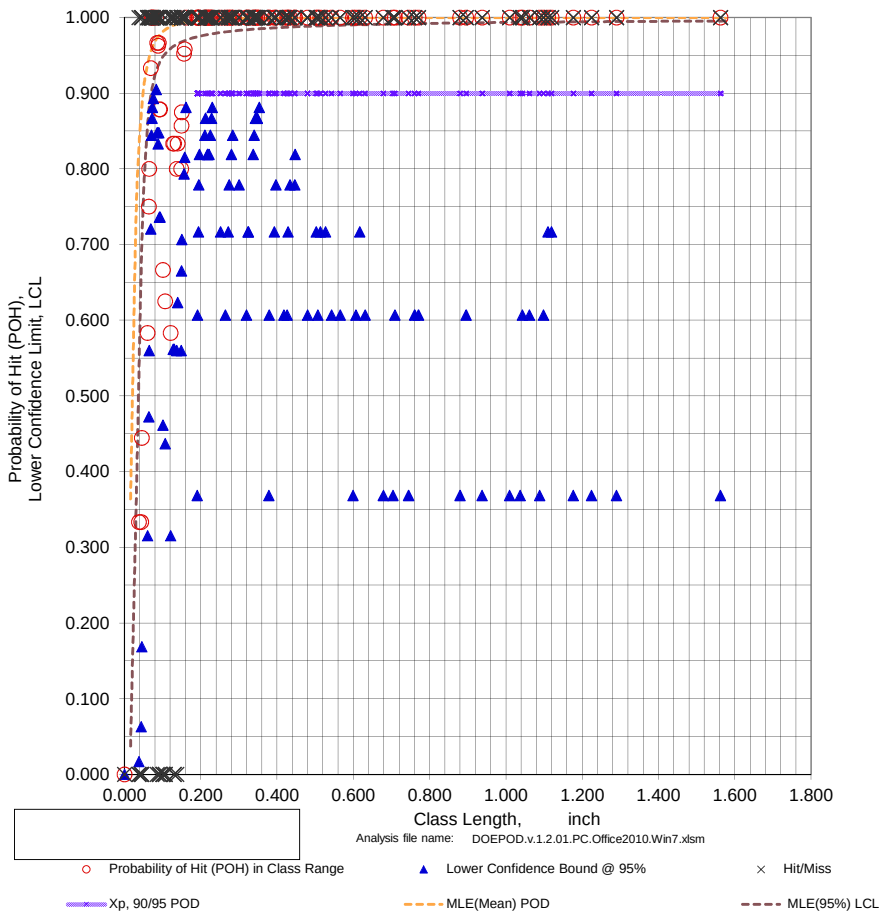
MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = CC002(3)L.xls

Data Set Name = CC002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:19 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0230 | inch |
| Classlength @ 90/95 Xpod = | 0.0830 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.911 | @ | 0.050 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.070 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1910 | inch |

File Name = CC002(3)L.xls
Data Set Name = CC002(3)L(CK. NO.)

## Directed DOE Options

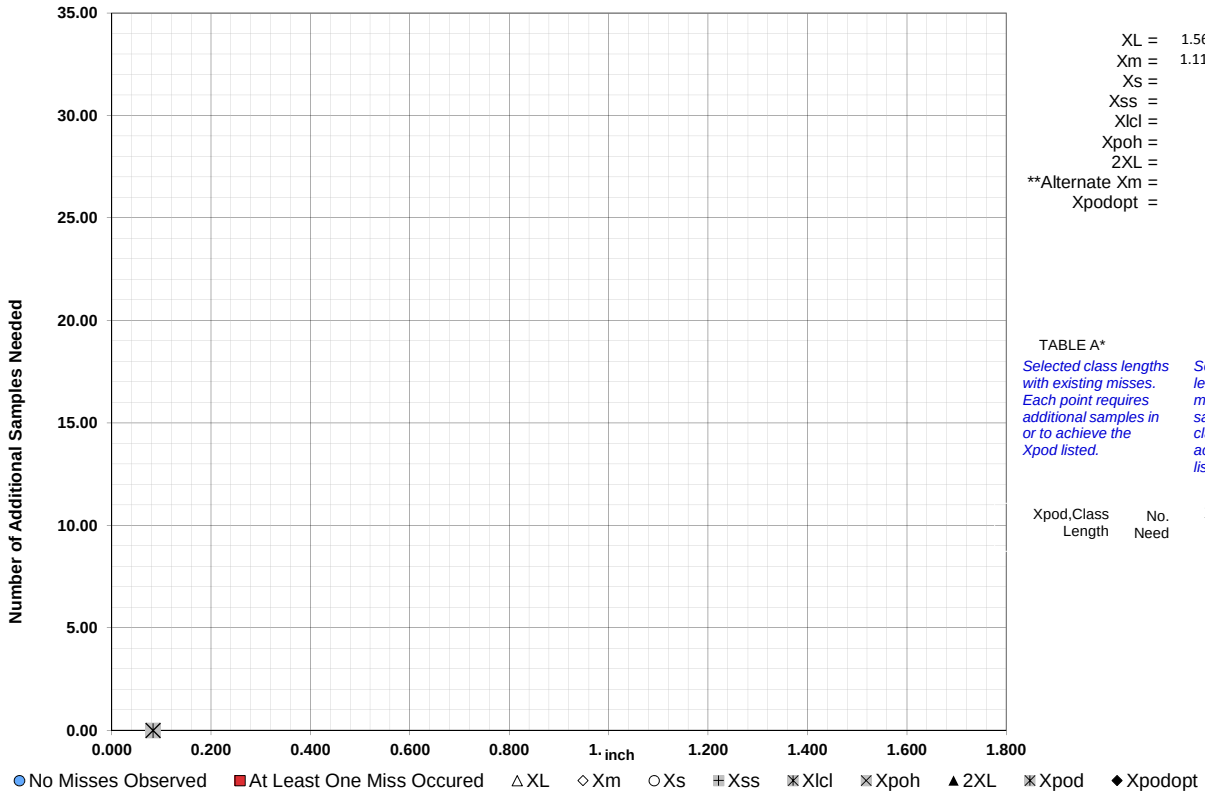



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | |
| Xm = | 1.119 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 5 more large flaws.

Any highlighted Misses are RED and shown in Column A of this data sheet

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = CC003(3)L.xls

Data Set Name = CC003(3)L(CK. NO.)

Date & Time = 6/4/15 10:24 PM

Xpod 90/95 Reached Anywhere? REACHED

Classwidth @ 90/95 Xpod = 0.0230 inch

Classlength @ 90/95 Xpod = 0.0830 inch

Lower Confidence Bound = 0.9050

Best LCL =

Classwidth @ Best LCL = inch

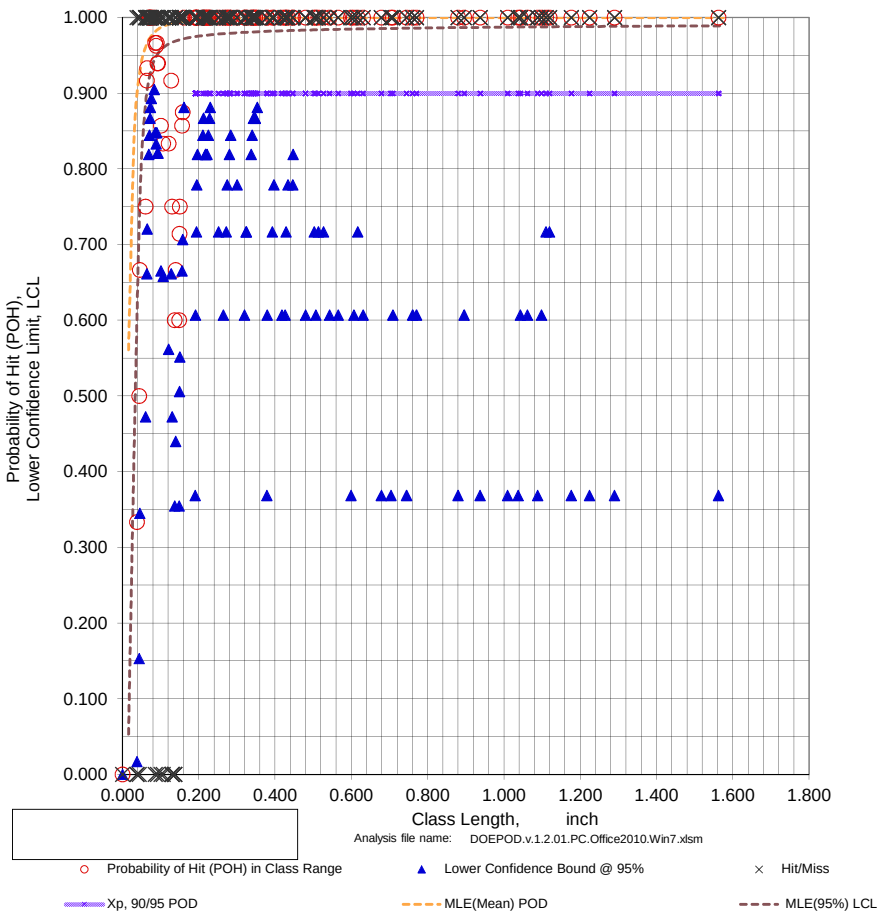
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000




CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.906 @ 0.040 inch

NTIAC 90/95 POD = 0.904 @ 0.065 inch

False Call Rate = with UCL @ 95% =

Largest Classlength , XL = 1.562 inch

Samples Needed @ XL =

Classlength Mid-point , Xm = 1.119 inch

Samples Needed @ Xm =

Smallest Classlength, Xs = inch

Samples Needed @ Xs =

New Smaller Classlength, Xss = inch

BestLCL Classlength, Xlcl = inch

Samples Needed @ Xlcl =

POH Classlength, Xpoh = inch

Samples Needed @ Xpoh =

New Largest Classlength , 2XL = inch

Xm is Near Verification Point = inch

Opt. POD classlength, Xpodopt = inch

Samples Needed @Xpodopt =

Xp = 0.1910 inch

File Name = CC003(3)L.xls
Data Set Name = CC003(3)L(CK. NO.)

## Directed DOE Options

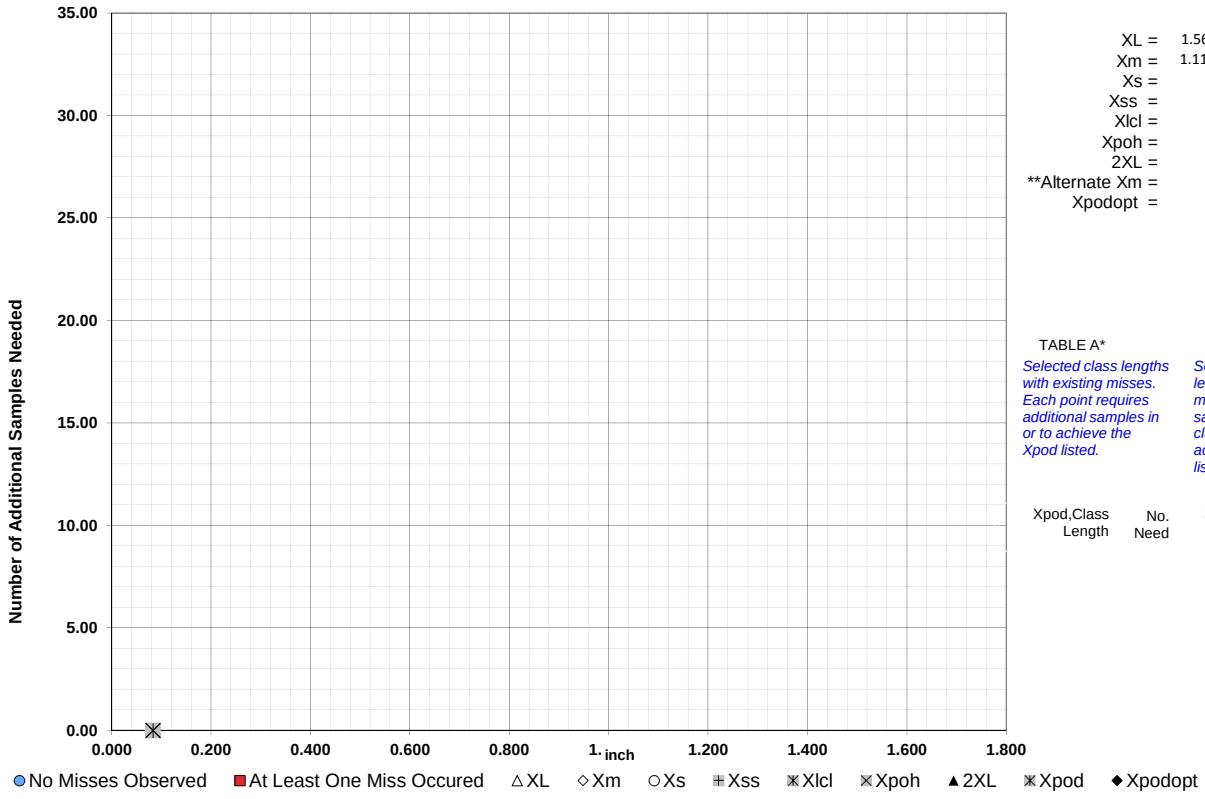



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.562 |
| Xm = | 1.119 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.705.**

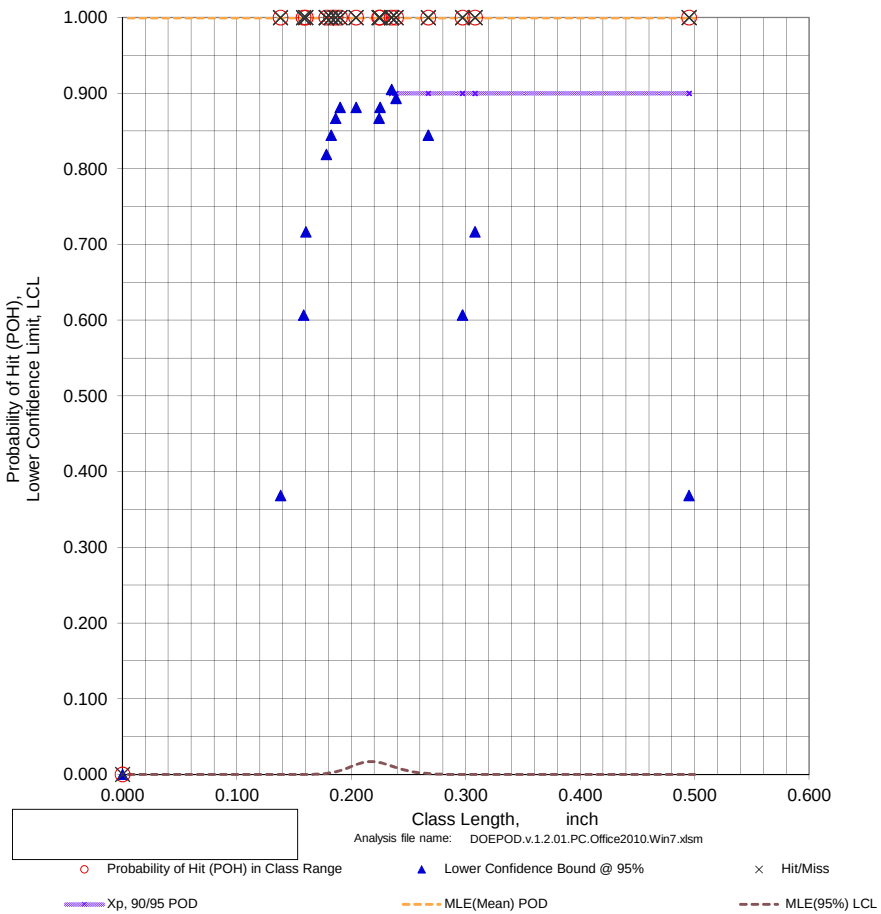
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **CD001(3)L.xls**

Data Set Name = **CD001(3)L(CK. NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:28 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0570 | inch |
| Classlength @ 90/95 Xpod = | 0.2350 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1380 -0.057 inch 26 Samples

NTIAC 90% POD = 1.000 @ 0.005 inch

NTIAC 90/95 POD = @ inch

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.308 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.138 | inch |
| Samples Needed @Xpodopt = | 26 | |
| Xp = | 0.2350 | inch |

File Name = CD001(3)L.xls
Data Set Name = CD001(3)L(CK. NO. )

## Directed DOE Options

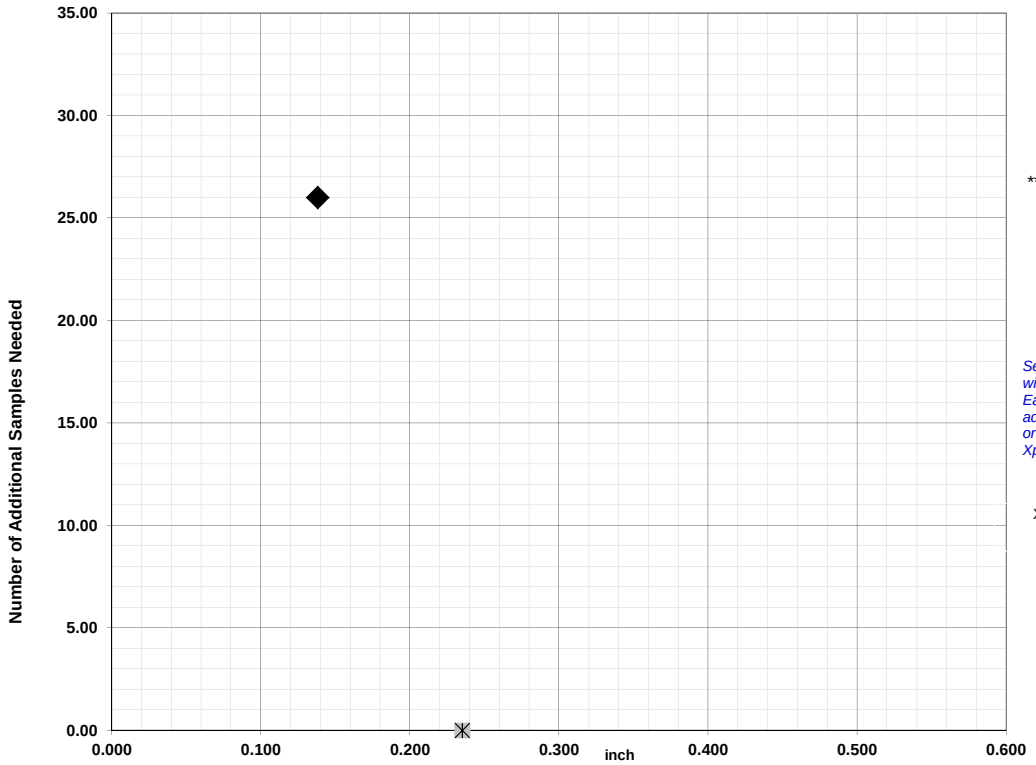



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | |
| Xm = | 0.308 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.138 | 26 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

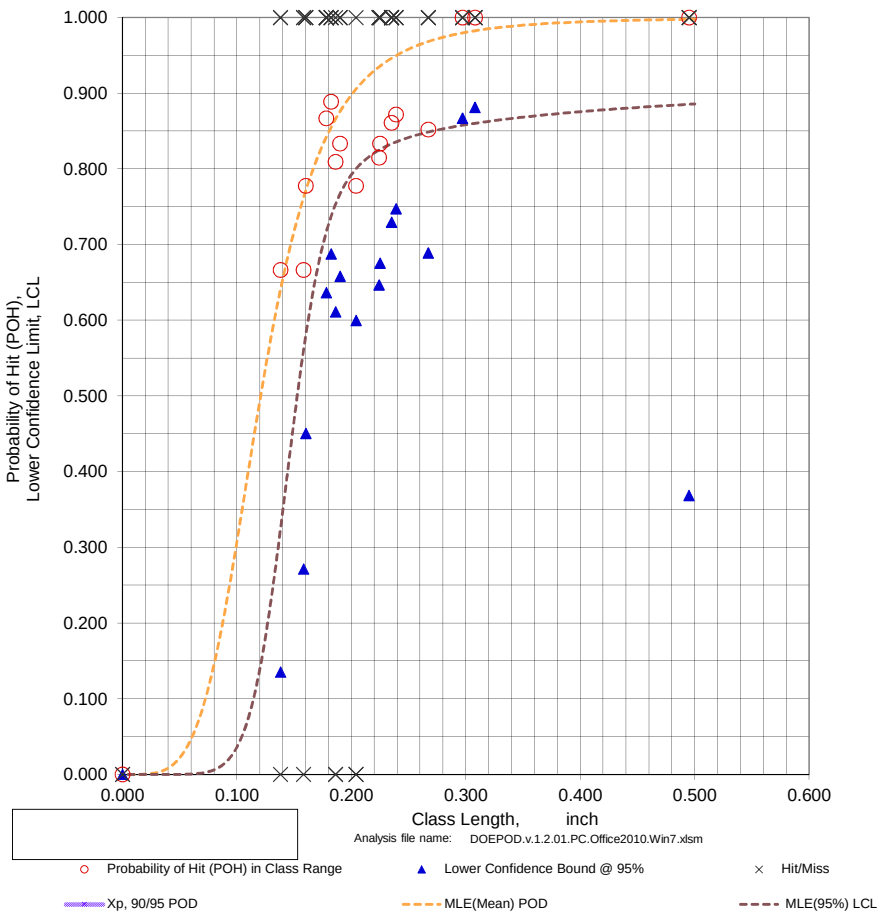
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CD002(3)L.xls
Data Set Name = CD002(3)L(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:29 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0840 | inch |
| Classlength @ Best LCL = | 0.3080 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2240 -0.019 inch 26 Samples

NTIAC 90% POD = 0.907 @ 0.205 inch

NTIAC 90/95 POD = 0.900 @ 0.725 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.308 | inch |
| Samples Needed @ Xlcl = | 5 | |
| POH Classlength, Xpoh = | 0.297 | inch |
| Samples Needed @ Xpoh = | 8 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CD002(3)L.xls
Data Set Name = CD002(3)L(CK. NO. )

## Directed DOE Options

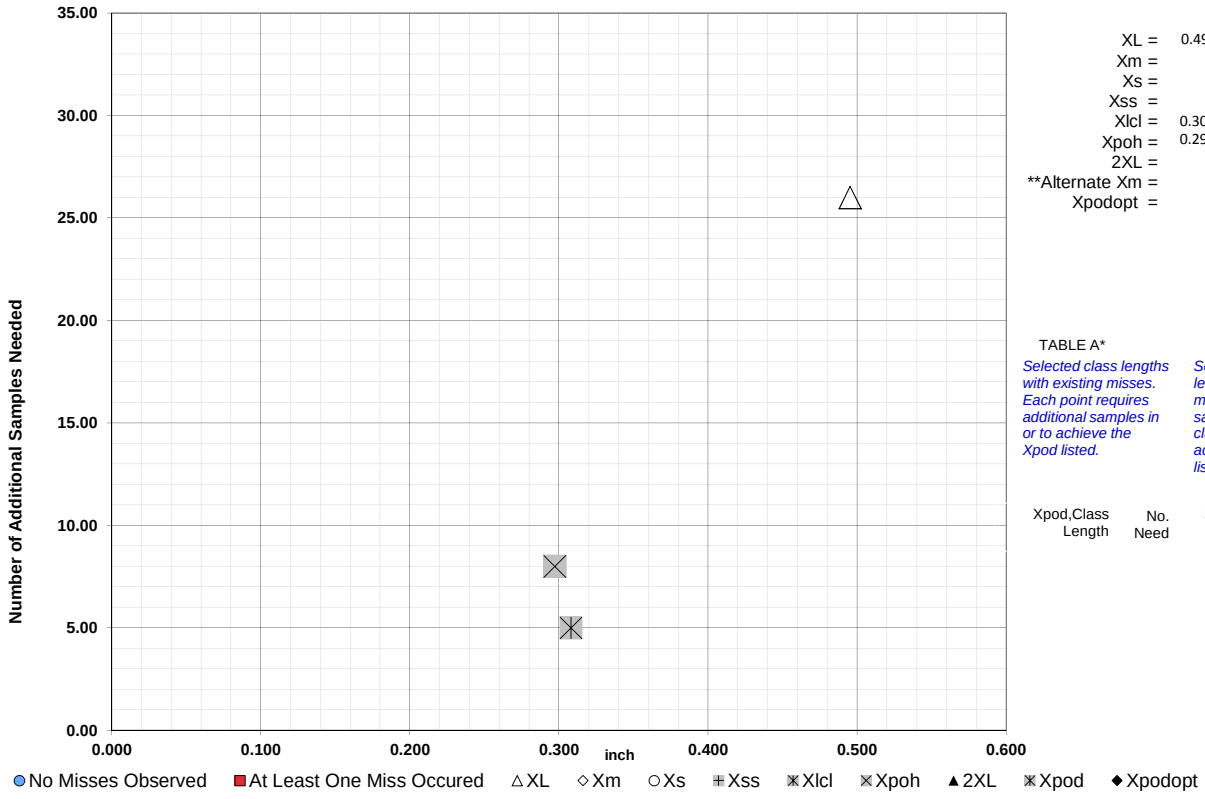



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.308 | 5 |
| Xpoh = | 0.297 | 8 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

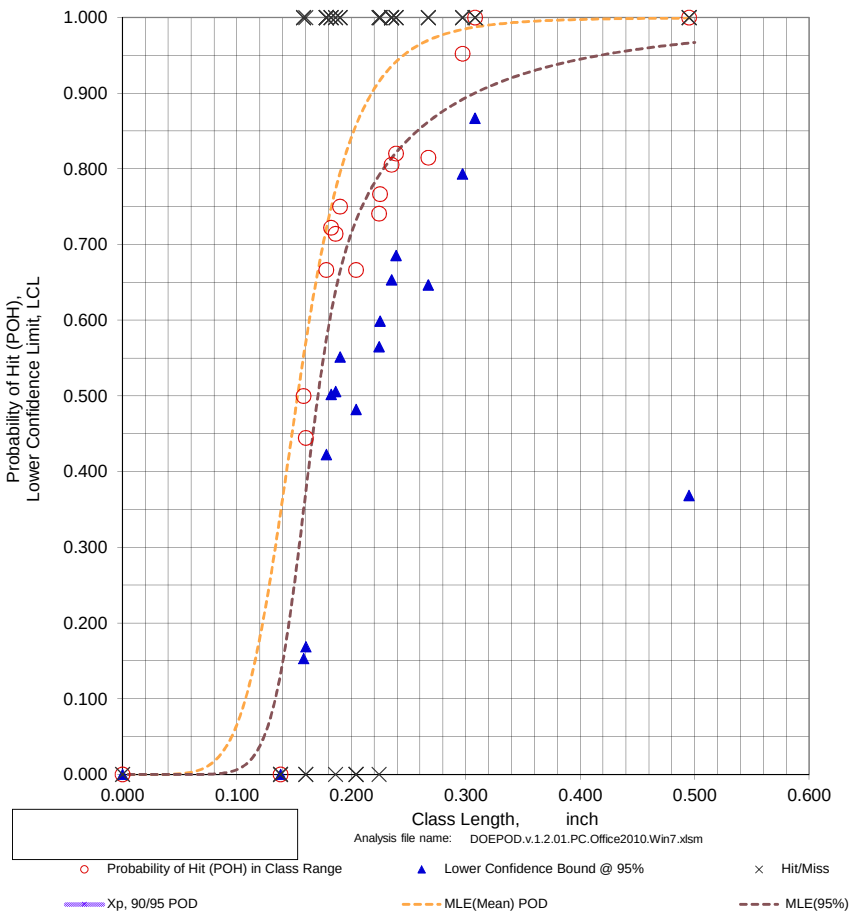
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CD003(3)L.xls
Data Set Name = CD003(3)L(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:30 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0830 | inch |
| Classlength @ Best LCL = | 0.3080 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2350 -0.010 inch 23 Samples

NTIAC 90% POD = 0.906 @ 0.220 inch

NTIAC 90/95 POD = 0.902 @ 0.310 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.308 | inch |
| Samples Needed @ Xlcl = | 8 | |
| POH Classlength, Xpoh = | 0.308 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CD003(3)L.xls
Data Set Name = CD003(3)L(CK. NO. )

## Directed DOE Options

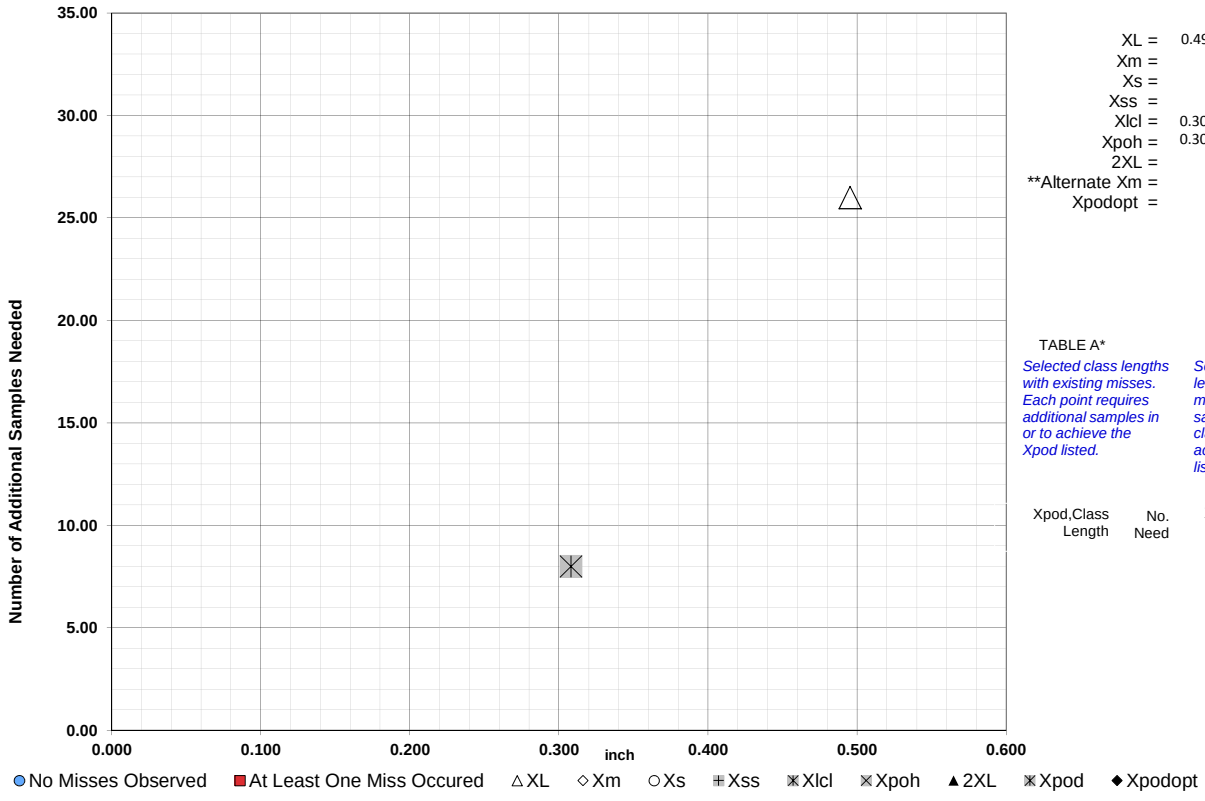



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.308 | 8 |
| Xpoh = | 0.308 | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

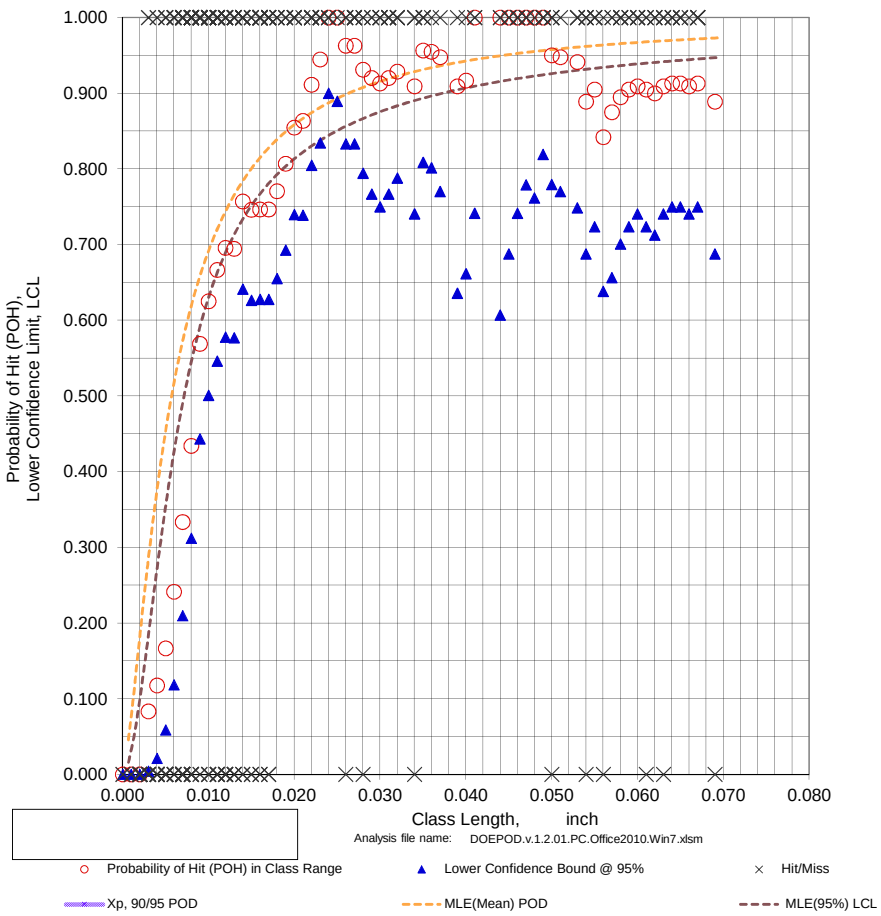
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.072.**

**Warning: No false call analysis.**




File Name = **CE011(6)D.xls**

Data Set Name = **CE011(6)D(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:31 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0060 | inch |
| Classlength @ 90/95 Xpod = | 0.0240 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.916 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.040 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | 43 | |
| Classlength Mid-point , Xm = | 0.049 | inch |
| Samples Needed @ Xm = | 14 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE011(6)D.xls
Data Set Name = CE011(6)D(CRK #)

## Directed DOE Options

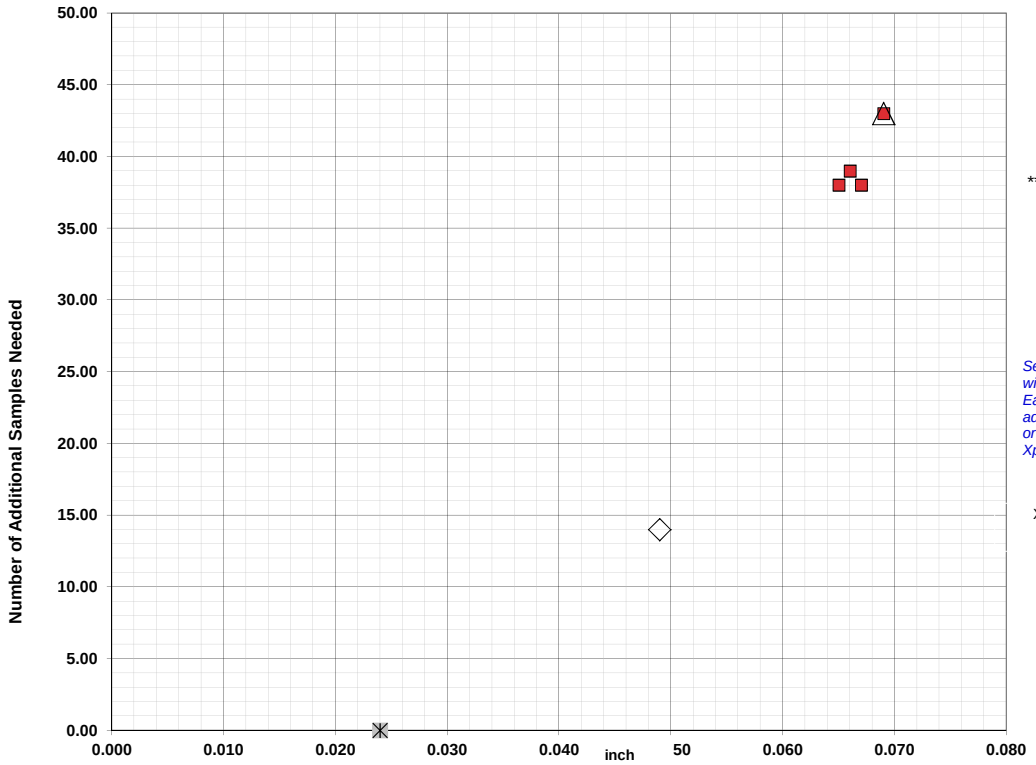



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.069 | 43 |
| Xm = | 0.049 | 14 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.0690 | 43 |
| 0.0670 | 38 |
| 0.0660 | 39 |
| 0.0650 | 38 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

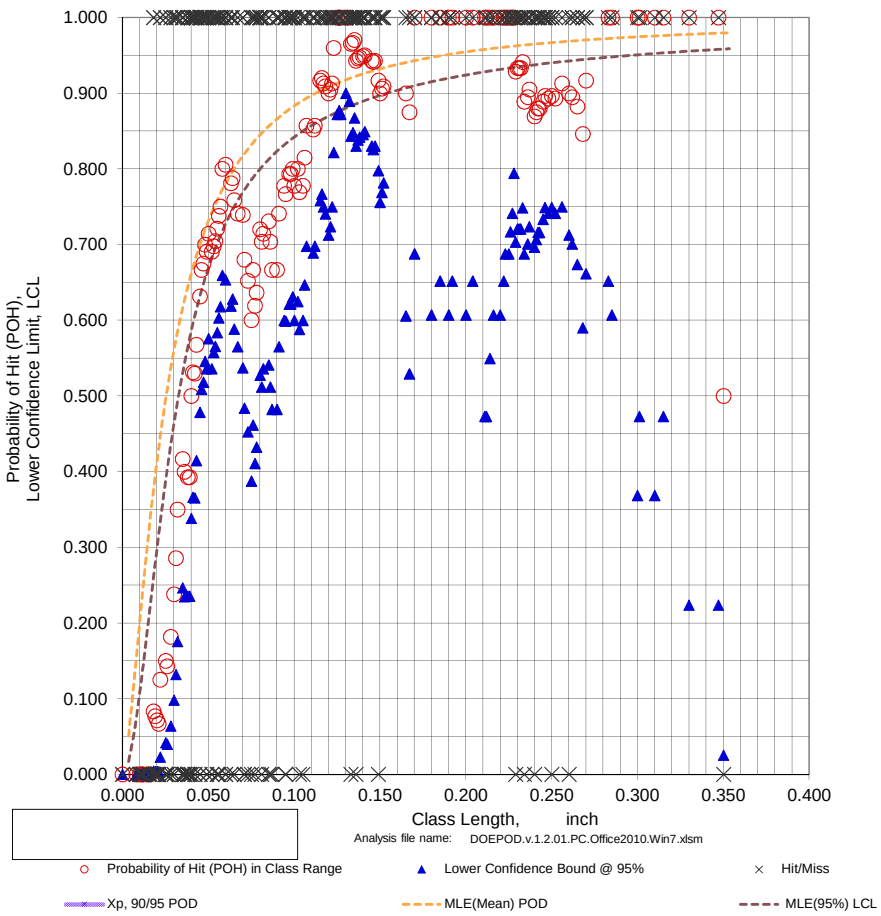
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.39.**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**




| | |
|---|---|
| File Name = | CE011(6)L.xls |
| Data Set Name = | CE011(6)L(CRK #) |
| Date & Time = | 6/4/15 10:32 PM |
| Xpod 90/95 Reached Anywhere? | REACHED |
| Classwidth @ 90/95 Xpod = | 0.0190 inch |
| Classlength @ 90/95 Xpod = | 0.1300 inch |
| Lower Confidence Bound = | 0.9001 |
| Best LCL = | |
| Classwidth @ Best LCL = | inch |
| Classlength @ Best LCL = | inch |
| User Provided a 90/95 POD @ = | inch |
| User's Maximum Allowed Classlength = | inch |
| Inspector Classwidth @ Xp = | inch |
| POD @ Xpod = | 1.0000 |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

| | | | | |
|---|---|---|---|---|
| Survey/Optimum Xpoh = | 0.000 | inch | | Samples |
| NTIAC 90% POD = | 0.905 | @ | 0.115 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.155 | inch |
| **False Call Rate =** | | **with UCL @ 95% =** | | |

| | |
|---|---|
| Largest Classlength , XL = | 0.350 inch |
| Samples Needed @ XL = | 44 |
| Classlength Mid-point , Xm = | 0.228 inch |
| Samples Needed @ Xm = | 16 |
| Smallest Classlength, Xs = | inch |
| Samples Needed @ Xs = | |
| New Smaller Classlength, Xss = | inch |
| BestLCL Classlength, Xlcl = | inch |
| Samples Needed @ Xlcl = | |
| POH Classlength, Xpoh = | inch |
| Samples Needed @ Xpoh = | |
| New Largest Classlength , 2XL = | inch |
| Xm is Near Verification Point = | inch |
| Opt. POD classlength, Xpodopt = | inch |
| Samples Needed @Xpodopt = | |
| Xp = | inch |

File Name = CE011(6)L.xls
Data Set Name = CE011(6)L(CRK #)

## Directed DOE Options

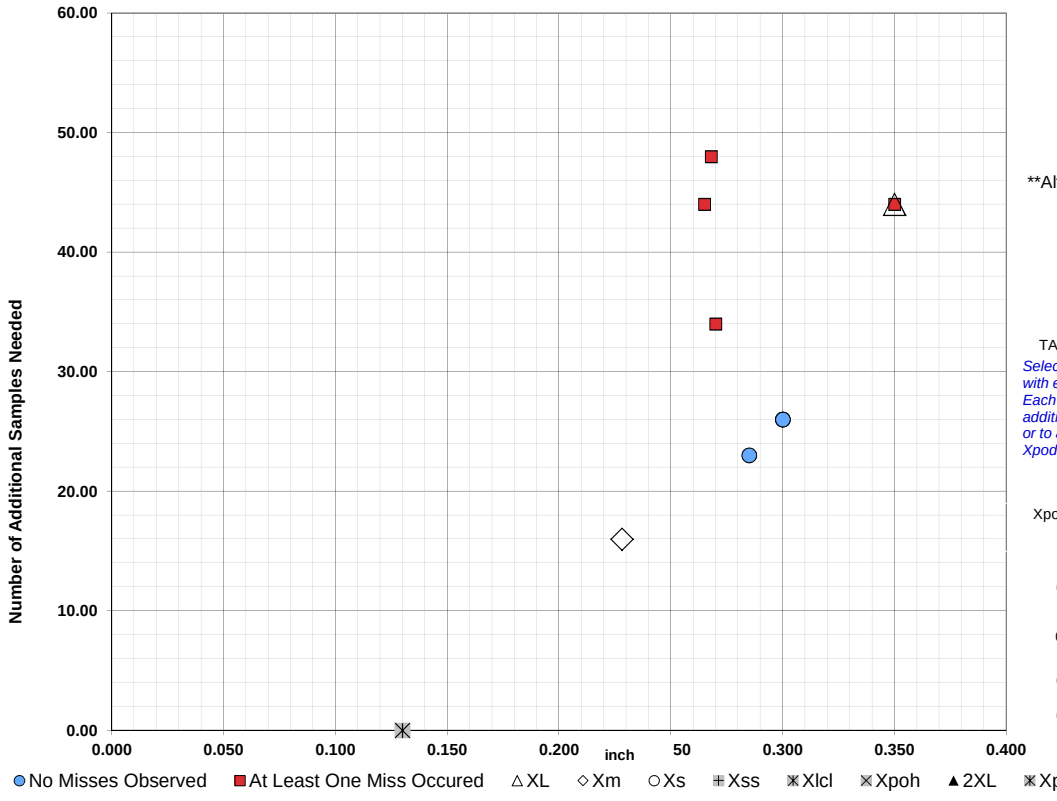



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.350 | 44 |
| Xm = | 0.228 | 16 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3500 | 44 |
| 0.2700 | 34 |
| 0.2680 | 48 |
| 0.2650 | 44 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.3000 | 26 |
| 0.3000 | 26 |
| 0.2850 | 23 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation successful.

Any highlighted Misses are RED and shown in Column A of this data sheet

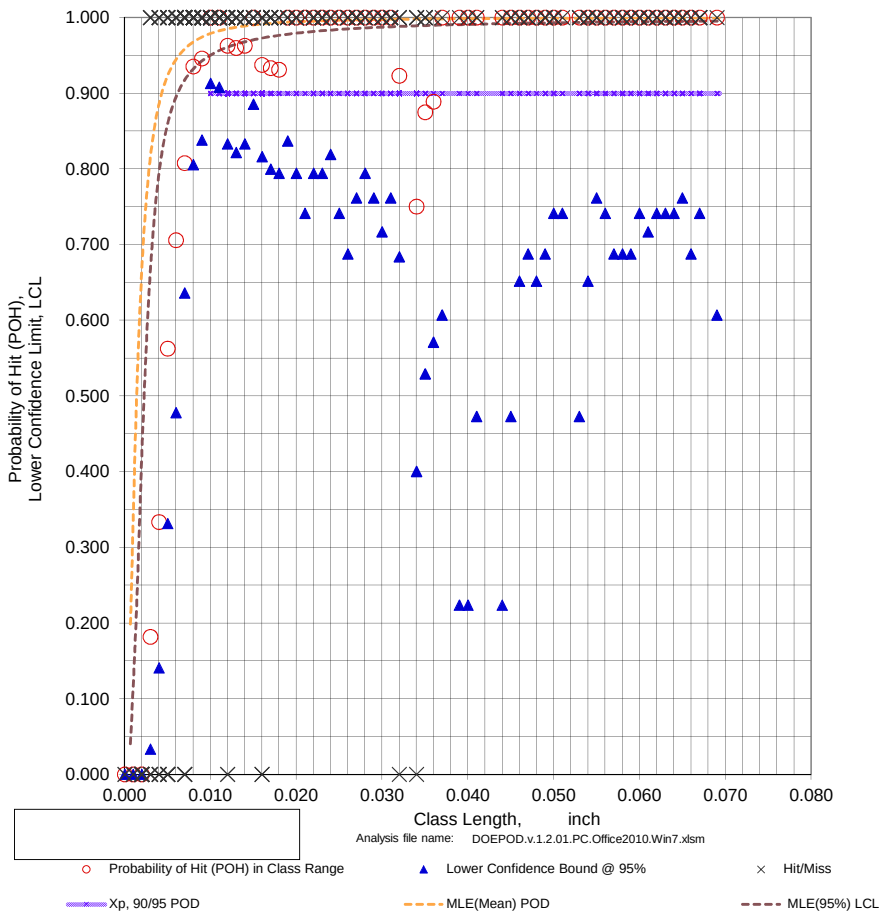
MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = CE012(6)D.xls

Data Set Name = CE012(6)D(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:33 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0100 | inch |
| Lower Confidence Bound = | 0.9129 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




CASE 1+ - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp VALIDATES between Xpod and XL when causes of highlighted Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.917 | @ | 0.005 | inch |
| NTIAC 90/95 POD = | 0.949 | @ | 0.010 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.028 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0100 | inch |

File Name = CE012(6)D.xls
Data Set Name = CE012(6)D(CRK #)

## Directed DOE Options

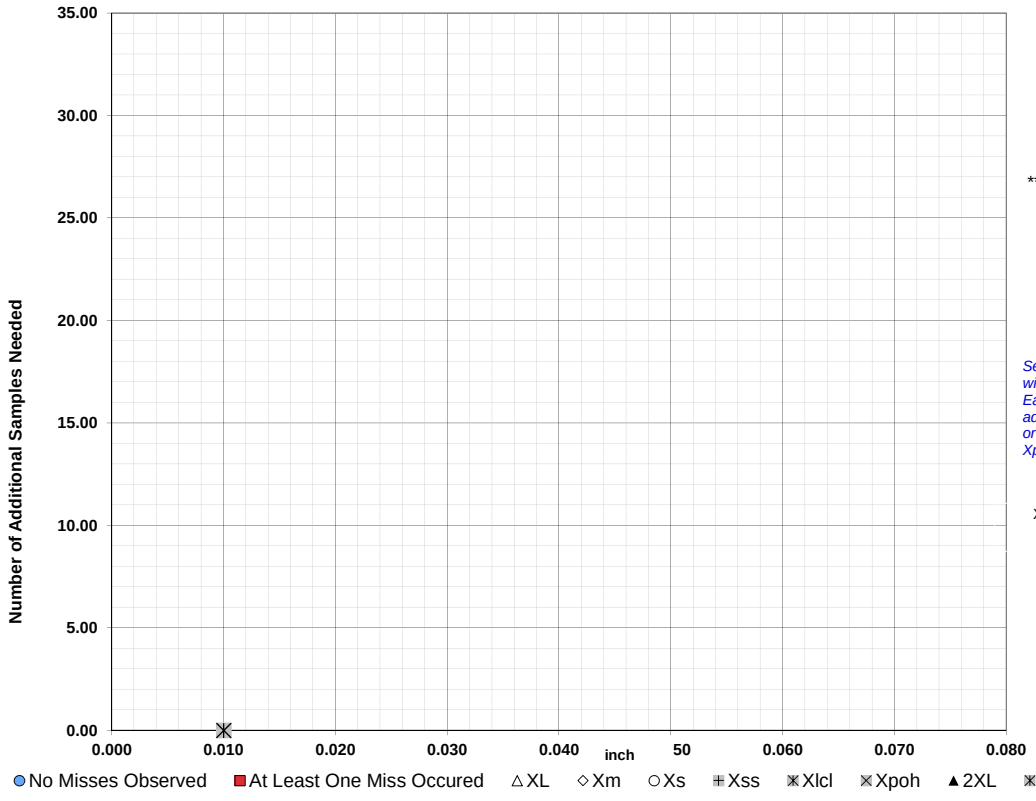



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.069 |
| Xm = | 0.028 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

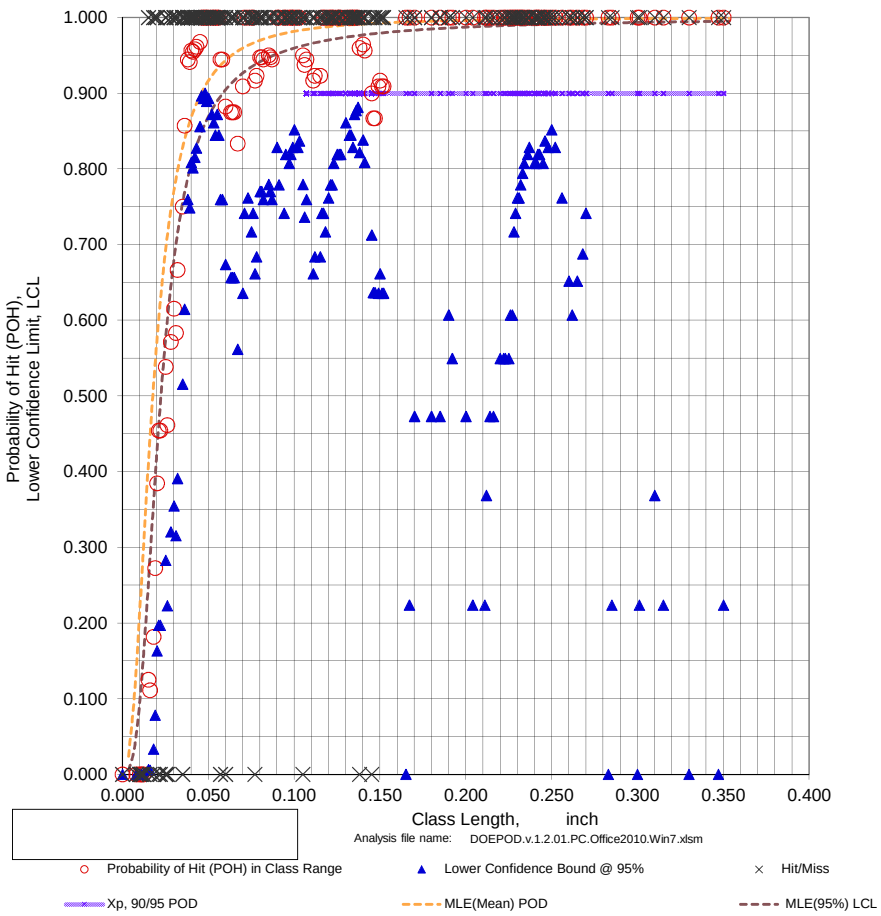
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 1 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE012(6)L.xls**

Data Set Name = **CE012(6)L(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:41 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0100 | inch |
| Classlength @ 90/95 Xpod = | 0.0480 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.923 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.915 | @ | 0.040 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.137 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1070 | inch |

File Name = CE012(6)L.xls
Data Set Name = CE012(6)L(CRK #)

## Directed DOE Options

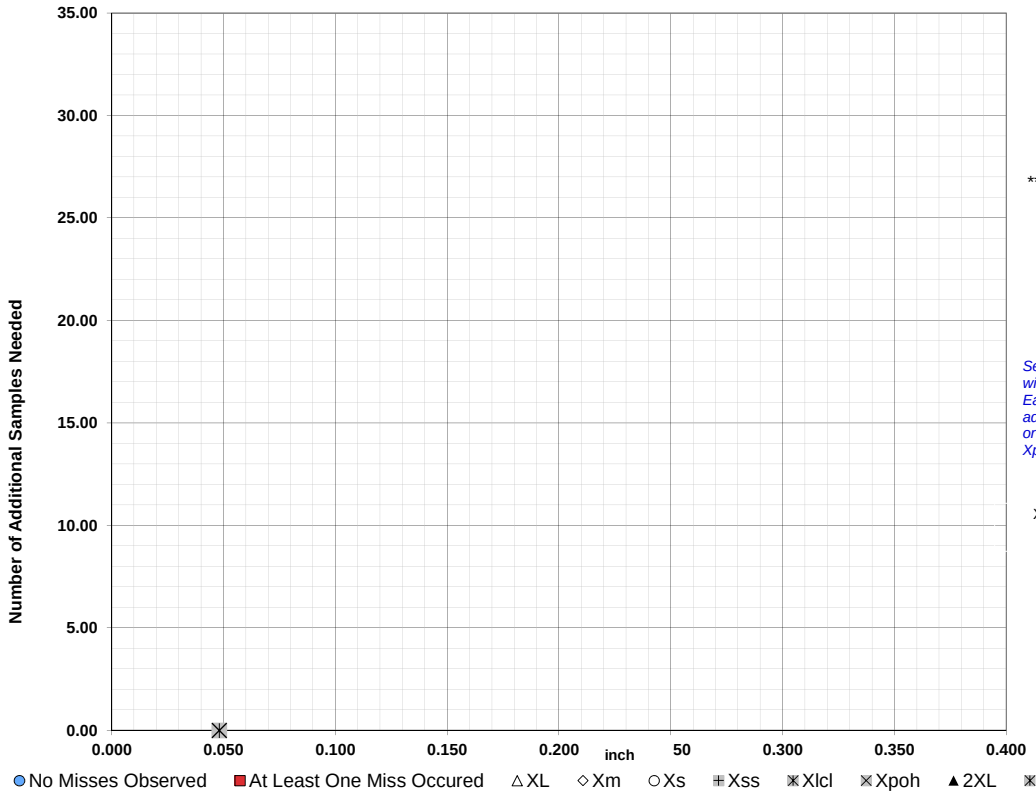



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.350 |
| Xm = | 0.137 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

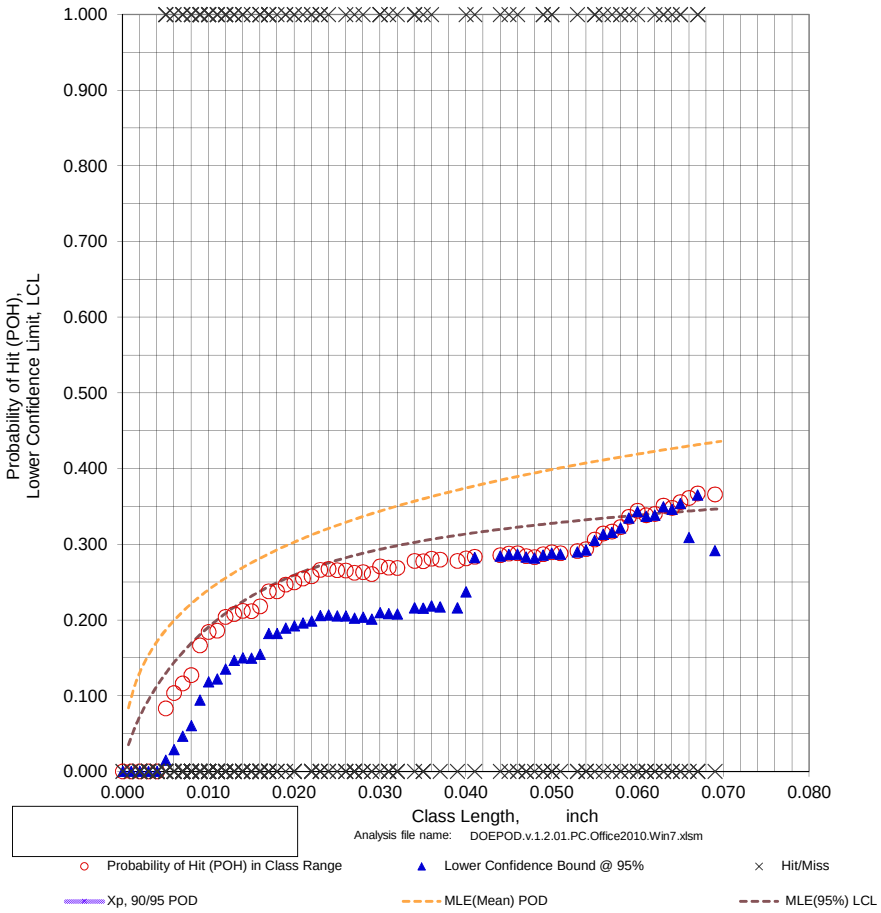
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE021(6)D.xls
Data Set Name = CE021(6)D(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:46 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3653 | |
| Classwidth @ Best LCL = | 0.0510 | inch |
| Classlength @ Best LCL = | 0.0670 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.138 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE021(6)D.xls
Data Set Name = CE021(6)D(CRK #)

## Directed DOE Options

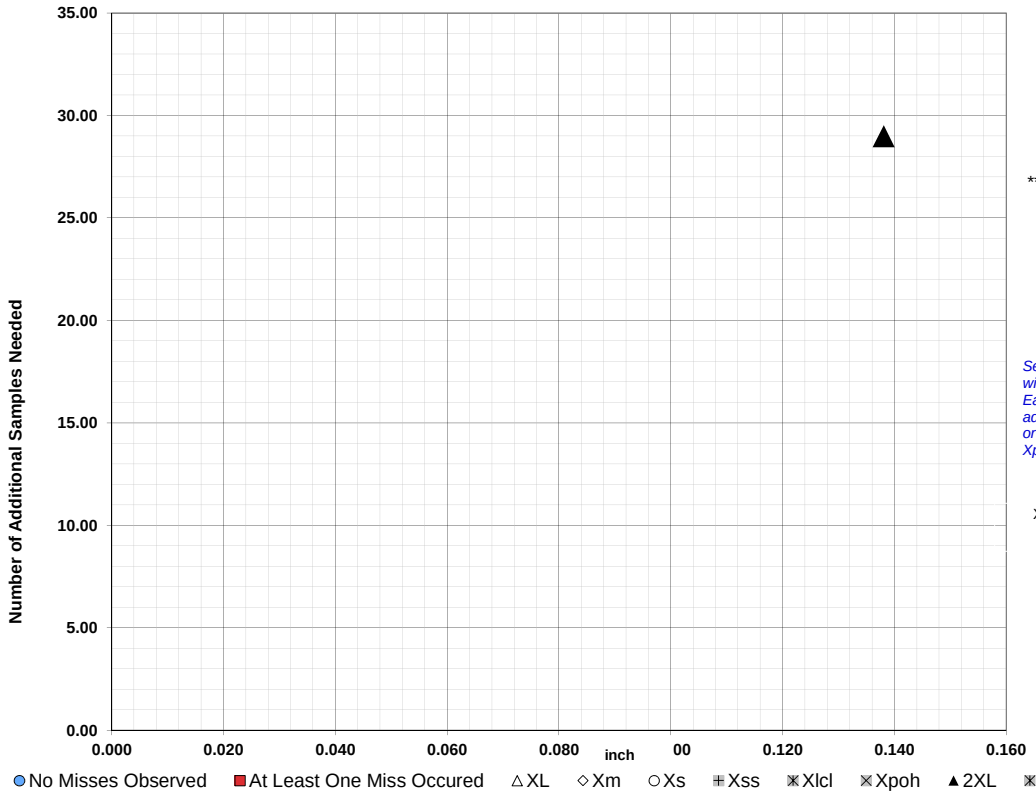



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.138 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

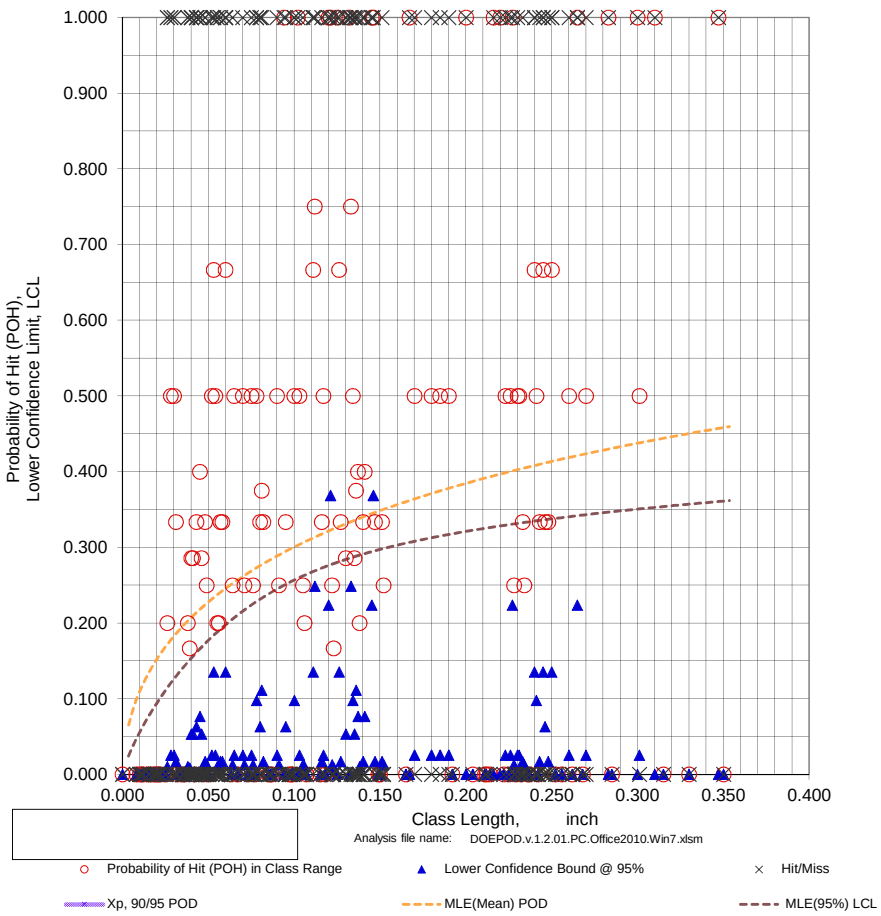
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE021(6)L.xls
Data Set Name = CE021(6)L(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:47 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.1210 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE021(6)L.xls
Data Set Name = CE021(6)L(CRK #)

## Directed DOE Options

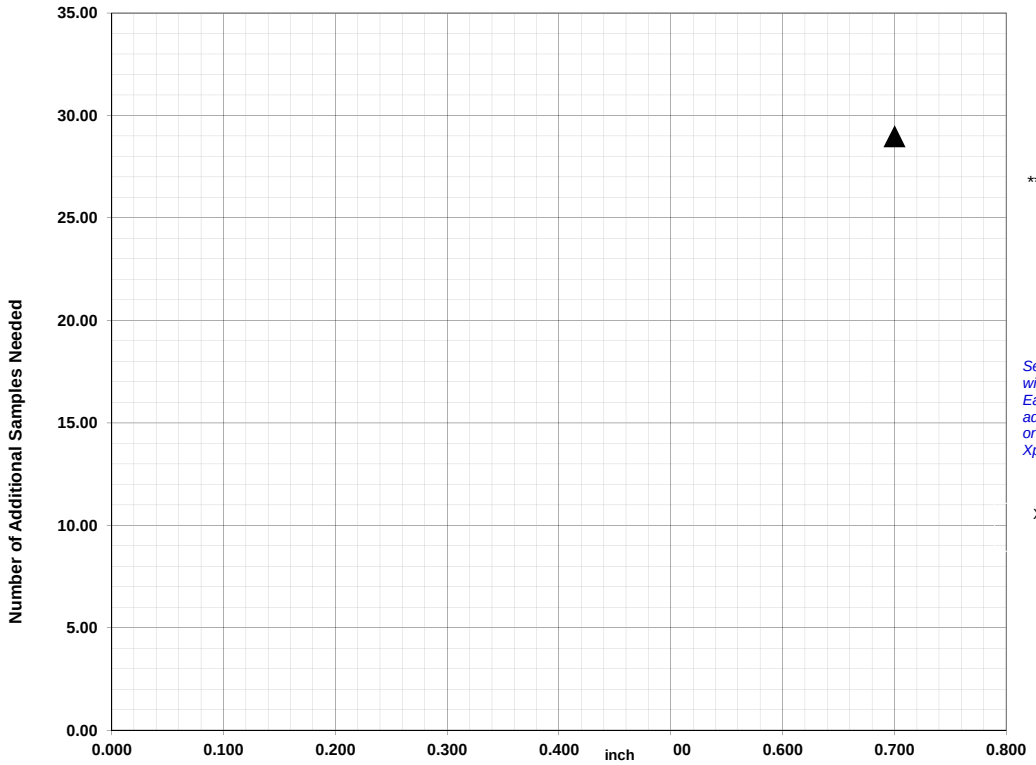



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

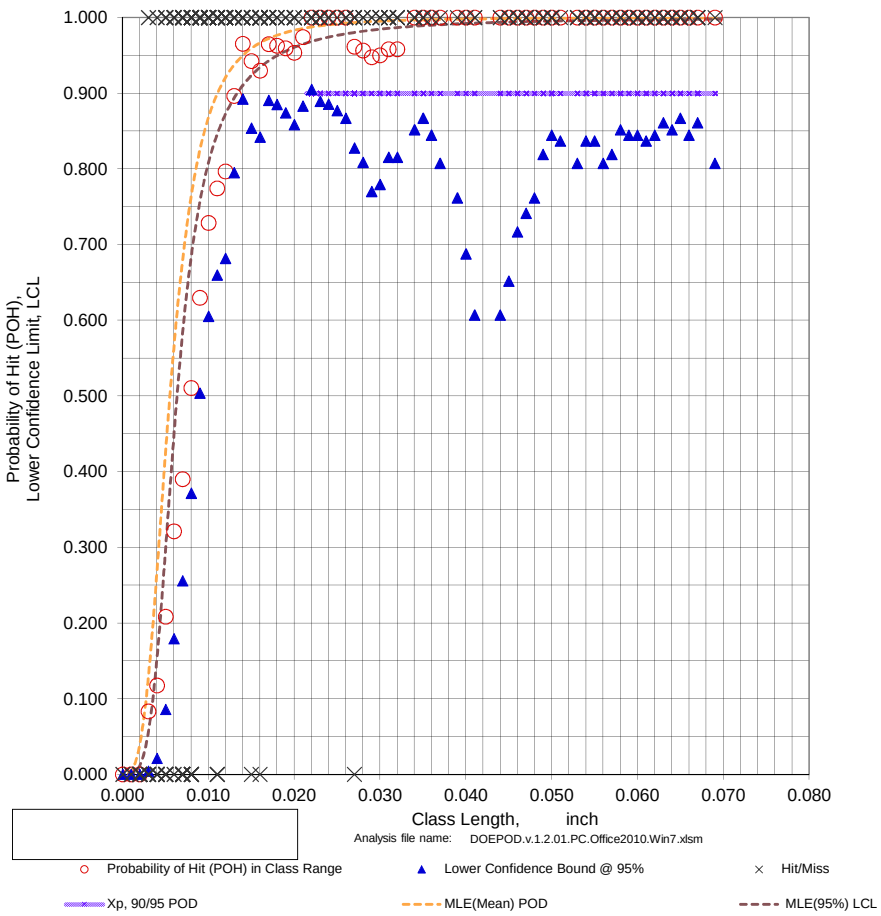
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 1 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE022(6)D.xls**

Data Set Name = **CE022(6)D(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:48 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0050 | inch |
| Classlength @ 90/95 Xpod = | 0.0220 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.959 | @ | 0.015 | inch |
| NTIAC 90/95 POD = | 0.924 | @ | 0.015 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.035 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0220 | inch |

File Name = CE022(6)D.xls
Data Set Name = CE022(6)D(CRK #)

## Directed DOE Options

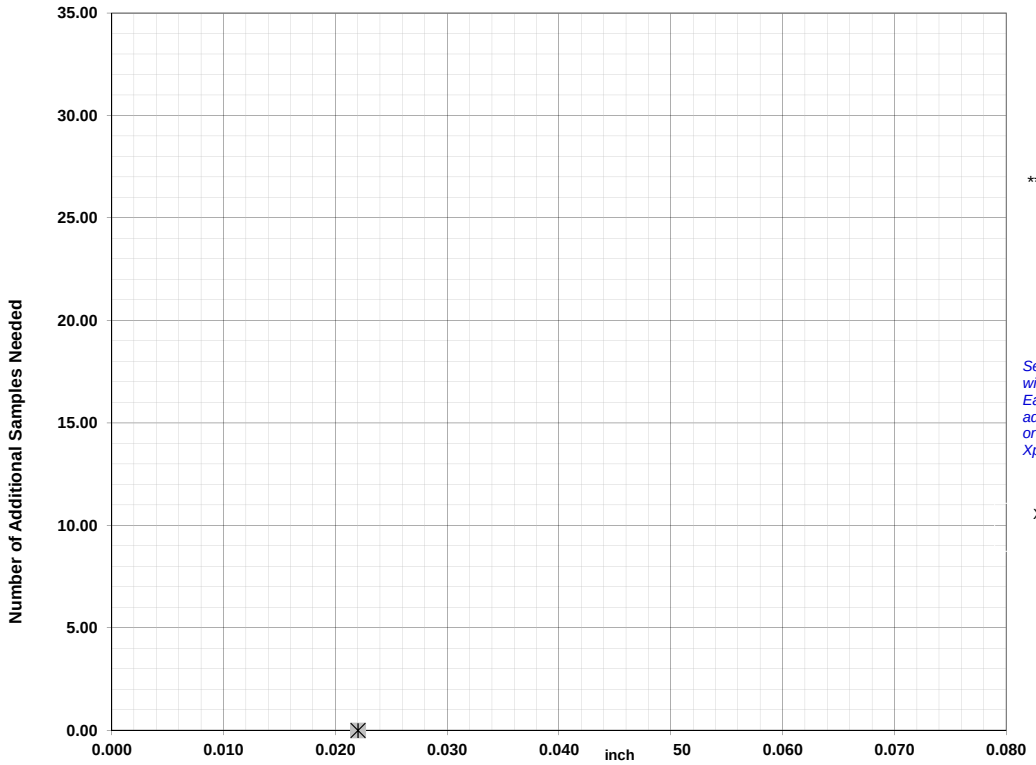



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.069 |
| Xm = | 0.035 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

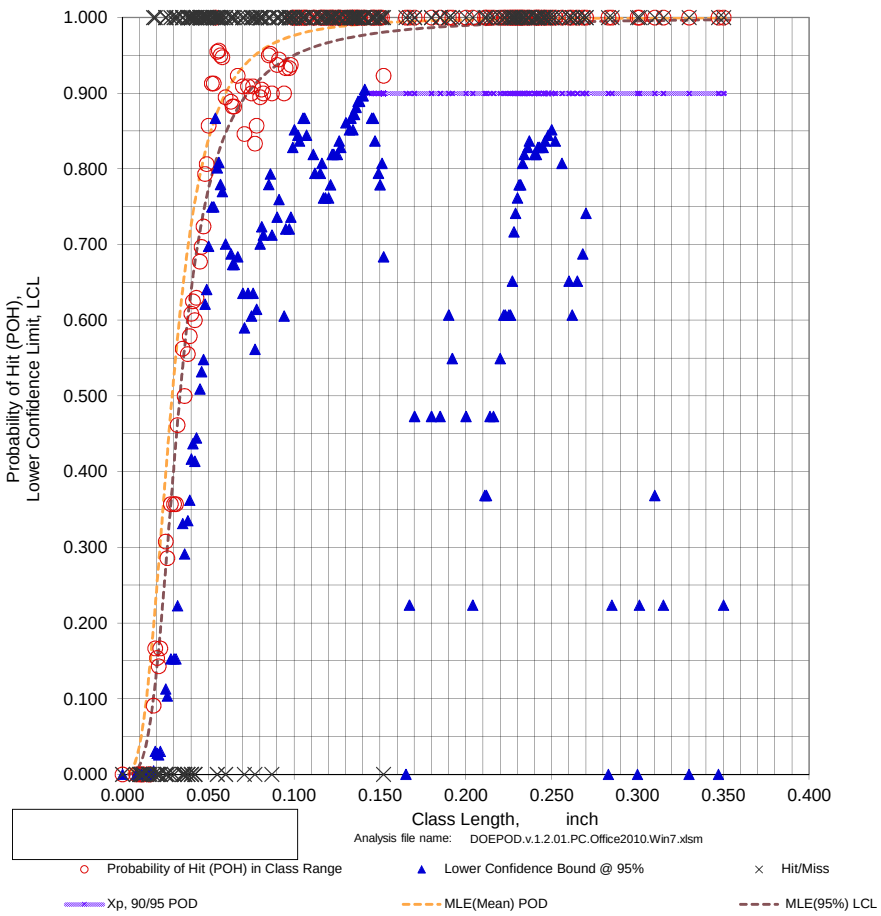
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.423.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE022(6)L.xls**

Data Set Name = **CE022(6)L(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:51 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.1410 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.920 | @ | 0.065 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.075 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.250 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1410 | inch |

File Name = CE022(6)L.xls
Data Set Name = CE022(6)L(CRK #)

## Directed DOE Options

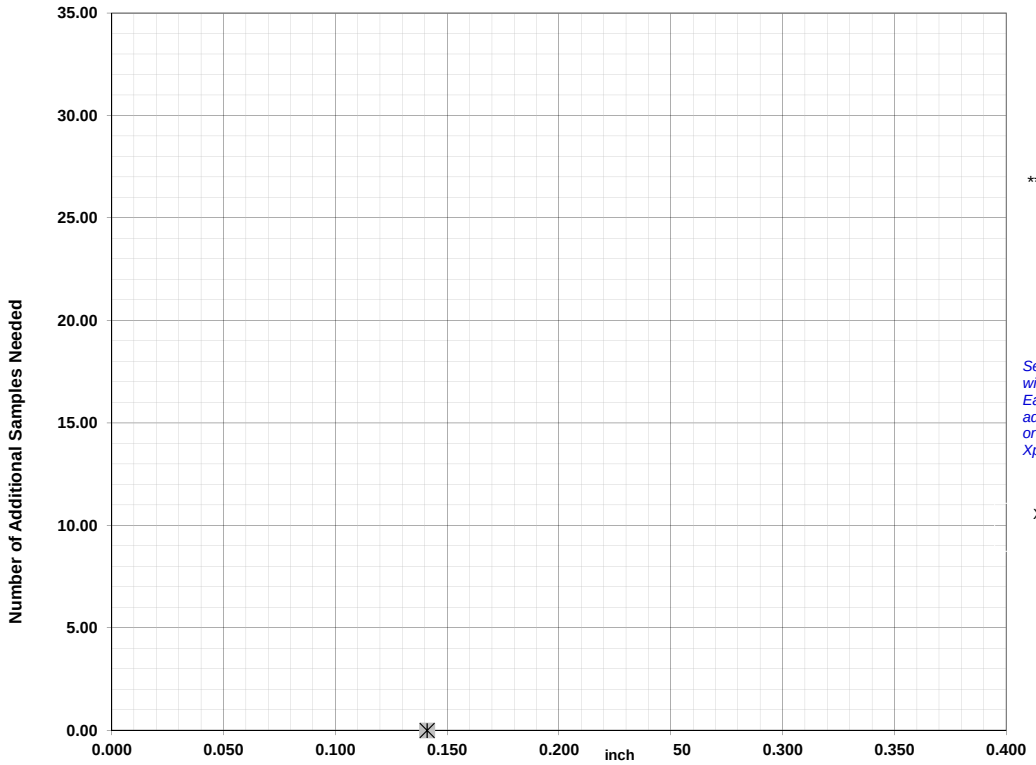



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.350 |
| Xm = | 0.250 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

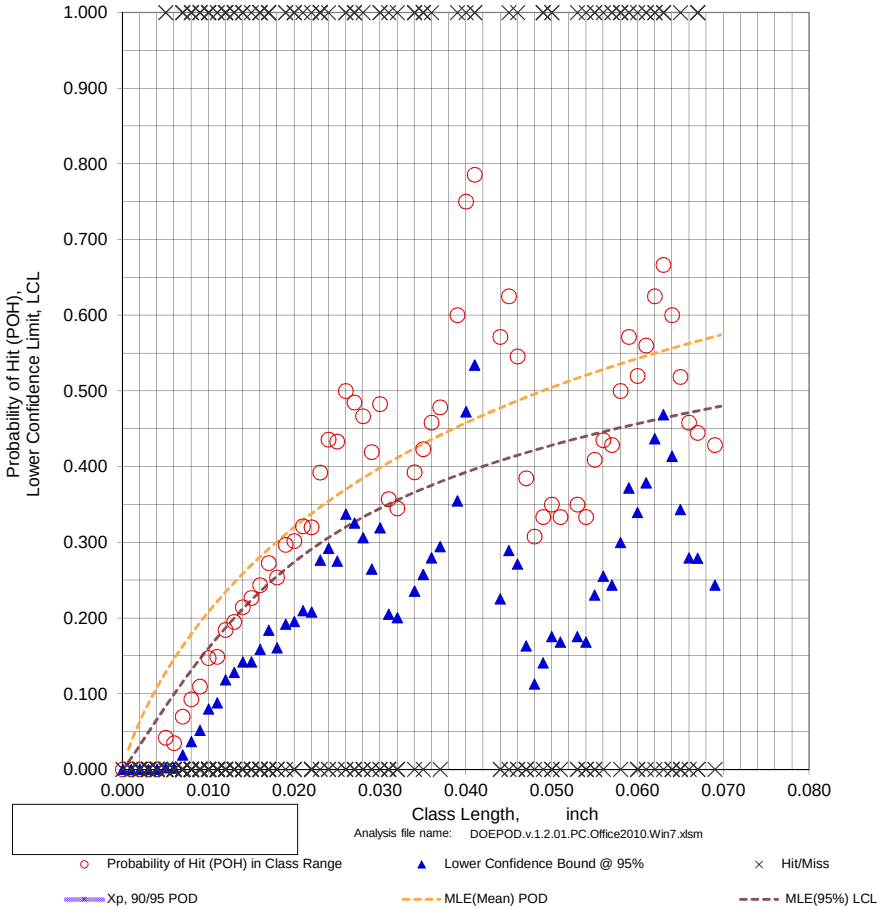
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE031(6)D.xls
Data Set Name = CE031(6)D(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:55 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5343 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0410 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.138 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE031(6)D.xls
Data Set Name = CE031(6)D(CRK #)

## Directed DOE Options

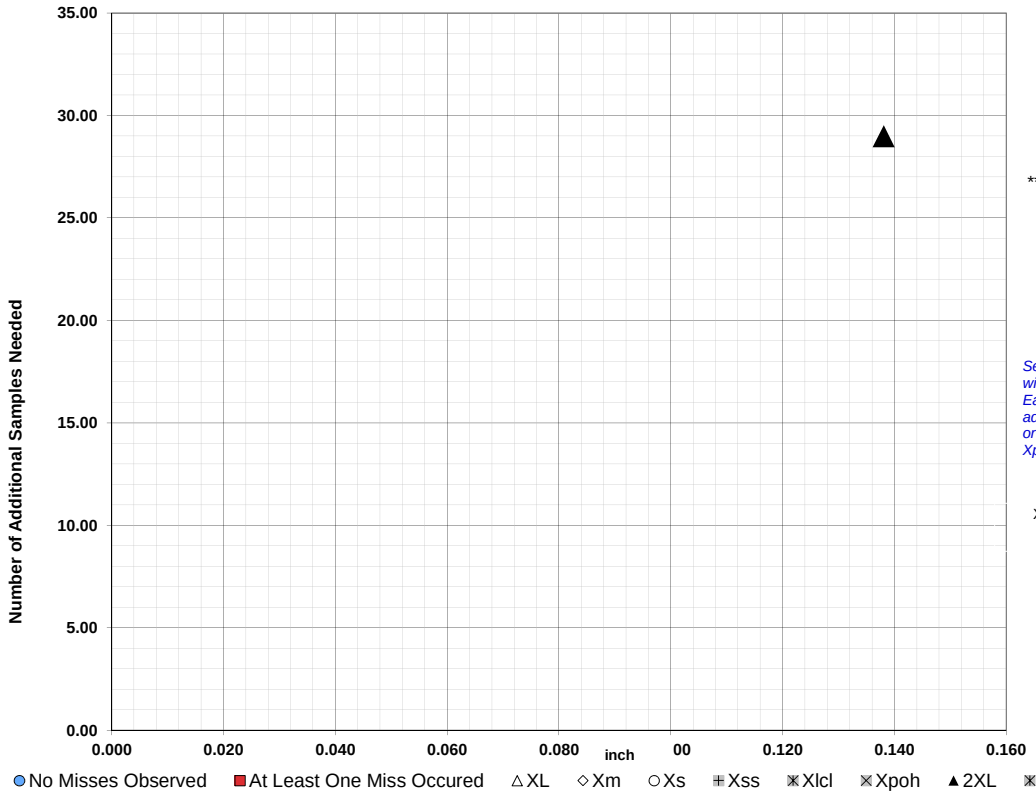



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.138 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

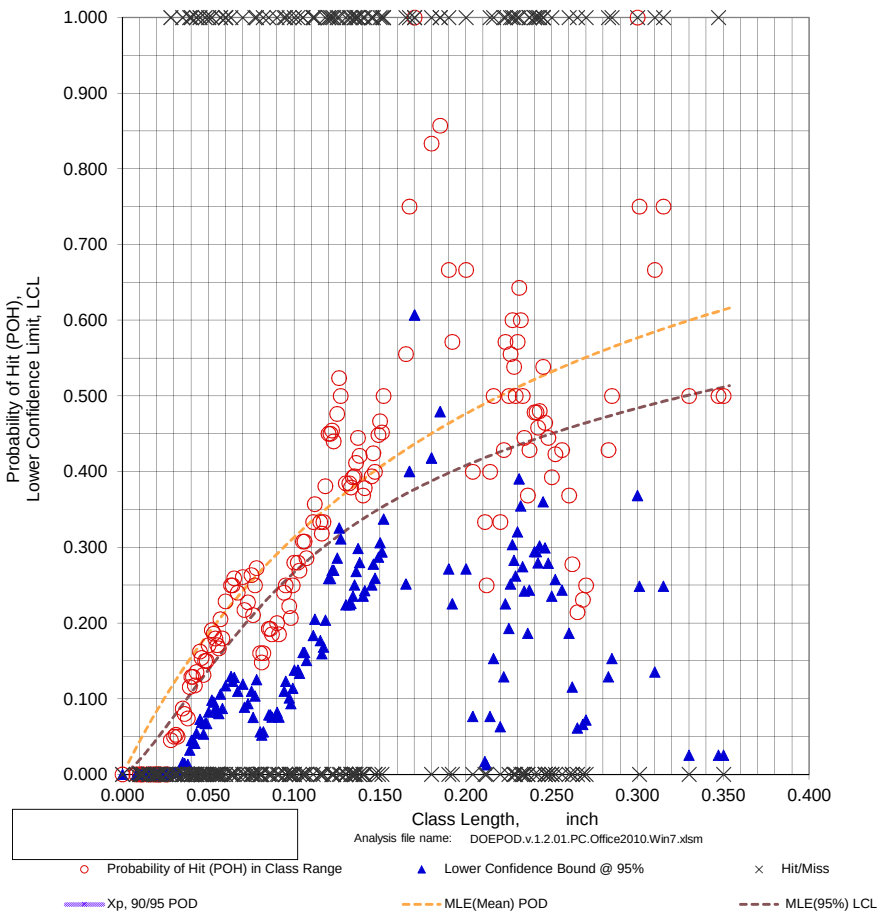
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE031(6)L.xls
Data Set Name = CE031(6)L(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:56 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0180 | inch |
| Classlength @ Best LCL = | 0.1700 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE031(6)L.xls
Data Set Name = CE031(6)L(CRK #)

## Directed DOE Options

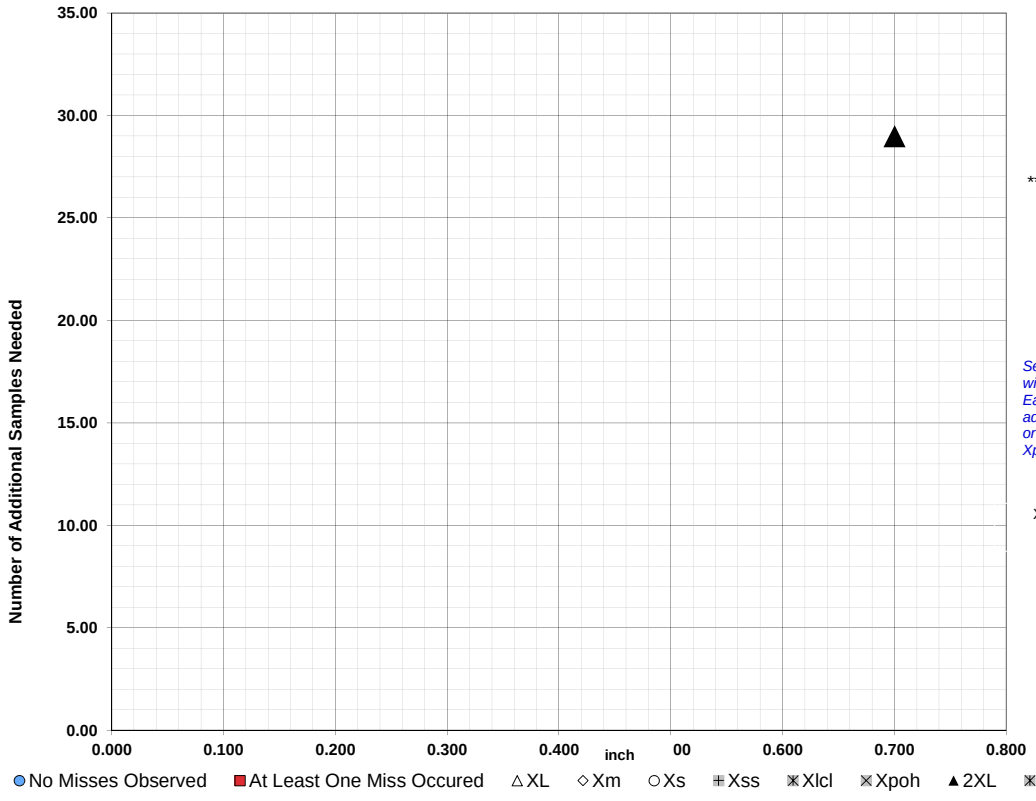



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

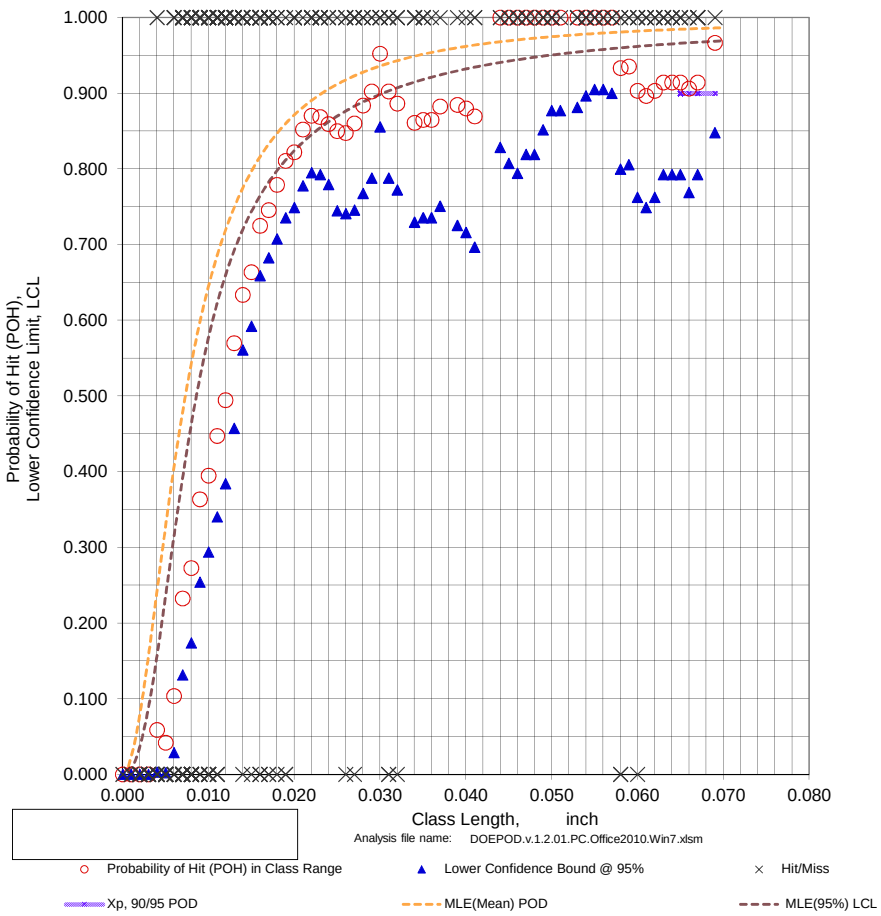
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.165.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE032(6)D.xls**

Data Set Name = **CE032(6)D(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:58 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0100 | inch |
| Classlength @ 90/95 Xpod = | 0.0550 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to satisfy XL requirements. Further VALIDATION is required. Recommend satisfying Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in T**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.918 | @ | 0.035 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.062 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0650 | inch |

File Name = CE032(6)D.xls
Data Set Name = CE032(6)D(CRK #)

## Directed DOE Options

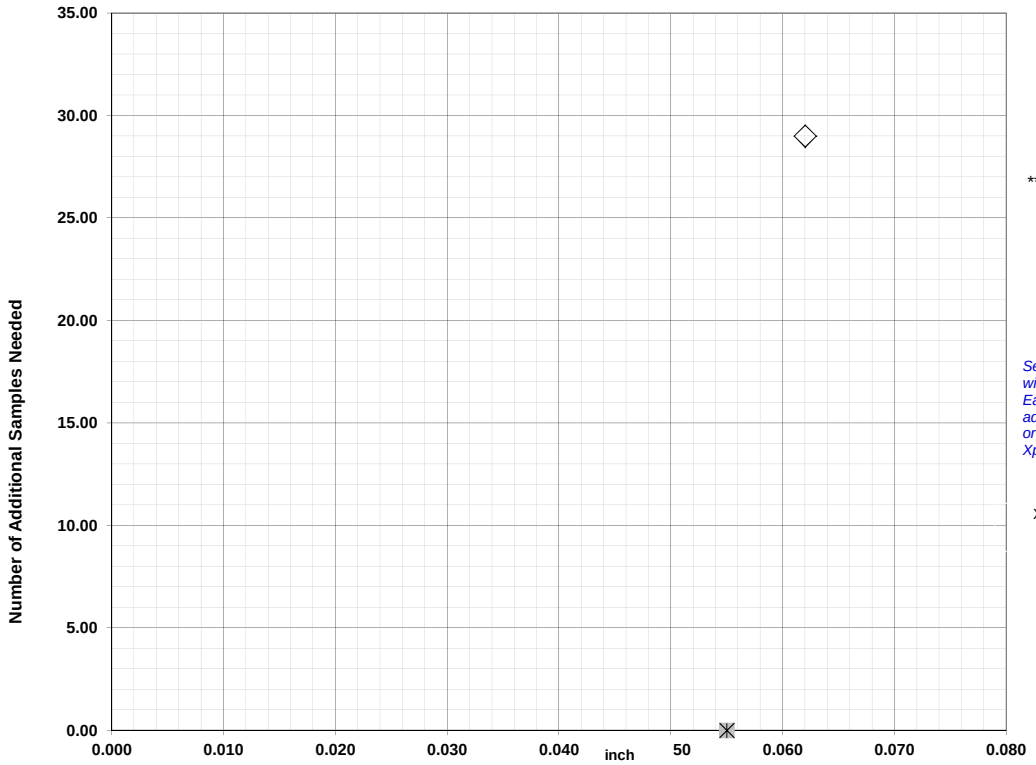



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.069 | |
| Xm = | 0.062 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

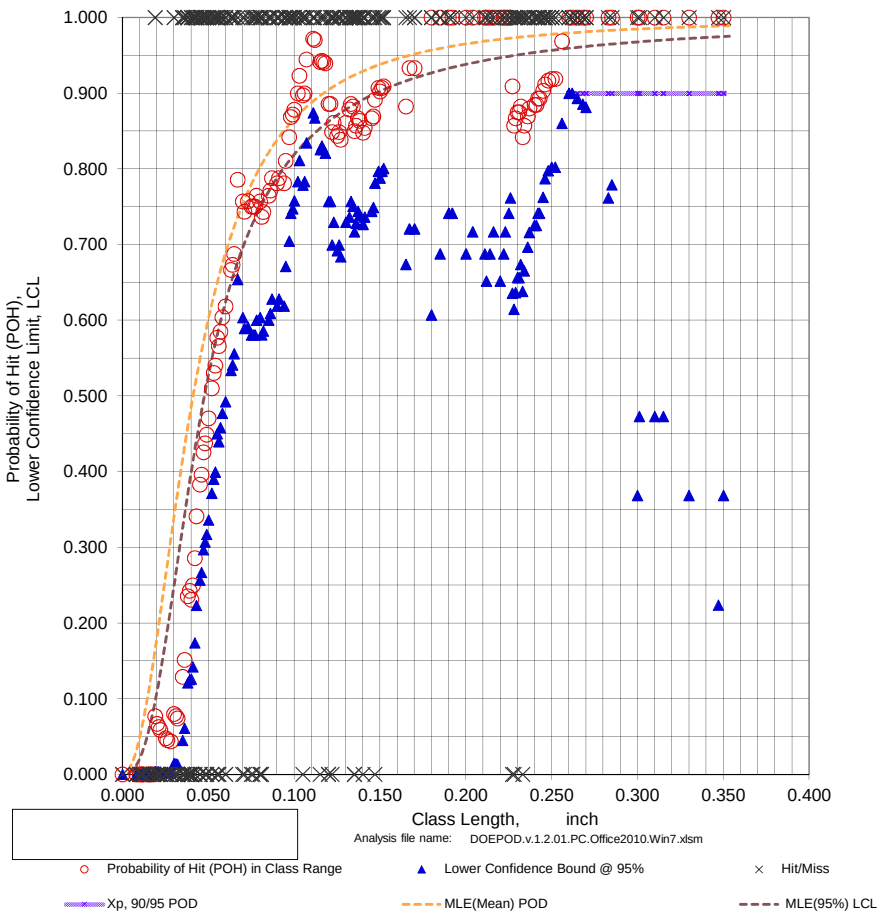
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.78.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **CE032(6)L.xls**

Data Set Name = **CE032(6)L(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 10:59 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0260 | inch |
| Classlength @ 90/95 Xpod = | 0.2600 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.2360 -0.002 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.120 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.150 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.285 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.258 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.2600 | inch |

File Name = CE032(6)L.xls
Data Set Name = CE032(6)L(CRK #)

## Directed DOE Options

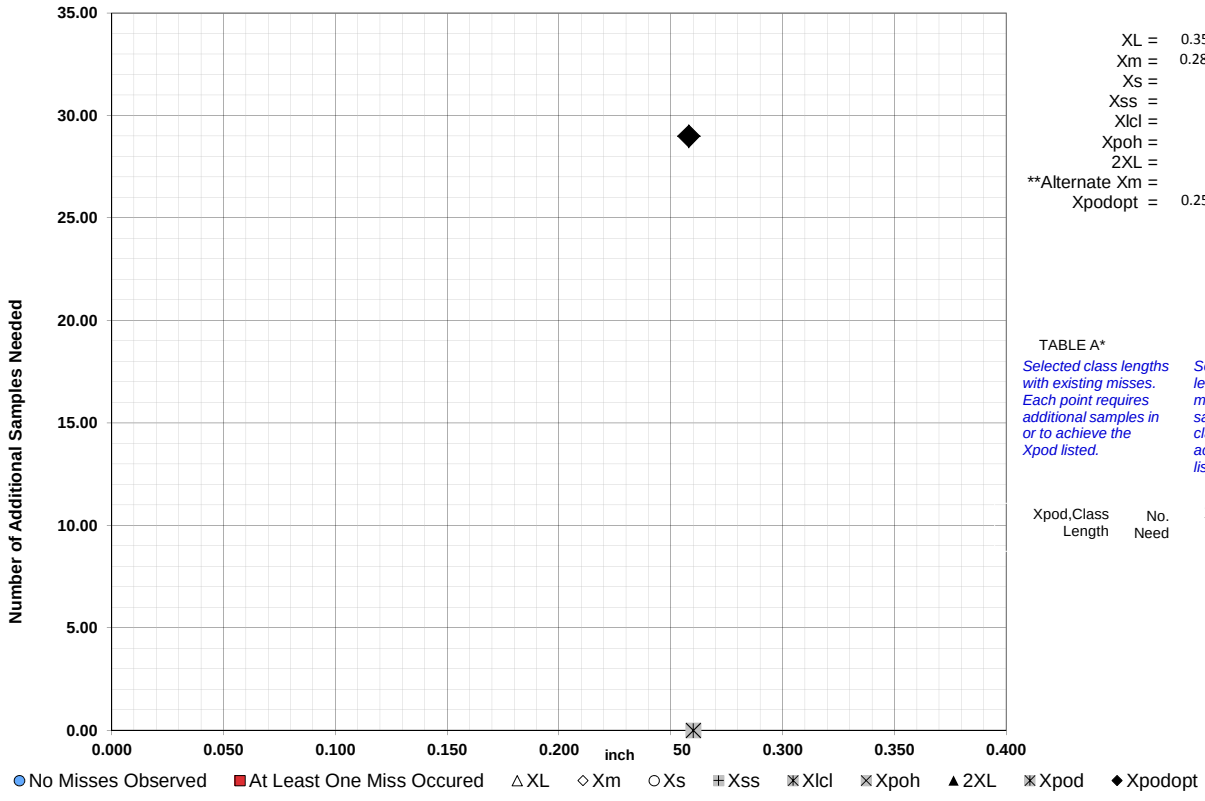



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.350 | |
| Xm = | 0.285 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.258 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

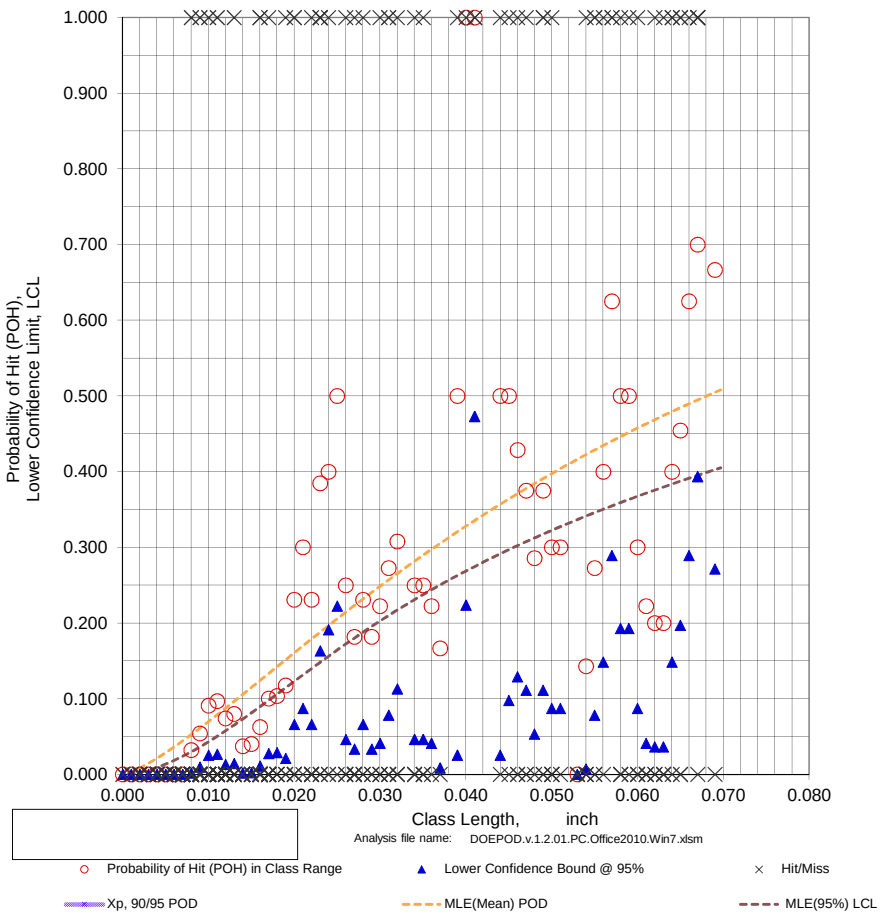
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = CE041(6)D.xls
Data Set Name = CE041(6)D(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:00 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4729 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.0410 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.138 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE041(6)D.xls
Data Set Name = CE041(6)D(CRK NO. )

## Directed DOE Options

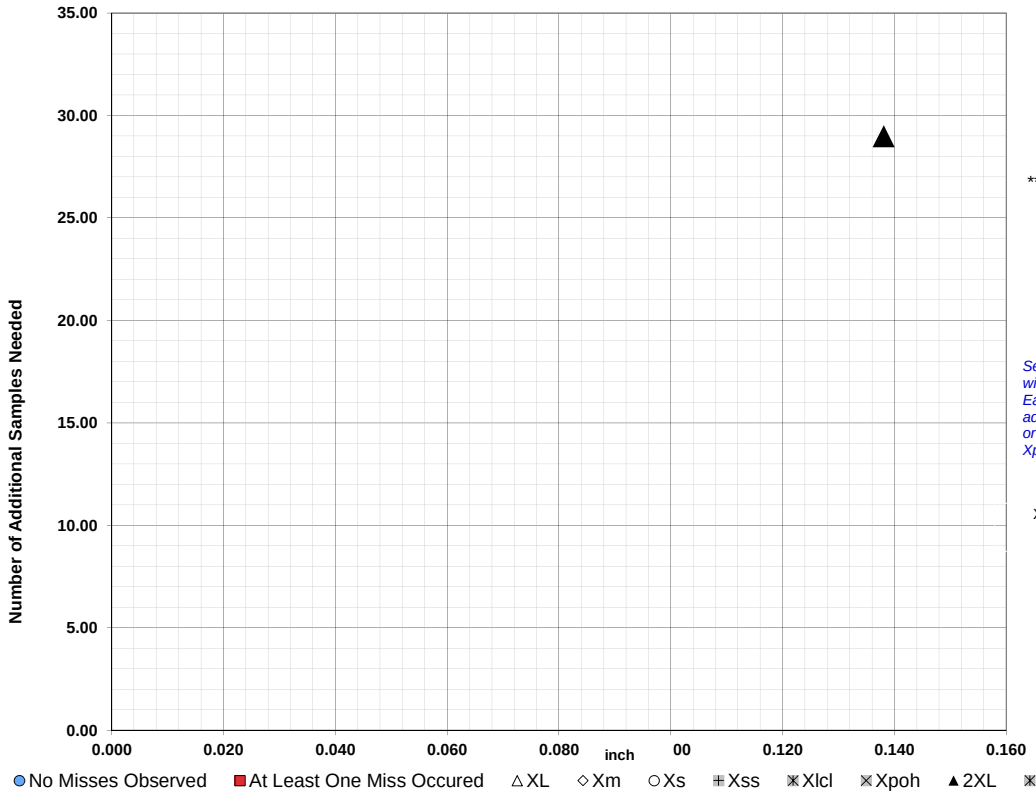



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.138 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

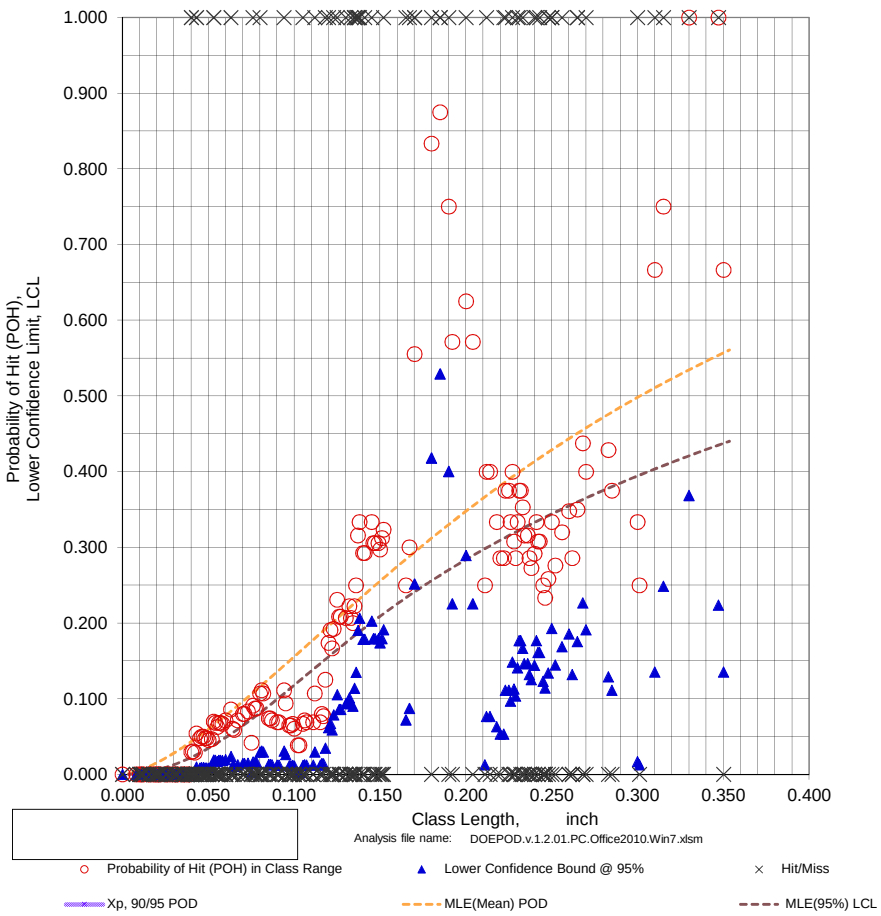
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE041(6)L.xls
Data Set Name = CE041(6)L(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:01 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5293 | |
| Classwidth @ Best LCL = | 0.0200 | inch |
| Classlength @ Best LCL = | 0.1850 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE041(6)L.xls
Data Set Name = CE041(6)L(CRK NO. )

## Directed DOE Options

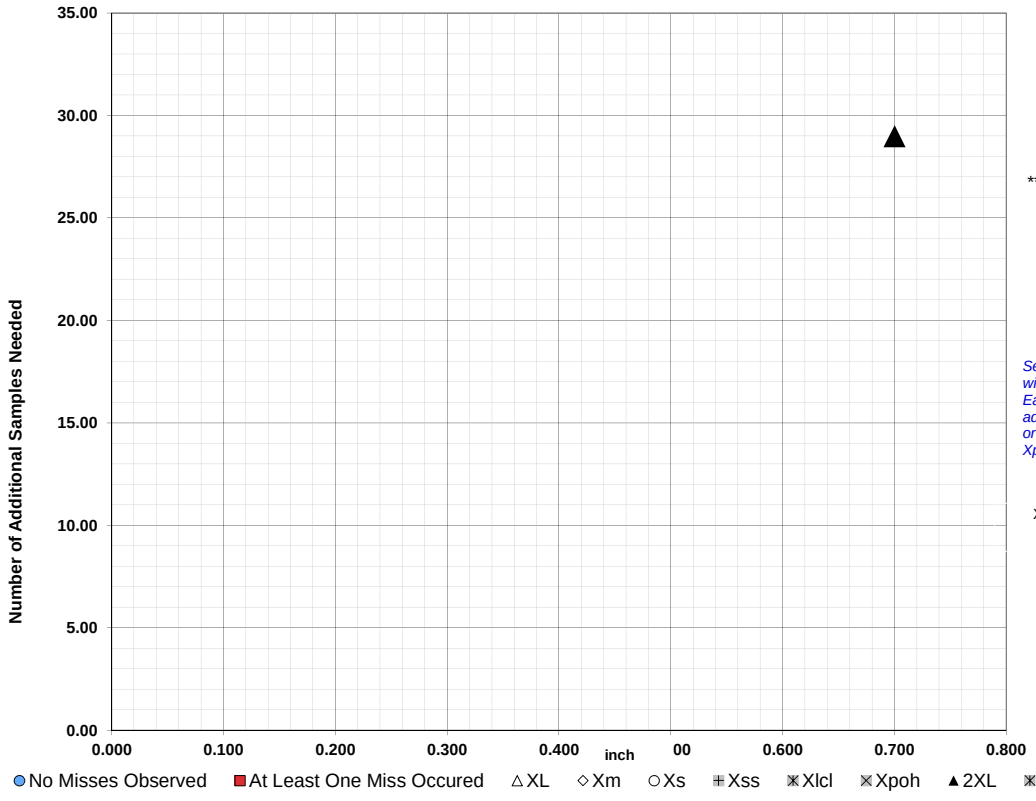



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

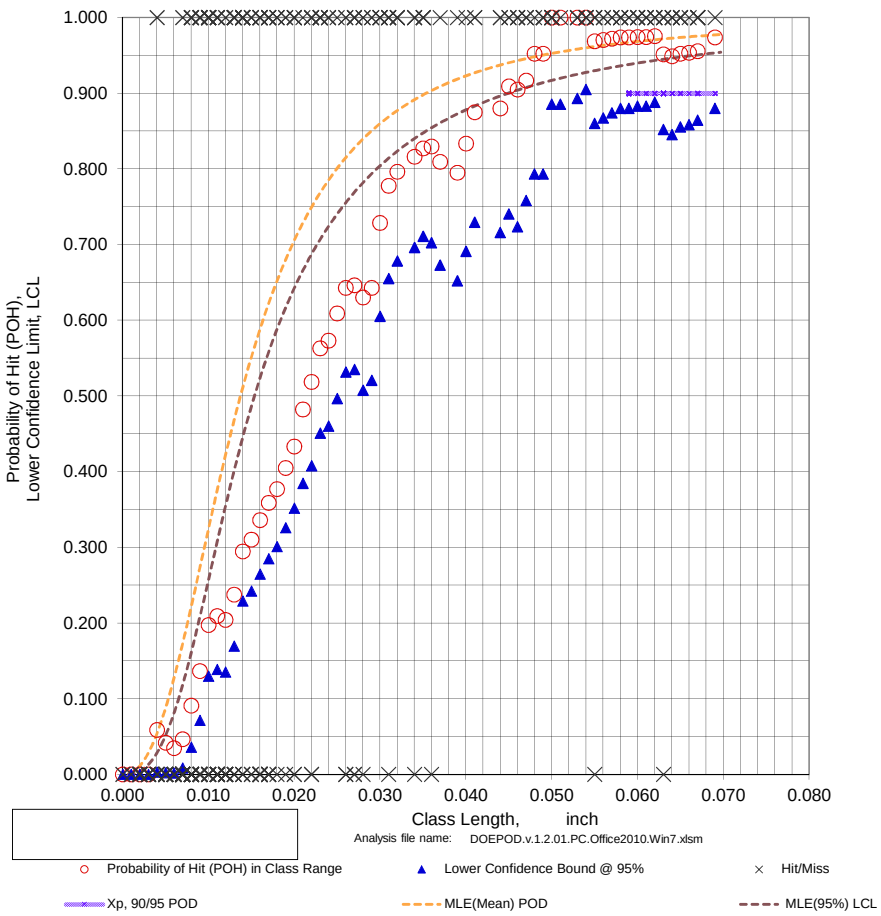
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.162.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE042(6)D.xls**

Data Set Name = **CE042(6)D(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:04 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0130 | inch |
| Classlength @ 90/95 Xpod = | 0.0540 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and alternate Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.923 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.045 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.059 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0590 | inch |

File Name = CE042(6)D.xls
Data Set Name = CE042(6)D(CRK NO. )

## Directed DOE Options

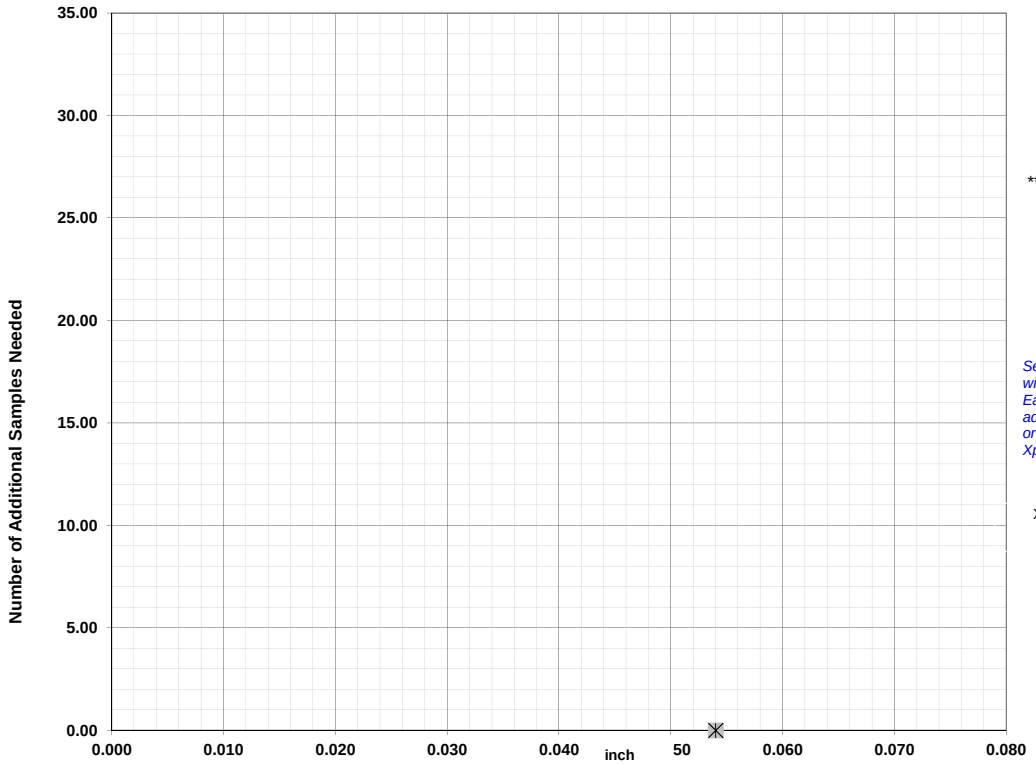



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.069 | |
| Xm = | 0.059 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

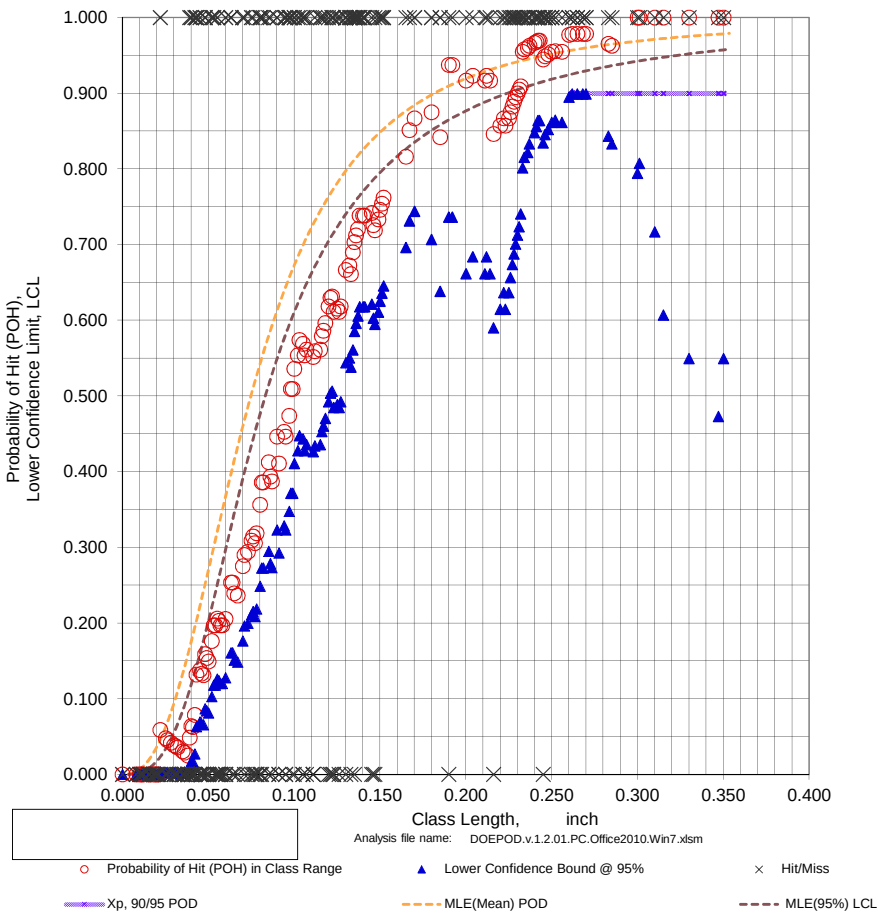
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.786.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE042(6)L.xls**

Data Set Name = **CE042(6)L(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:05 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0420 | inch |
| Classlength @ 90/95 Xpod = | 0.2620 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.2480 -0.002 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.225 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.301 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2620 | inch |

File Name = CE042(6)L.xls
Data Set Name = CE042(6)L(CRK NO. )

## Directed DOE Options

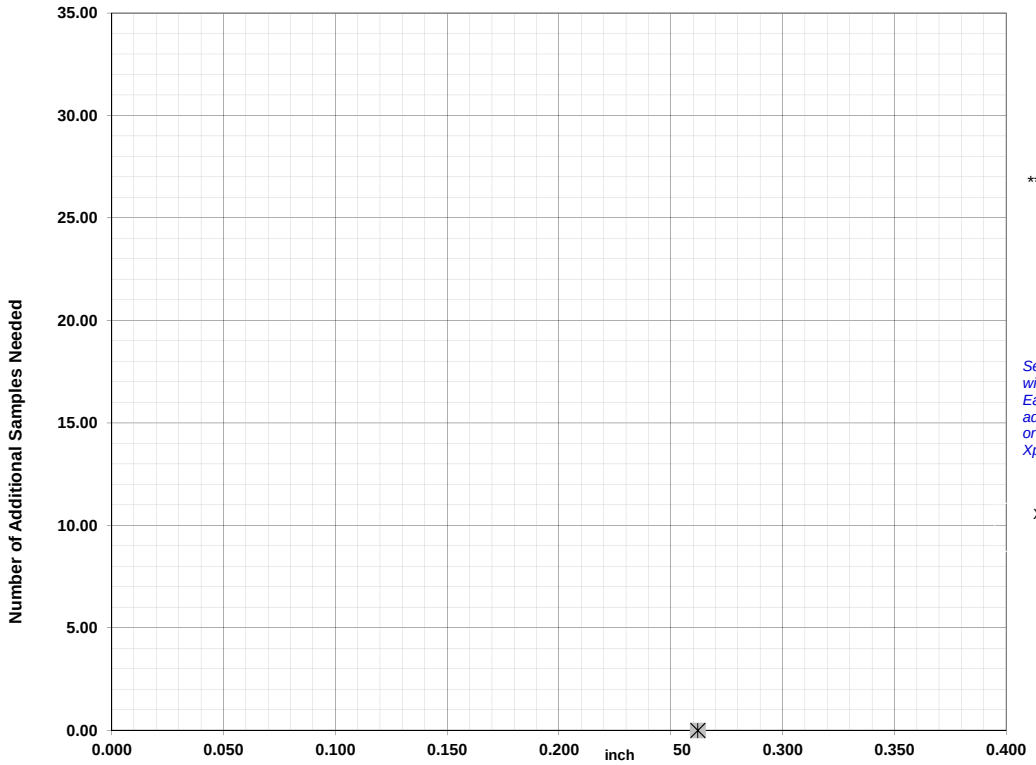



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.350 |
| Xm = | 0.301 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

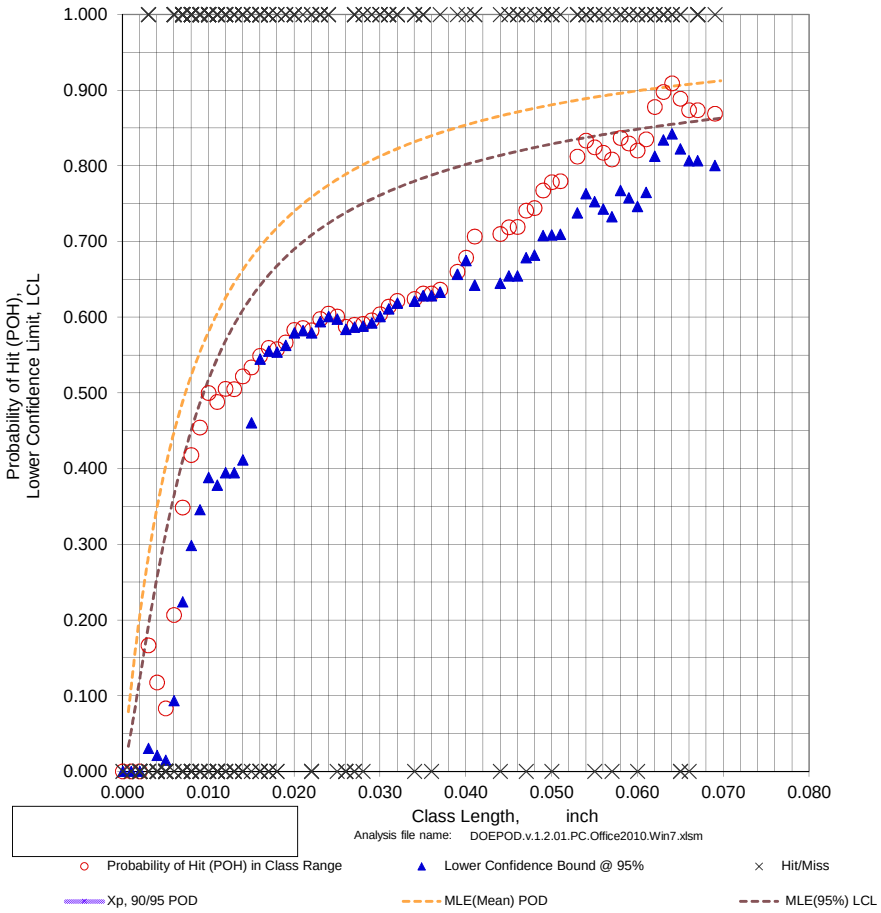
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE051(6)D.xls
Data Set Name = CE051(6)D(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:06 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8421 | |
| Classwidth @ Best LCL = | 0.0350 | inch |
| Classlength @ Best LCL = | 0.0640 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0690 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.065 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.115 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.138 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE051(6)D.xls
Data Set Name = CE051(6)D(CRK NO. )

## Directed DOE Options

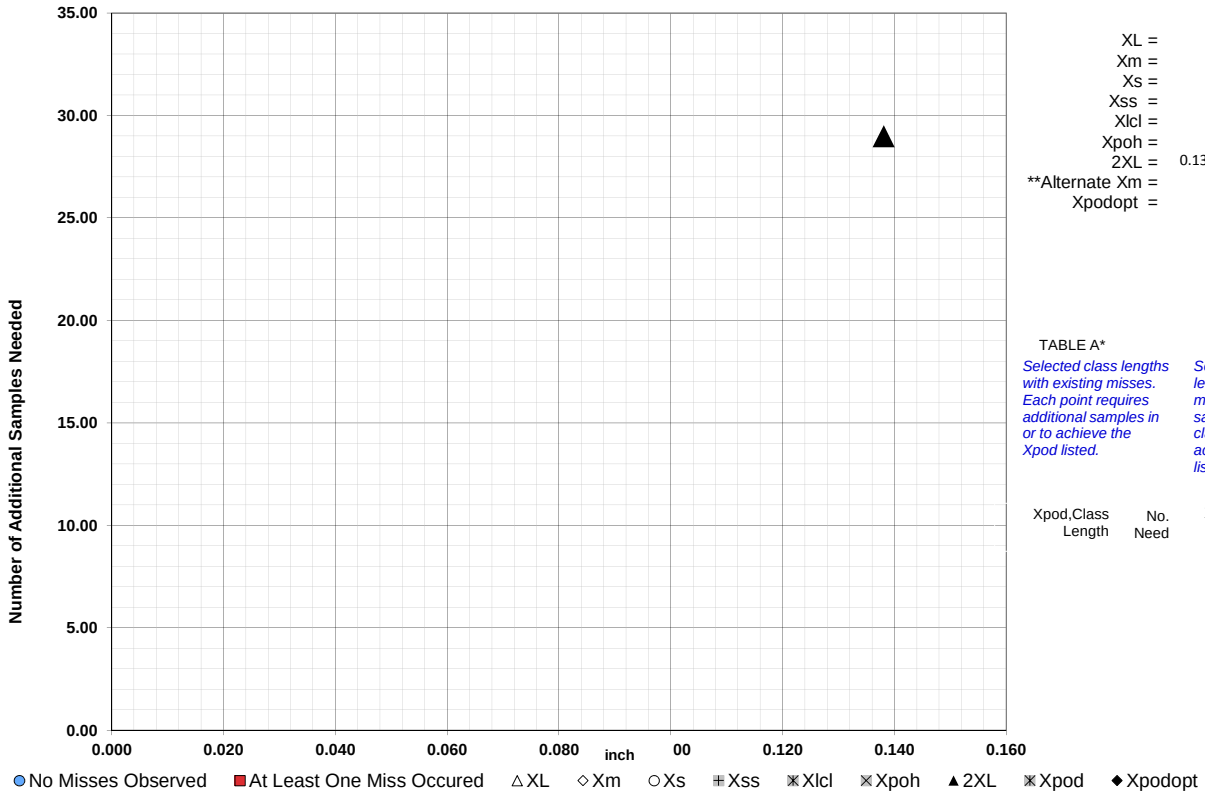



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.138 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

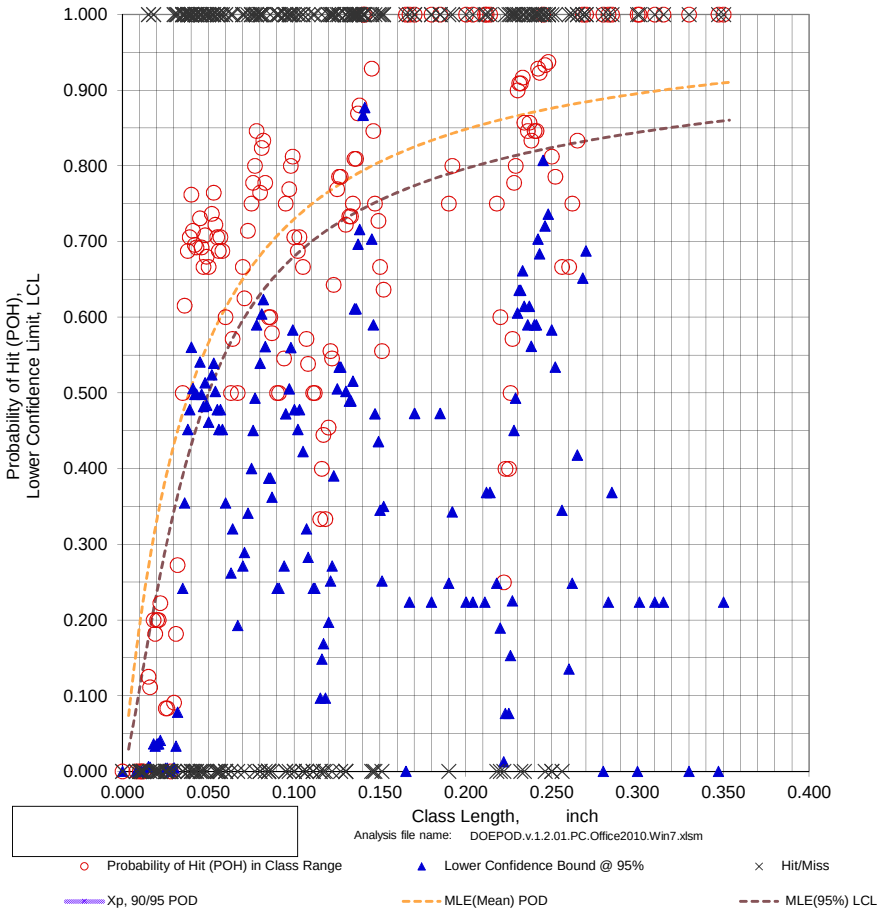
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE051(6)L.xls
Data Set Name = CE051(6)L(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:07 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8768 | |
| Classwidth @ Best LCL = | 0.0090 | inch |
| Classlength @ Best LCL = | 0.1410 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2600 -0.003 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.315 inch
NTIAC 90/95 POD = 0.900 @ 0.575 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.268 | inch |
| Samples Needed @ Xpoh = | 22 | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE051(6)L.xls
Data Set Name = CE051(6)L(CRK NO. )

## Directed DOE Options

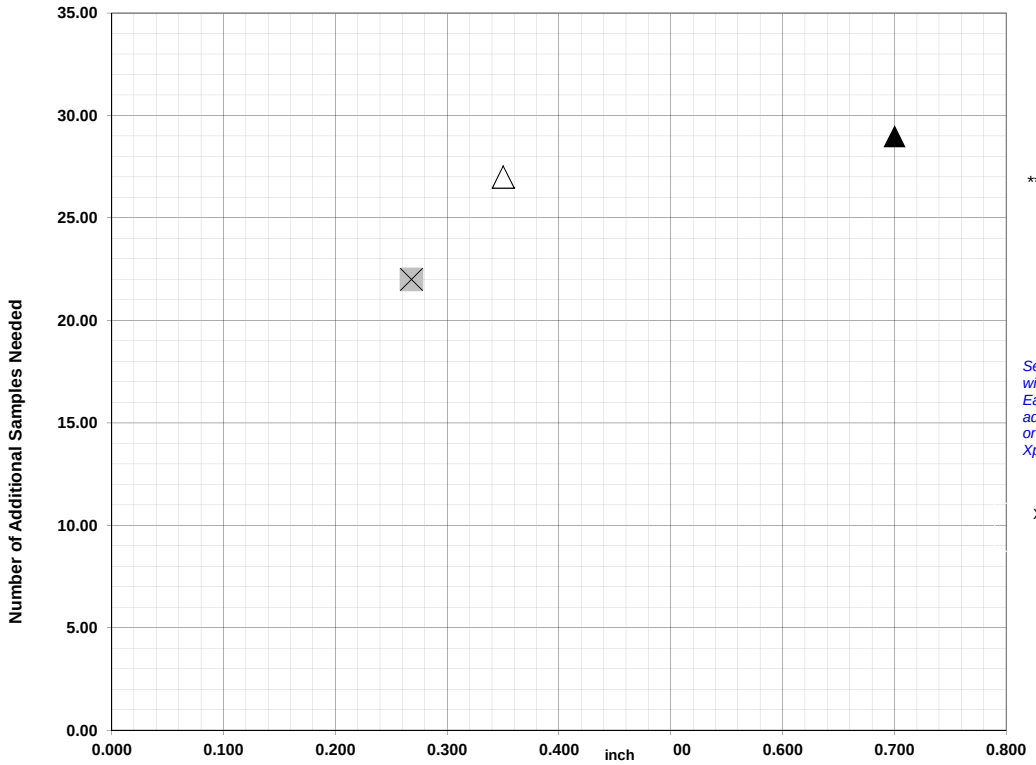



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.350 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.268 | 22 |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

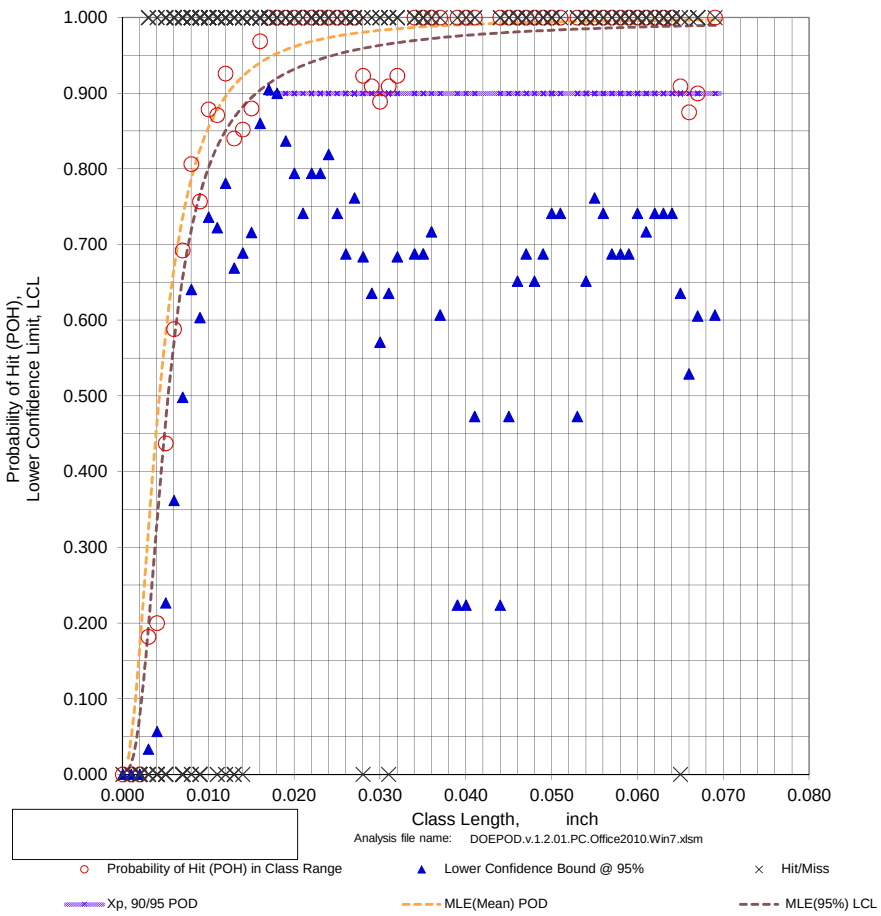
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation successful.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE052(6)D.xls**

Data Set Name = **CE052(6)D(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:09 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0170 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1+ - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp VALIDATES between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.932 | @ | 0.015 | inch |
| NTIAC 90/95 POD = | 0.932 | @ | 0.020 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.055 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0170 | inch |

File Name = CE052(6)D.xls
Data Set Name = CE052(6)D(CRK NO. )

## Directed DOE Options

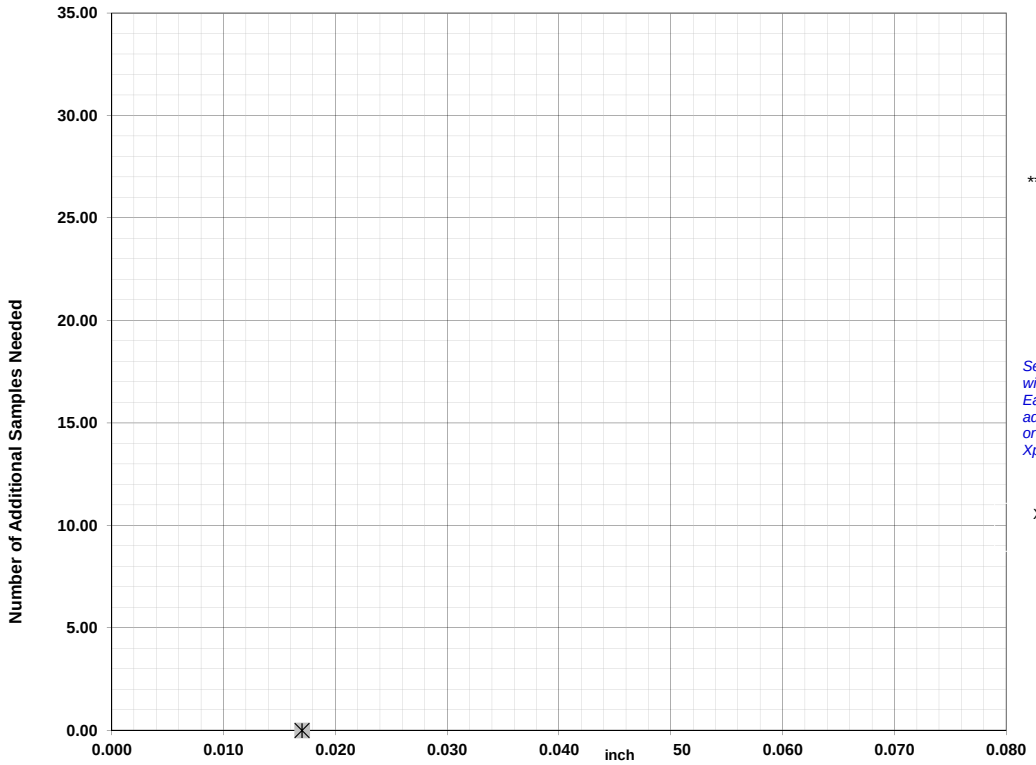



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.069 |
| Xm = | 0.055 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

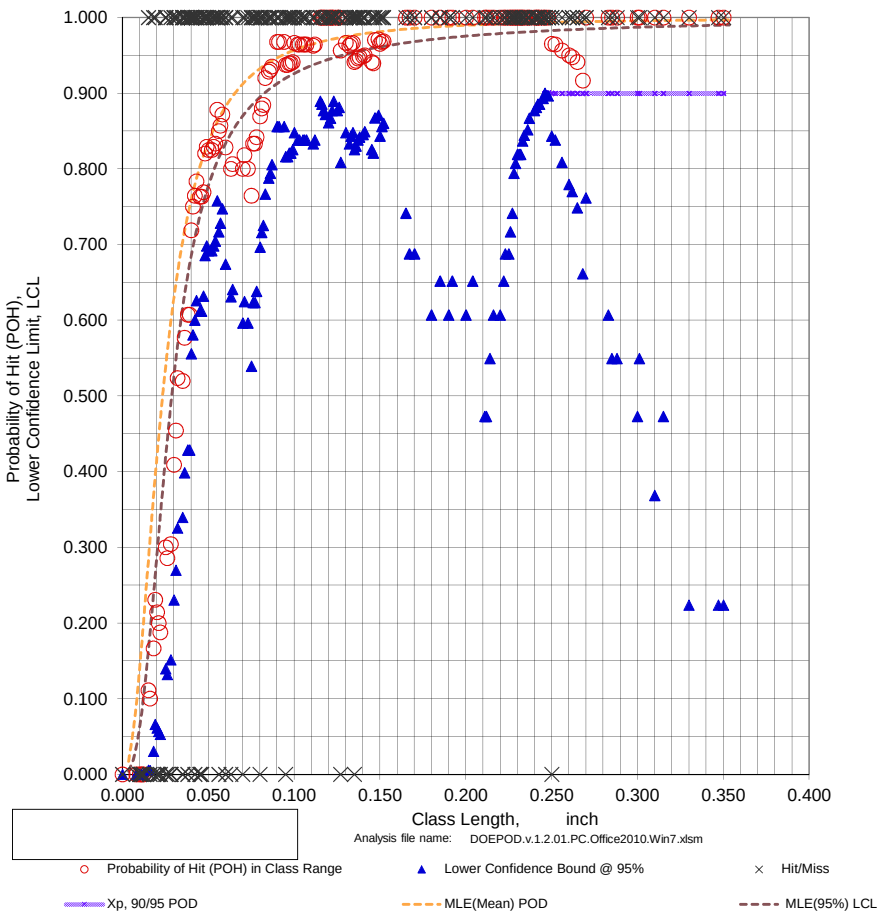
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.738.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE052(6)L.xls**

Data Set Name = **CE052(6)L(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:12 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0190 | inch |
| Classlength @ 90/95 Xpod = | 0.2460 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.070 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.085 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.283 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2460 | inch |

File Name = CE052(6)L.xls
Data Set Name = CE052(6)L(CRK NO. )

## Directed DOE Options

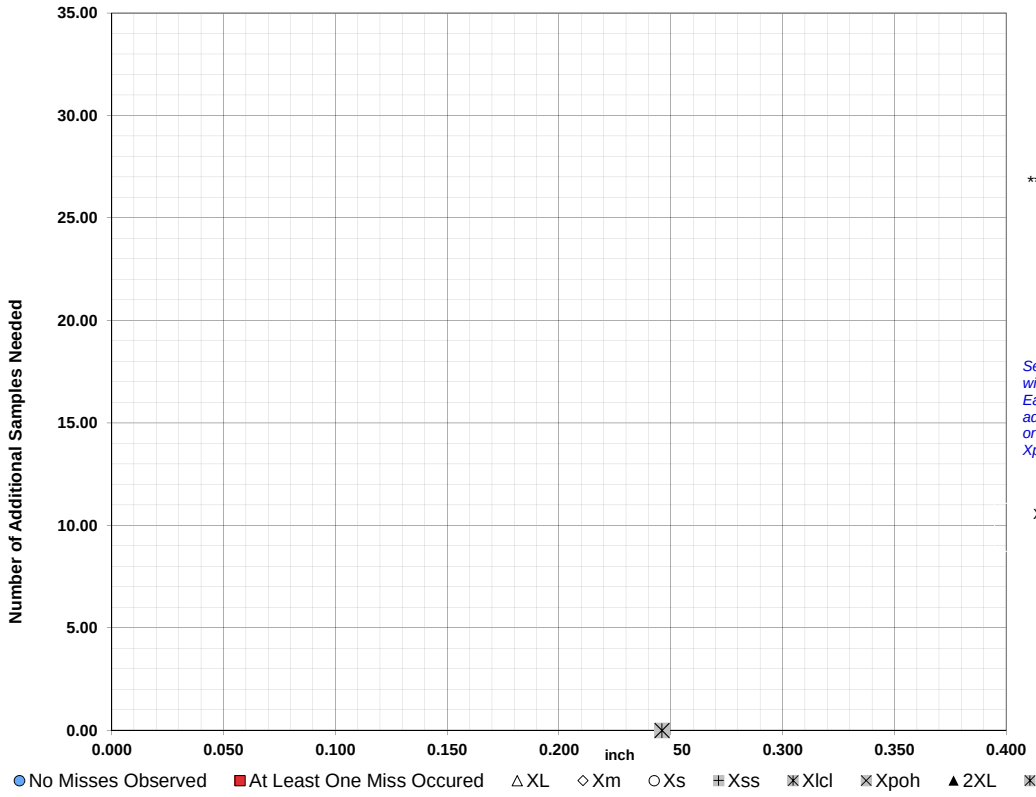



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.350 |
| Xm = | 0.283 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

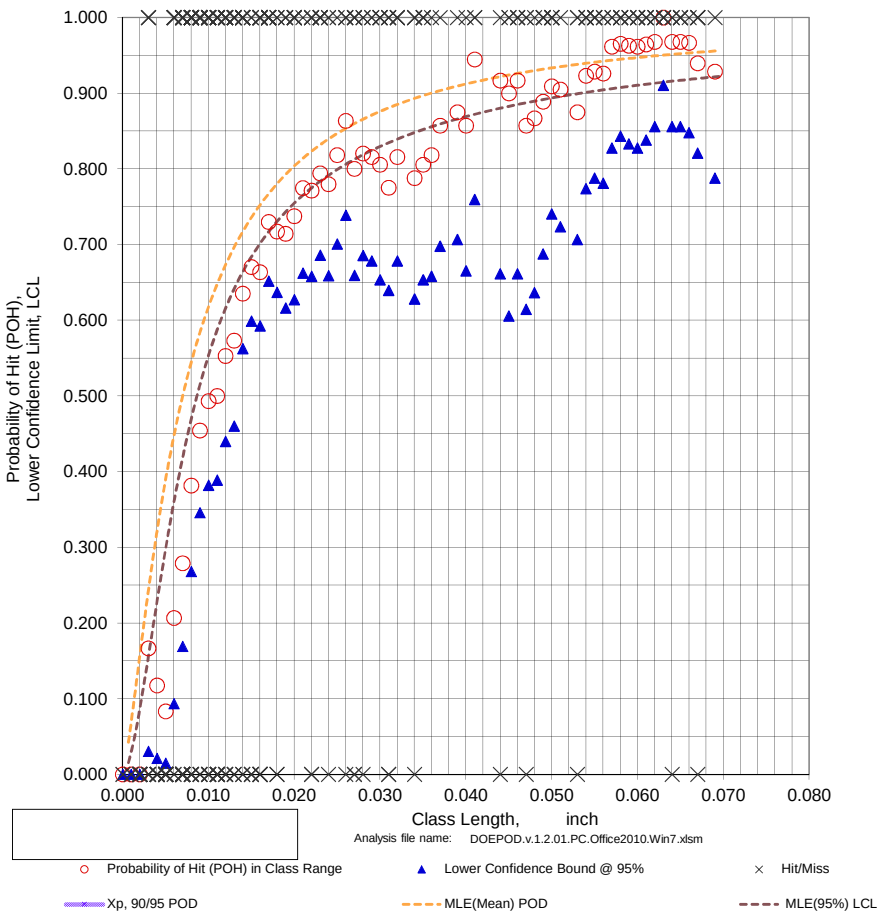
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.189.**

**Warning: No false call analysis.**




File Name = **CE061(6)D.xls**

Data Set Name = **CE061(6)D(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:14 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0090 | inch |
| Classlength @ 90/95 Xpod = | 0.0630 | inch |
| Lower Confidence Bound = | 0.9104 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.055 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | 33 | |
| Classlength Mid-point , Xm = | 0.066 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE061(6)D.xls
Data Set Name = CE061(6)D(CRK NO. )

## Directed DOE Options

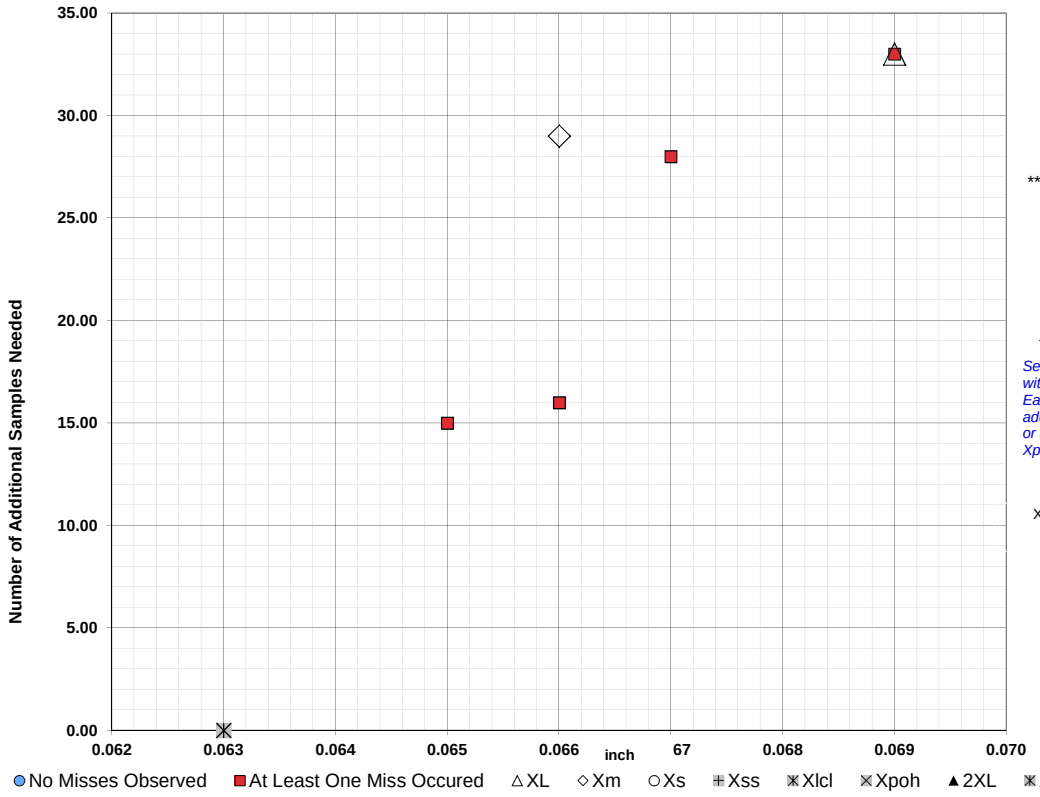



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.069 | 33 |
| Xm = | 0.066 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.0690 | 33 |
| 0.0670 | 28 |
| 0.0660 | 16 |
| 0.0650 | 15 |

TABLE B*

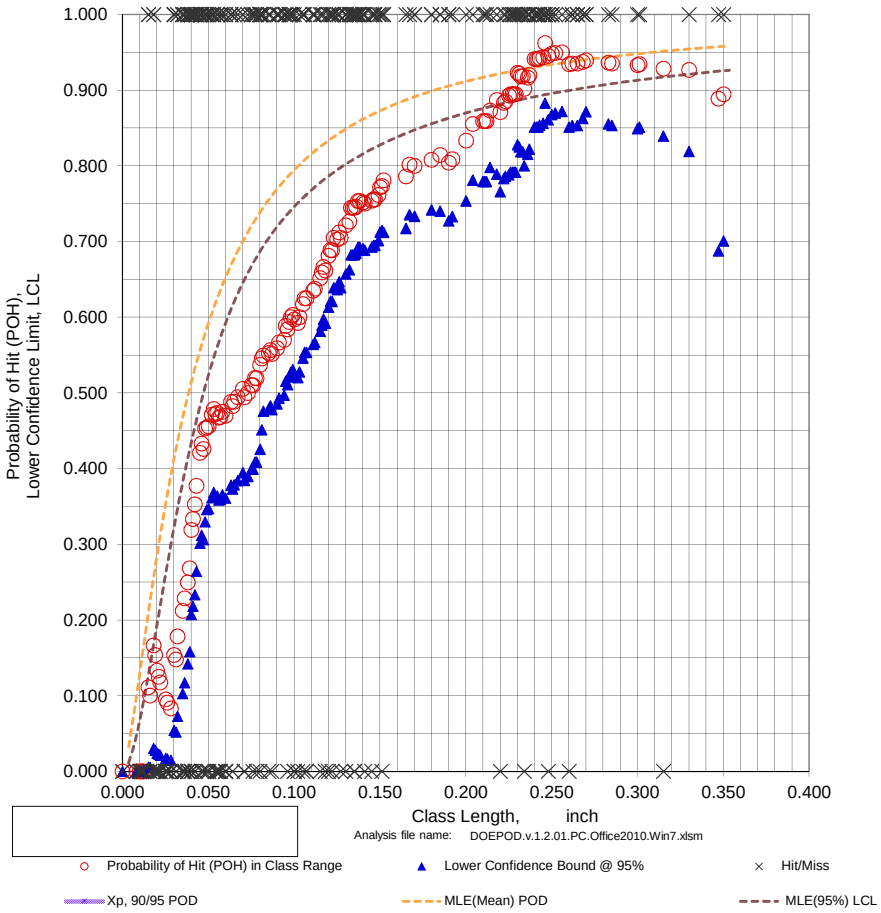
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE061(6)L.xls
Data Set Name = CE061(6)L(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:15 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8829 | |
| Classwidth @ Best LCL = | 0.0940 | inch |
| Classlength @ Best LCL = | 0.2460 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3300 -0.014 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.265 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE061(6)L.xls
Data Set Name = CE061(6)L(CRK NO. )

## Directed DOE Options

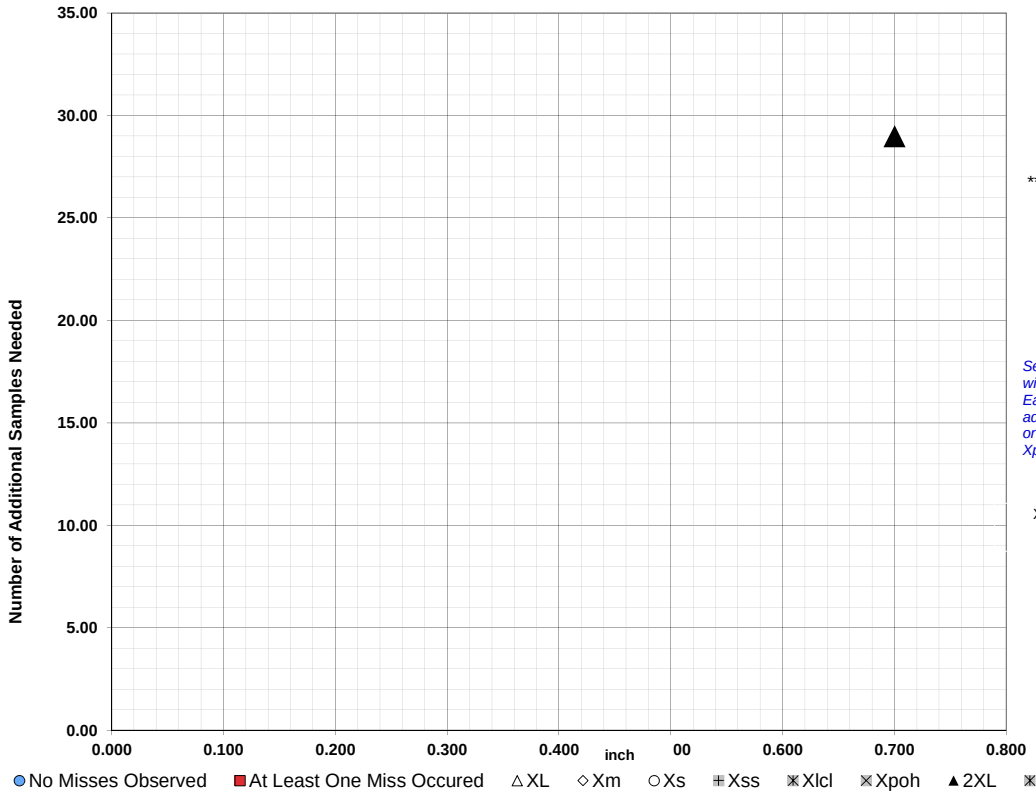



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

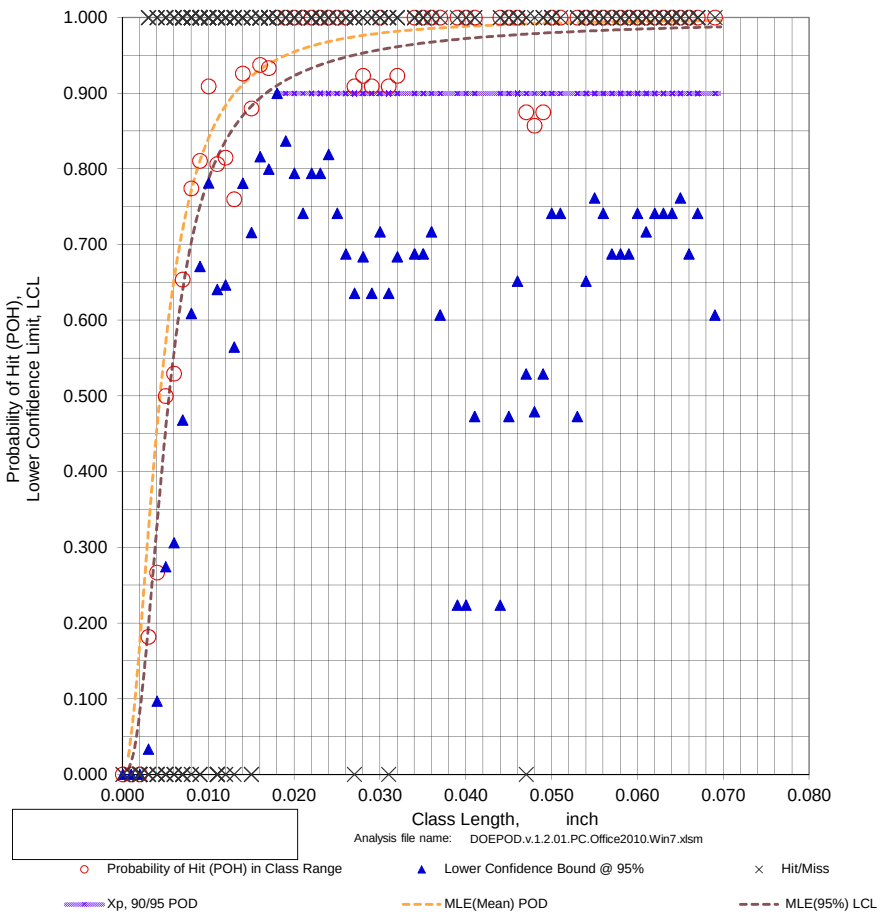
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 1 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE062(6)D.xls**

Data Set Name = **CE062(6)D(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:17 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0180 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.922 | @ | 0.015 | inch |
| NTIAC 90/95 POD = | 0.923 | @ | 0.020 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.055 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0180 | inch |

File Name = CE062(6)D.xls
Data Set Name = CE062(6)D(CRK NO. )

## Directed DOE Options

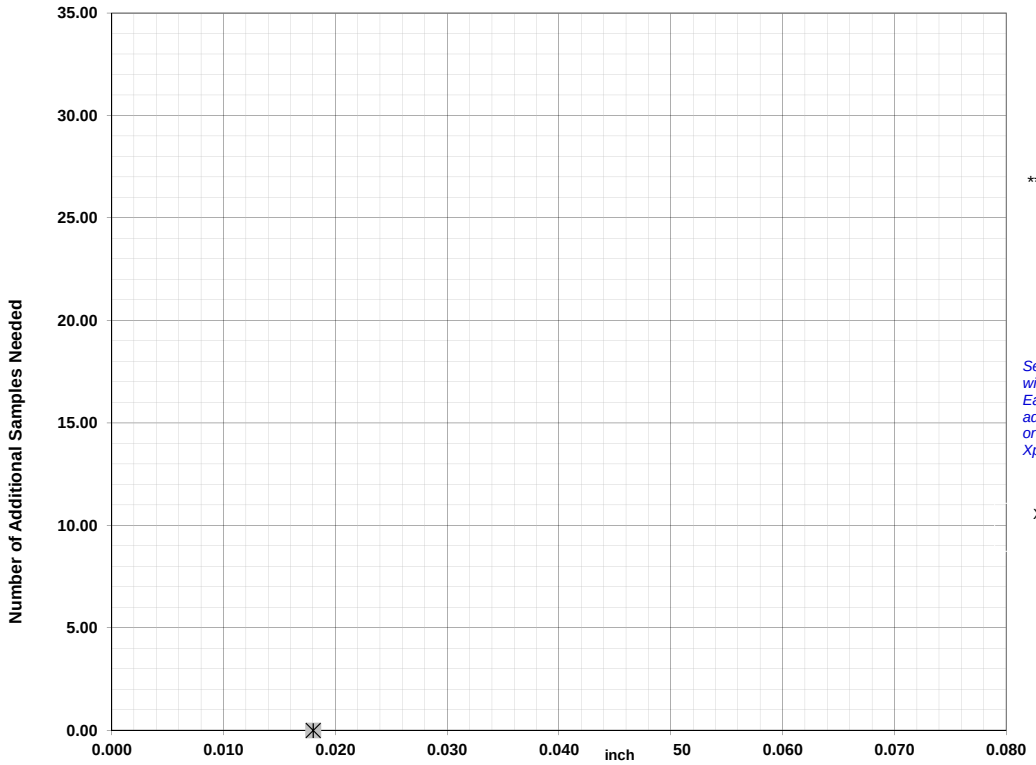



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.069 |
| Xm = | 0.055 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

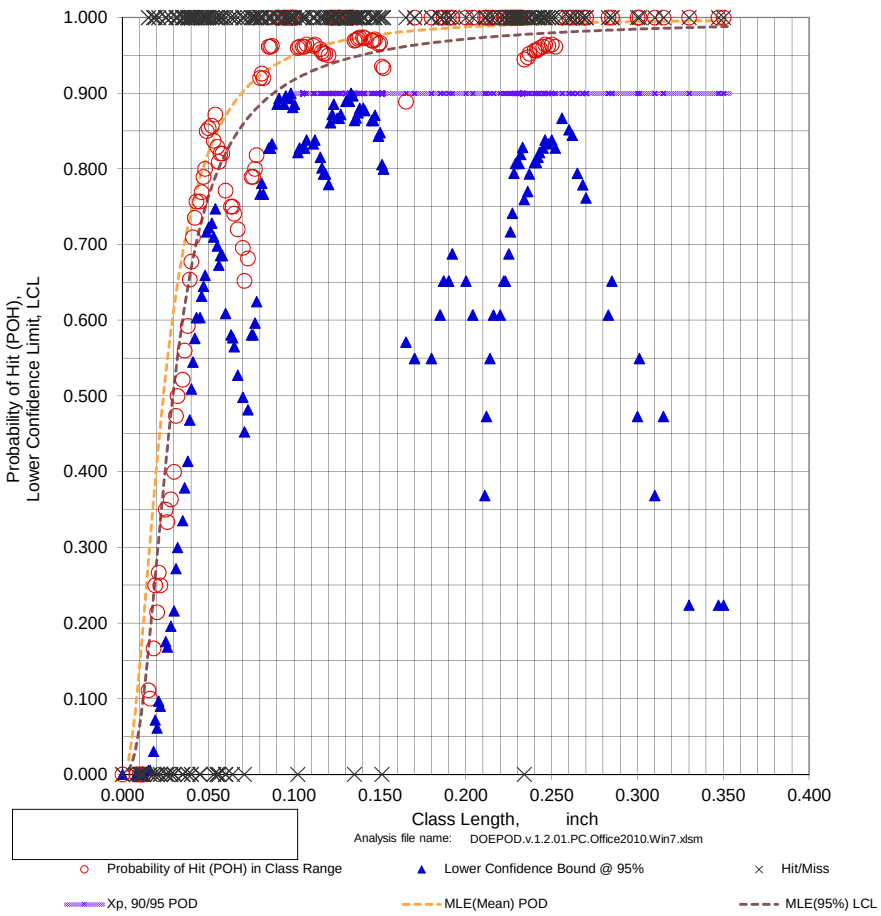
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 2 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE062(6)L.xls**

Data Set Name = **CE062(6)L(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:20 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0180 | inch |
| Classlength @ 90/95 Xpod = | 0.0980 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.070 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.256 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1050 | inch |

File Name = CE062(6)L.xls
Data Set Name = CE062(6)L(CRK NO. )

## Directed DOE Options

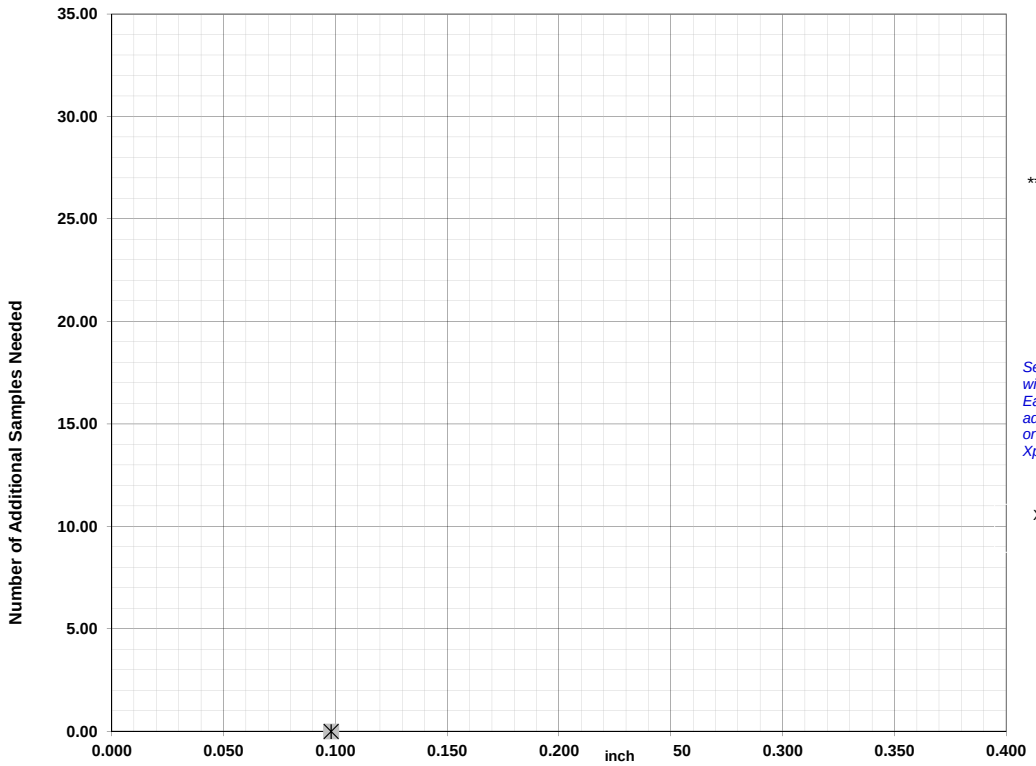



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.350 |
| Xm = | 0.256 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

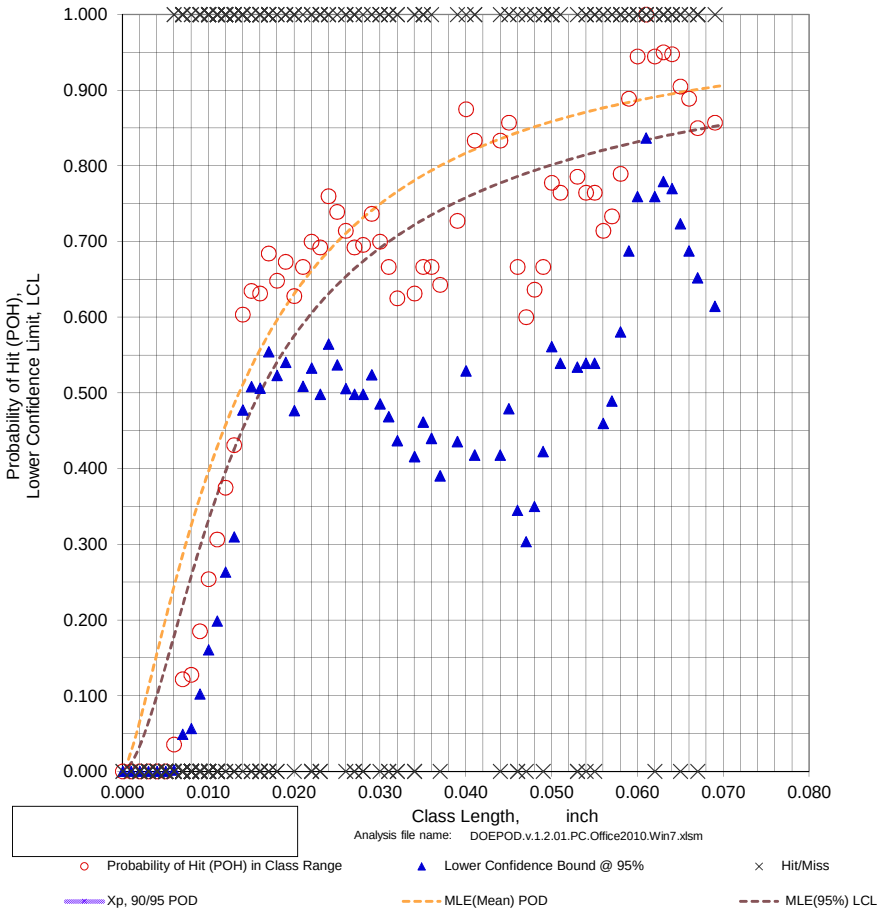
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE071(6)D.xls
Data Set Name = CE071(6)D(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:24 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8368 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.0610 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0690 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.070 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.105 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.138 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE071(6)D.xls
Data Set Name = CE071(6)D(CRK NO. )

## Directed DOE Options

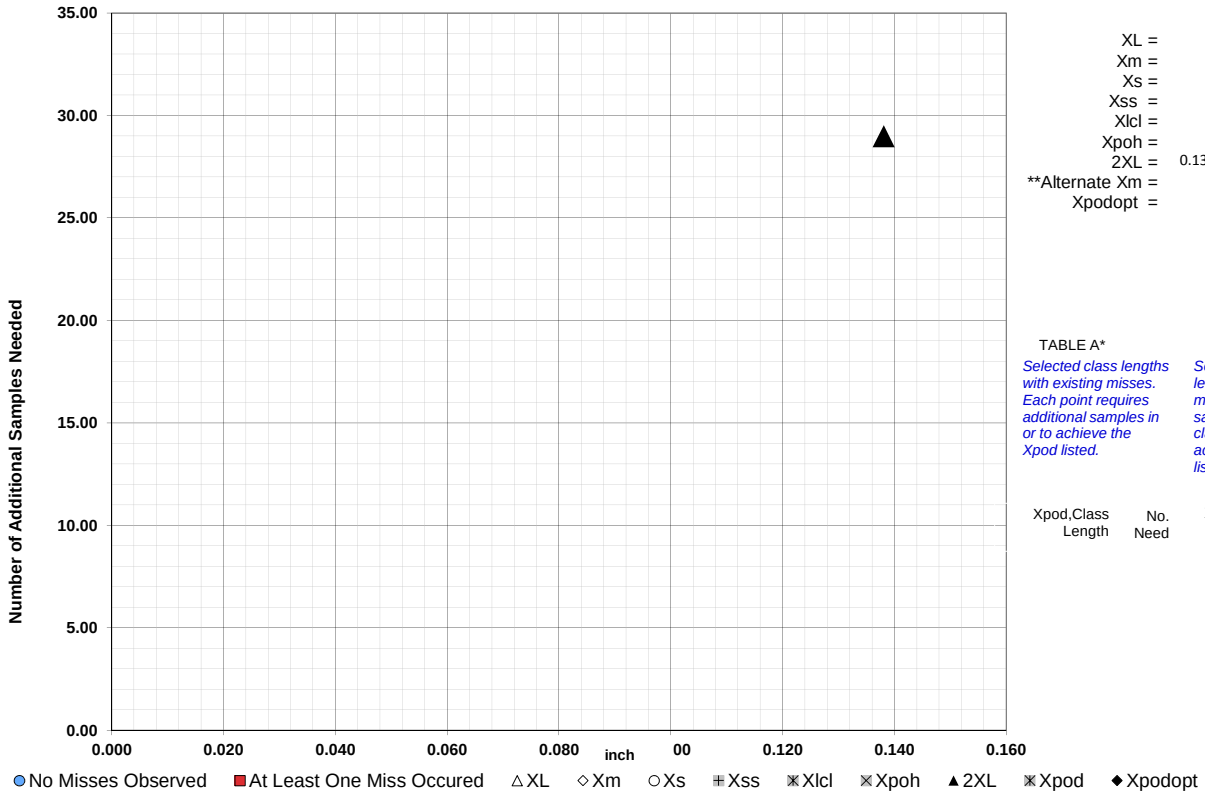



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.138 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

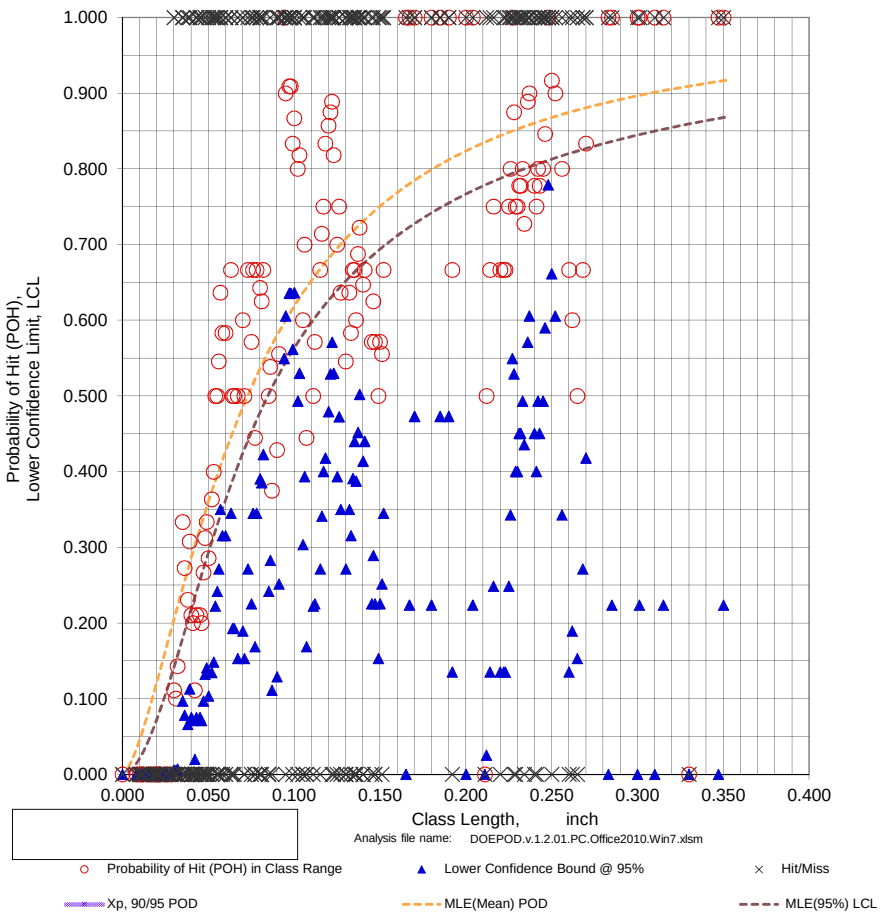
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = CE071(6)L.xls
Data Set Name = CE071(6)L(CRK NO. )

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:25 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0060 | inch |
| Classlength @ Best LCL = | 0.2480 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3470 -0.016 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.310 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.455 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.347 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE071(6)L.xls
Data Set Name = CE071(6)L(CRK NO. )

## Directed DOE Options

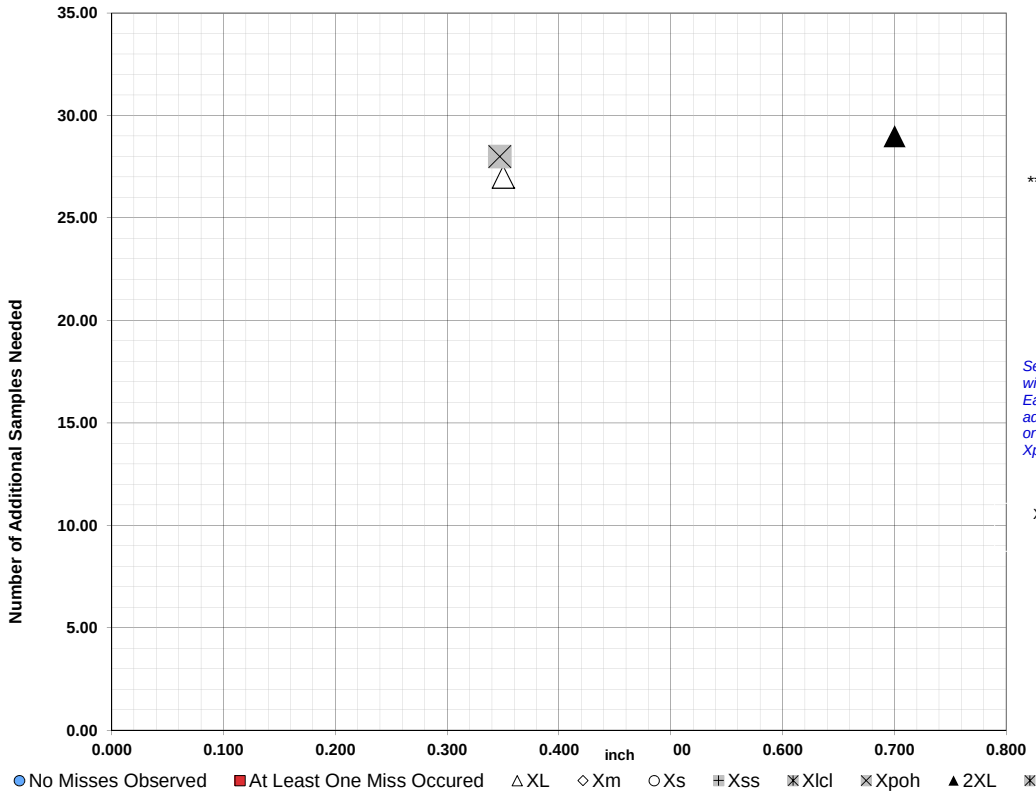



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.350 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.347 | 28 |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

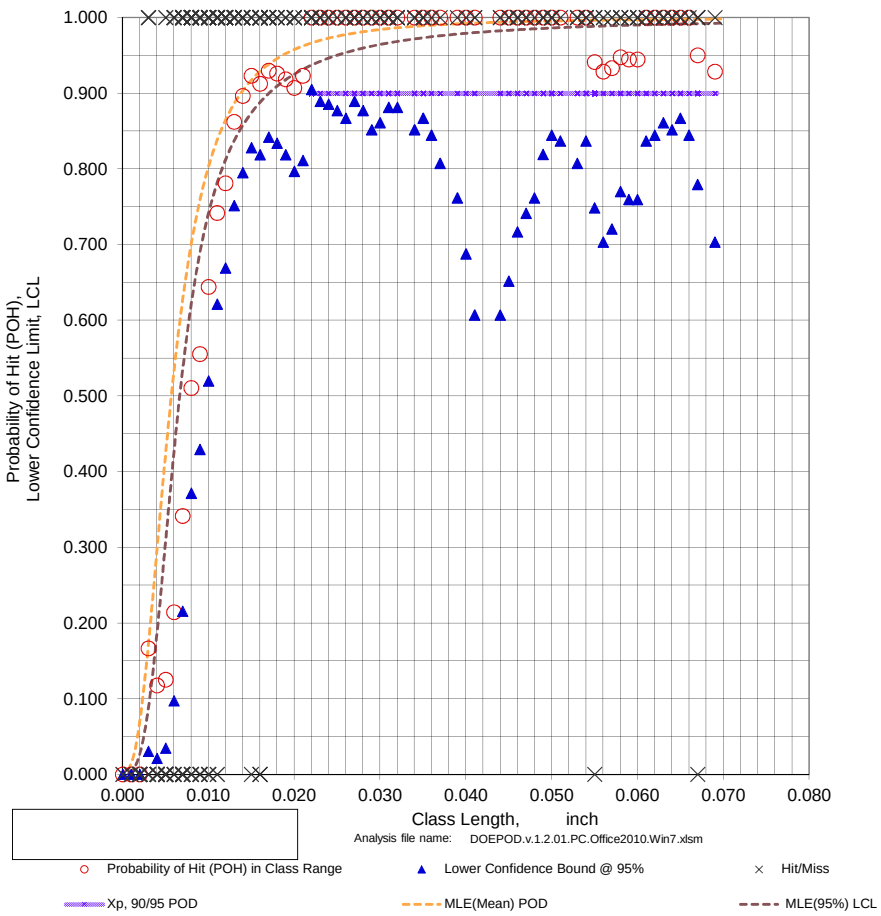
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 1 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE072(6)D.xls**

Data Set Name = **CE072(6)D(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:27 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0050 | inch |
| Classlength @ 90/95 Xpod = | 0.0220 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.917 | @ | 0.015 | inch |
| NTIAC 90/95 POD = | 0.925 | @ | 0.020 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.069 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.035 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0220 | inch |

File Name = CE072(6)D.xls
Data Set Name = CE072(6)D(CRK NO. )

## Directed DOE Options

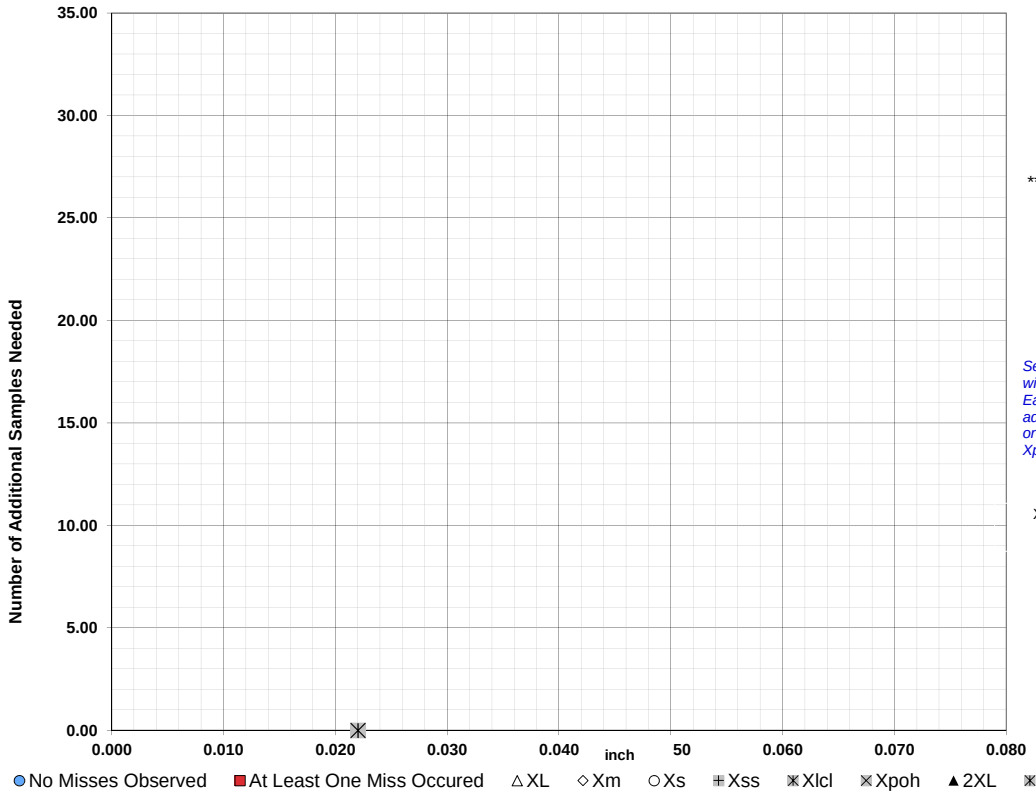



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.069 |
| Xm = | 0.035 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

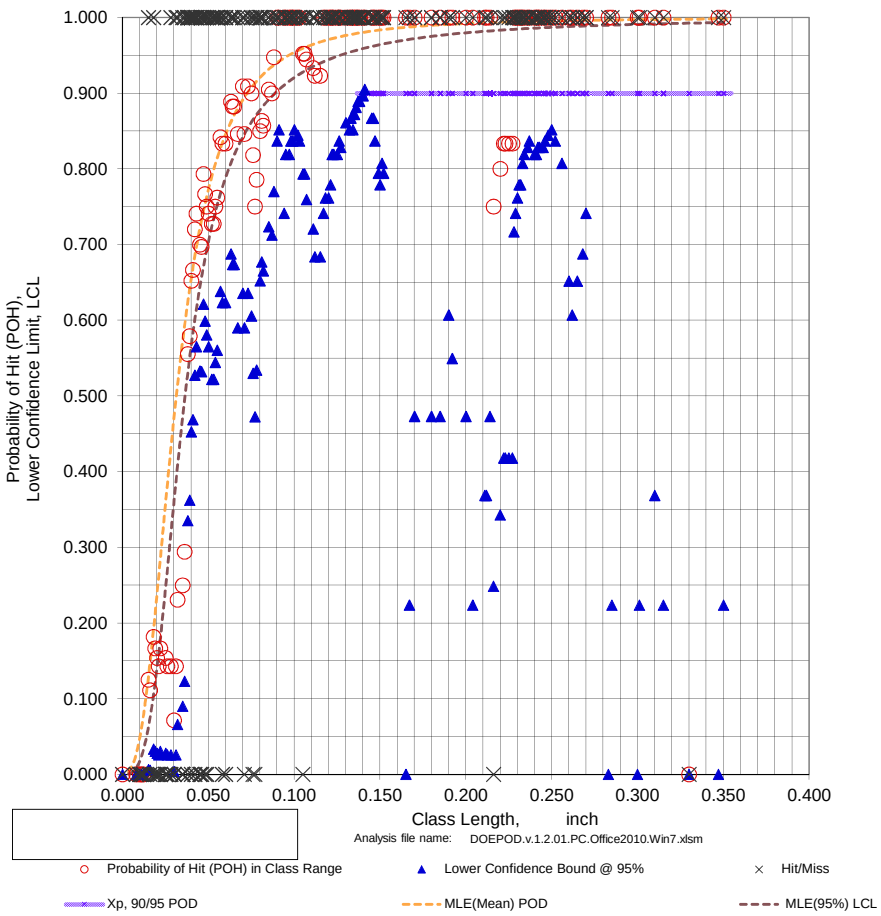
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.423.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **CE072(6)L.xls**

Data Set Name = **CE072(6)L(CRK NO. )**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:29 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.1410 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.090 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.350 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.250 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1410 | inch |

File Name = CE072(6)L.xls
Data Set Name = CE072(6)L(CRK NO. )

## Directed DOE Options

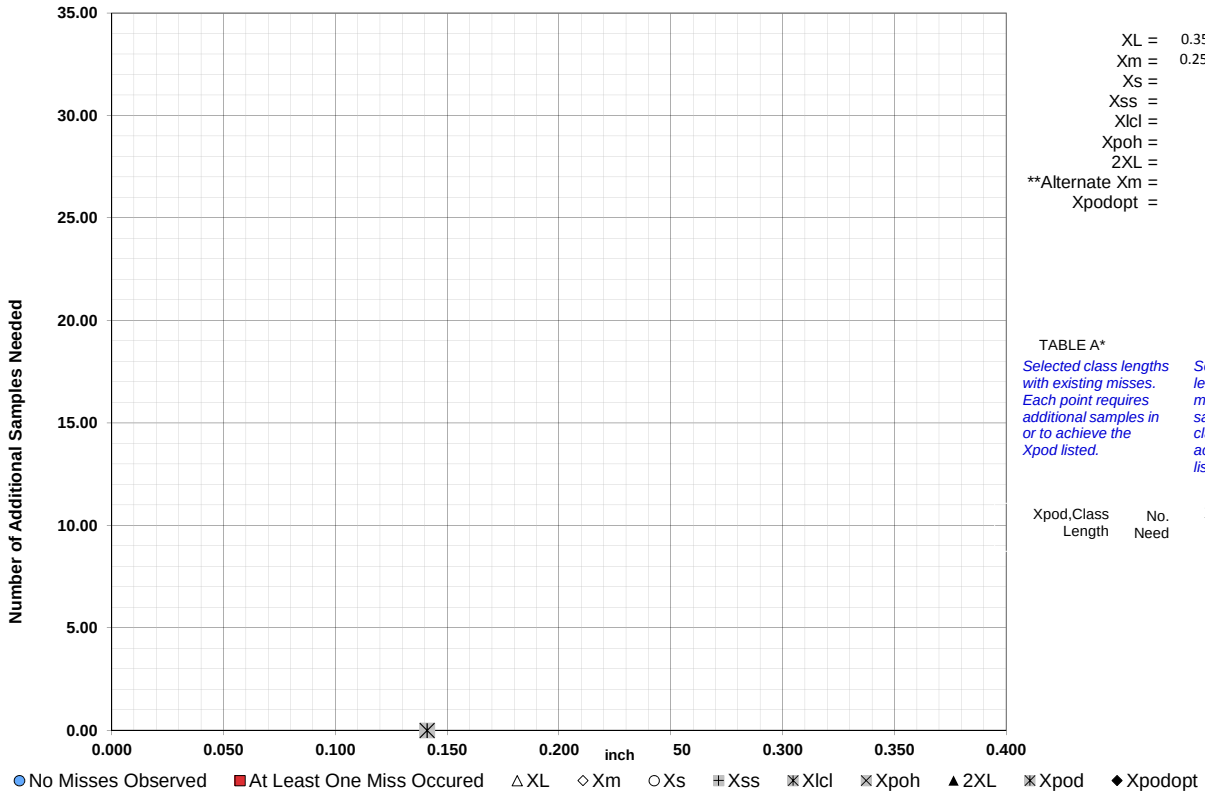



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.350 |
| Xm = | 0.250 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

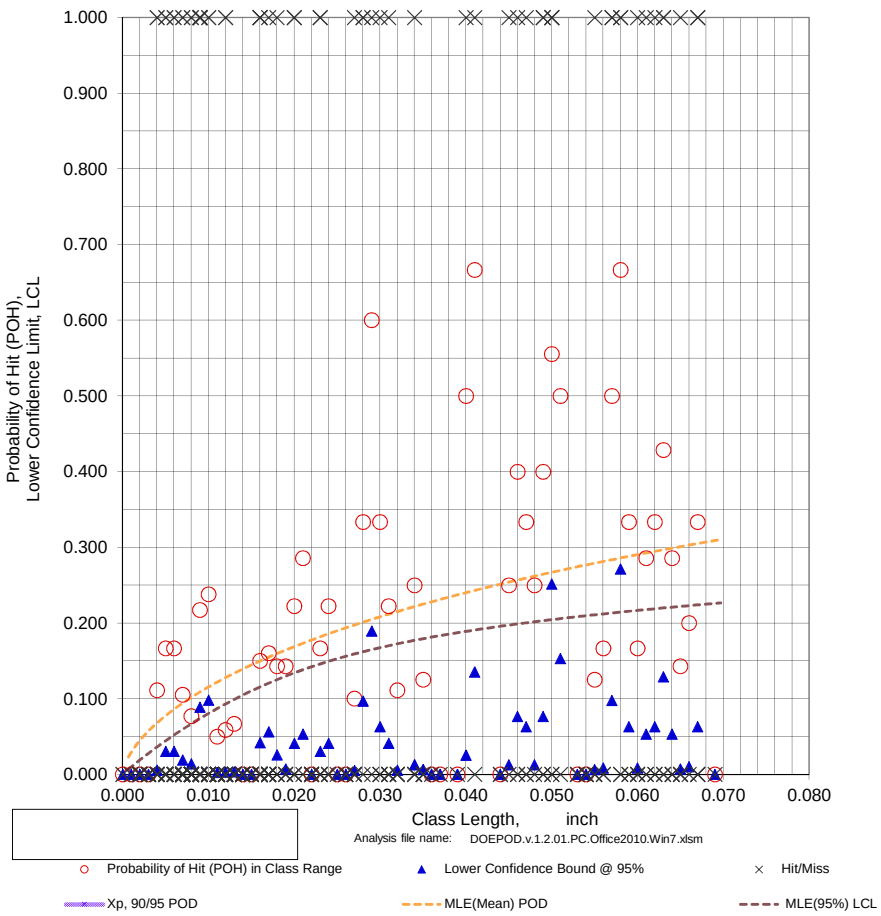
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = CE081(6)D.xls
Data Set Name = CE081(6)D(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:32 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2713 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0580 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.138 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE081(6)D.xls
Data Set Name = CE081(6)D(CRK #)

## Directed DOE Options

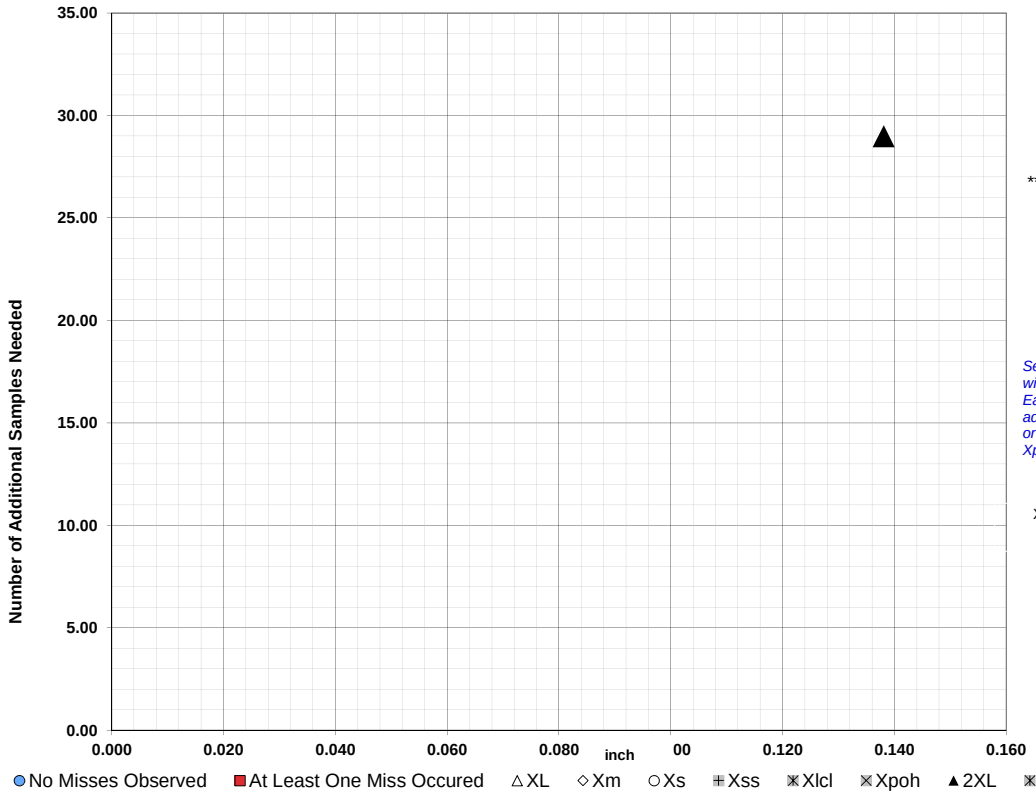



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.138 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

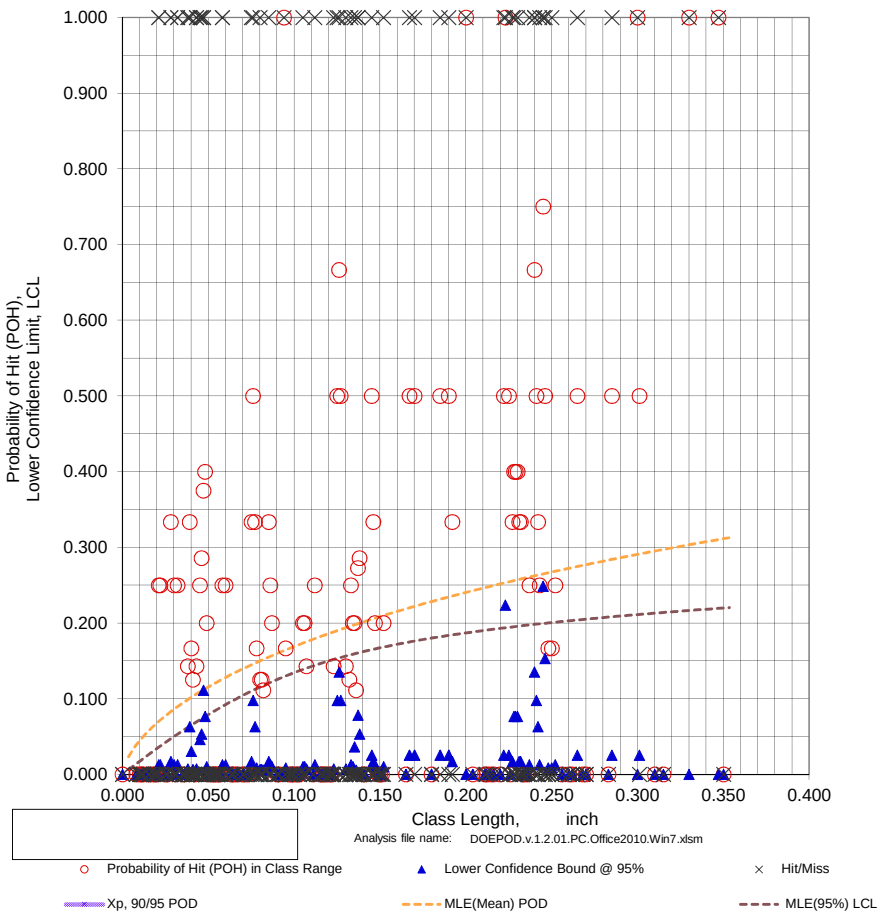
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = CE081(6)L.xls
Data Set Name = CE081(6)L(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:33 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2486 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.2450 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.700 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = CE081(6)L.xls
Data Set Name = CE081(6)L(CRK #)

## Directed DOE Options

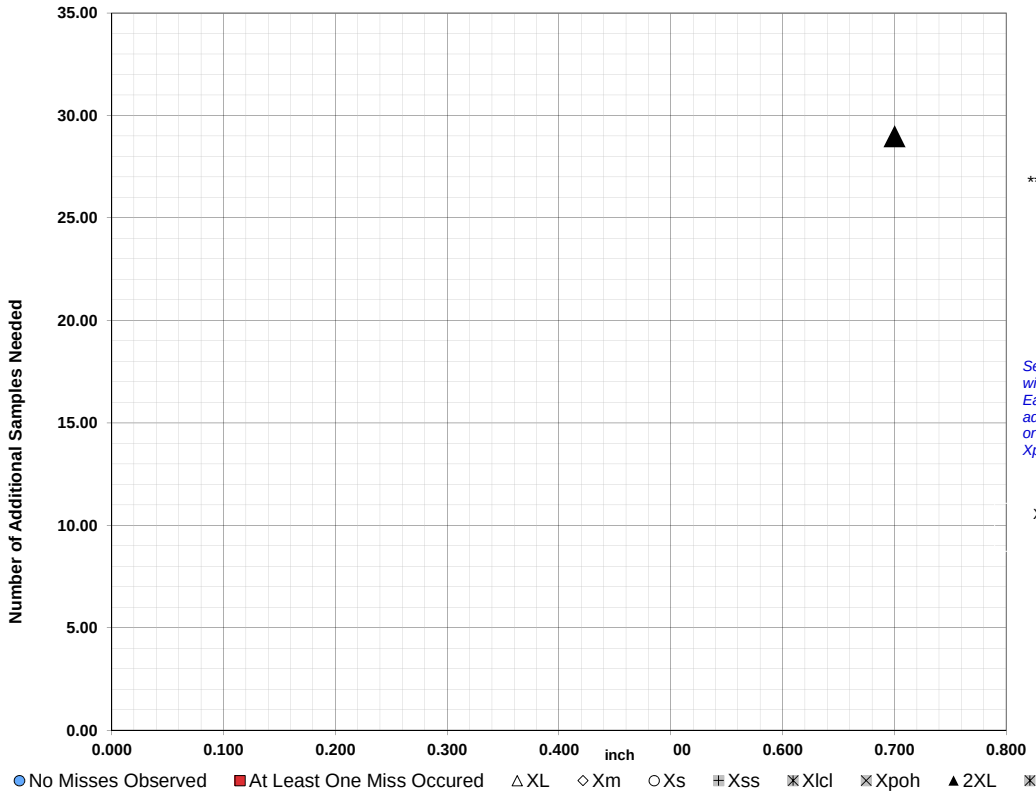



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.700 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

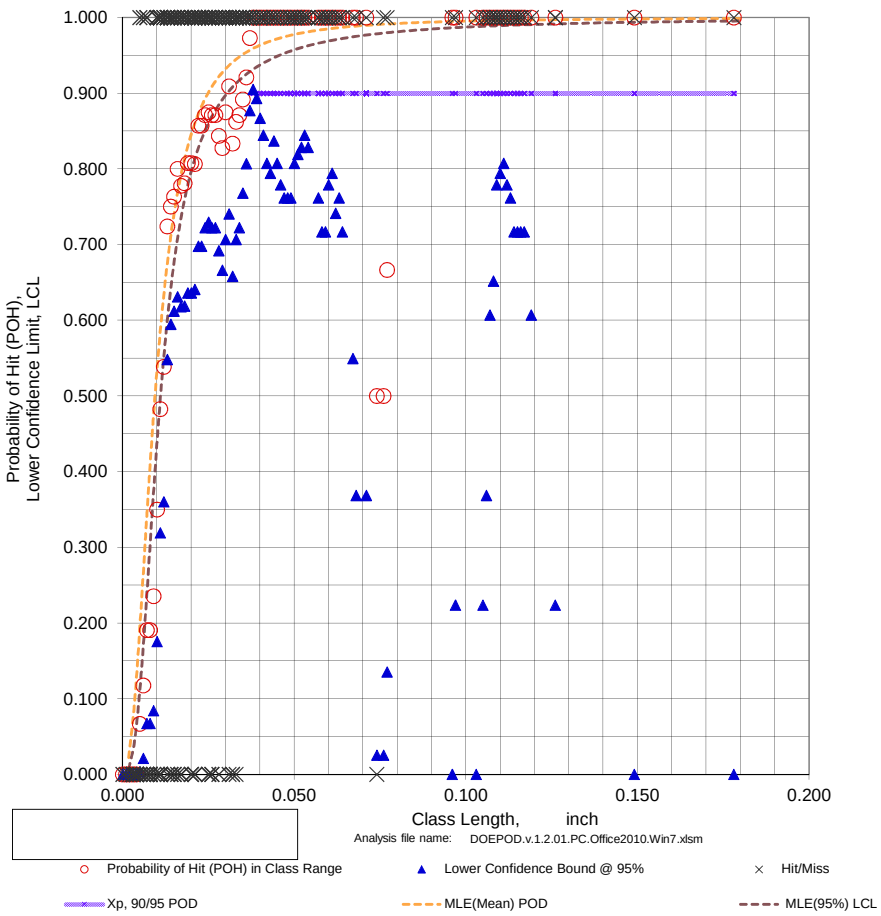
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1001AD.XLS**

Data Set Name = **D1001AD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:36 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0040 | inch |
| Classlength @ 90/95 Xpod = | 0.0380 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.921 | @ | 0.035 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.111 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0380 | inch |

File Name = D1001AD.XLS
Data Set Name = D1001AD(CRACK #)

## Directed DOE Options

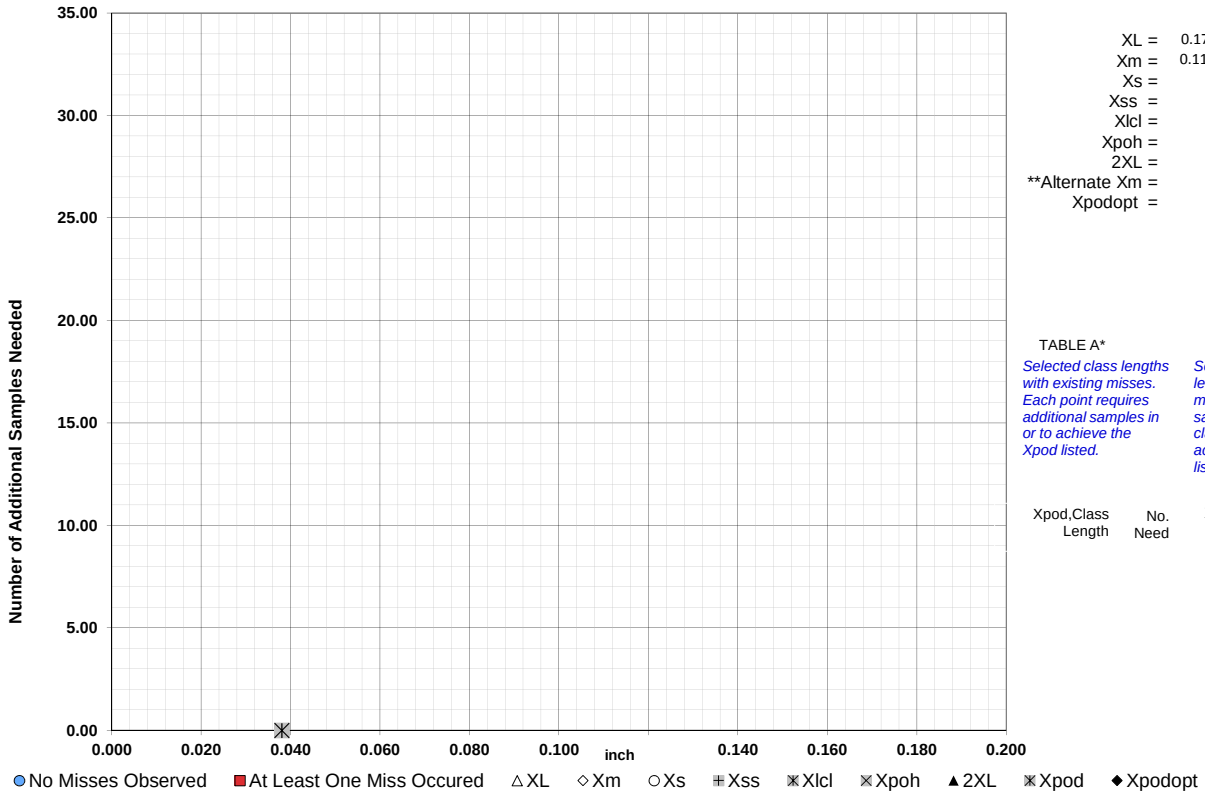



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.178 |
| Xm = | 0.111 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

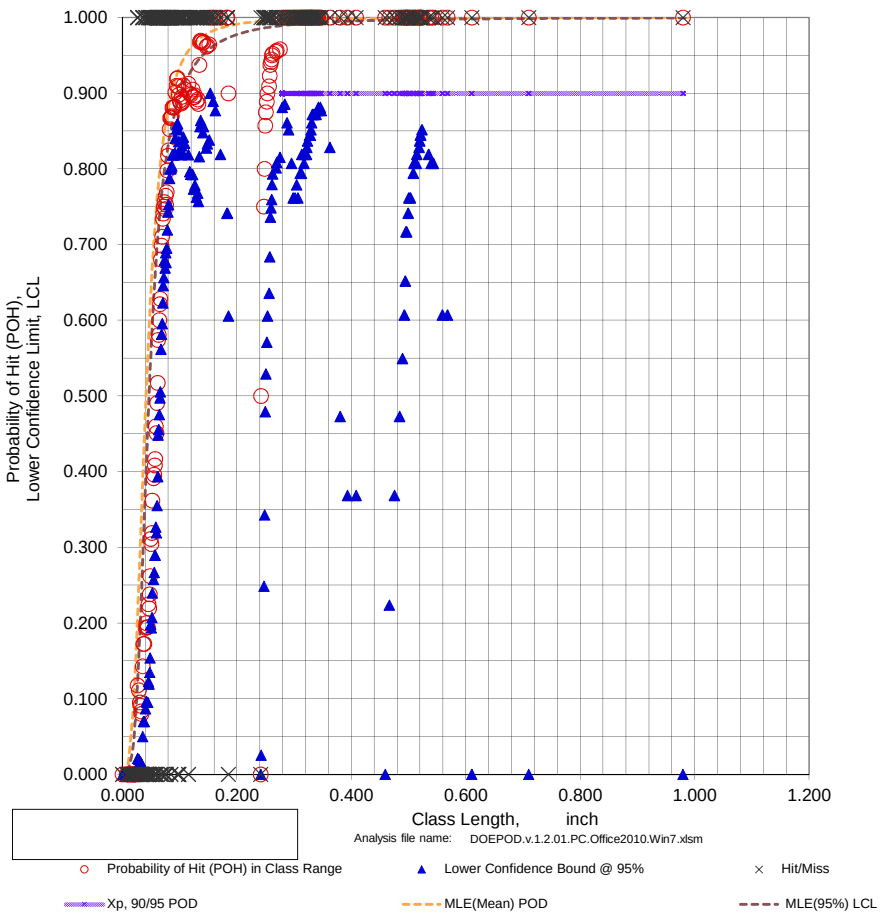
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1001AL.XLS**

Data Set Name = **D1001AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:38 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0360 | inch |
| Classlength @ 90/95 Xpod = | 0.1530 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.913 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.523 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2790 | inch |

File Name = D1001AL.XLS
Data Set Name = D1001AL(CRACK #)

## Directed DOE Options

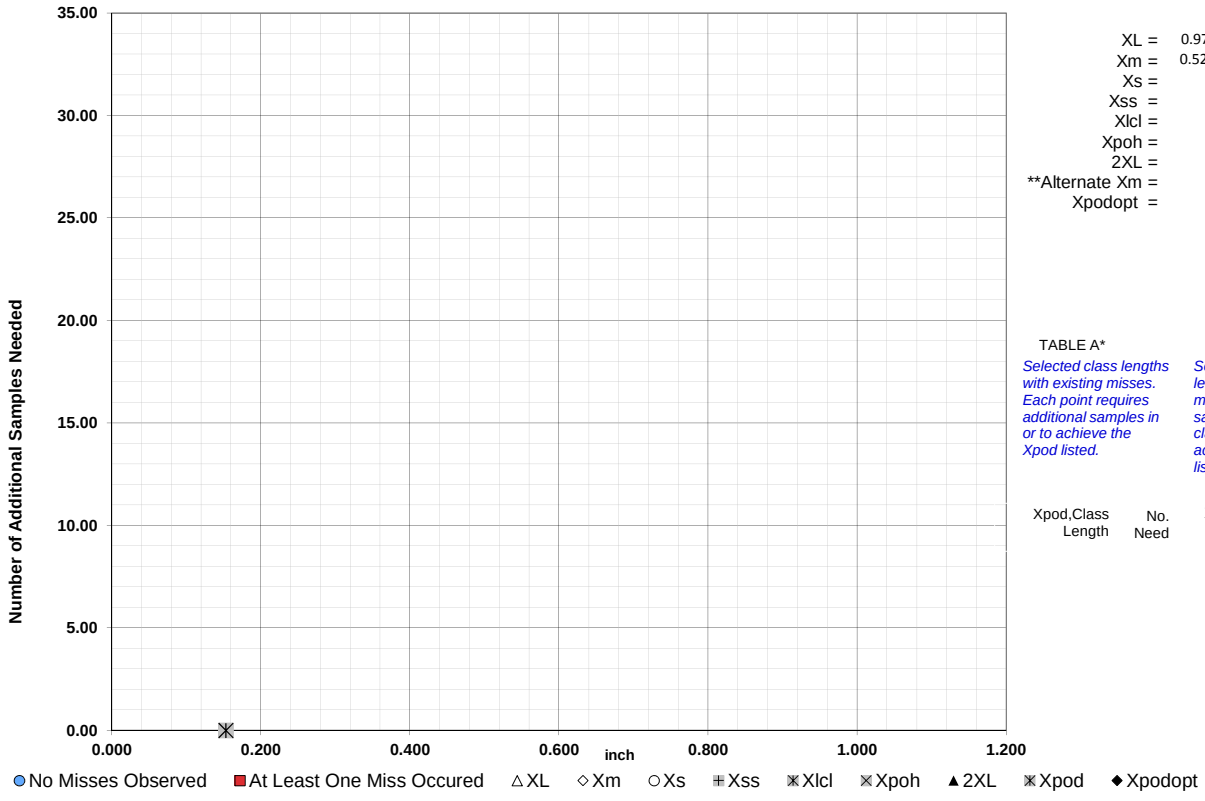



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.523 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

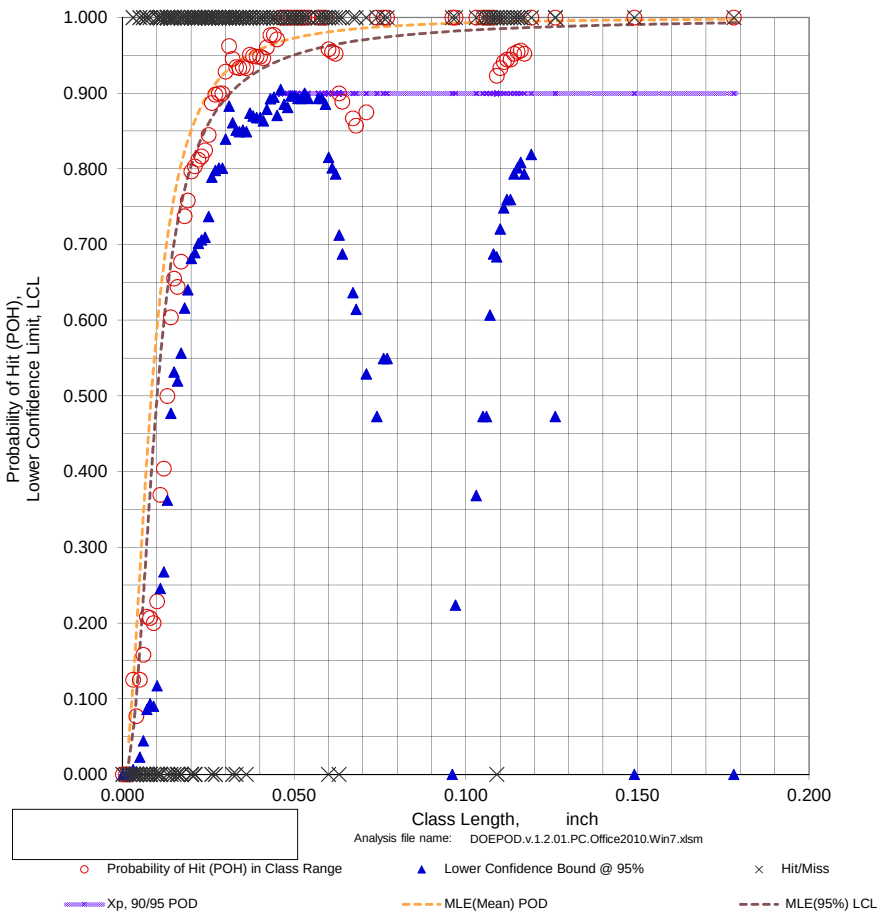
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1001BD.XLS**

Data Set Name = **D1001BD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:40 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0090 | inch |
| Classlength @ 90/95 Xpod = | 0.0460 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.928 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.915 | @ | 0.035 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0460 | inch |

File Name = D1001BD.XLS
Data Set Name = D1001BD(CRACK #)

## Directed DOE Options

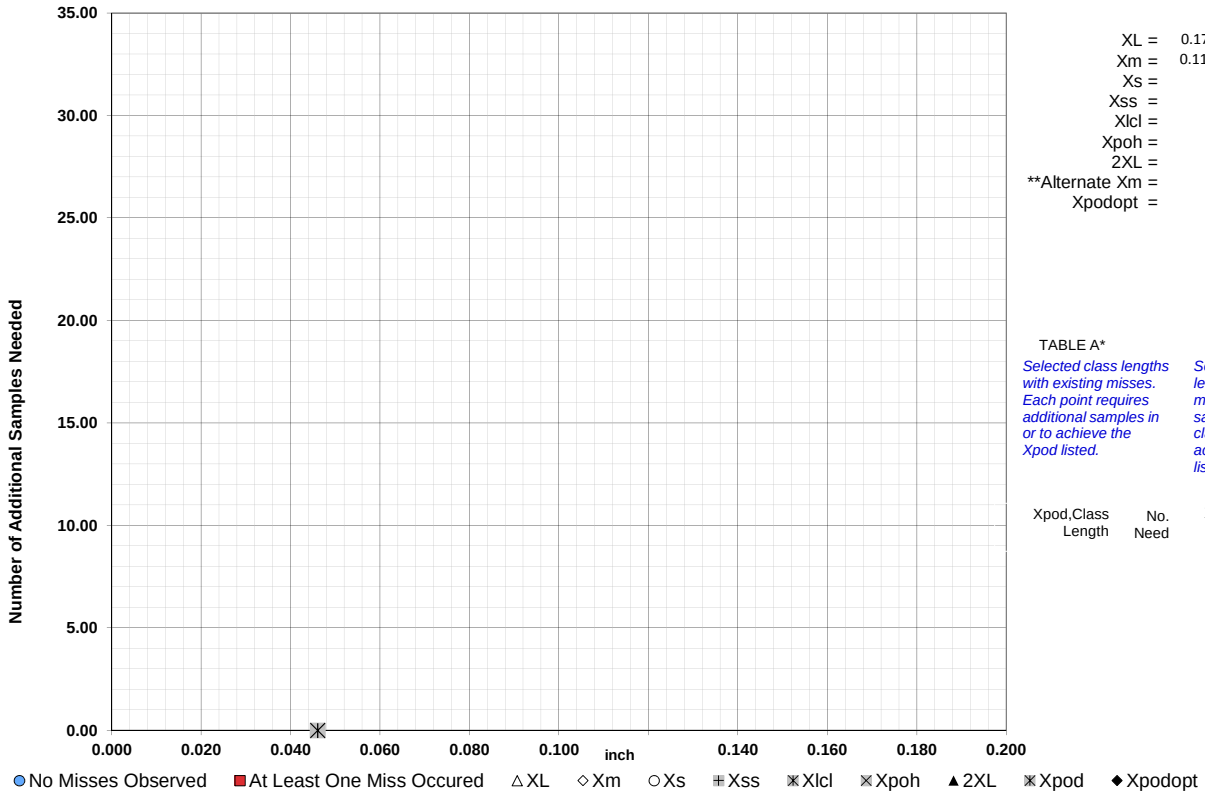



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.178 |
| Xm = | 0.119 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

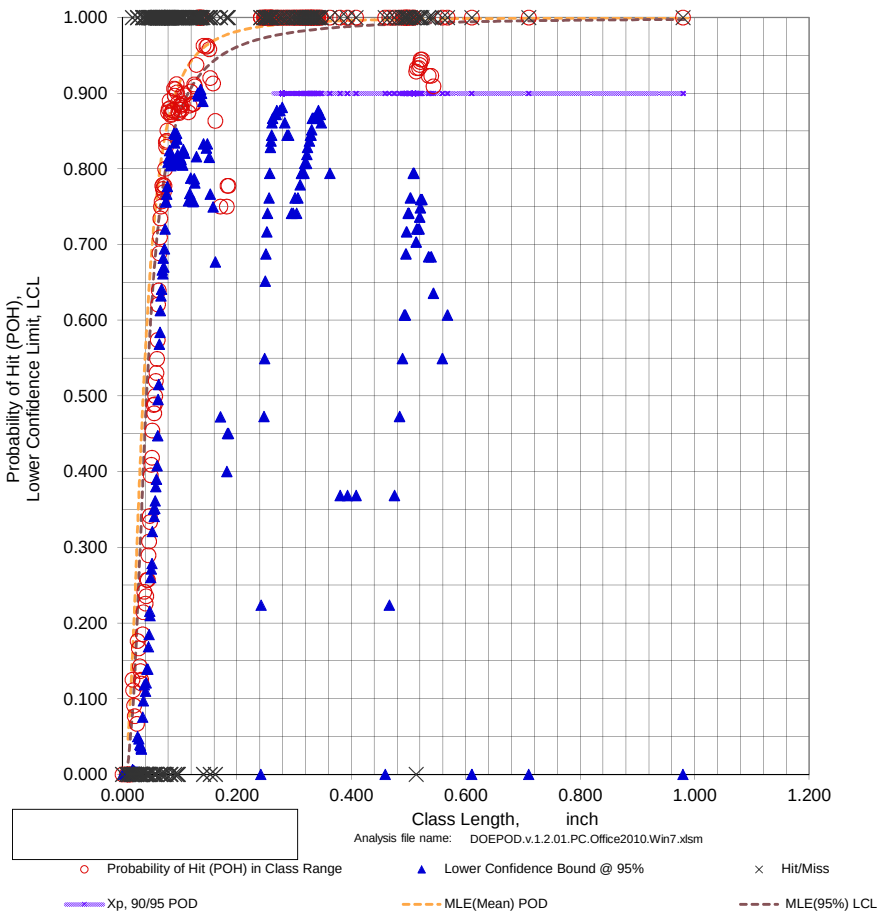
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1001BL.XLS**

Data Set Name = **D1001BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:42 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0330 | inch |
| Classlength @ 90/95 Xpod = | 0.1310 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.115 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.345 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2790 | inch |

File Name = D1001BL.XLS
Data Set Name = D1001BL(CRACK #)

## Directed DOE Options

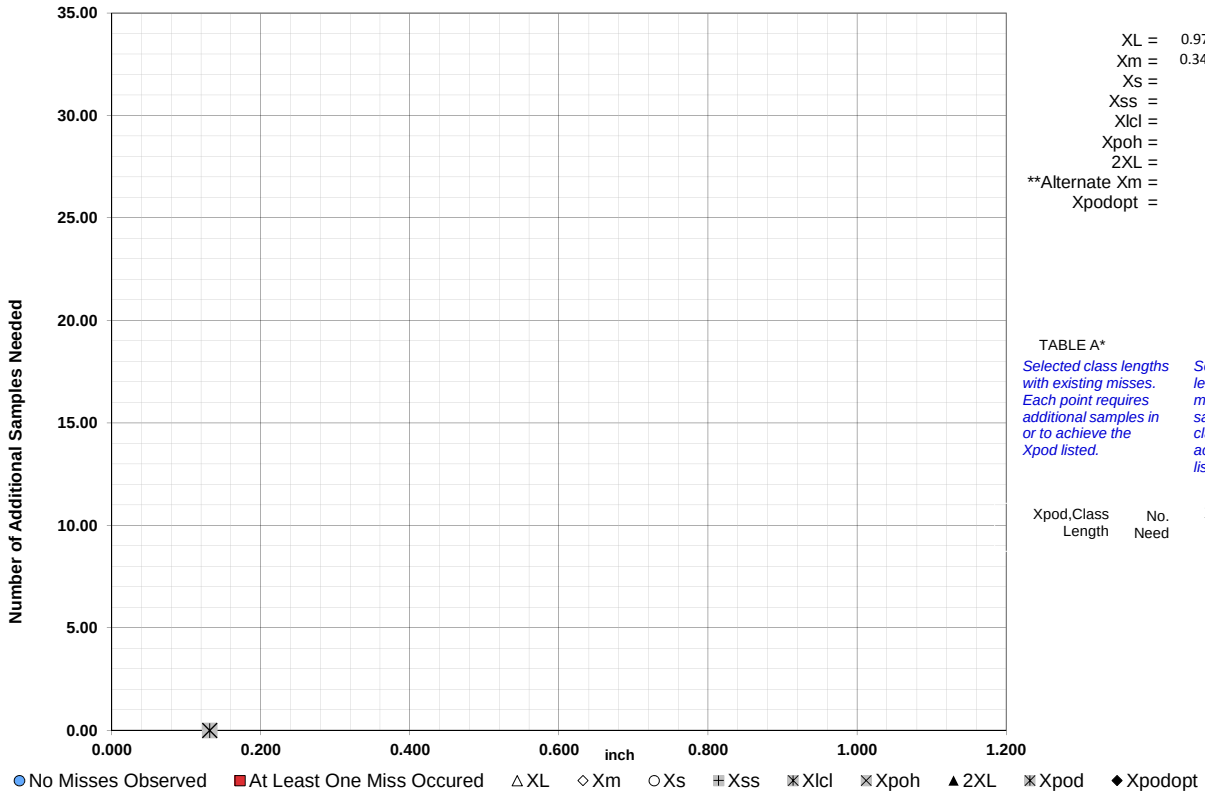



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.345 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

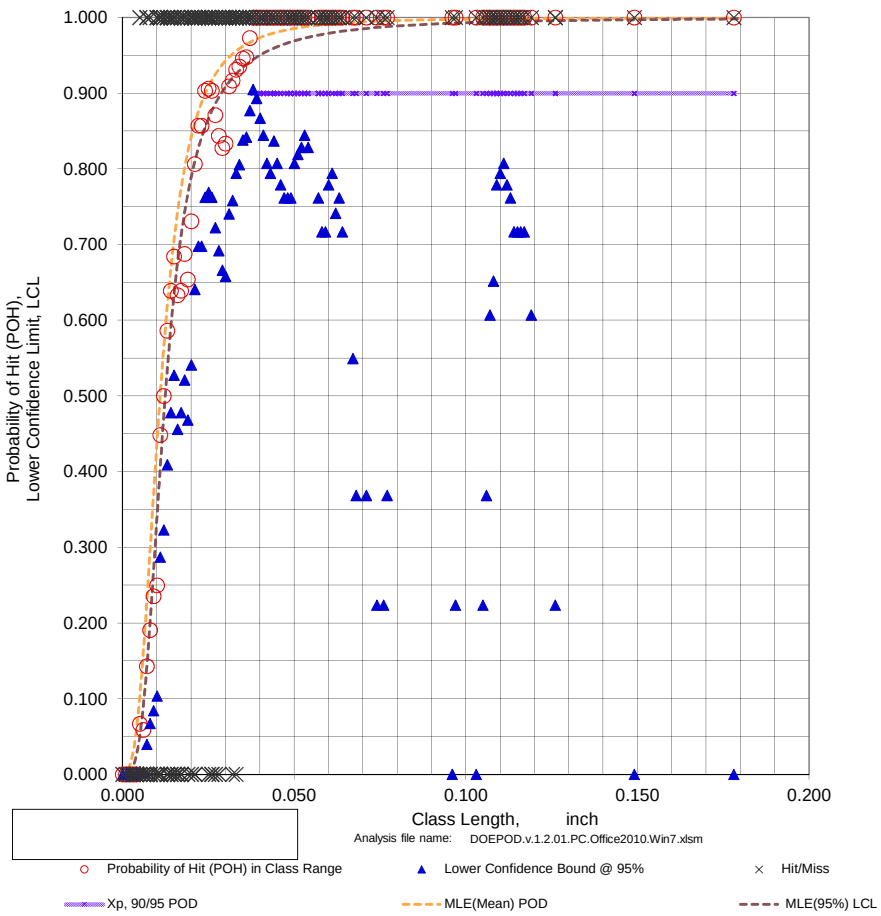
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D1001CD.XLS**
Data Set Name = **D1001CD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:44 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0040 | inch |
| Classlength @ 90/95 Xpod = | 0.0380 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0350 -0.001 inch 15 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.909 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.909 | @ | 0.030 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.111 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.038 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0380 | inch |

File Name = D1001CD.XLS
Data Set Name = D1001CD(CRACK #)

## Directed DOE Options

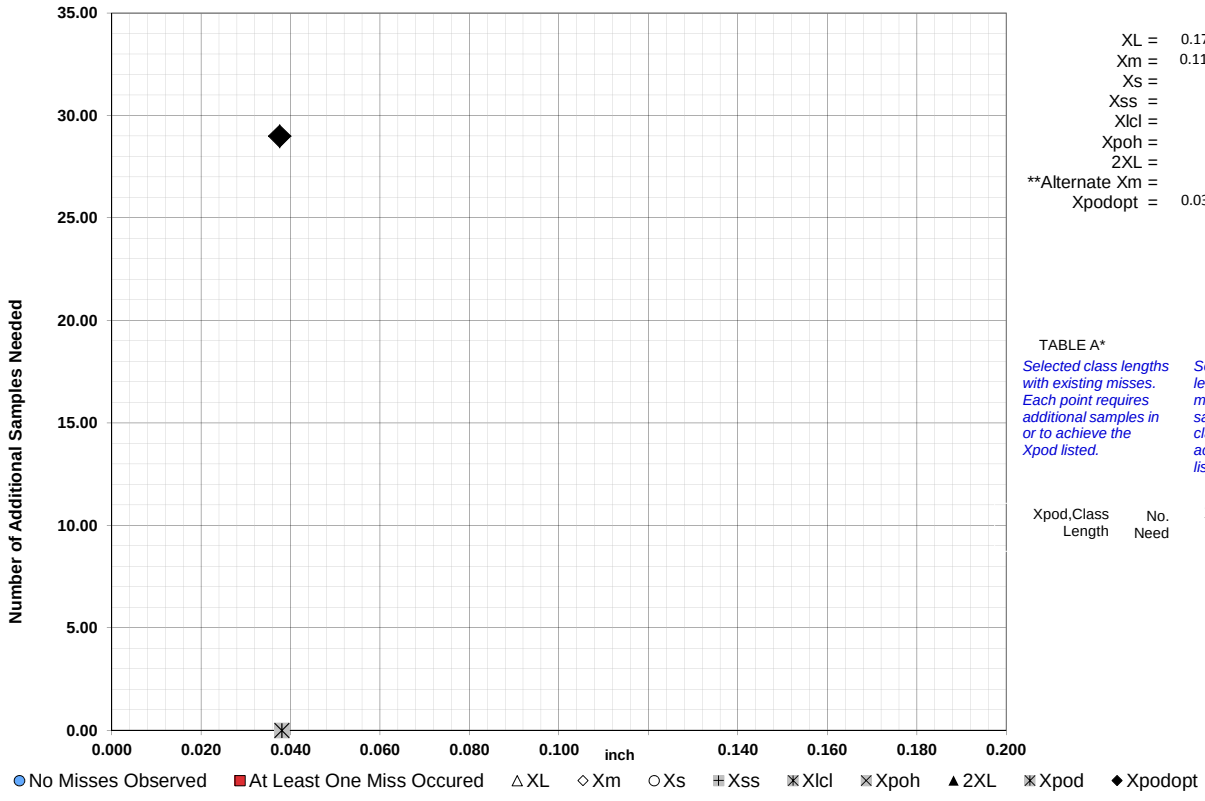



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | |
| Xm = | 0.111 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.038 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

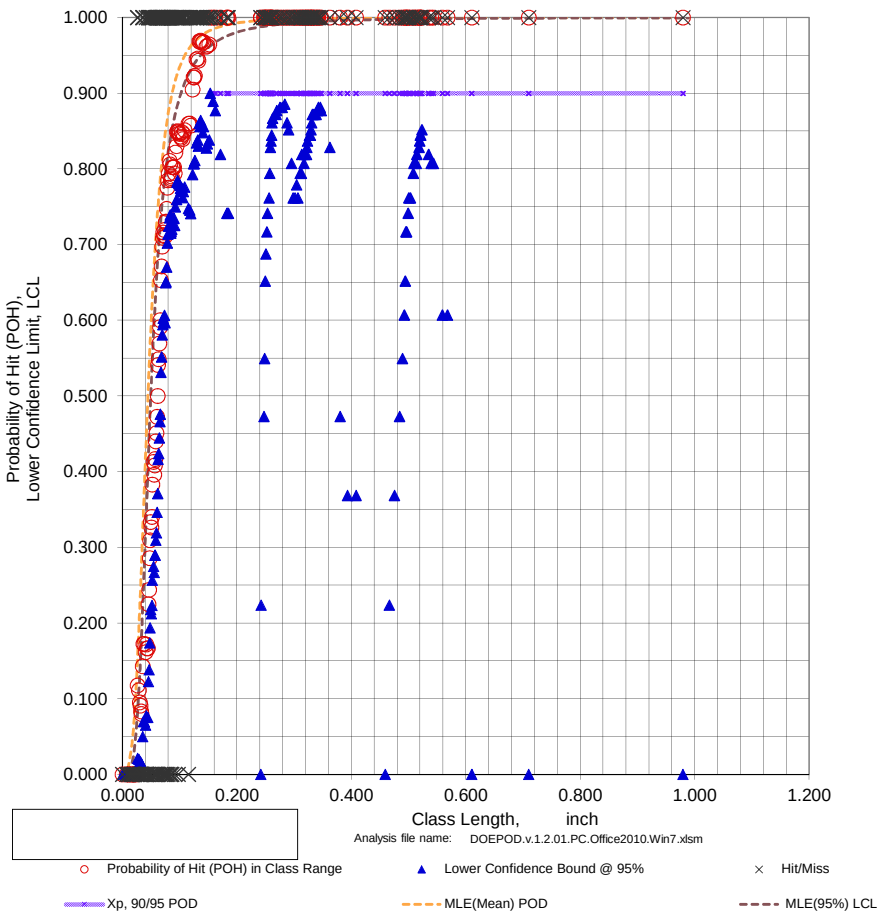
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 10 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D1001CL.XLS**

Data Set Name = **D1001CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:45 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0360 | inch |
| Classlength @ 90/95 Xpod = | 0.1530 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1170 -0.001 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.911 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.523 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.152 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1530 | inch |

File Name = D1001CL.XLS
Data Set Name = D1001CL(CRACK #)

## Directed DOE Options

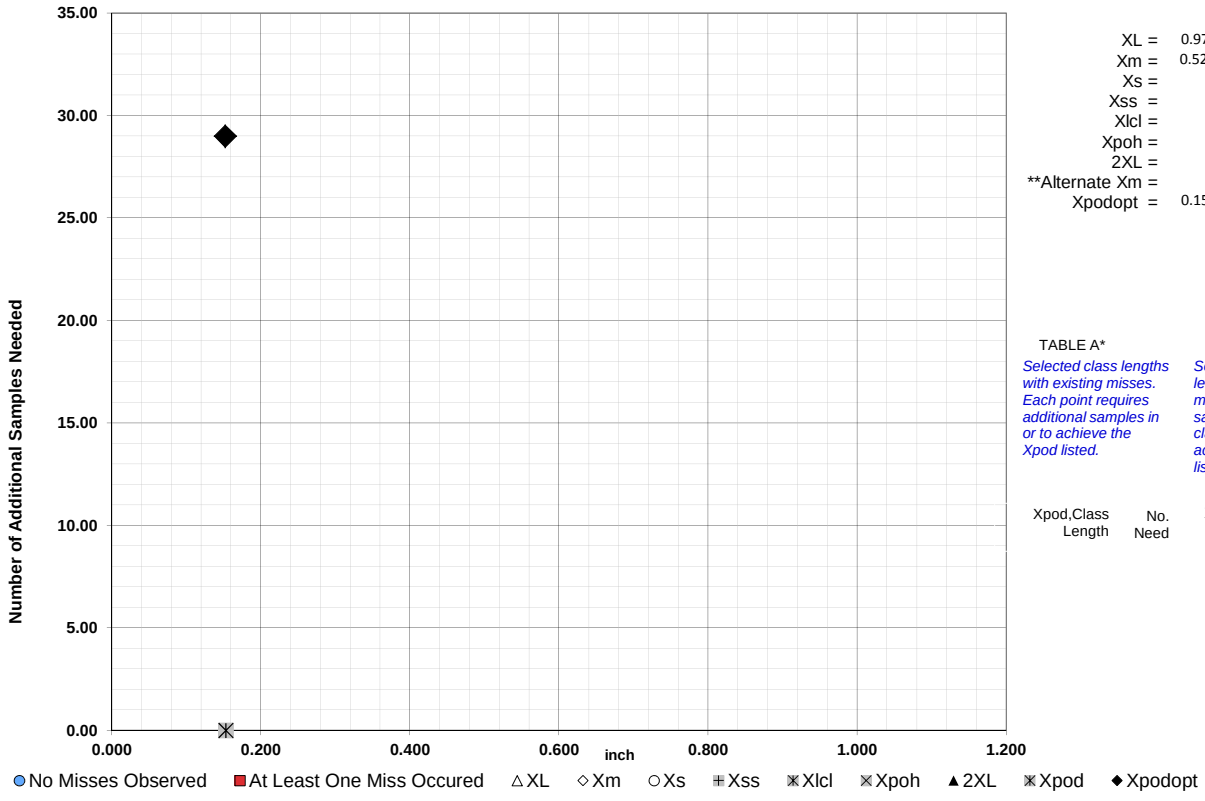



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | |
| Xm = | 0.523 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.152 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

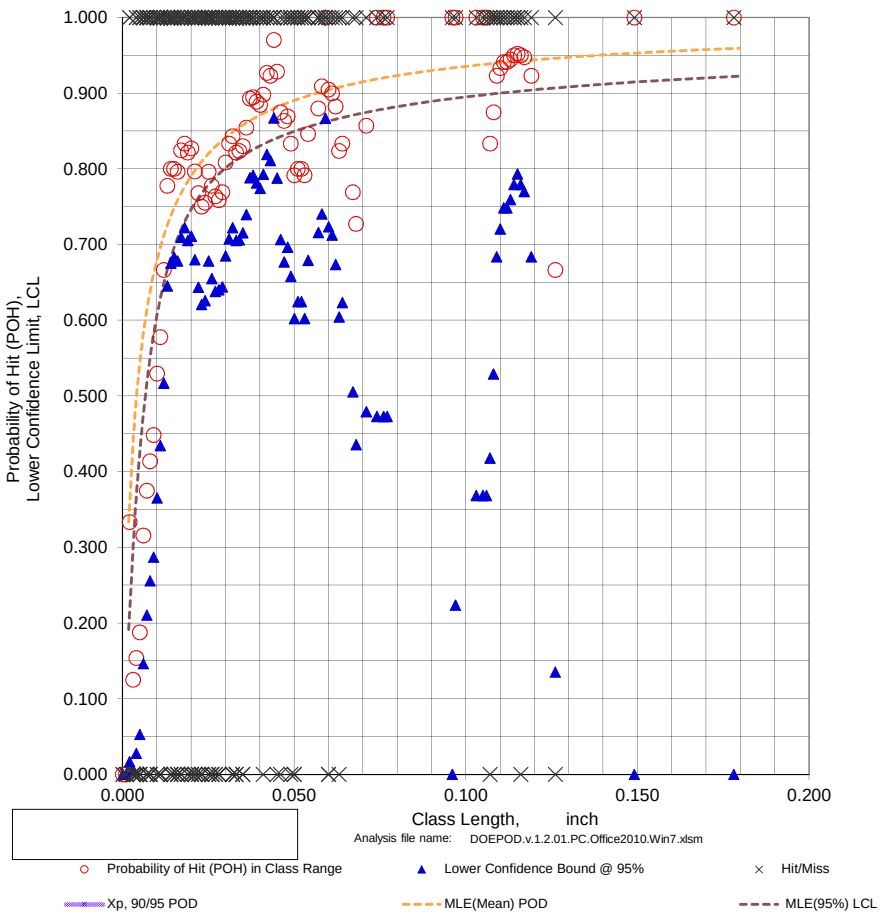
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D1002AD.XLS
Data Set Name = D1002AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:48 PM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8673 | |
| Classwidth @ Best LCL = | 0.0080 | inch |
| Classlength @ Best LCL = | 0.0440 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1490 -0.022 inch 28 Samples

NTIAC 90% POD = 0.904 @ 0.060 inch
NTIAC 90/95 POD = 0.900 @ 0.110 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.149 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D1002AD.XLS
Data Set Name = D1002AD(CRACK #)

## Directed DOE Options

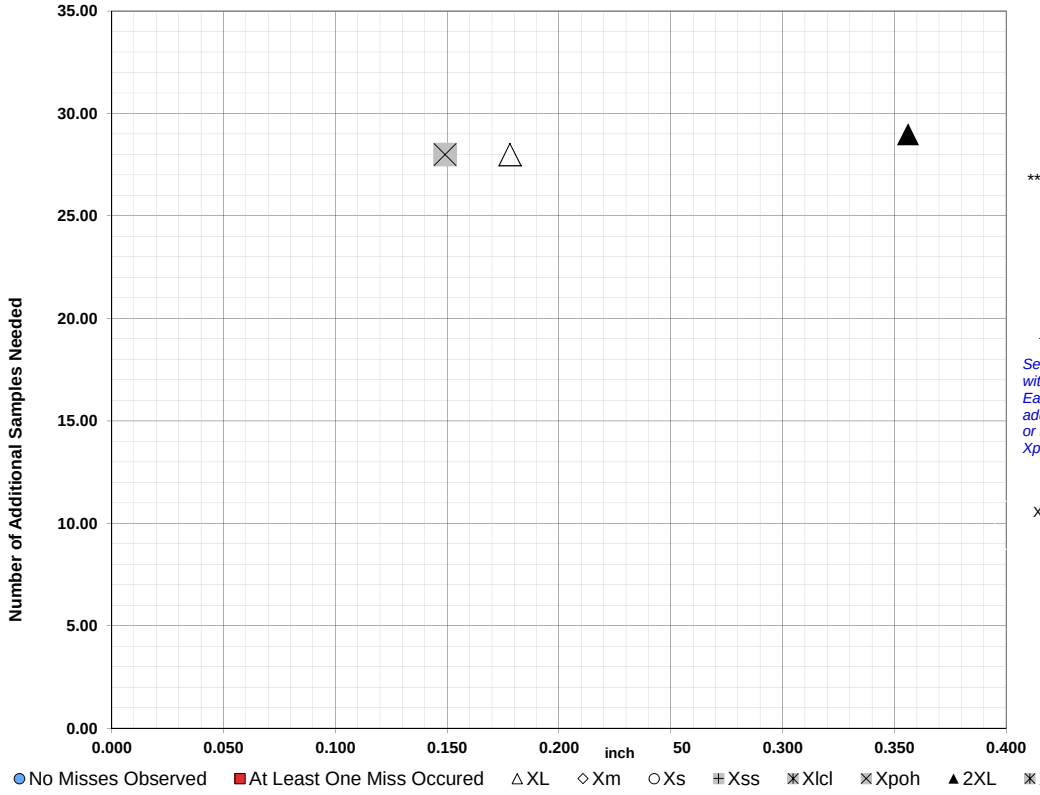



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.149 | 28 |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

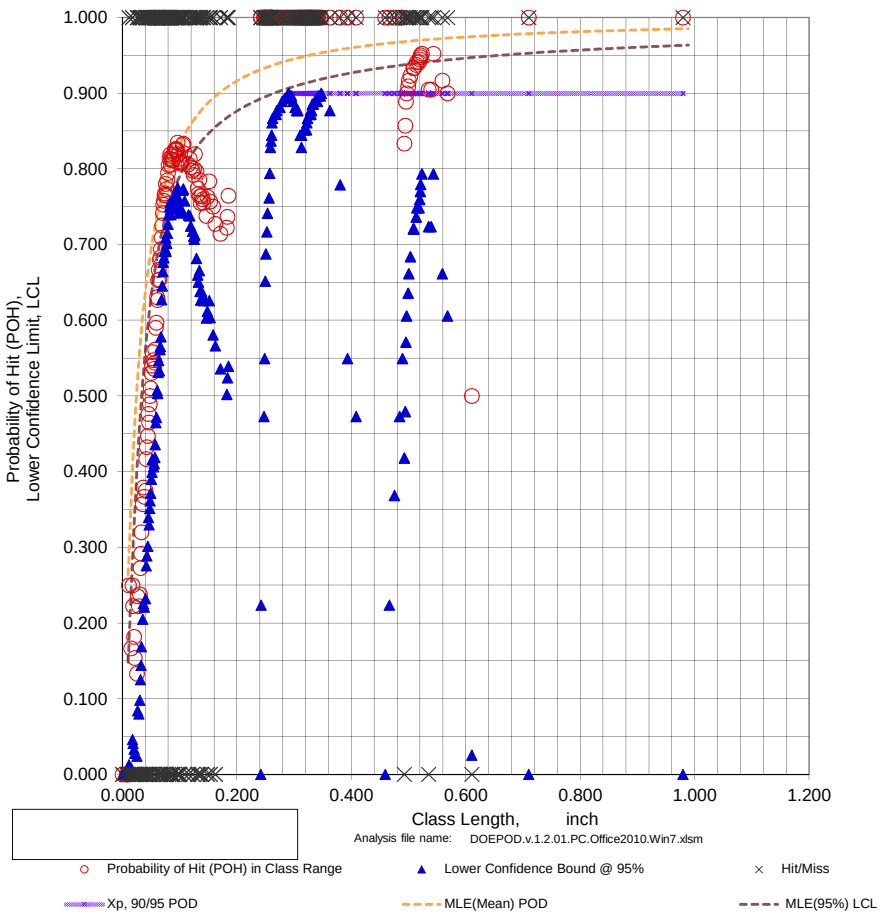
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 13 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1002AL.XLS**

Data Set Name = **D1002AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:49 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0490 | inch |
| Classlength @ 90/95 Xpod = | 0.2900 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.170 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.265 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.489 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2900 | inch |

File Name = D1002AL.XLS
Data Set Name = D1002AL(CRACK #)

## Directed DOE Options

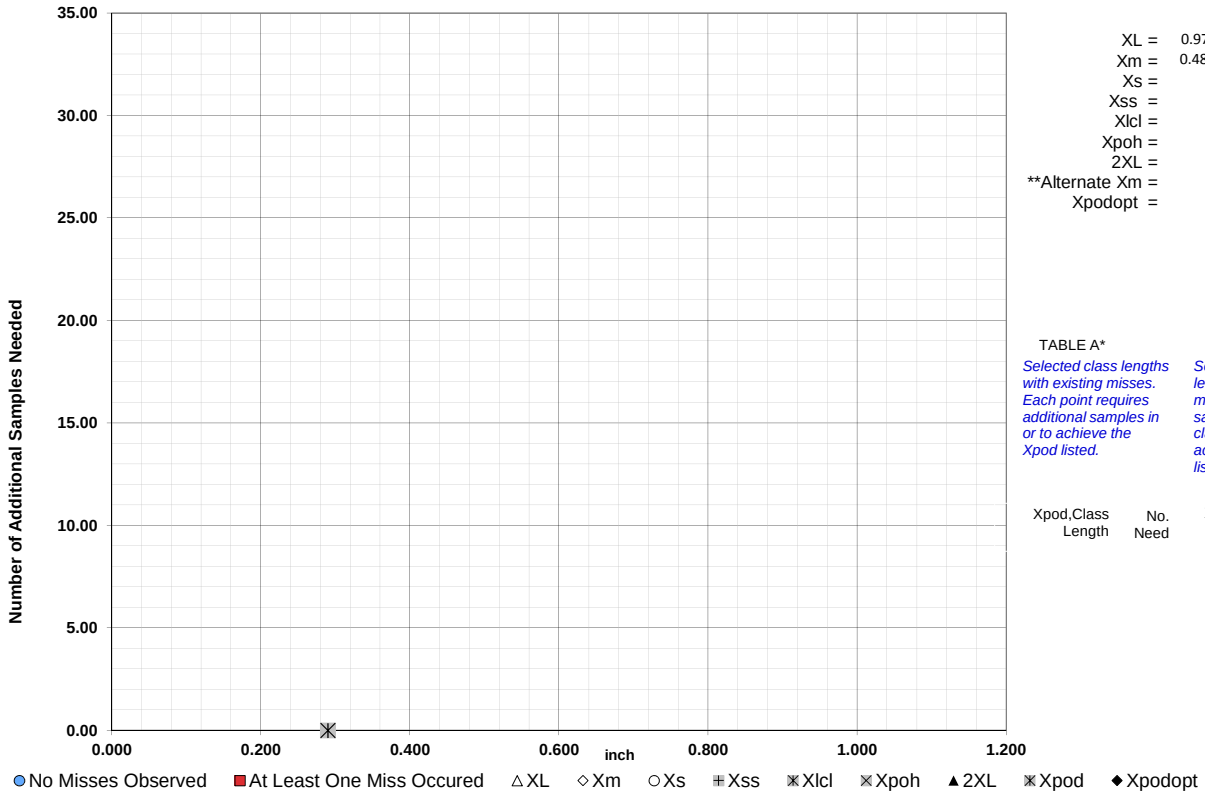



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.489 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

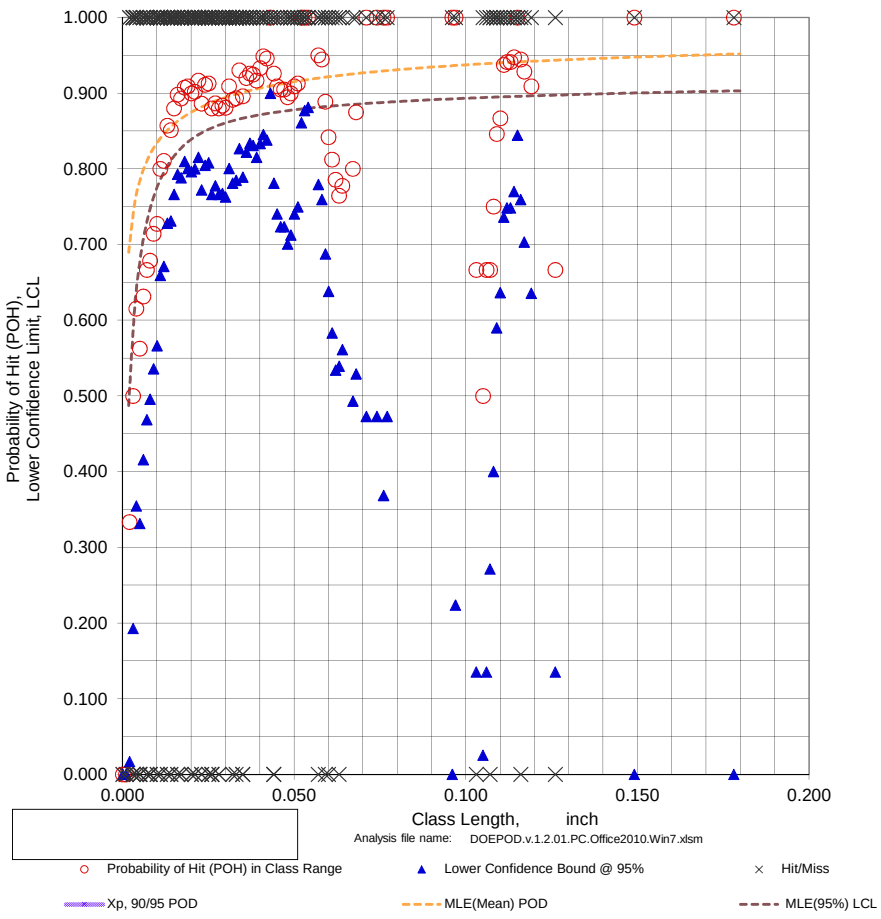
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Warning: No false call analysis.**




File Name = **D1002BD.XLS**

Data Set Name = **D1002BD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:51 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0070 | inch |
| Classlength @ 90/95 Xpod = | 0.0430 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.020 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.055 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | 0.115 | inch |
| Samples Needed @ Xm = | 11 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D1002BD.XLS
Data Set Name = D1002BD(CRACK #)

## Directed DOE Options

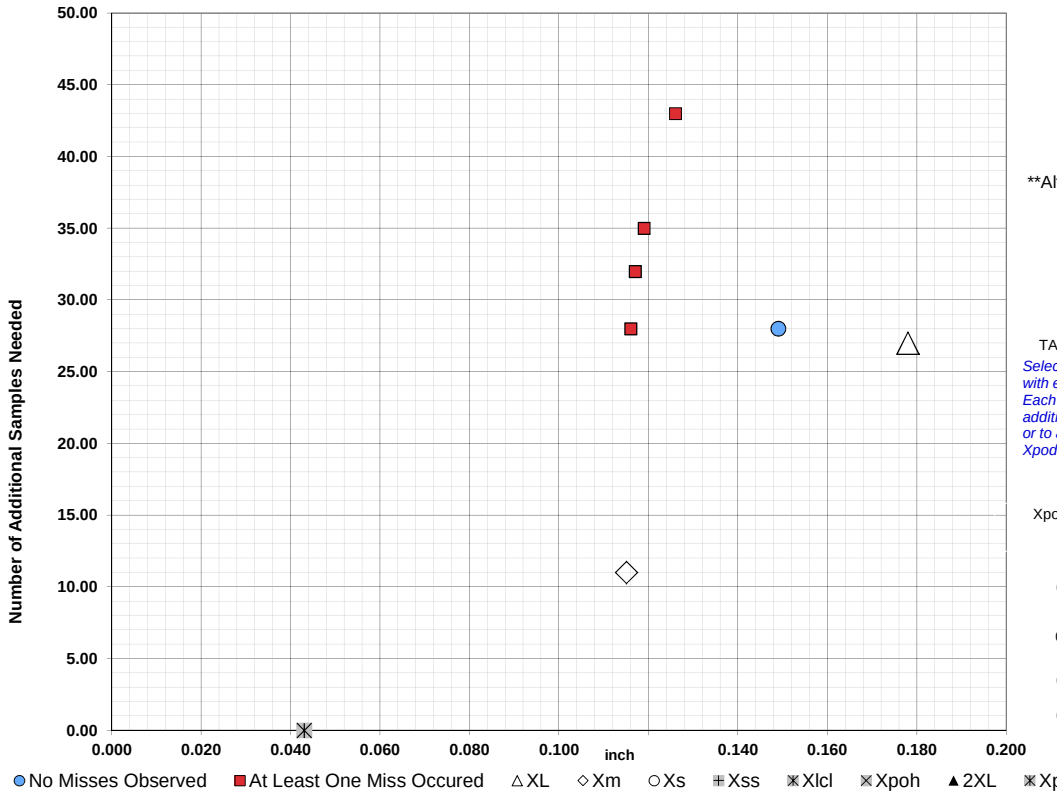



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 27 |
| Xm = | 0.115 | 11 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1260 | 43 |
| 0.1190 | 35 |
| 0.1170 | 32 |
| 0.1160 | 28 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

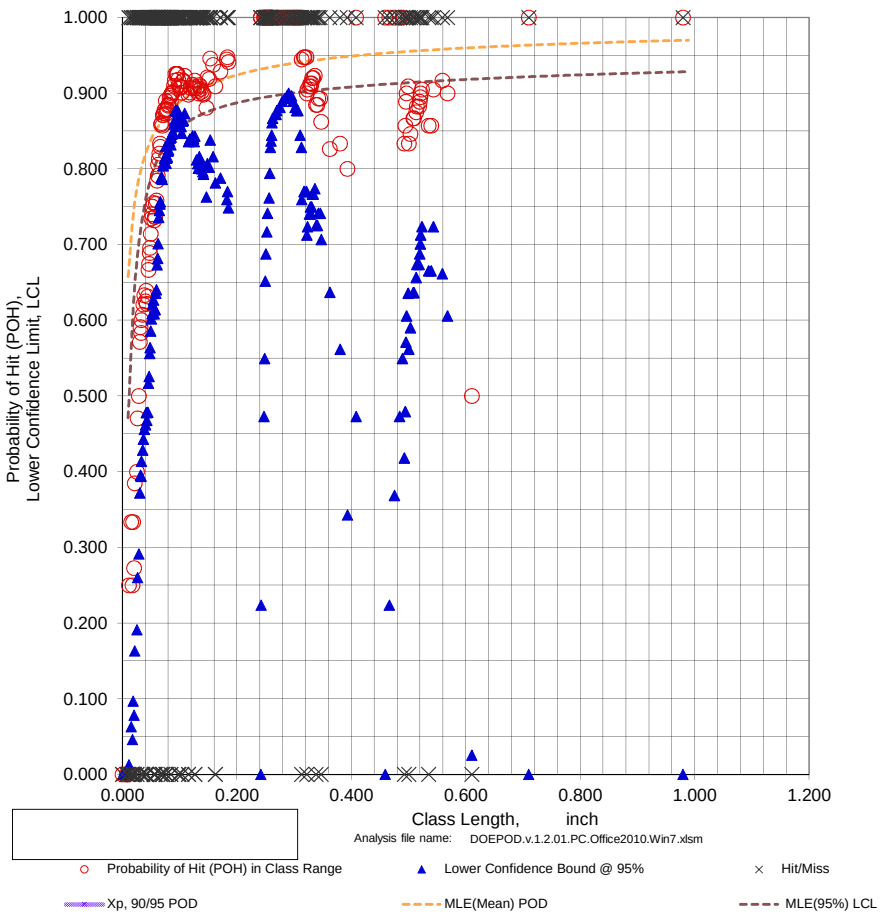
| Xpod,Class Length | No. Need |
|---|---|
| 0.1490 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 13 more large flaws.**

**Warning: No false call analysis.**




File Name = **D1002BL.XLS**

Data Set Name = **D1002BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:52 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0490 | inch |
| Classlength @ 90/95 Xpod = | 0.2900 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.125 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.295 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | 0.489 | inch |
| Samples Needed @ Xm = | 24 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D1002BL.XLS
Data Set Name = D1002BL(CRACK #)

## Directed DOE Options

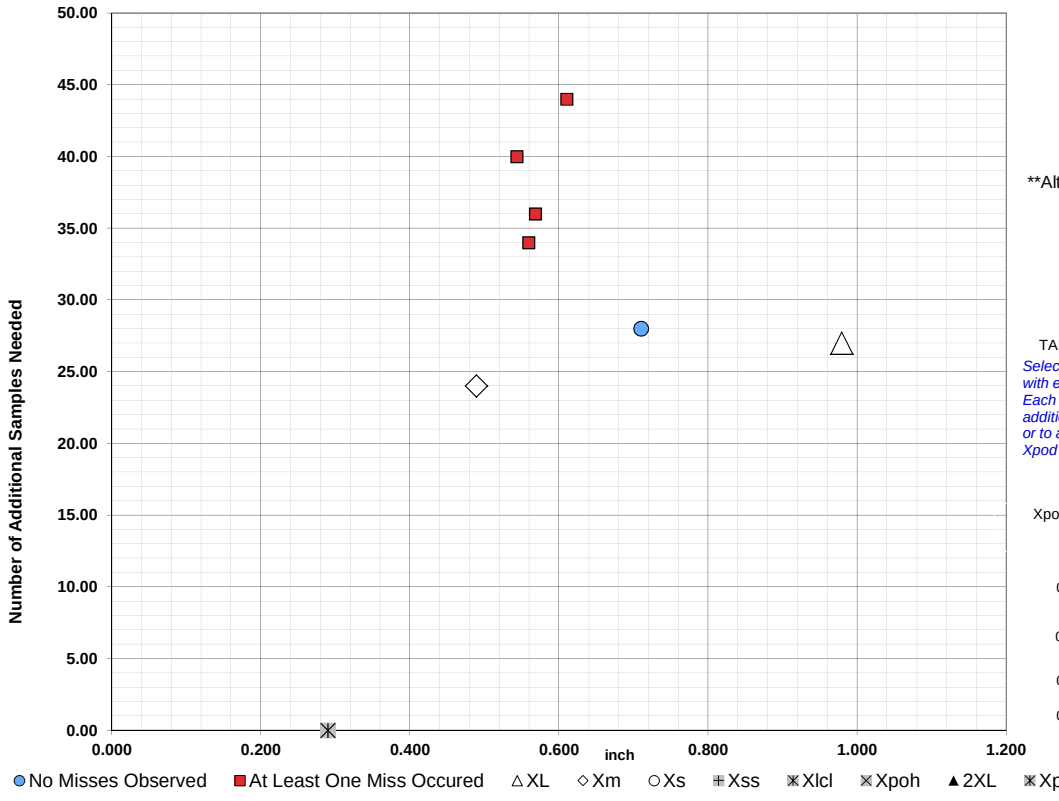



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 27 |
| Xm = | 0.489 | 24 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.6100 | 44 |
| 0.5680 | 36 |
| 0.5590 | 34 |
| 0.5430 | 40 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.7100 | 28 |

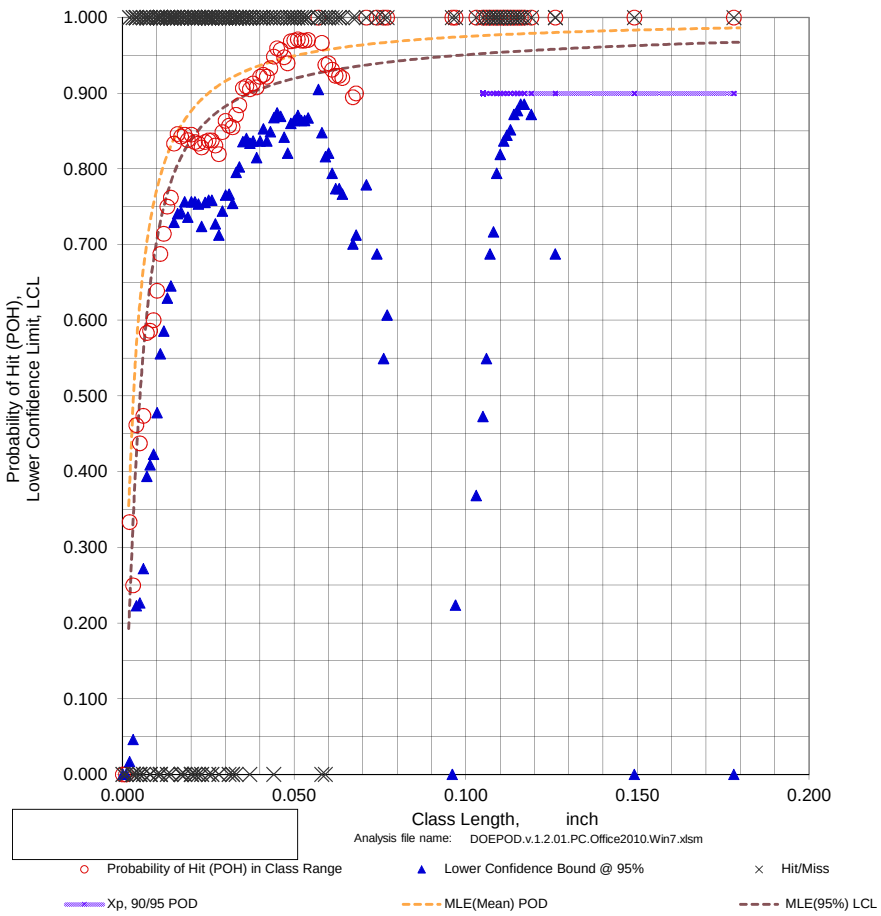
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 13 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1002CD.XLS**

Data Set Name = **D1002CD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:54 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.0570 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.040 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.117 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1050 | inch |

File Name = D1002CD.XLS
Data Set Name = D1002CD(CRACK #)

## Directed DOE Options

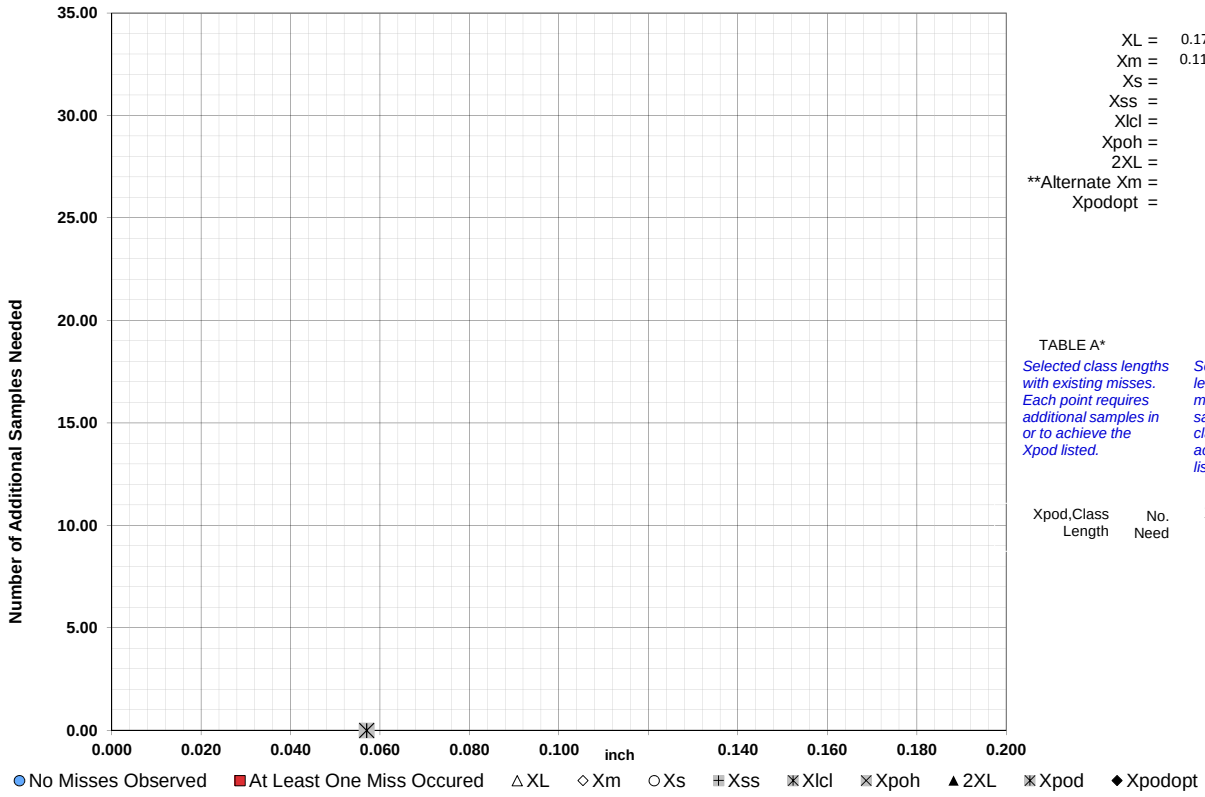



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.178 |
| Xm = | 0.117 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

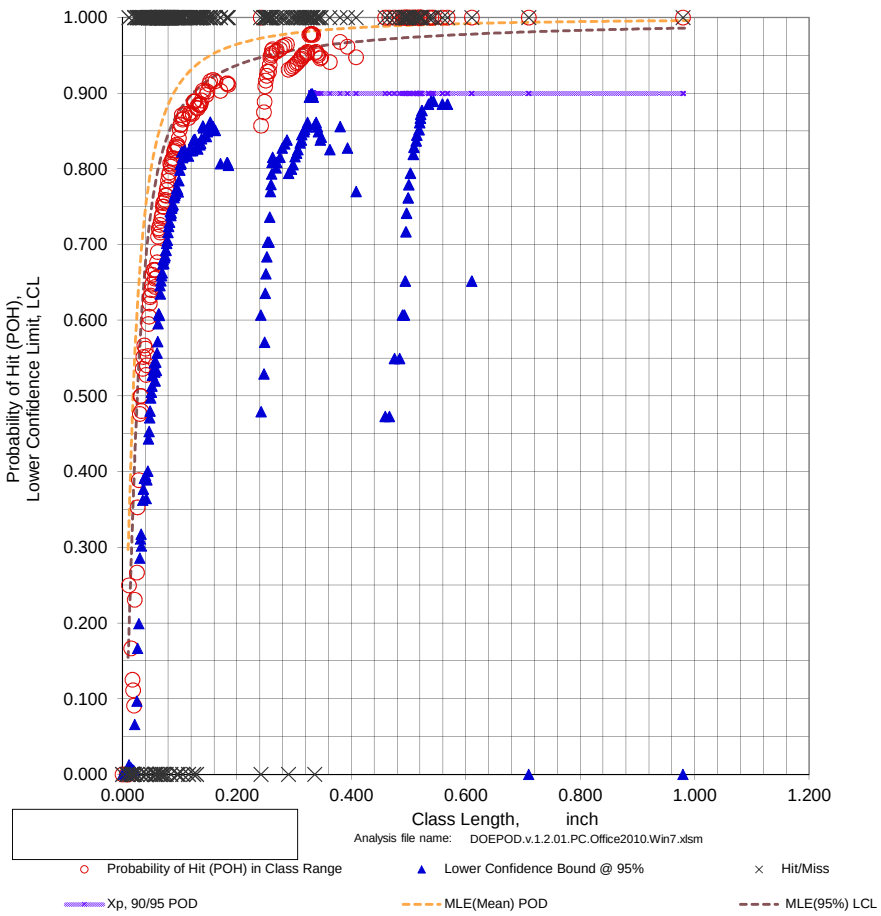
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.987.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1002CL.XLS**

Data Set Name = **D1002CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:55 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0820 | inch |
| Classlength @ 90/95 Xpod = | 0.3290 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9783 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.125 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.543 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3290 | inch |

File Name = D1002CL.XLS
Data Set Name = D1002CL(CRACK #)

## Directed DOE Options

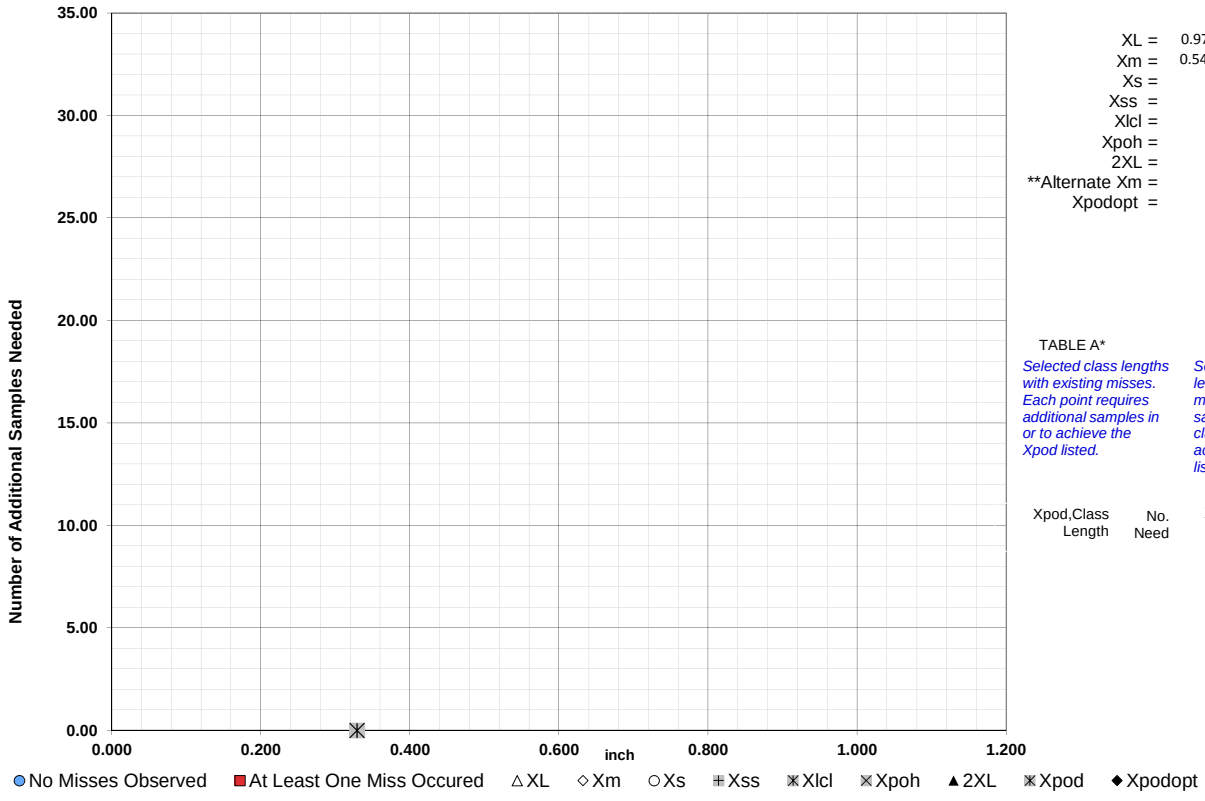



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.979 |
| Xm = | 0.543 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

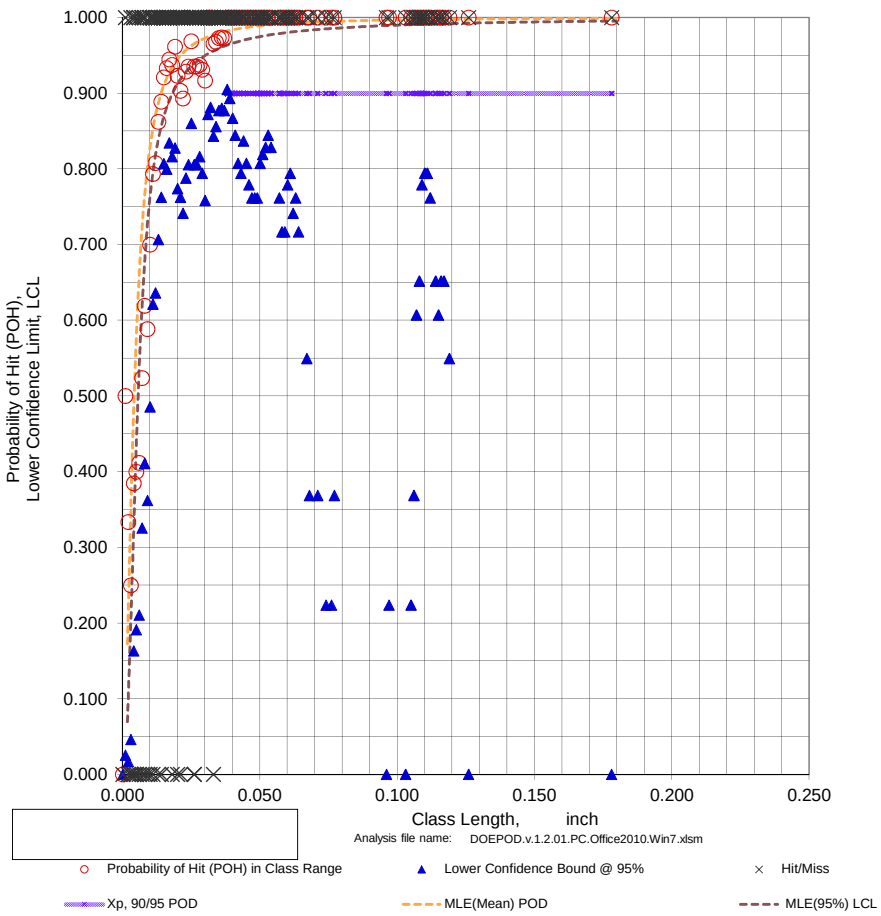
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.**

**Warning: No false call analysis.**




File Name = **D1003AD.XLS**

Data Set Name = **D1003AD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:57 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0040 | inch |
| Classlength @ 90/95 Xpod = | 0.0380 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0350 -0.001 inch 15 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.910 | @ | 0.015 | inch |
| NTIAC 90/95 POD = | 0.913 | @ | 0.020 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.111 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.038 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.0380 | inch |

File Name = D1003AD.XLS
Data Set Name = D1003AD(CRACK #)

## Directed DOE Options

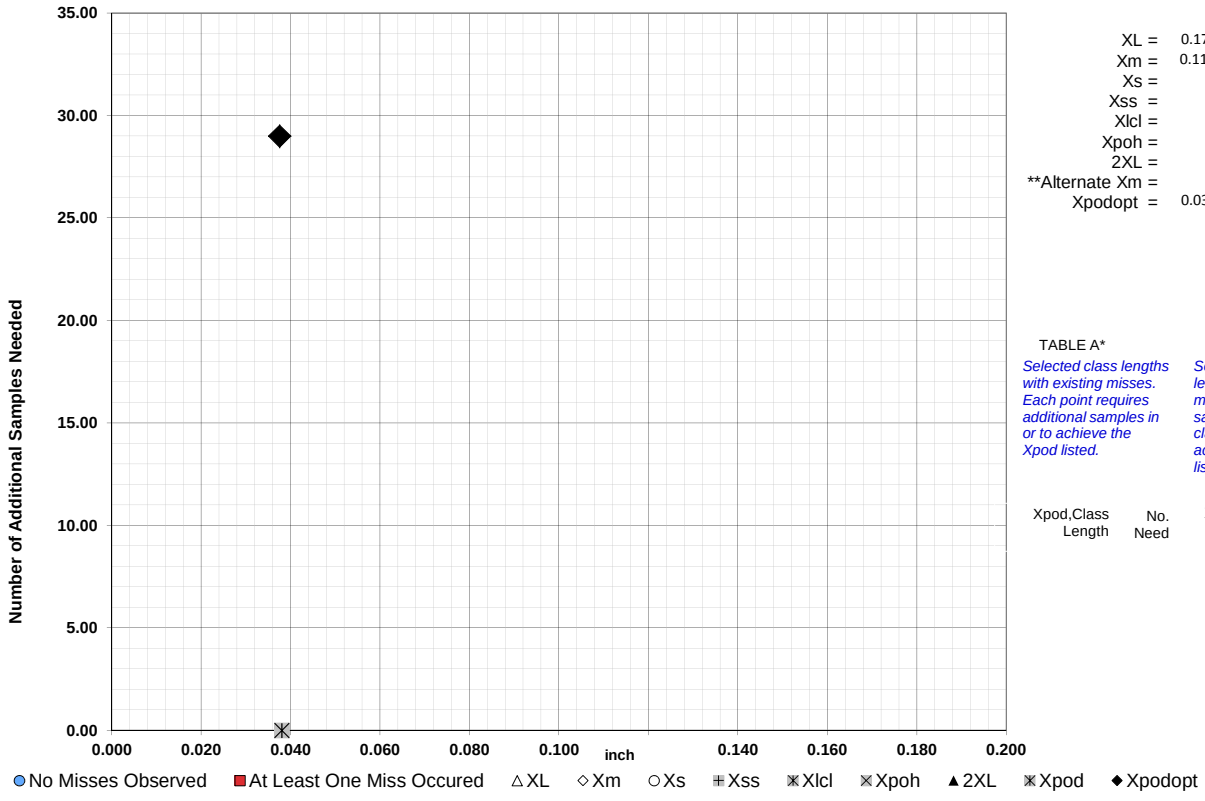



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | |
| Xm = | 0.111 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.038 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

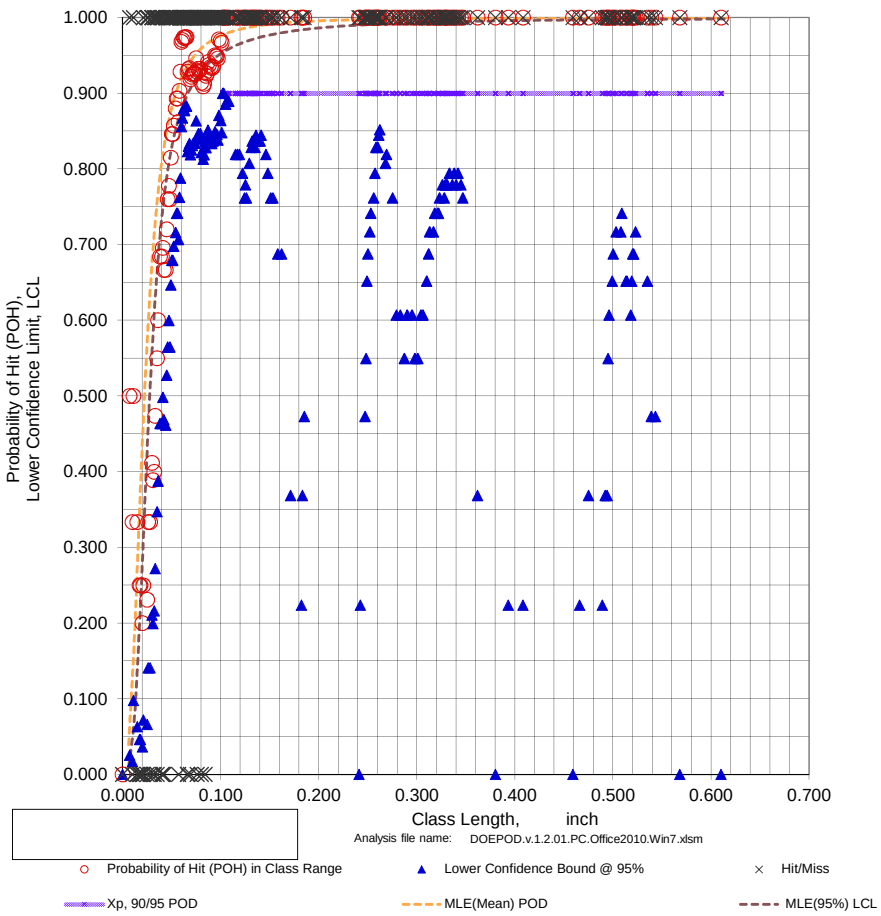
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 5 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D1003AL.XLS**

Data Set Name = **D1003AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/4/15 11:59 PM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0170 | inch |
| Classlength @ 90/95 Xpod = | 0.1020 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0860 -0.001 inch 23 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.055 | inch |
| NTIAC 90/95 POD = | 0.909 | @ | 0.070 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.262 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.102 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1020 | inch |

File Name = D1003AL.XLS
Data Set Name = D1003AL(CRACK #)

## Directed DOE Options

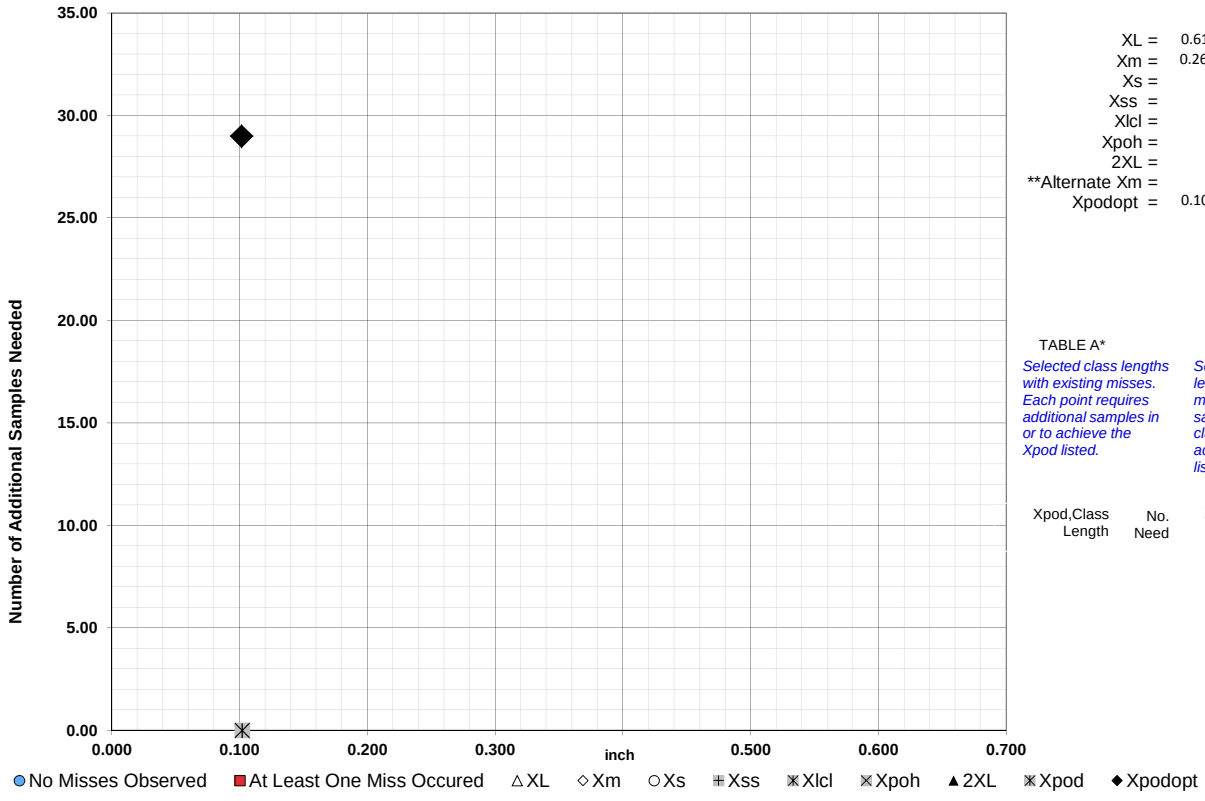



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.610 | |
| Xm = | 0.262 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.102 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

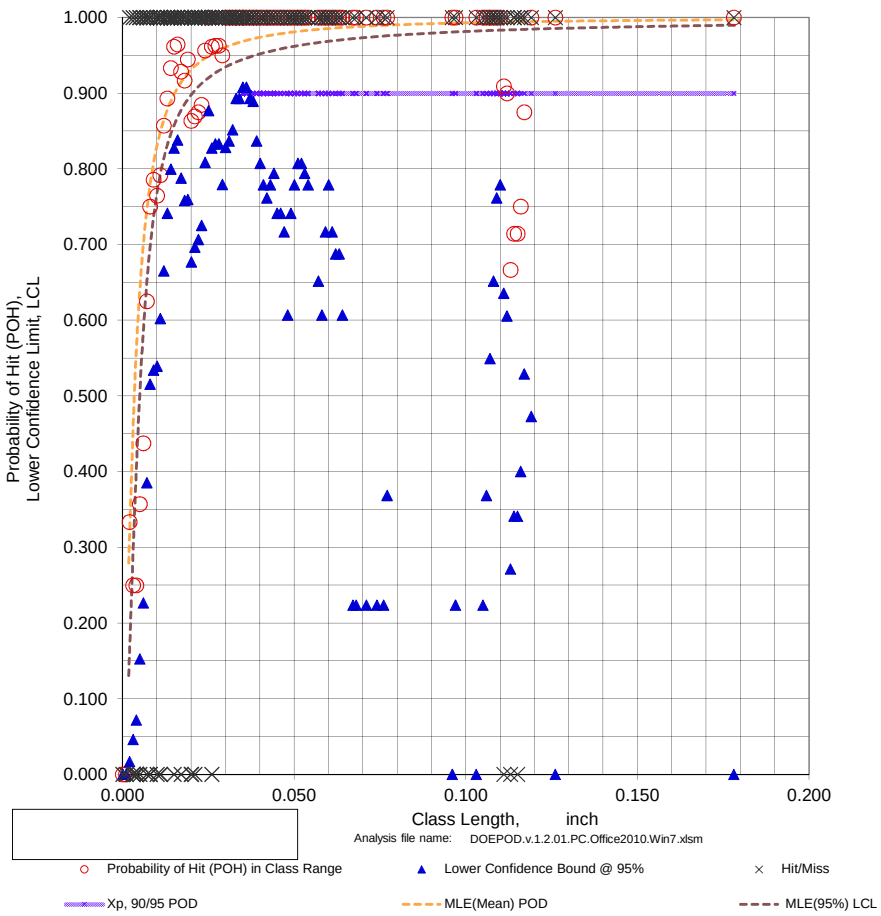
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D1003BD.XLS**

Data Set Name = **D1003BD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:02 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0030 | inch |
| Classlength @ 90/95 Xpod = | 0.0350 | inch |
| Lower Confidence Bound = | 0.9077 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.931 | @ | 0.020 | inch |
| NTIAC 90/95 POD = | 0.920 | @ | 0.025 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.110 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0350 | inch |

File Name = D1003BD.XLS
Data Set Name = D1003BD(CRACK #)

## Directed DOE Options

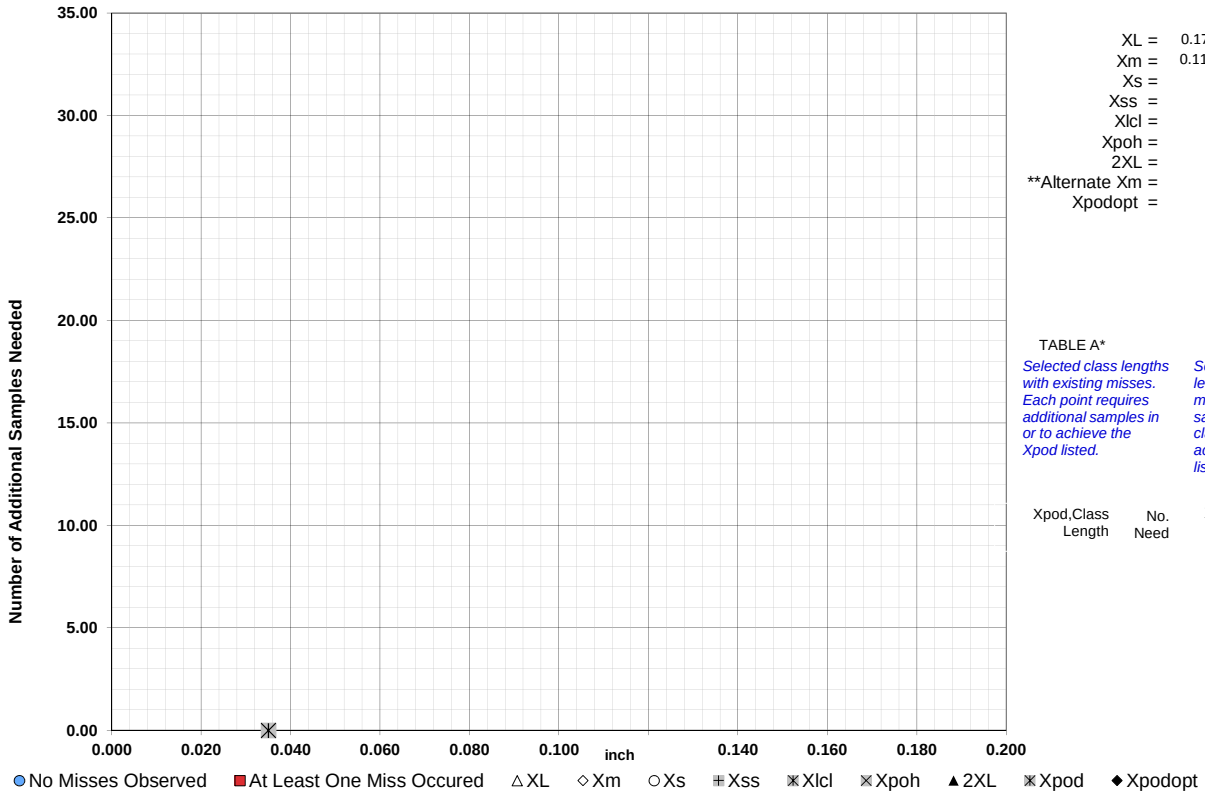



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | |
| Xm = | 0.110 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

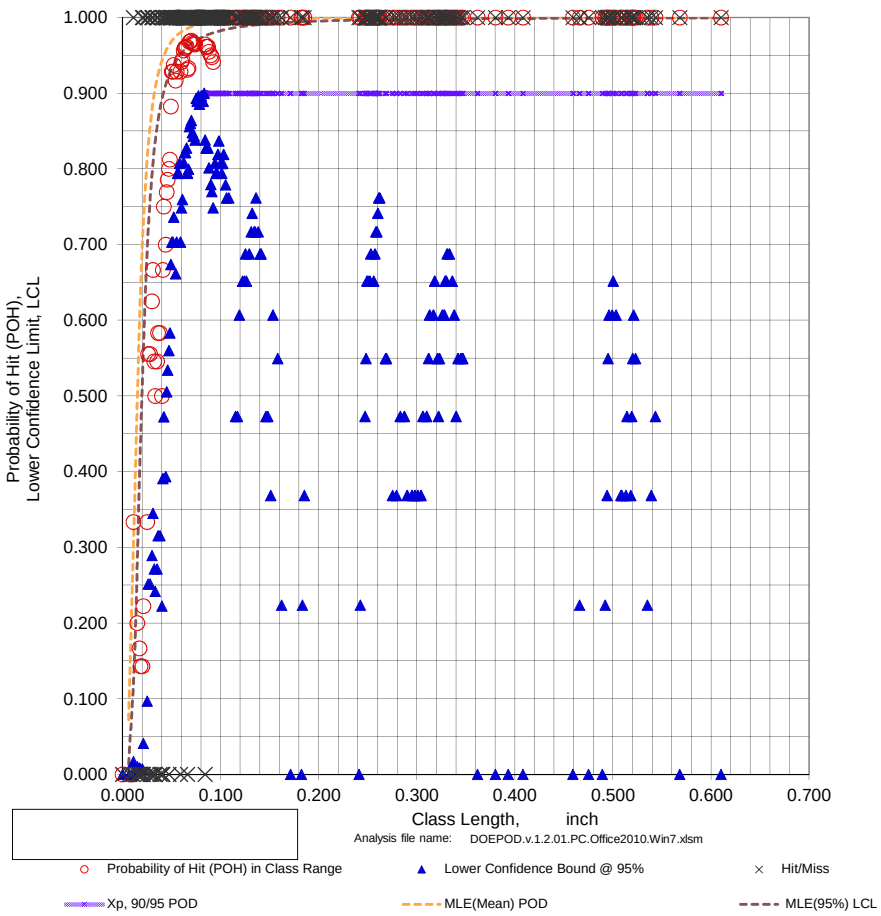
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 4 more large flaws.

Any highlighted Misses are RED and shown in Column A of this data sheet

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| File Name = | D1003BL.XLS | |
| Data Set Name = | D1003BL(CRACK #) | |
| Date & Time = | 6/5/15 12:05 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0080 | inch |
| Classlength @ 90/95 Xpod = | 0.0830 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.

| | | | | |
|---|---|---|---|---|
| Survey/Optimum Xpoh = | 0.000 | inch | | Samples |
| NTIAC 90% POD = | 0.926 | @ | 0.035 | inch |
| NTIAC 90/95 POD = | 0.920 | @ | 0.045 | inch |
| False Call Rate = | with UCL @ 95% = | | | |
| Largest Classlength , XL = | 0.610 | inch | | |
| Samples Needed @ XL = | | | | |
| Classlength Mid-point , Xm = | 0.262 | inch | | |
| Samples Needed @ Xm = | | | | |
| Smallest Classlength, Xs = | | inch | | |
| Samples Needed @ Xs = | | | | |
| New Smaller Classlength, Xss = | | inch | | |
| BestLCL Classlength, Xlcl = | | inch | | |
| Samples Needed @ Xlcl = | | | | |
| POH Classlength, Xpoh = | | inch | | |
| Samples Needed @ Xpoh = | | | | |
| New Largest Classlength , 2XL = | | inch | | |
| Xm is Near Verification Point = | | inch | | |
| Opt. POD classlength, Xpodopt = | | inch | | |
| Samples Needed @Xpodopt = | | | | |
| Xp = | 0.0830 | inch | | |

File Name = D1003BL.XLS
Data Set Name = D1003BL(CRACK #)

## Directed DOE Options

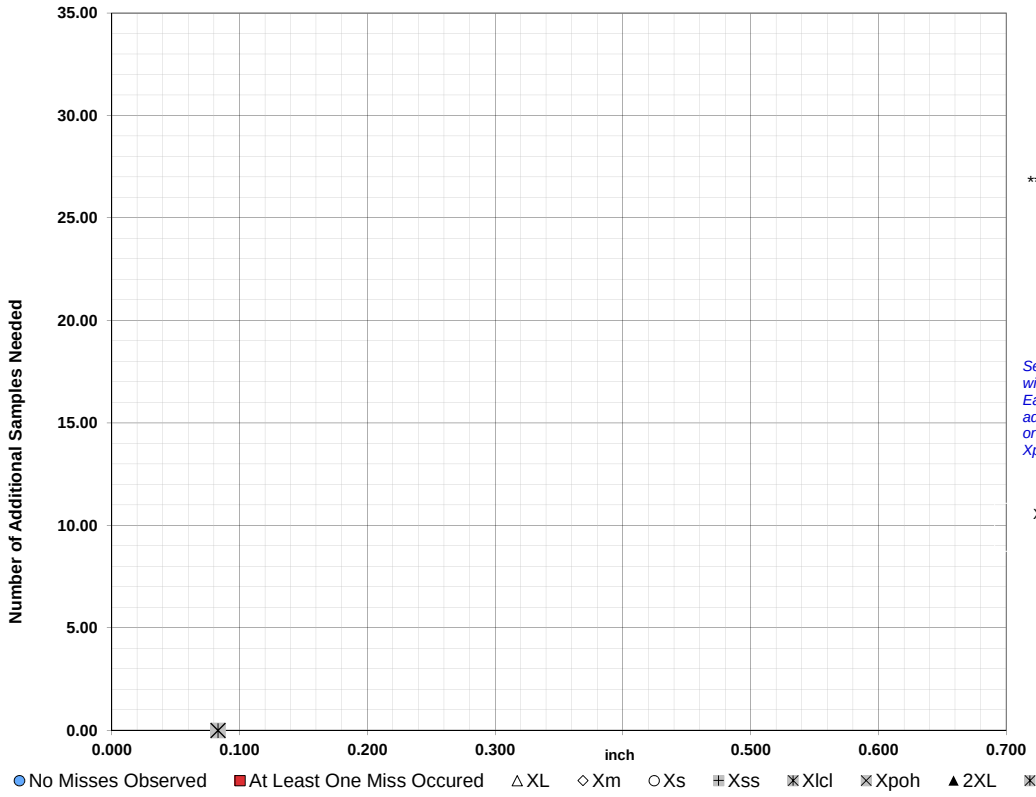



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.262 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

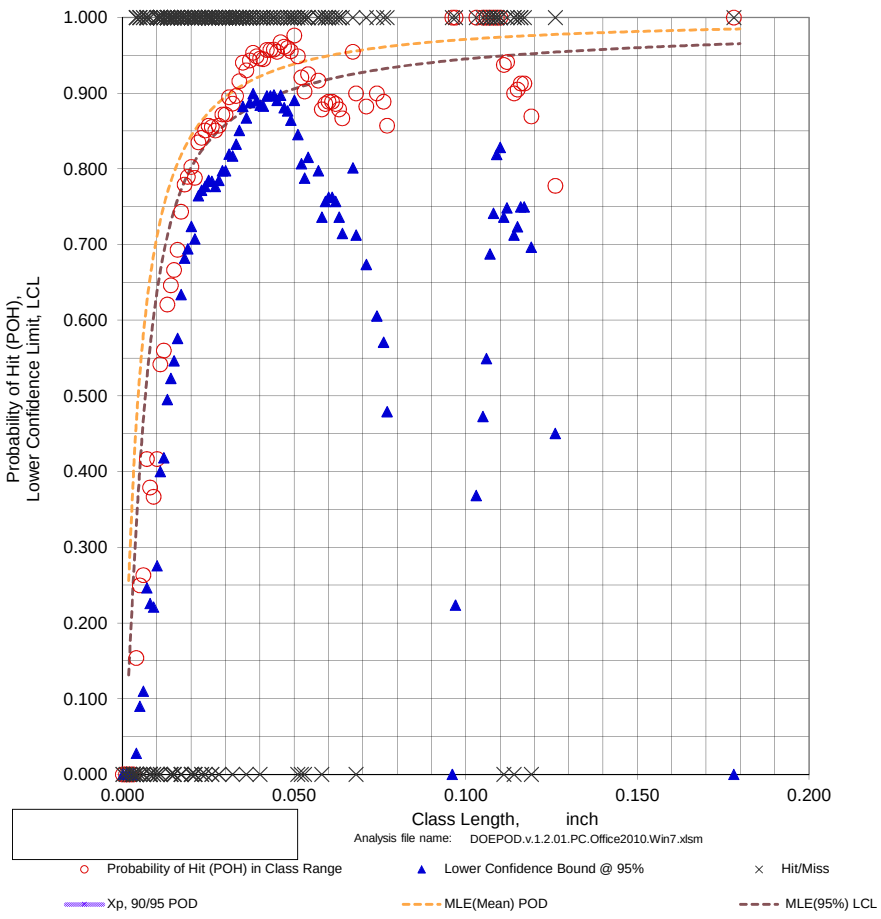
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Warning: No false call analysis.**




File Name = **D1003CD.XLS**

Data Set Name = **D1003CD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:10 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0130 | inch |
| Classlength @ 90/95 Xpod = | 0.0460 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9672 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.911 | @ | 0.035 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.050 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | 0.110 | inch |
| Samples Needed @ Xm = | 13 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D1003CD.XLS
Data Set Name = D1003CD(CRACK #)

## Directed DOE Options

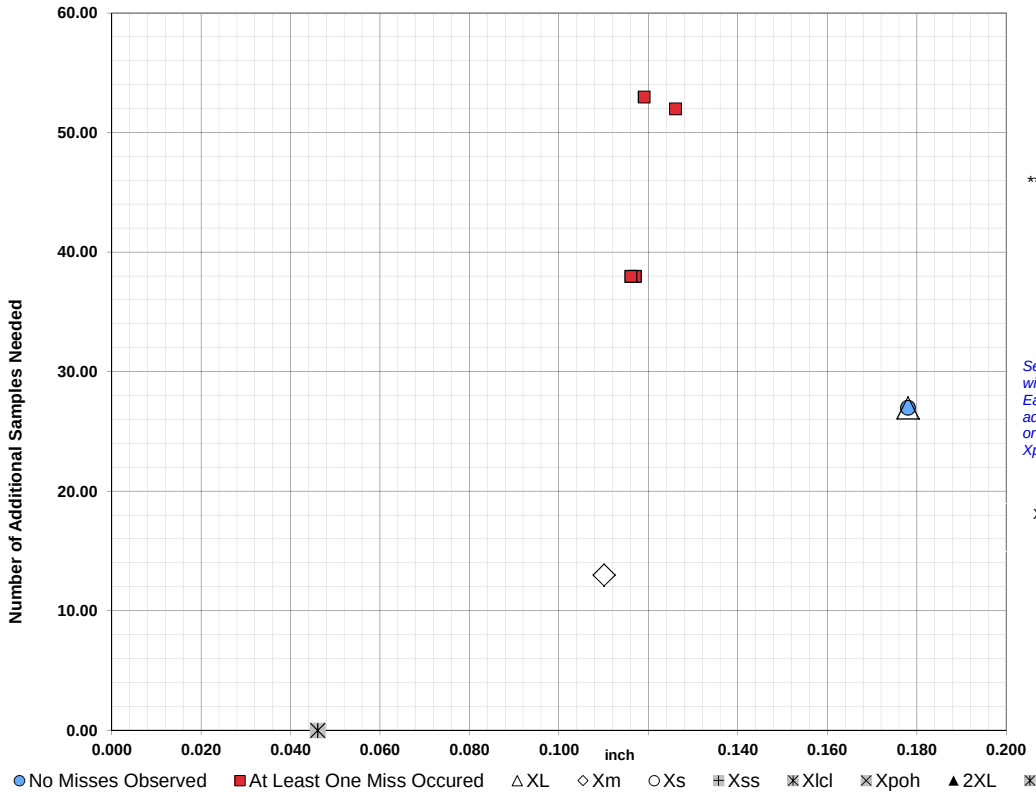



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 27 |
| Xm = | 0.110 | 13 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1260 | 52 |
| 0.1190 | 53 |
| 0.1170 | 38 |
| 0.1160 | 38 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1780 | 27 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.87.**

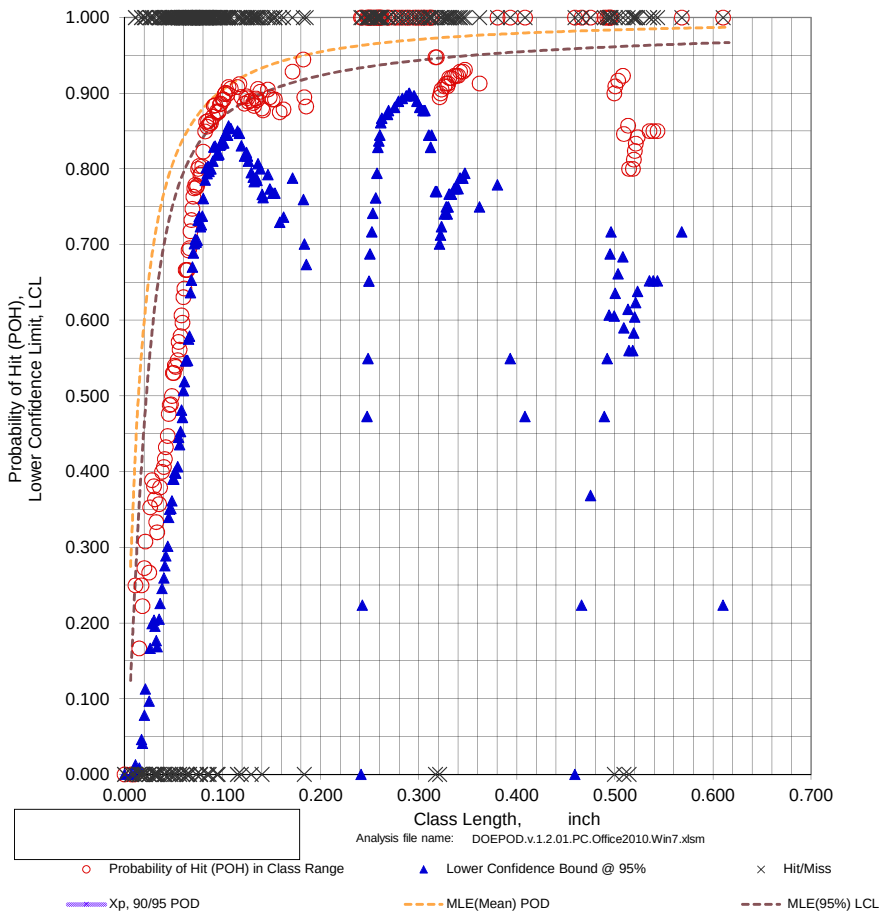
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **D1003CL.XLS**

Data Set Name = **D1003CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:12 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0490 | inch |
| Classlength @ 90/95 Xpod = | 0.2900 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.140 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | 18 | |
| Classlength Mid-point , Xm = | 0.380 | inch |
| Samples Needed @ Xm = | 17 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D1003CL.XLS
Data Set Name = D1003CL(CRACK #)

## Directed DOE Options

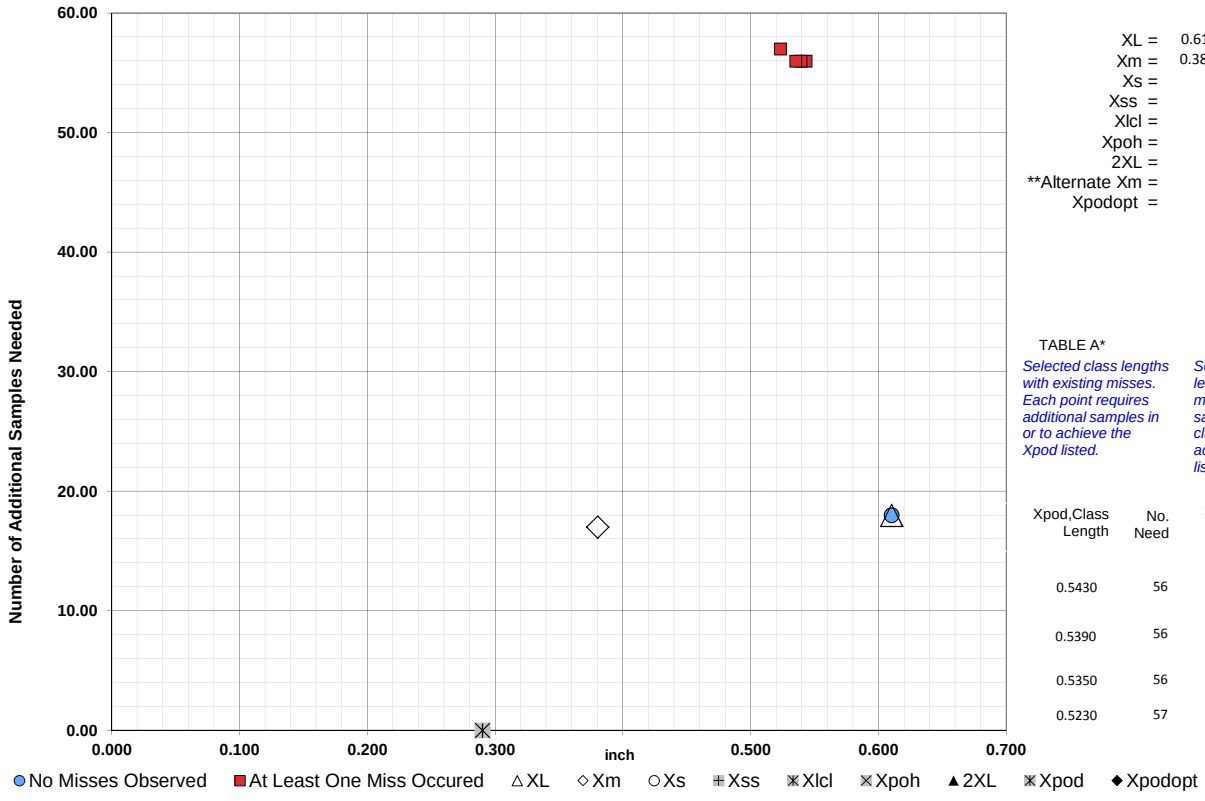



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.610 | 18 |
| Xm = | 0.380 | 17 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5430 | 56 |
| 0.5390 | 56 |
| 0.5350 | 56 |
| 0.5230 | 57 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.6100 | 18 |

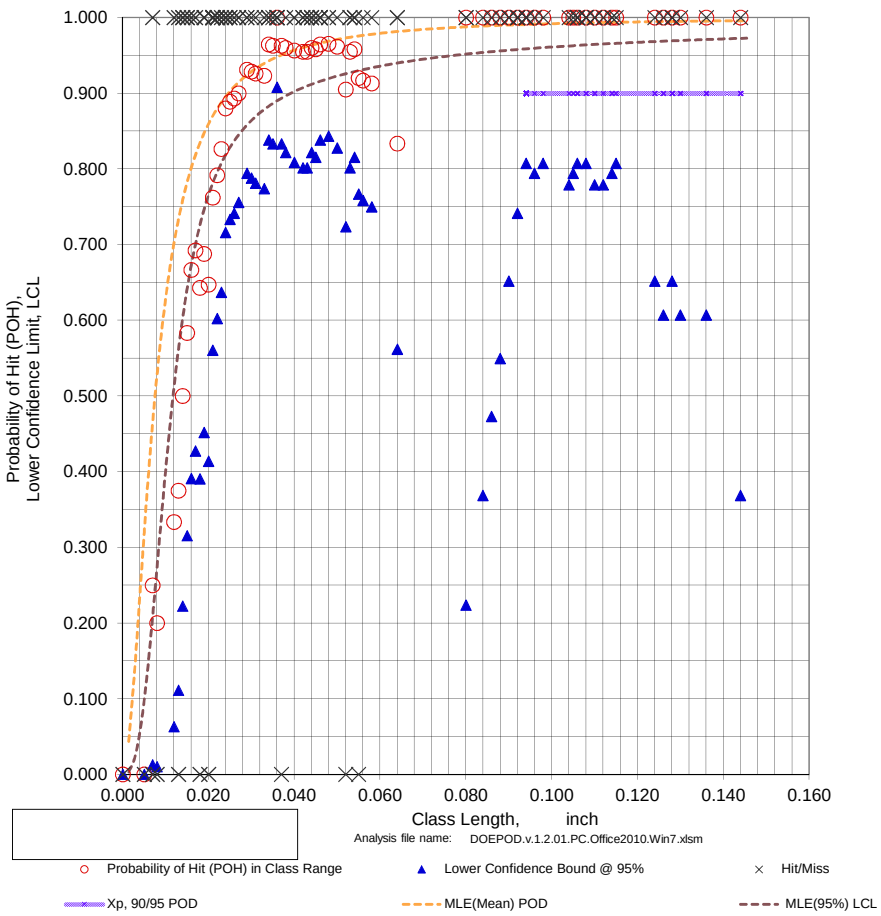
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 6 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D2002AD.XLS**

Data Set Name = **D2002AD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:13 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0150 | inch |
| Classlength @ 90/95 Xpod = | 0.0360 | inch |
| Lower Confidence Bound = | 0.9077 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.040 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.144 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.115 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0940 | inch |

File Name = D2002AD.XLS
Data Set Name = D2002AD(CRACK #)

## Directed DOE Options

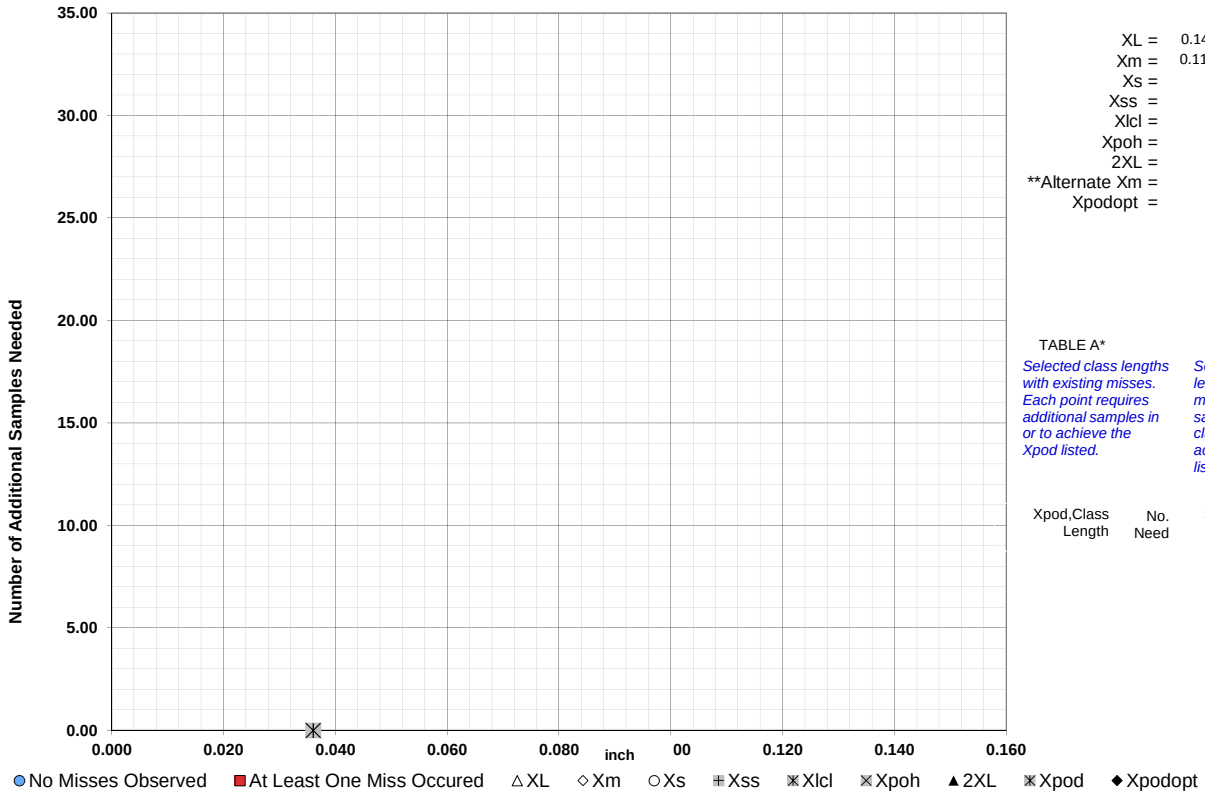



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.144 |
| Xm = | 0.115 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

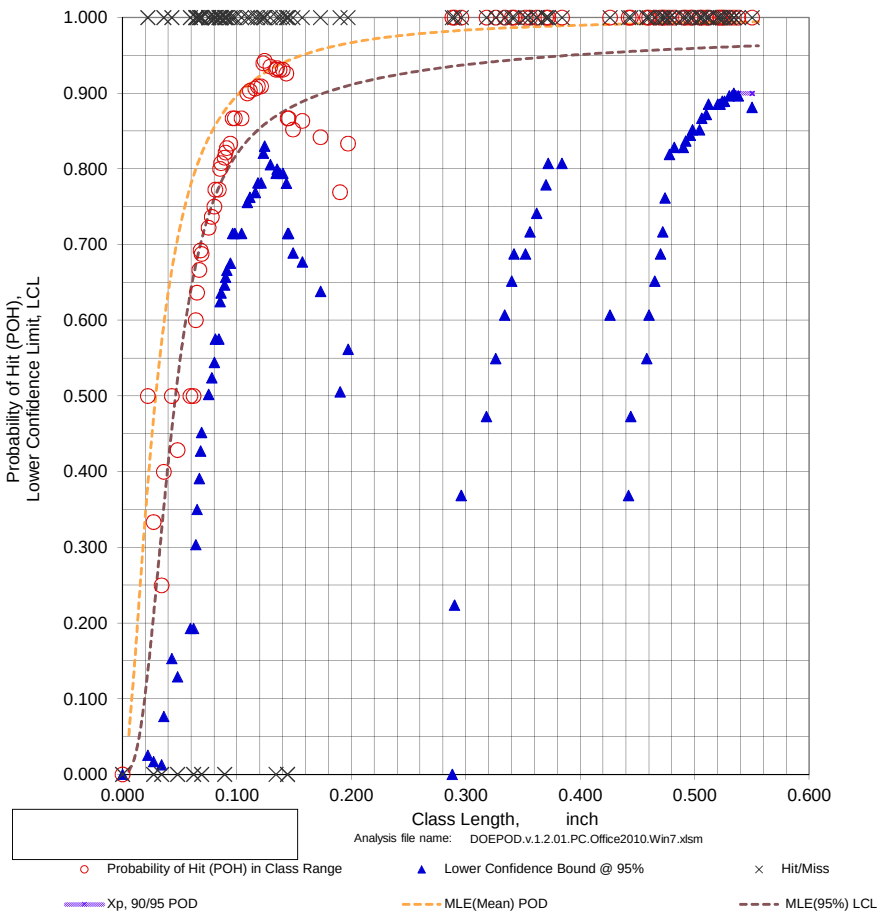
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.602.**

**Warning: No false call analysis.**




File Name = **D2002AL.XLS**

Data Set Name = **D2002AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:14 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0600 | inch |
| Classlength @ 90/95 Xpod = | 0.5340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1490 -0.004 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.180 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.538 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.288 | inch |
| Samples Needed @Xpodopt = | 28 | |
| Xp = | 0.5340 | inch |

File Name = D2002AL.XLS
Data Set Name = D2002AL(CRACK #)

## Directed DOE Options

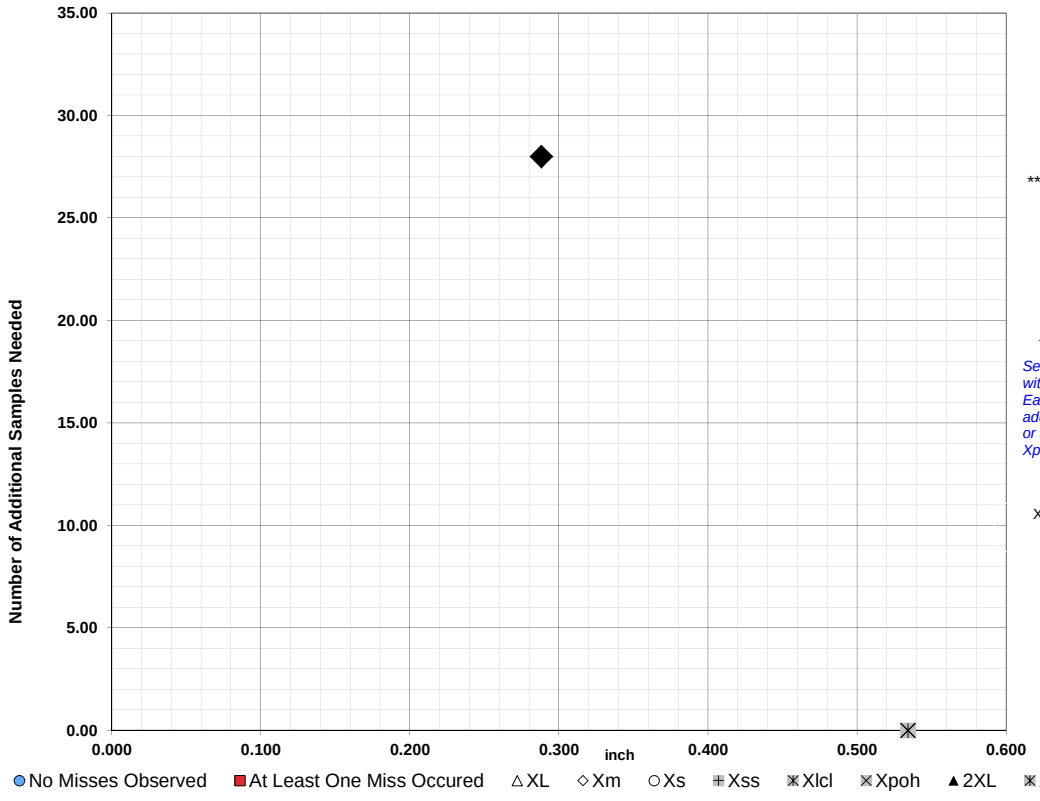



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | |
| Xm = | 0.538 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.288 | 28 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

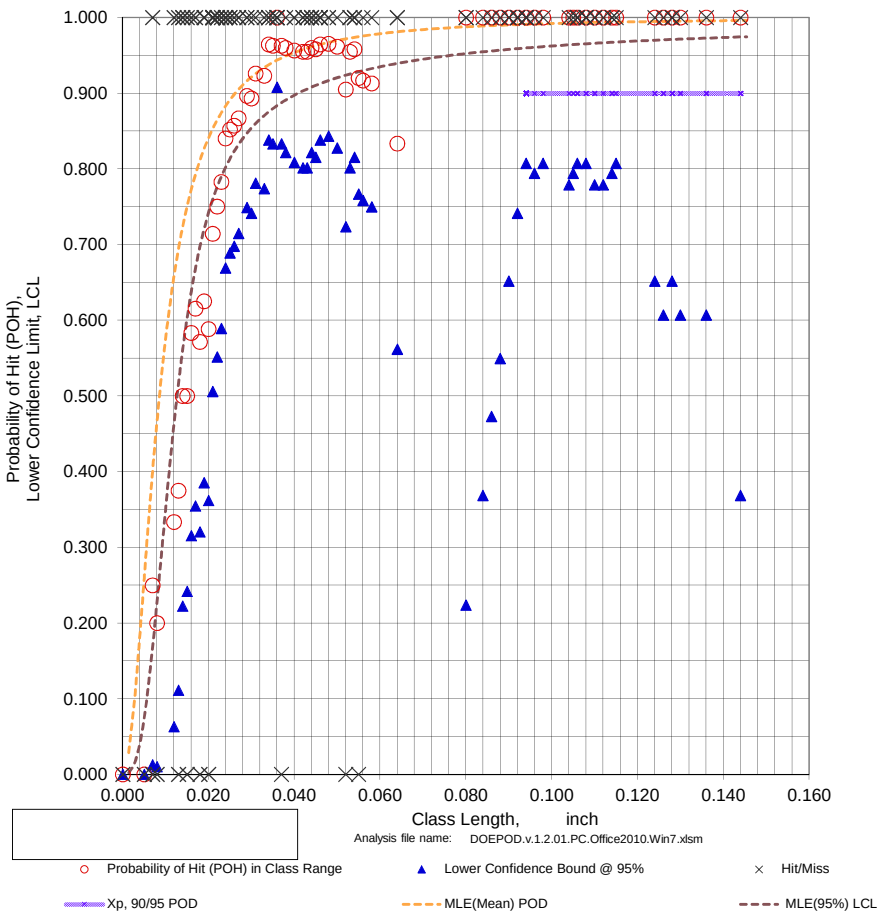
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 6 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D2002BD.XLS**

Data Set Name = **D2002BD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:15 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0150 | inch |
| Classlength @ 90/95 Xpod = | 0.0360 | inch |
| Lower Confidence Bound = | 0.9077 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.921 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.910 | @ | 0.045 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.144 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.115 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0940 | inch |

File Name = D2002BD.XLS
Data Set Name = D2002BD(CRACK #)

## Directed DOE Options

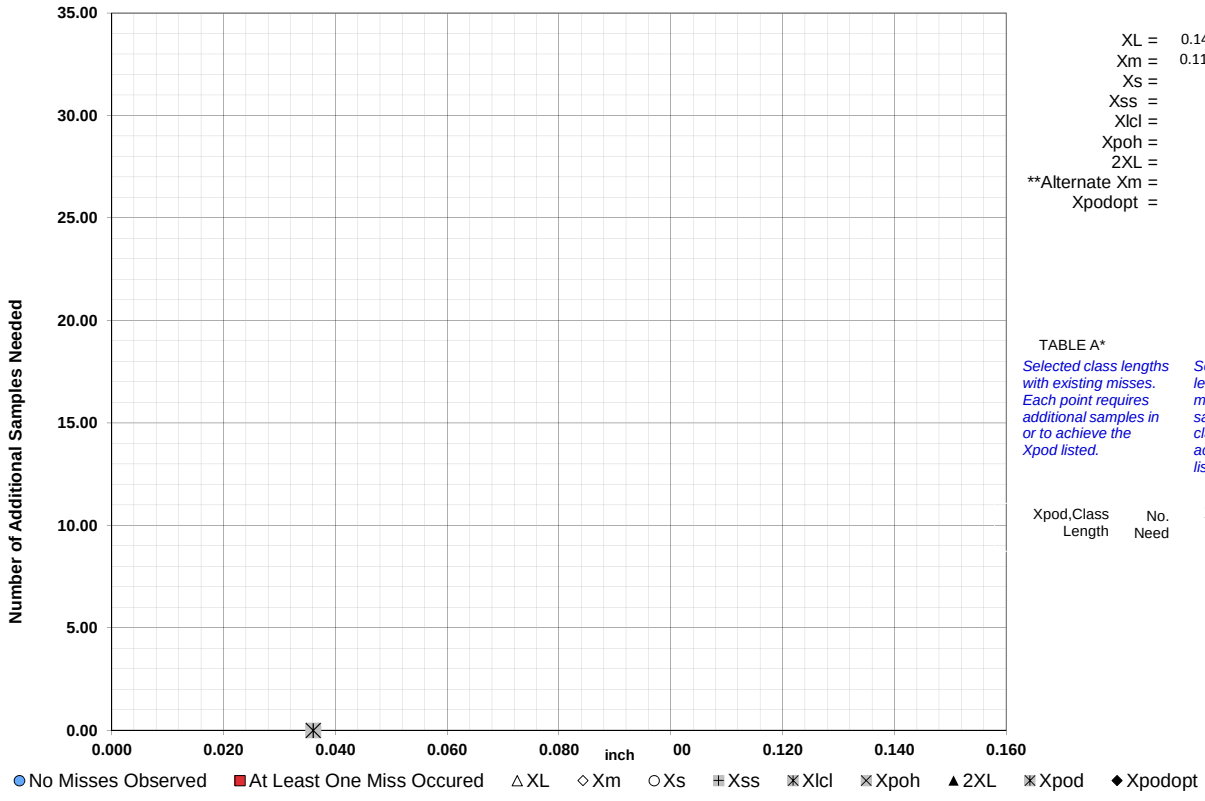



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.144 |
| Xm = | 0.115 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

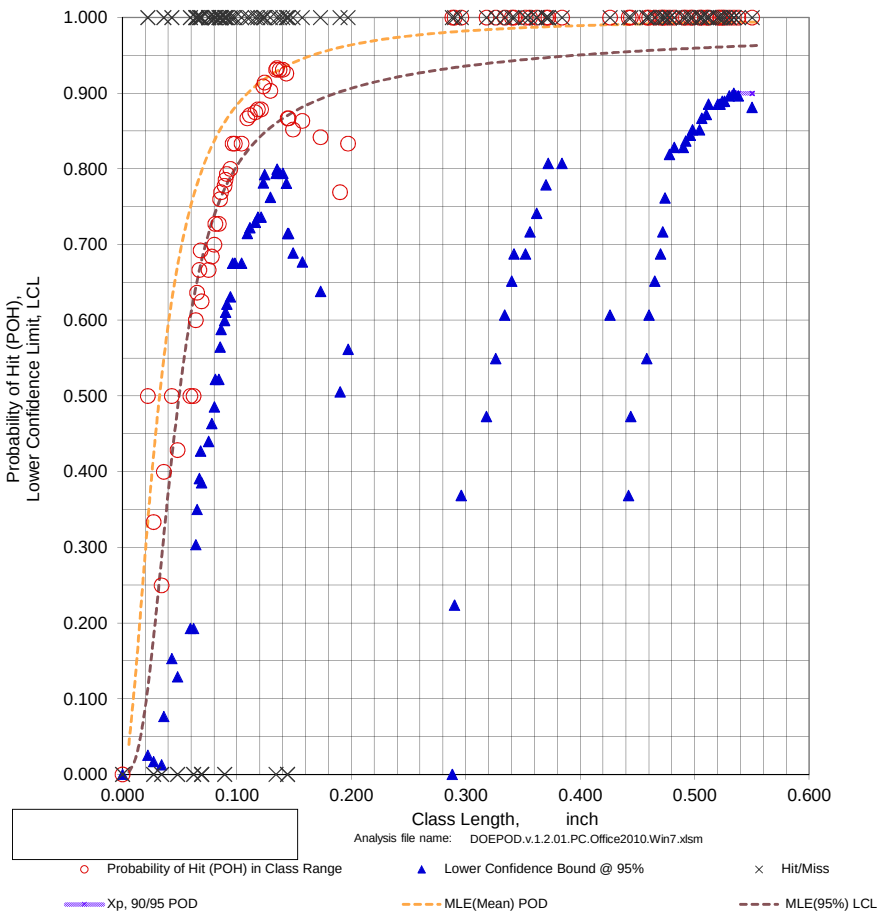
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.602.**

**Warning: No false call analysis.**




File Name = **D2002BL.XLS**

Data Set Name = **D2002BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:15 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0600 | inch |
| Classlength @ 90/95 Xpod = | 0.5340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1490 -0.004 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.190 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.538 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.288 | inch |
| Samples Needed @Xpodopt = | 28 | |
| Xp = | 0.5340 | inch |

File Name = D2002BL.XLS
Data Set Name = D2002BL(CRACK #)

## Directed DOE Options

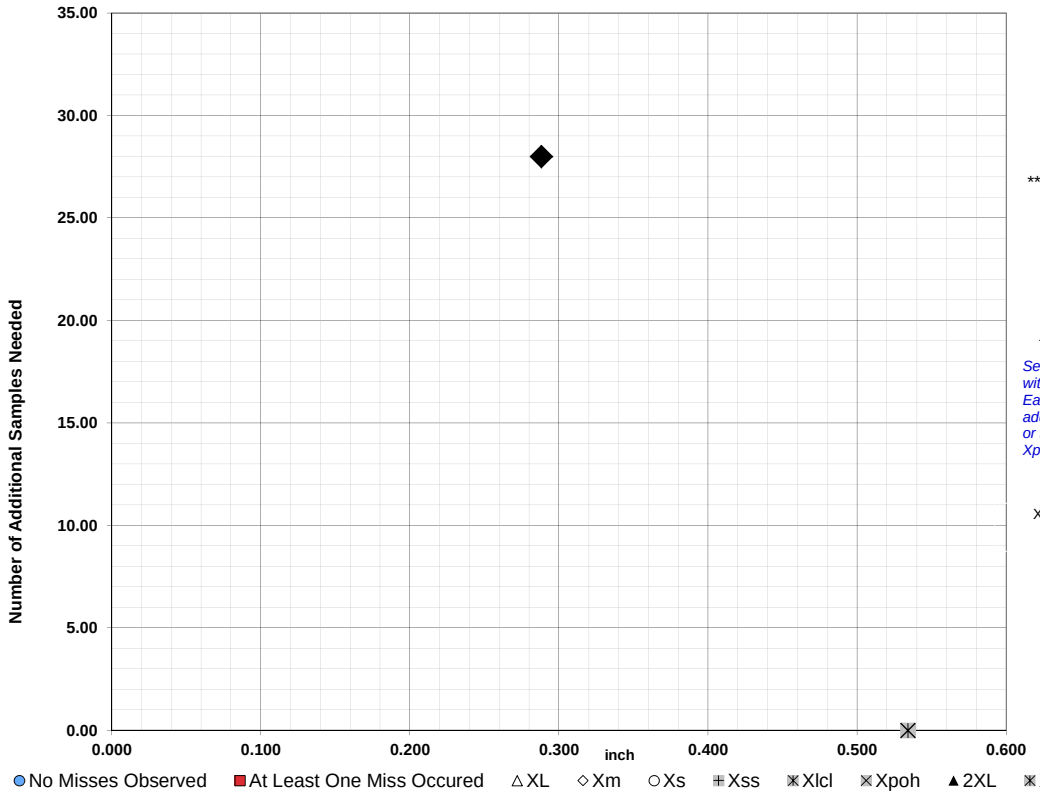



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | |
| Xm = | 0.538 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.288 | 28 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

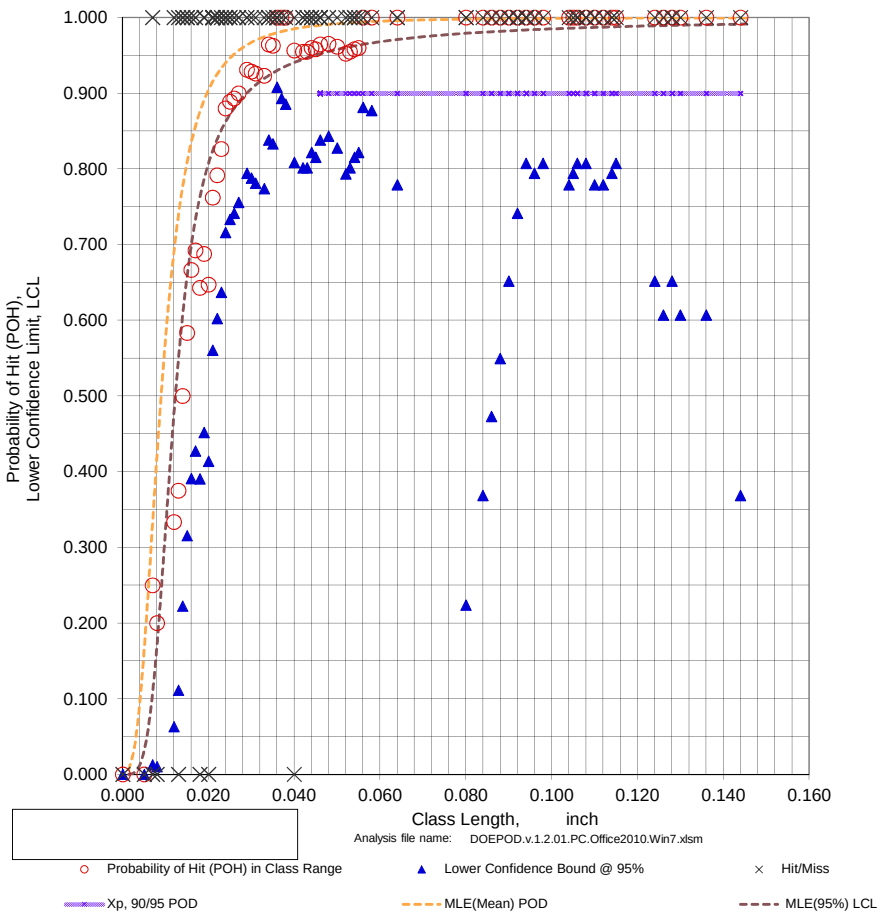
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 6 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D2002CD.XLS**

Data Set Name = **D2002CD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:16 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0150 | inch |
| Classlength @ 90/95 Xpod = | 0.0360 | inch |
| Lower Confidence Bound = | 0.9077 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.020 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.030 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.144 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.115 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0460 | inch |

File Name = D2002CD.XLS
Data Set Name = D2002CD(CRACK #)

## Directed DOE Options

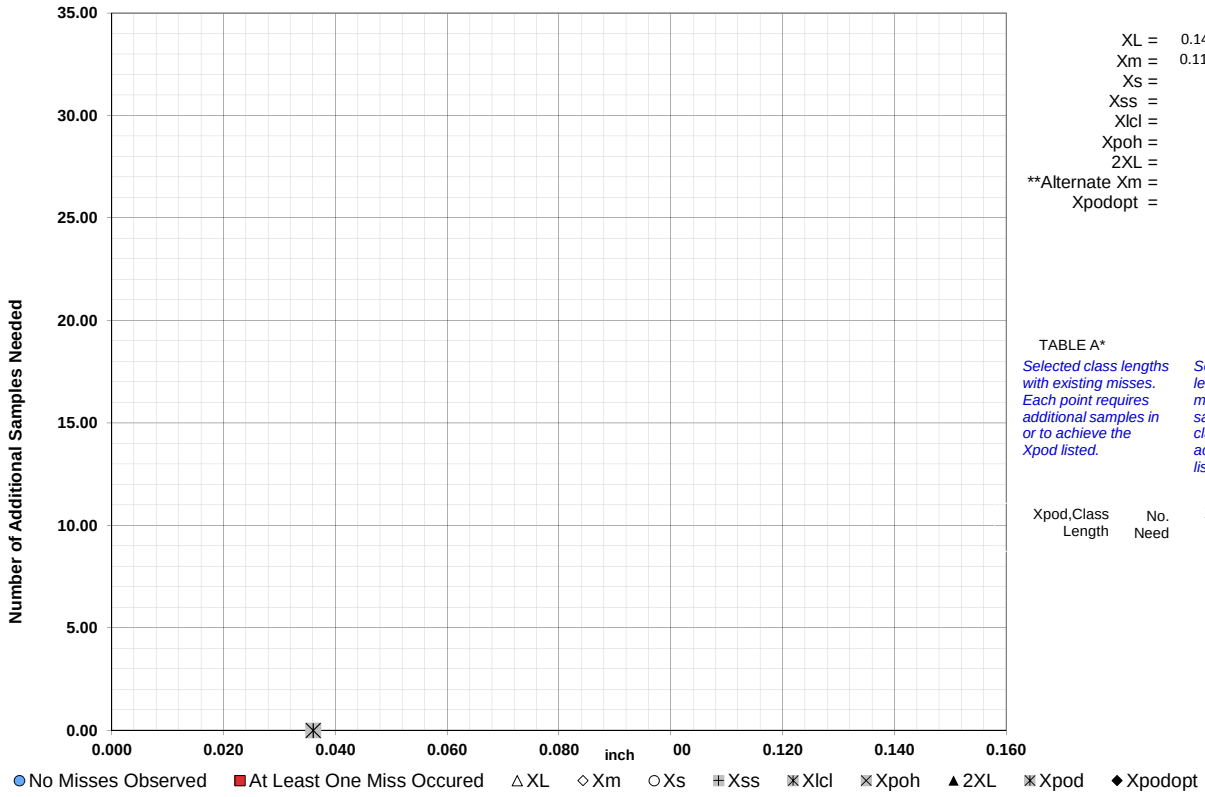



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.144 | |
| Xm = | 0.115 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

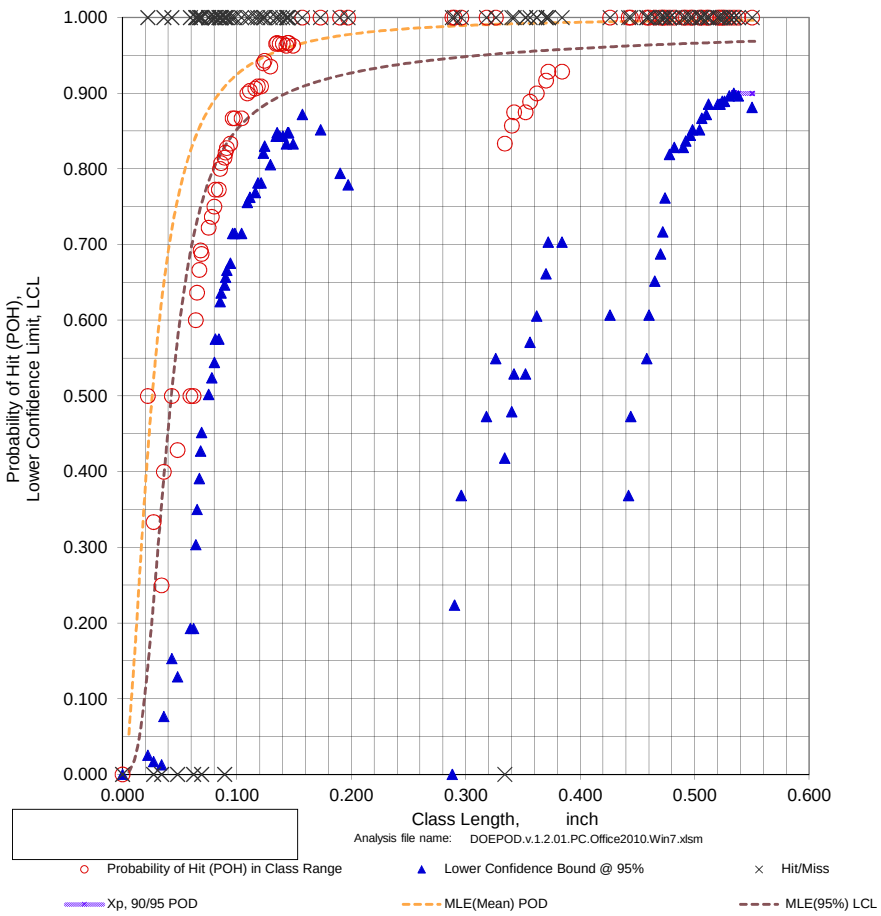
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.602.**

**Warning: No false call analysis.**




File Name = **D2002CL.XLS**

Data Set Name = **D2002CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:17 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0600 | inch |
| Classlength @ 90/95 Xpod = | 0.5340 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.3400 -0.005 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.085 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.145 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.538 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.426 | inch |
| Samples Needed @Xpodopt = | 23 | |
| Xp = | 0.5340 | inch |

File Name = D2002CL.XLS
Data Set Name = D2002CL(CRACK #)

## Directed DOE Options

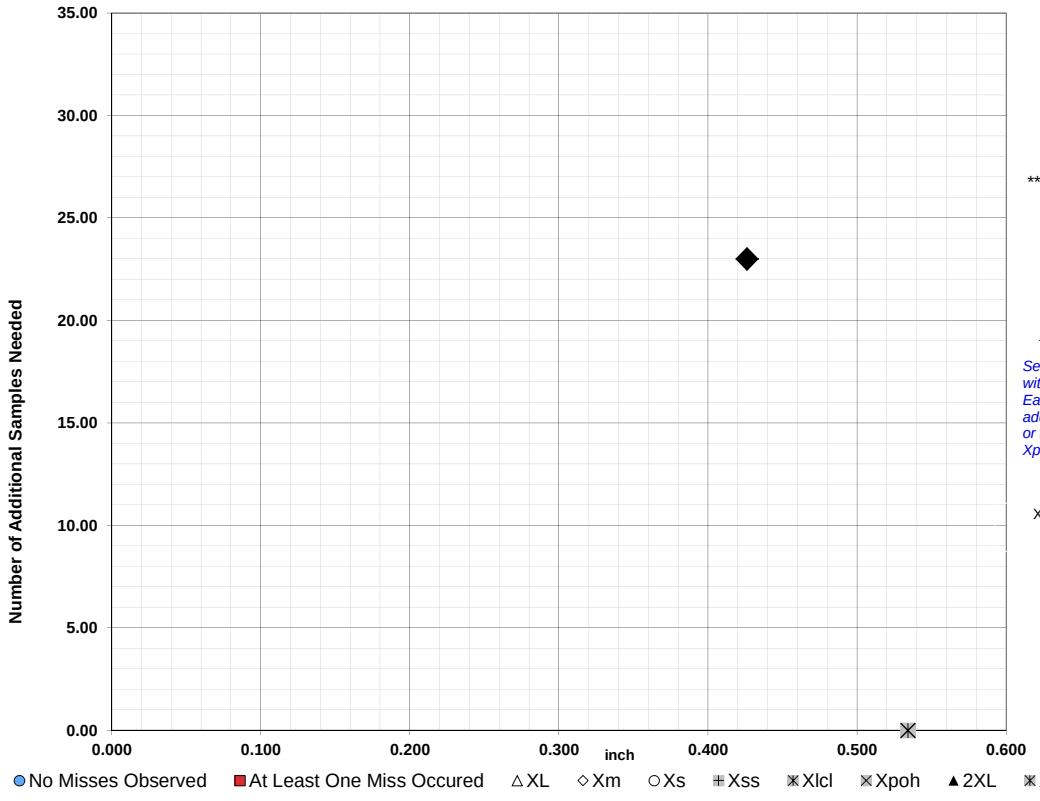



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | |
| Xm = | 0.538 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.426 | 23 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

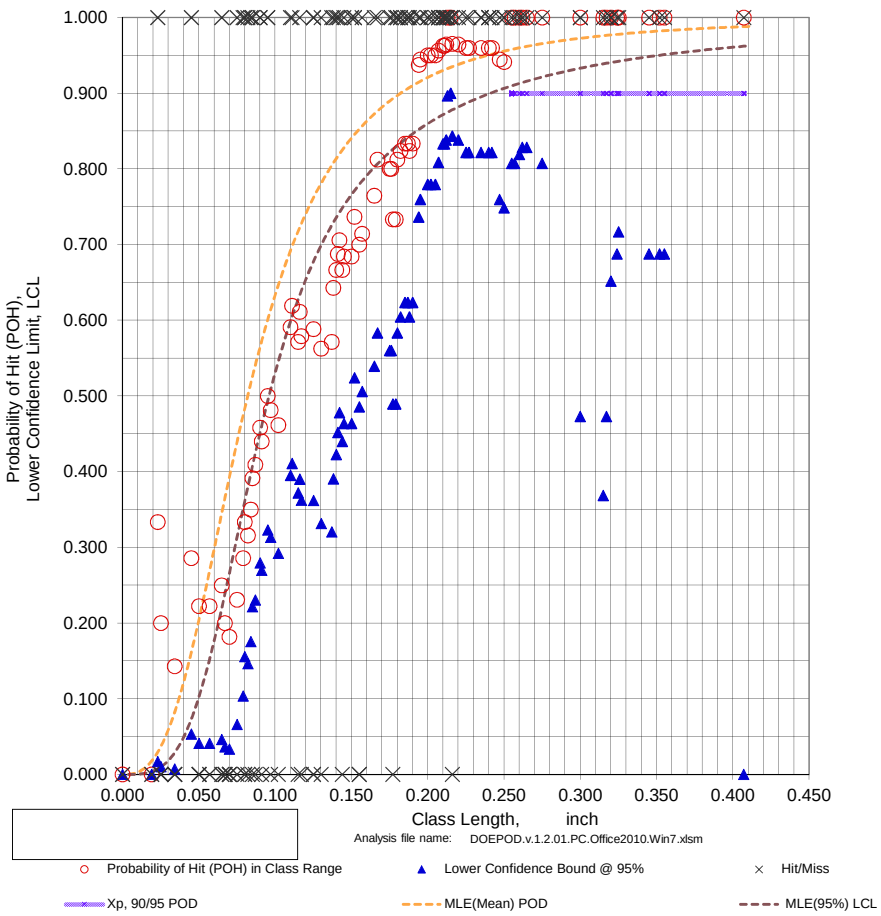
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.645.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D3001AL.XLS**

Data Set Name = **D3001AL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:18 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0350 | inch |
| Classlength @ 90/95 Xpod = | 0.2150 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.245 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.265 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2550 | inch |

File Name = D3001AL.XLS
Data Set Name = D3001AL(CRK #)

## Directed DOE Options

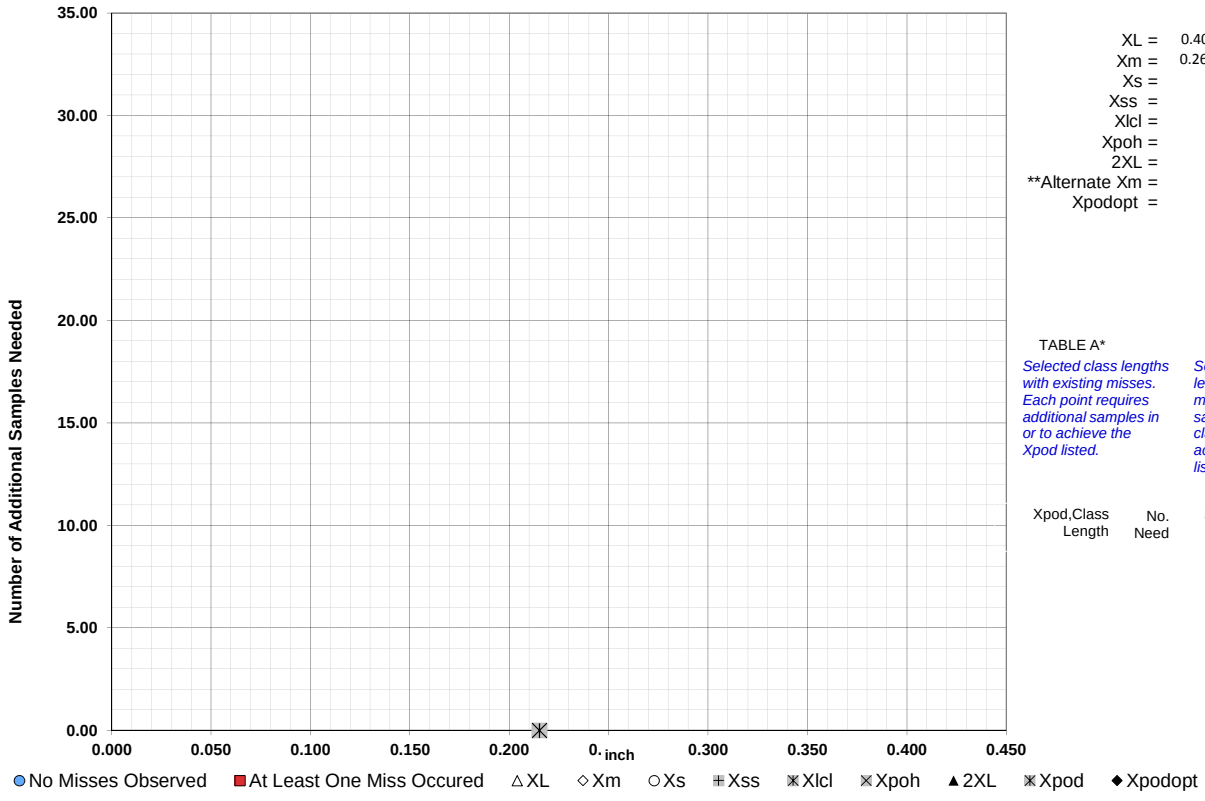



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.407 |
| Xm = | 0.265 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

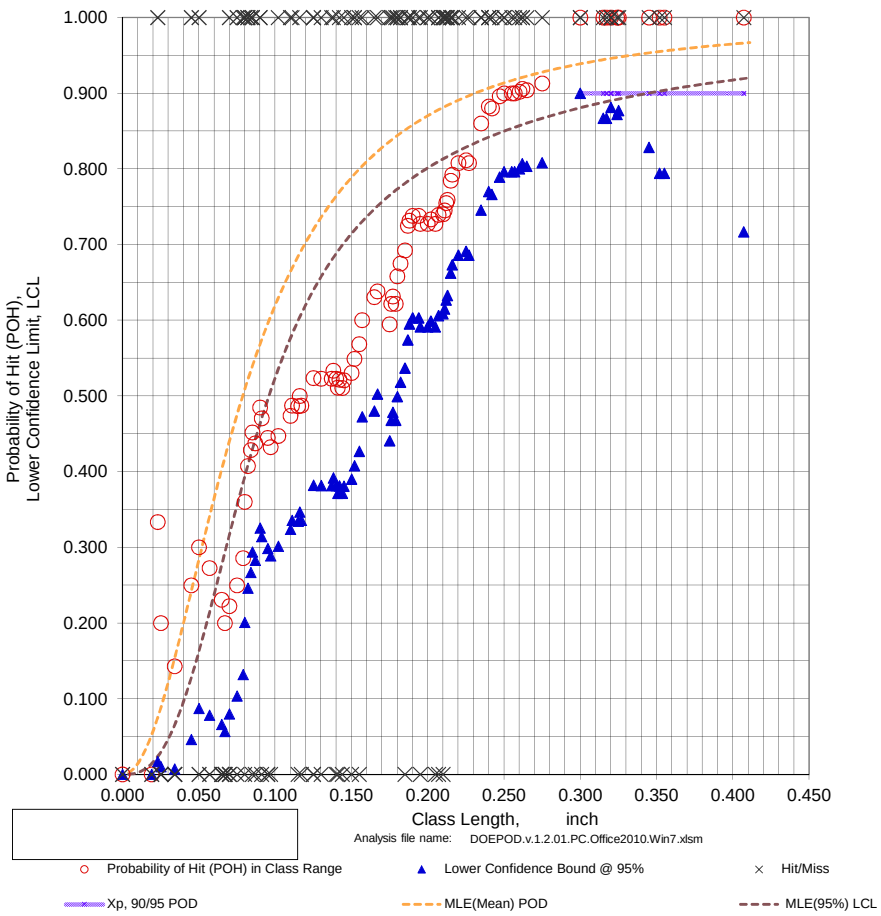
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.9.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D3001BL.XLS**

Data Set Name = **D3001BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:19 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0880 | inch |
| Classlength @ 90/95 Xpod = | 0.3000 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.2120 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.235 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.345 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.345 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.288 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.3000 | inch |

File Name = D3001BL.XLS
Data Set Name = D3001BL(CRK #)

## Directed DOE Options

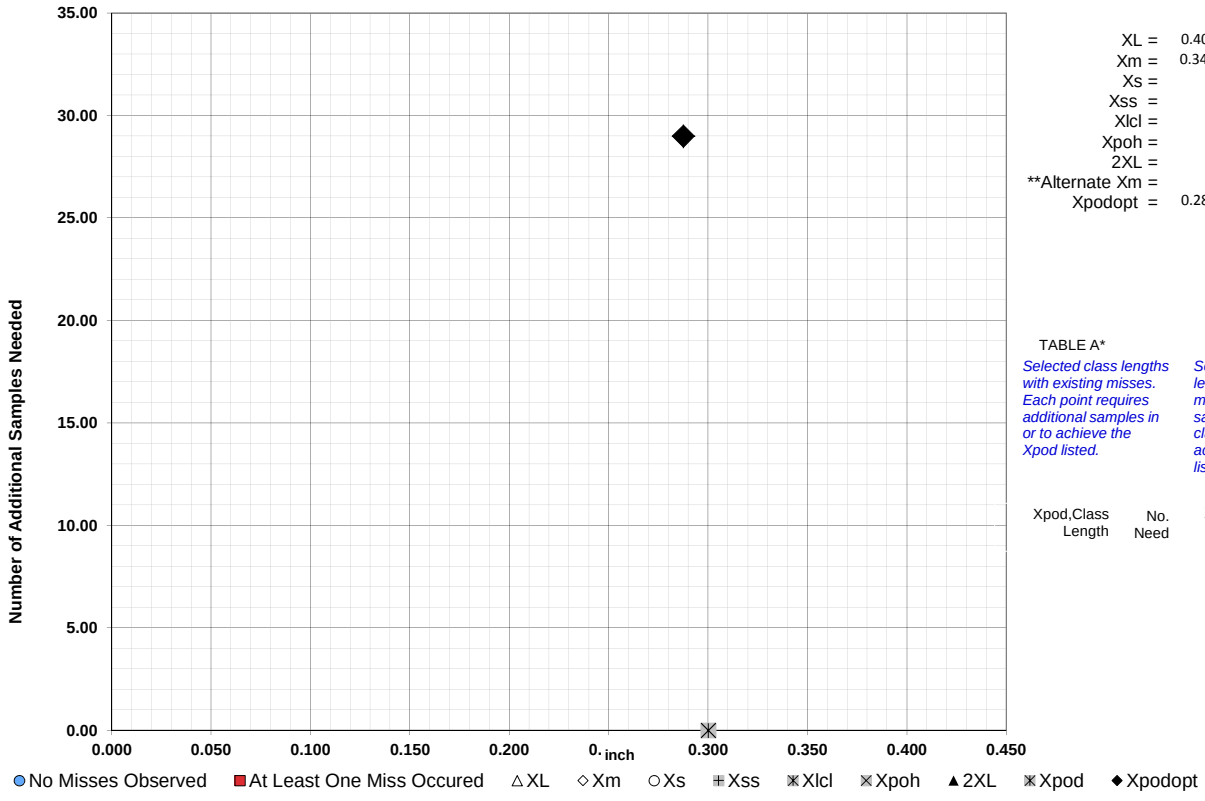



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.345 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.288 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

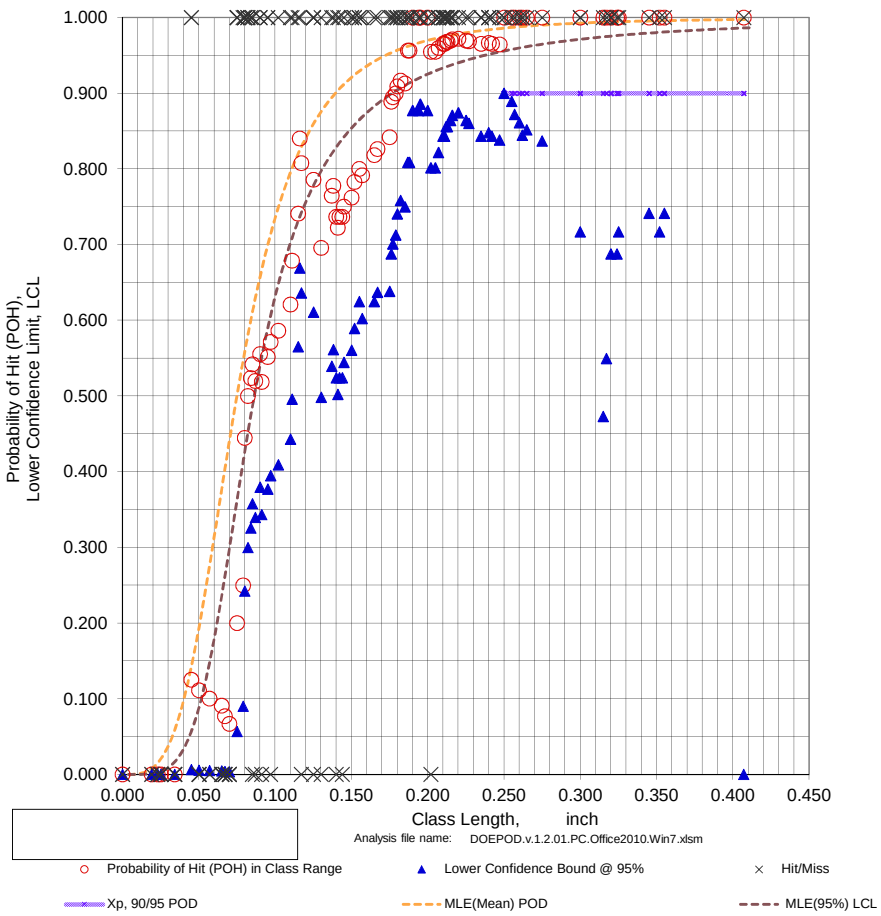
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.75.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D3001CL.XLS**

Data Set Name = **D3001CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:20 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0450 | inch |
| Classlength @ 90/95 Xpod = | 0.2500 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.2050 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.140 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.180 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.355 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.249 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.2500 | inch |

File Name = D3001CL.XLS
Data Set Name = D3001CL(CRK #)

## Directed DOE Options

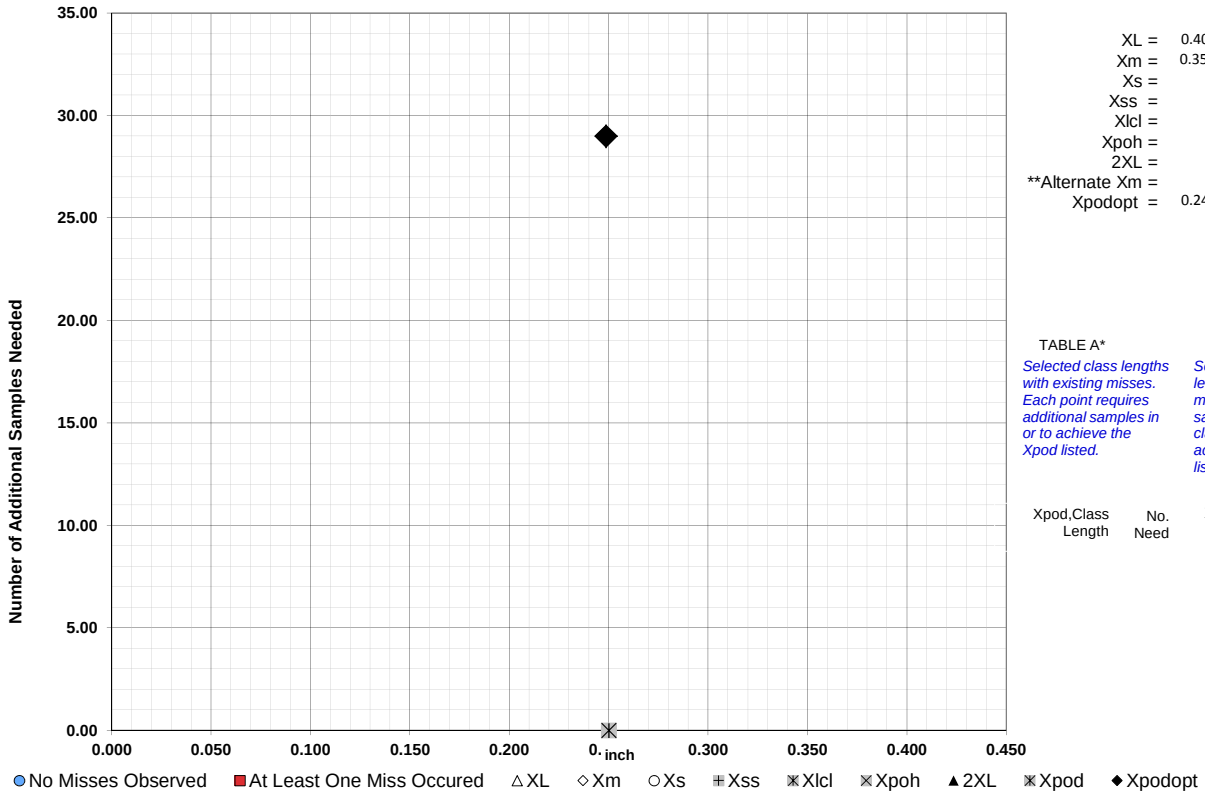



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.355 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.249 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

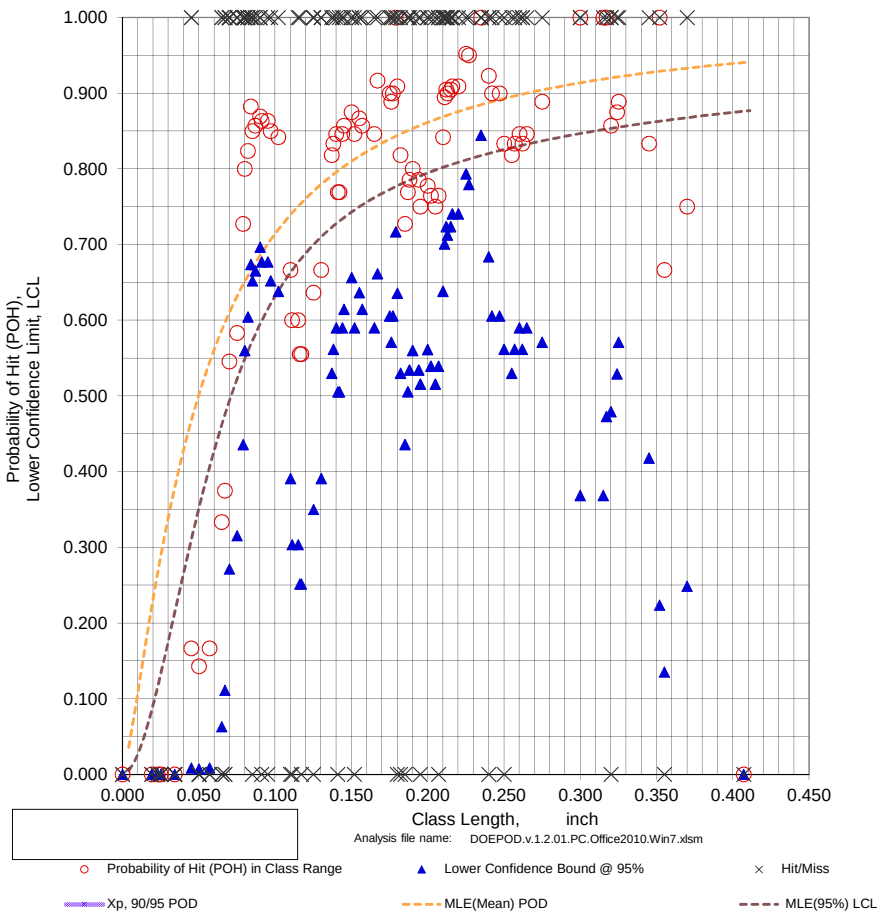
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D3003AL.XLS
Data Set Name = D3003AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:21 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8444 | |
| Classwidth @ Best LCL = | 0.0250 | inch |
| Classlength @ Best LCL = | 0.2350 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.265 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.555 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D3003AL.XLS
Data Set Name = D3003AL(CRK #)

## Directed DOE Options

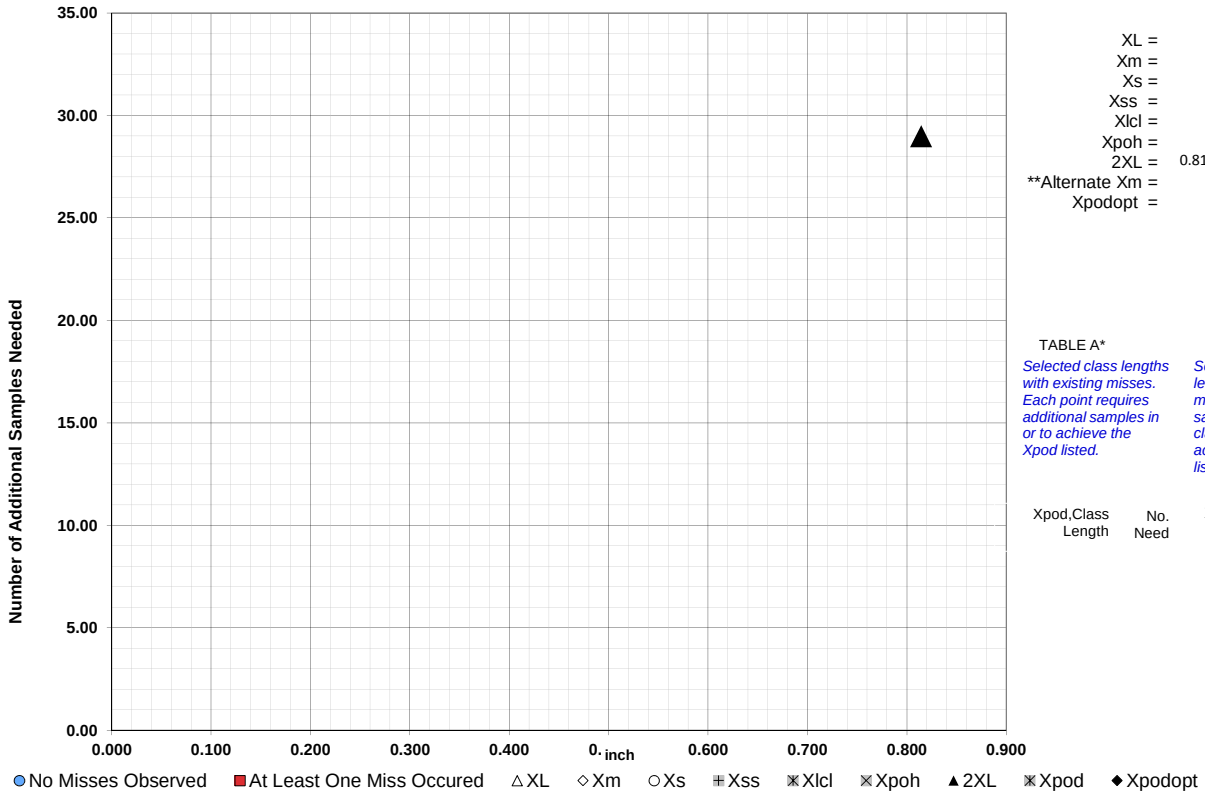



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.648.**

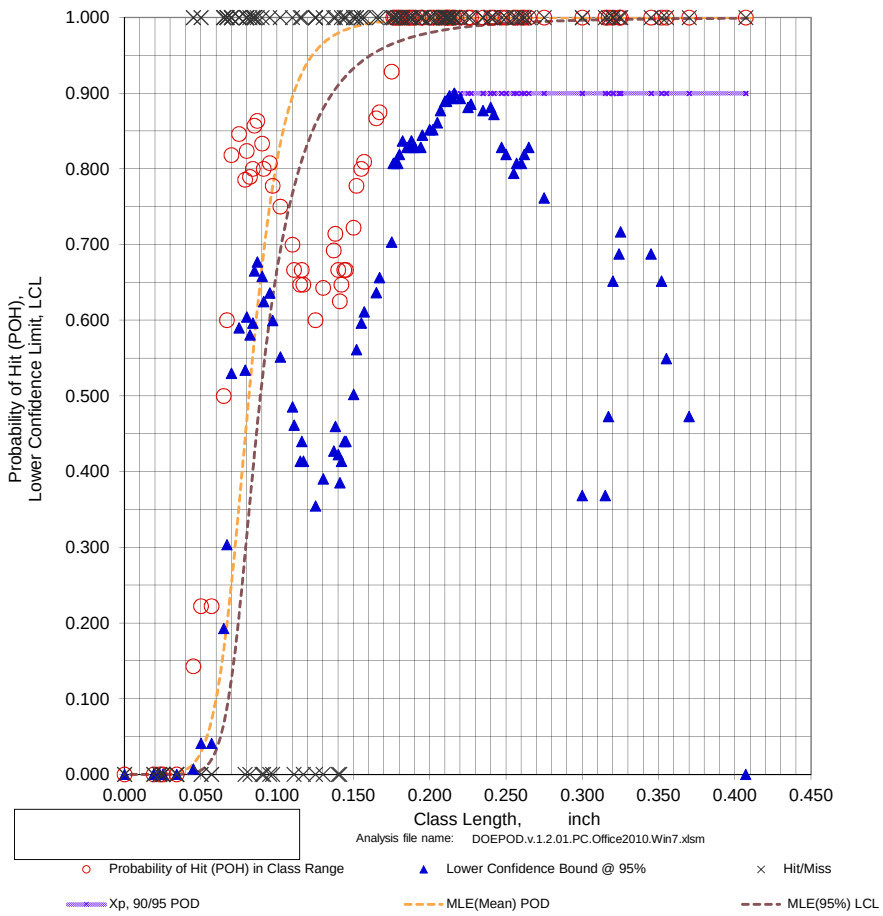
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **D3003BL.XLS**

Data Set Name = **D3003BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:22 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0340 | inch |
| Classlength @ 90/95 Xpod = | 0.2160 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.1440 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.922 | @ | 0.115 | inch |
| NTIAC 90/95 POD = | 0.911 | @ | 0.140 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.265 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.176 | inch |
| Samples Needed @Xpodopt = | 15 | |
| Xp = | 0.2160 | inch |

File Name = D3003BL.XLS
Data Set Name = D3003BL(CRK #)

## Directed DOE Options

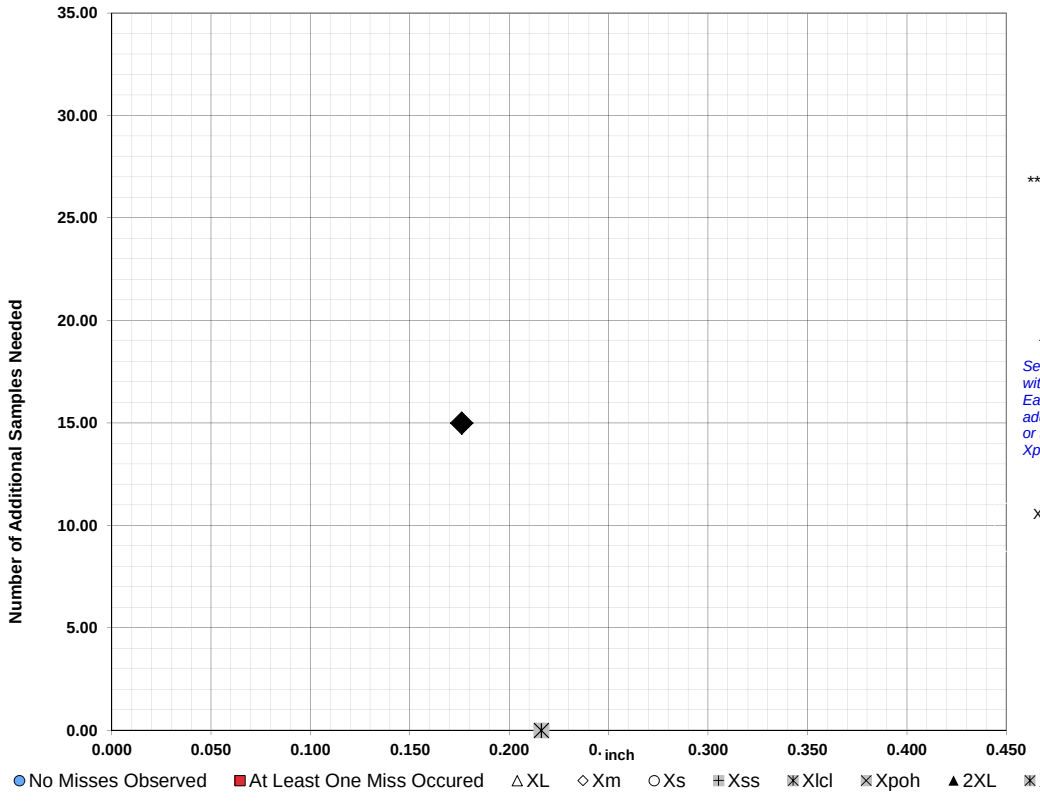



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.407 | |
| Xm = | 0.265 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.176 | 15 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

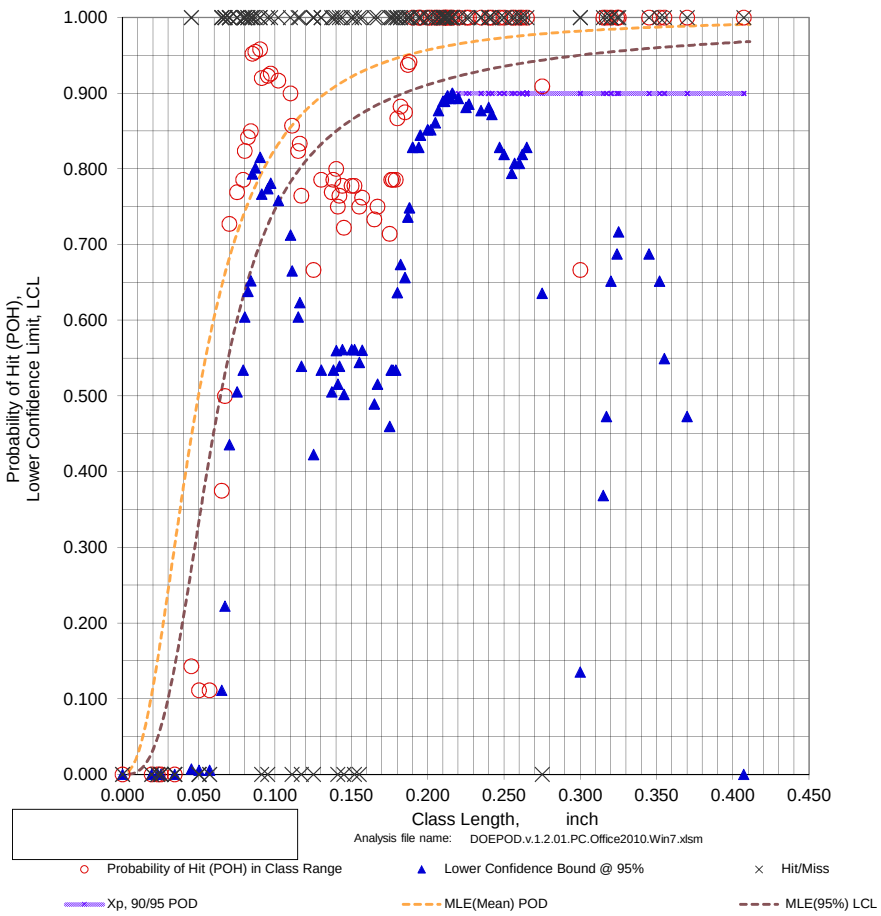
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.648.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D3003CL.XLS**

Data Set Name = **D3003CL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:23 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0340 | inch |
| Classlength @ 90/95 Xpod = | 0.2160 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.135 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.185 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.407 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.265 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.2160 | inch |

File Name = D3003CL.XLS
Data Set Name = D3003CL(CRK #)

## Directed DOE Options

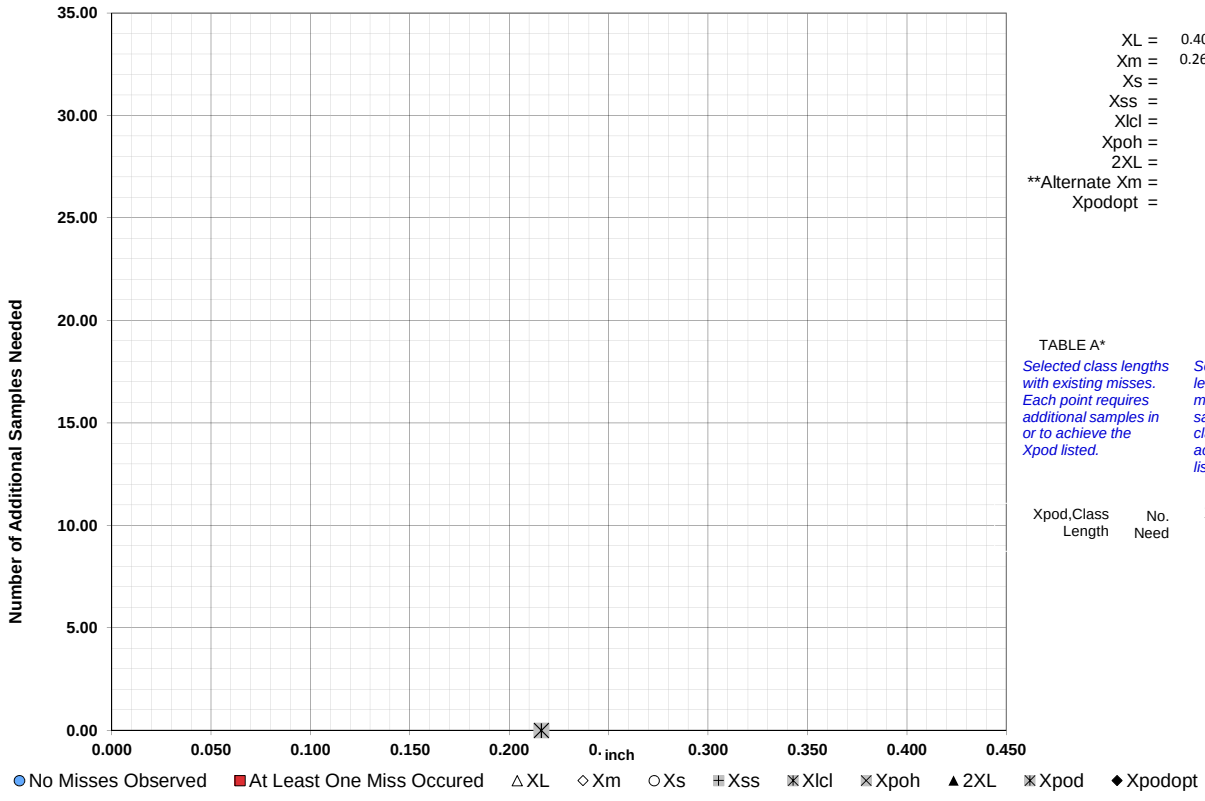



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.407 |
| Xm = | 0.265 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

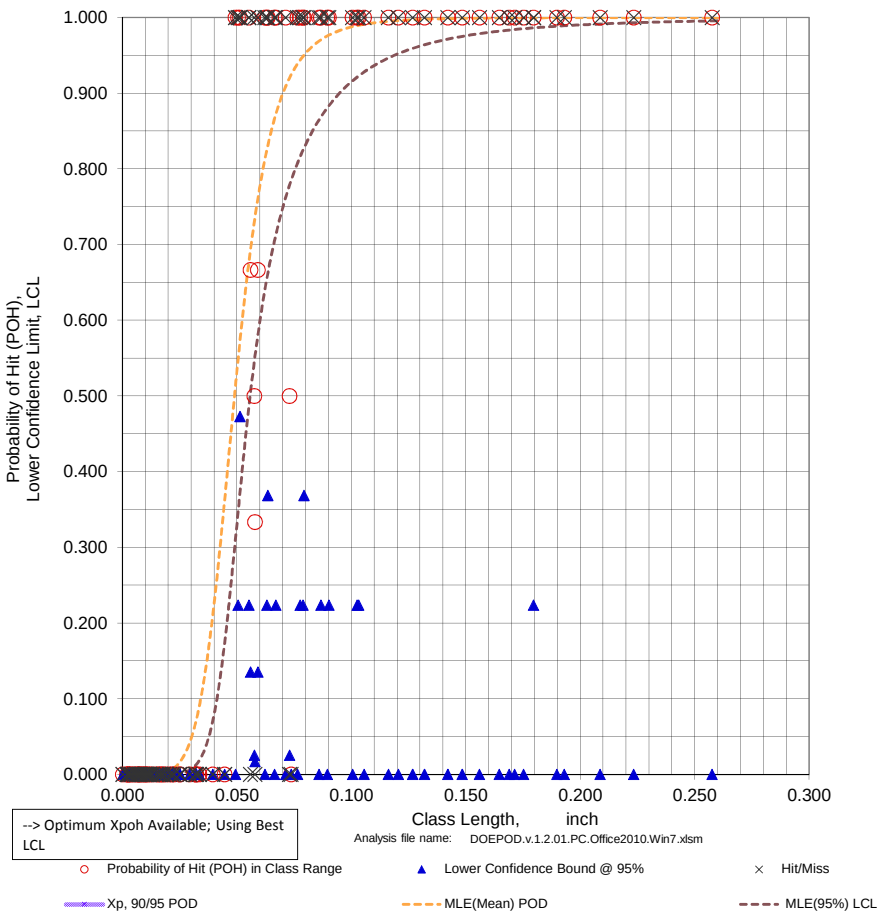
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D4004.XLS
Data Set Name = D4004(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:24 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4729 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.0512 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.0764 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.932 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.095 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.257 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.076 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D4004.XLS
Data Set Name = D4004(HOLE #)

## Directed DOE Options

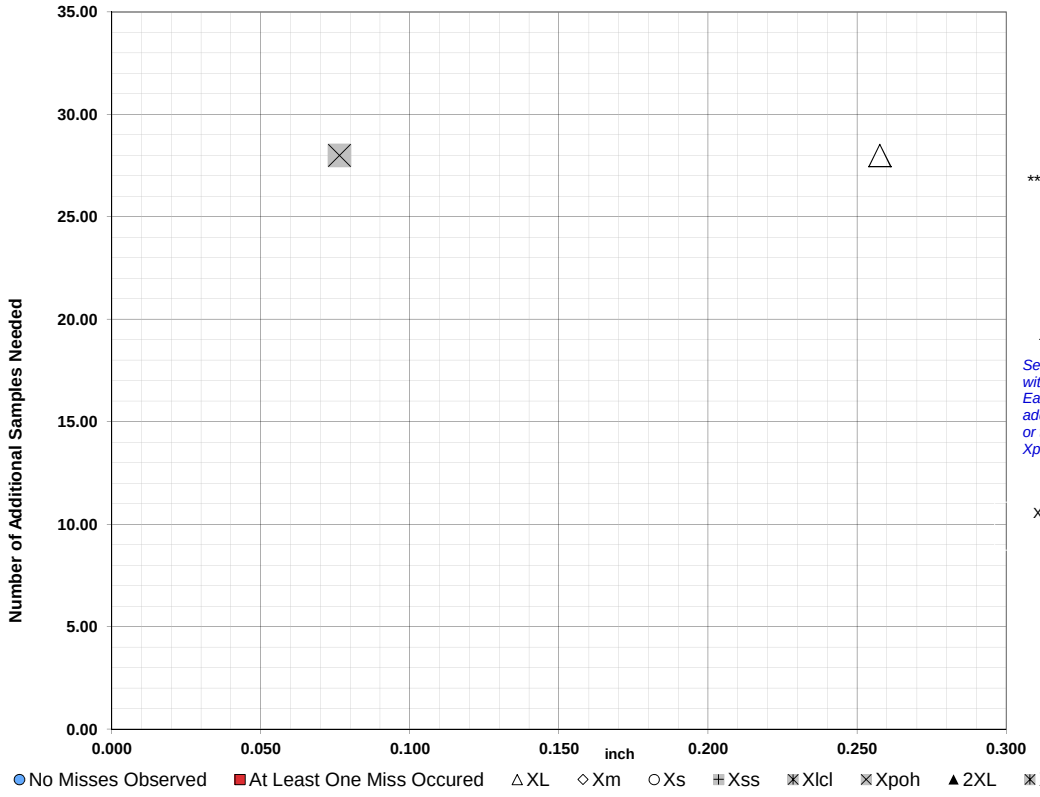



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.257 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.076 | 28 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

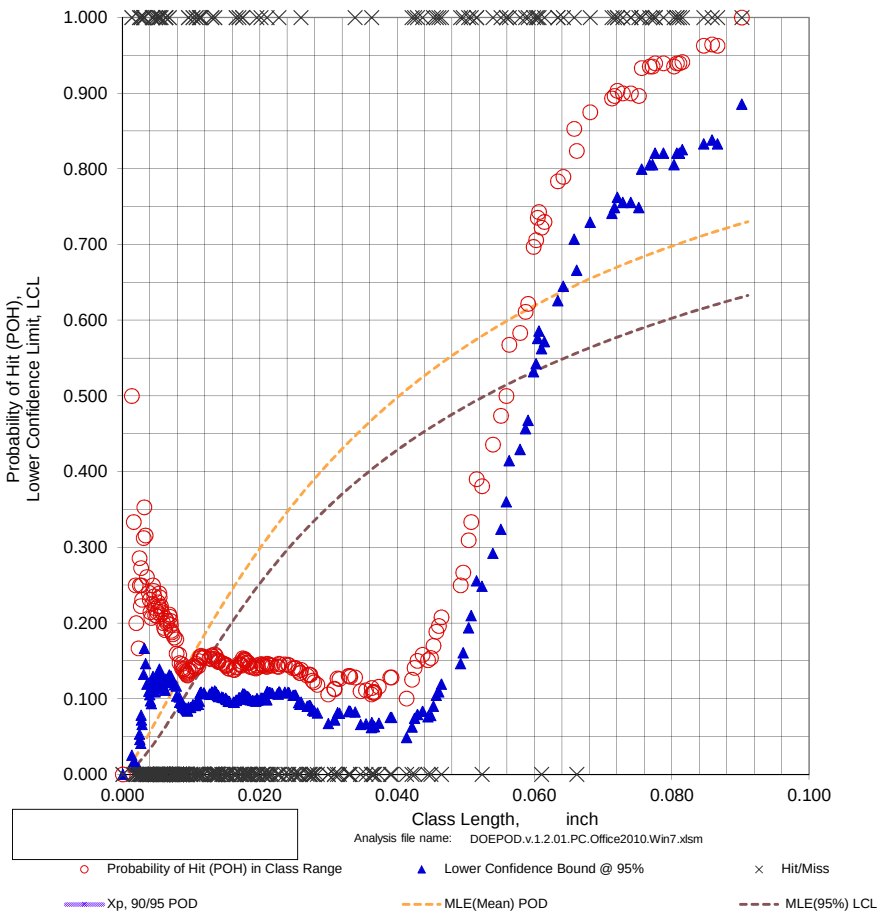
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D5004.XLS
Data Set Name = D5004(HOLE #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:25 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8855 | |
| Classwidth @ Best LCL = | 0.0230 | inch |
| Classlength @ Best LCL = | 0.0902 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0681 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.245 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.510 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.090 | inch |
| Samples Needed @ XL = | 4 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.090 | inch |
| Samples Needed @ Xlcl = | 4 | |
| POH Classlength, Xpoh = | 0.090 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.180 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D5004.XLS
Data Set Name = D5004(HOLE #)

## Directed DOE Options

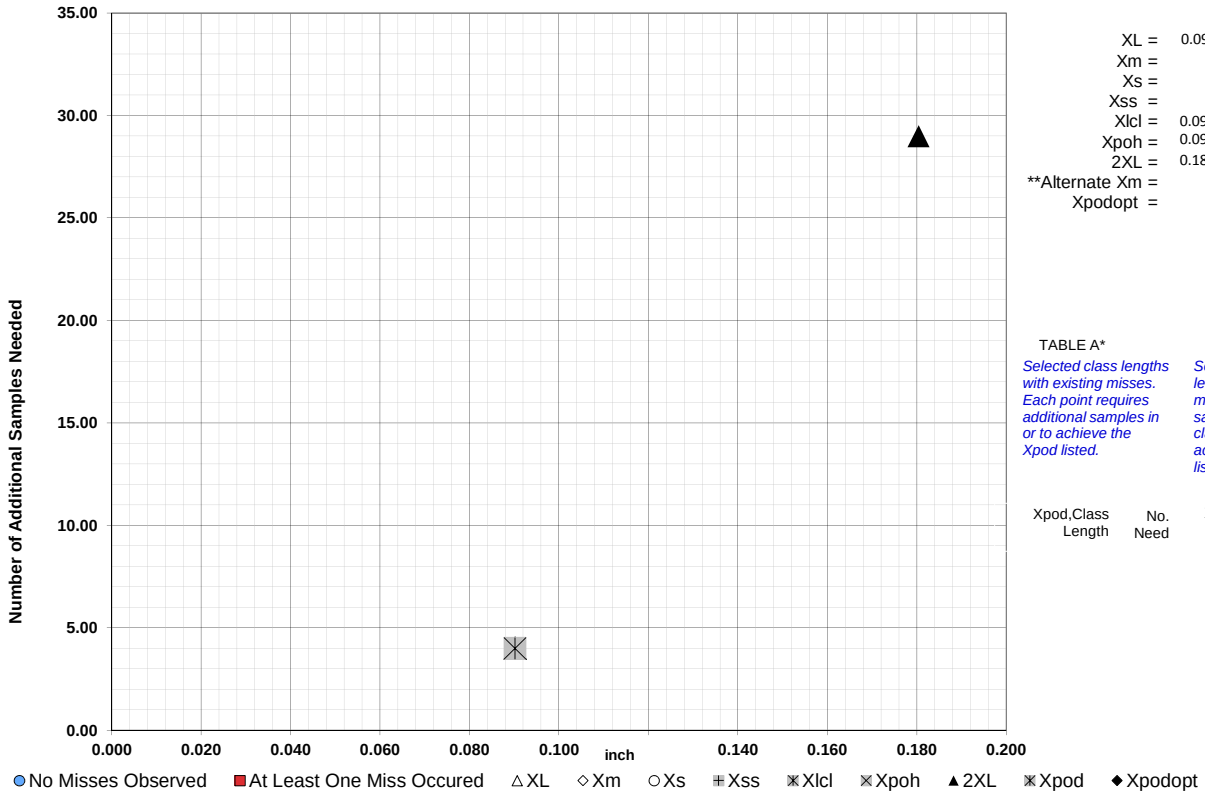



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.090 | 4 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.090 | 4 |
| Xpoh = | 0.090 | |
| 2XL = | 0.180 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

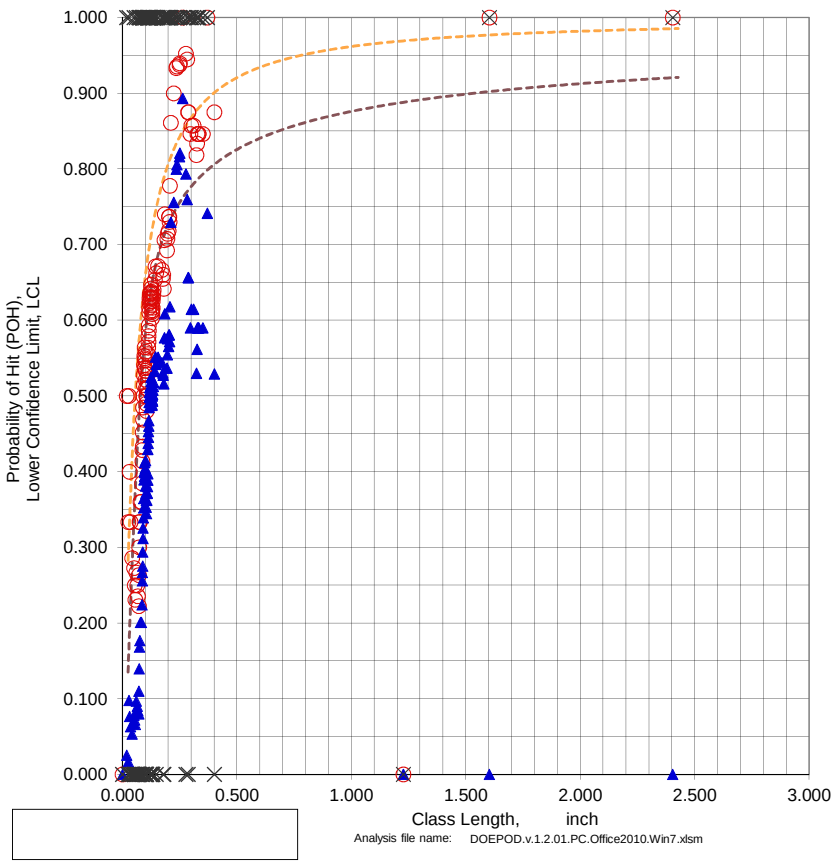
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D6001AL.XLS
Data Set Name = D6001AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:28 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0800 | inch |
| Classlength @ Best LCL = | 0.2620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.400 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D6001AL.XLS
Data Set Name = D6001AL(CRK #)

## Directed DOE Options

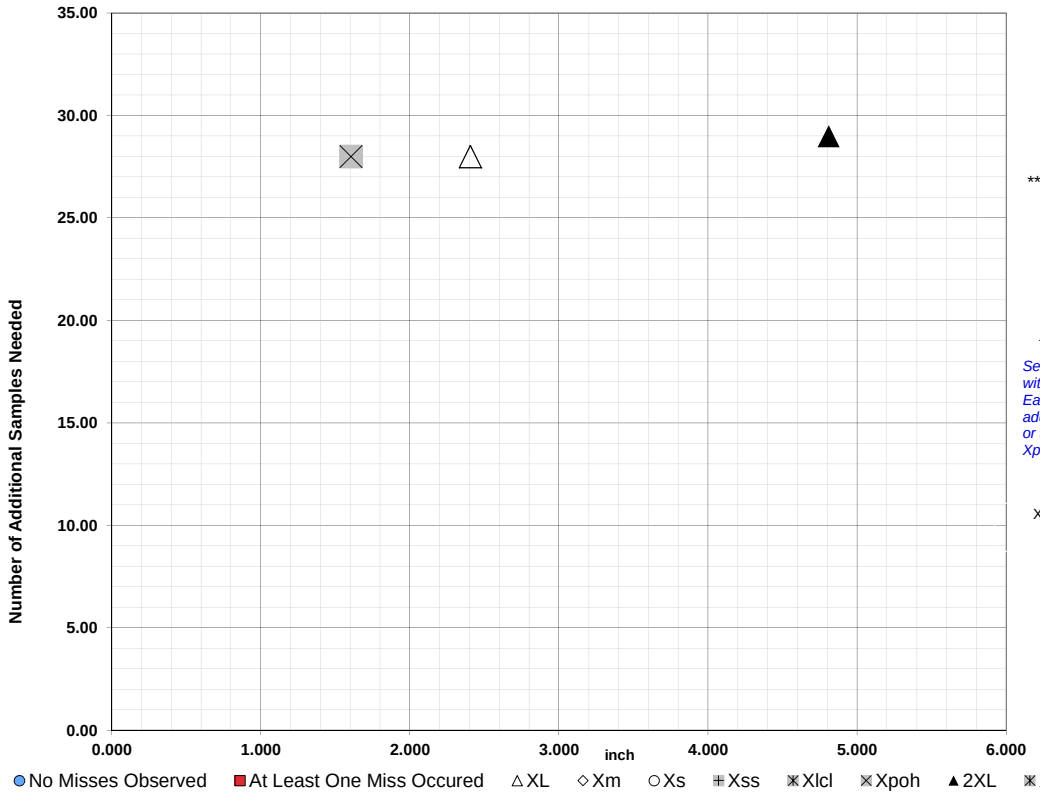



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

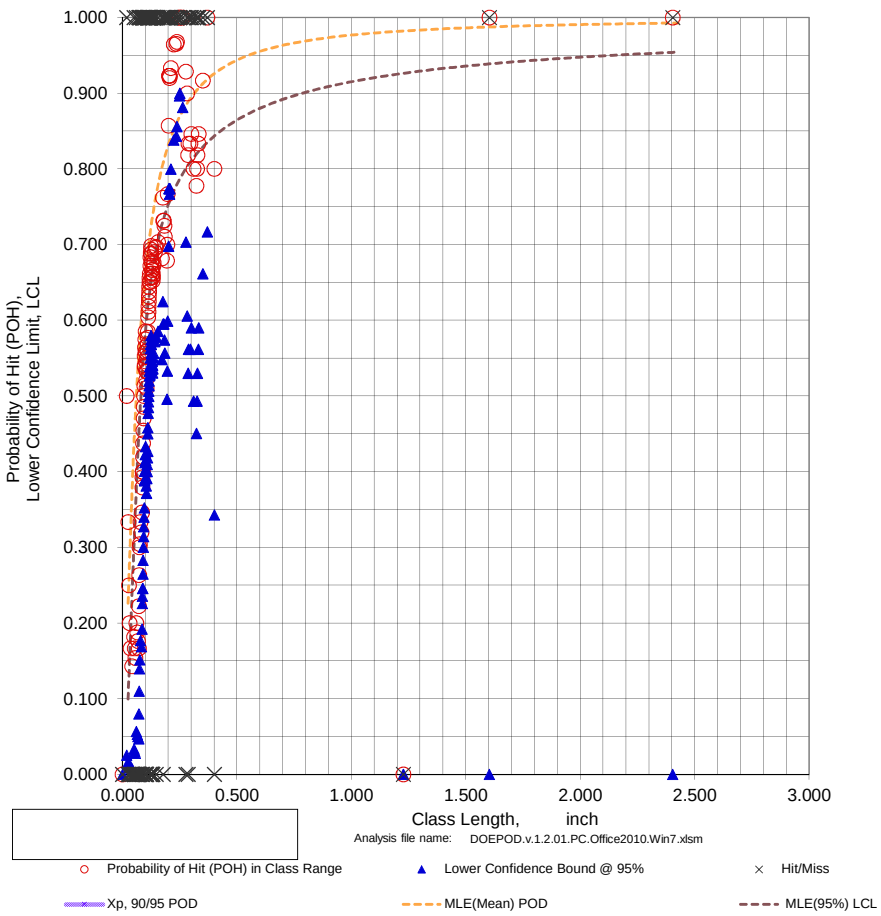
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 20 more large flaws.**

**Warning: No false call analysis.**




File Name = **D6001BL.XLS**

Data Set Name = **D6001BL(CRK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:30 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0700 | inch |
| Classlength @ 90/95 Xpod = | 0.2500 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.315 | inch |
| NTIAC 90/95 POD = | | @ | | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | 1.603 | inch |
| Samples Needed @ Xm = | 28 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D6001BL.XLS
Data Set Name = D6001BL(CRK #)

## Directed DOE Options

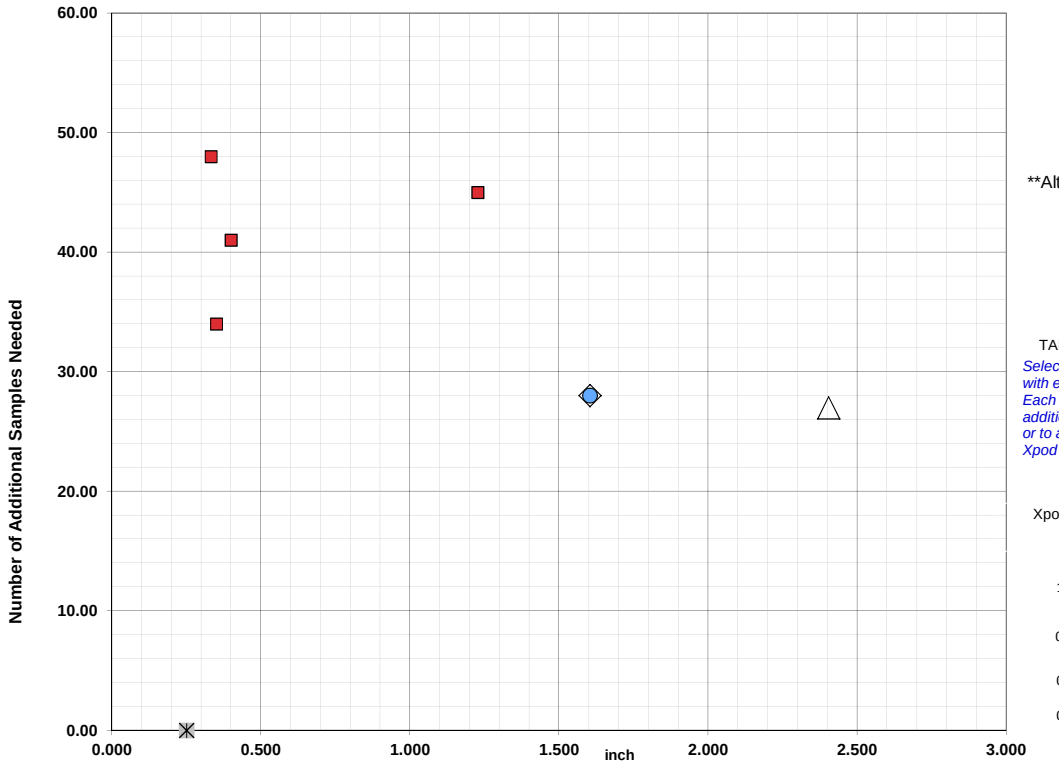



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 27 |
| Xm = | 1.603 | 28 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2270 | 45 |
| 0.4000 | 41 |
| 0.3500 | 34 |
| 0.3320 | 48 |

TABLE B*

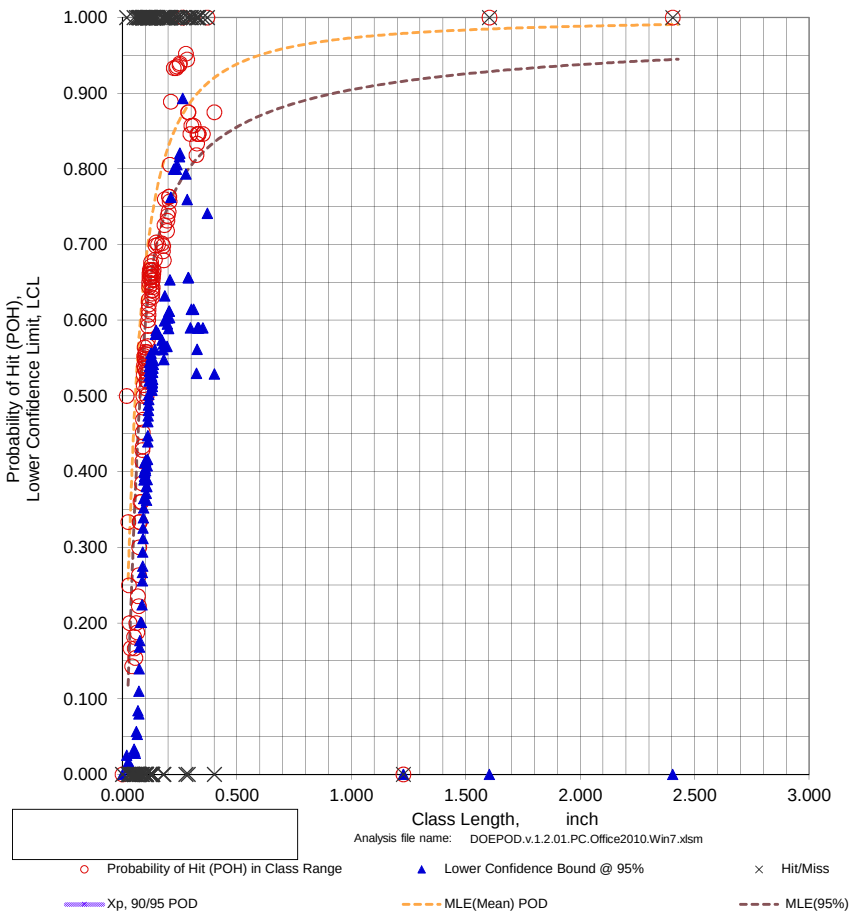
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.6030 | 28 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D6001CL.XLS
Data Set Name = D6001CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:31 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0800 | inch |
| Classlength @ Best LCL = | 0.2620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.330 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D6001CL.XLS
Data Set Name = D6001CL(CRK #)

## Directed DOE Options

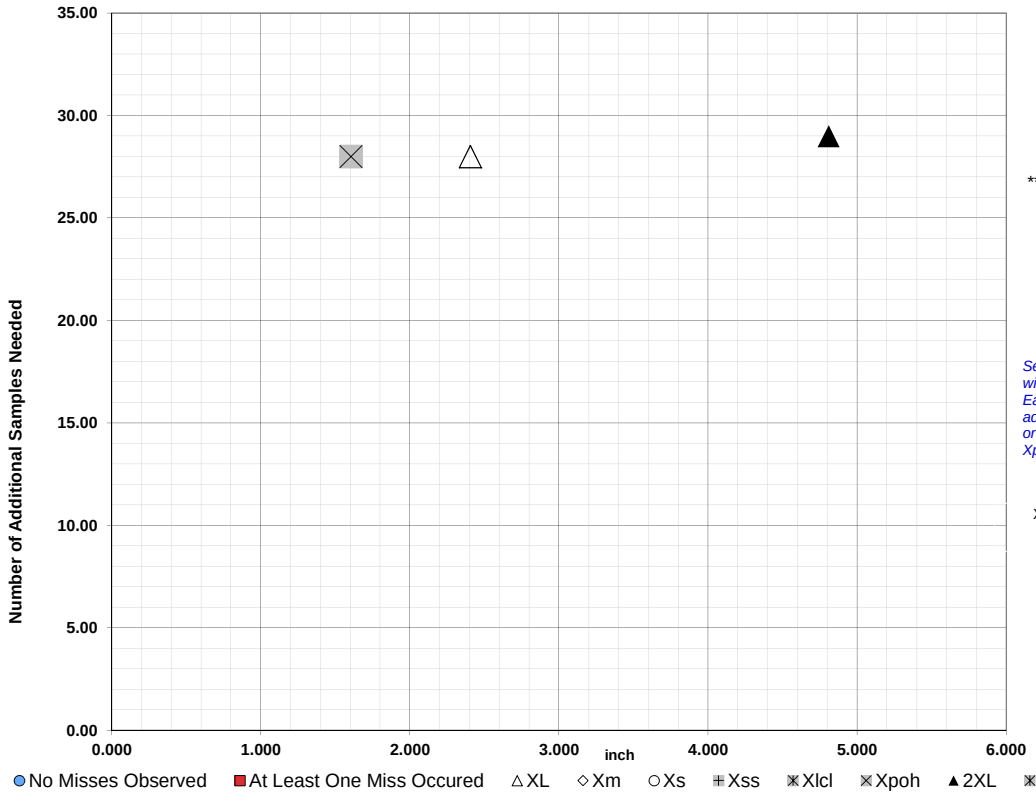



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

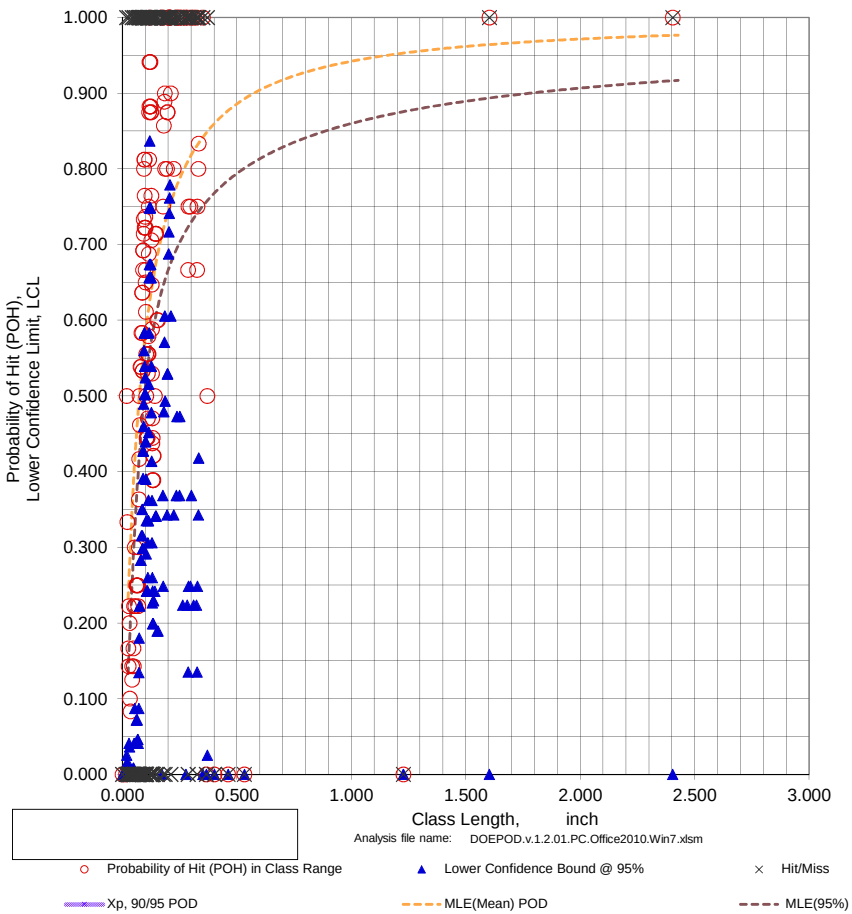
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D6003AL.XLS
Data Set Name = D6003AL(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:33 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8368 | |
| Classwidth @ Best LCL = | 0.0130 | inch |
| Classlength @ Best LCL = | 0.1183 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.575 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D6003AL.XLS
Data Set Name = D6003AL(CRK # )

## Directed DOE Options

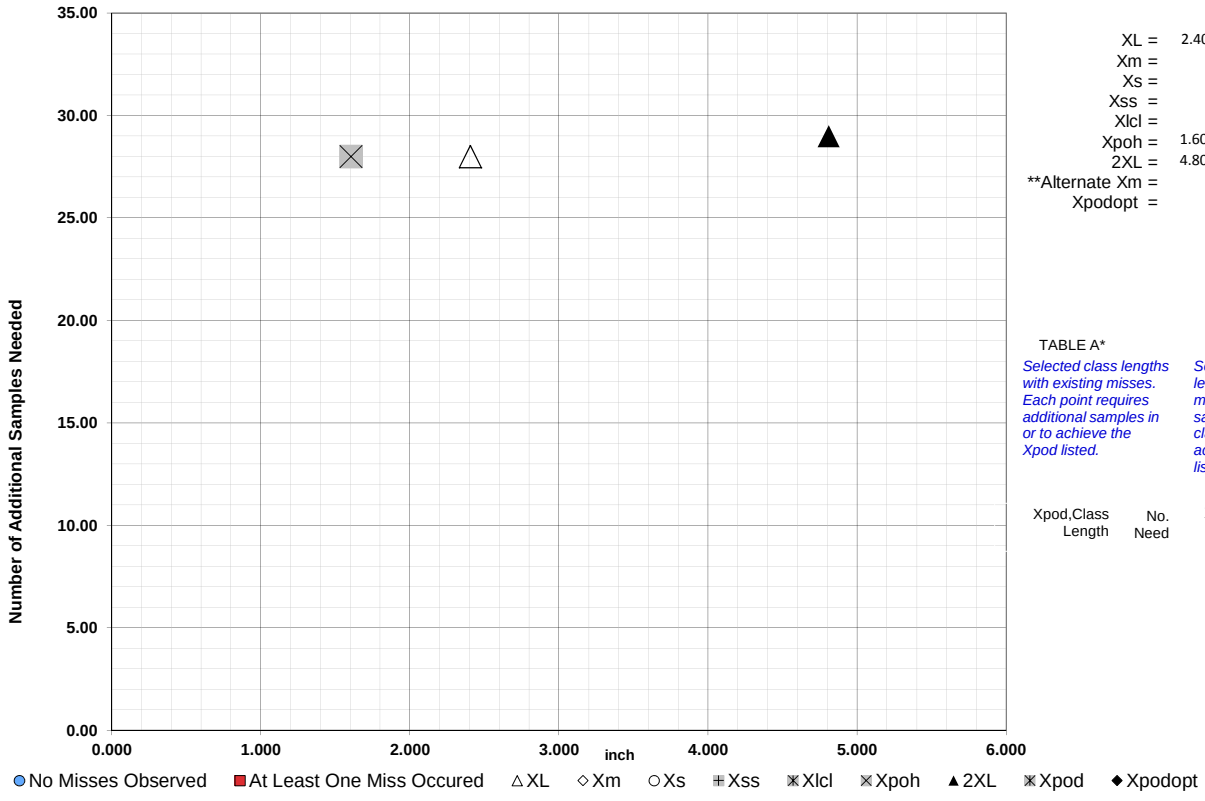



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

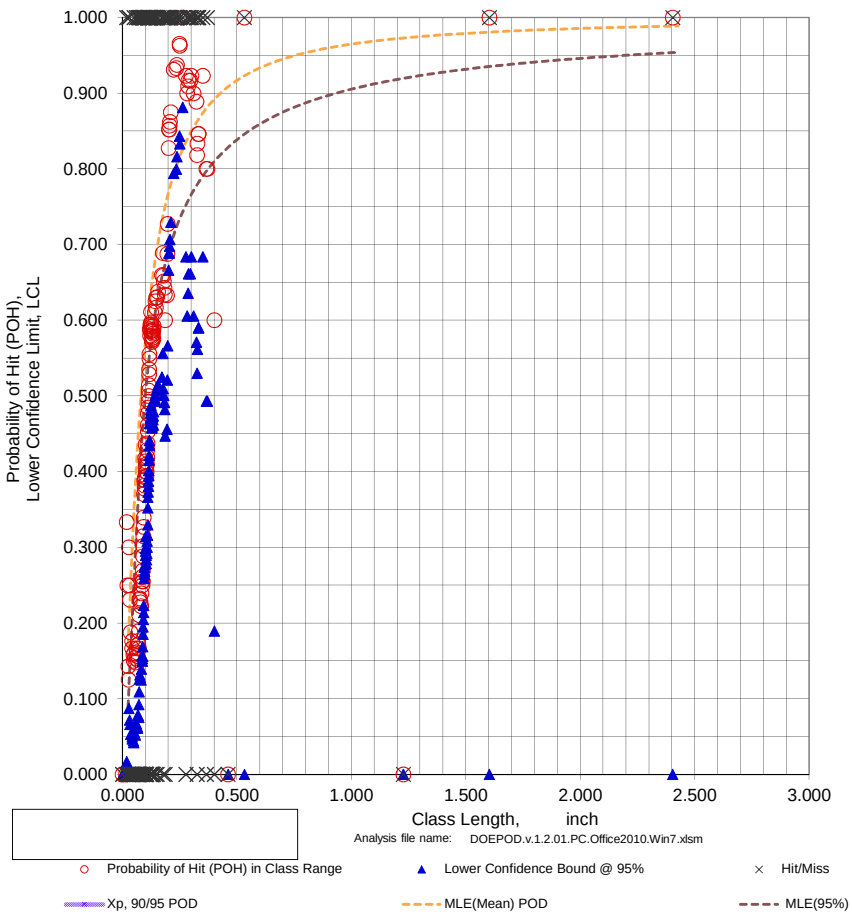
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D6003BL.XLS
Data Set Name = D6003BL(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:35 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0680 | inch |
| Classlength @ Best LCL = | 0.2620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.430 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D6003BL.XLS
Data Set Name = D6003BL(CRK # )

## Directed DOE Options

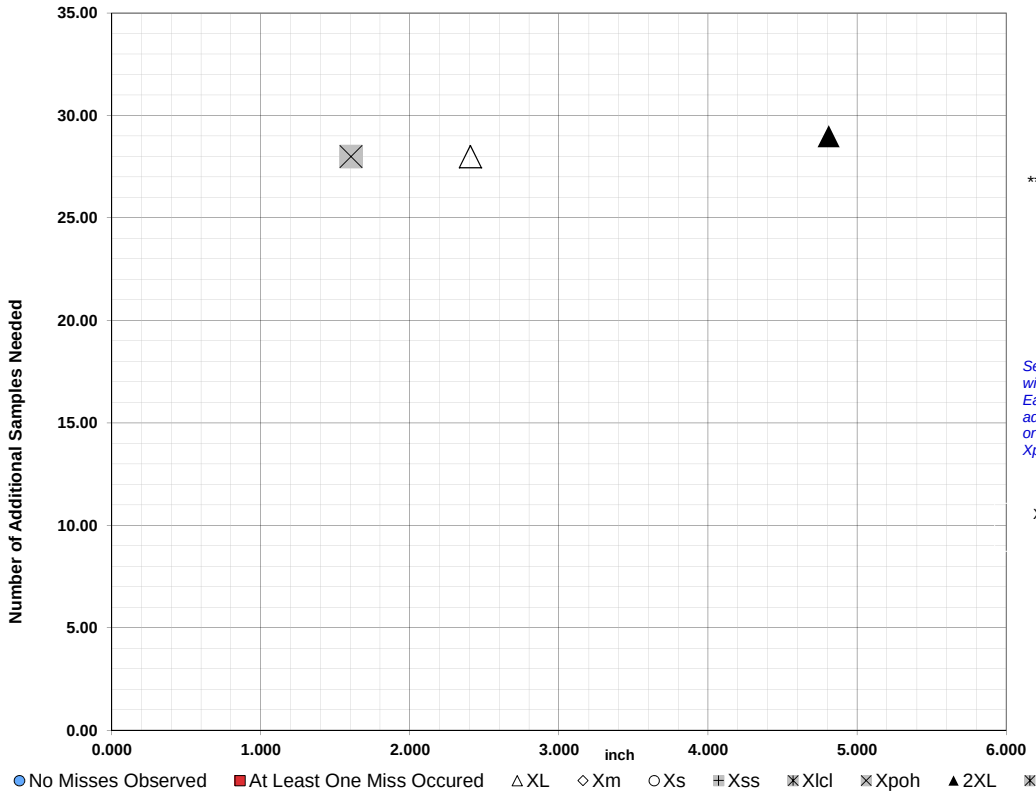



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

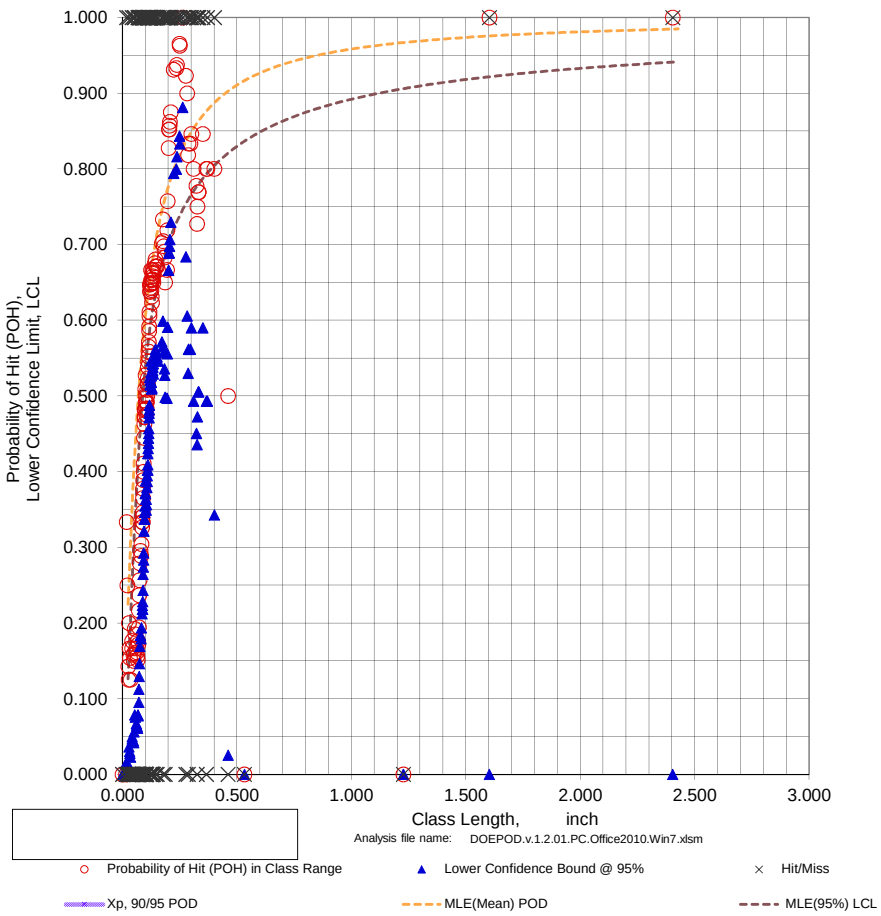
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D6003CL.XLS
Data Set Name = D6003CL(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:37 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0680 | inch |
| Classlength @ Best LCL = | 0.2620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.450 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D6003CL.XLS
Data Set Name = D6003CL(CRK # )

## Directed DOE Options

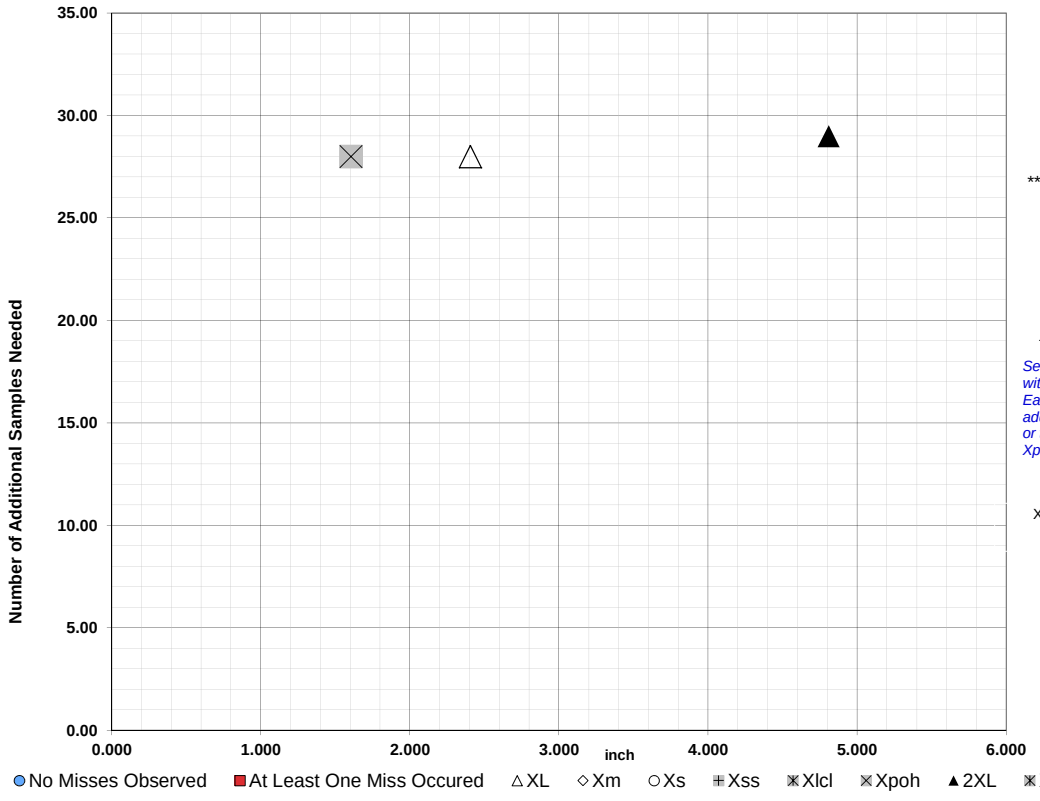



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

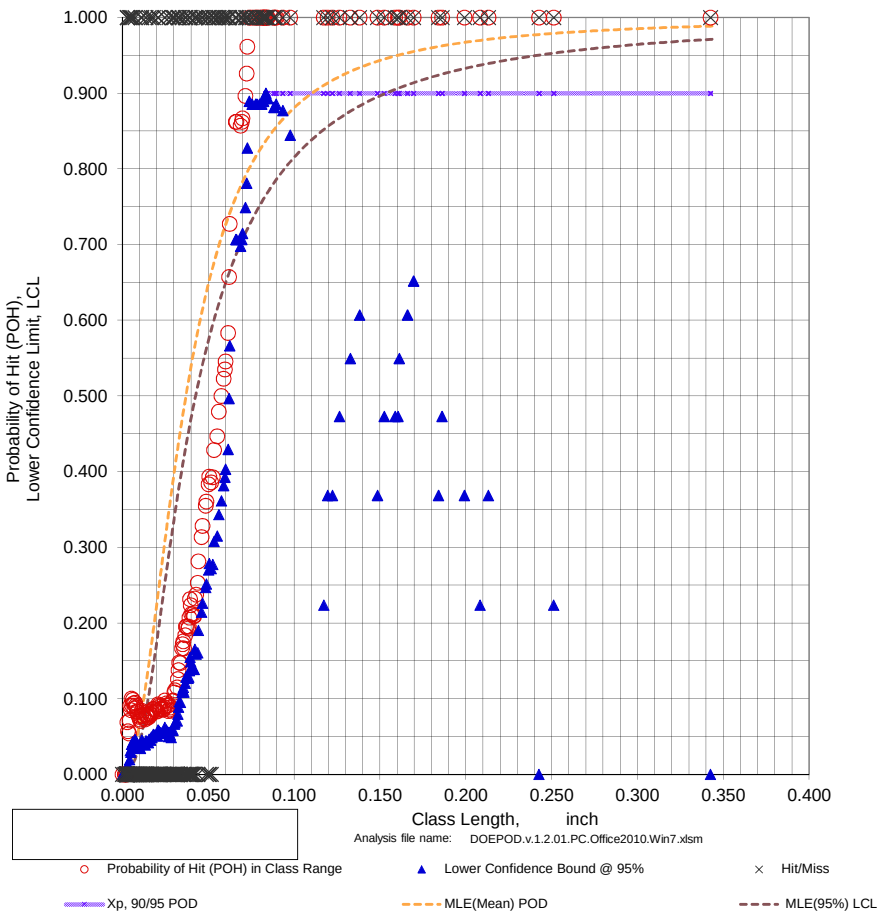
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D7001L.XLS**

Data Set Name = **D7001L(Uti-a-1)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:39 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0220 | inch |
| Classlength @ 90/95 Xpod = | 0.0833 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0532 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.907 | @ | 0.115 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.155 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.074 | inch |
| Samples Needed @Xpodopt = | 3 | |
| Xp = | 0.0833 | inch |

File Name = D7001L.XLS
Data Set Name = D7001L(Uti-a-1)

## Directed DOE Options

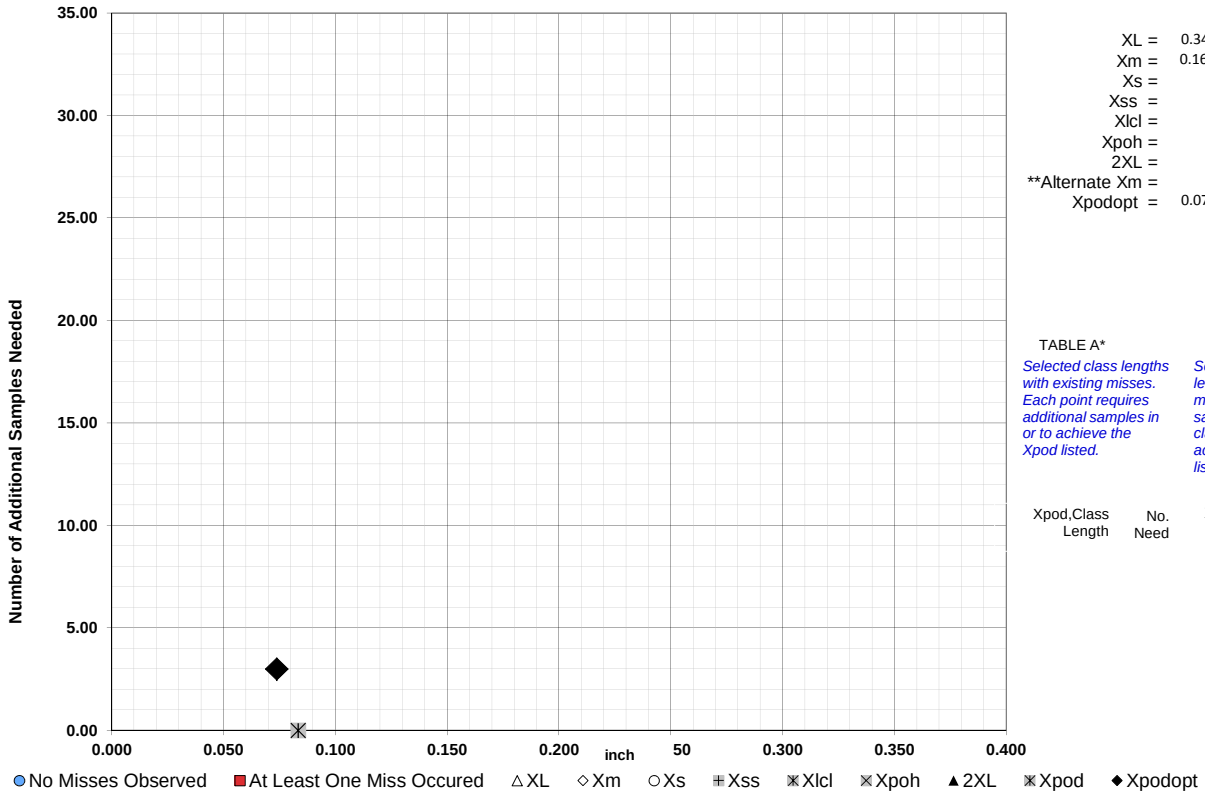



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.074 | 3 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

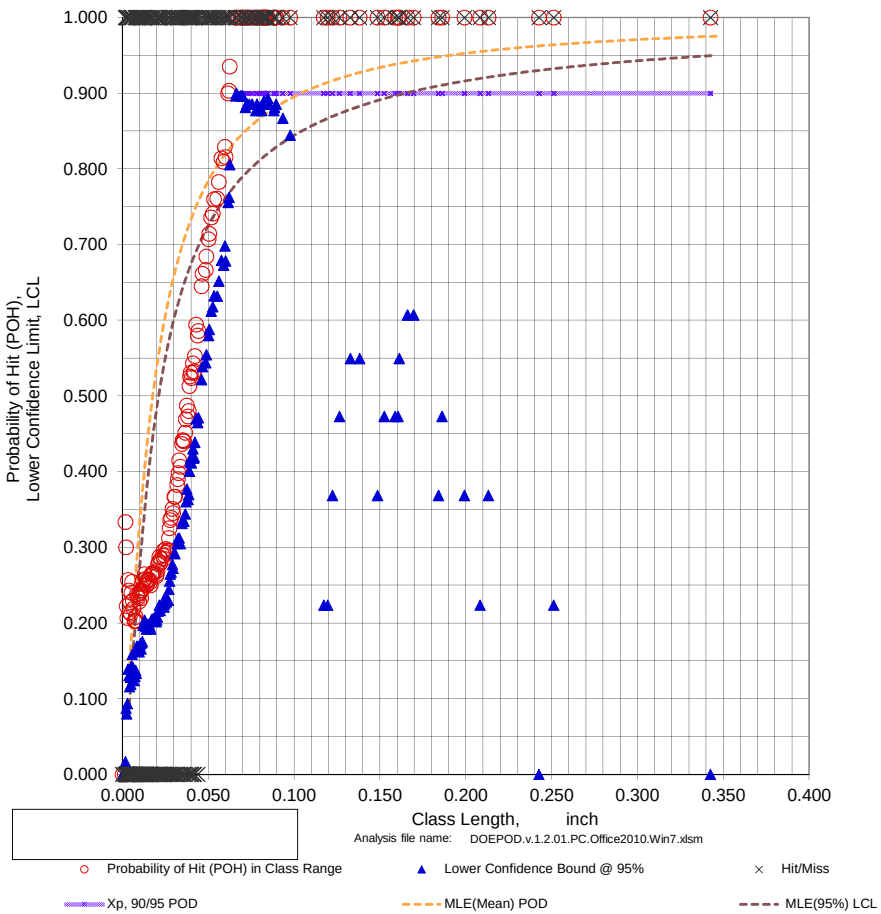
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D7002L.XLS**
Data Set Name = **D7002L(Uti-a-2)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:40 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0210 | inch |
| Classlength @ 90/95 Xpod = | 0.0663 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0460 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.165 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.066 | inch |
| Samples Needed @Xpodopt = | 1 | |
| Xp = | 0.0663 | inch |

File Name = D7002L.XLS
Data Set Name = D7002L(Uti-a-2)

## Directed DOE Options

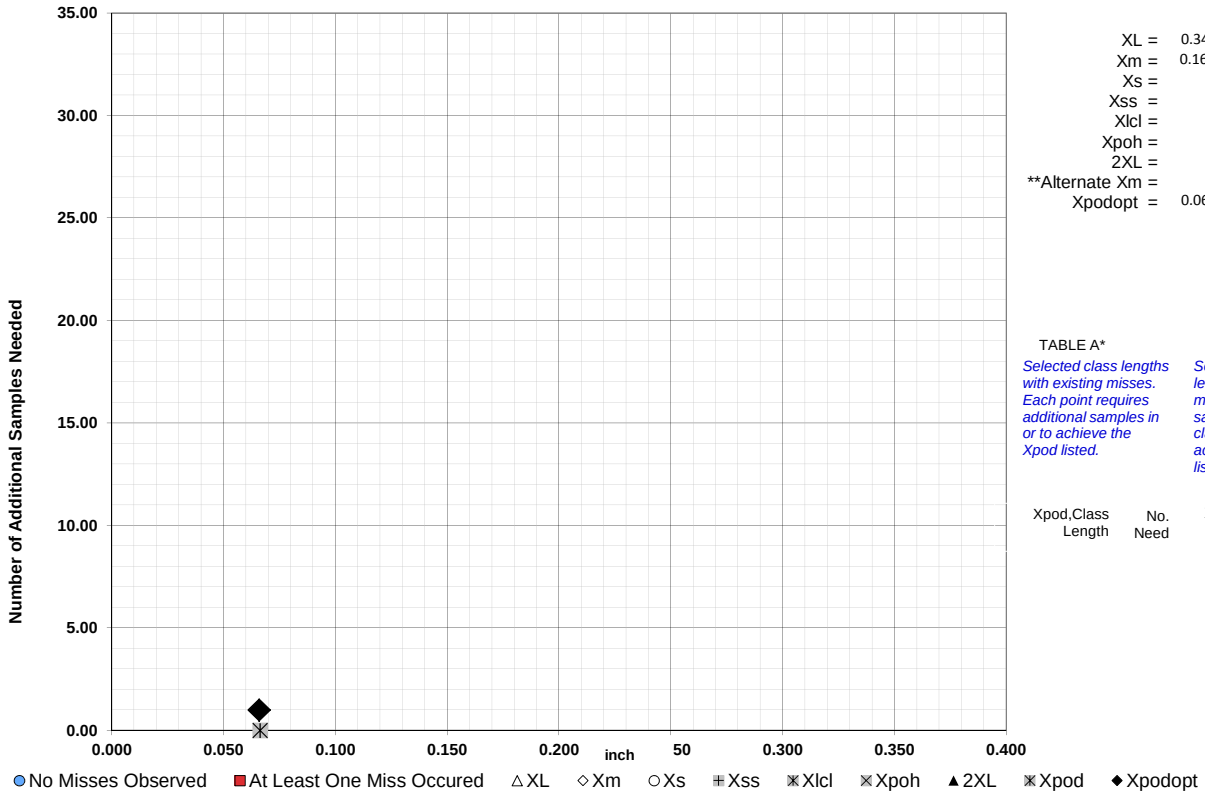



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.066 | 1 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

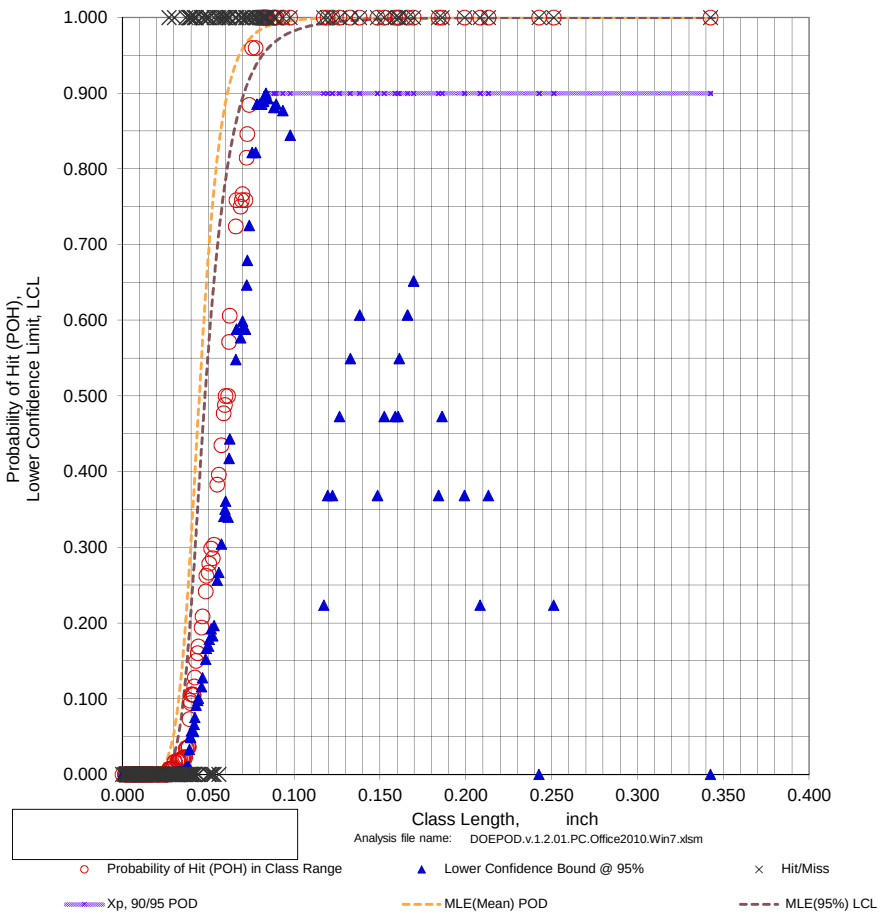
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **D7003L.XLS**

Data Set Name = **D7003L(Uti-c)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:41 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0220 | inch |
| Classlength @ 90/95 Xpod = | 0.0833 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0575 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.933 | @ | 0.065 | inch |
| NTIAC 90/95 POD = | 0.925 | @ | 0.075 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.078 | inch |
| Samples Needed @Xpodopt = | 4 | |
| Xp = | 0.0833 | inch |

File Name = D7003L.XLS
Data Set Name = D7003L(Uti-c)

## Directed DOE Options

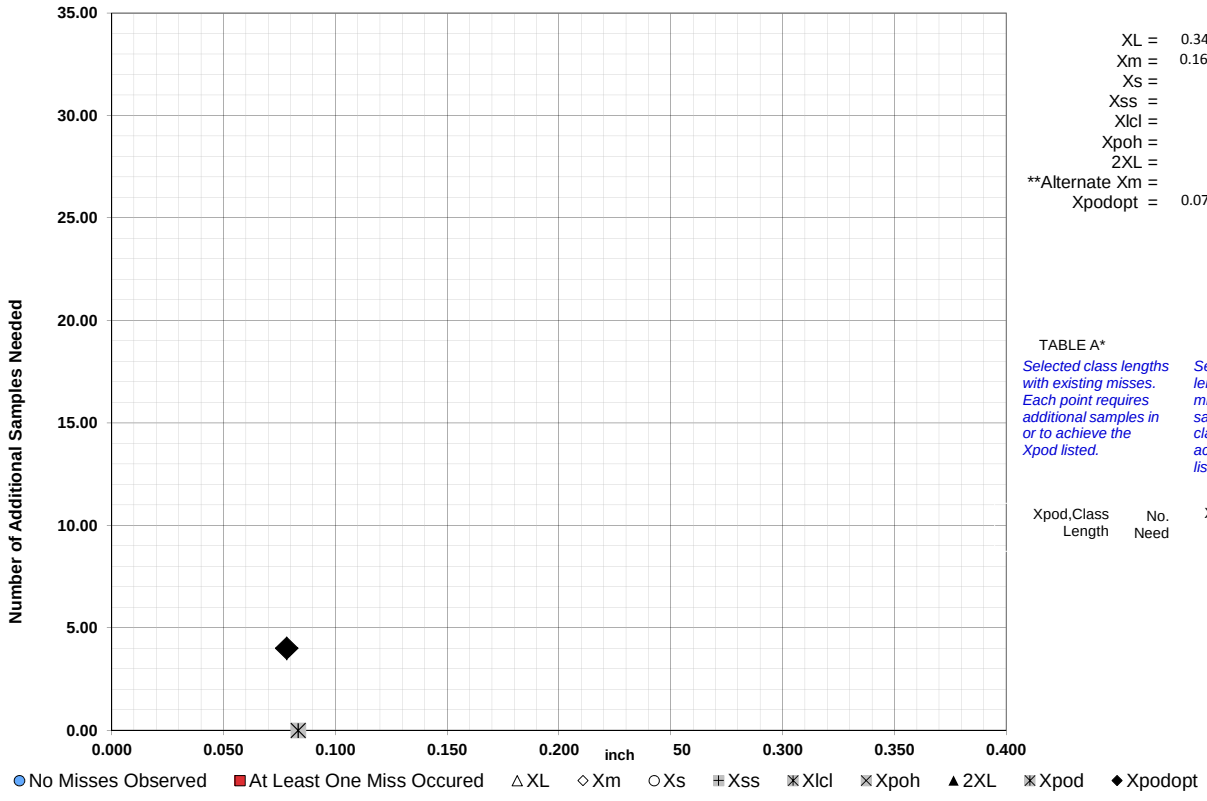



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.078 | 4 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

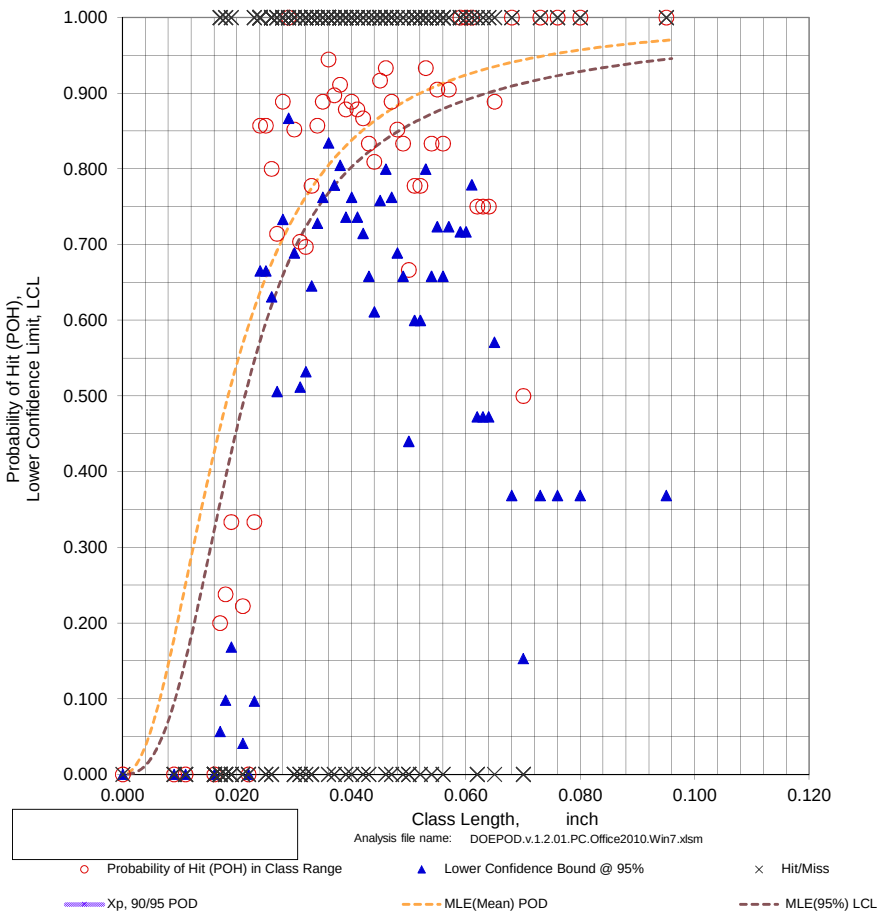
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D8001(3)D.xls
Data Set Name = D8001(3)D(CK. NO)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:42 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.0290 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0730 -0.002 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.910 | @ | 0.055 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.065 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.095 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.073 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.190 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D8001(3)D.xls
Data Set Name = D8001(3)D(CK. NO)

## Directed DOE Options

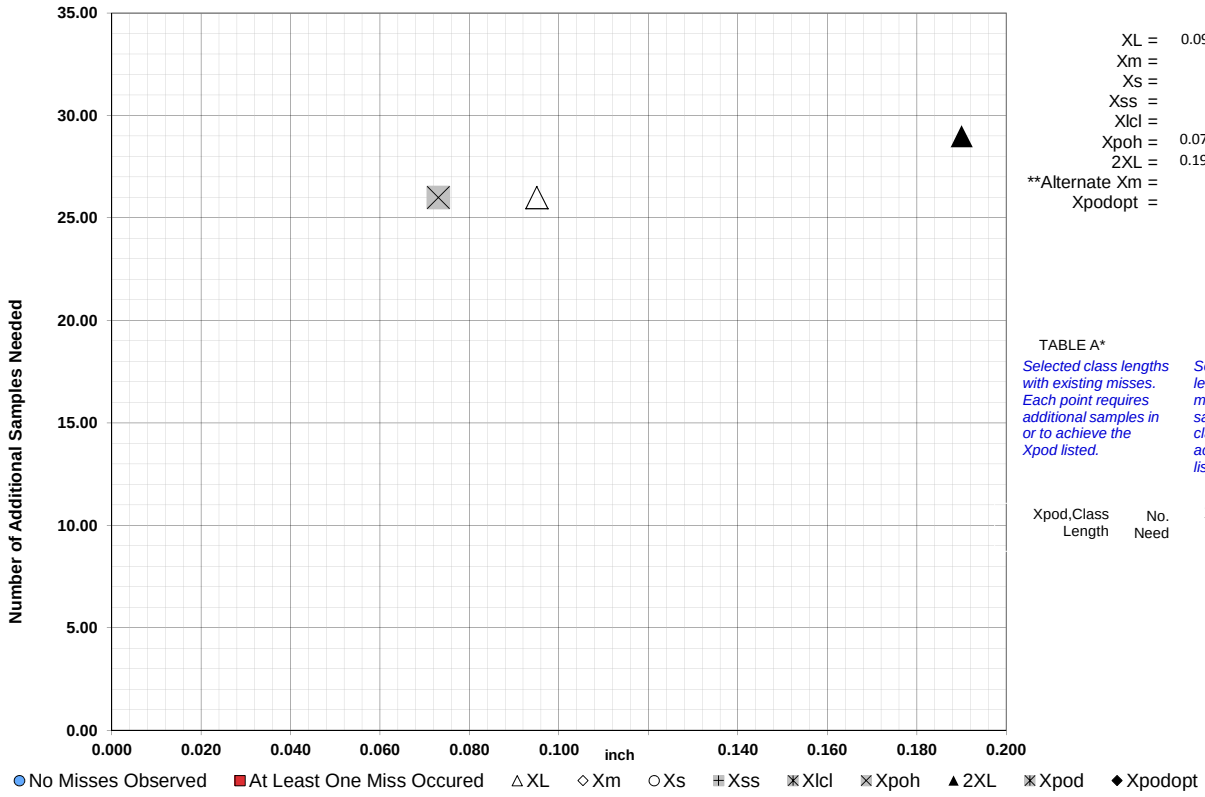



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.073 | 26 |
| 2XL = | 0.190 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

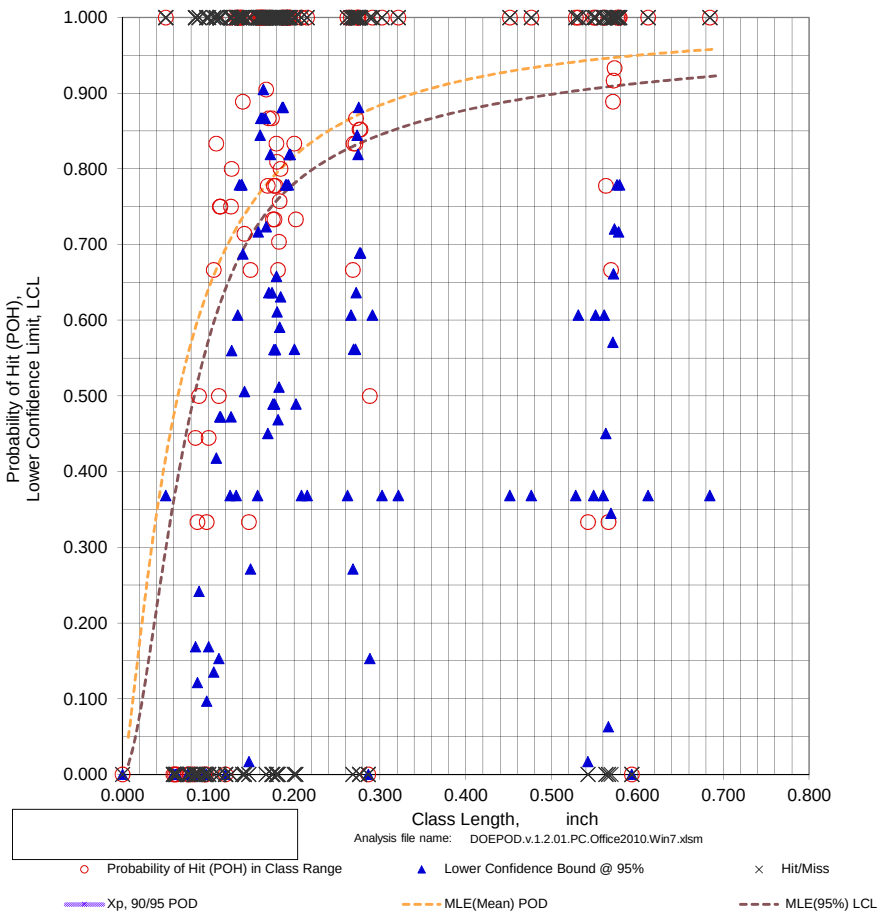
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Warning: No false call analysis.**




File Name = **D8001(3)L.xls**

Data Set Name = **D8001(3)L(CK. NO)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:44 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0040 | inch |
| Classlength @ 90/95 Xpod = | 0.1640 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.340 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.510 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | 0.551 | inch |
| Samples Needed @ Xm = | 23 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D8001(3)L.xls
Data Set Name = D8001(3)L(CK. NO)

## Directed DOE Options

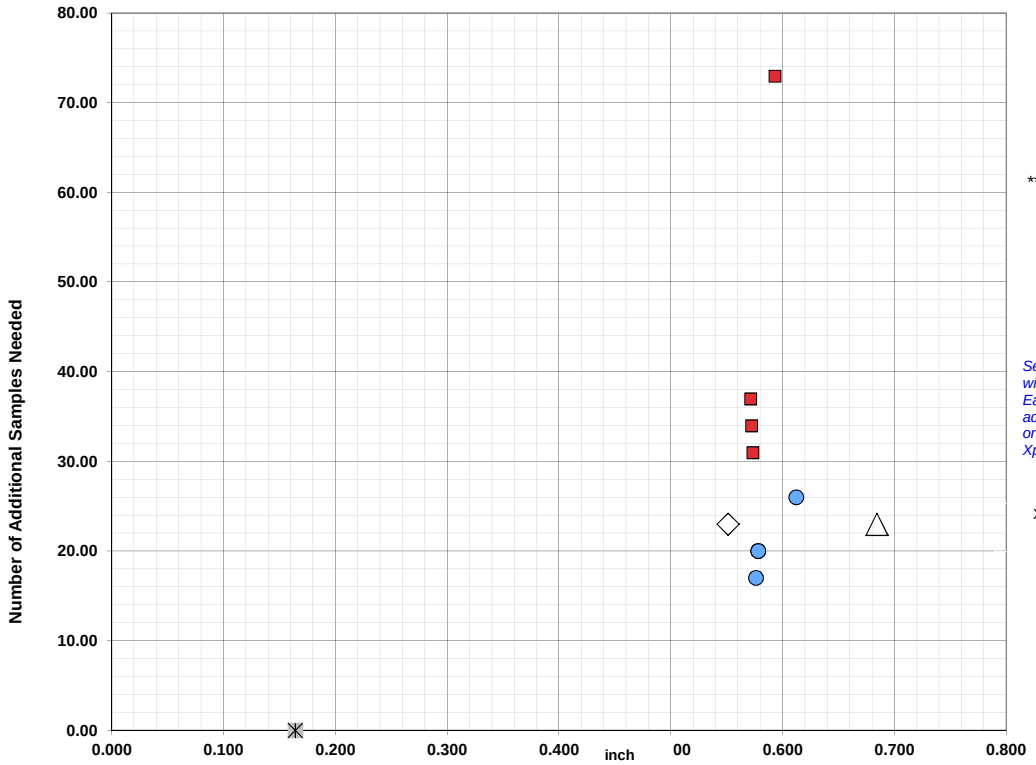



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | 23 |
| Xm = | 0.551 | 23 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5930 | 73 |
| 0.5730 | 31 |
| 0.5720 | 34 |
| 0.5710 | 37 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.6120 | 26 |
| 0.5780 | 20 |
| 0.5780 | 20 |
| 0.5760 | 17 |

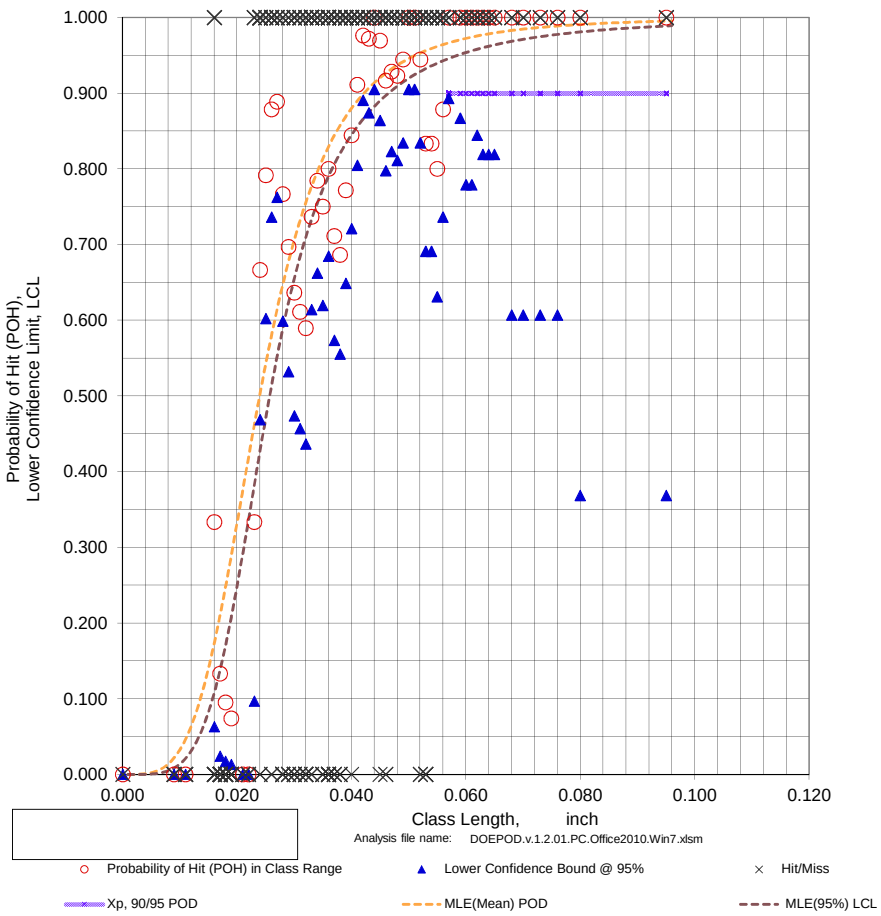
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.132.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D8002(3)D.xls**

Data Set Name = **D8002(3)D(CK.NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:46 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0030 | inch |
| Classlength @ 90/95 Xpod = | 0.0440 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.921 | @ | 0.045 | inch |
| NTIAC 90/95 POD = | 0.920 | @ | 0.050 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.095 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.057 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0570 | inch |

File Name = D8002(3)D.xls
Data Set Name = D8002(3)D(CK.NO.)

## Directed DOE Options

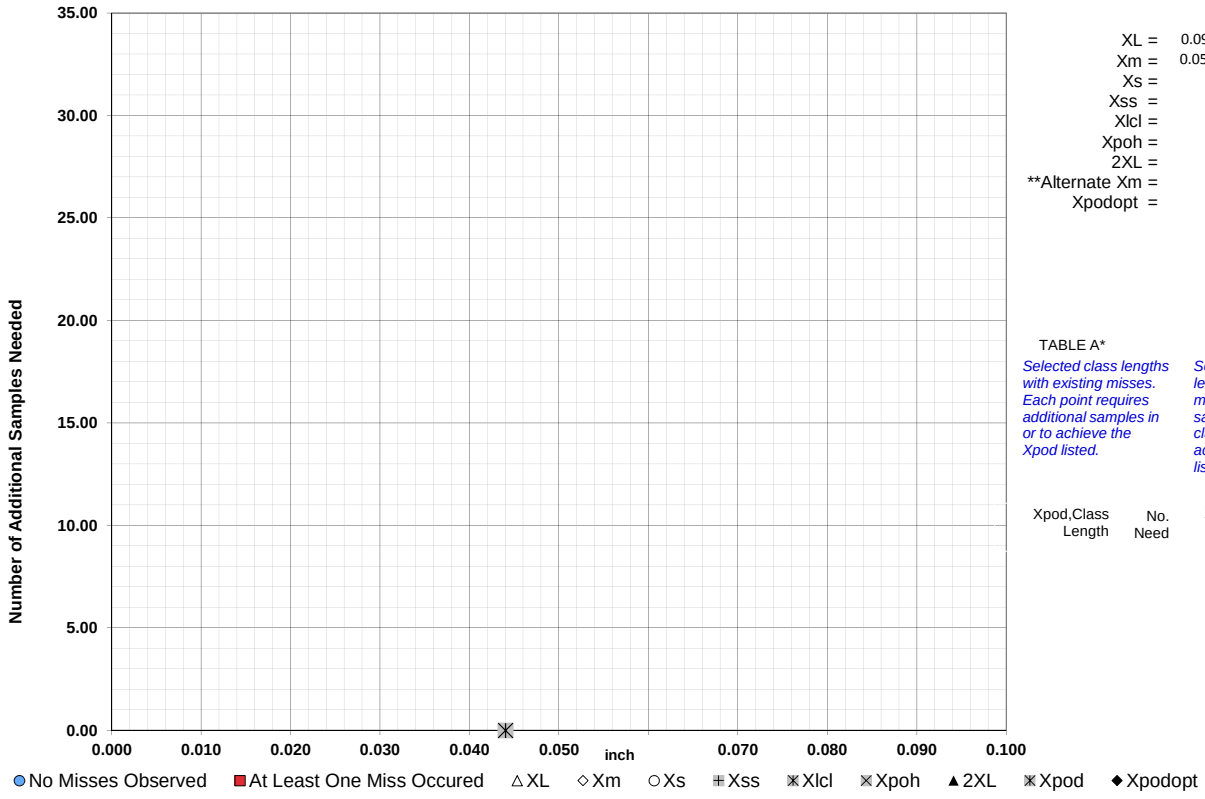



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.095 |
| Xm = | 0.057 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

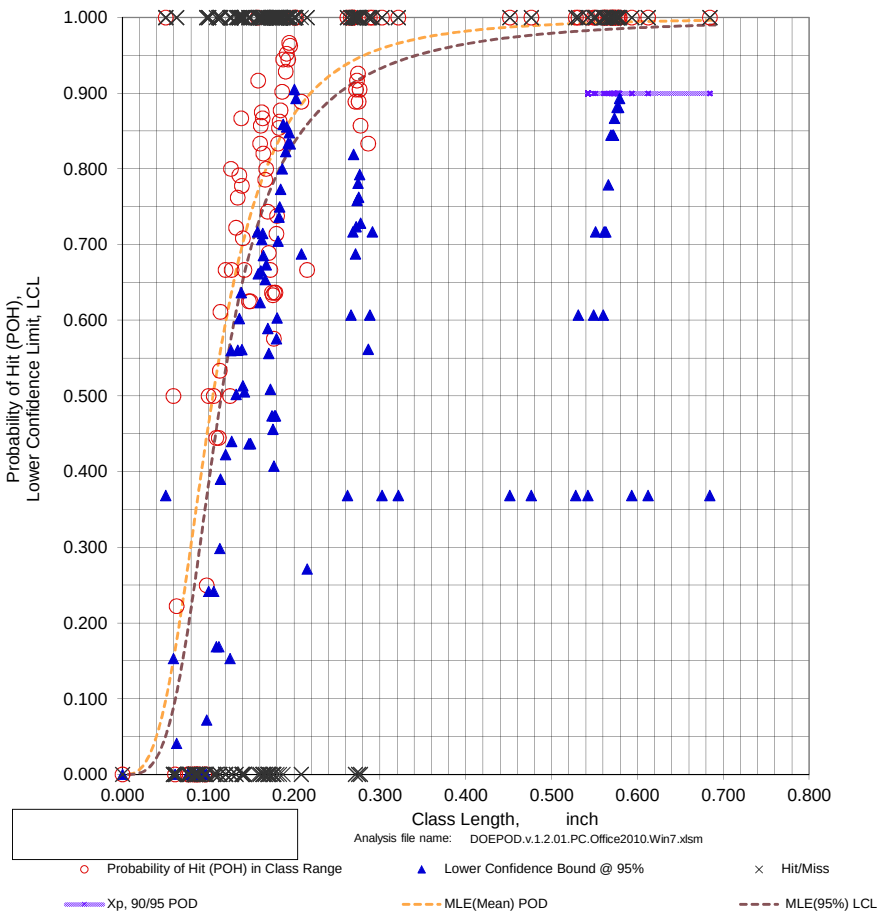
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 12 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **D8002(3)L.xls**

Data Set Name = **D8002(3)L(CK.NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:48 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0100 | inch |
| Classlength @ 90/95 Xpod = | 0.2000 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.220 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.255 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.563 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.5420 | inch |

File Name = D8002(3)L.xls
Data Set Name = D8002(3)L(CK.NO.)

## Directed DOE Options

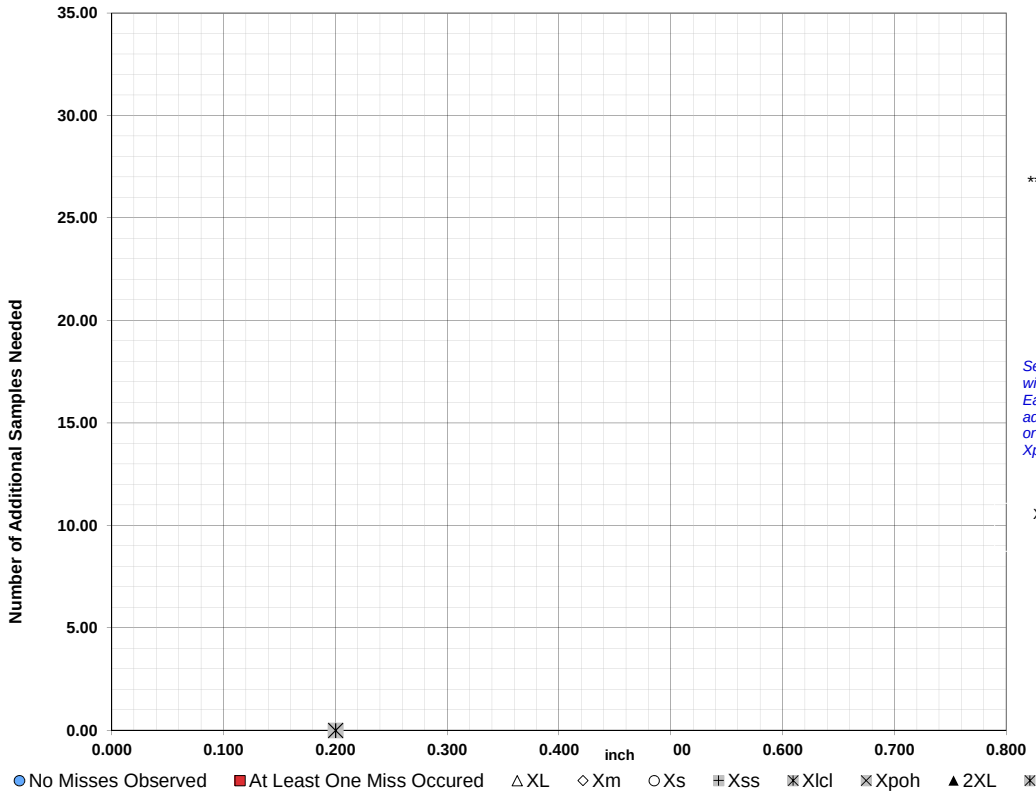



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.684 |
| Xm = | 0.563 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

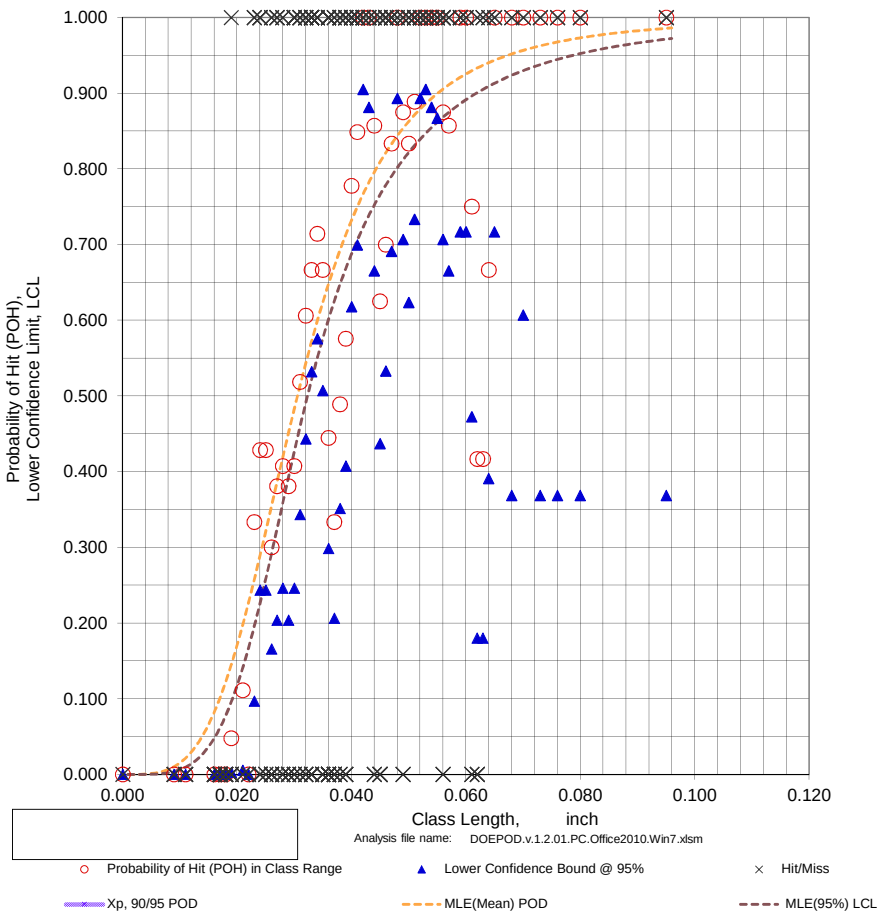
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.126.**

**Warning: No false call analysis.**




File Name = **D8003(3)D.xls**

Data Set Name = **D8003(3)D(CK.NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:50 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0420 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.925 | @ | 0.060 | inch |
| NTIAC 90/95 POD = | 0.913 | @ | 0.065 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.095 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | 0.065 | inch |
| Samples Needed @ Xm = | 20 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D8003(3)D.xls
Data Set Name = D8003(3)D(CK.NO.)

## Directed DOE Options

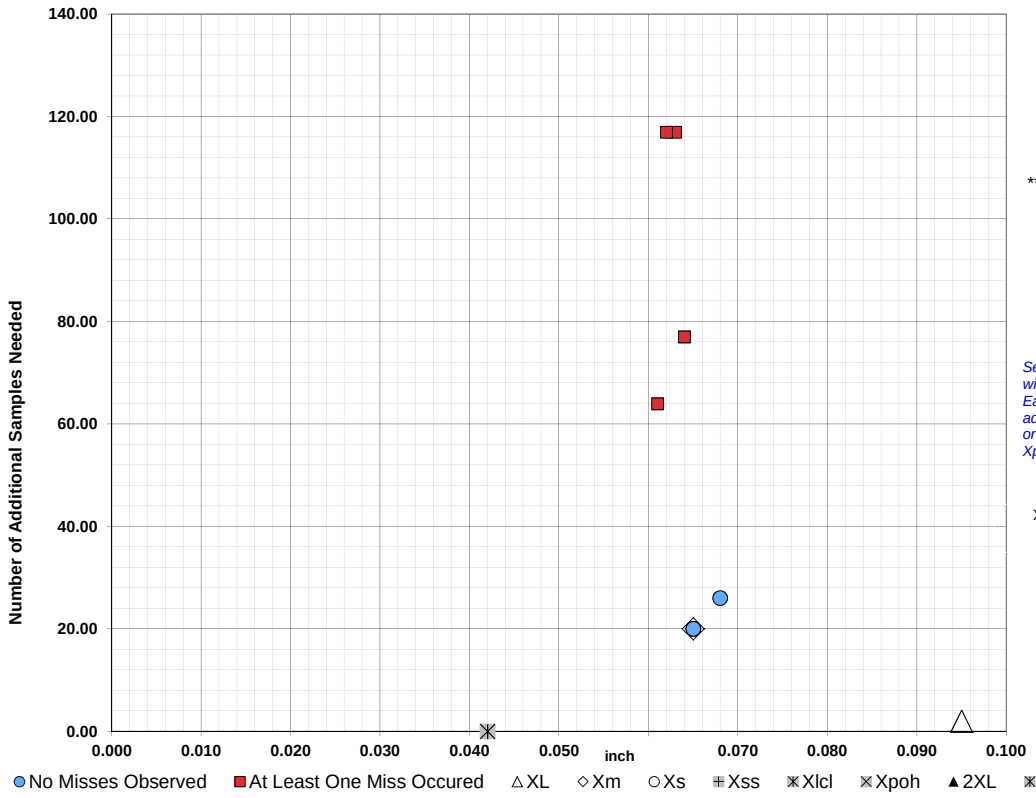



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.095 | 2 |
| Xm = | 0.065 | 20 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.0640 | 77 |
| 0.0630 | 117 |
| 0.0620 | 117 |
| 0.0610 | 64 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

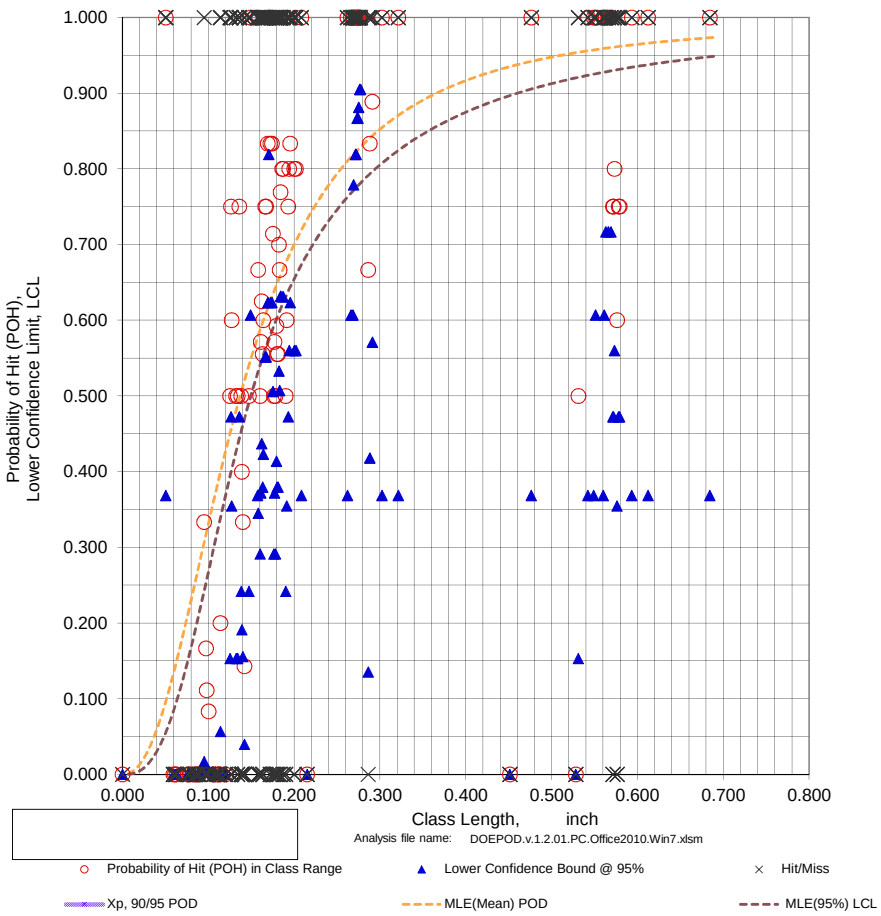
| Xpod,Class Length | No. Need |
|---|---|
| 0.0680 | 26 |
| 0.0650 | 20 |
| 0.0650 | 20 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.828.**

**Warning: No false call analysis.**




File Name = **D8003(3)L.xls**

Data Set Name = **D8003(3)L(CK.NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:51 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0050 | inch |
| Classlength @ 90/95 Xpod = | 0.2760 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.370 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.460 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.684 | inch |
| Samples Needed @ XL = | 13 | |
| Classlength Mid-point , Xm = | 0.569 | inch |
| Samples Needed @ Xm = | 20 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D8003(3)L.xls
Data Set Name = D8003(3)L(CK.NO.)

## Directed DOE Options

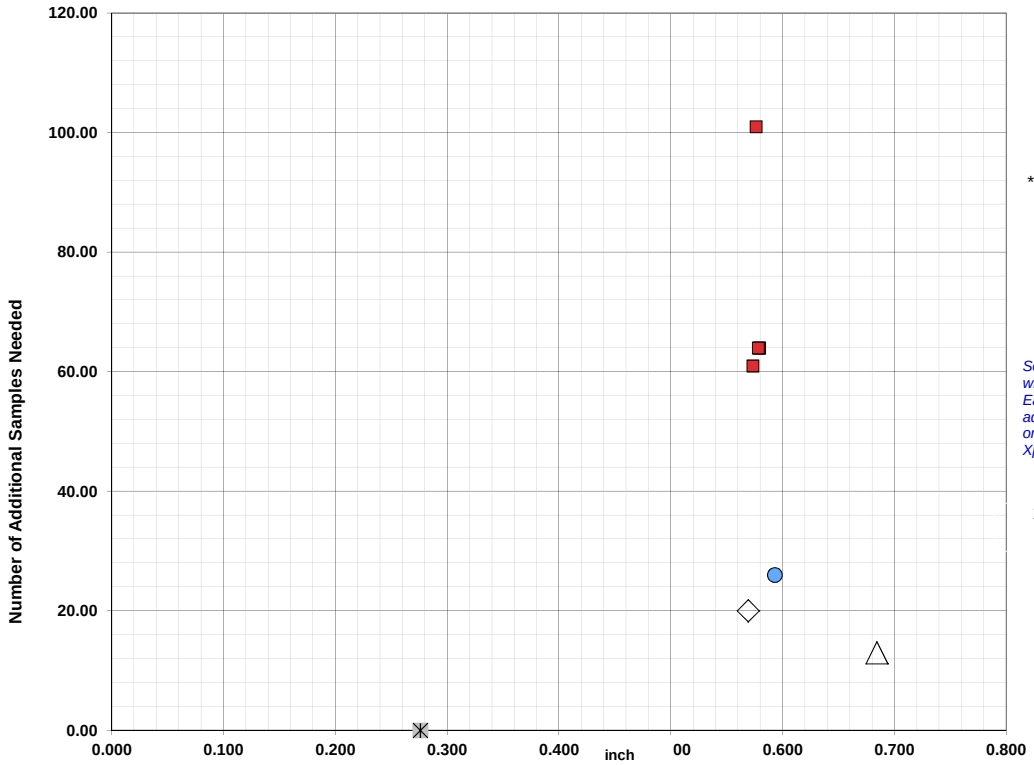



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.684 | 13 |
| Xm = | 0.569 | 20 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5790 | 64 |
| 0.5780 | 64 |
| 0.5760 | 101 |
| 0.5730 | 61 |

TABLE B*

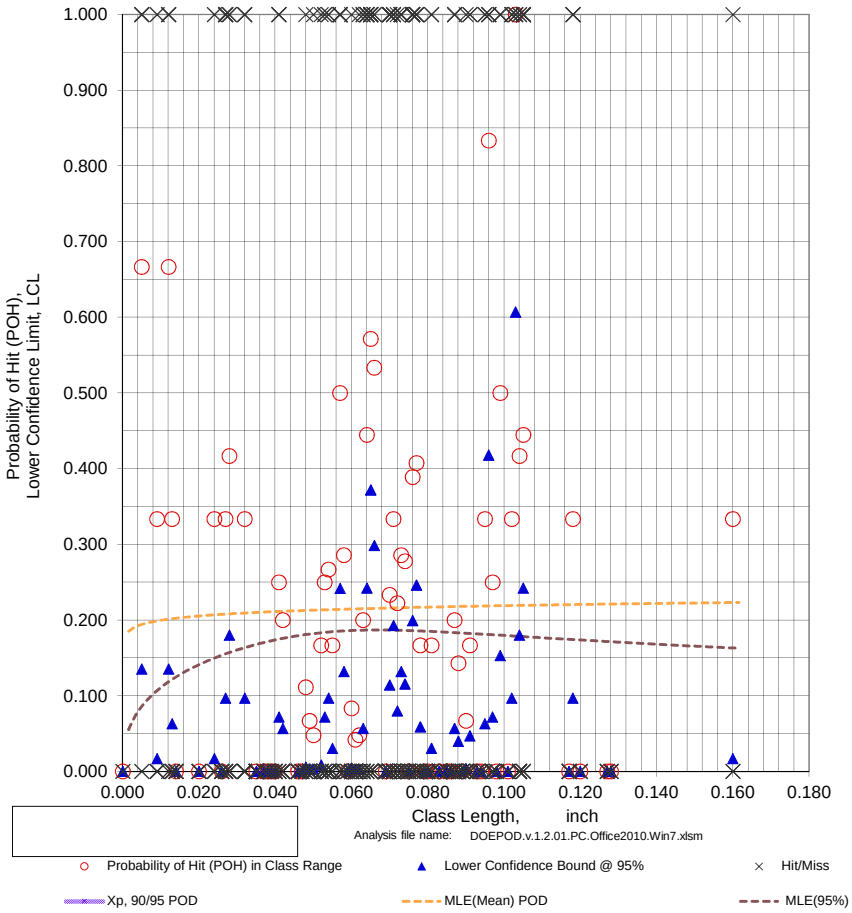
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.5930 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D9001(3)D.xls
Data Set Name = D9001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:52 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.1030 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.320 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9001(3)D.xls
Data Set Name = D9001(3)D(CK. NO.)

## Directed DOE Options

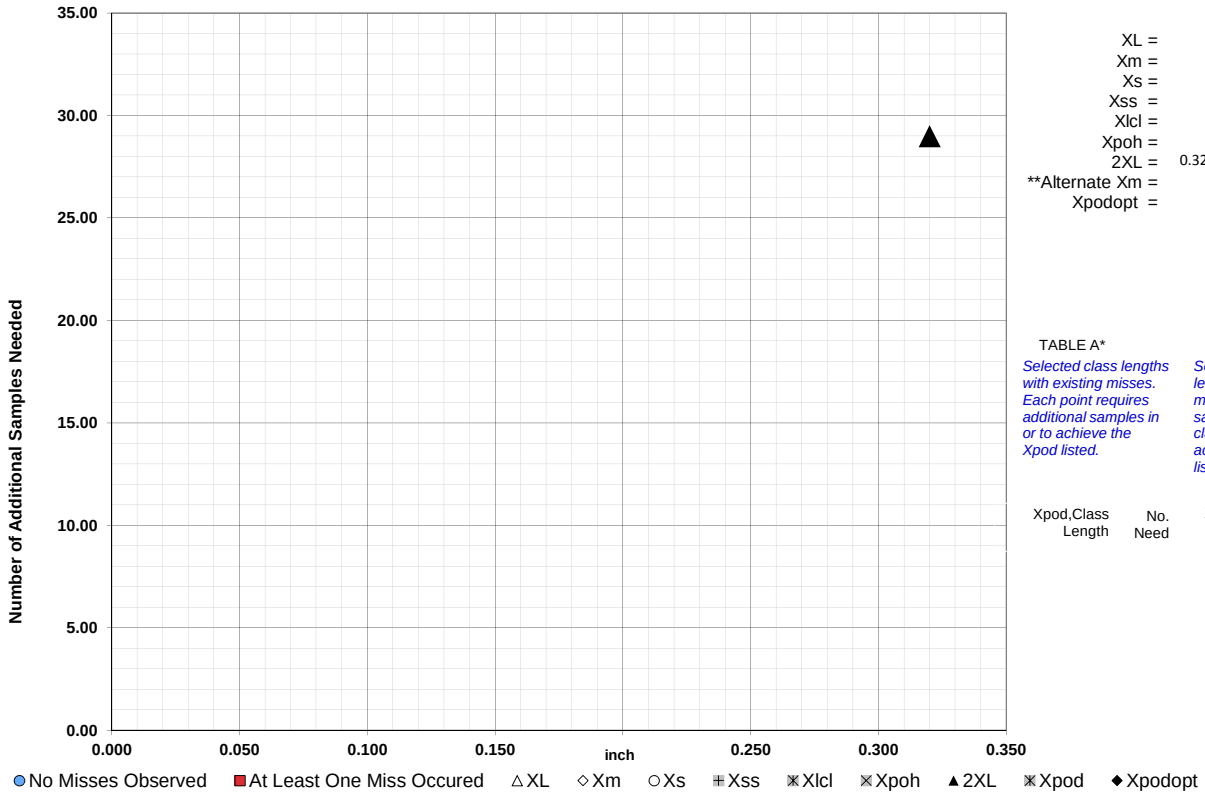



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.320 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

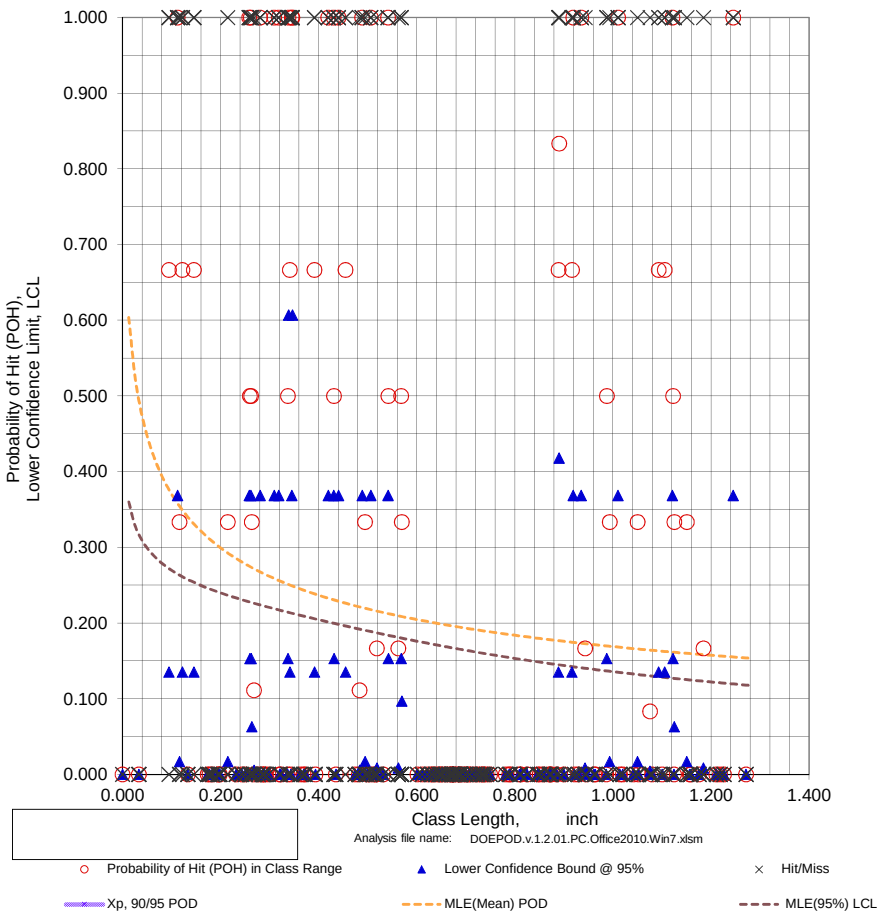
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D9001(3)L.xls
Data Set Name = D9001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:54 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.3380 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9001(3)L.xls
Data Set Name = D9001(3)L(CK. NO.)

## Directed DOE Options

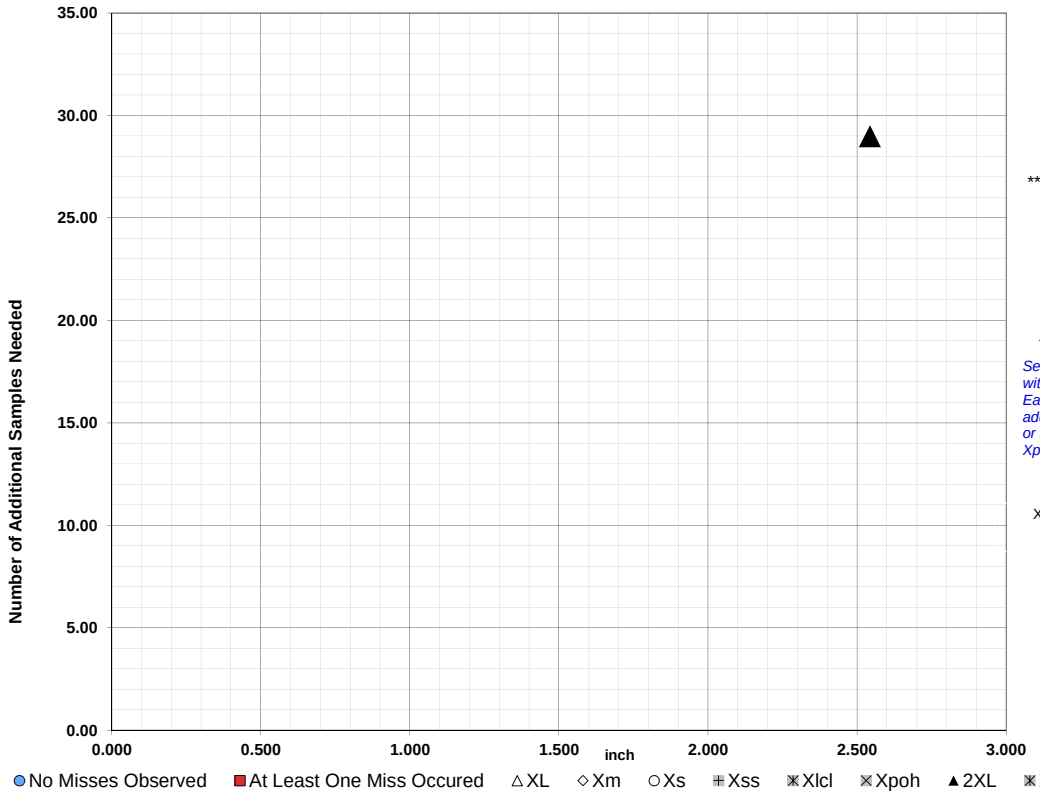



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

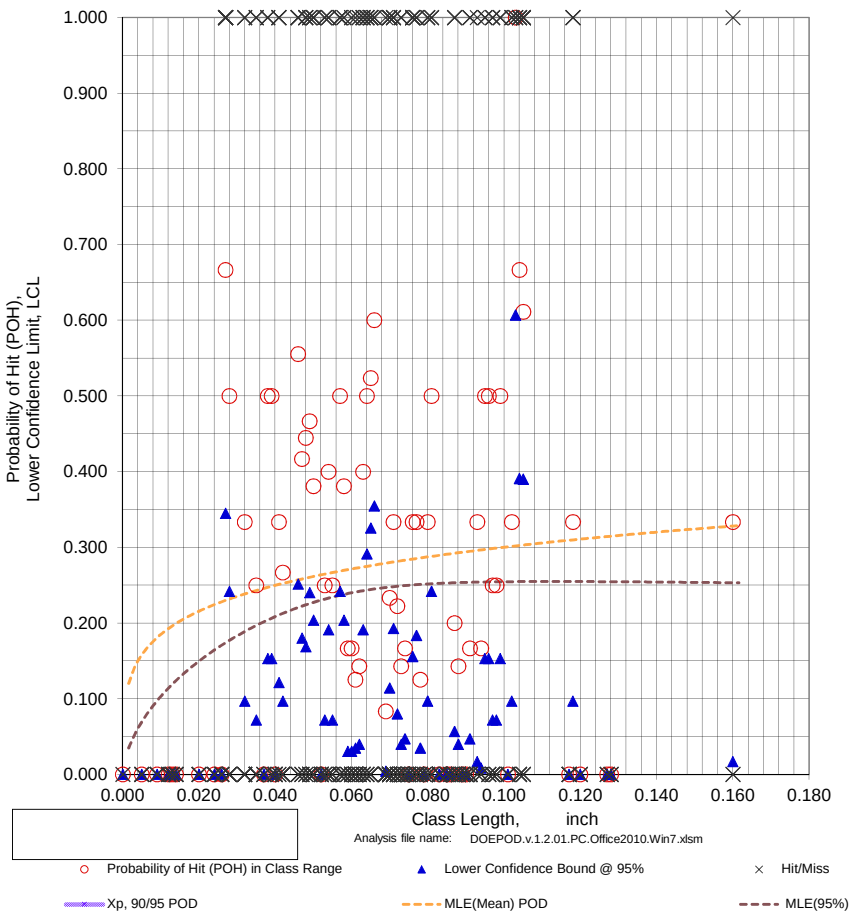
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D9002(3)D.xls
Data Set Name = D9002(3)D(CK.NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:57 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.1030 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.320 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9002(3)D.xls
Data Set Name = D9002(3)D(CK.NO.)

## Directed DOE Options

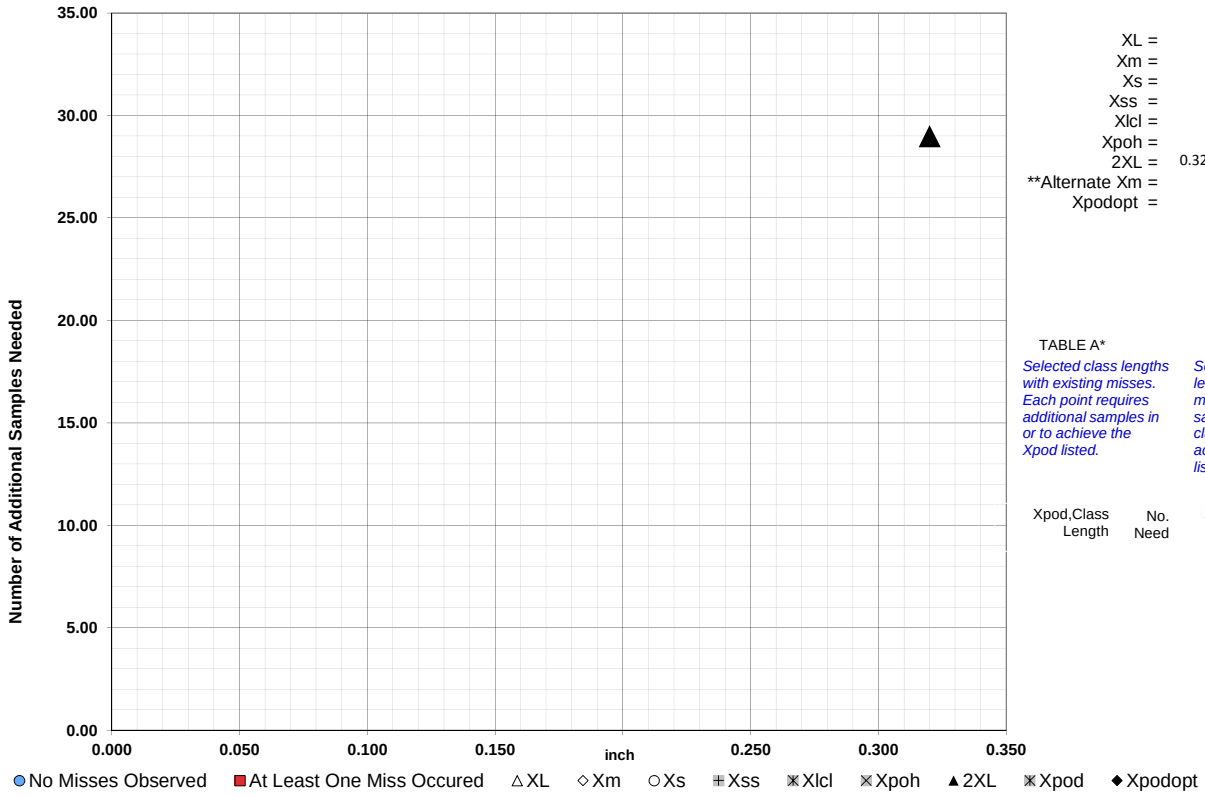



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.320 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

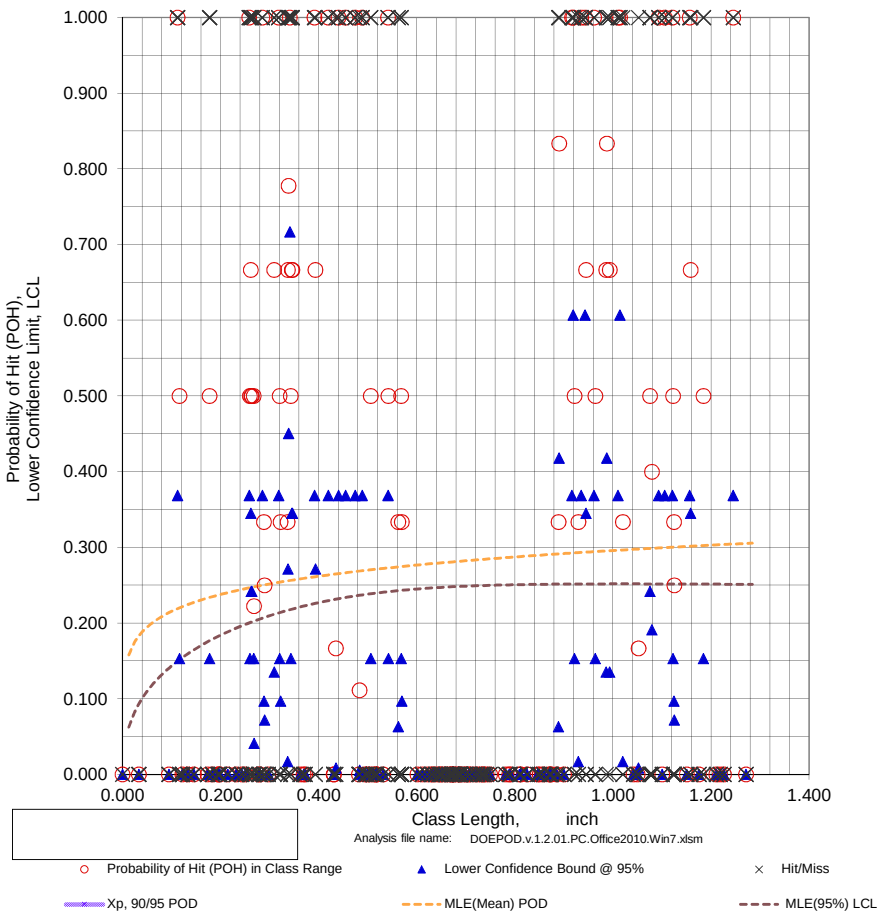
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = D9002(3)L.xls
Data Set Name = D9002(3)L(CK.NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 12:59 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.3410 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.900 @ 0.005 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9002(3)L.xls
Data Set Name = D9002(3)L(CK.NO.)

## Directed DOE Options

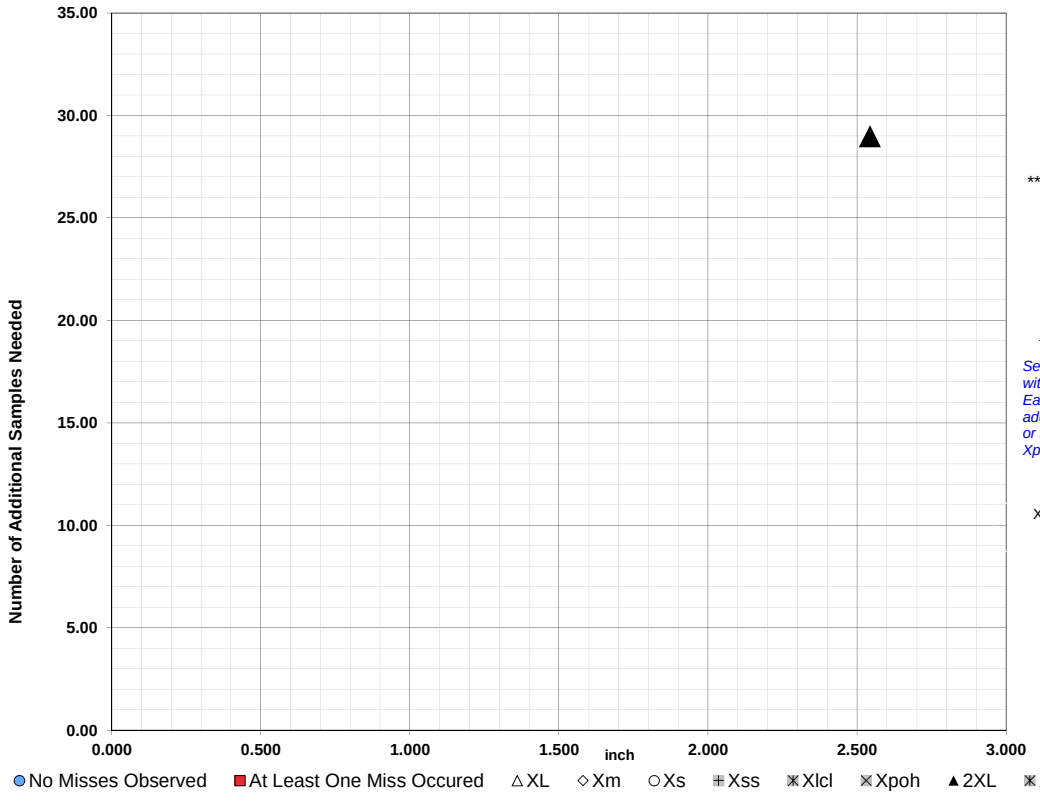



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.189.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

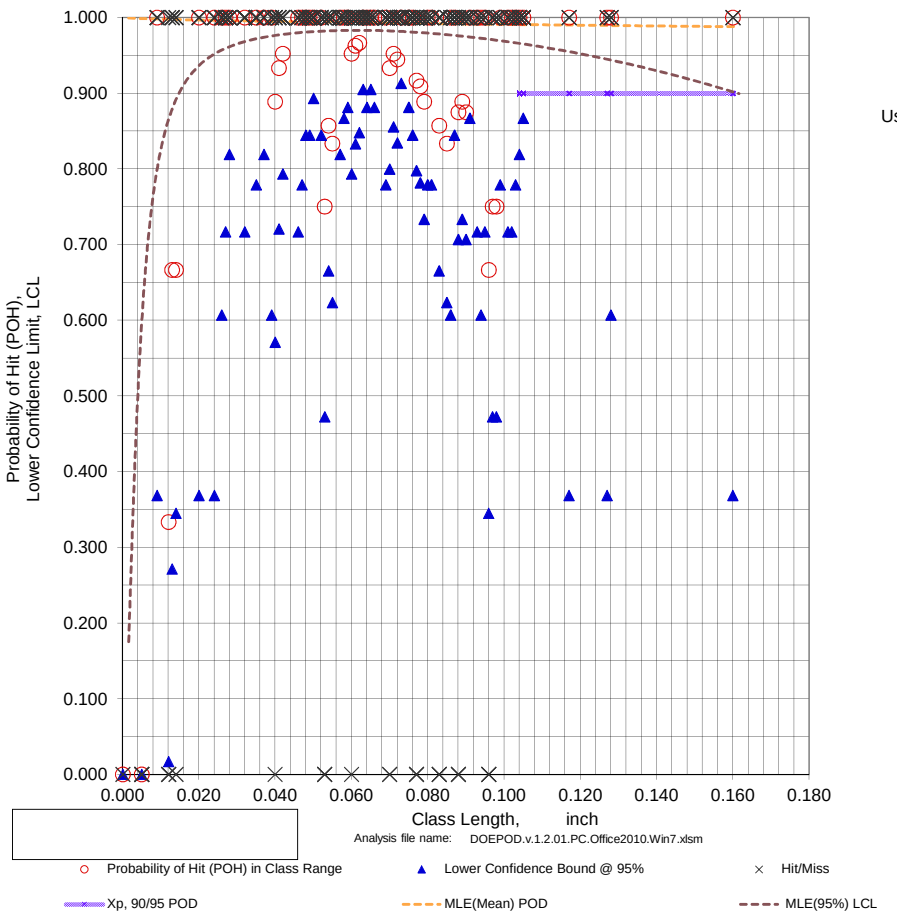
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **D9003(3)D.xls**

Data Set Name = **D9003(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:02 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0630 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.999 | @ | 0.005 | inch |
| NTIAC 90/95 POD = | 0.913 | @ | 0.015 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.160 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.105 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.1040 | inch |

File Name = D9003(3)D.xls
Data Set Name = D9003(3)D(CK. NO.)

## Directed DOE Options

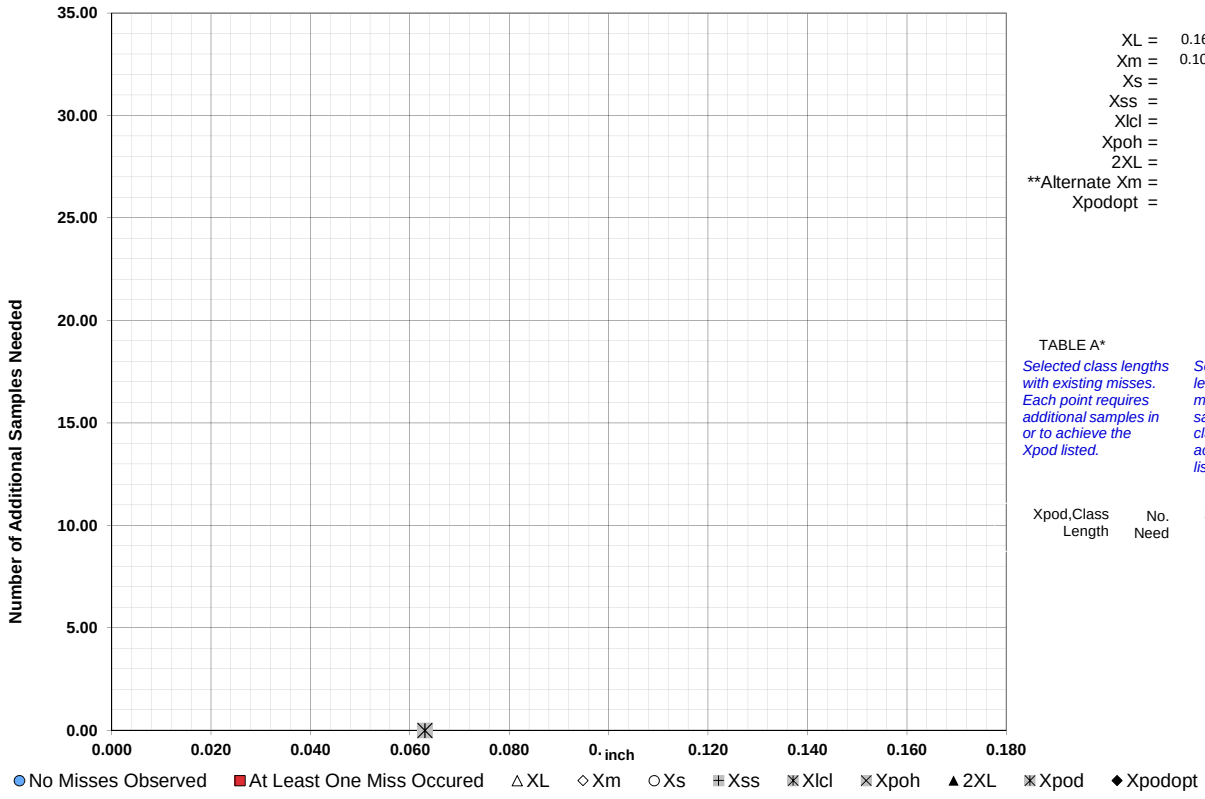



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.160 |
| Xm = | 0.105 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 2.064.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

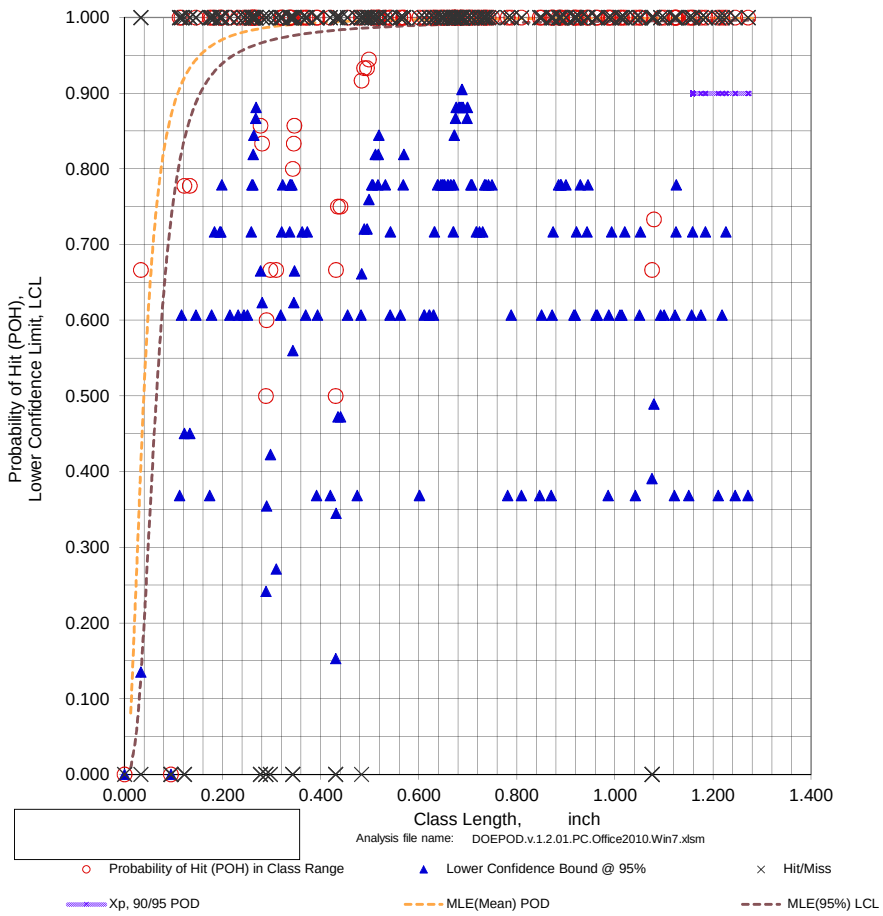
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **D9003(3)L.xls**

Data Set Name = **D9003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:19 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0170 | inch |
| Classlength @ 90/95 Xpod = | 0.6880 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and alternate Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.906 | @ | 0.160 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.271 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.846 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 1.1580 | inch |

File Name = D9003(3)L.xls
Data Set Name = D9003(3)L(CK. NO.)

## Directed DOE Options

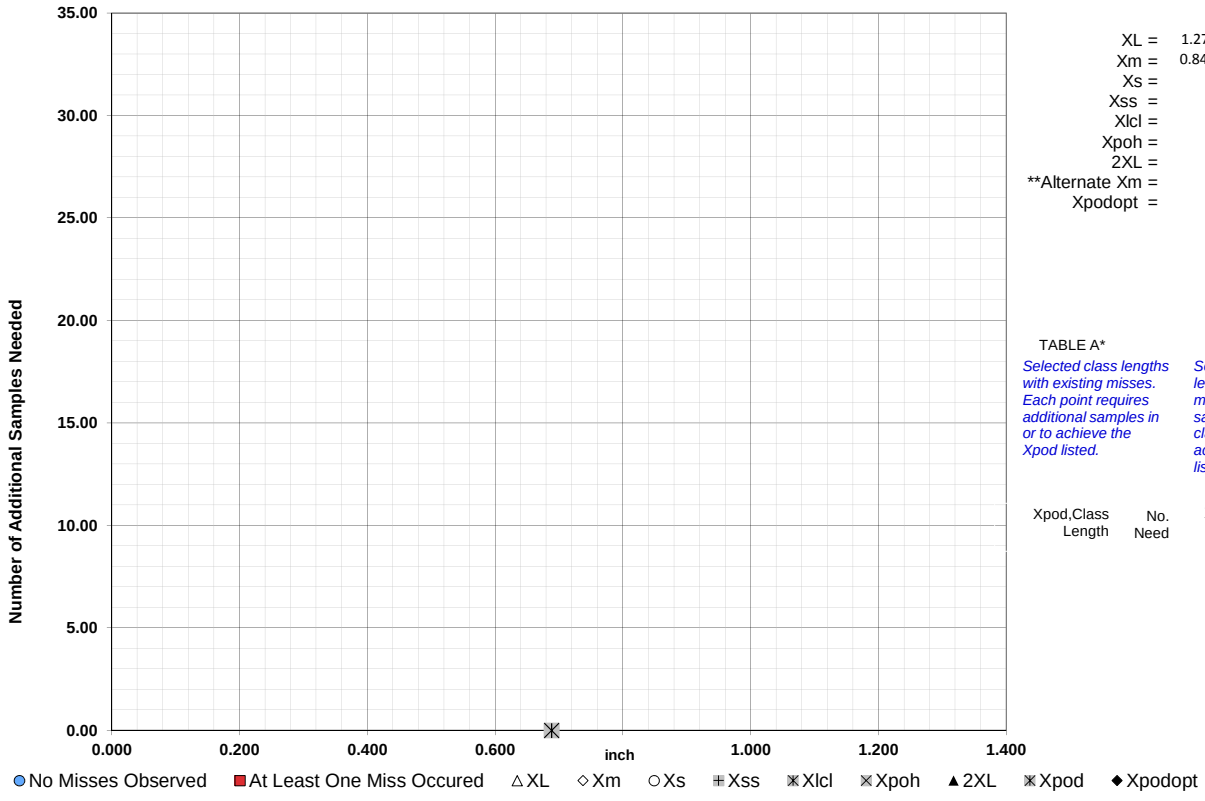



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.271 |
| Xm = | 0.846 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

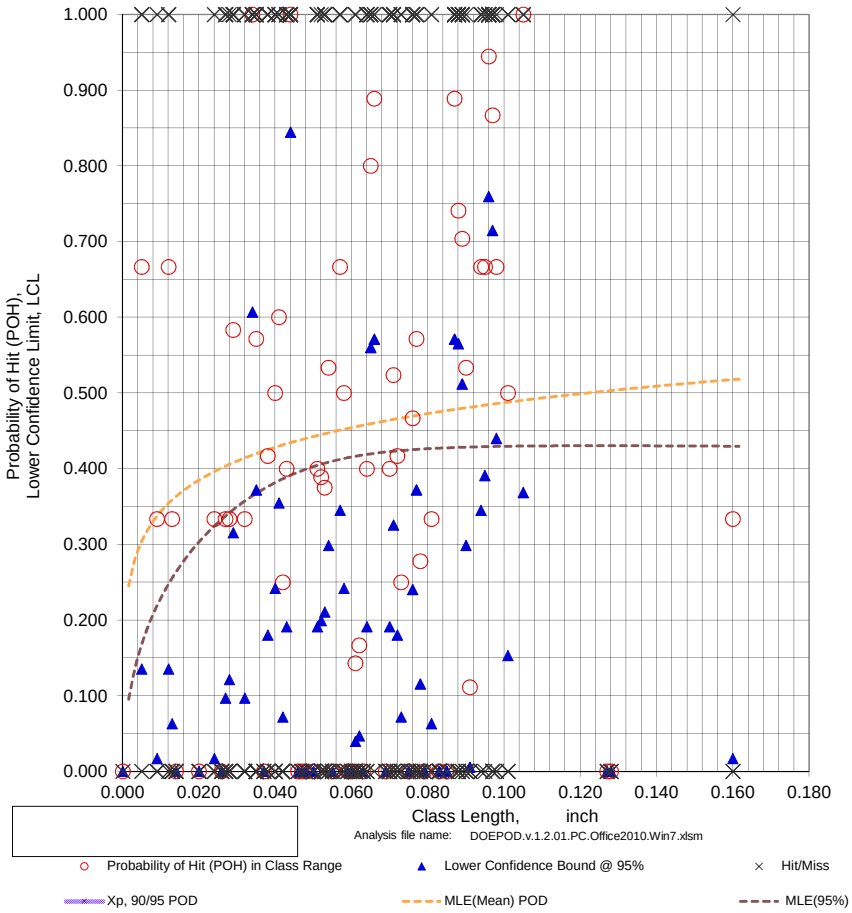
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D9004(3)D.xls
Data Set Name = D9004(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:32 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8444 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0440 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.320 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9004(3)D.xls
Data Set Name = D9004(3)D(CK. NO.)

## Directed DOE Options

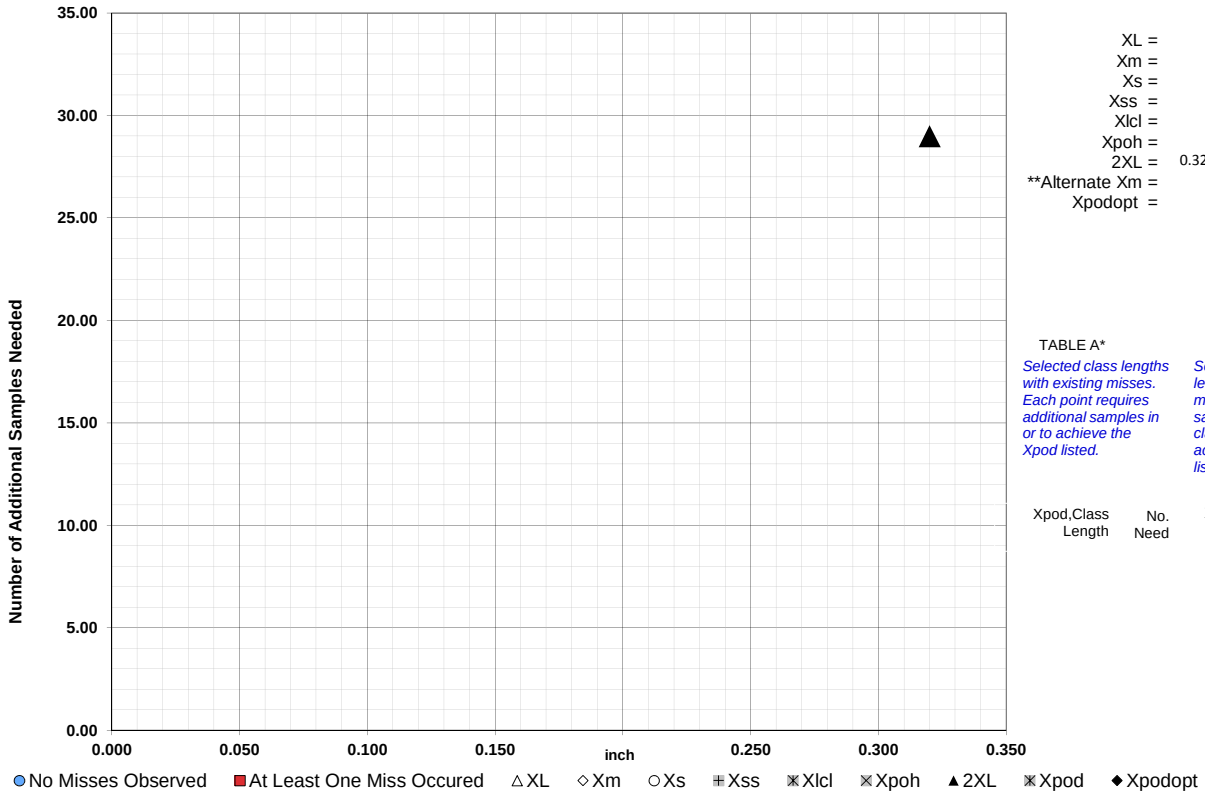



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.320 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

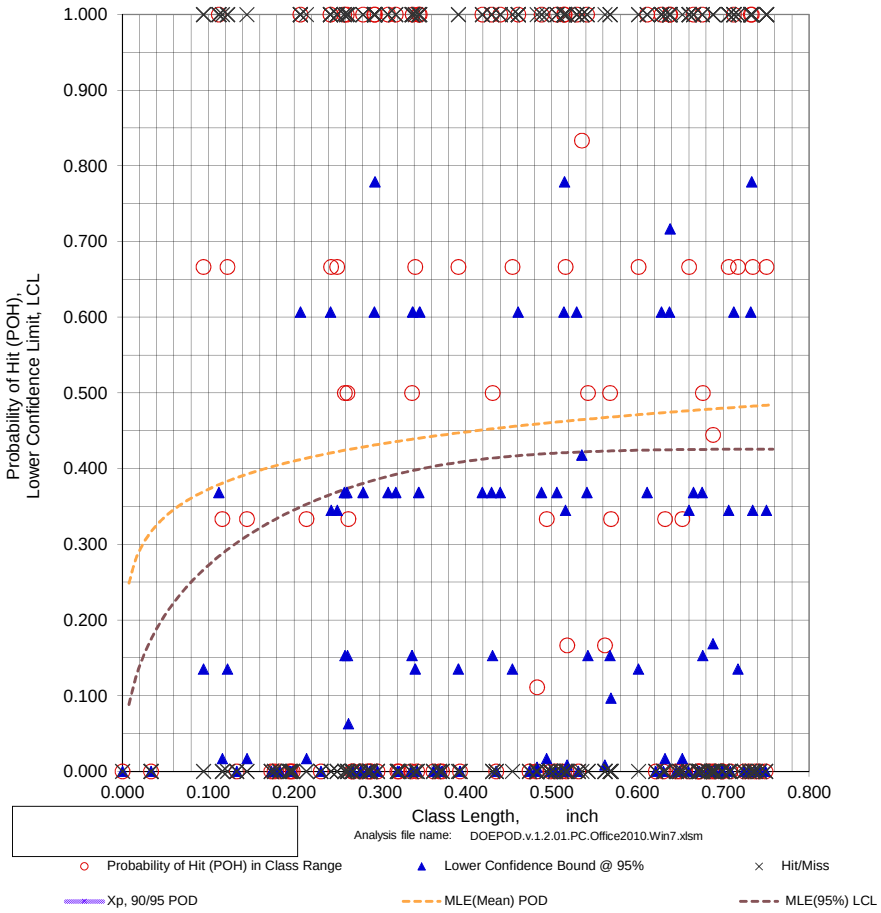
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D9004(3)L.xls
Data Set Name = D9004(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:33 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.2940 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.500 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9004(3)L.xls
Data Set Name = D9004(3)L(CK. NO.)

## Directed DOE Options

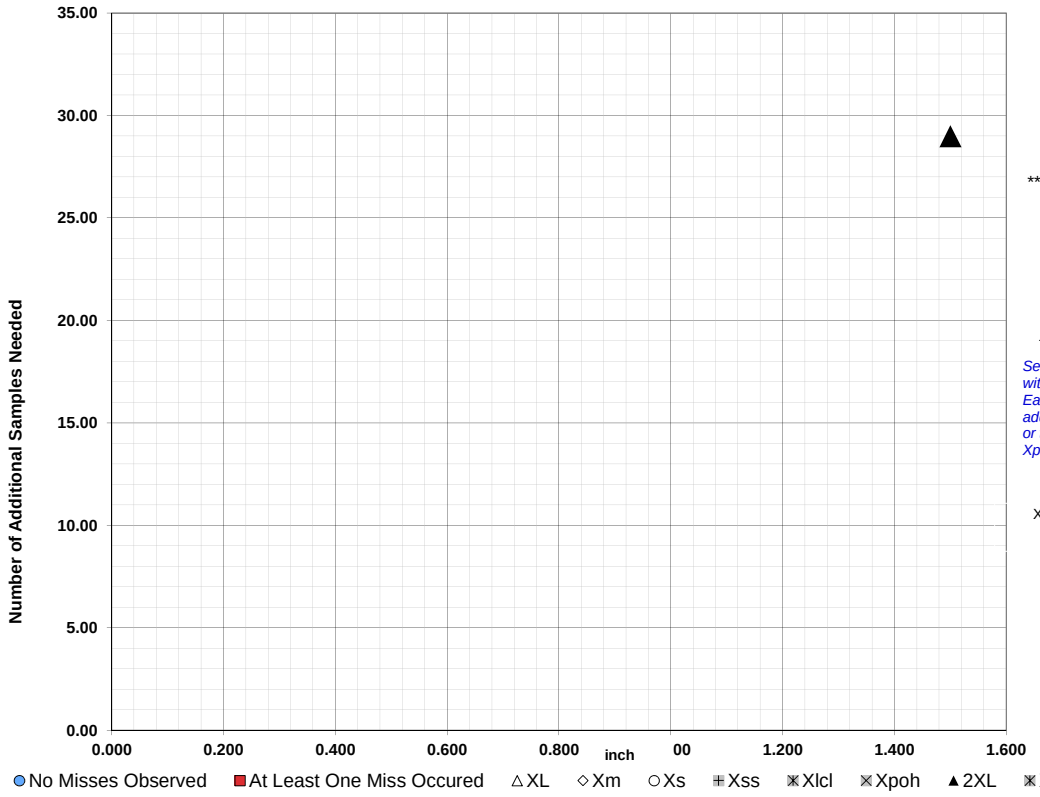



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.500 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

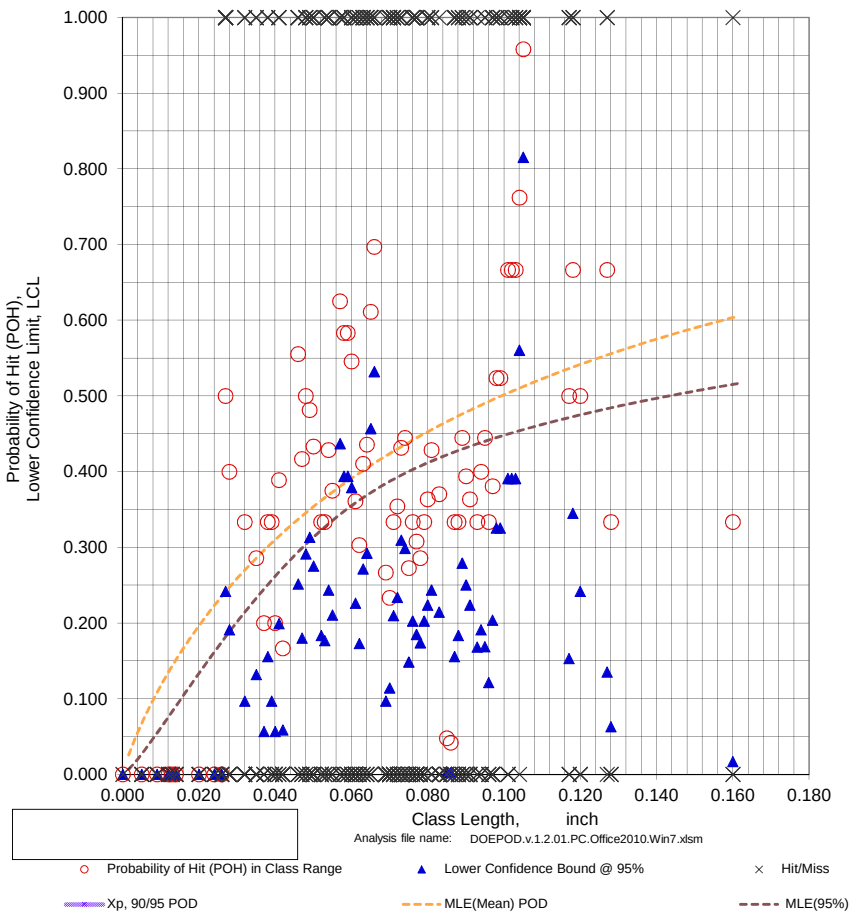
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = D9005(3)D.xls
Data Set Name = D9005(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:36 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8153 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.1050 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.320 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9005(3)D.xls
Data Set Name = D9005(3)D(CK. NO.)

## Directed DOE Options

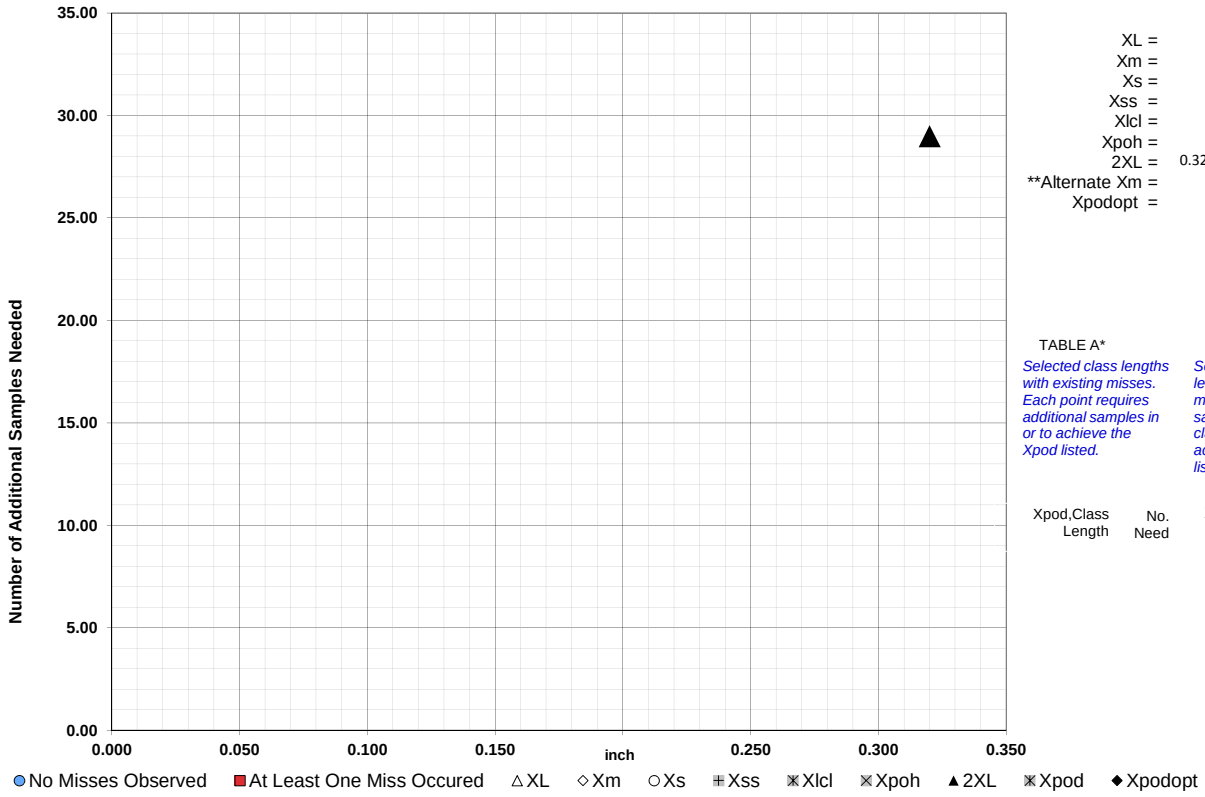



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.320 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

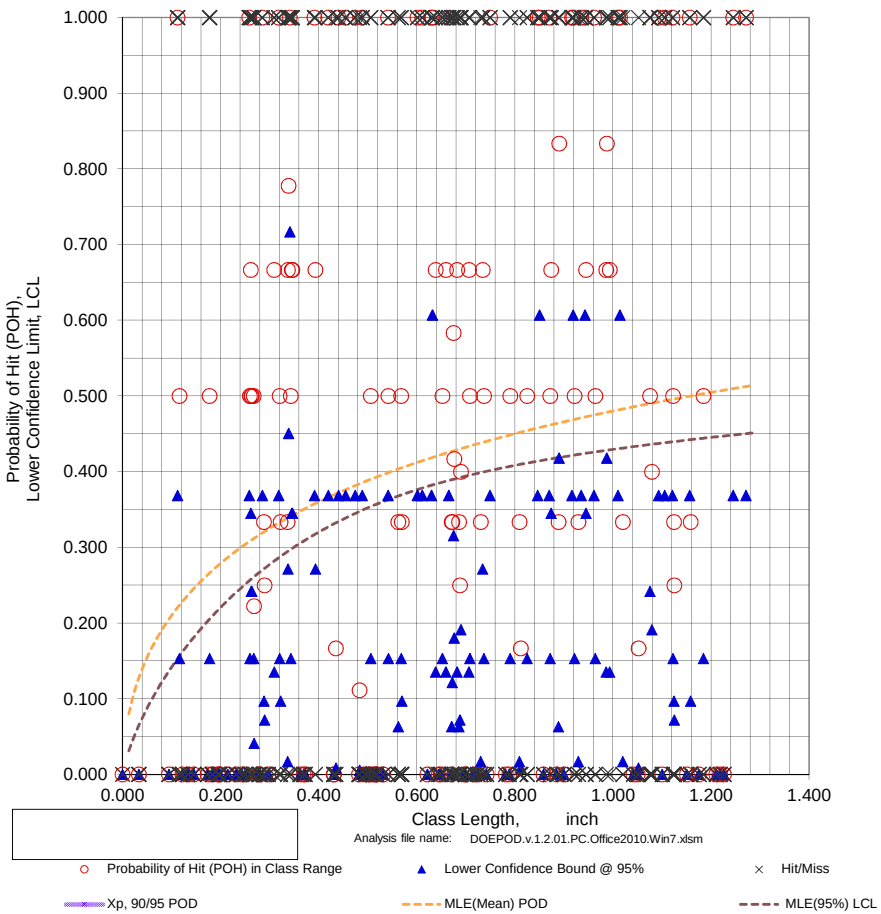
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = D9005(3)L.xls
Data Set Name = D9005(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:38 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.3410 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.2450 -0.018 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.271 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.245 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.542 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = D9005(3)L.xls
Data Set Name = D9005(3)L(CK. NO.)

## Directed DOE Options

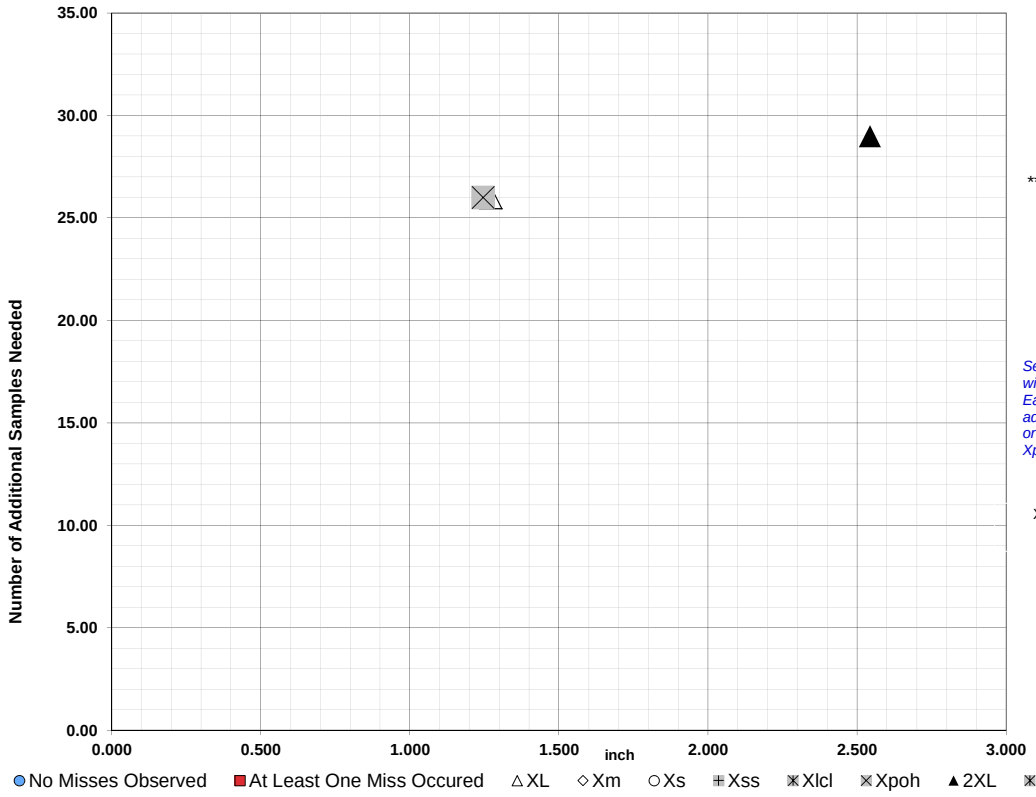



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.271 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.245 | 26 |
| 2XL = | 2.542 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.291.**

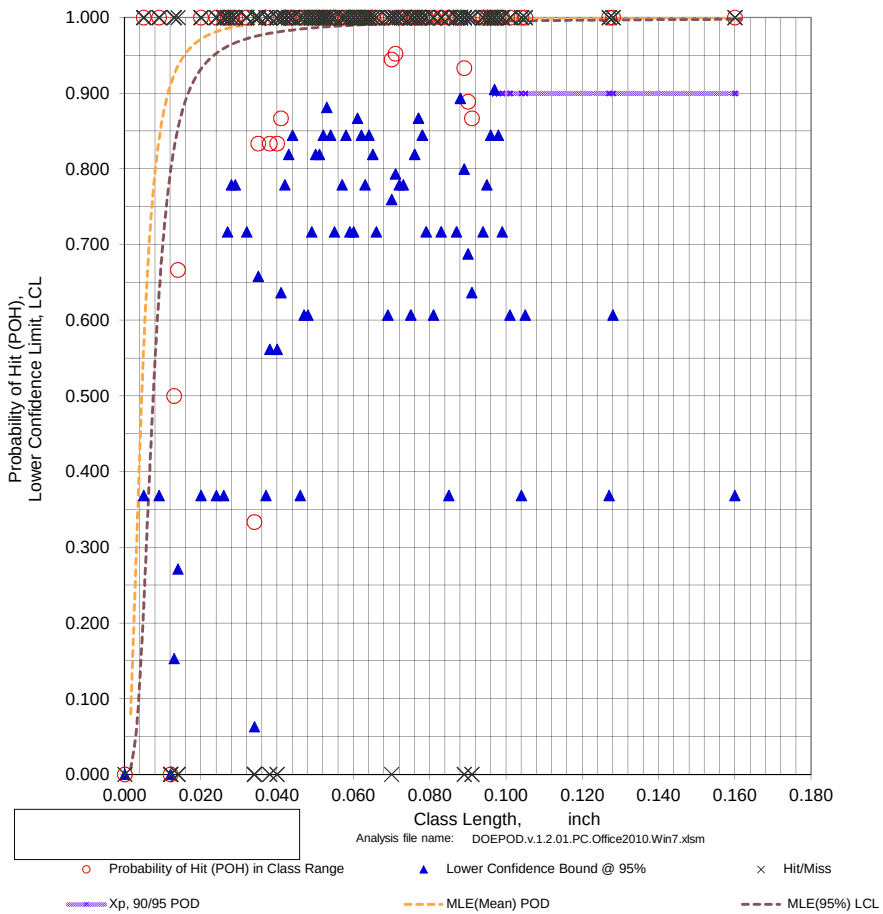
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **D9006(3)D.xls**

Data Set Name = **D9006(3)D(CRACK)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:40 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0010 | inch |
| Classlength @ 90/95 Xpod = | 0.0970 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0940 -0.001 inch 20 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.940 | @ | 0.015 | inch |
| NTIAC 90/95 POD = | 0.927 | @ | 0.020 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.160 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.128 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.094 | inch |
| Samples Needed @Xpodopt = | 20 | |
| Xp = | 0.0970 | inch |

File Name = D9006(3)D.xls
Data Set Name = D9006(3)D(CRACK)

## Directed DOE Options

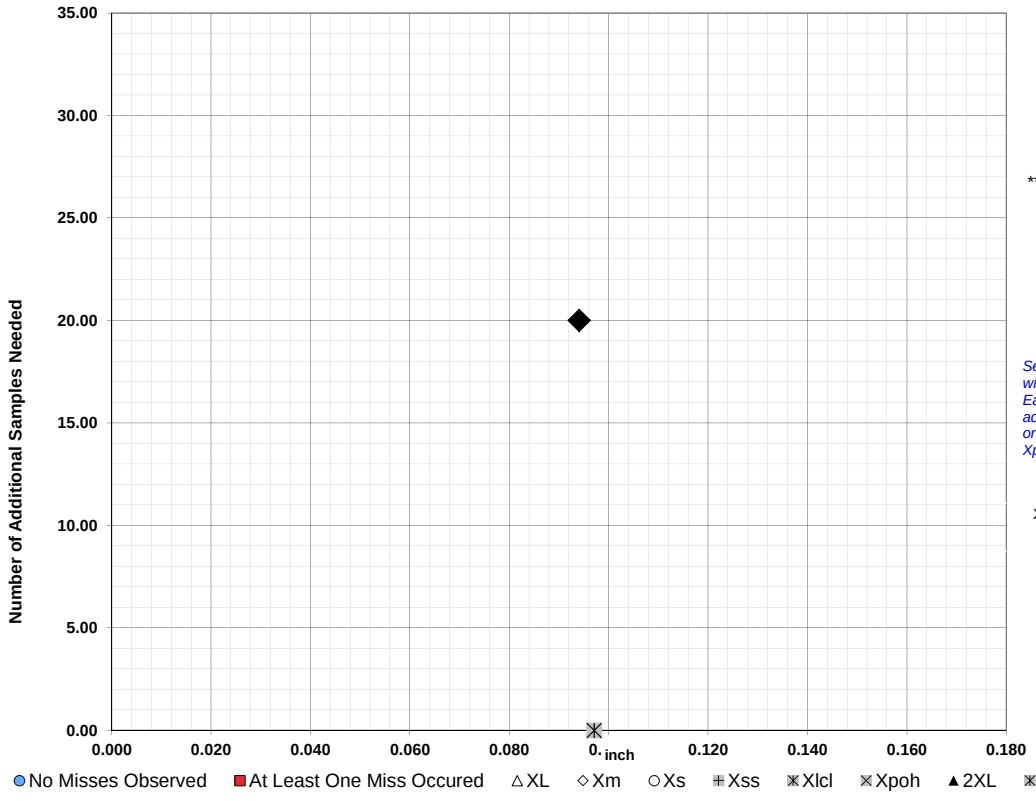



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.160 | |
| Xm = | 0.128 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.094 | 20 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.554.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

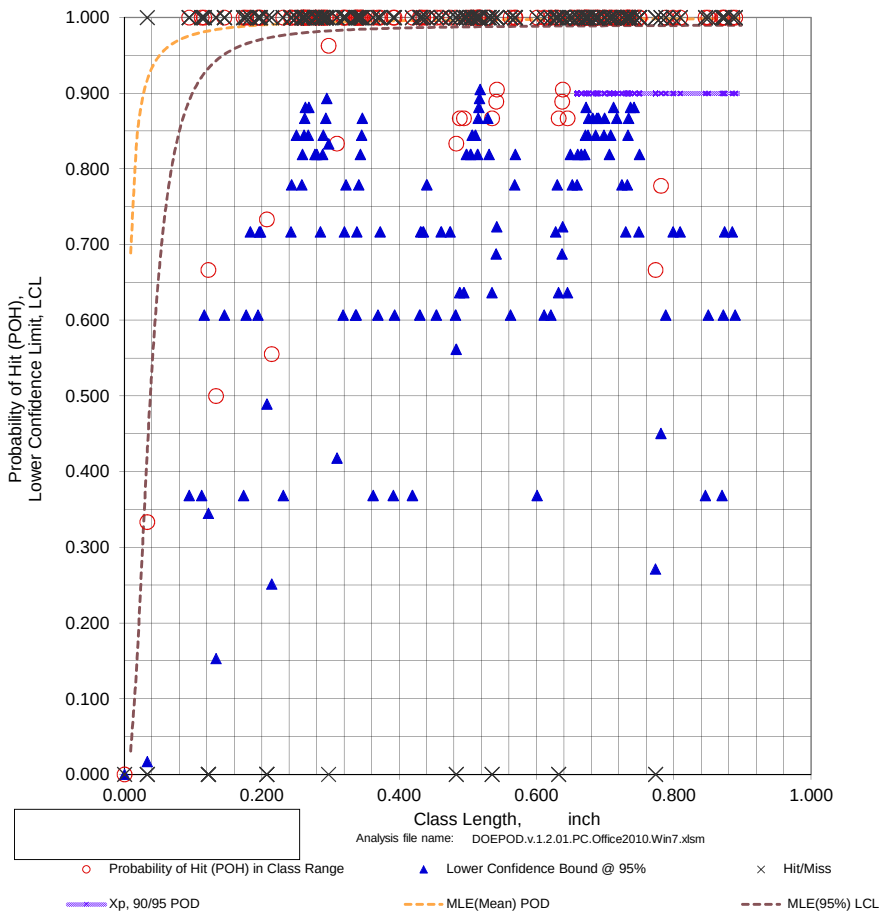
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **D9006(3)L.xls**

Data Set Name = **D9006(3)L(CRACK)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 1:58 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0140 | inch |
| Classlength @ 90/95 Xpod = | 0.5180 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.918 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.903 | @ | 0.100 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.889 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.742 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.6590 | inch |

File Name = D9006(3)L.xls
Data Set Name = D9006(3)L(CRACK)

## Directed DOE Options

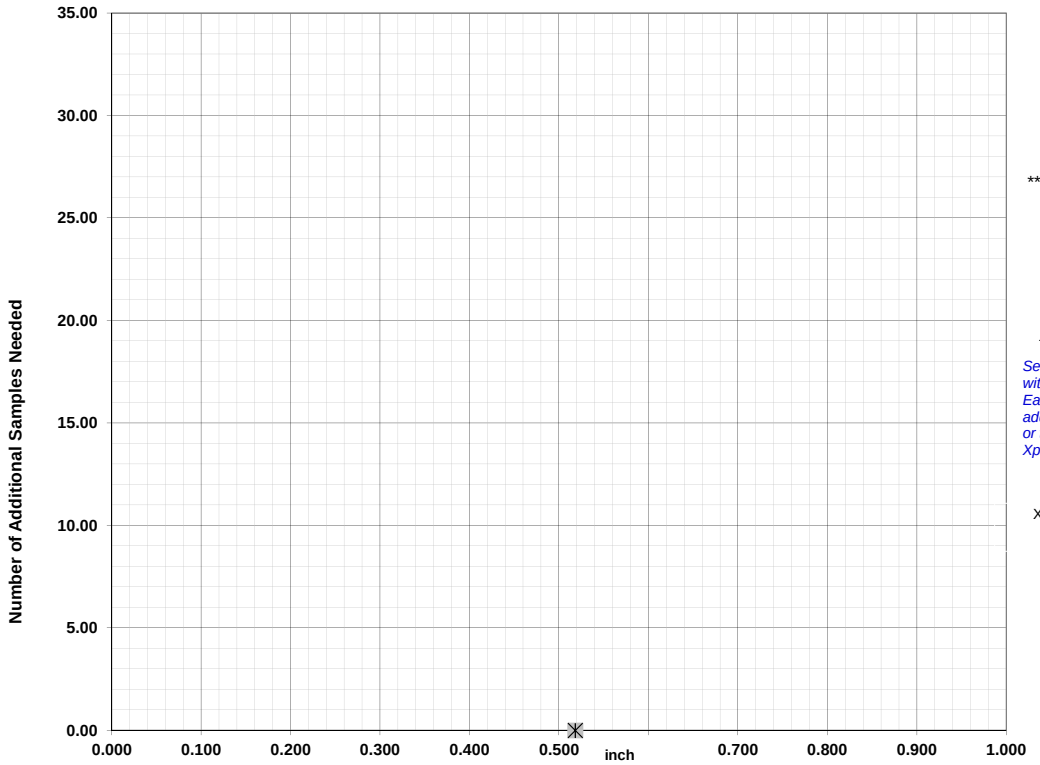



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.889 |
| Xm = | 0.742 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

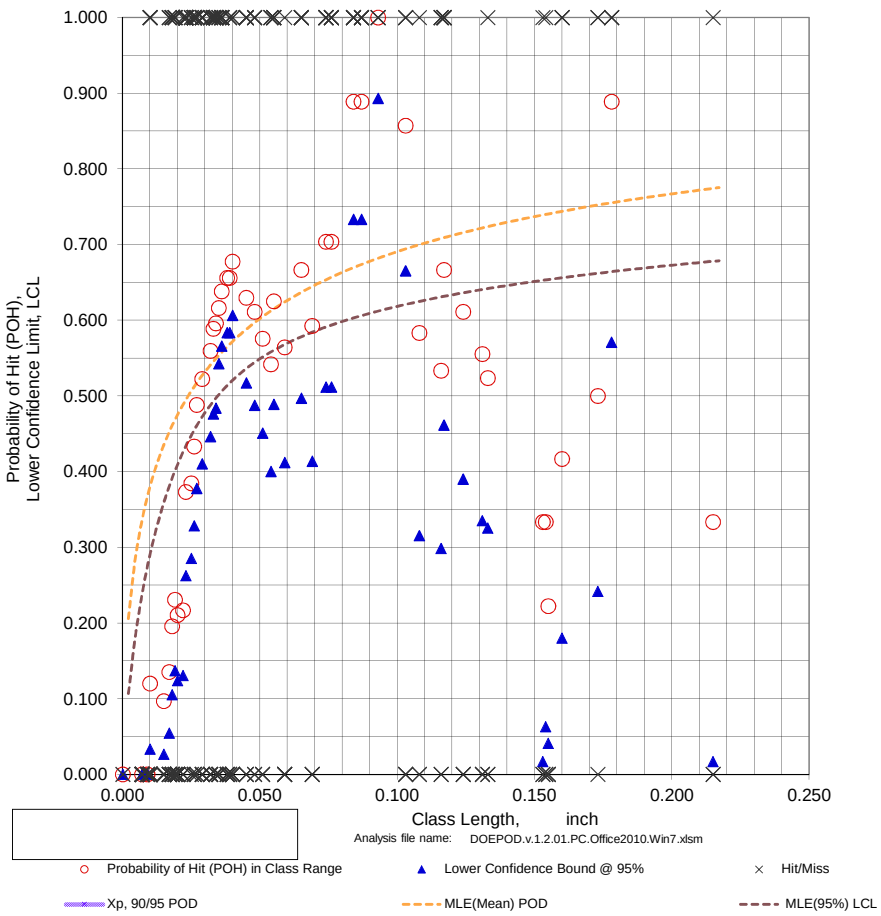
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DA001(3)D.xls
Data Set Name = DA001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:17 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0190 | inch |
| Classlength @ Best LCL = | 0.0930 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DA001(3)D.xls
Data Set Name = DA001(3)D(CK. NO.)

## Directed DOE Options

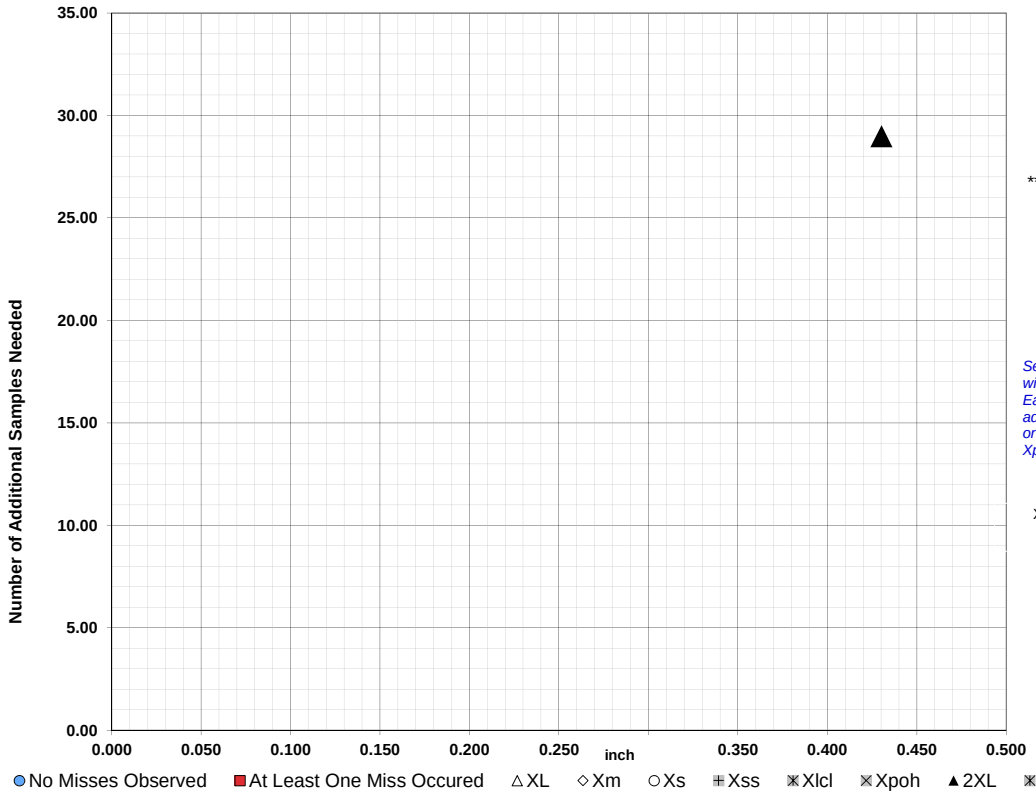



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

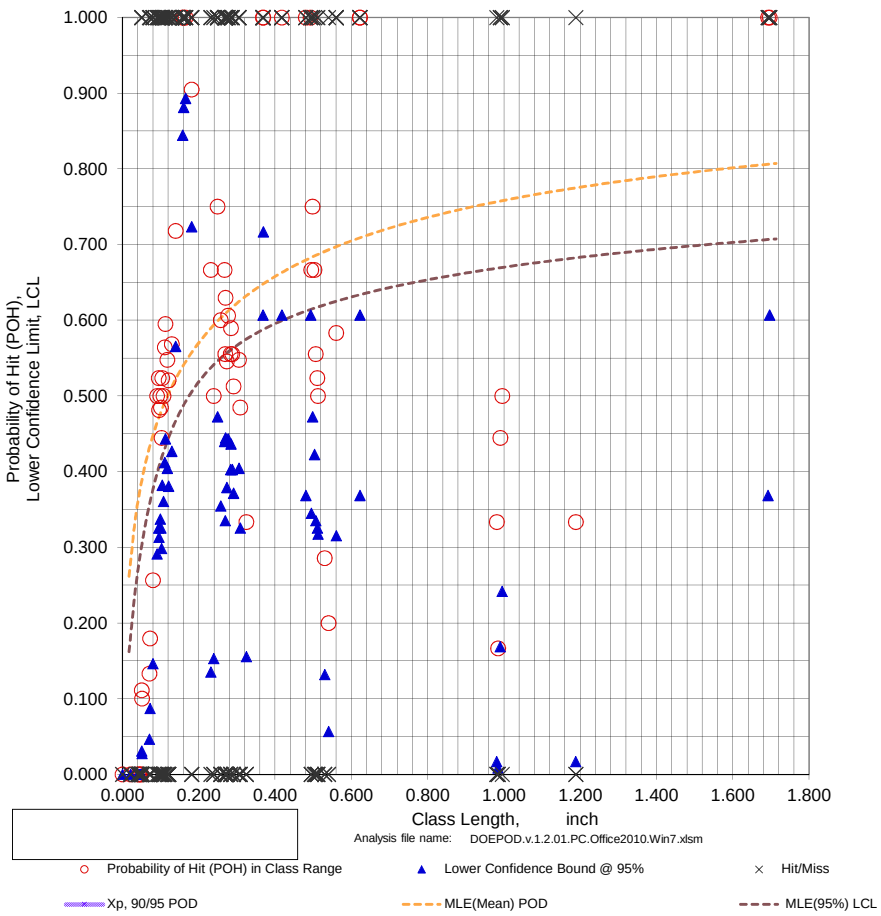
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = DA001(3)L.xls
Data Set Name = DA001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:19 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0360 | inch |
| Classlength @ Best LCL = | 0.1650 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6920 -0.500 inch 26 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.696 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.692 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 3.392 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DA001(3)L.xls
Data Set Name = DA001(3)L(CK. NO.)

## Directed DOE Options

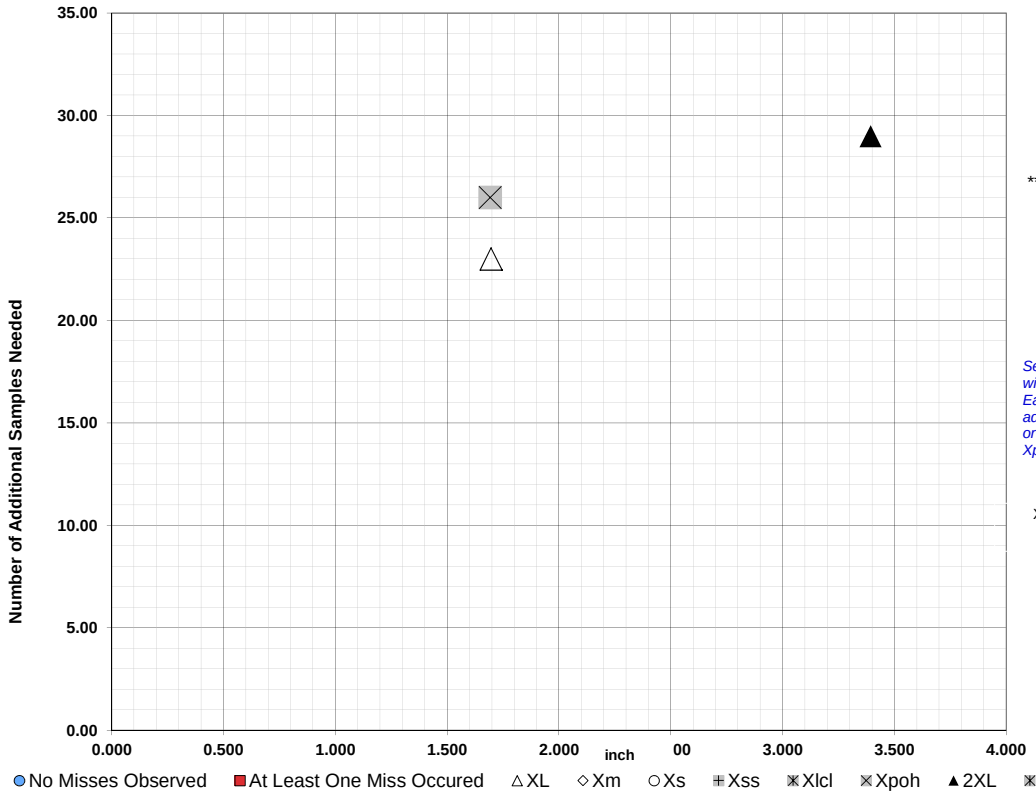



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.696 | 23 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.692 | 26 |
| 2XL = | 3.392 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

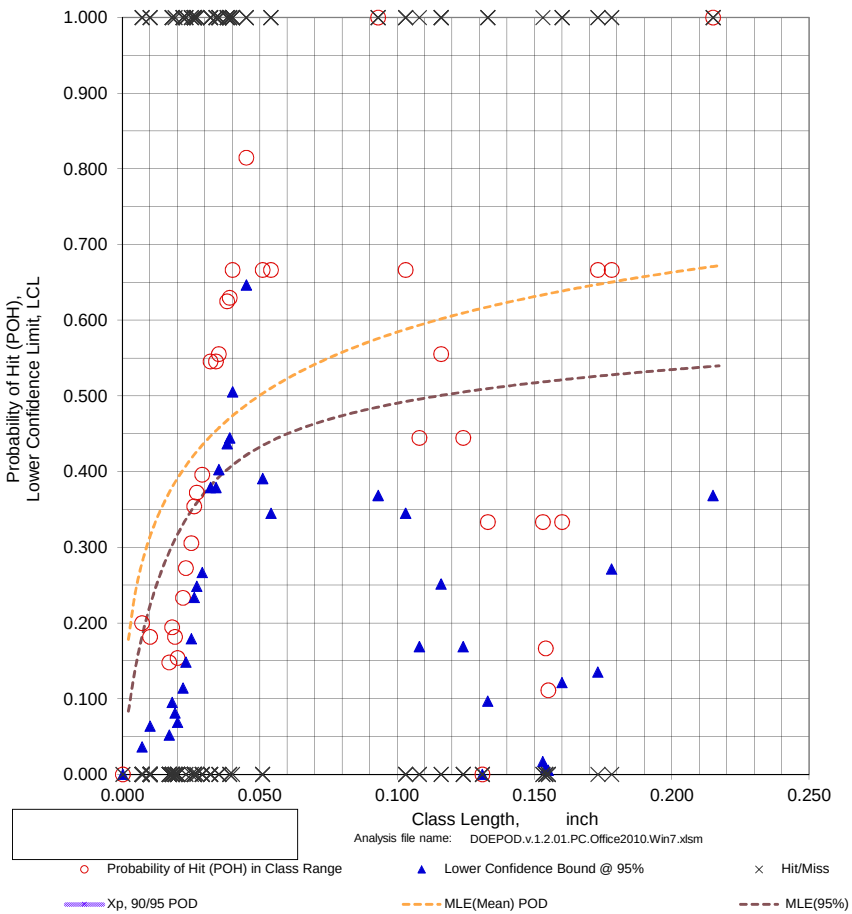
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DA002(3)D.xls
Data Set Name = DA002(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:20 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6467 | |
| Classwidth @ Best LCL = | 0.0110 | inch |
| Classlength @ Best LCL = | 0.0450 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2150 -0.036 inch 26 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.215 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.215 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DA002(3)D.xls
Data Set Name = DA002(3)D(CK. NO.)

## Directed DOE Options

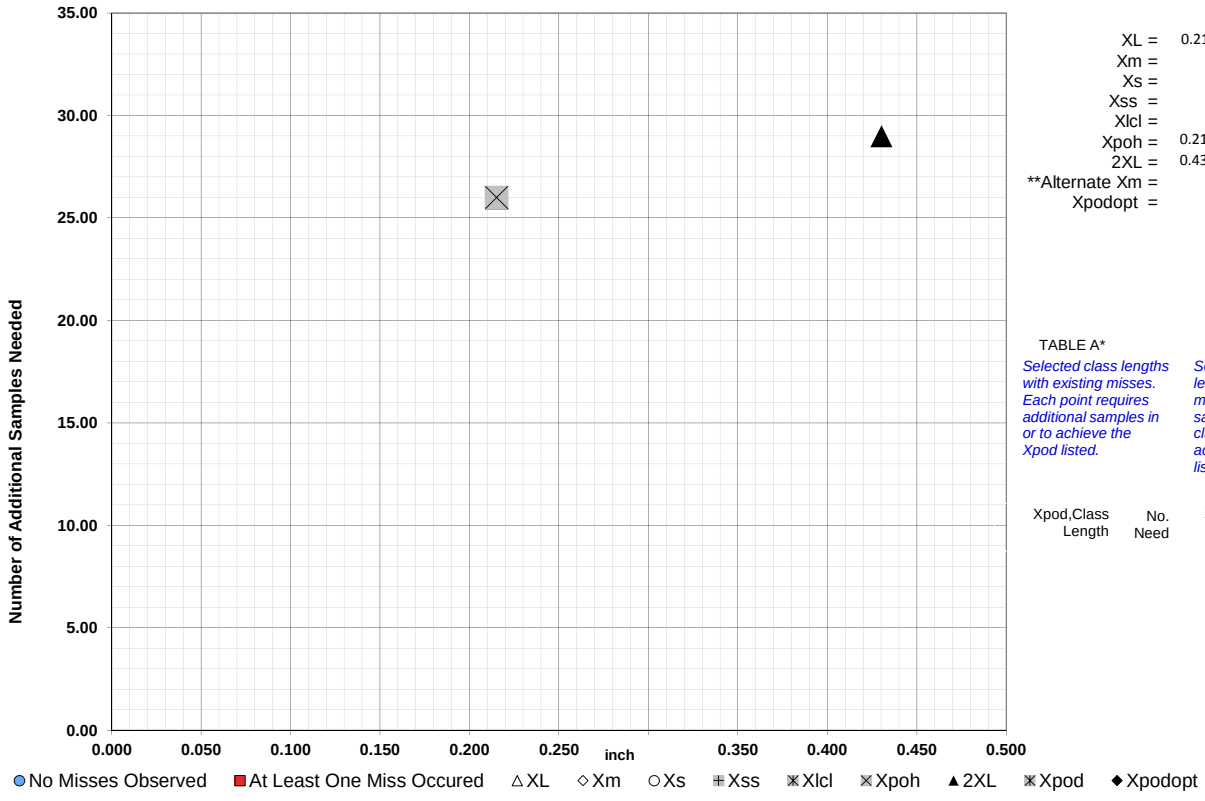



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.215 | 26 |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

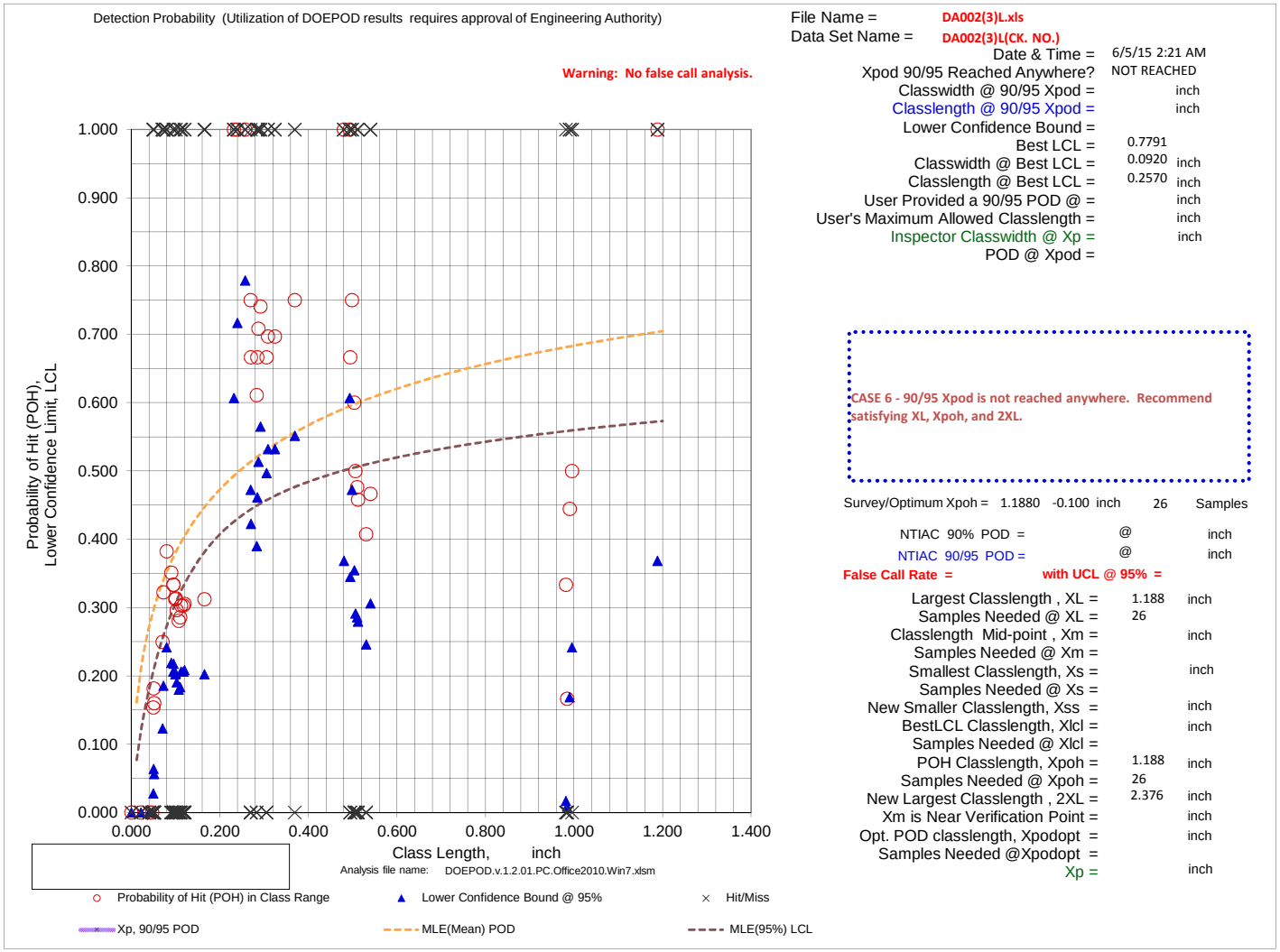
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = DA002(3)L.xls
Data Set Name = DA002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:21 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0920 | inch |
| Classlength @ Best LCL = | 0.2570 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.1880 -0.100 inch 26 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.188 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.188 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.376 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DA002(3)L.xls
Data Set Name = DA002(3)L(CK. NO.)

## Directed DOE Options

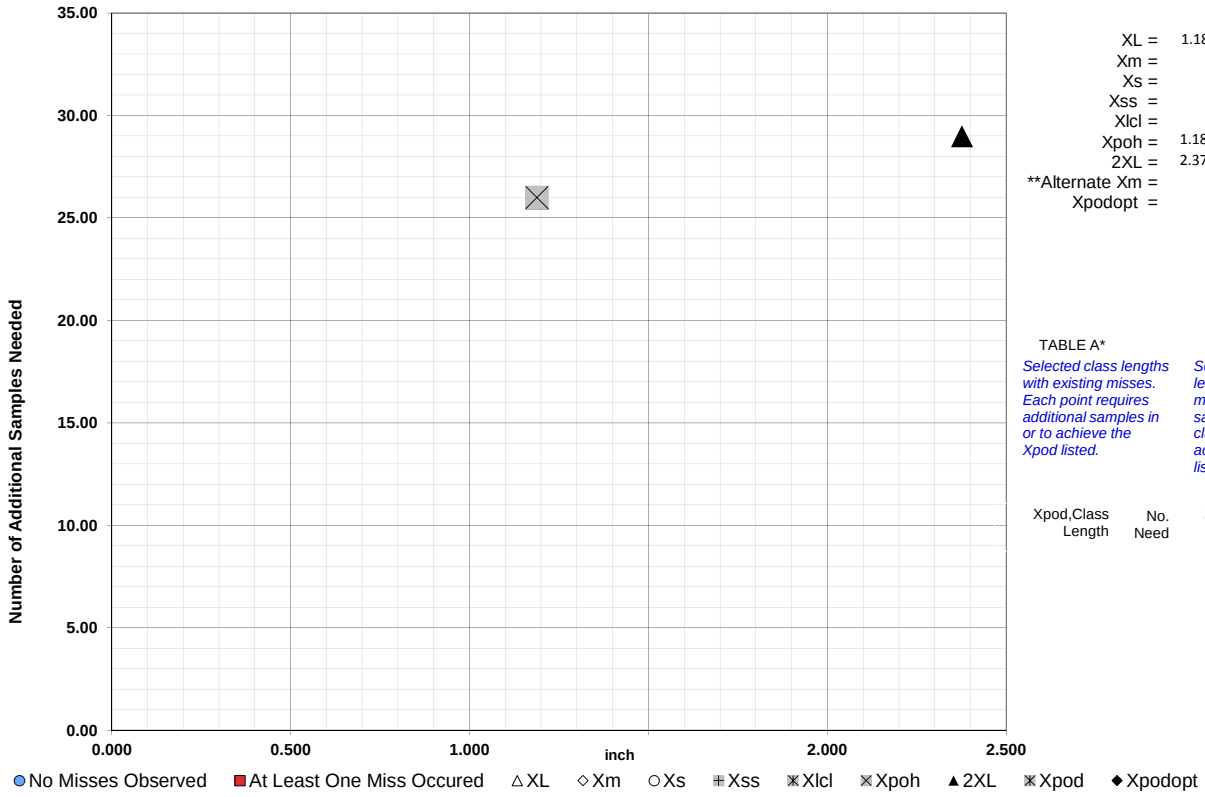



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.188 | 26 |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

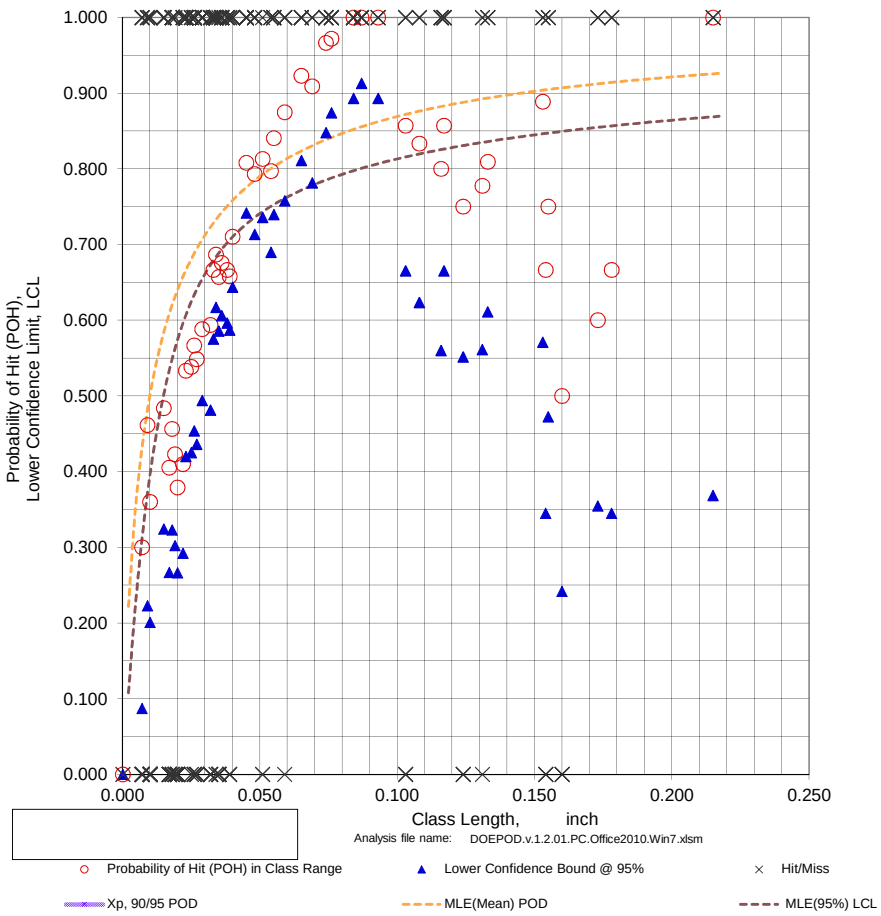
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.261.**

**Warning: No false call analysis.**




File Name = **DA003(3)D.xls**

Data Set Name = **DA003(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:23 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0220 | inch |
| Classlength @ 90/95 Xpod = | 0.0870 | inch |
| Lower Confidence Bound = | 0.9129 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.145 | inch |
| NTIAC 90/95 POD = | | @ | | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.215 | inch |
| Samples Needed @ XL = | 20 | |
| Classlength Mid-point , Xm = | 0.151 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DA003(3)D.xls
Data Set Name = DA003(3)D(CK. NO.)

## Directed DOE Options

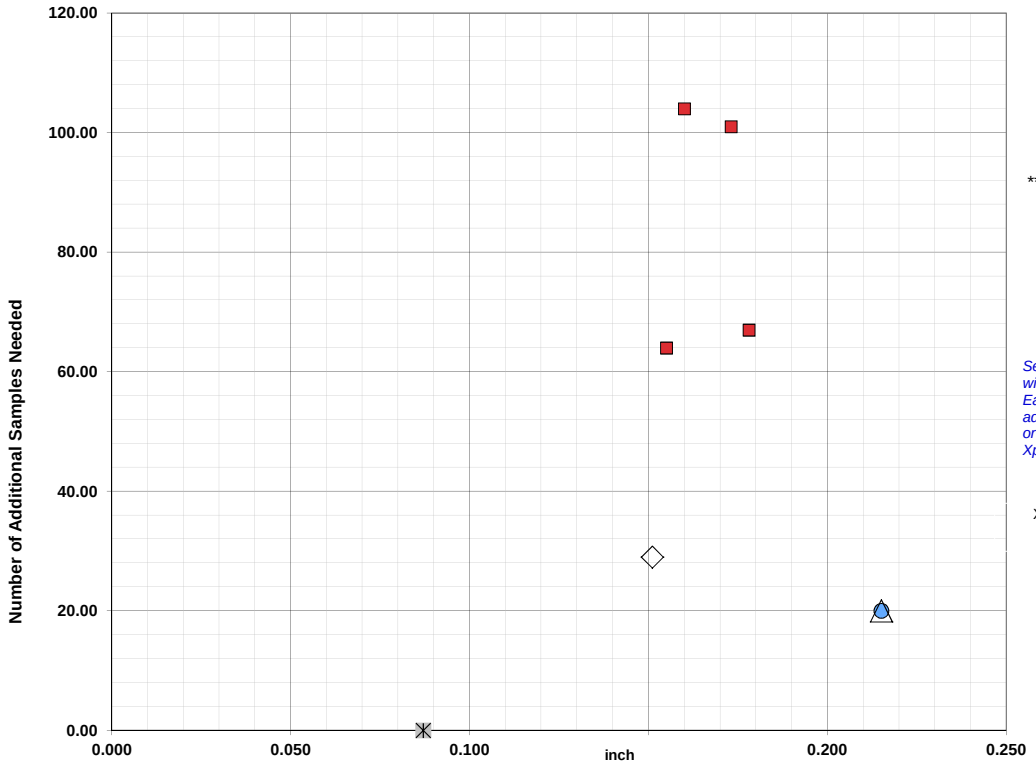



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 20 |
| Xm = | 0.151 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1780 | 67 |
| 0.1730 | 101 |
| 0.1600 | 104 |
| 0.1550 | 64 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.2150 | 20 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 15 more large flaws.**

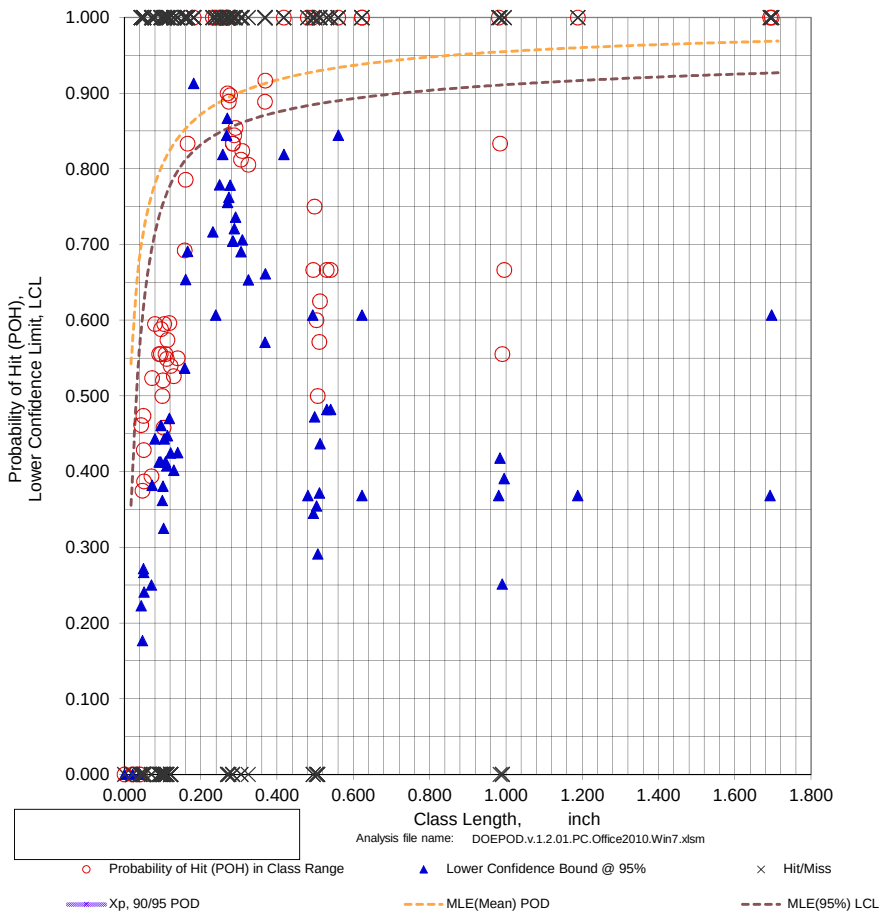
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **DA003(3)L.xls**

Data Set Name = **DA003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:24 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0520 | inch |
| Classlength @ 90/95 Xpod = | 0.1810 | inch |
| Lower Confidence Bound = | 0.9129 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.900 @ 0.350 inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.696 | inch |
| Samples Needed @ XL = | 17 | |
| Classlength Mid-point , Xm = | 0.560 | inch |
| Samples Needed @ Xm = | 11 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DA003(3)L.xls
Data Set Name = DA003(3)L(CK. NO.)

## Directed DOE Options

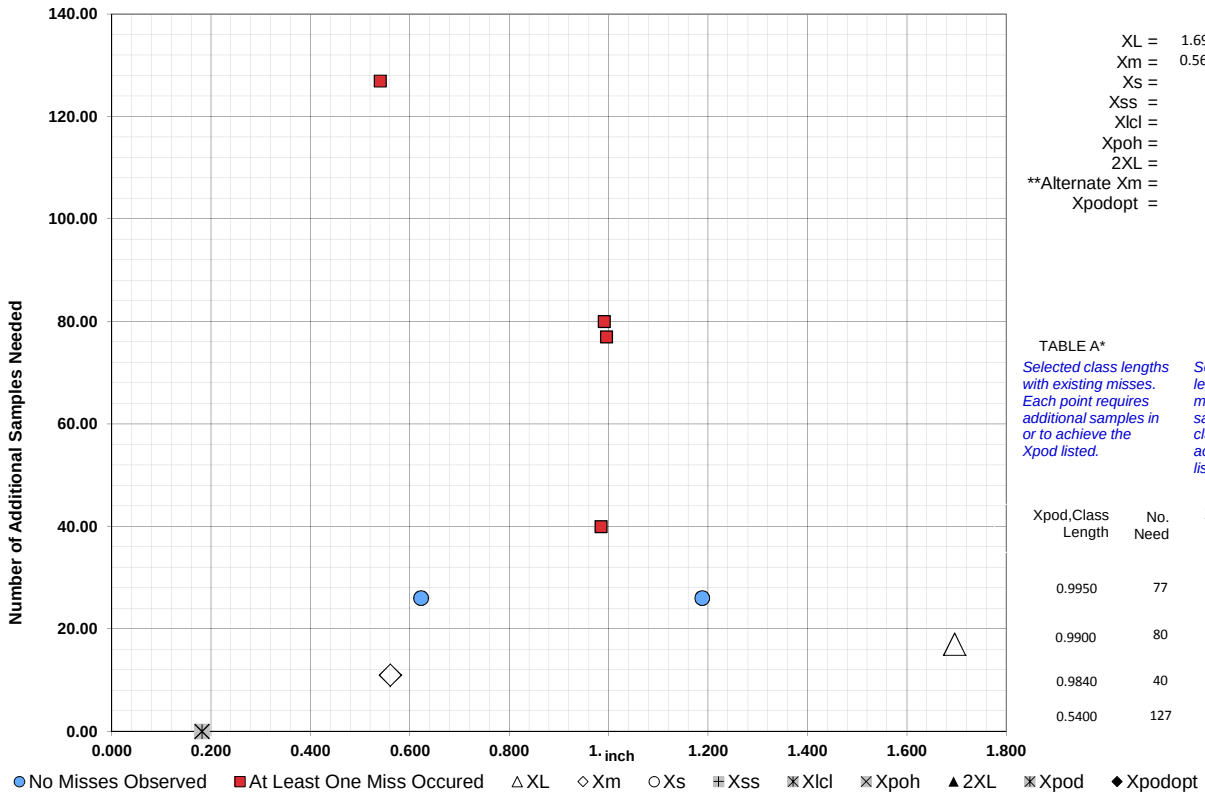



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.696 | 17 |
| Xm = | 0.560 | 11 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.9950 | 77 |
| 0.9900 | 80 |
| 0.9840 | 40 |
| 0.5400 | 127 |

TABLE B*

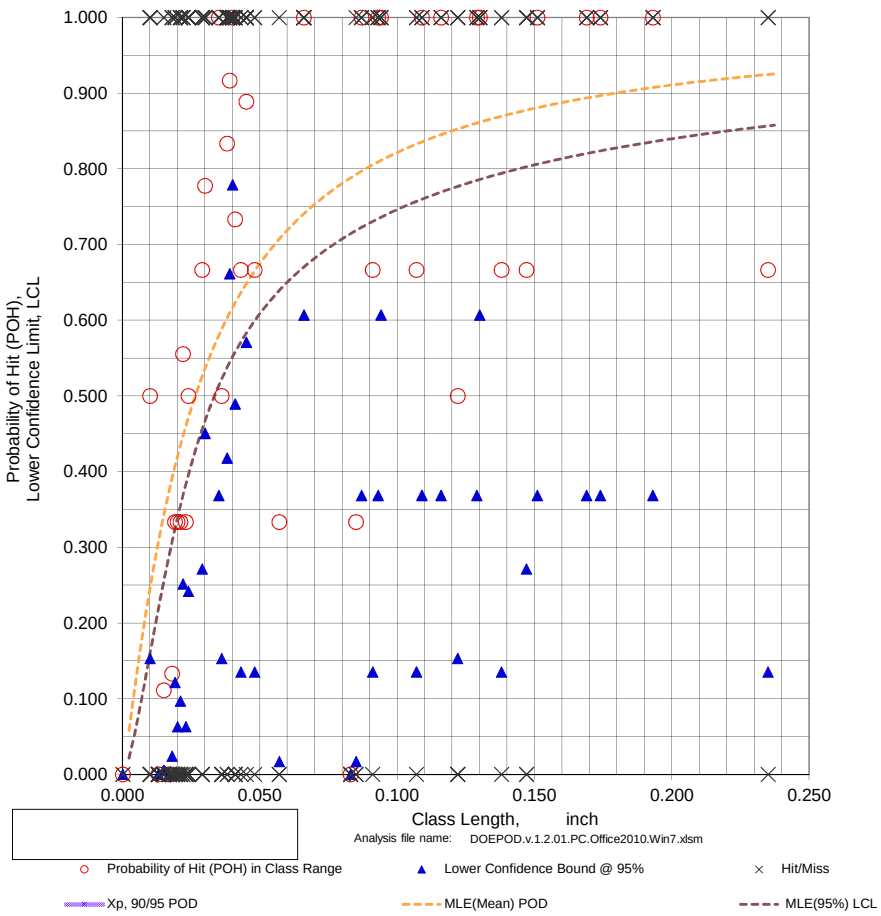
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.1880 | 26 |
| 0.6220 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DB001(3)D.xls
Data Set Name = DB001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:25 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0400 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.901 @ 0.180 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.470 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DB001(3)D.xls
Data Set Name = DB001(3)D(CK. NO.)

## Directed DOE Options

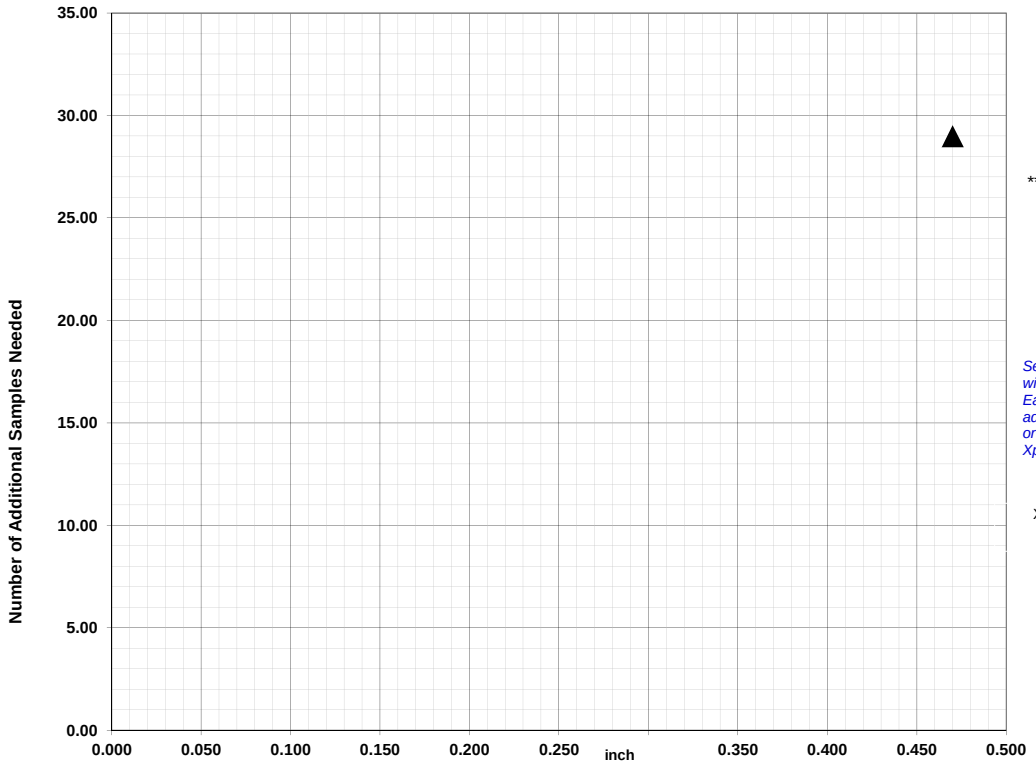



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.470 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

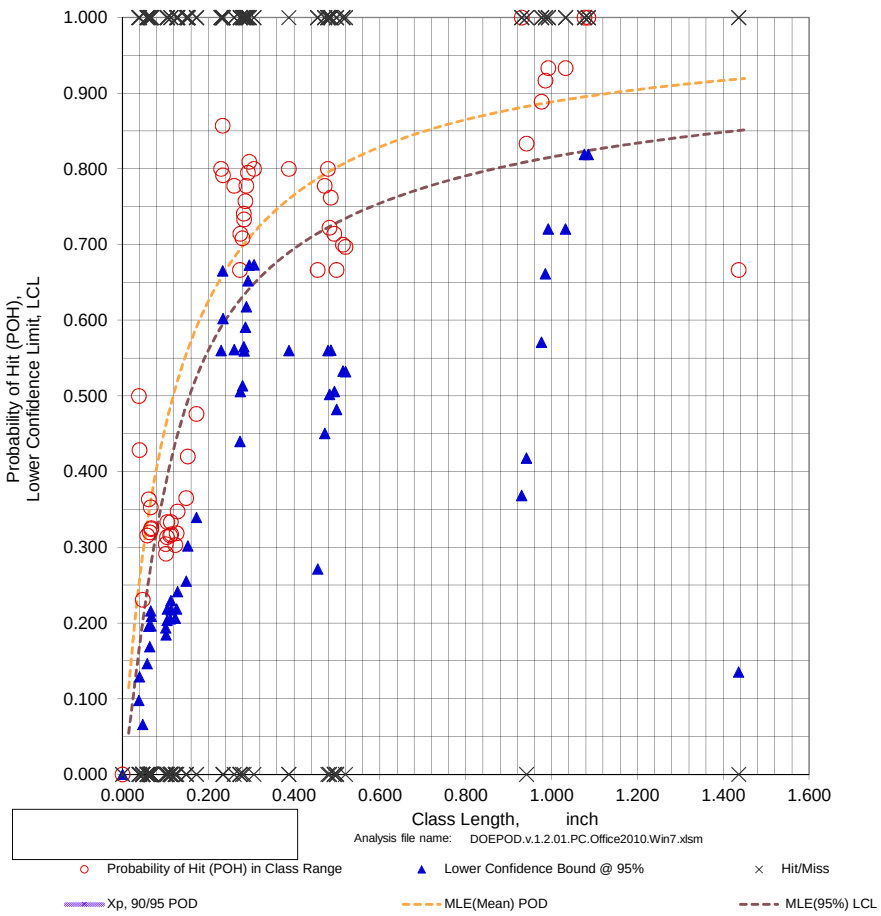
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DB001(3)L.xls
Data Set Name = DB001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:27 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.1000 | inch |
| Classlength @ Best LCL = | 1.0760 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DB001(3)L.xls
Data Set Name = DB001(3)L(CK. NO.)

## Directed DOE Options

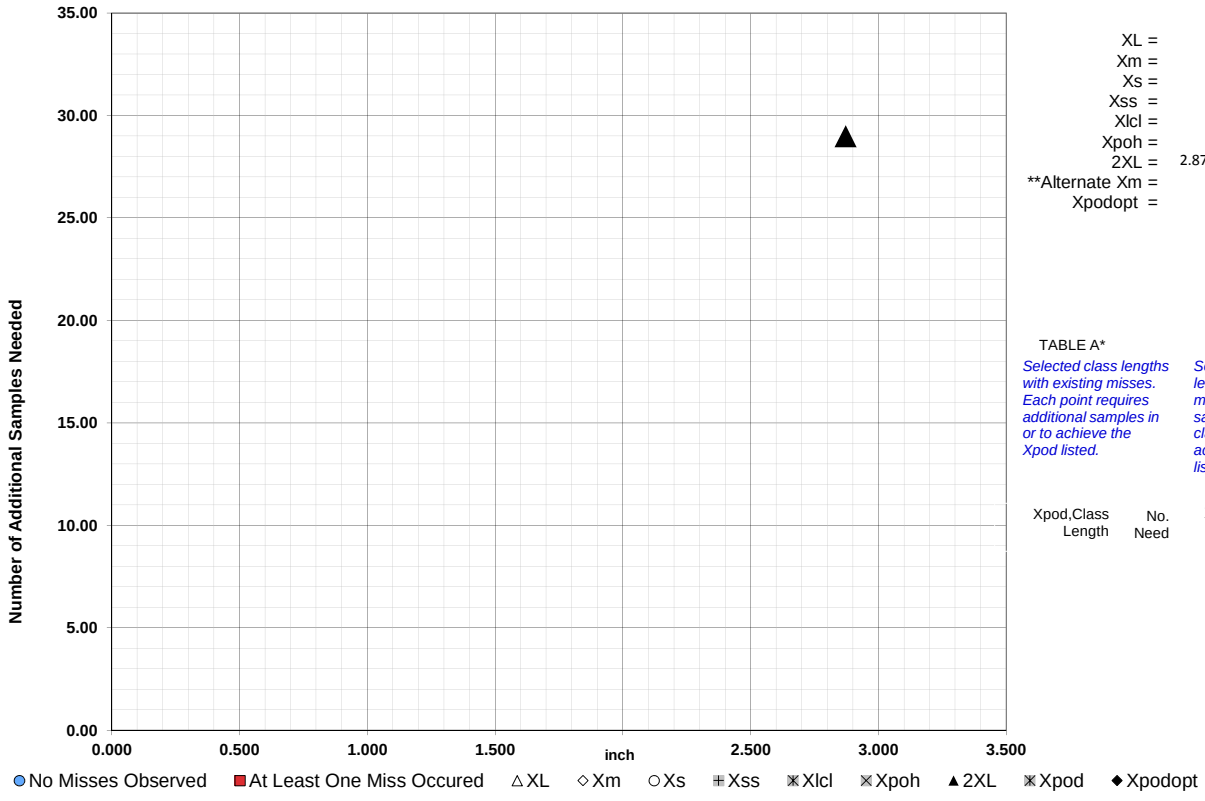



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

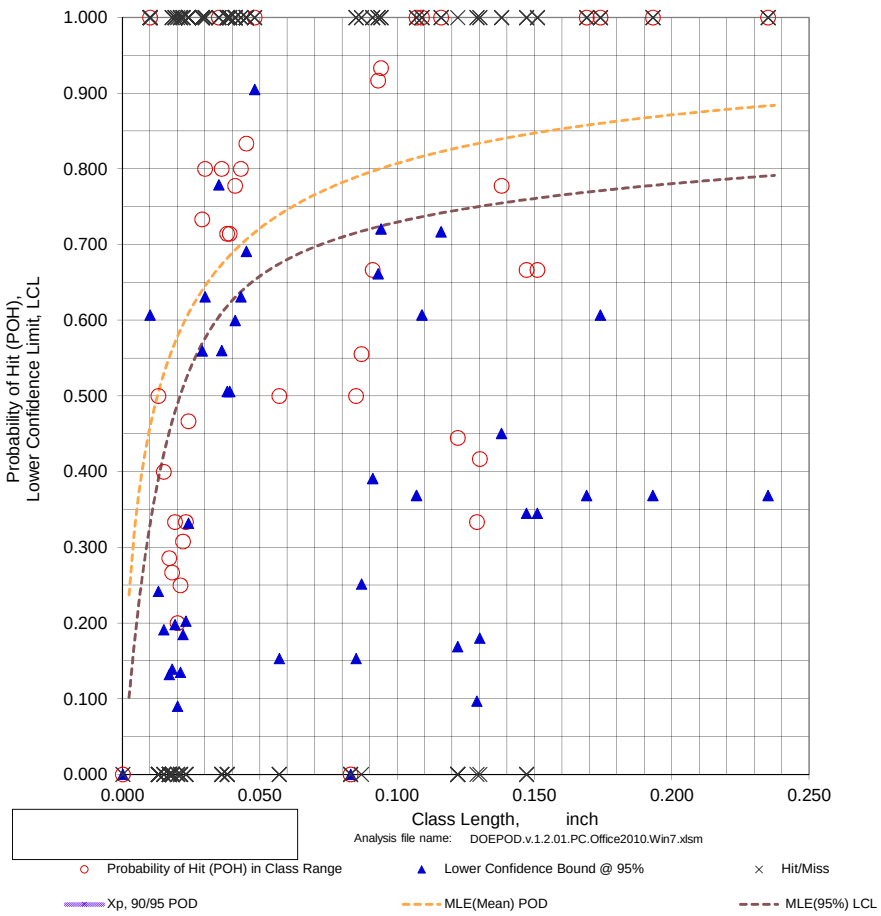
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 11 more large flaws.**

**Warning: No false call analysis.**




File Name = **DB002(3)D.xls**

Data Set Name = **DB002(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:28 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0090 | inch |
| Classlength @ 90/95 Xpod = | 0.0480 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.235 | inch |
| Samples Needed @ XL = | 14 | |
| Classlength Mid-point , Xm = | 0.116 | inch |
| Samples Needed @ Xm = | 20 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DB002(3)D.xls
Data Set Name = DB002(3)D(CK. NO.)

## Directed DOE Options

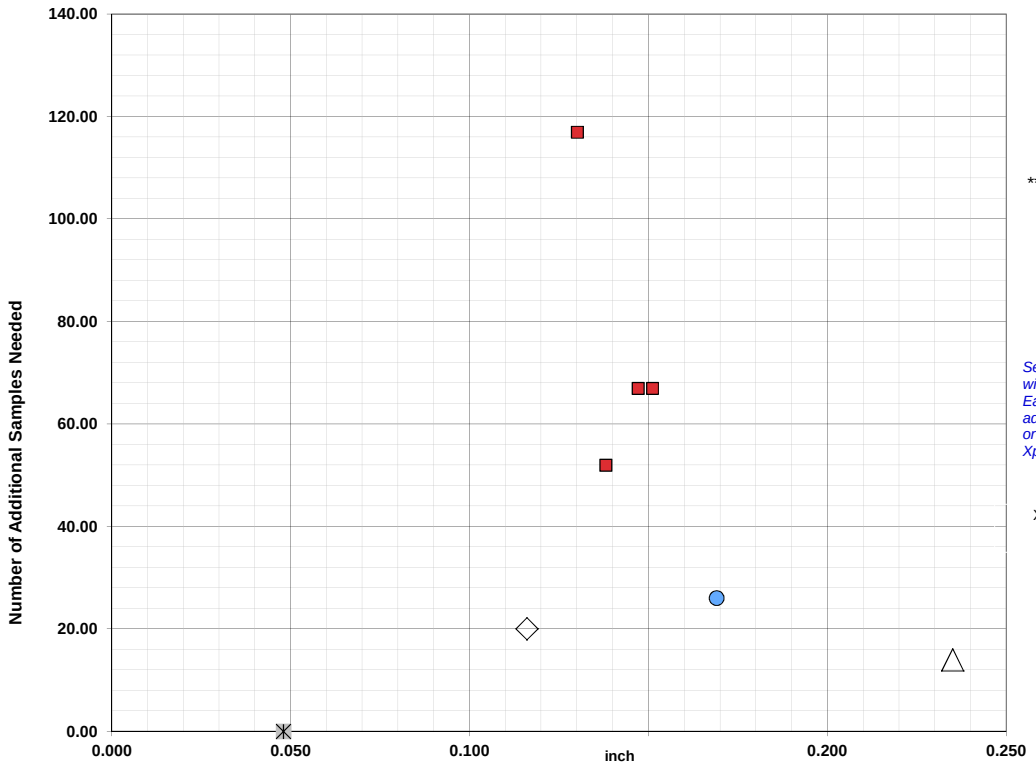



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.235 | 14 |
| Xm = | 0.116 | 20 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1510 | 67 |
| 0.1470 | 67 |
| 0.1380 | 52 |
| 0.1300 | 117 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

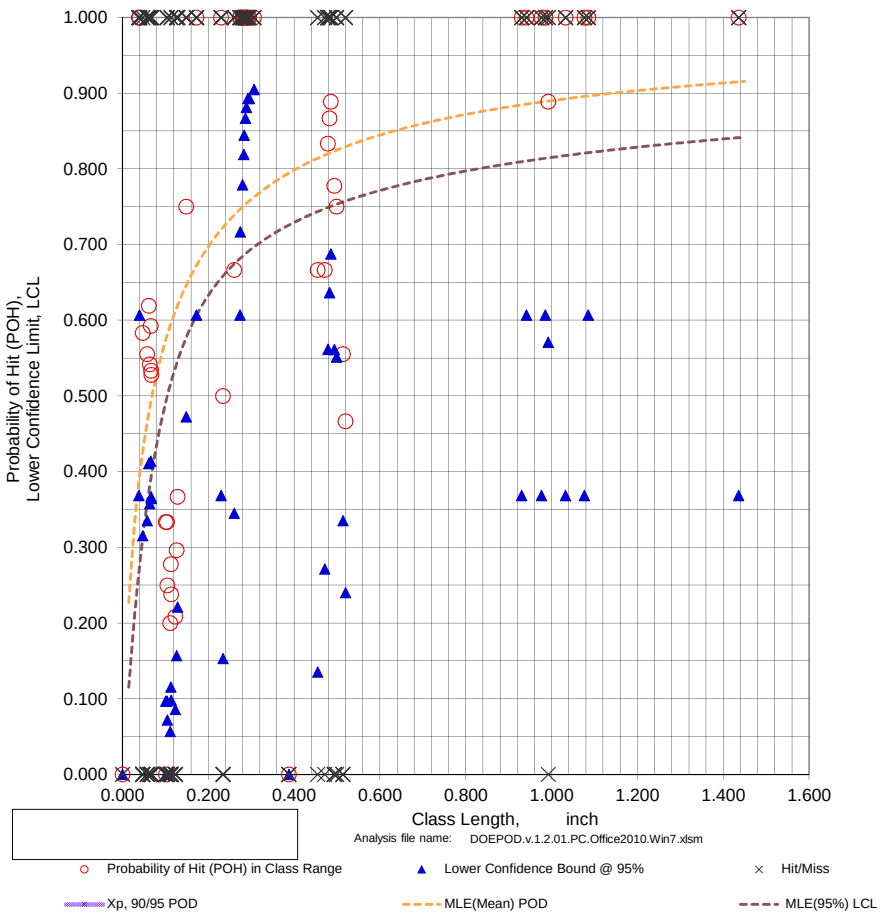
| Xpod,Class Length | No. Need |
|---|---|
| 0.1690 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 16 more large flaws.**

**Warning: No false call analysis.**




File Name = **DB002(3)L.xls**

Data Set Name = **DB002(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:29 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0330 | inch |
| Classlength @ 90/95 Xpod = | 0.3060 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | 17 | |
| Classlength Mid-point , Xm = | 1.085 | inch |
| Samples Needed @ Xm = | 23 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DB002(3)L.xls
Data Set Name = DB002(3)L(CK. NO.)

## Directed DOE Options

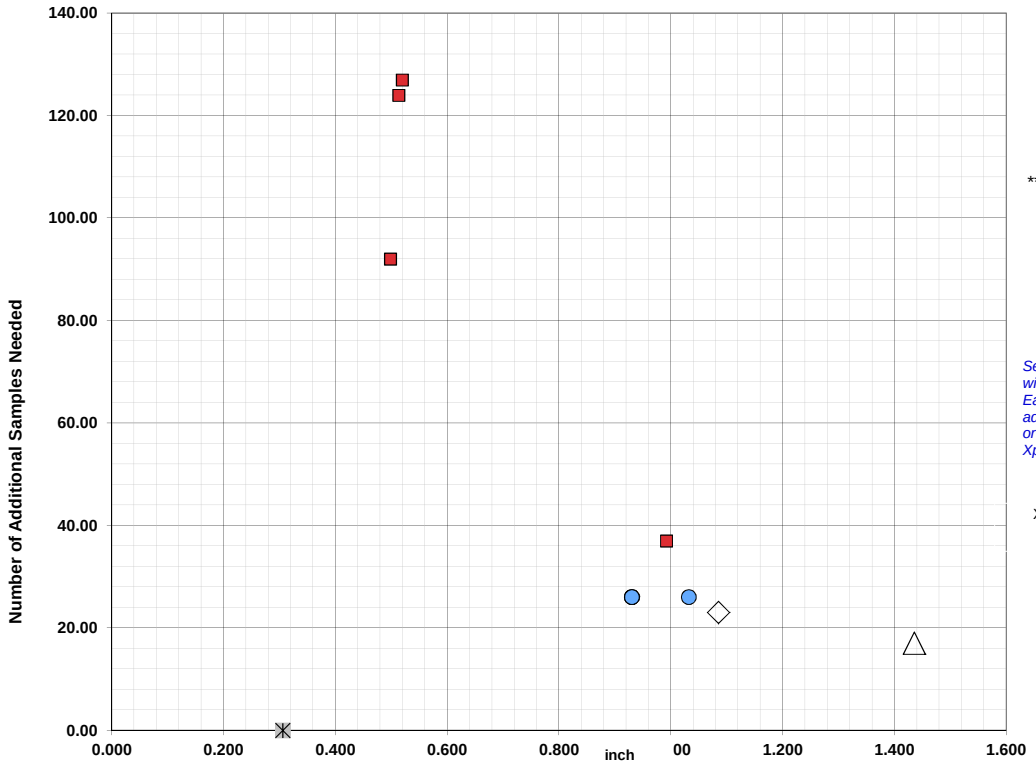



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 17 |
| Xm = | 1.085 | 23 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.9920 | 37 |
| 0.5190 | 127 |
| 0.5130 | 124 |
| 0.4980 | 92 |

TABLE B*

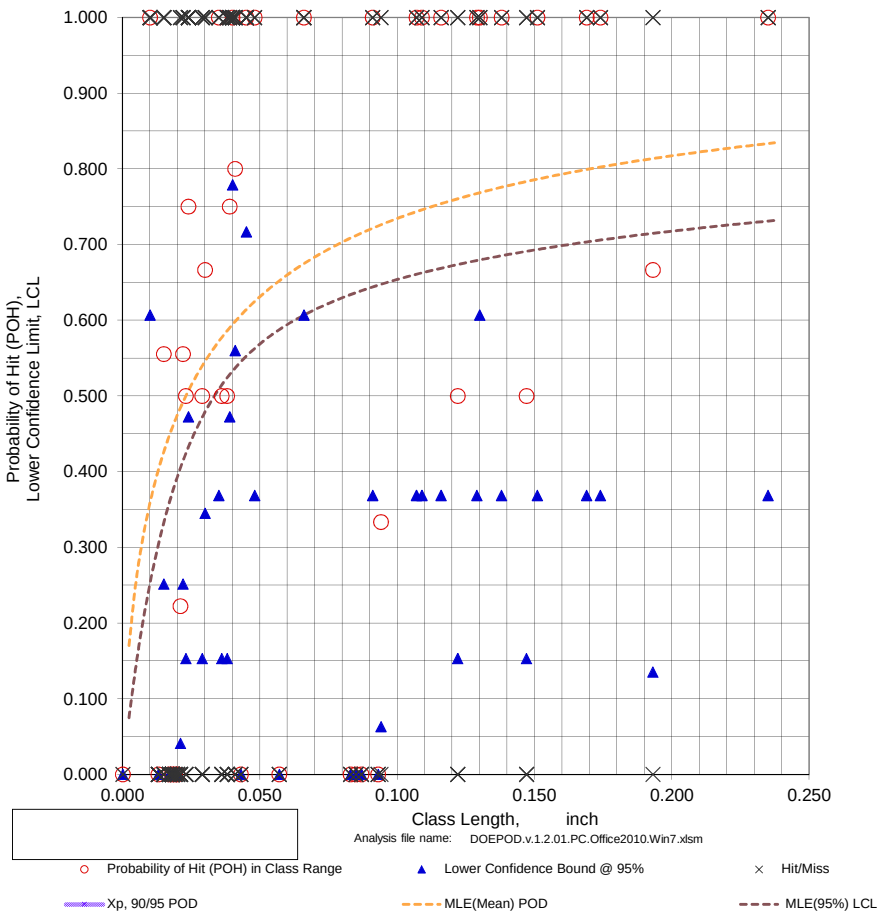
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.0320 | 26 |
| 0.9300 | 26 |
| 0.9300 | 26 |
| 0.9300 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DB003(3)D.xls
Data Set Name = DB003(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:30 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0400 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2350 -0.041 inch 26 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.235 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.235 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.470 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DB003(3)D.xls
Data Set Name = DB003(3)D(CK. NO.)

## Directed DOE Options

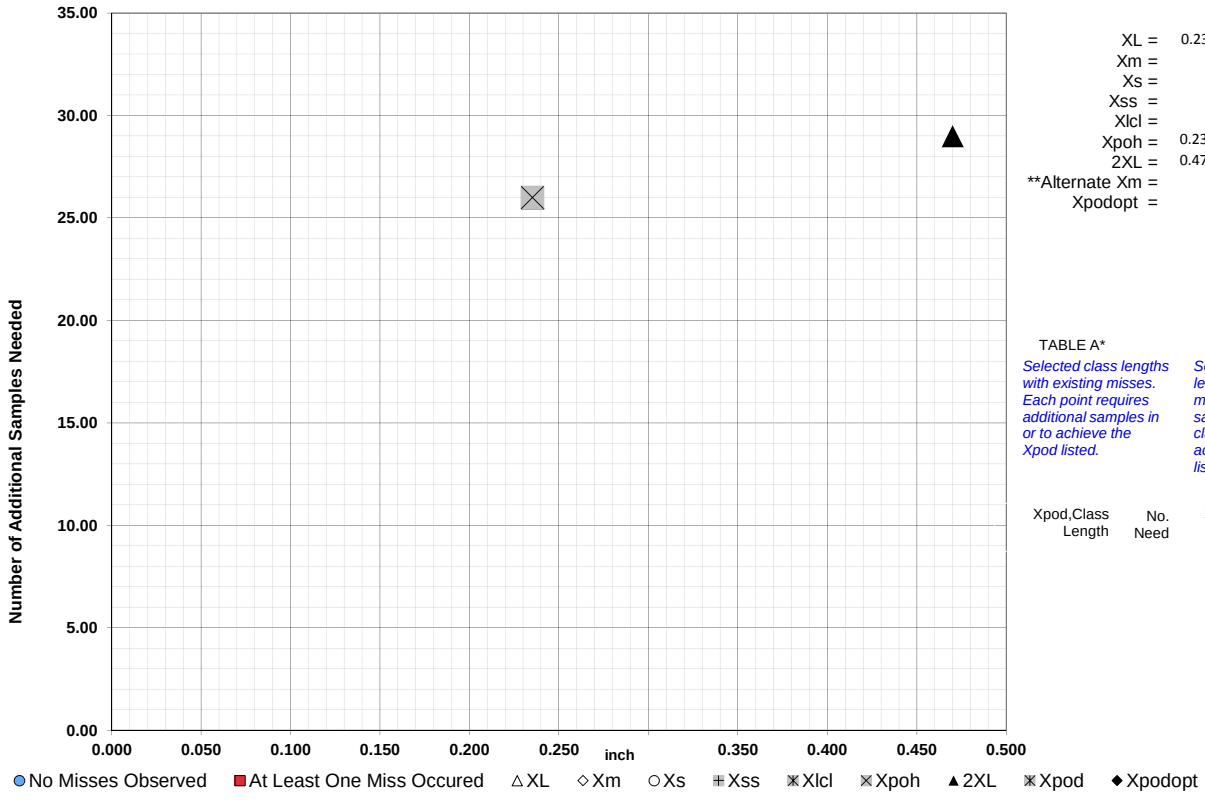



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.235 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.235 | 26 |
| 2XL = | 0.470 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

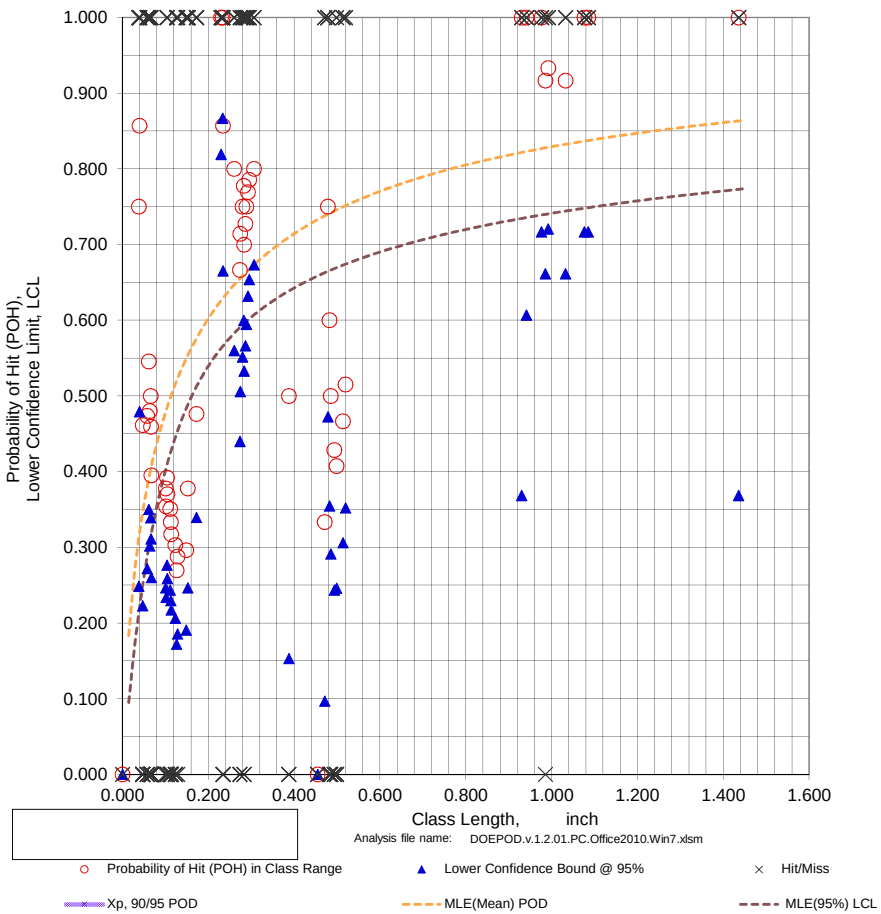
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DB003(3)L.xls
Data Set Name = DB003(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:31 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0850 | inch |
| Classlength @ Best LCL = | 0.2330 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.9920 -0.006 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 1.435 | | inch |
| Samples Needed @ XL = | 26 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 1.076 | | inch |
| Samples Needed @ Xpoh = | 20 | | |
| New Largest Classlength , 2XL = | 2.870 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = DB003(3)L.xls
Data Set Name = DB003(3)L(CK. NO.)

## Directed DOE Options

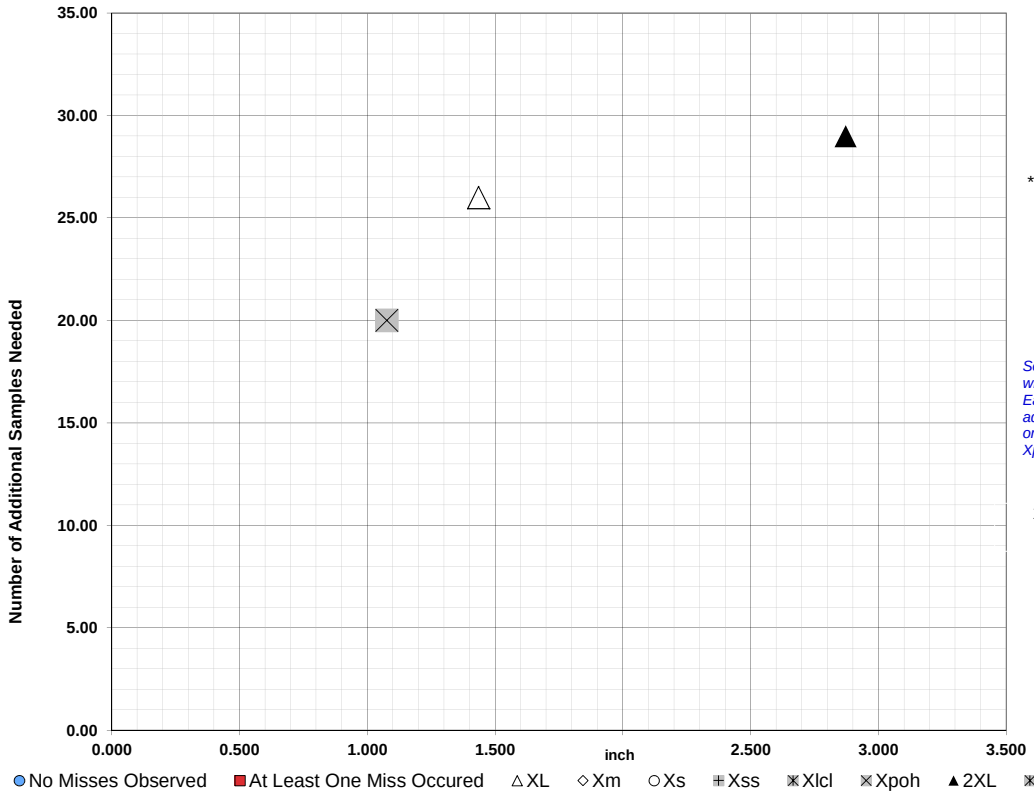



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.076 | 20 |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 3 more large flaws.

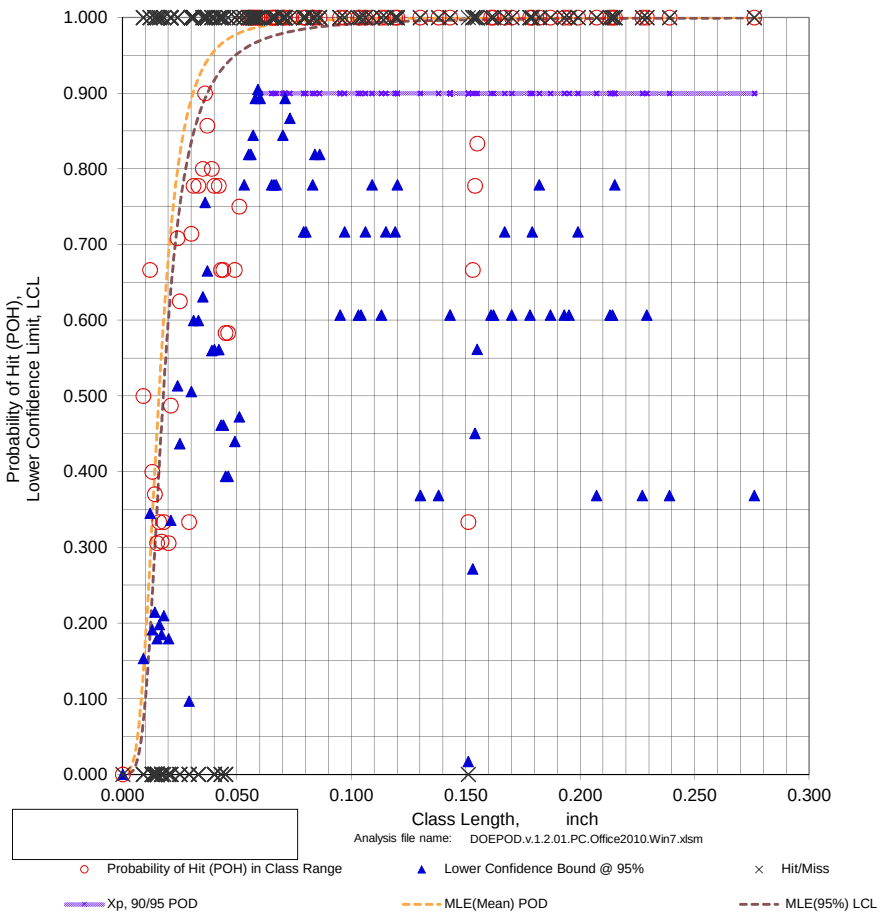
Any highlighted Misses are RED and shown in Column A of this data sheet

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = DC001(3)D.xls

Data Set Name = DC001(3)D(CK. NO.)




| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:32 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0060 | inch |
| Classlength @ 90/95 Xpod = | 0.0590 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.923 | @ | 0.040 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.276 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.215 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0590 | inch |

File Name = DC001(3)D.xls
Data Set Name = DC001(3)D(CK. NO.)

## Directed DOE Options

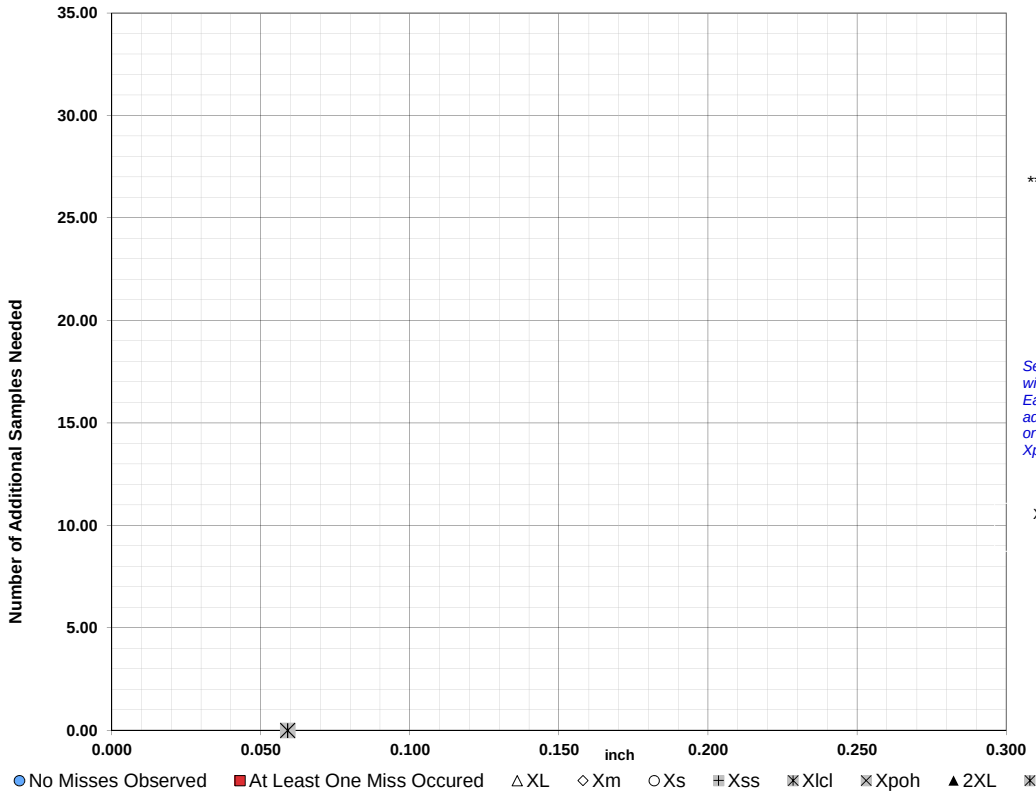



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.276 |
| Xm = | 0.215 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

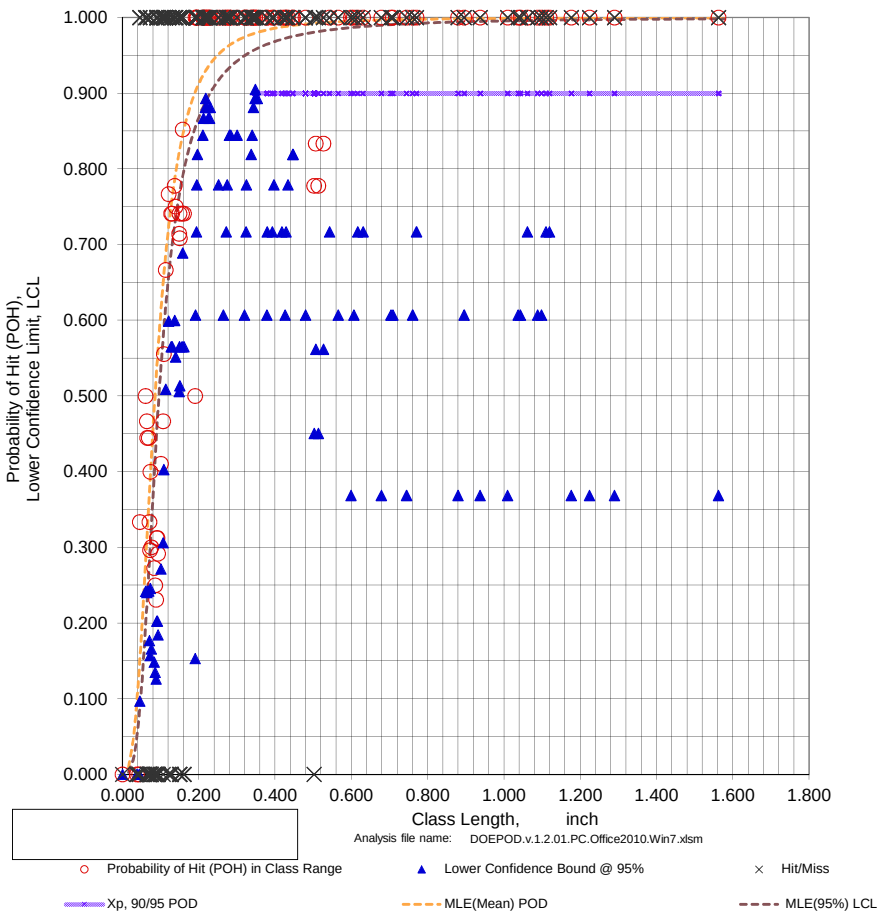
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **DC001(3)L.xls**

Data Set Name = **DC001(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:37 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0290 | inch |
| Classlength @ 90/95 Xpod = | 0.3480 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.180 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.215 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3480 | inch |

File Name = DC001(3)L.xls
Data Set Name = DC001(3)L(CK. NO.)

## Directed DOE Options

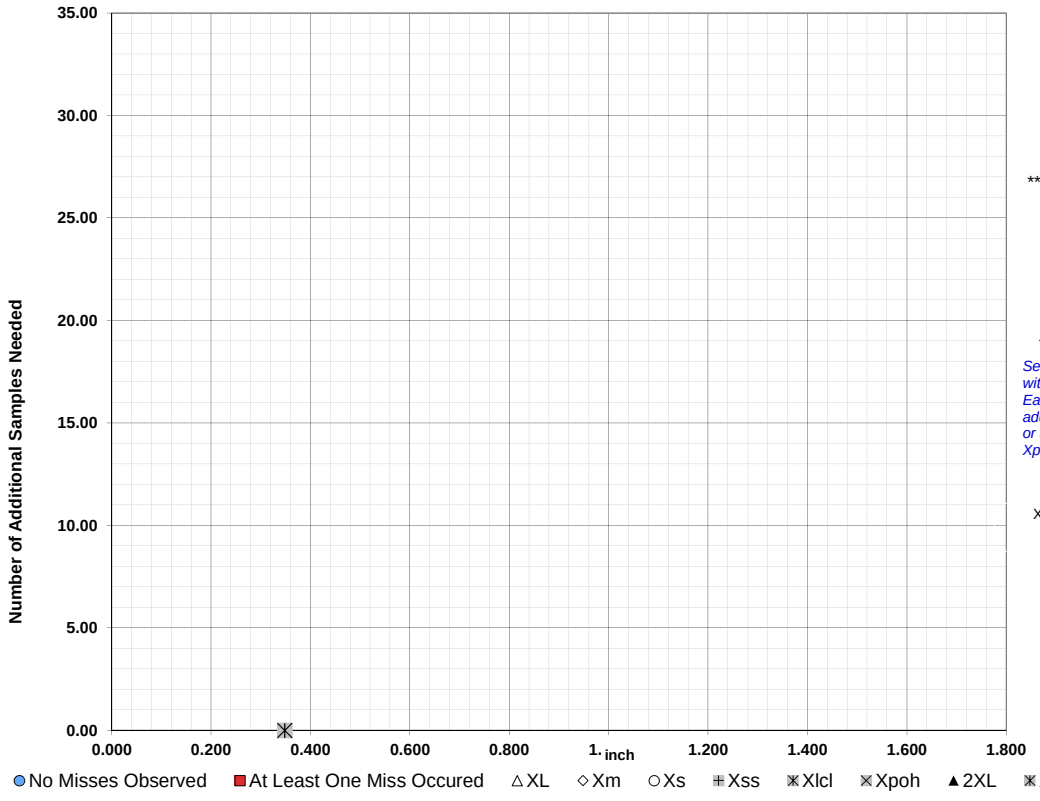



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.562 |
| Xm = | 1.119 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

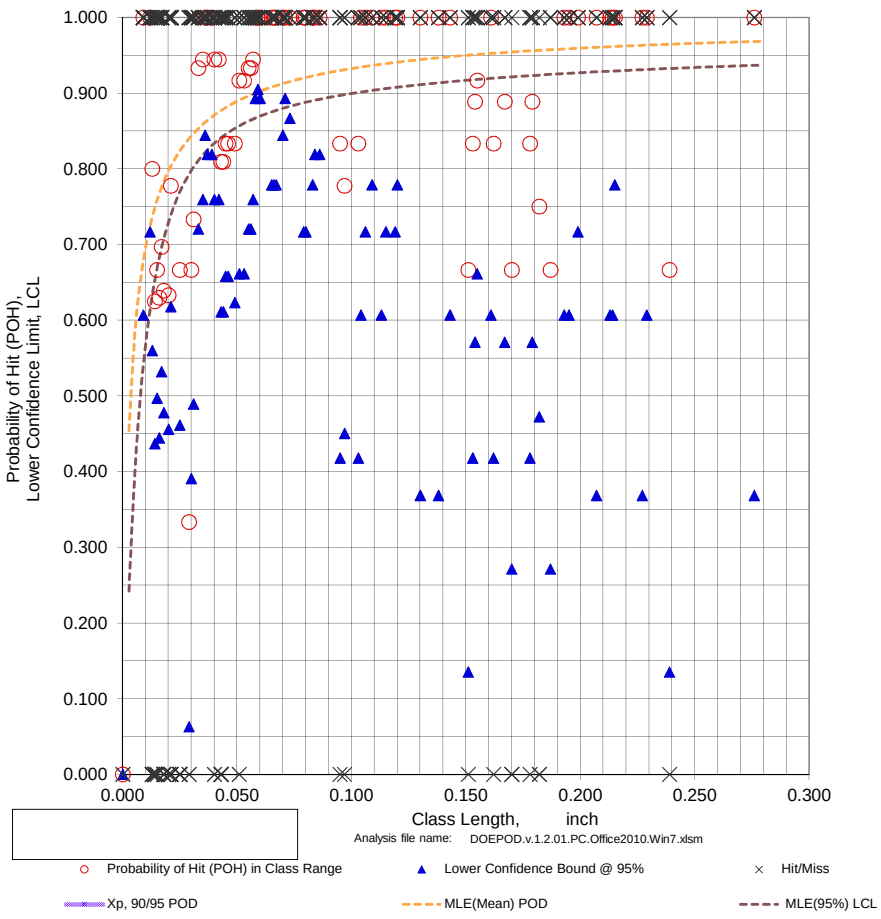
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 3 more large flaws.**

**Warning: No false call analysis.**




File Name = **DC002(3)D.xls**

Data Set Name = **DC002(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:43 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0060 | inch |
| Classlength @ 90/95 Xpod = | 0.0590 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.060 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.276 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | 0.215 | inch |
| Samples Needed @ Xm = | 17 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DC002(3)D.xls
Data Set Name = DC002(3)D(CK. NO.)

## Directed DOE Options

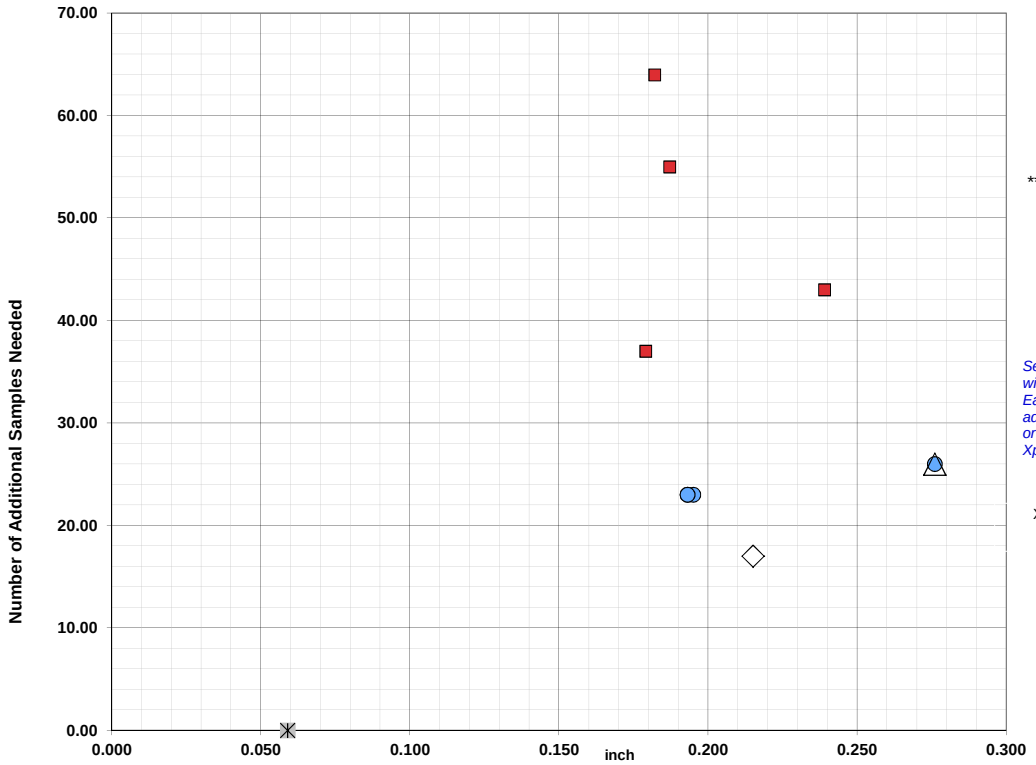



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.276 | 26 |
| Xm = | 0.215 | 17 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.2390 | 43 |
| 0.1870 | 55 |
| 0.1820 | 64 |
| 0.1790 | 37 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.2760 | 26 |
| 0.1950 | 23 |
| 0.1930 | 23 |
| 0.1930 | 23 |

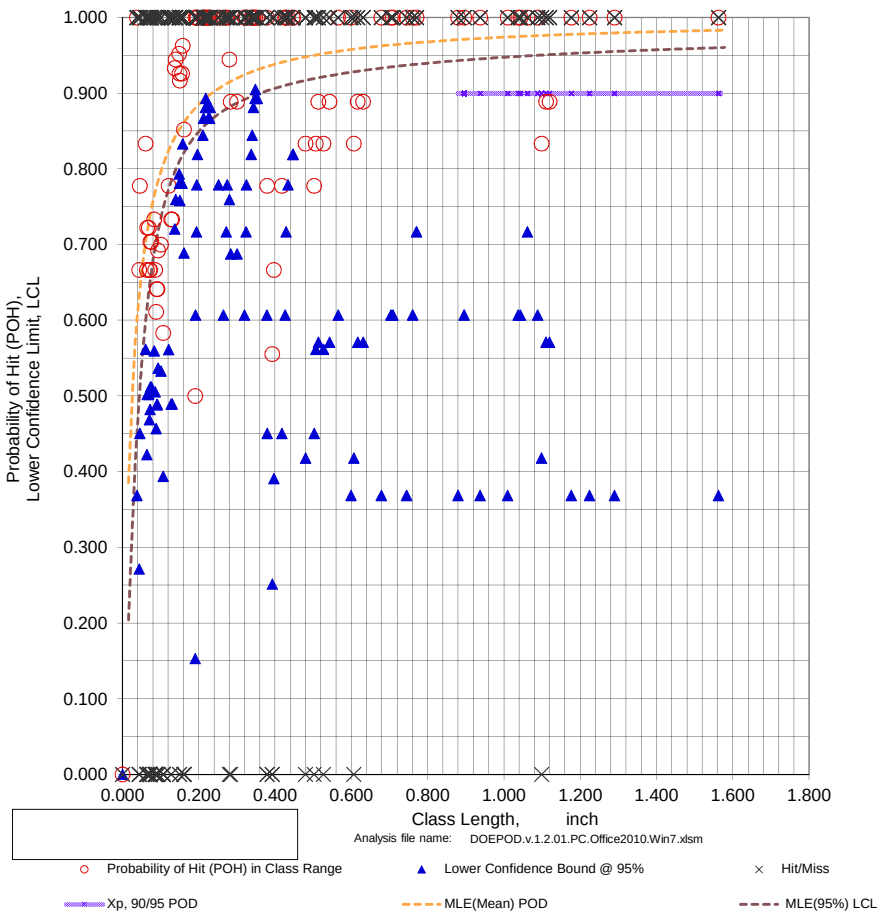
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **DC002(3)L.xls**

Data Set Name = **DC002(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:47 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0290 | inch |
| Classlength @ 90/95 Xpod = | 0.3480 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.235 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.360 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.061 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.8950 | inch |

File Name = DC002(3)L.xls
Data Set Name = DC002(3)L(CK. NO.)

## Directed DOE Options

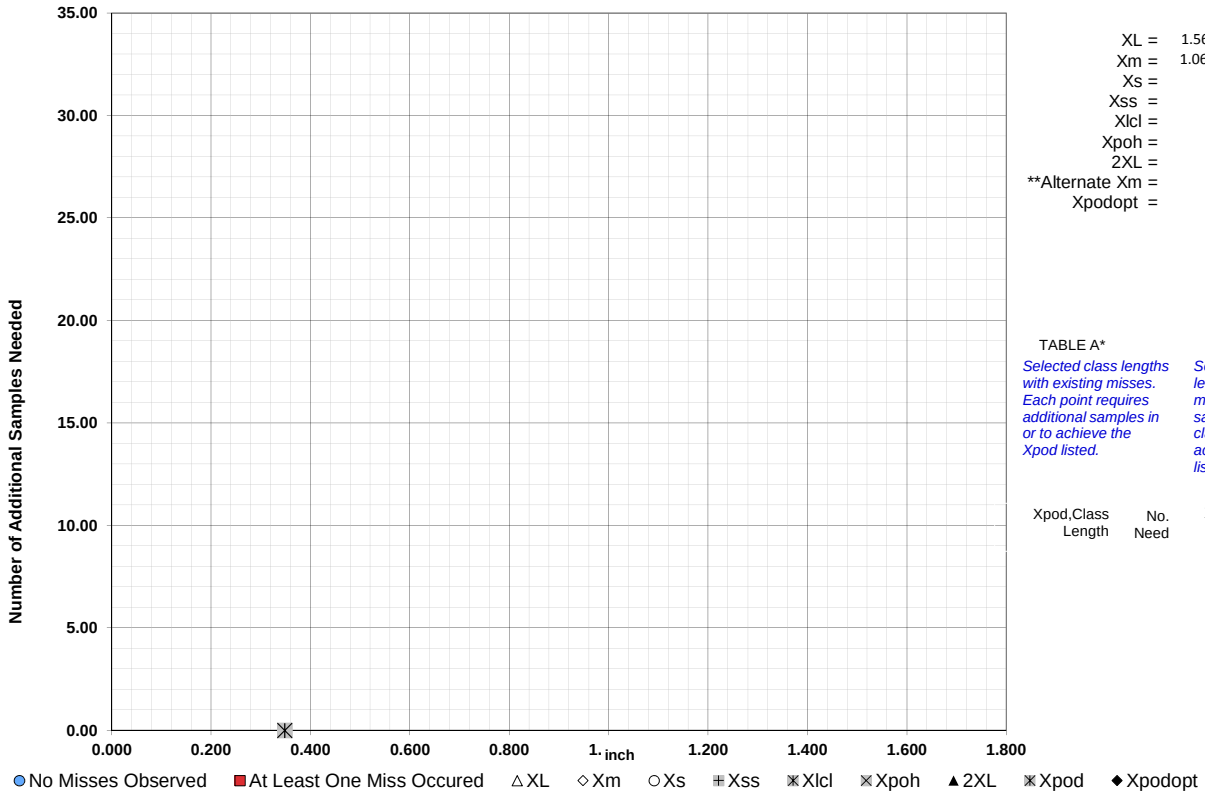



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.562 |
| Xm = | 1.061 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

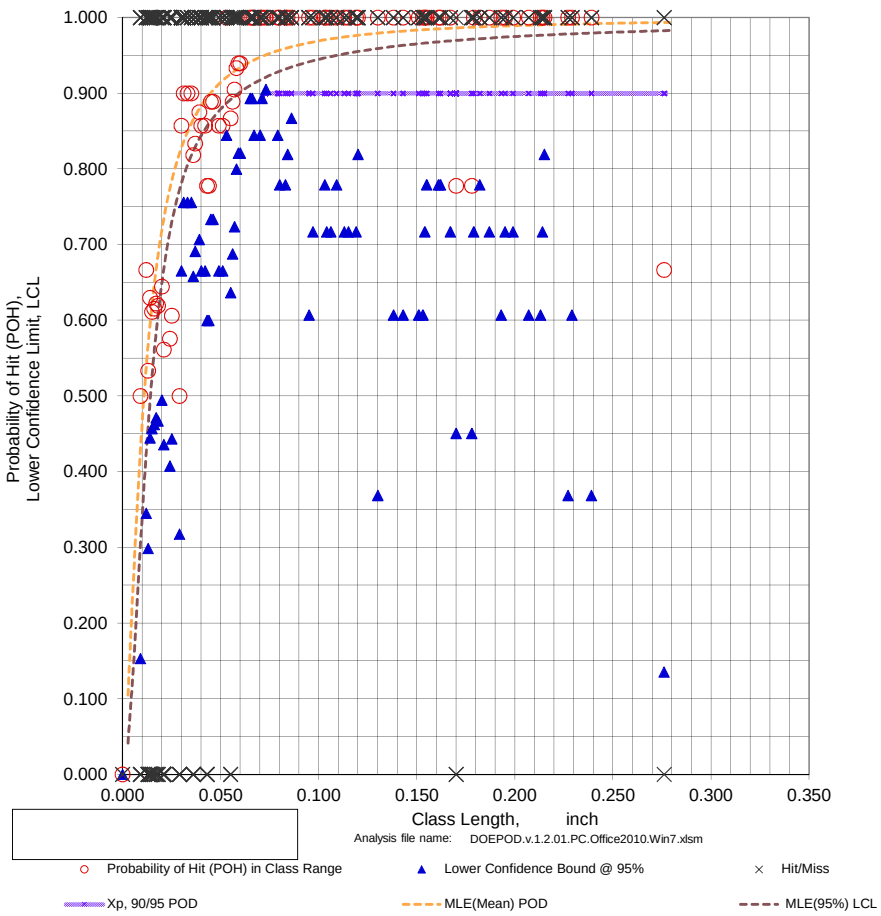
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 5 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **DC003(3)D.xls**

Data Set Name = **DC003(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:50 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0080 | inch |
| Classlength @ 90/95 Xpod = | 0.0730 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.045 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.060 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.276 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.215 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.0730 | inch |

File Name = DC003(3)D.xls
Data Set Name = DC003(3)D(CK. NO.)

## Directed DOE Options

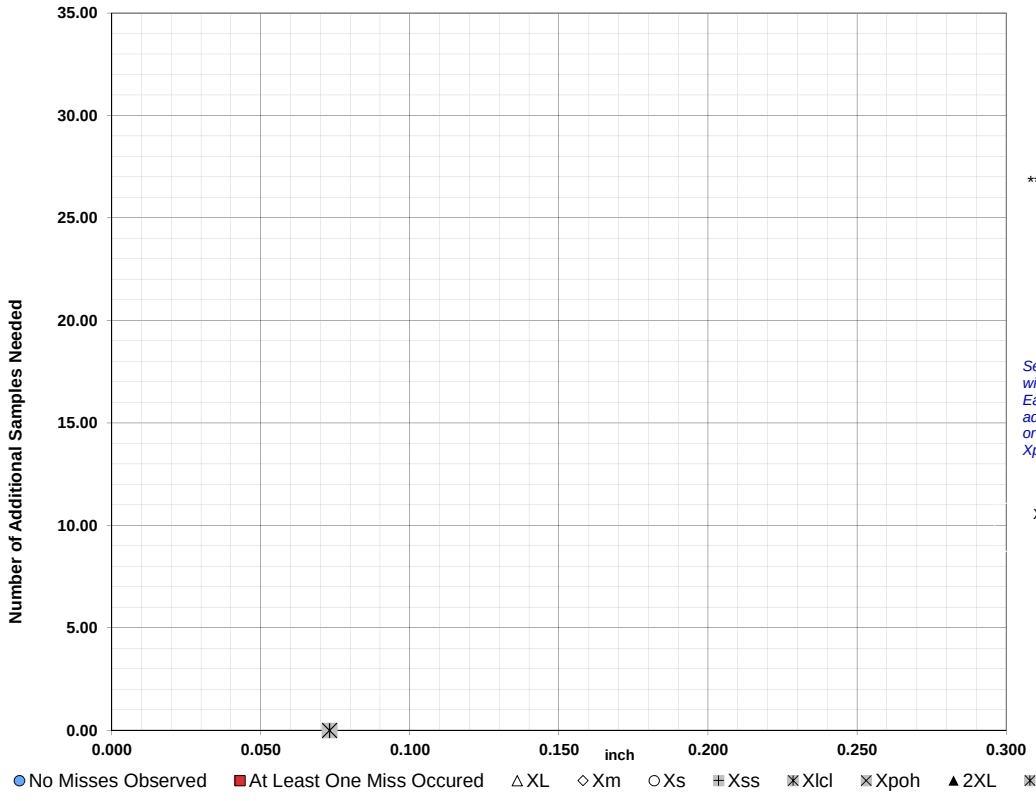



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.276 |
| Xm = | 0.215 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

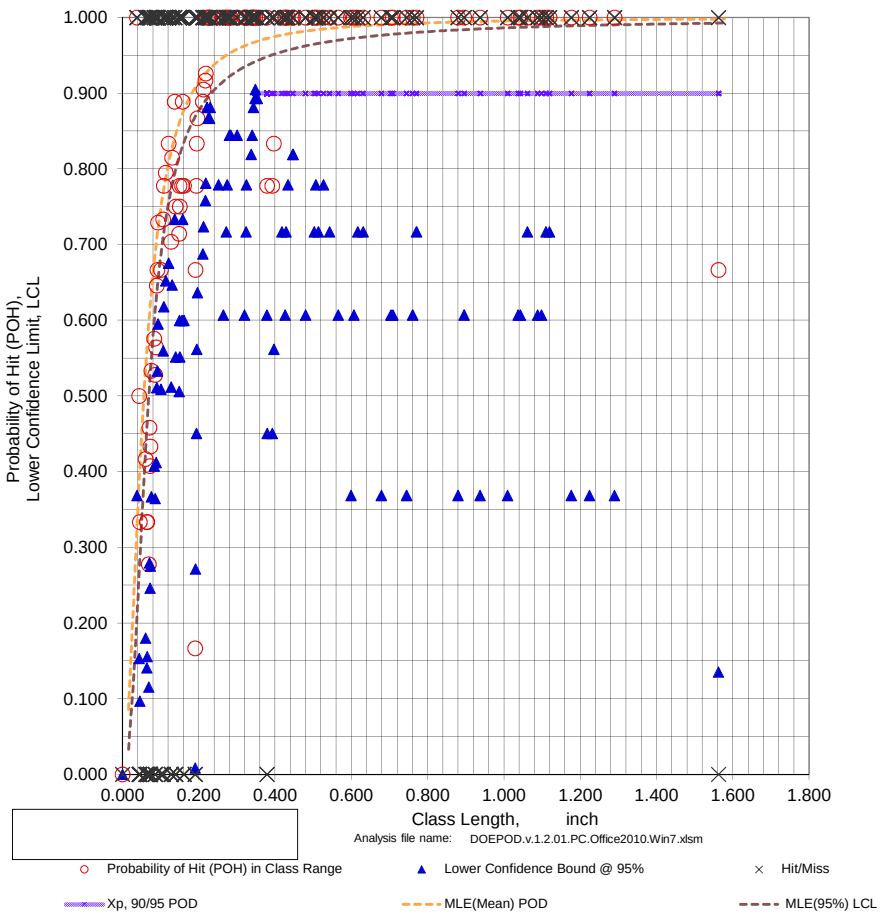
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **DC003(3)L.xls**

Data Set Name = **DC003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 2:54 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0290 | inch |
| Classlength @ 90/95 Xpod = | 0.3480 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.185 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.235 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.3480 | inch |

File Name = DC003(3)L.xls
Data Set Name = DC003(3)L(CK. NO.)

## Directed DOE Options

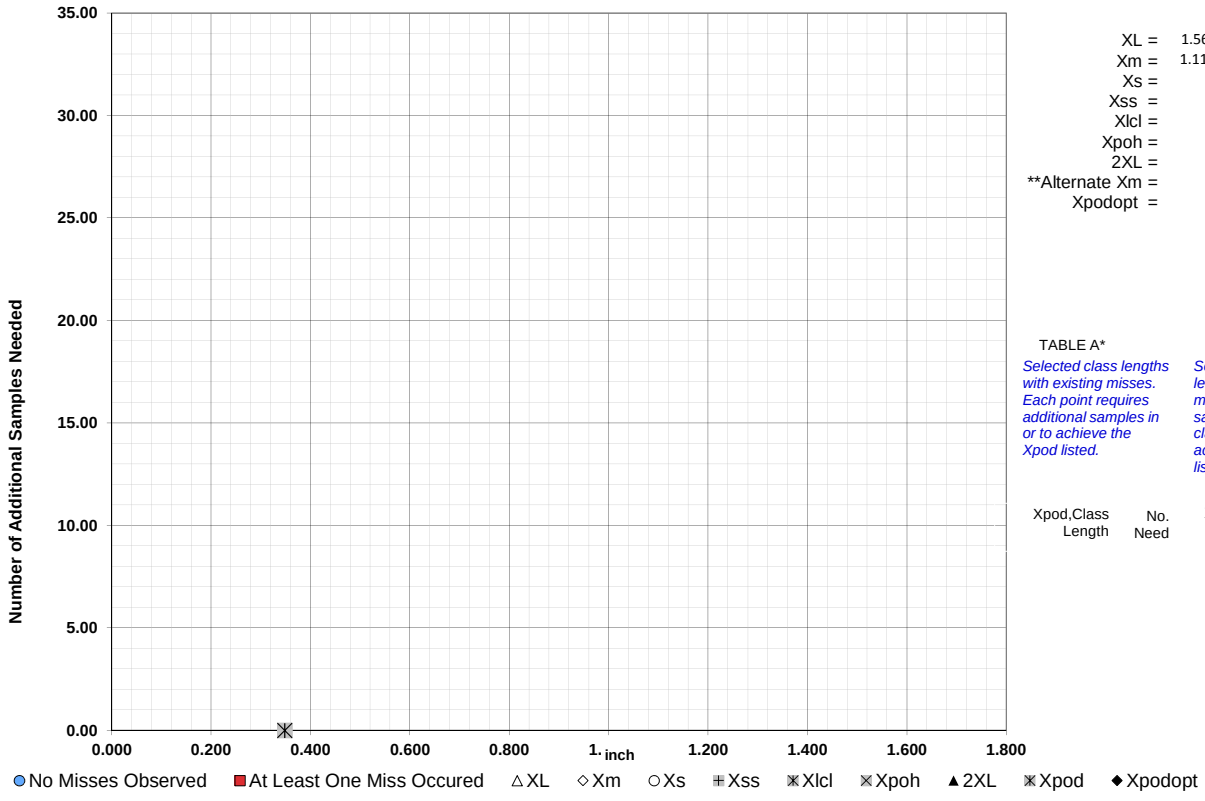



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.562 |
| Xm = | 1.119 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

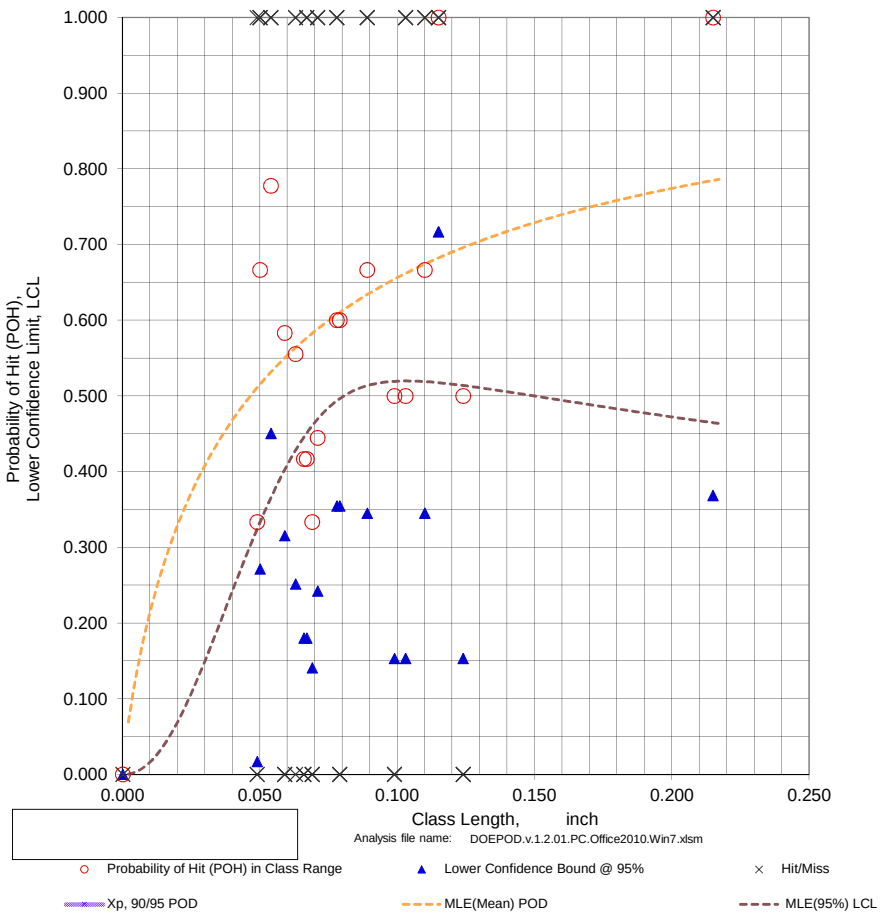
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = DD001(3)D.xls
Data Set Name = DD001(3)D(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:00 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.1150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2150 -0.090 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.215 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.215 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DD001(3)D.xls
Data Set Name = DD001(3)D(CK. NO. )

## Directed DOE Options

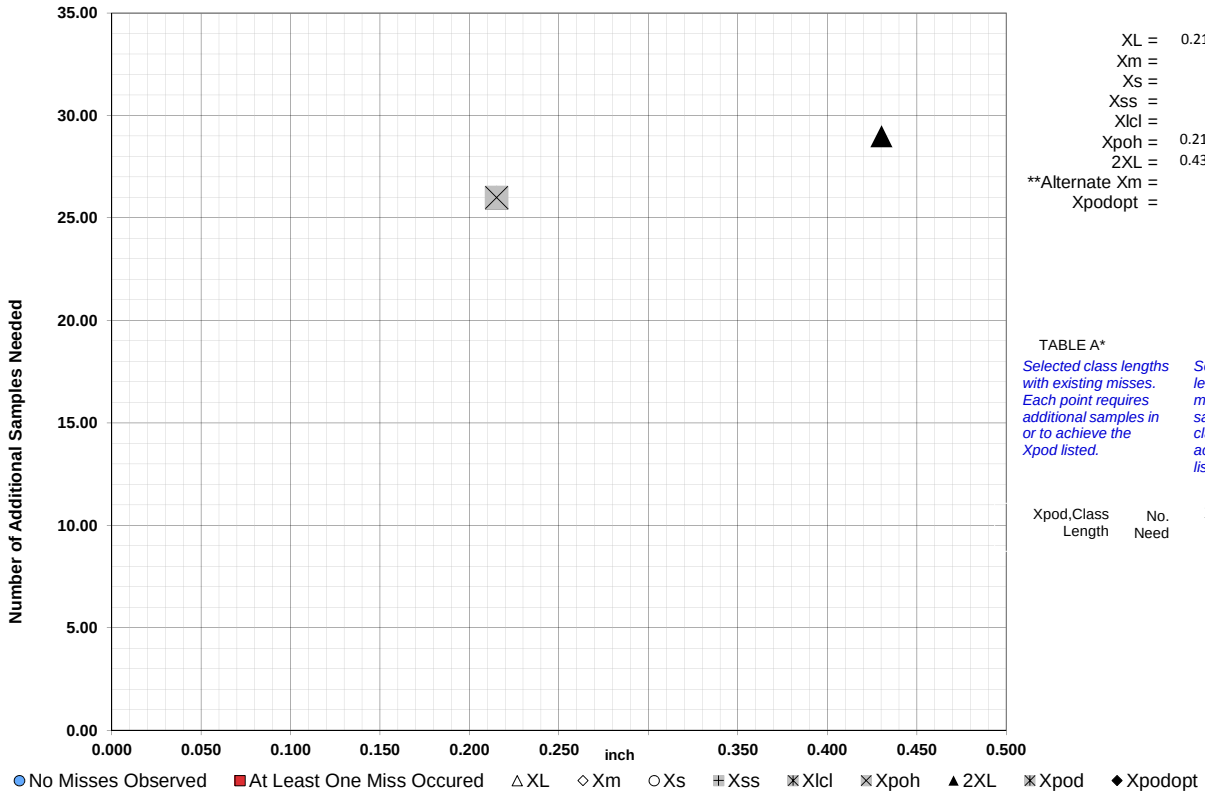



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.215 | 26 |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

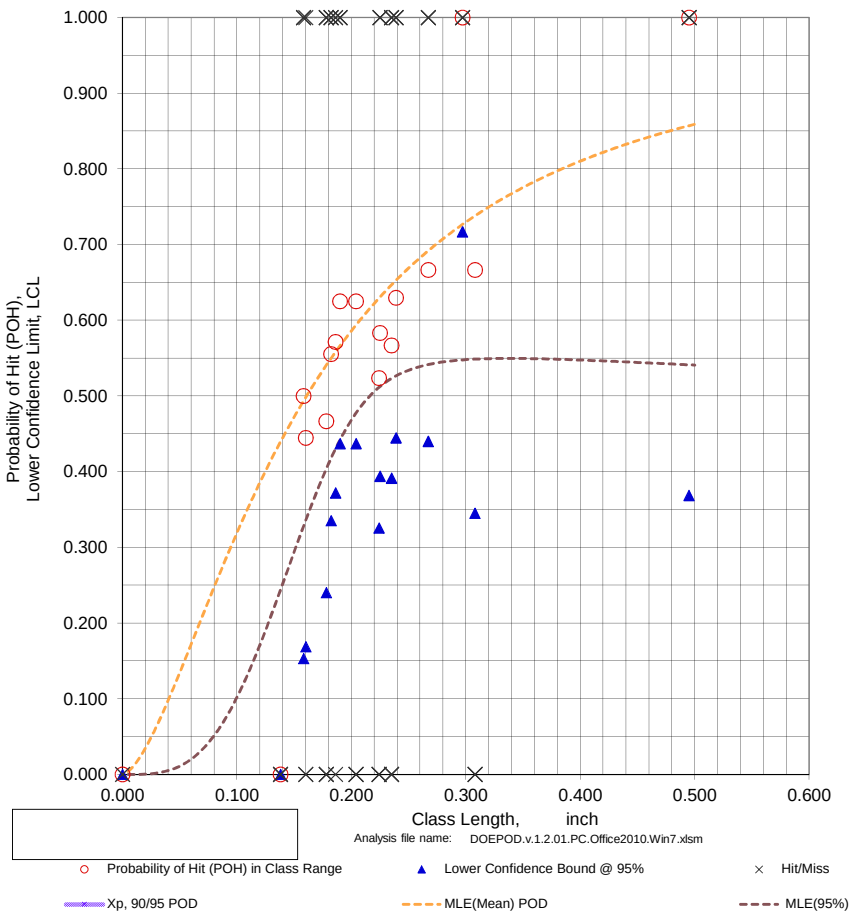
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DD001(3)L.xls
Data Set Name = DD001(3)L(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:01 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0580 | inch |
| Classlength @ Best LCL = | 0.2970 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.4950 -0.100 inch 26 Samples

NTIAC 90% POD = 0.900 @ 0.640 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.495 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.990 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DD001(3)L.xls
Data Set Name = DD001(3)L(CK. NO. )

## Directed DOE Options

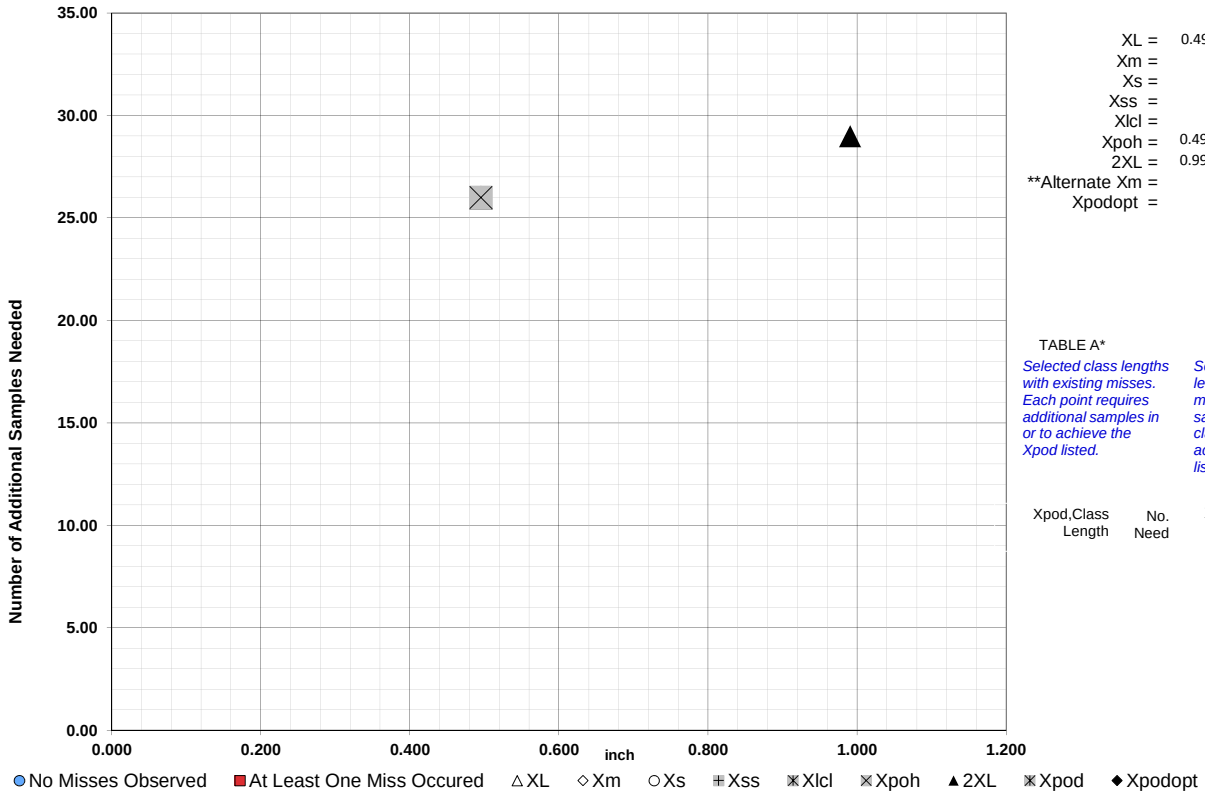



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.495 | 26 |
| 2XL = | 0.990 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

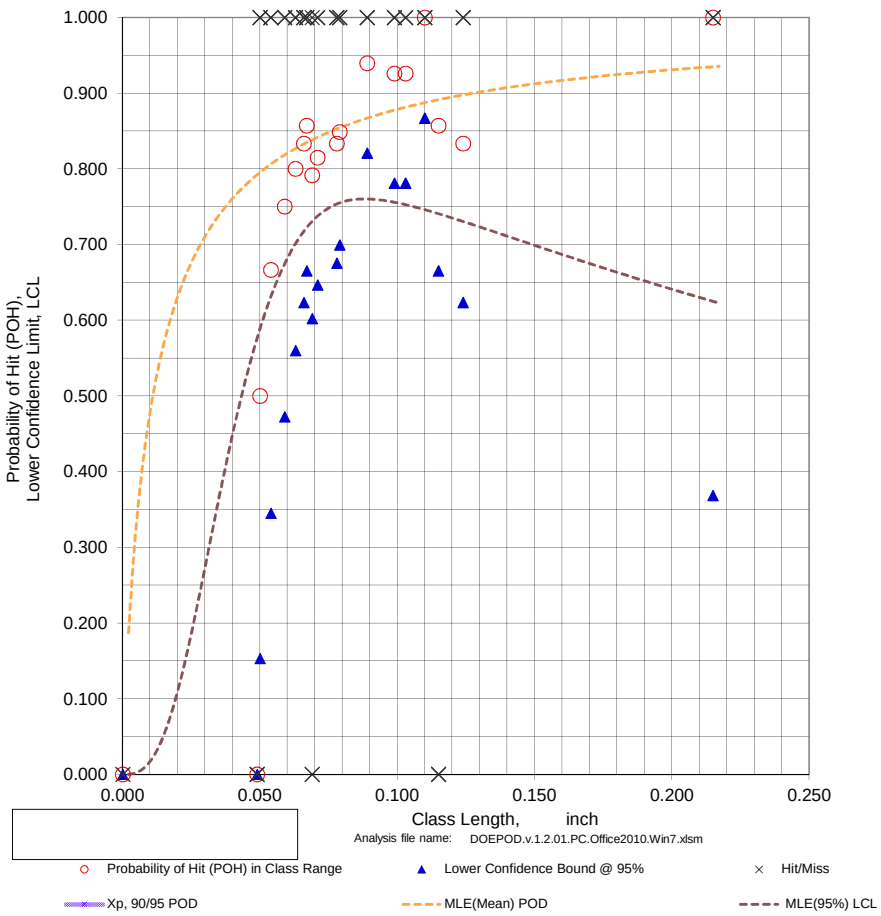
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DD002(3)D.xls
Data Set Name = DD002(3)D(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:02 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0390 | inch |
| Classlength @ Best LCL = | 0.1100 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1240 -0.008 inch 26 Samples

NTIAC 90% POD = 0.902 @ 0.130 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.215 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.215 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DD002(3)D.xls
Data Set Name = DD002(3)D(CK. NO. )

## Directed DOE Options

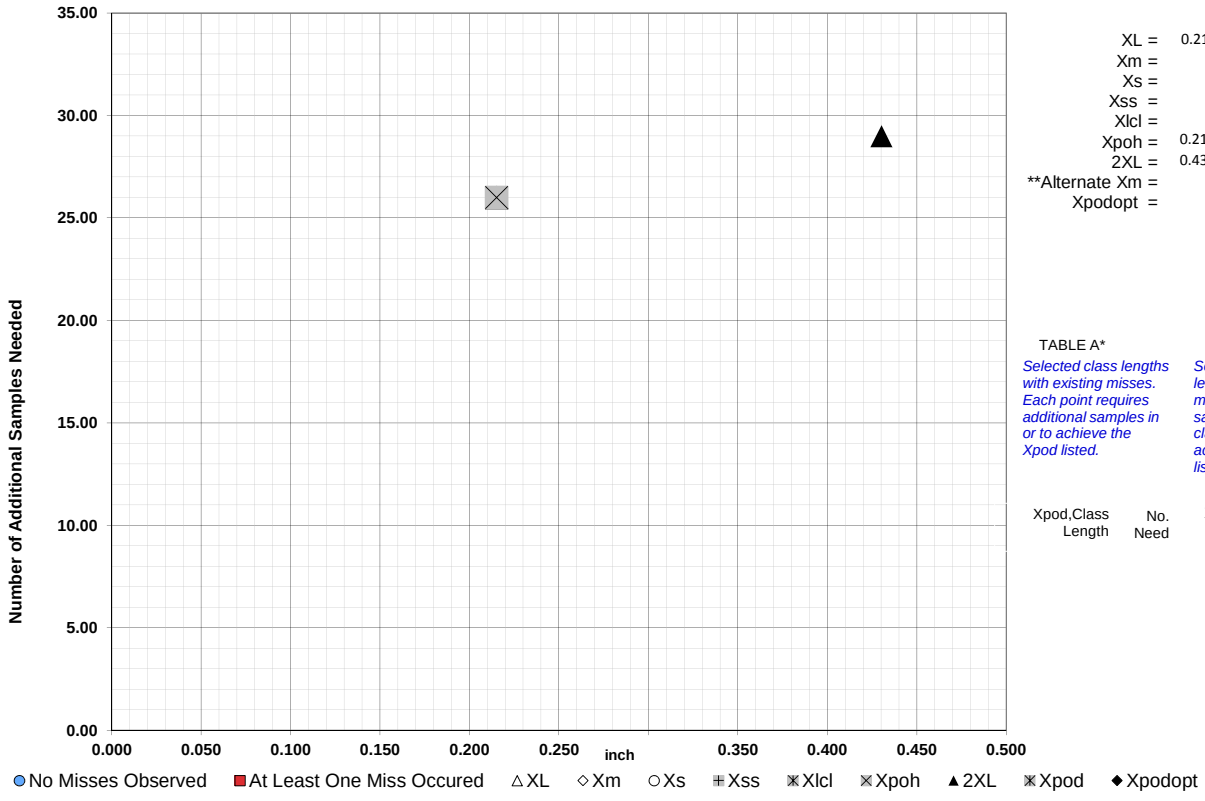



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.215 | 26 |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

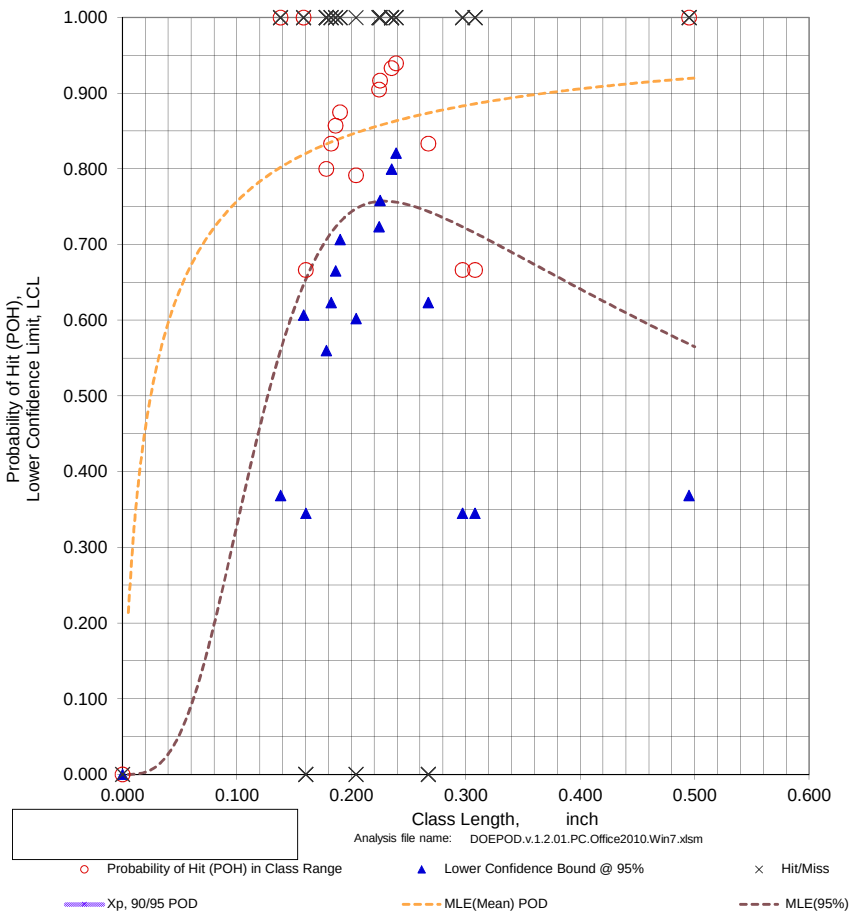
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DD002(3)L.xls
Data Set Name = DD002(3)L(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:03 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8209 | |
| Classwidth @ Best LCL = | 0.0610 | inch |
| Classlength @ Best LCL = | 0.2390 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2970 -0.029 inch 26 Samples

NTIAC 90% POD = 0.900 @ 0.370 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.495 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.990 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DD002(3)L.xls
Data Set Name = DD002(3)L(CK. NO. )

## Directed DOE Options

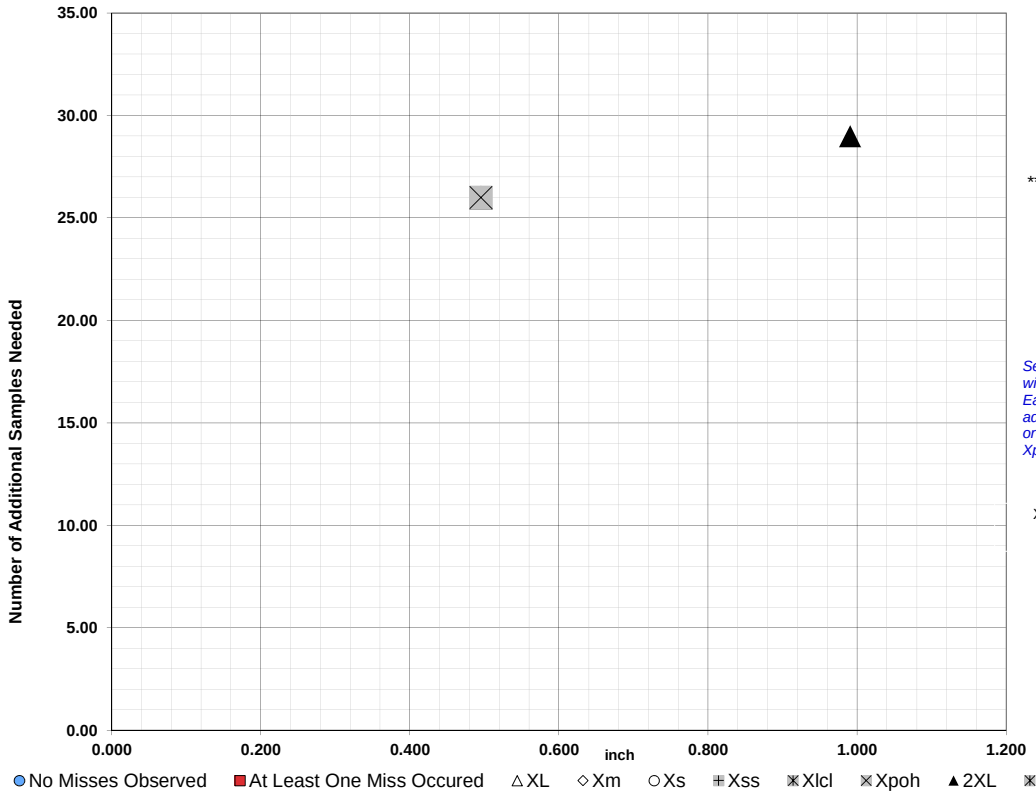



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.495 | 26 |
| 2XL = | 0.990 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

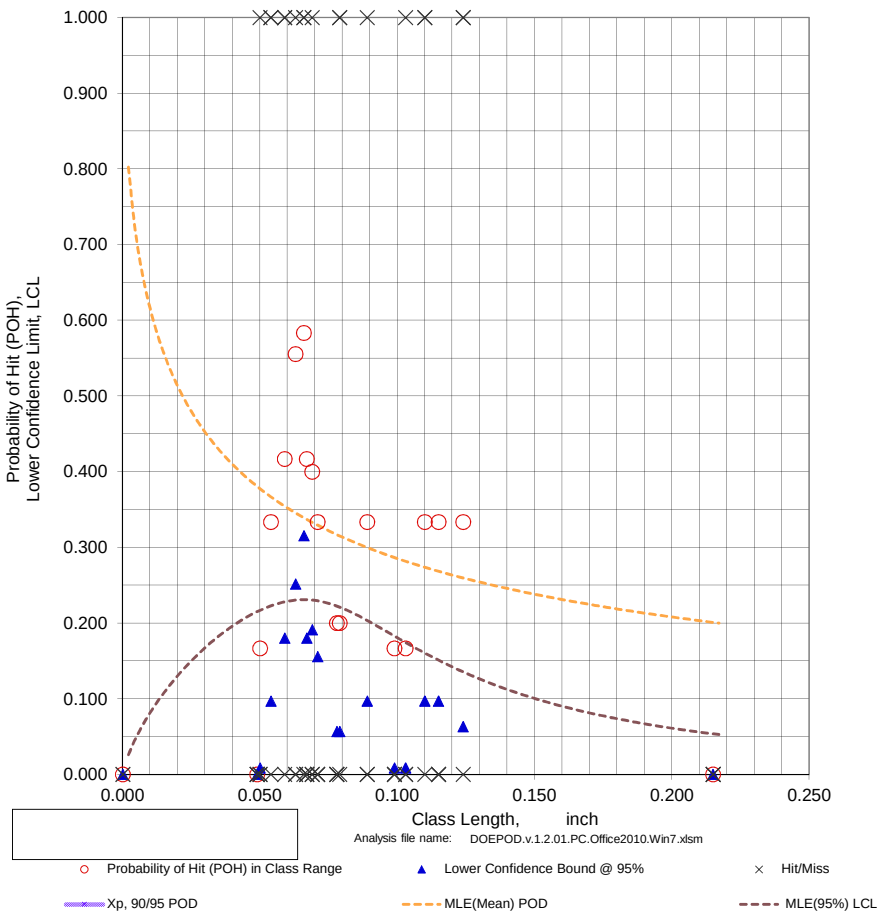
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DD003(3)D.xls
Data Set Name = DD003(3)D(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:04 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3152 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.0660 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DD003(3)D.xls
Data Set Name = DD003(3)D(CK. NO. )

## Directed DOE Options

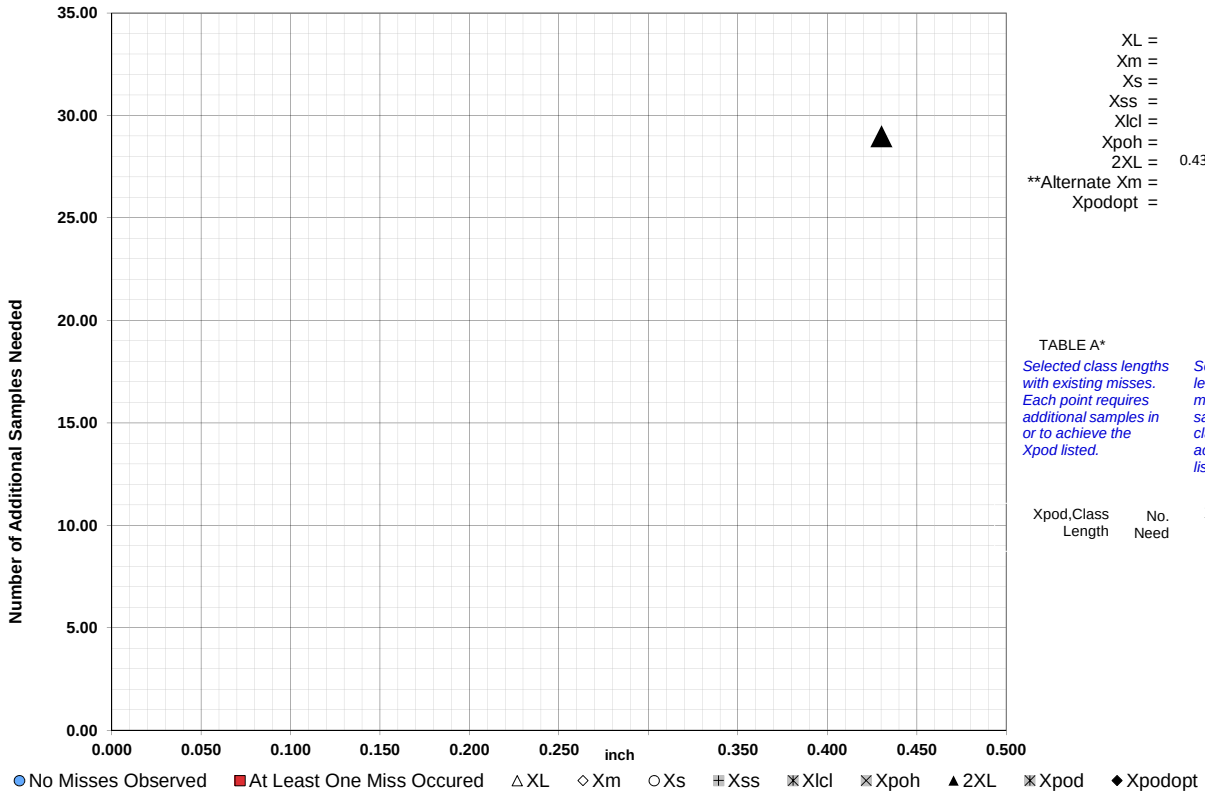



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

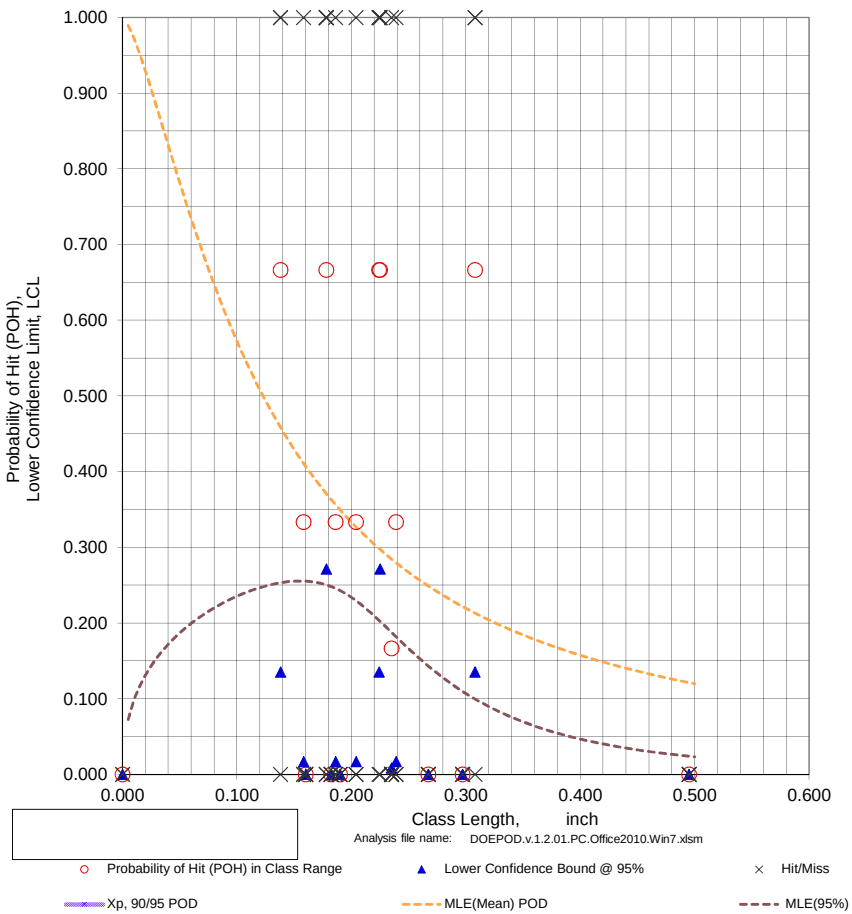
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = DD003(3)L.xls
Data Set Name = DD003(3)L(CK. NO. )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:05 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2713 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.1780 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.989 @ 0.005 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.990 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = DD003(3)L.xls
Data Set Name = DD003(3)L(CK. NO. )

## Directed DOE Options

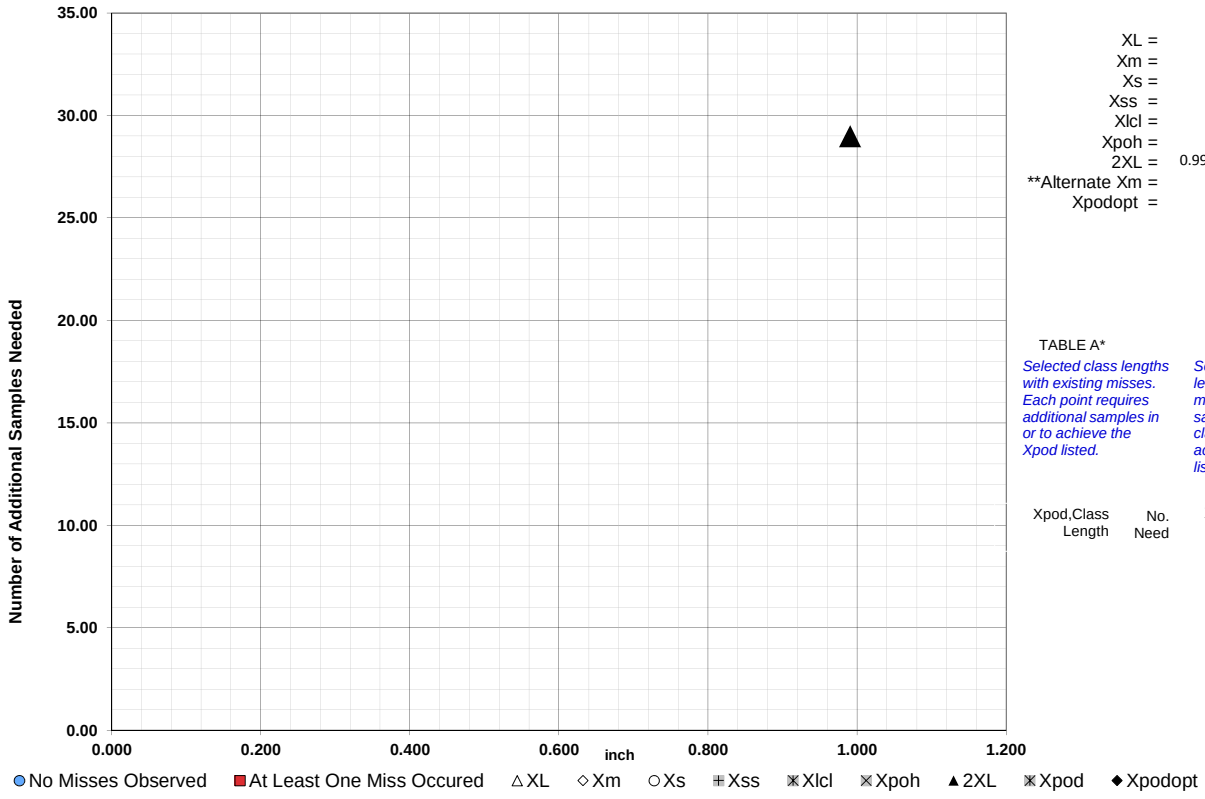



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.990 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

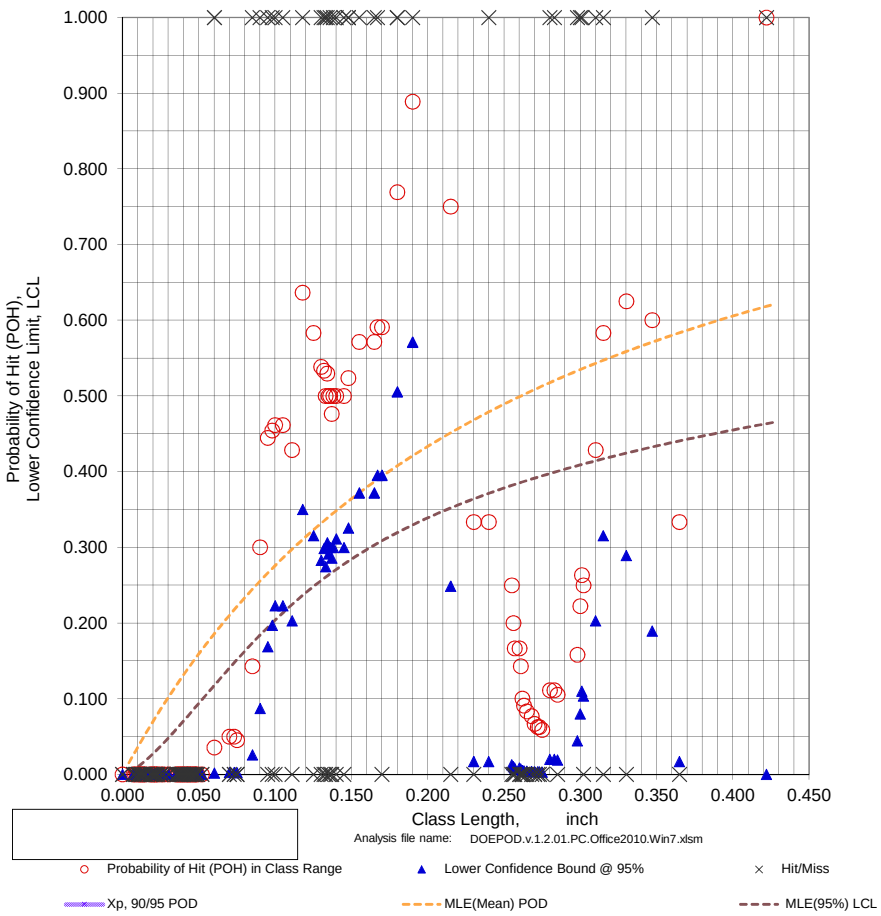
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = E1001AL.XLS
Data Set Name = E1001AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:07 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5709 | |
| Classwidth @ Best LCL = | 0.0420 | inch |
| Classlength @ Best LCL = | 0.1900 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.4220 -0.056 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.422 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.422 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.844 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = E1001AL.XLS
Data Set Name = E1001AL(CRACK #)

## Directed DOE Options

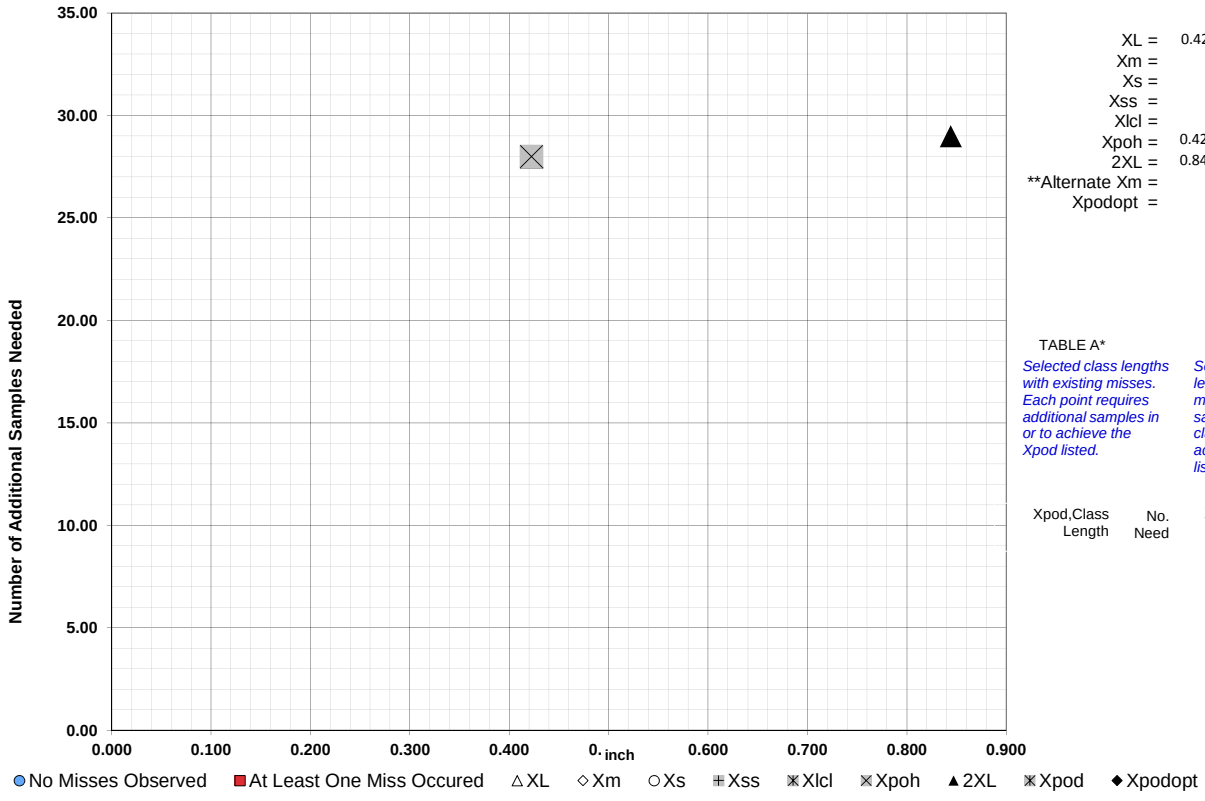



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.422 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.422 | 28 |
| 2XL = | 0.844 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

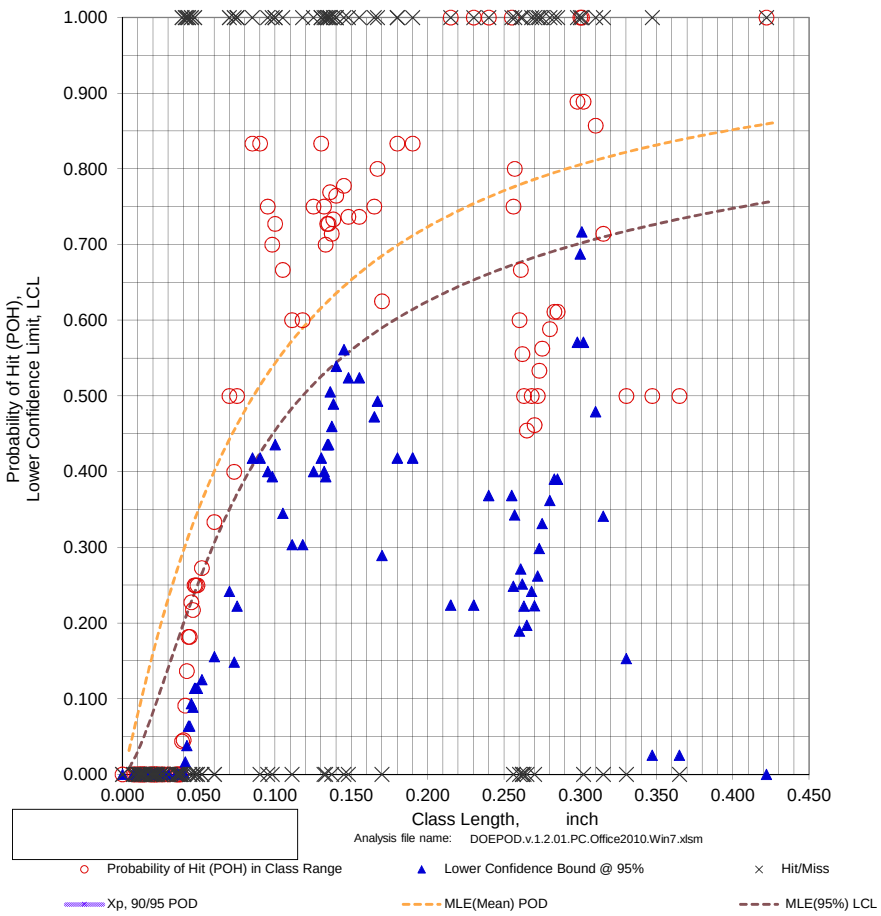
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = E1002AL.XLS
Data Set Name = E1002AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:10 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0290 | inch |
| Classlength @ Best LCL = | 0.3010 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.4220 -0.056 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.595 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.422 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.422 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.844 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = E1002AL.XLS
Data Set Name = E1002AL(CRACK #)

## Directed DOE Options

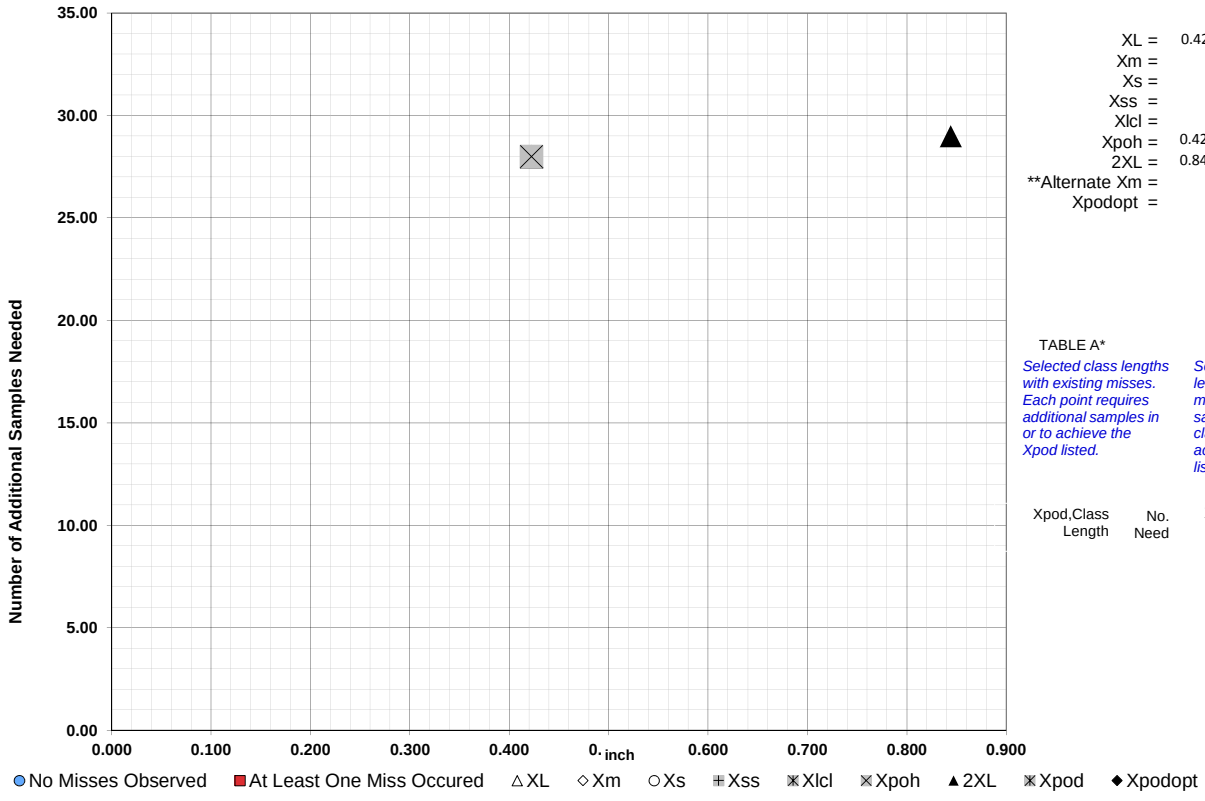



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.422 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.422 | 28 |
| 2XL = | 0.844 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

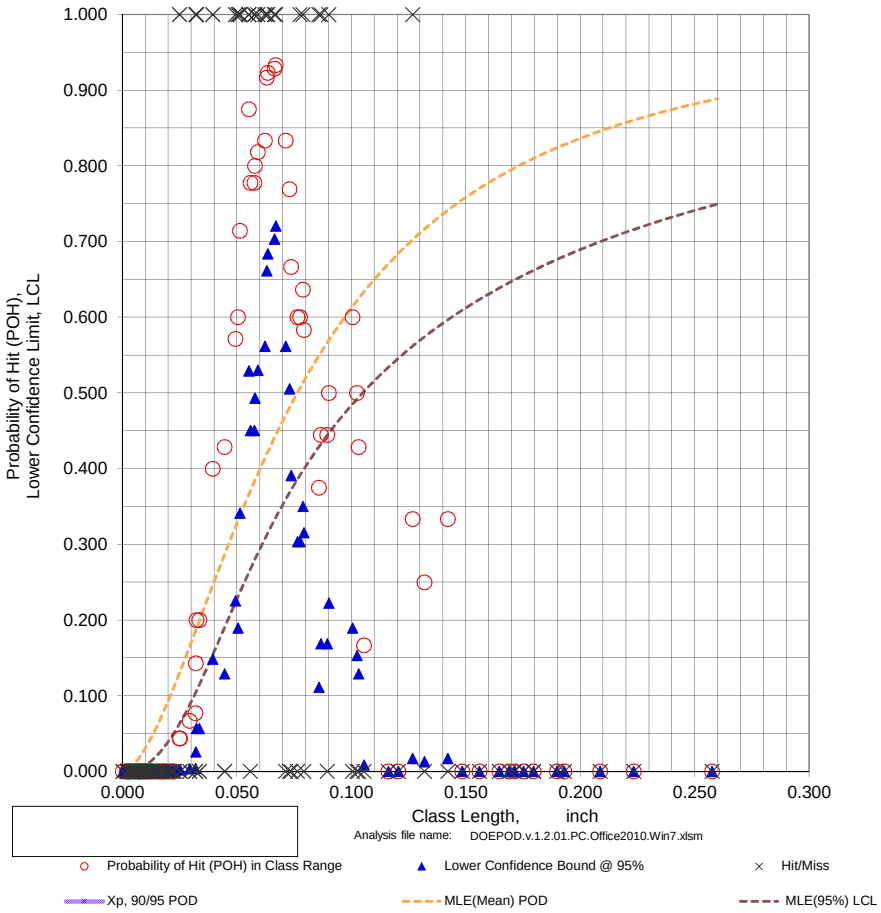
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = E2006.XLS
Data Set Name = E2006(HOLE #)

MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:11 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7206 | |
| Classwidth @ Best LCL = | 0.0180 | inch |
| Classlength @ Best LCL = | 0.0669 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.280 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.715 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.515 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = E2006.XLS
Data Set Name = E2006(HOLE #)

## Directed DOE Options

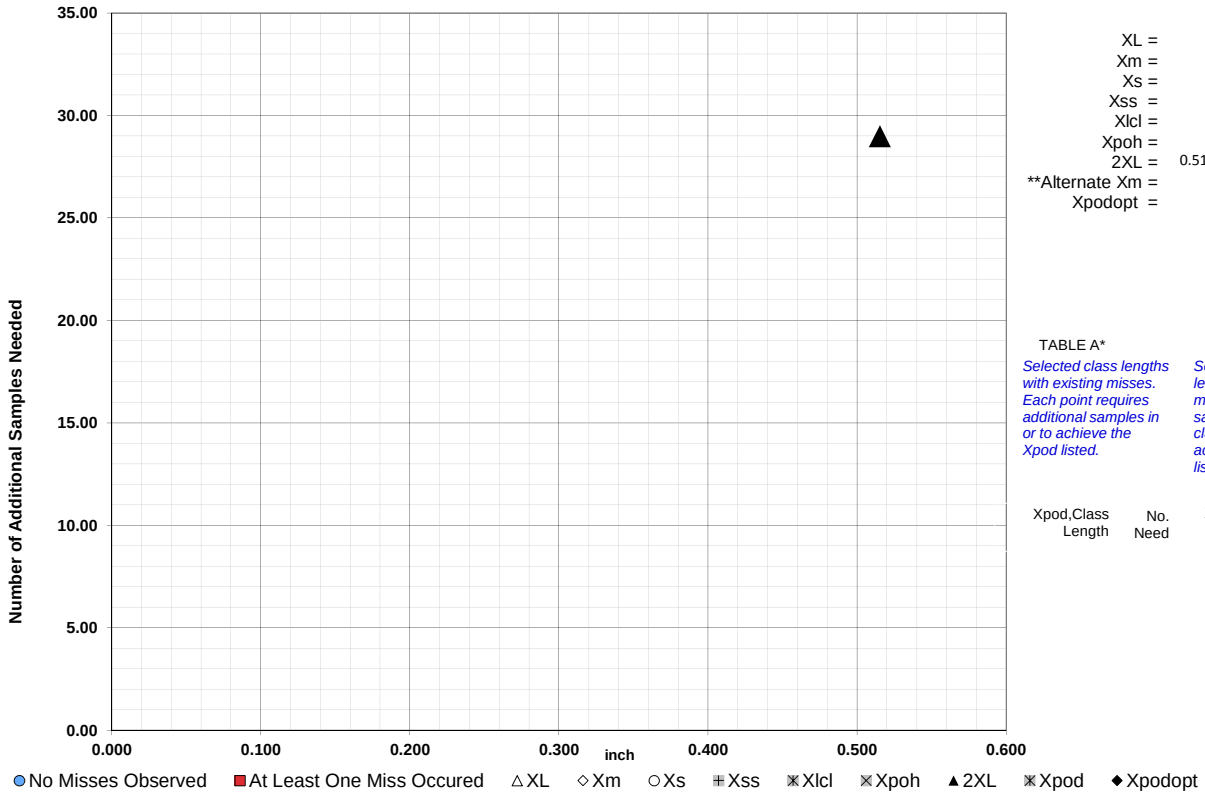



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.515 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

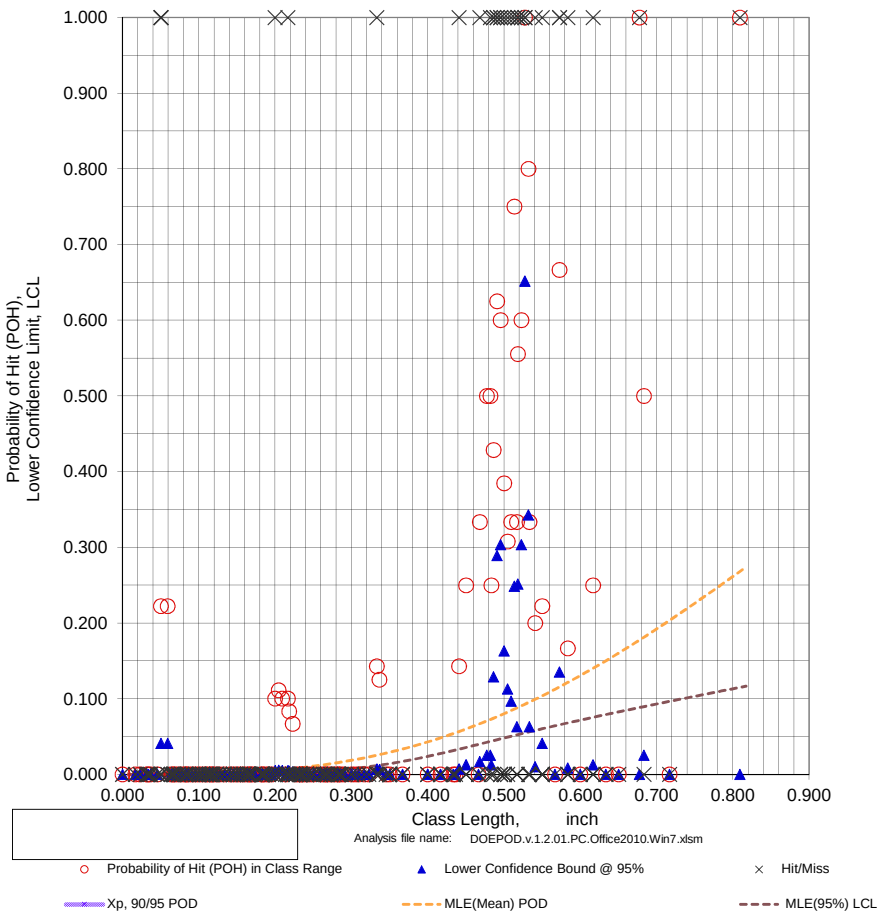
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10001AA.XLS
Data Set Name = F10001AA(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:13 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6518 | |
| Classwidth @ Best LCL = | 0.0100 | inch |
| Classlength @ Best LCL = | 0.5273 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.8091 -0.092 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.809 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.618 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10001AA.XLS
Data Set Name = F10001AA(CRACK #)

## Directed DOE Options

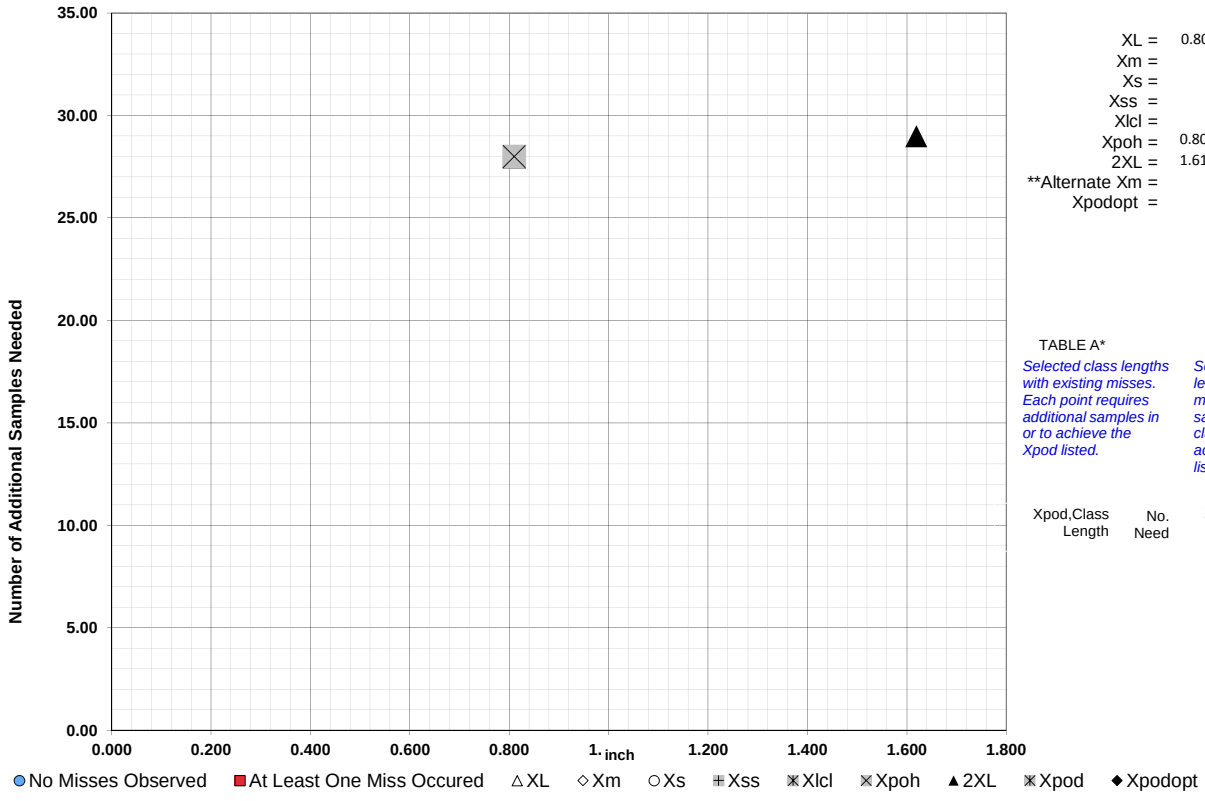



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.809 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.809 | 28 |
| 2XL = | 1.618 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

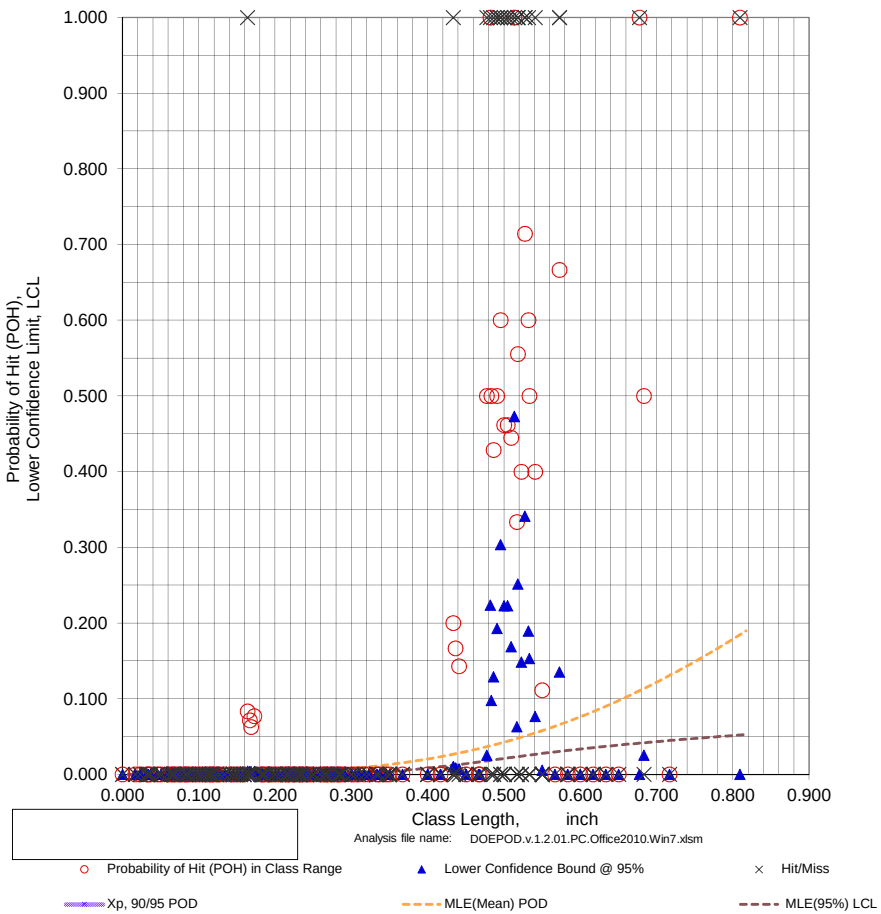
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10001BA.XLS
Data Set Name = F10001BA(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:14 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4729 | |
| Classwidth @ Best LCL = | 0.0100 | inch |
| Classlength @ Best LCL = | 0.5136 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.8091 -0.092 inch 28 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.809 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.618 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10001BA.XLS
Data Set Name = F10001BA(CRACK #)

## Directed DOE Options

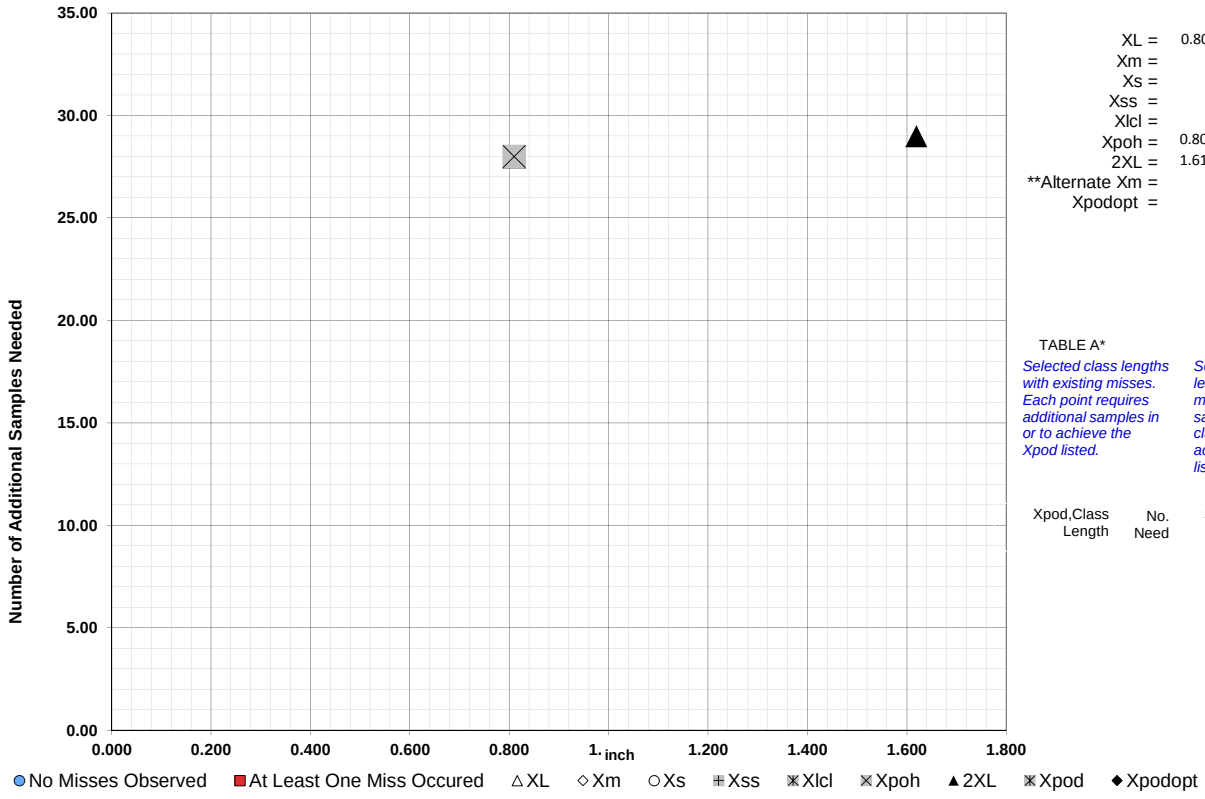



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.809 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.809 | 28 |
| 2XL = | 1.618 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

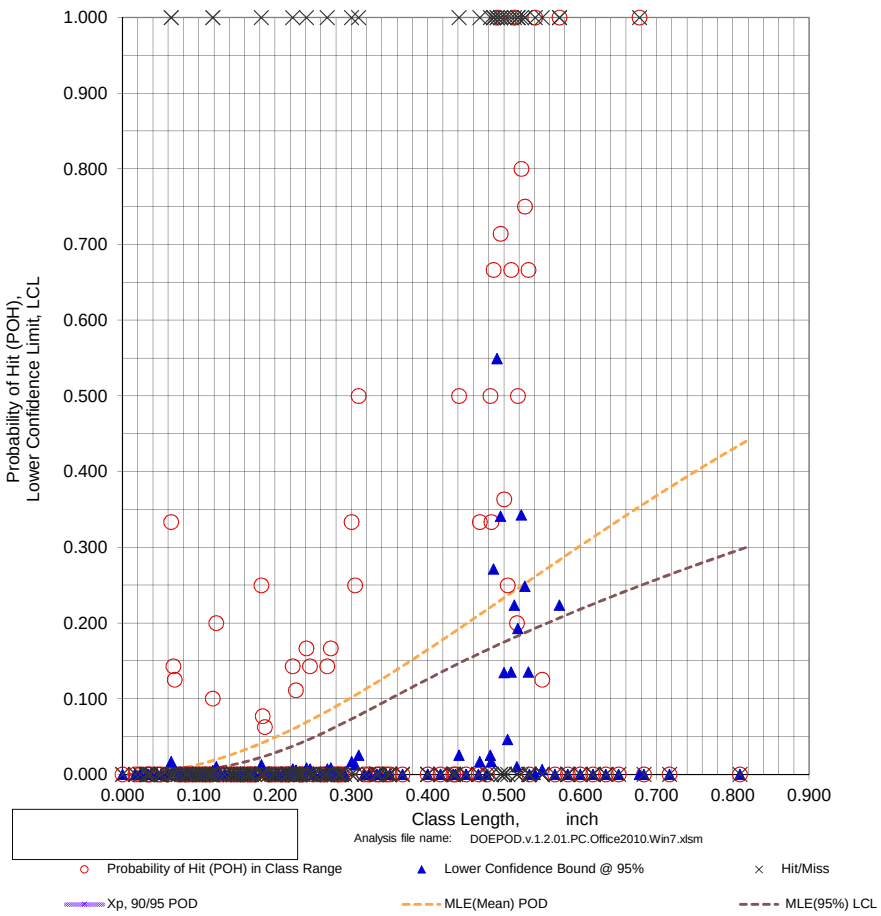
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = F10001CA.XLS
Data Set Name = F10001CA(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:16 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.4909 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.618 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10001CA.XLS
Data Set Name = F10001CA(CRACK #)

## Directed DOE Options

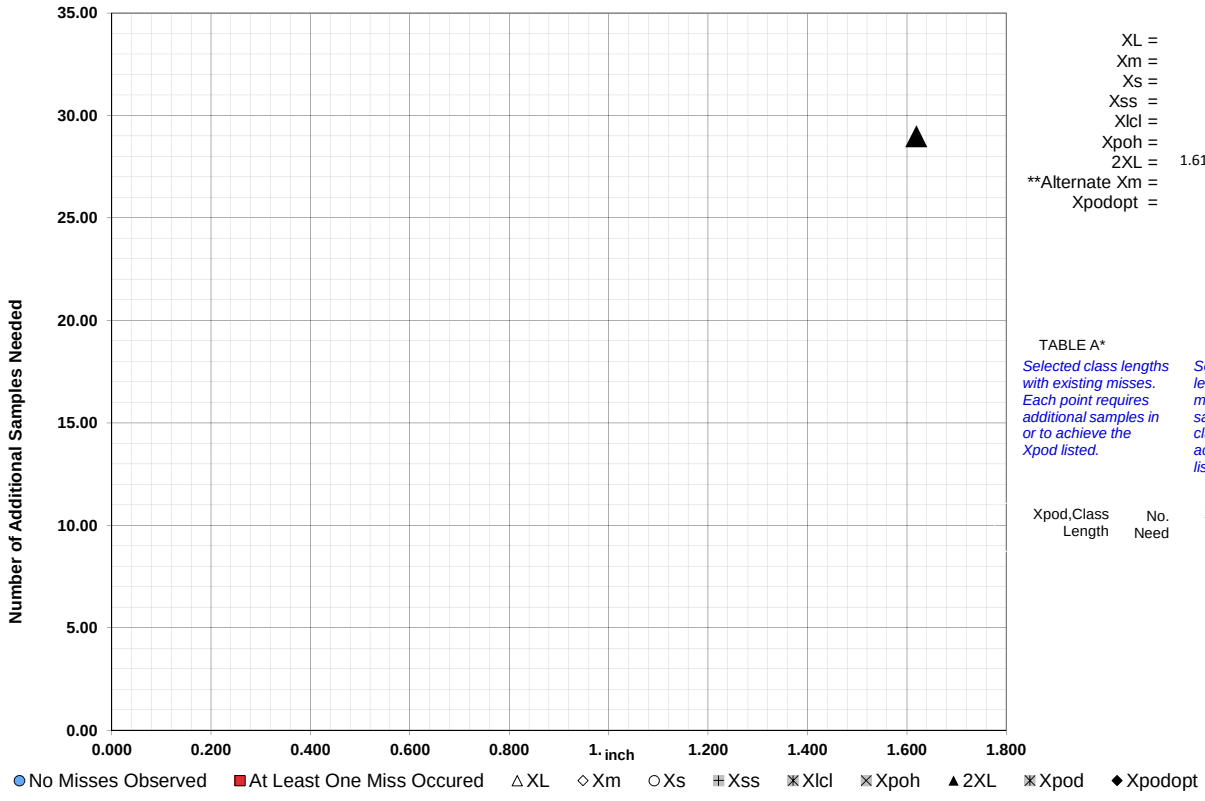



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.618 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

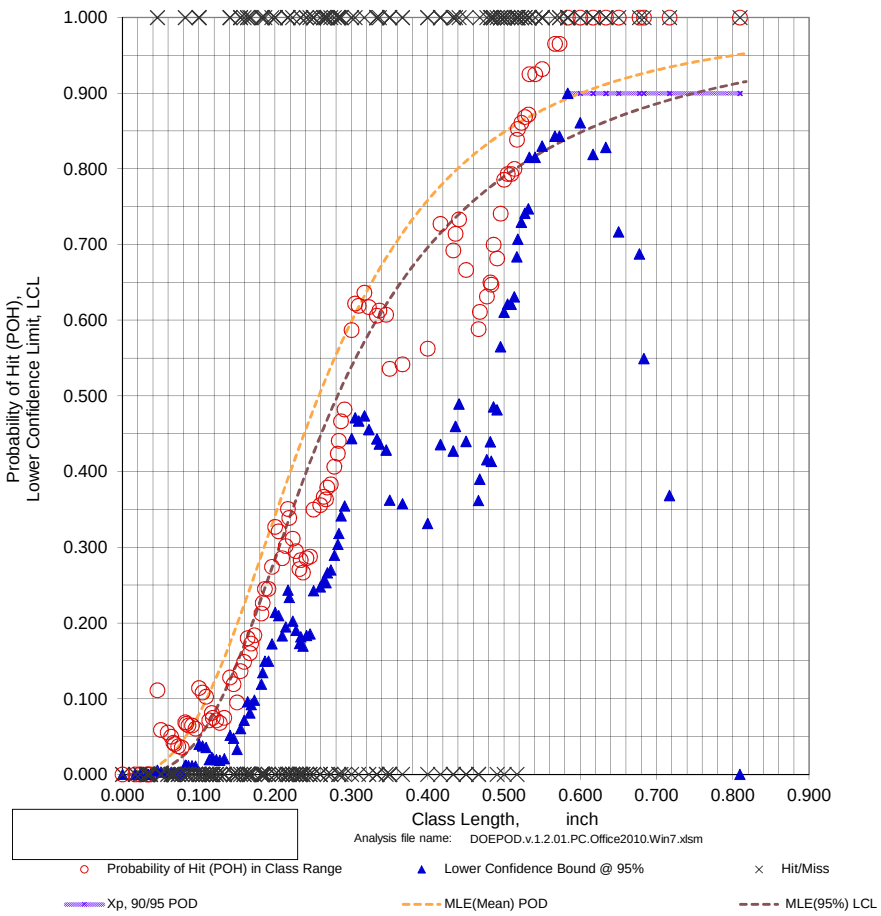
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.74999.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F10002AA.XLS**

Data Set Name = **F10002AA(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:17 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0660 | inch |
| Classlength @ 90/95 Xpod = | 0.5833 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.5182 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.605 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.750 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.650 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.578 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.5833 | inch |

File Name = F10002AA.XLS
Data Set Name = F10002AA(CRACK #)

## Directed DOE Options

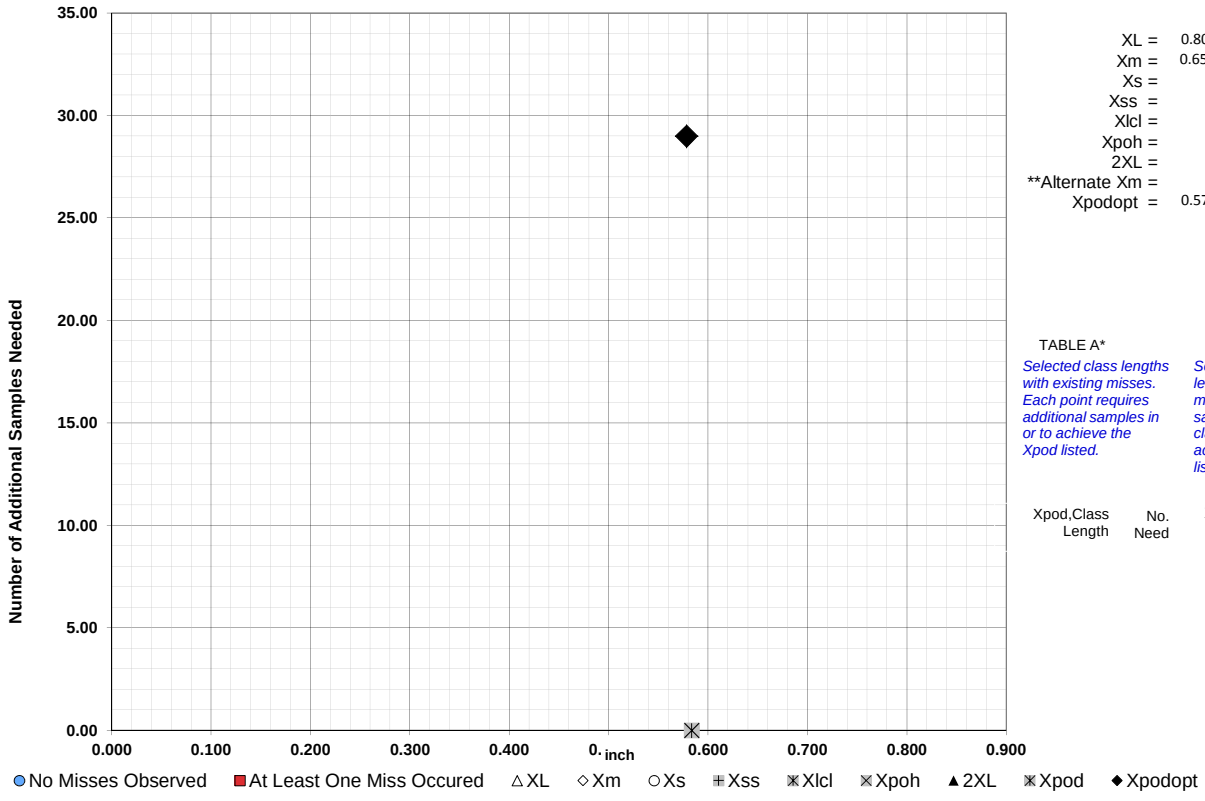



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.809 | |
| Xm = | 0.650 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.578 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

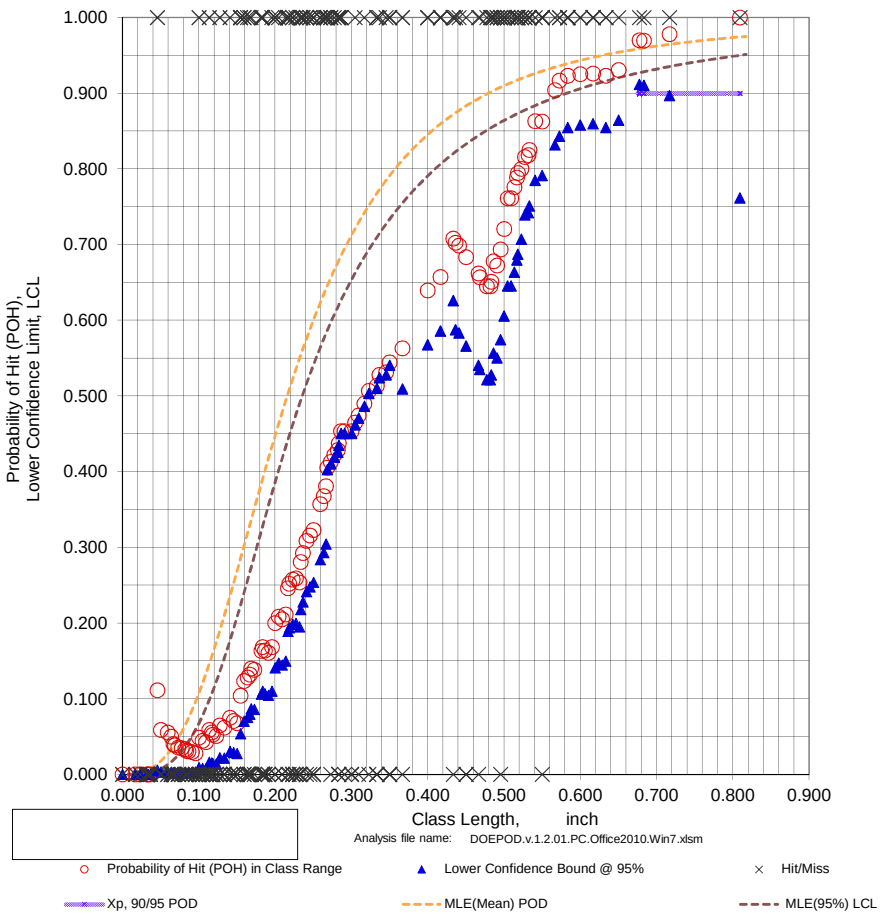
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 2.03181.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **F10002BA.XLS**

Data Set Name = **F10002BA(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:19 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.6773 | inch |
| Lower Confidence Bound = | 0.9117 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 0.9701 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and alternate Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.5667 -0.016 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.480 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.585 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.717 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.6773 | inch |

File Name = F10002BA.XLS
Data Set Name = F10002BA(CRACK #)

## Directed DOE Options

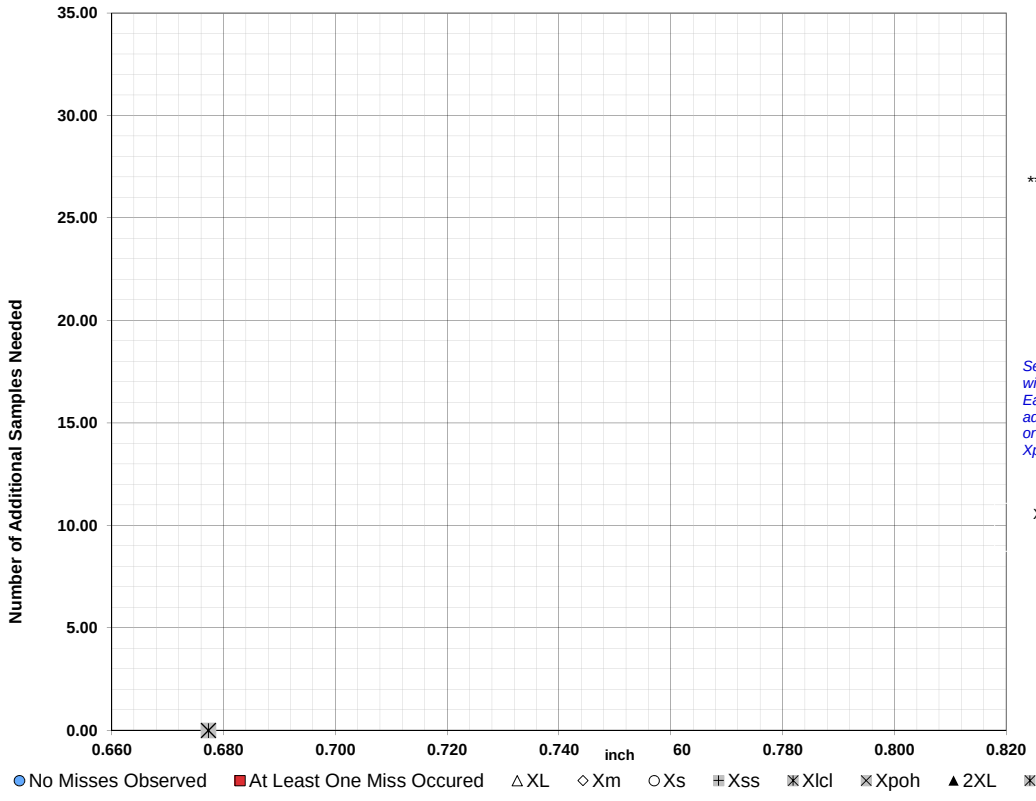



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.809 |
| Xm = | 0.717 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

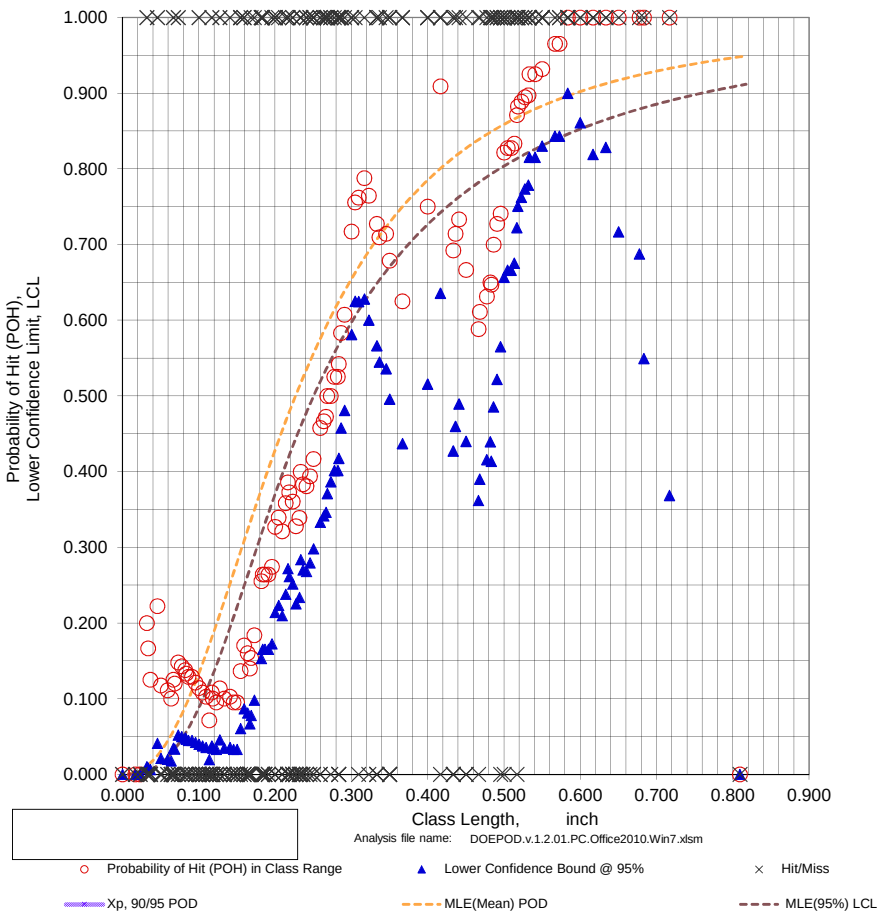
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.74999.**

**Warning: No false call analysis.**




File Name = **F10002CA.XLS**

Data Set Name = **F10002CA(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:21 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0660 | inch |
| Classlength @ 90/95 Xpod = | 0.5833 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Further VALIDATION is required. Recommend satisfying XL and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ 0.595 | inch |
| NTIAC 90/95 POD = | | @ | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | 45 | |
| Classlength Mid-point , Xm = | 0.650 | inch |
| Samples Needed @ Xm = | 20 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10002CA.XLS
Data Set Name = F10002CA(CRACK #)

## Directed DOE Options

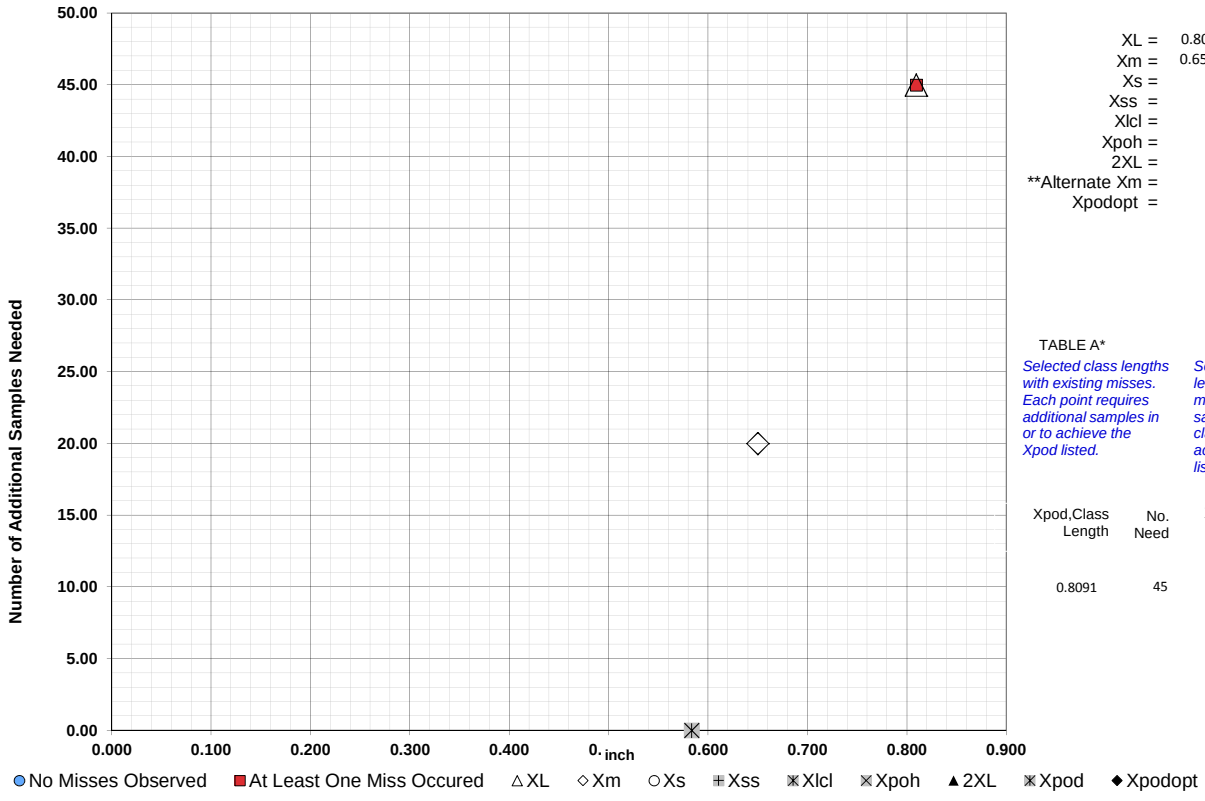



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.809 | 45 |
| Xm = | 0.650 | 20 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.8091 | 45 |

TABLE B*

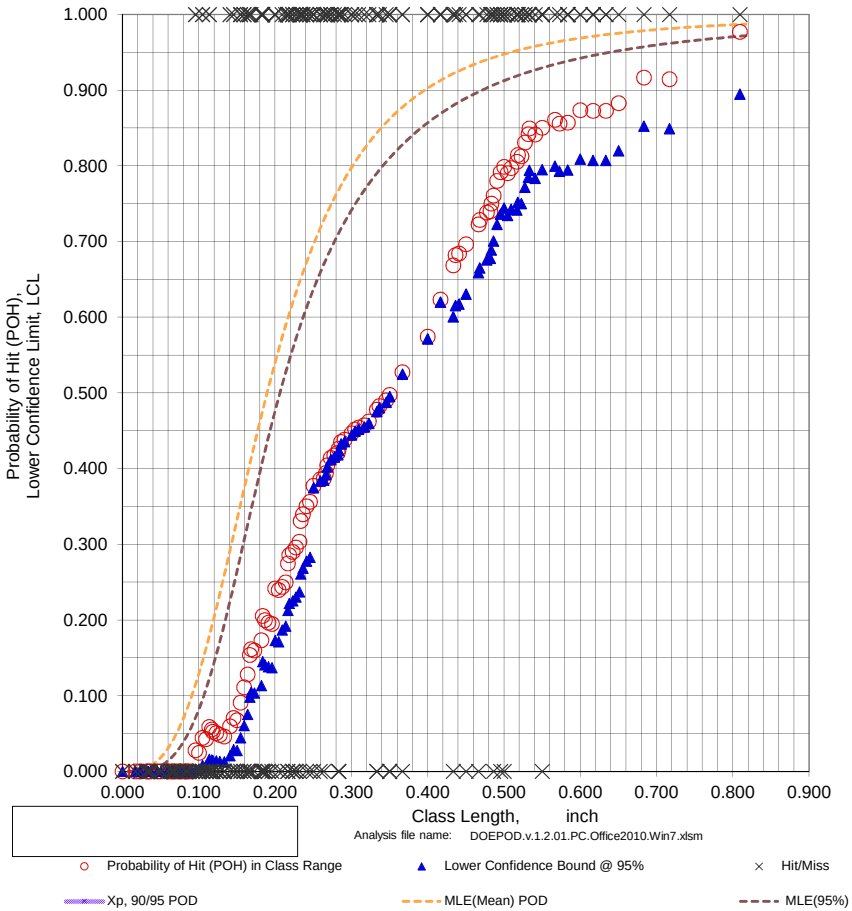
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10003AA.XLS
Data Set Name = F10003AA(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:23 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8949 | |
| Classwidth @ Best LCL = | 0.3000 | inch |
| Classlength @ Best LCL = | 0.8091 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.5667 -0.016 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.400 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.475 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.618 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10003AA.XLS
Data Set Name = F10003AA(CRACK #)

## Directed DOE Options

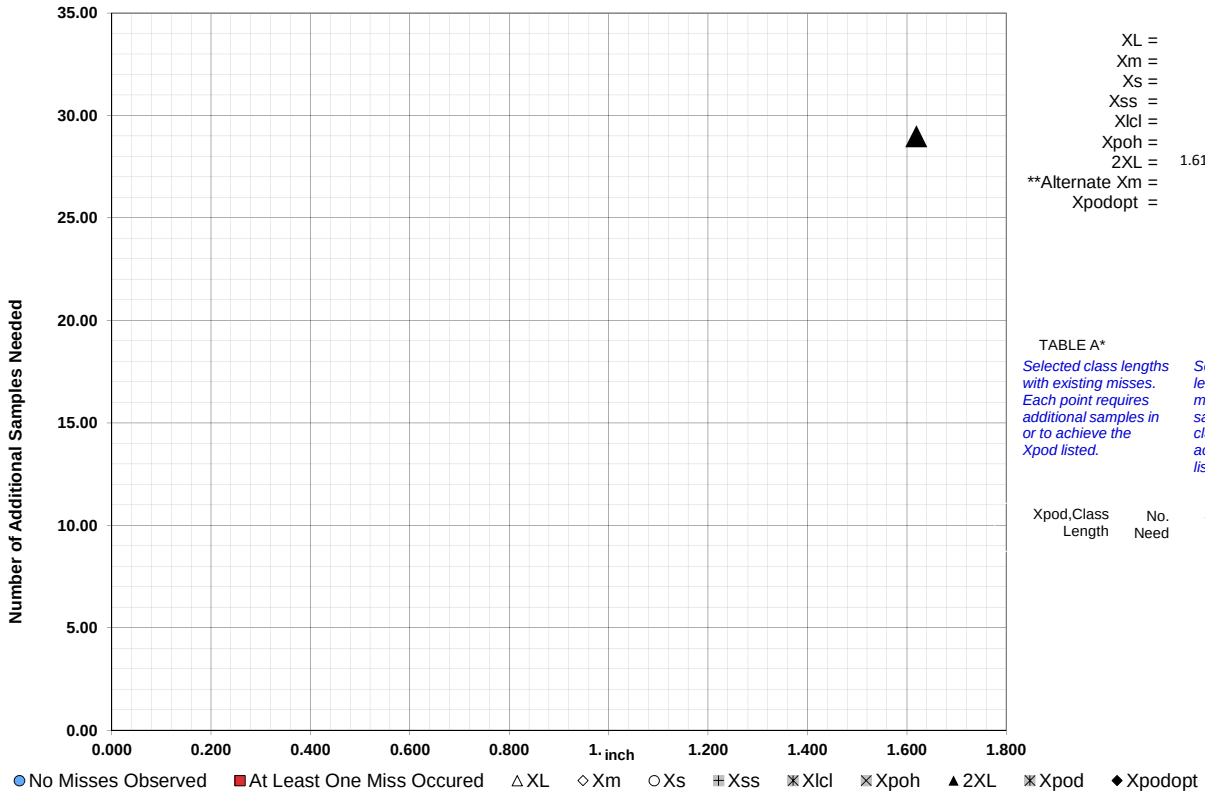



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.618 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

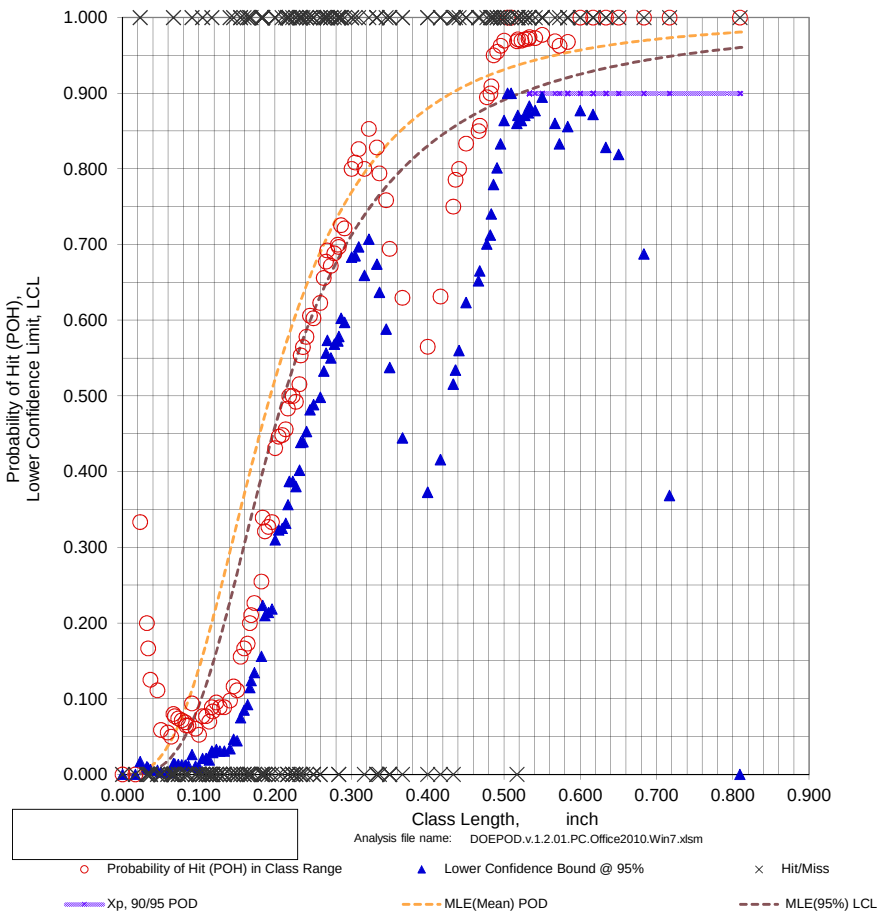
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.51362.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **F10003BA.XLS**

Data Set Name = **F10003BA(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:25 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0690 | inch |
| Classlength @ 90/95 Xpod = | 0.5045 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.435 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.525 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.600 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.5333 | inch |

File Name = F10003BA.XLS
Data Set Name = F10003BA(CRACK #)

## Directed DOE Options

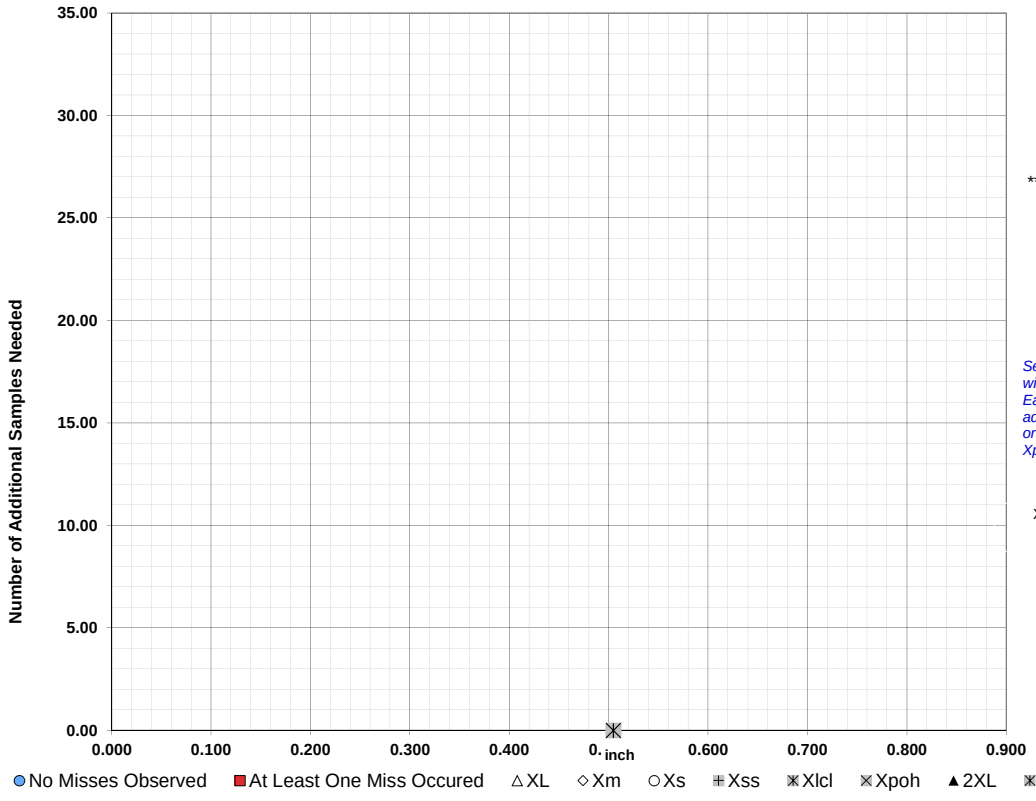



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.809 |
| Xm = | 0.600 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

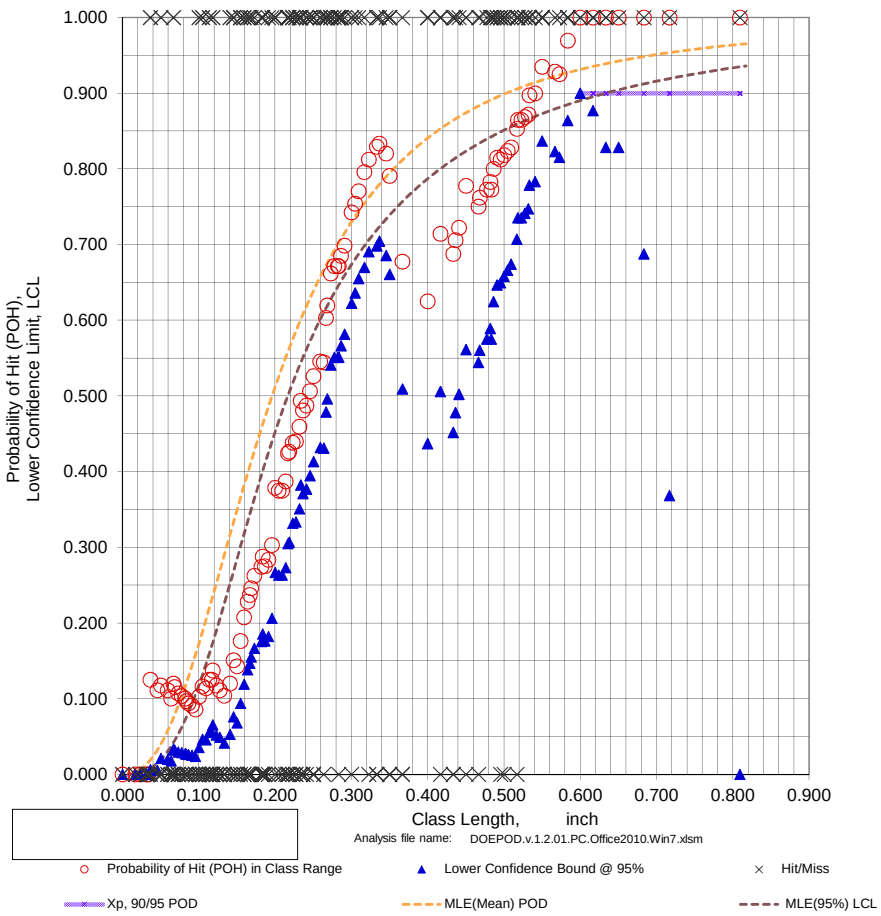
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.8.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F10003CA.XLS**
Data Set Name = **F10003CA(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:26 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0820 | inch |
| Classlength @ 90/95 Xpod = | 0.6000 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.5182 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.505 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.635 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.809 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.683 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.592 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.6000 | inch |

File Name = F10003CA.XLS
Data Set Name = F10003CA(CRACK #)

## Directed DOE Options

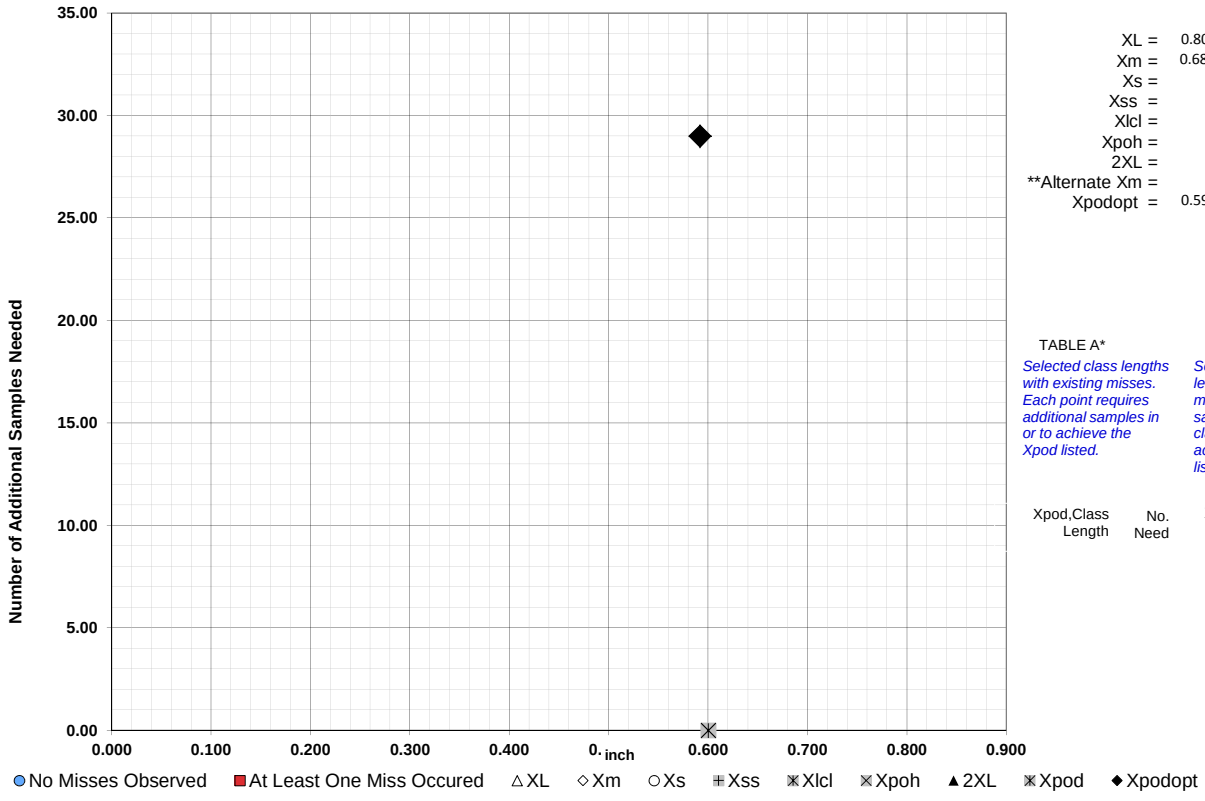



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.809 | |
| Xm = | 0.683 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.592 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

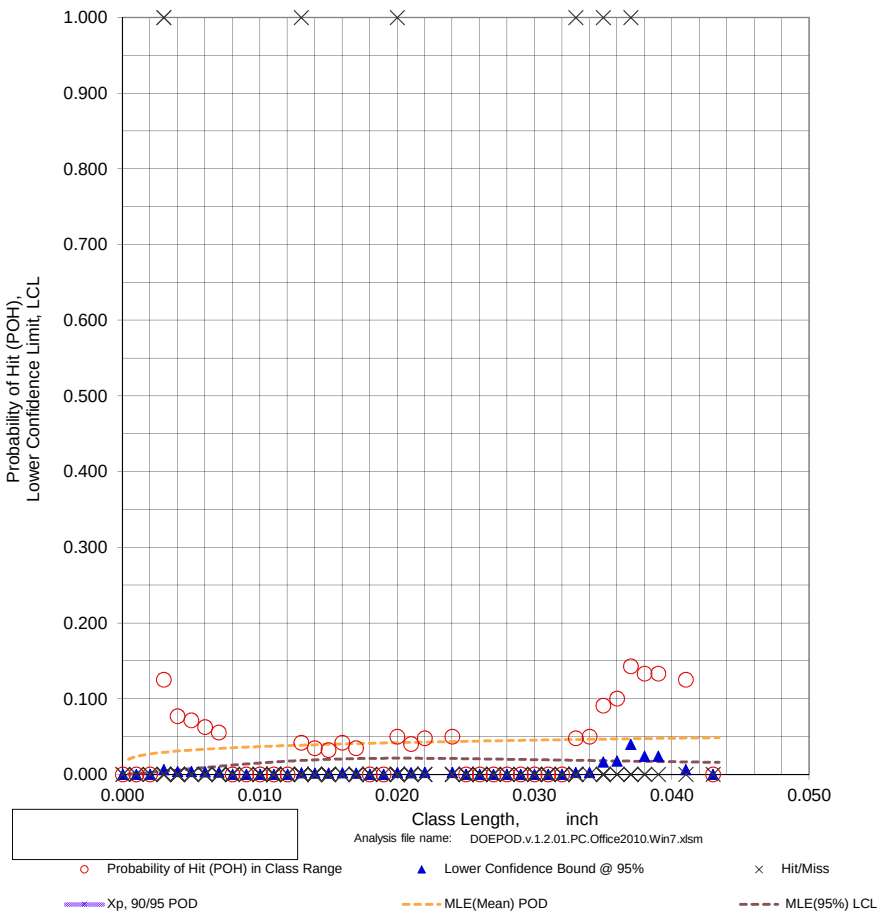
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10601AD.XLS
Data Set Name = F10601AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:28 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.0398 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.0370 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.909 @ 0.128 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.086 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10601AD.XLS
Data Set Name = F10601AD(CRACK #)

## Directed DOE Options

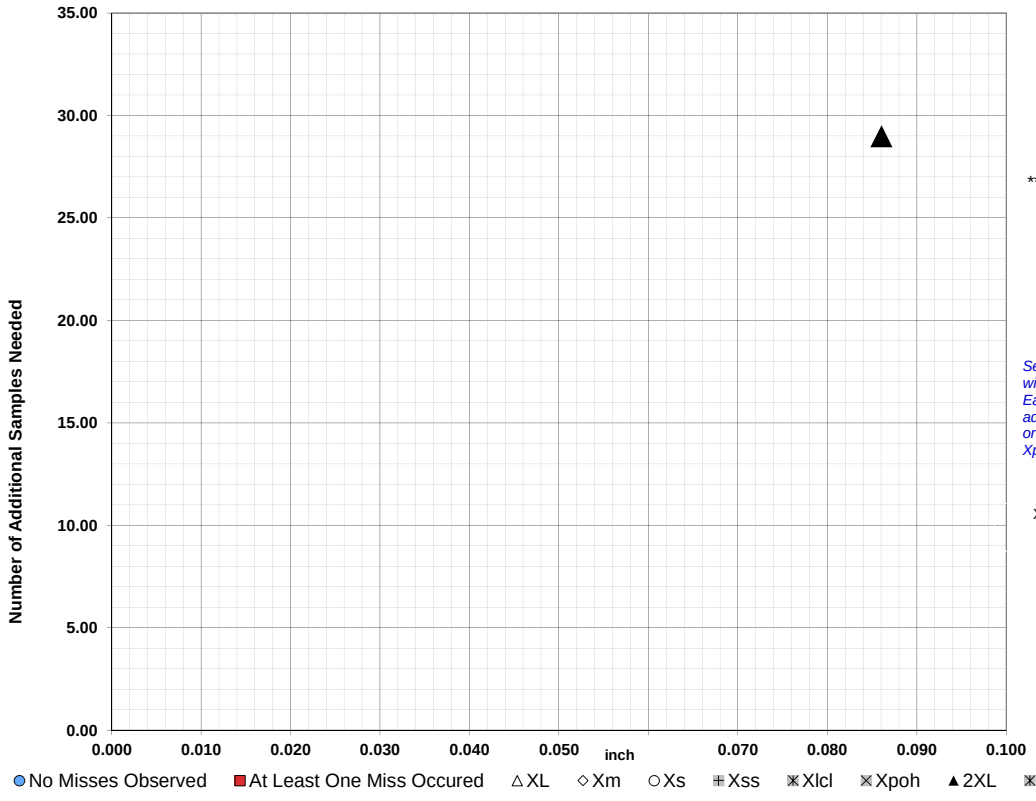



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.086 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

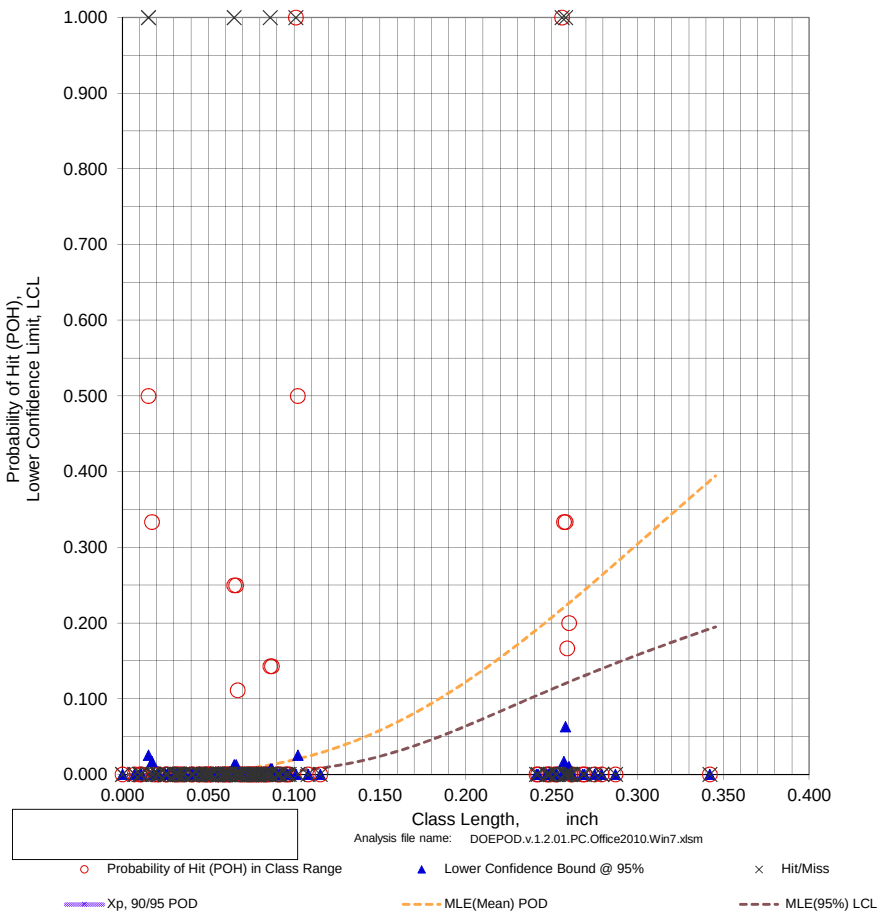
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10601AL.XLS
Data Set Name = F10601AL(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:30 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.0628 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.2580 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10601AL.XLS
Data Set Name = F10601AL(CRACK #)

## Directed DOE Options

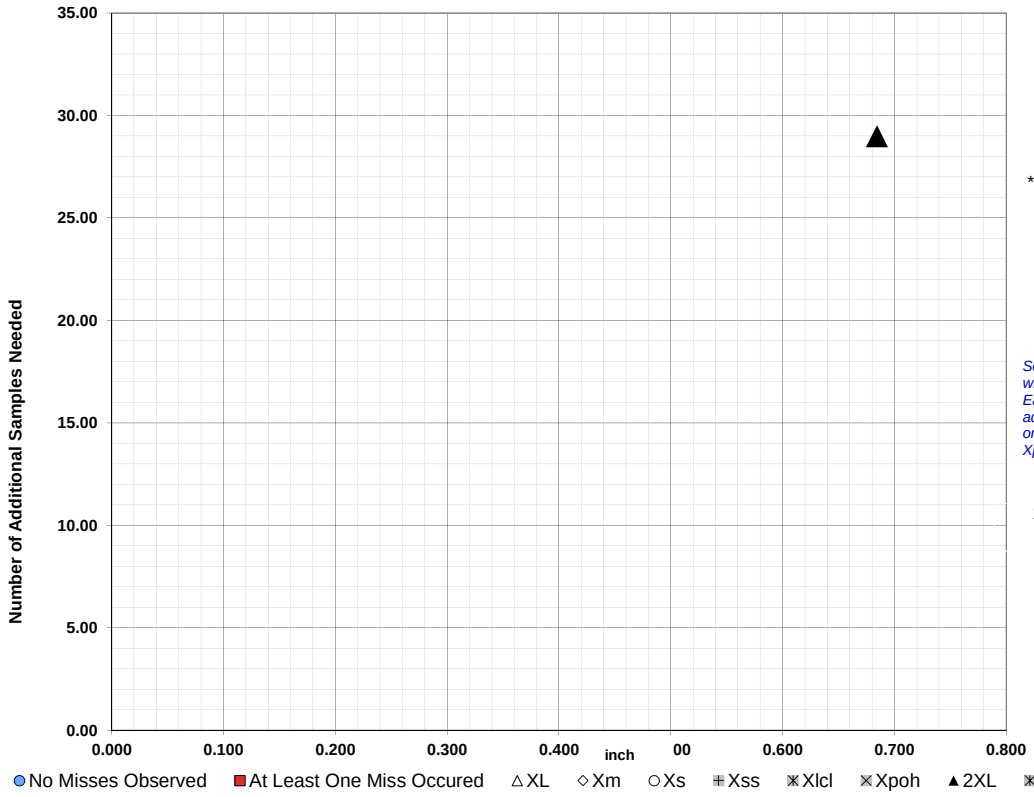



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

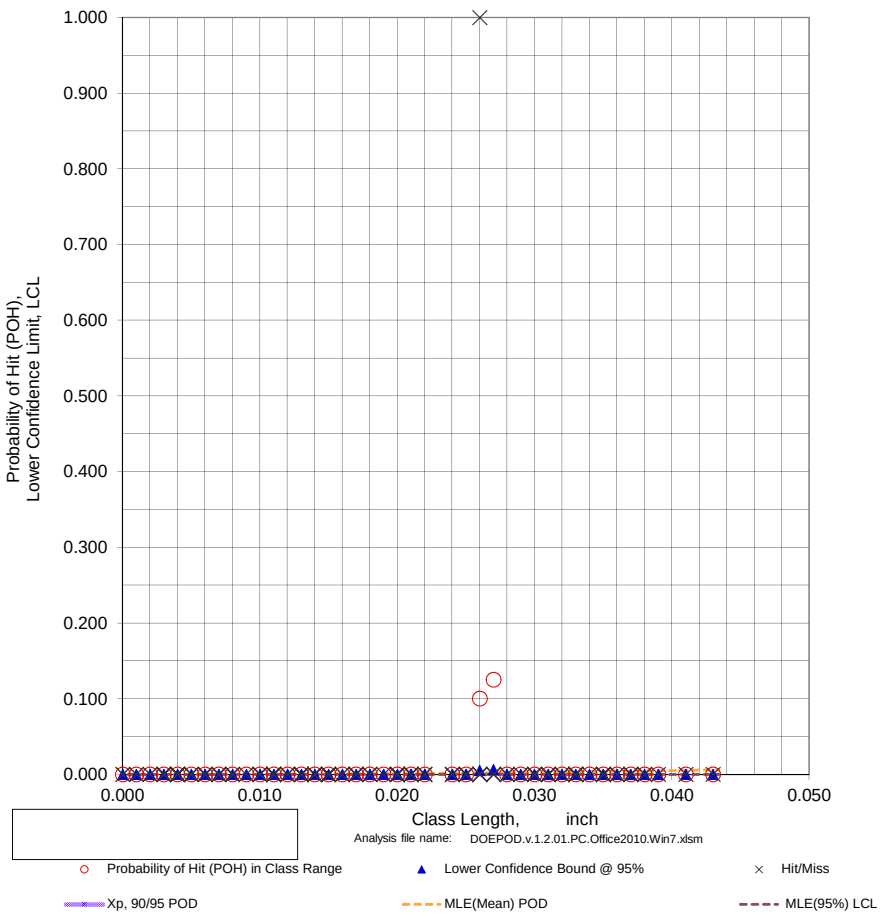
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10601BD.XLS
Data Set Name = F10601BD(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:32 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.0064 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0270 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.086 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10601BD.XLS
Data Set Name = F10601BD(CRACK #)

## Directed DOE Options

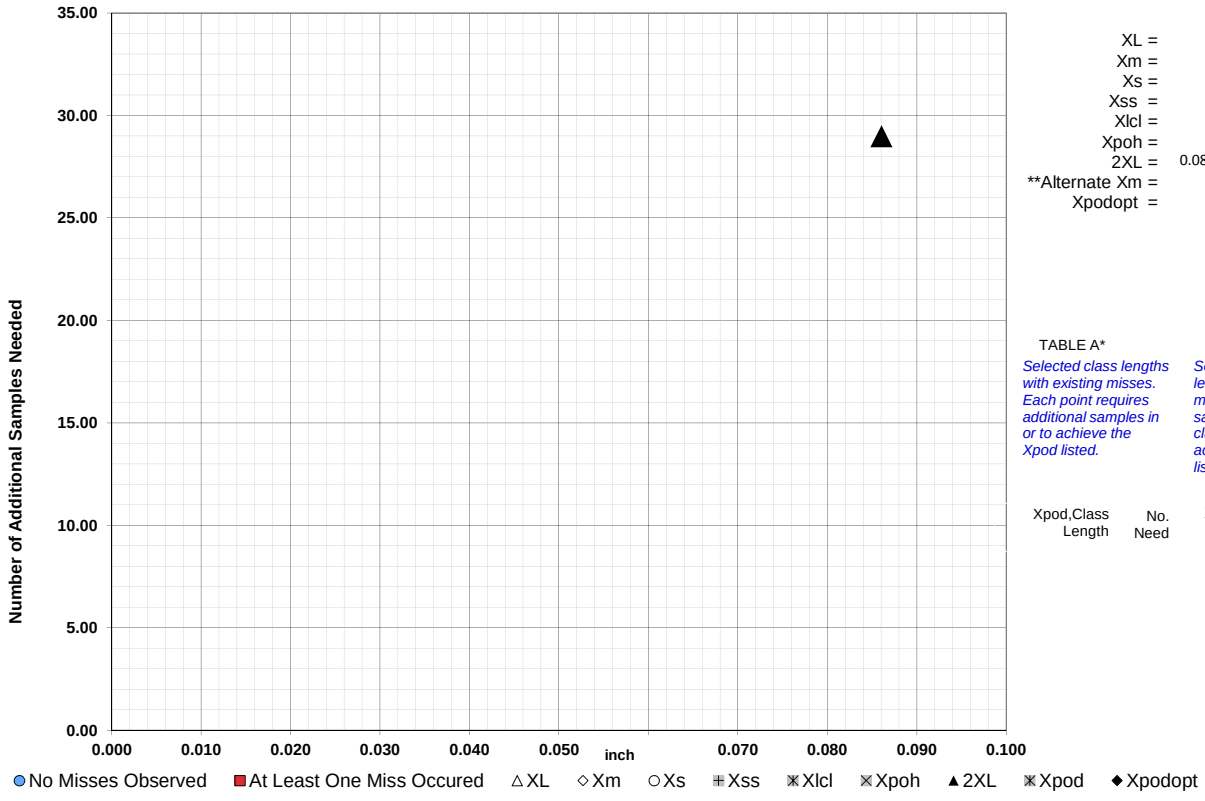



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.086 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

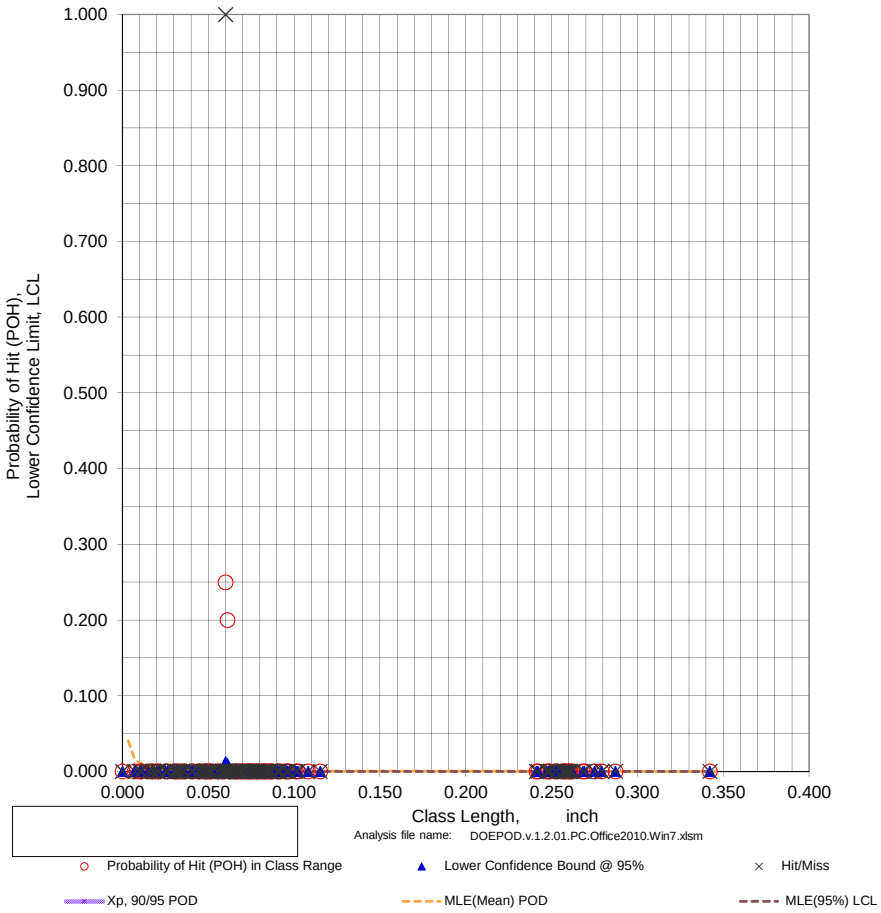
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10601BL.XLS
Data Set Name = F10601BL(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:33 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.0127 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0600 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10601BL.XLS
Data Set Name = F10601BL(CRACK #)

## Directed DOE Options

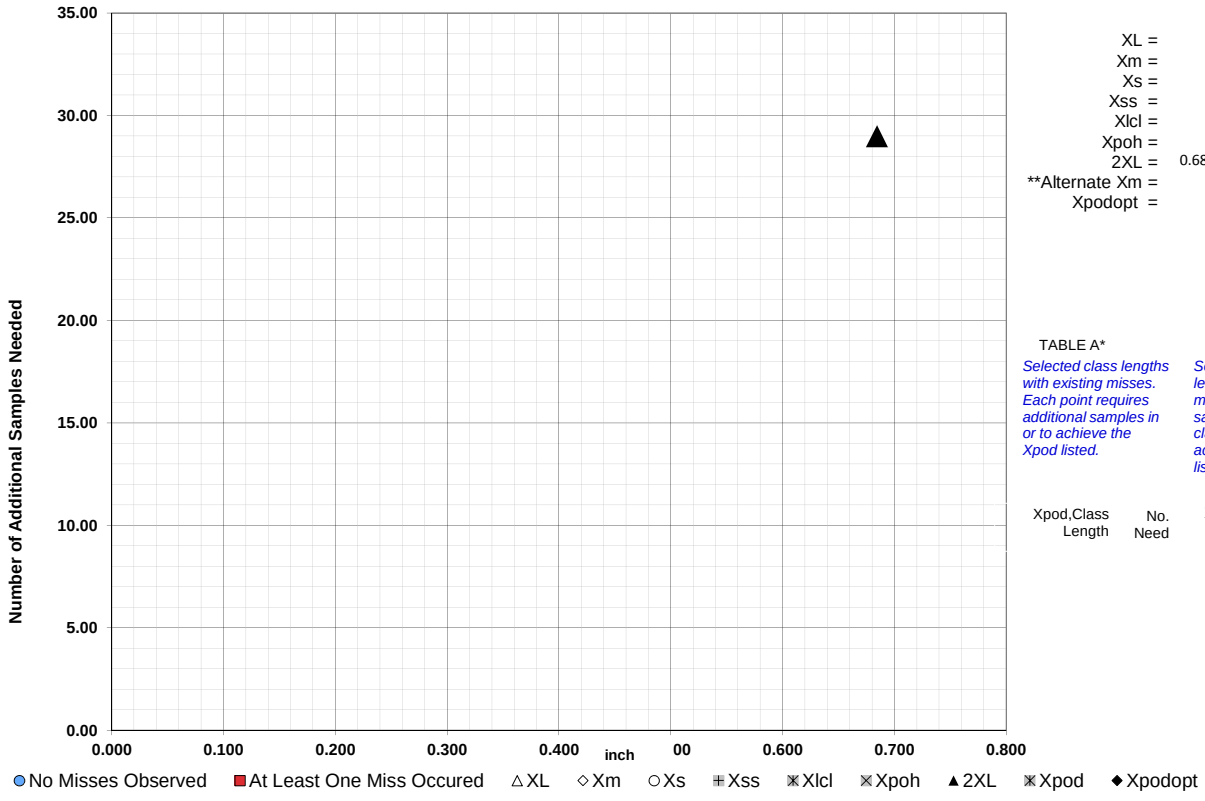



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

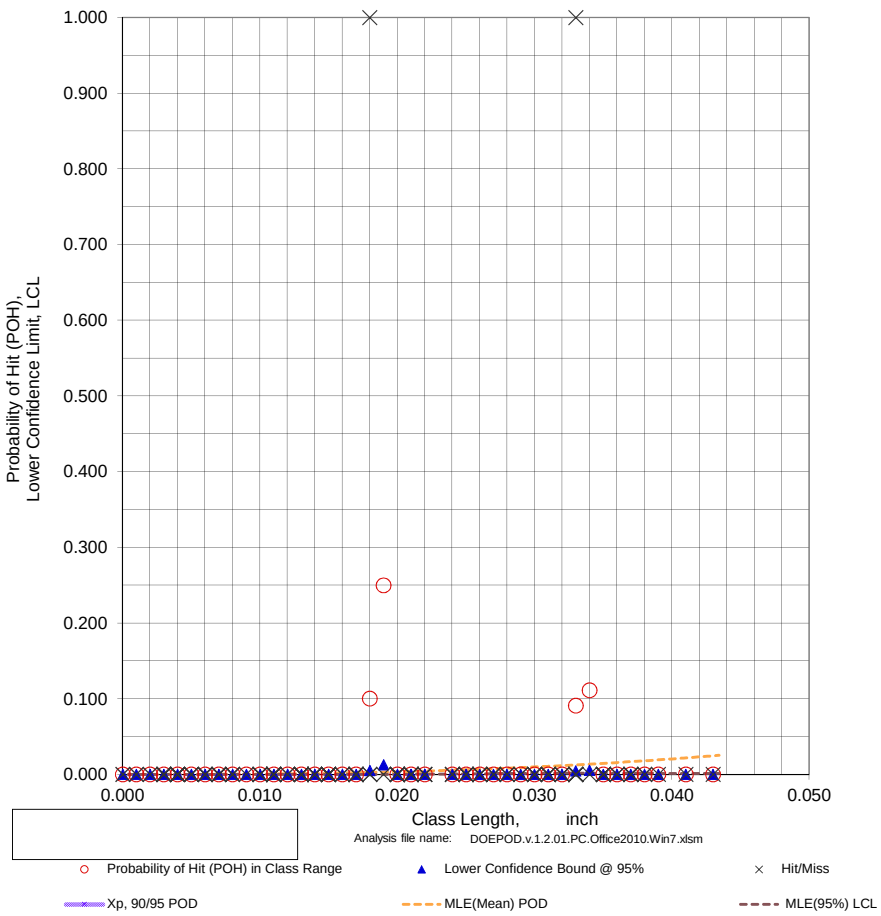
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10601CD.XLS
Data Set Name = F10601CD(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:35 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.0127 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0190 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.086 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10601CD.XLS
Data Set Name = F10601CD(CRACK #)

## Directed DOE Options

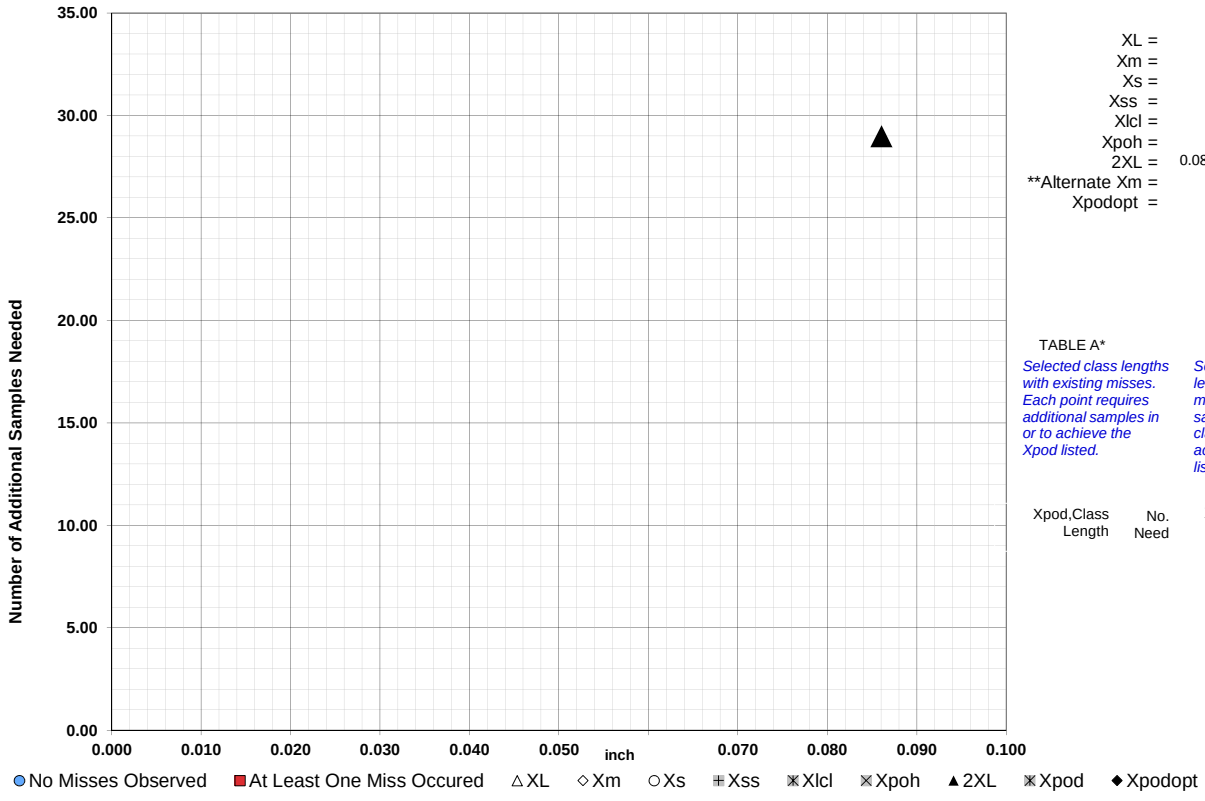



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.086 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

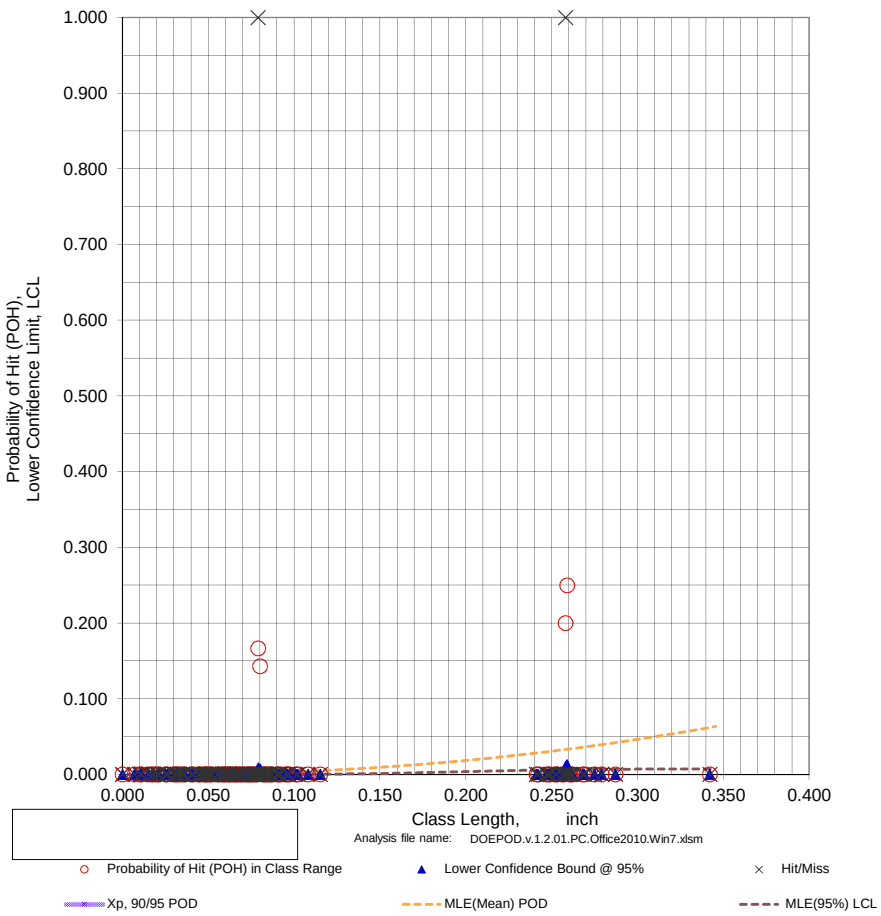
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F10601CL.XLS
Data Set Name = F10601CL(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:35 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.0127 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.2590 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10601CL.XLS
Data Set Name = F10601CL(CRACK #)

## Directed DOE Options

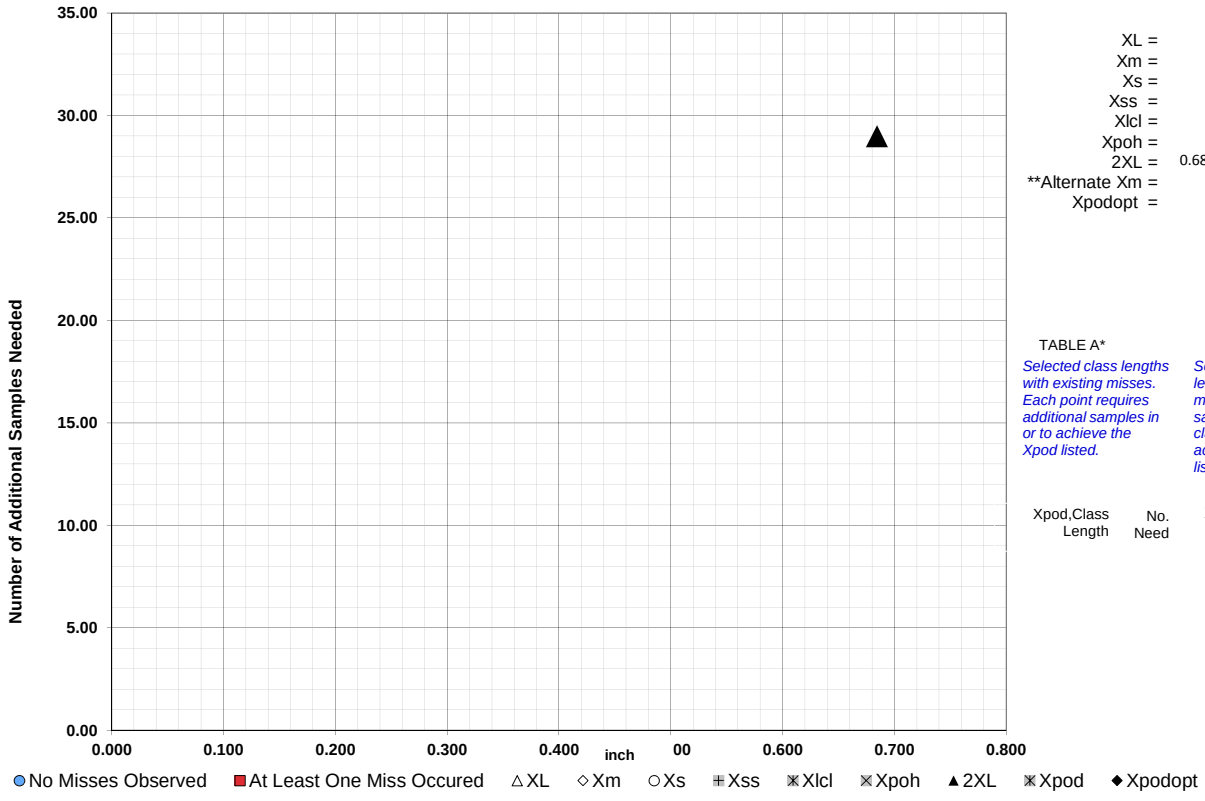



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

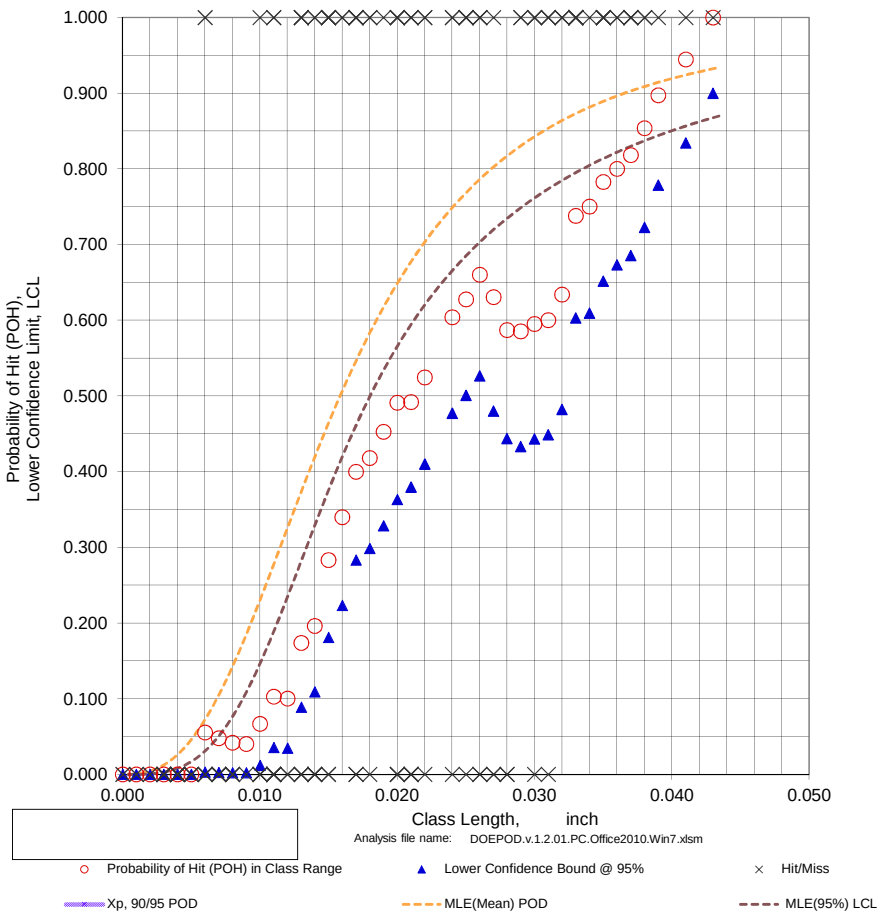
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.129.**

**Note: Xpodopt is within one class width of Xpod.**

**Warning: No false call analysis.**




File Name = **F10602AD.XLS**

Data Set Name = **F10602AD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:37 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.0430 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod is reached at XL. Increase flaw sizes to exceed 0.129. Recommend satisfying alternate 90/95 Xpodopt or Optimum Xpoh (if listed).**

Survey/Optimum Xpoh = 0.0330 -0.001 inch 18 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.919 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.914 | @ | 0.055 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.043 | inch |
| Samples Needed @ XL = | 0 | |
| Classlength Mid-point , Xm = | 0.043 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.042 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | | inch |

File Name = F10602AD.XLS
Data Set Name = F10602AD(CRACK #)

## Directed DOE Options

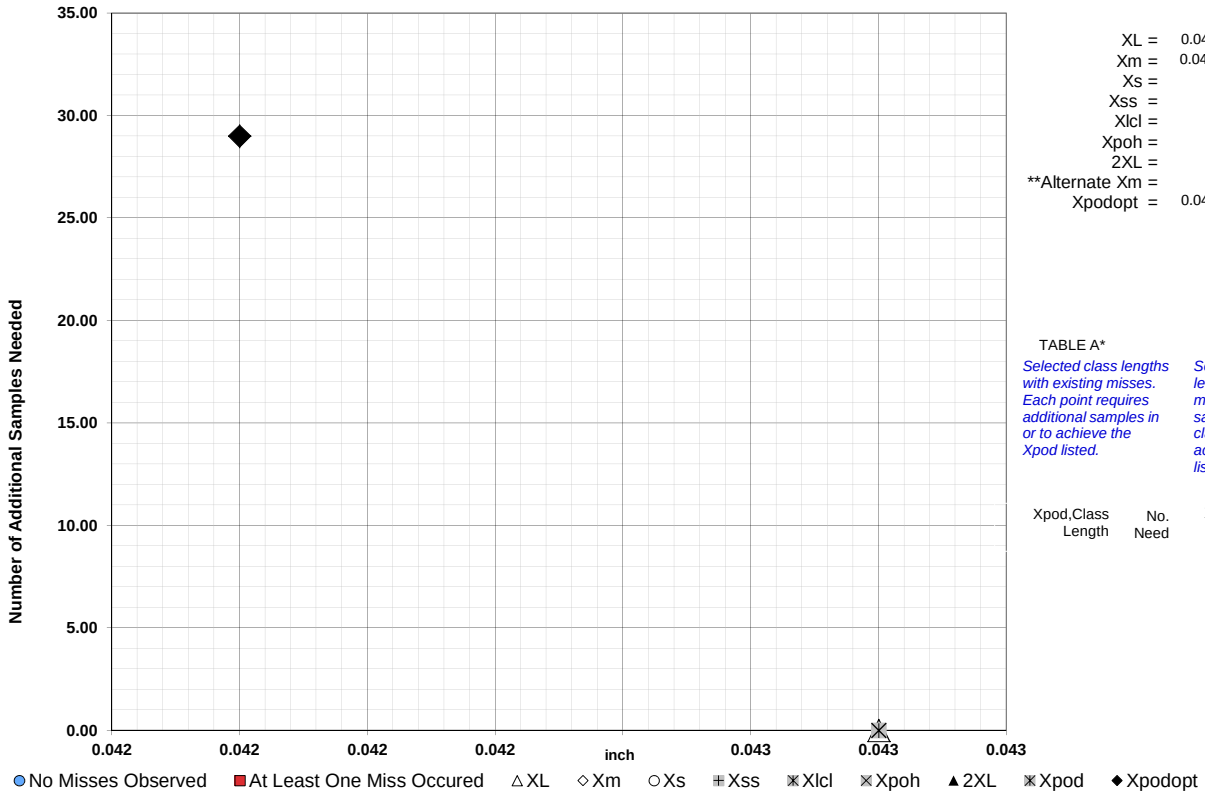



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.043 | 0 |
| Xm = | 0.043 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.042 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

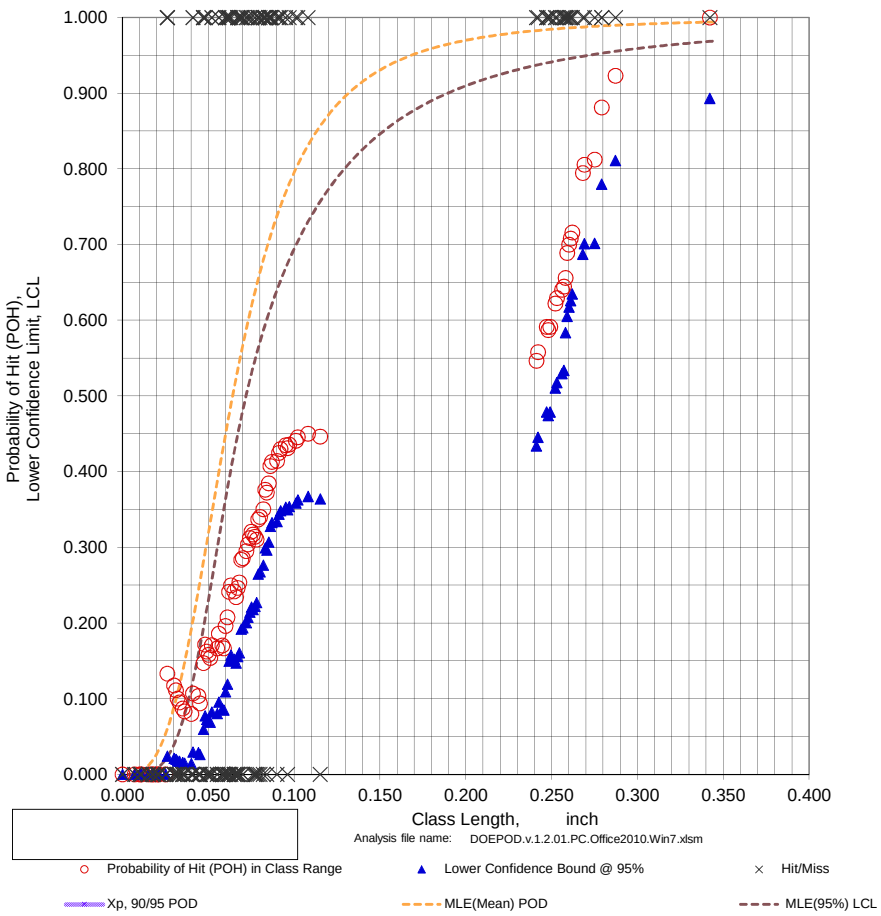
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10602AL.XLS
Data Set Name = F10602AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:37 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.3420 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2410 -0.100 inch 28 Samples

NTIAC 90% POD = 0.907 @ 0.135 inch
NTIAC 90/95 POD = 0.901 @ 0.190 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.342 | inch |
| Samples Needed @ Xlcl = | 2 | |
| POH Classlength, Xpoh = | 0.342 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10602AL.XLS
Data Set Name = F10602AL(CRACK #)

## Directed DOE Options

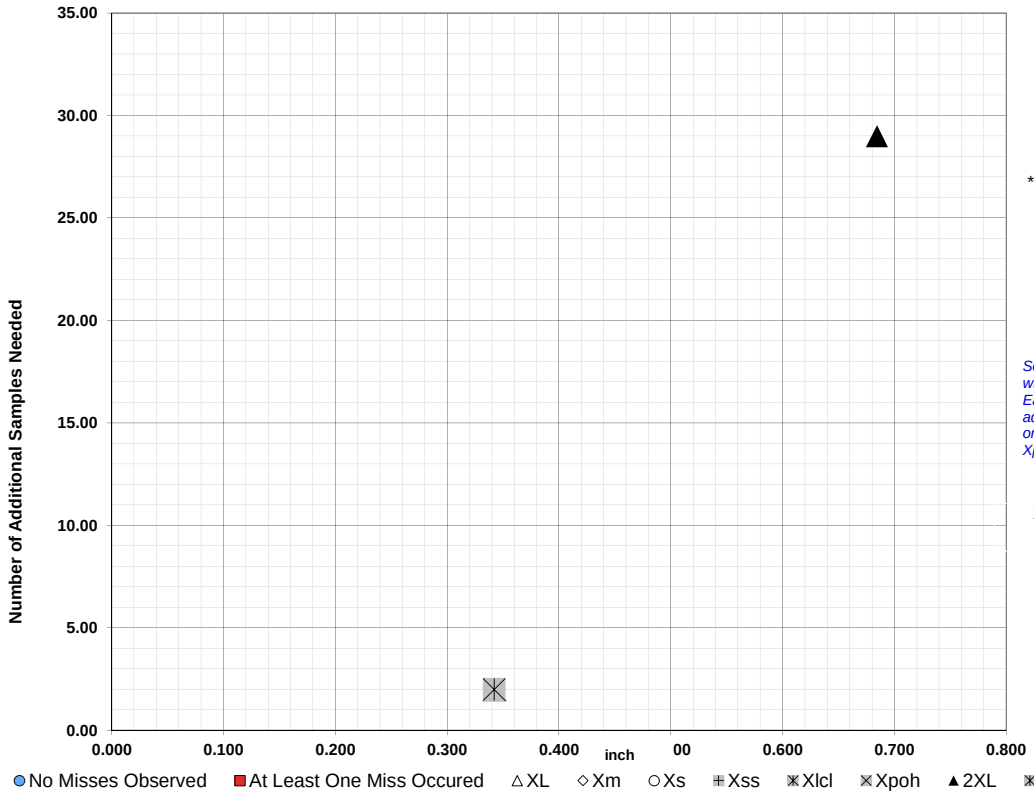



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 2 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.342 | 2 |
| Xpoh = | 0.342 | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

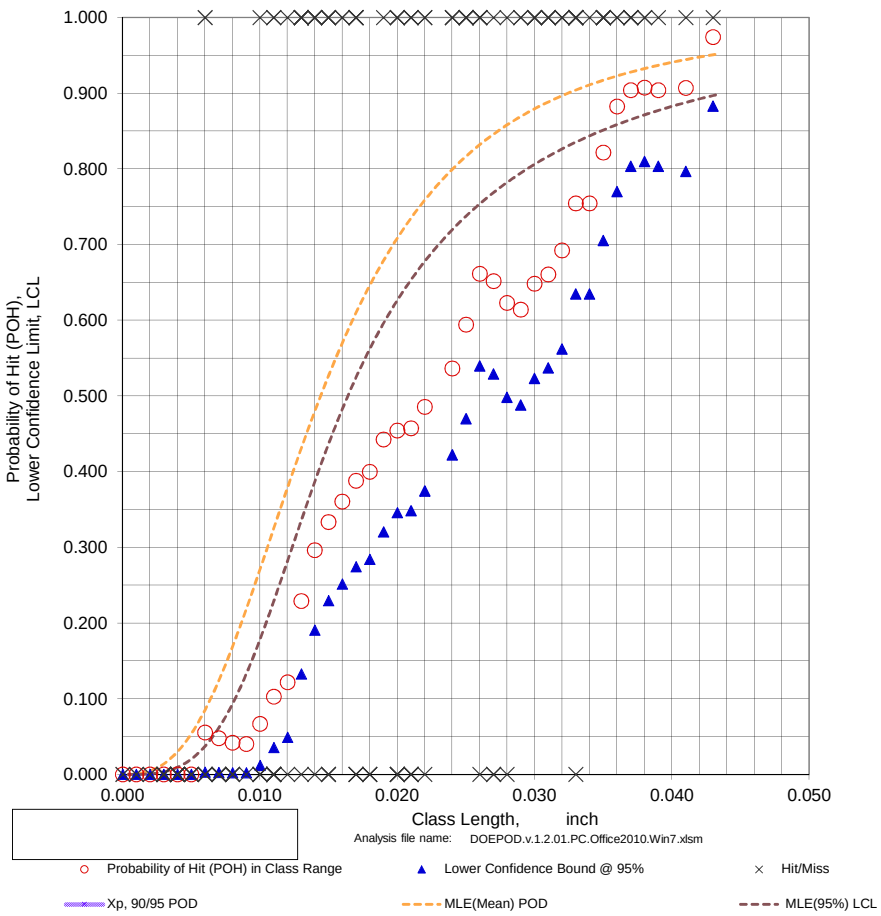
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10602BD.XLS
Data Set Name = F10602BD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:38 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8827 | |
| Classwidth @ Best LCL = | 0.0140 | inch |
| Classlength @ Best LCL = | 0.0430 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0350 -0.001 inch 22 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.917 | @ | 0.035 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.045 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.086 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10602BD.XLS
Data Set Name = F10602BD(CRACK #)

## Directed DOE Options

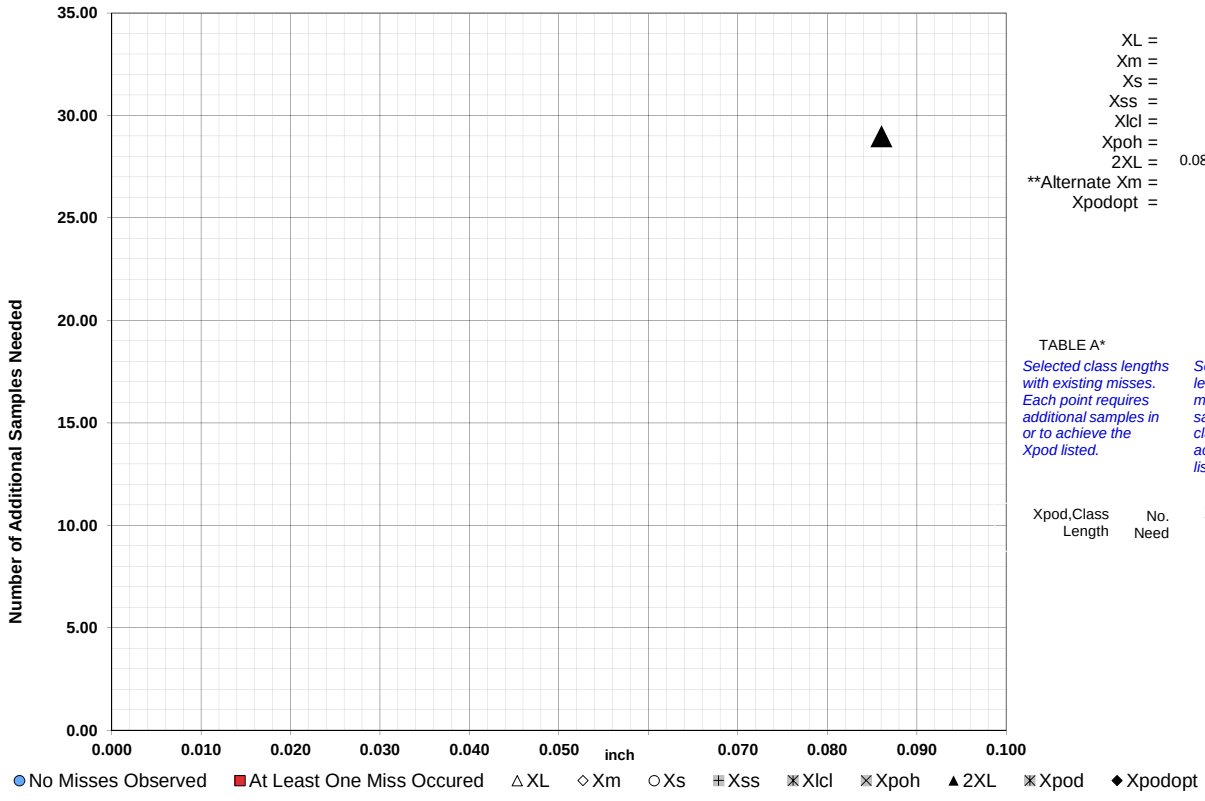



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.086 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

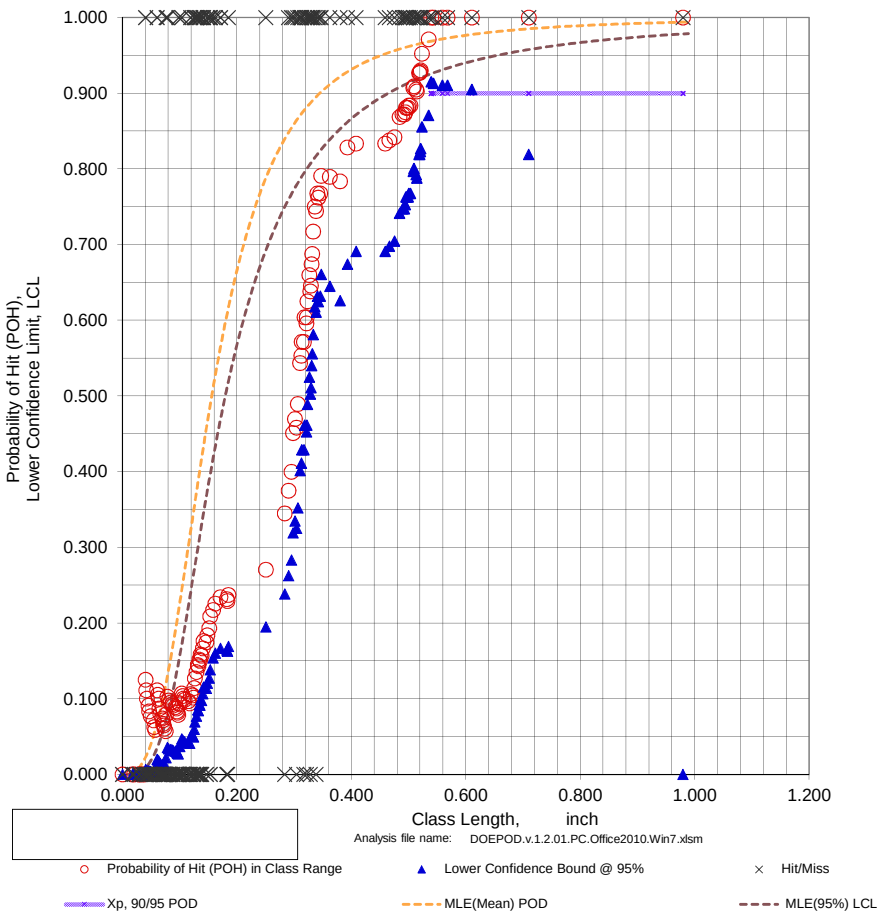
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.617.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F10602BL.XLS**

Data Set Name = **F10602BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:39 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.5390 | inch |
| Lower Confidence Bound = | 0.9152 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.3400 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.345 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.465 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.710 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.537 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.5390 | inch |

File Name = F10602BL.XLS
Data Set Name = F10602BL(CRACK #)

## Directed DOE Options

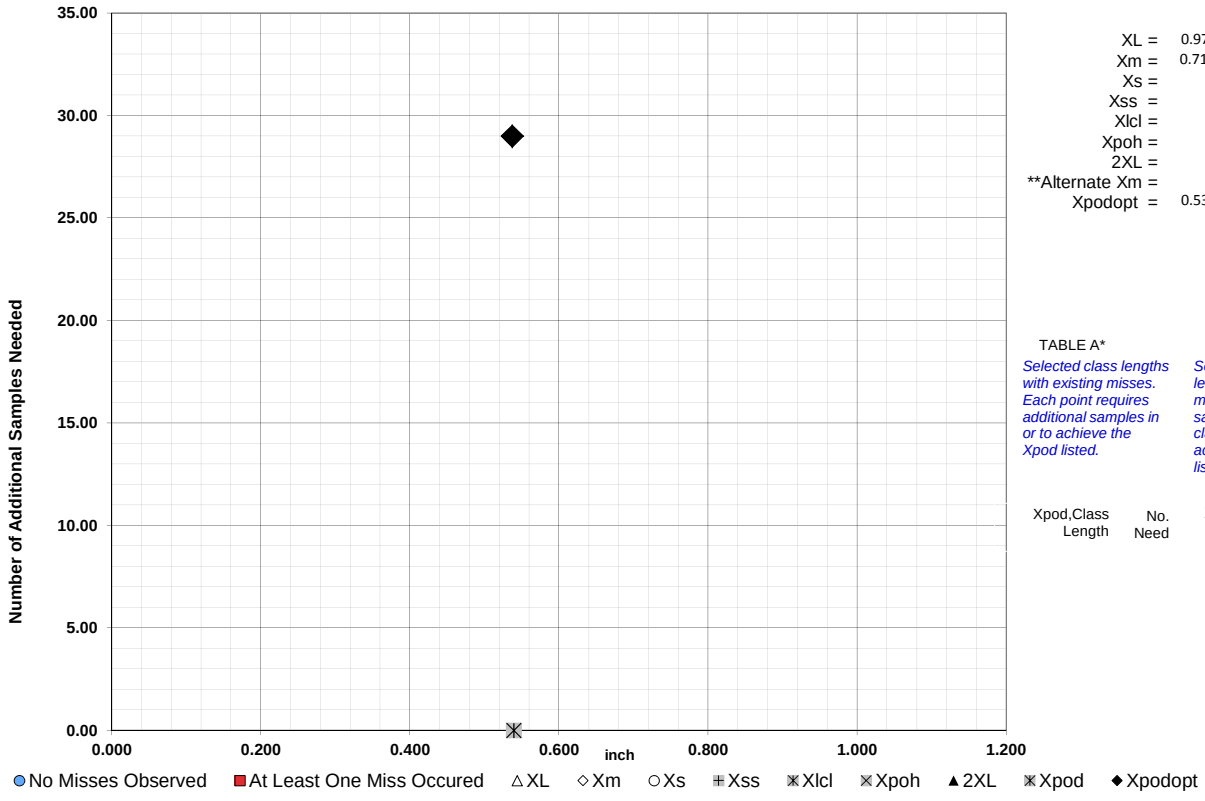



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | |
| Xm = | 0.710 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.537 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

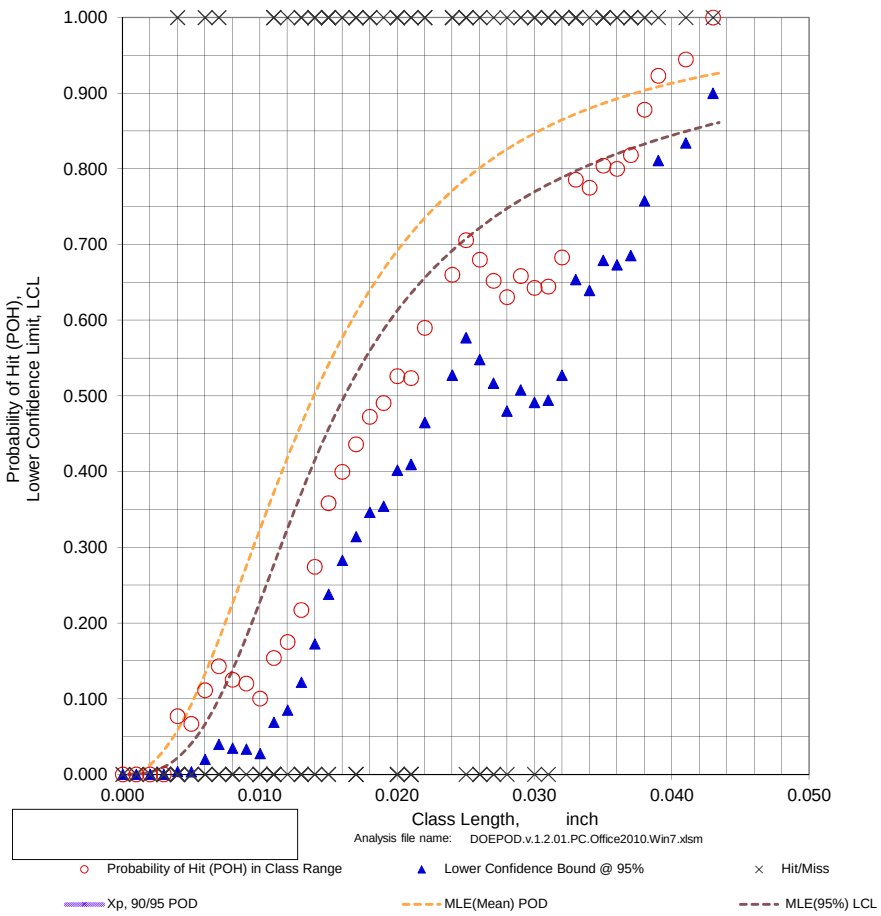
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.129.**

**Note: Xpodopt is within one class width of Xpod.**

**Warning: No false call analysis.**




File Name = **F10602CD.XLS**

Data Set Name = **F10602CD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:41 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.0430 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod is reached at XL. Increase flaw sizes to exceed 0.129. Recommend satisfying alternate 90/95 Xpodopt or Optimum Xpoh (if listed).**

Survey/Optimum Xpoh = 0.0330 -0.001 inch 18 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.913 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.055 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.043 | inch |
| Samples Needed @ XL = | 0 | |
| Classlength Mid-point , Xm = | 0.043 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.042 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | | inch |

File Name = F10602CD.XLS
Data Set Name = F10602CD(CRACK #)

## Directed DOE Options

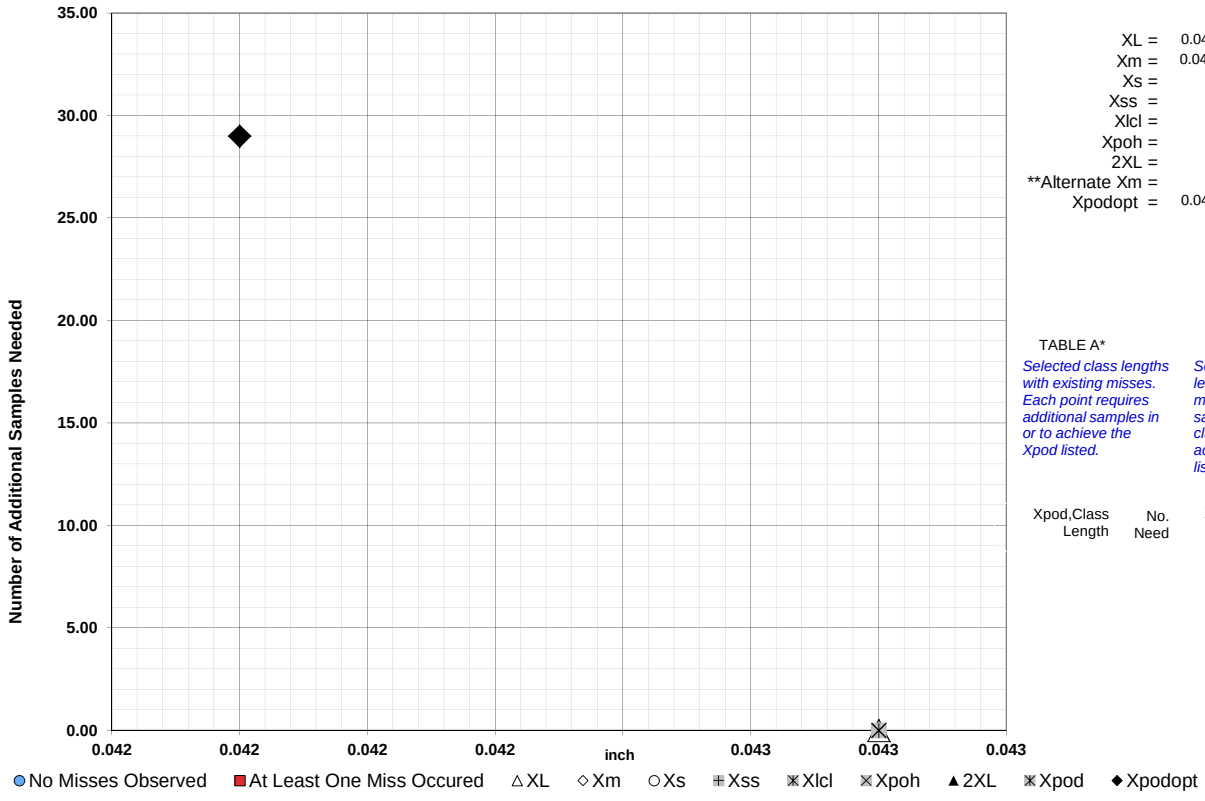



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.043 | 0 |
| Xm = | 0.043 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.042 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

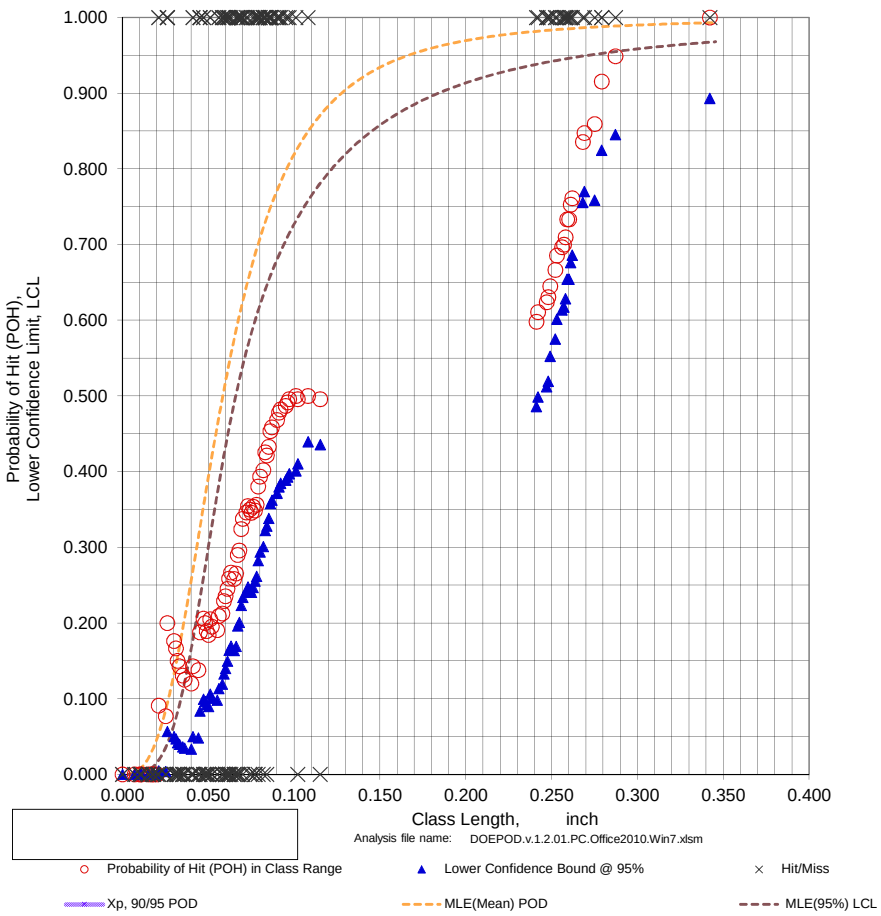
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10602CL.XLS
Data Set Name = F10602CL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:41 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.3420 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2410 -0.100 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.130 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.185 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.342 | inch |
| Samples Needed @ Xlcl = | 2 | |
| POH Classlength, Xpoh = | 0.342 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10602CL.XLS
Data Set Name = F10602CL(CRACK #)

## Directed DOE Options

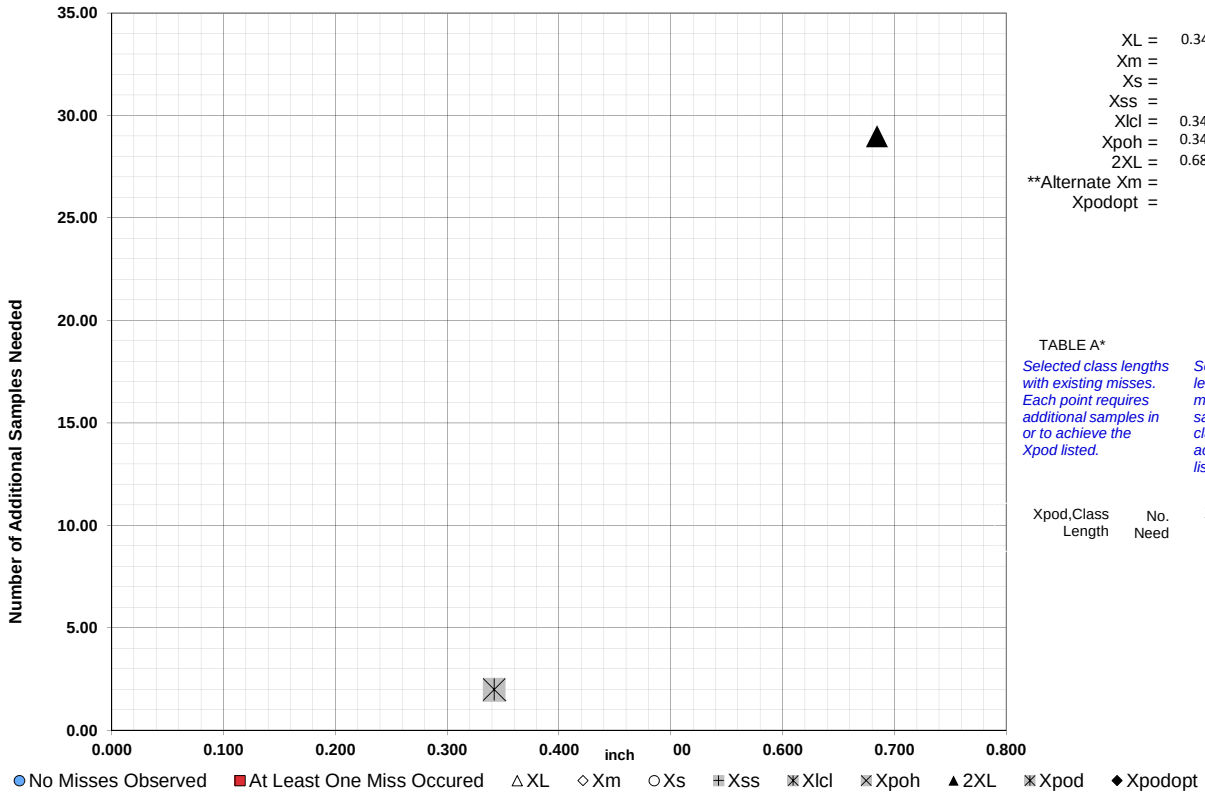



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 2 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.342 | 2 |
| Xpoh = | 0.342 | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

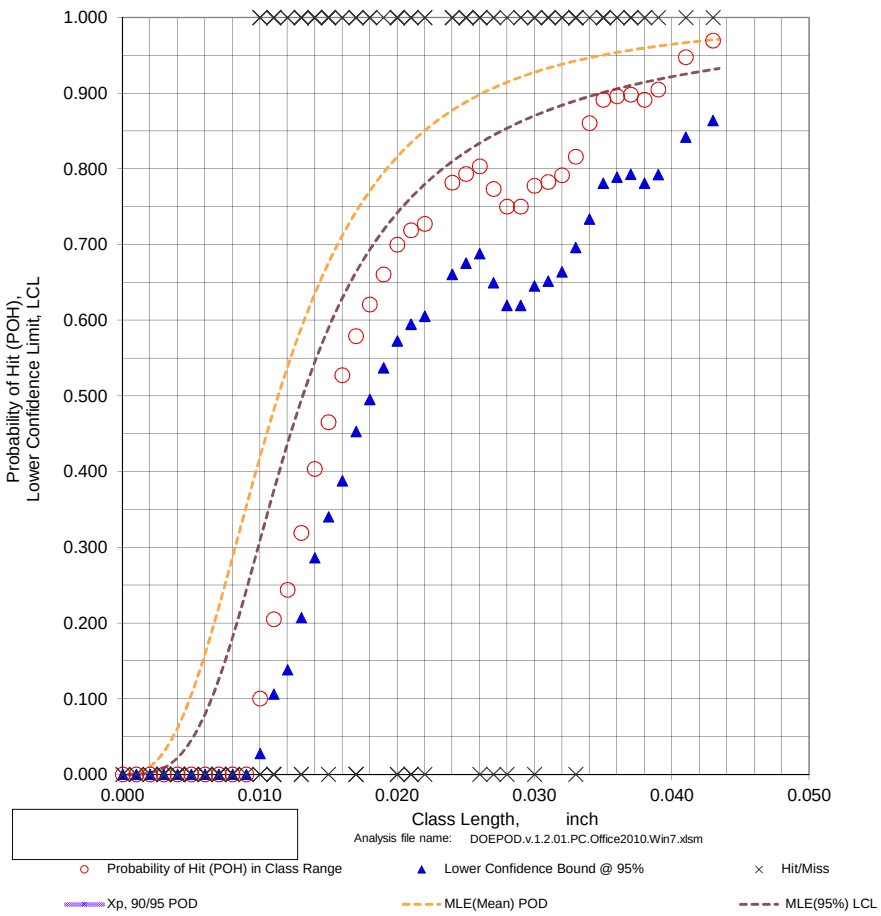
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10603AD.XLS
Data Set Name = F10603AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:43 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8637 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.0430 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0350 -0.001 inch 22 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.928 | @ | 0.030 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.035 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.086 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10603AD.XLS
Data Set Name = F10603AD(CRACK #)

## Directed DOE Options

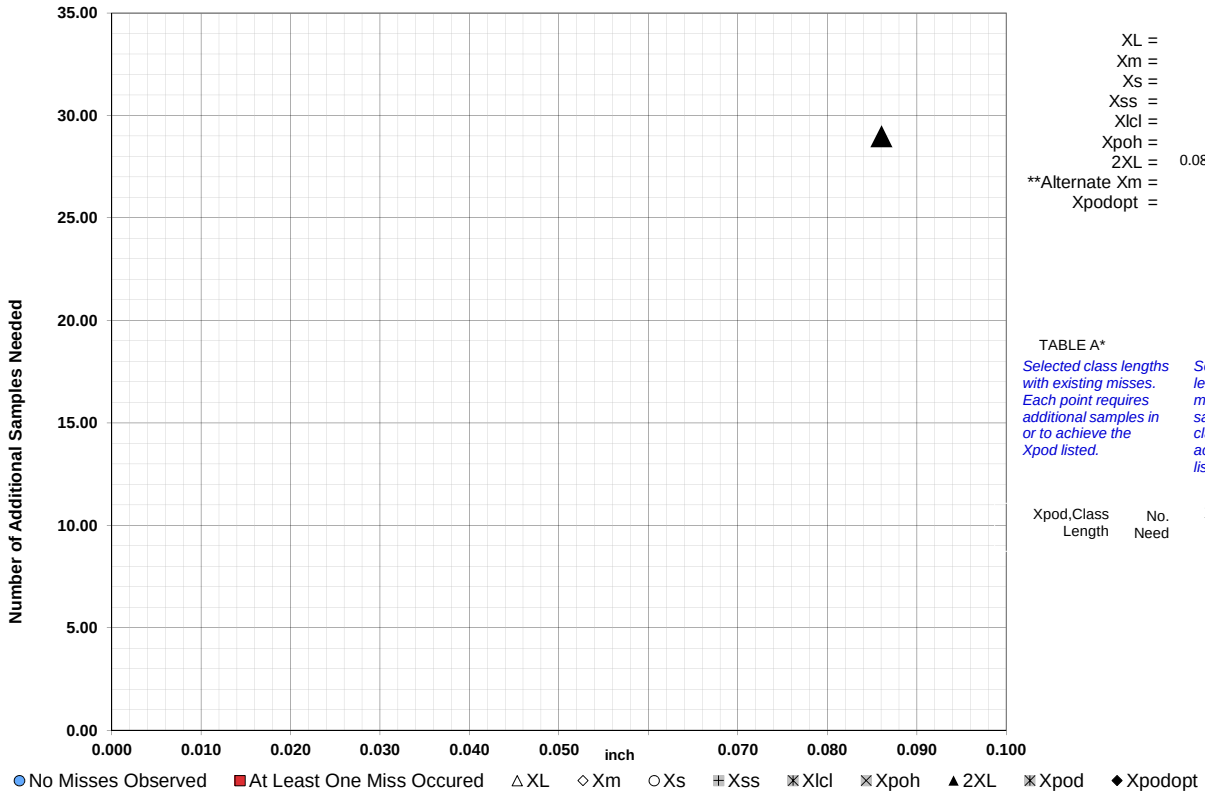



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.086 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

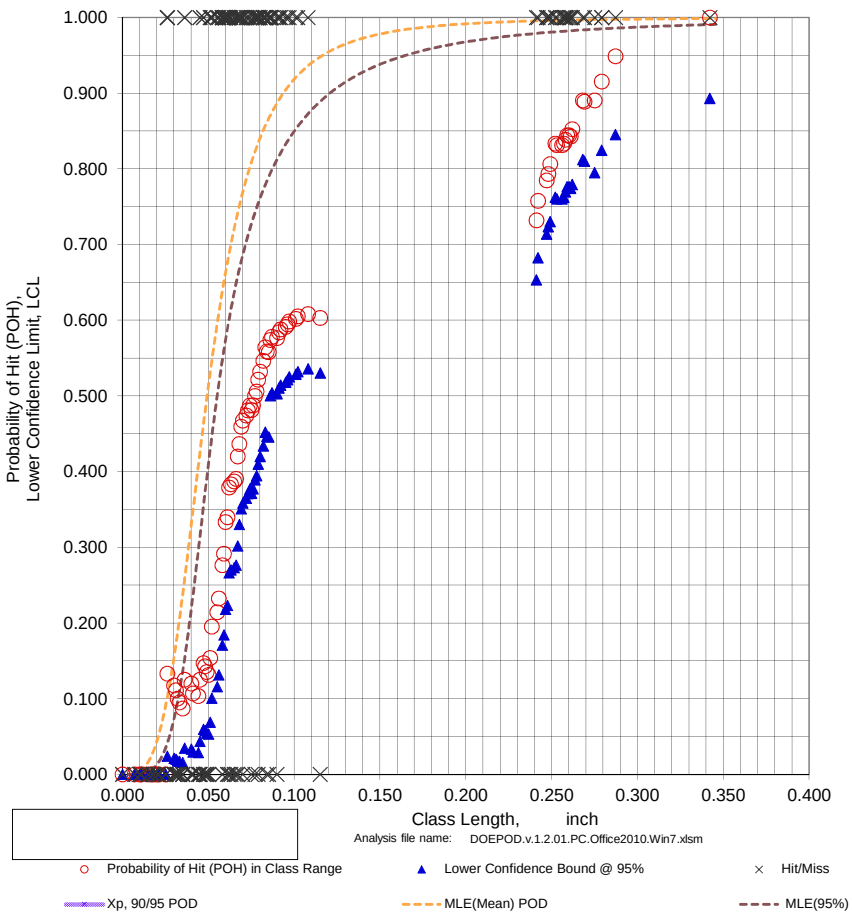
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10603AL.XLS
Data Set Name = F10603AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:43 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.3420 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2410 -0.100 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.904 | @ | 0.095 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.125 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.342 | inch |
| Samples Needed @ Xlcl = | 2 | |
| POH Classlength, Xpoh = | 0.342 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10603AL.XLS
Data Set Name = F10603AL(CRACK #)

## Directed DOE Options

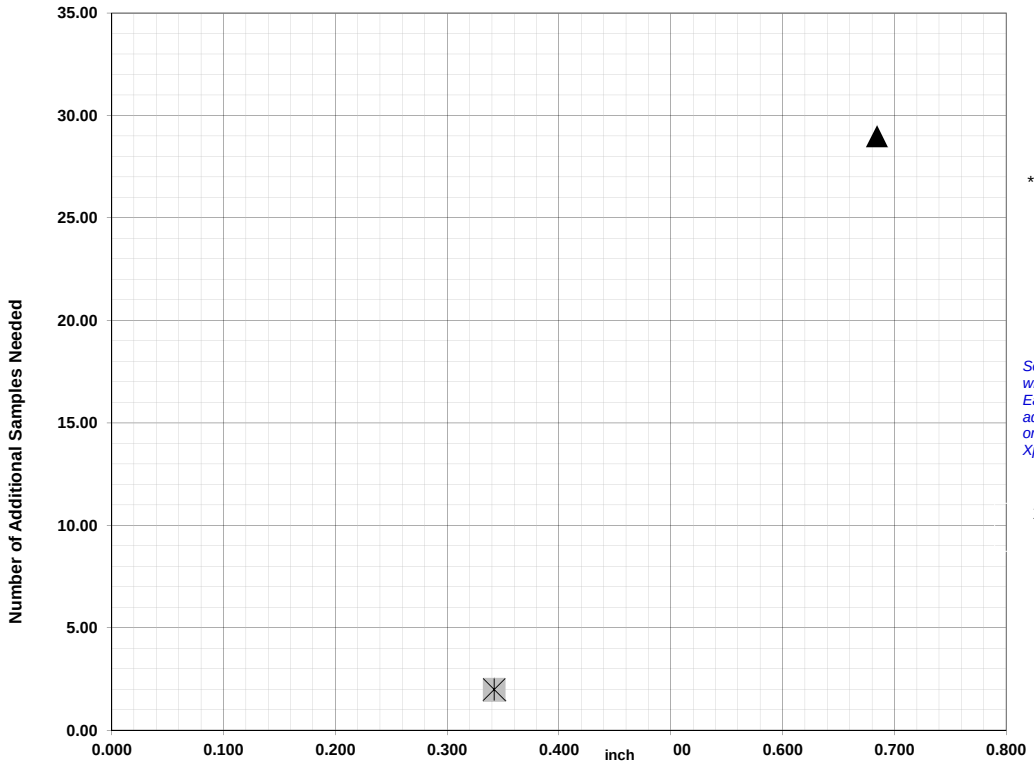



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 2 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.342 | 2 |
| Xpoh = | 0.342 | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

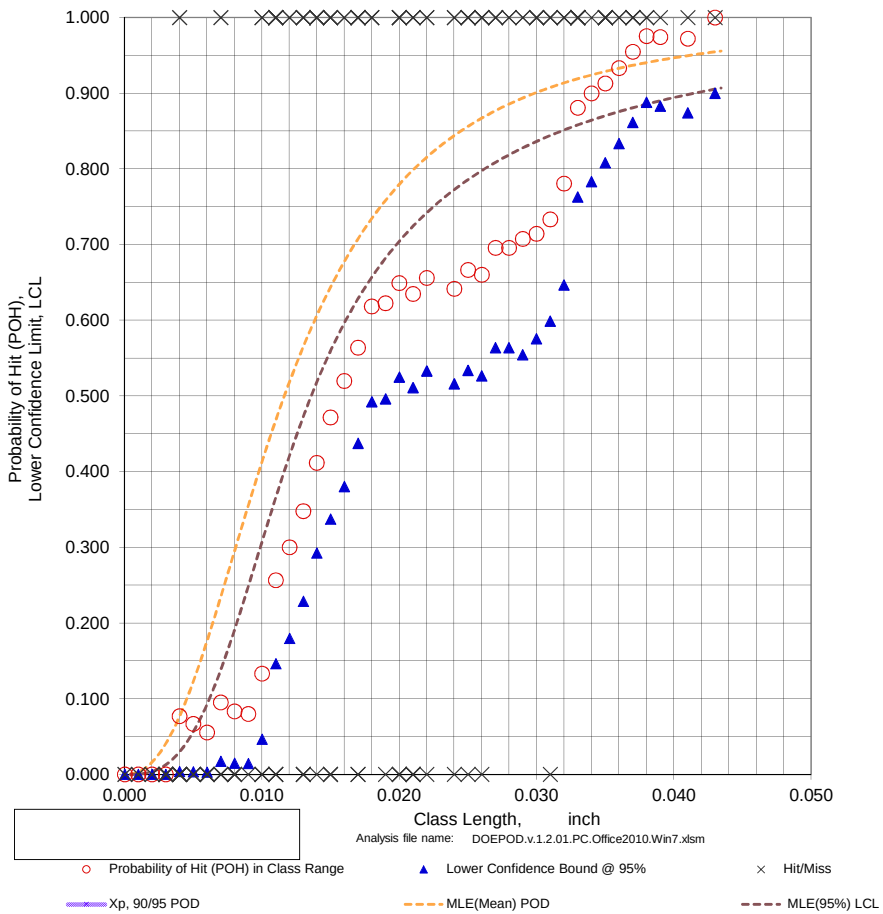
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.129.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F10603BD.XLS**

Data Set Name = **F10603BD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:45 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.0430 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod is reached at XL. Increase flaw sizes to exceed 0.129. Recommend satisfying alternate 90/95 Xpodopt or Optimum Xpoh (if listed).**

Survey/Optimum Xpoh = 0.0330 -0.001 inch 18 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.965 | @ | 0.025 | inch |
| NTIAC 90/95 POD = | 0.912 | @ | 0.025 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.043 | inch |
| Samples Needed @ XL = | 0 | |
| Classlength Mid-point , Xm = | 0.043 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.042 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | | inch |

File Name = F10603BD.XLS
Data Set Name = F10603BD(CRACK #)

## Directed DOE Options

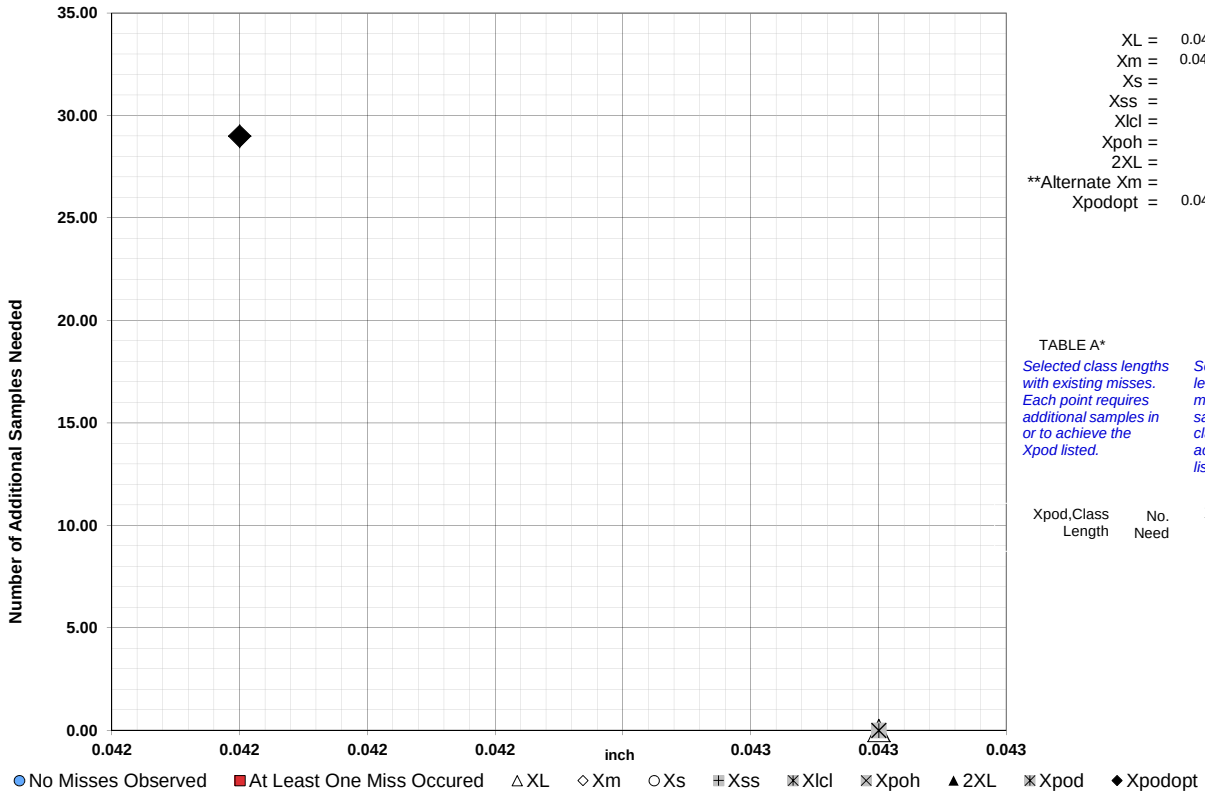



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.043 | 0 |
| Xm = | 0.043 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.042 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

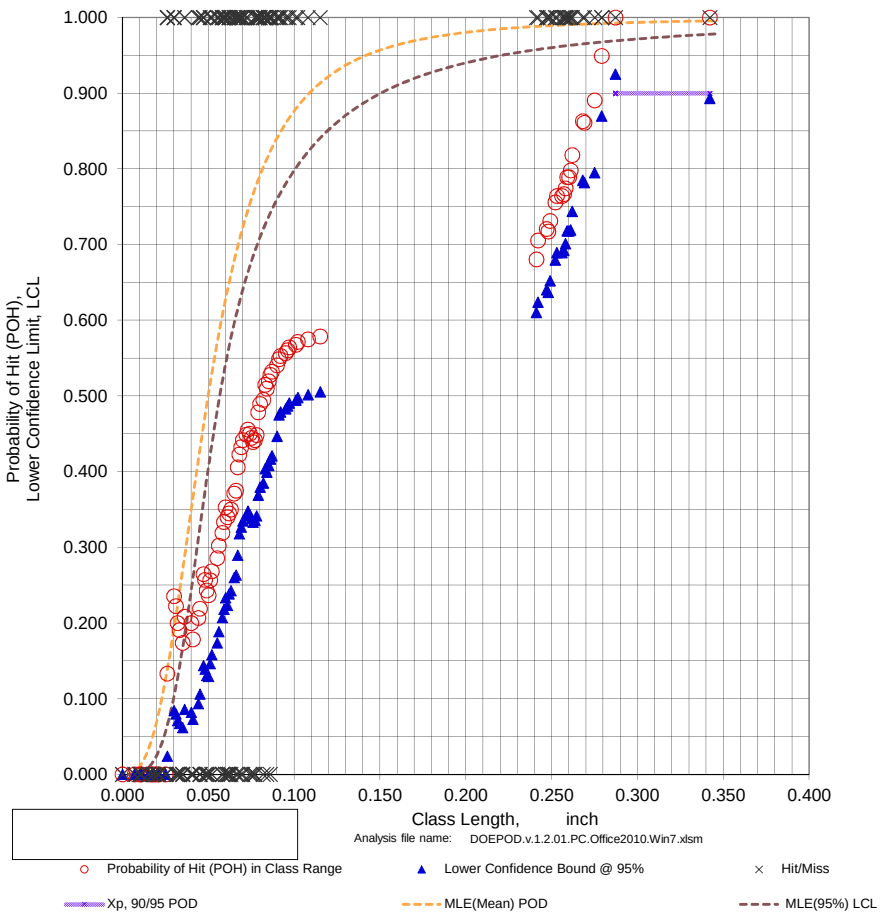
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.861.**

**Note: No Midpoint evaluation; Xpod near XL. Meet 2XL to extend VALIDATION Warning: No false call analysis.**




File Name = **F10603BL.XLS**

Data Set Name = **F10603BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:45 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.2870 | inch |
| Lower Confidence Bound = | 0.9253 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0900 -0.003 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.903 | @ | 0.110 | inch |
| NTIAC 90/95 POD = | 0.905 | @ | 0.155 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.315 | inch |
| Samples Needed @ Xm = | 0 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.283 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.2870 | inch |

File Name = F10603BL.XLS
Data Set Name = F10603BL(CRACK #)

## Directed DOE Options

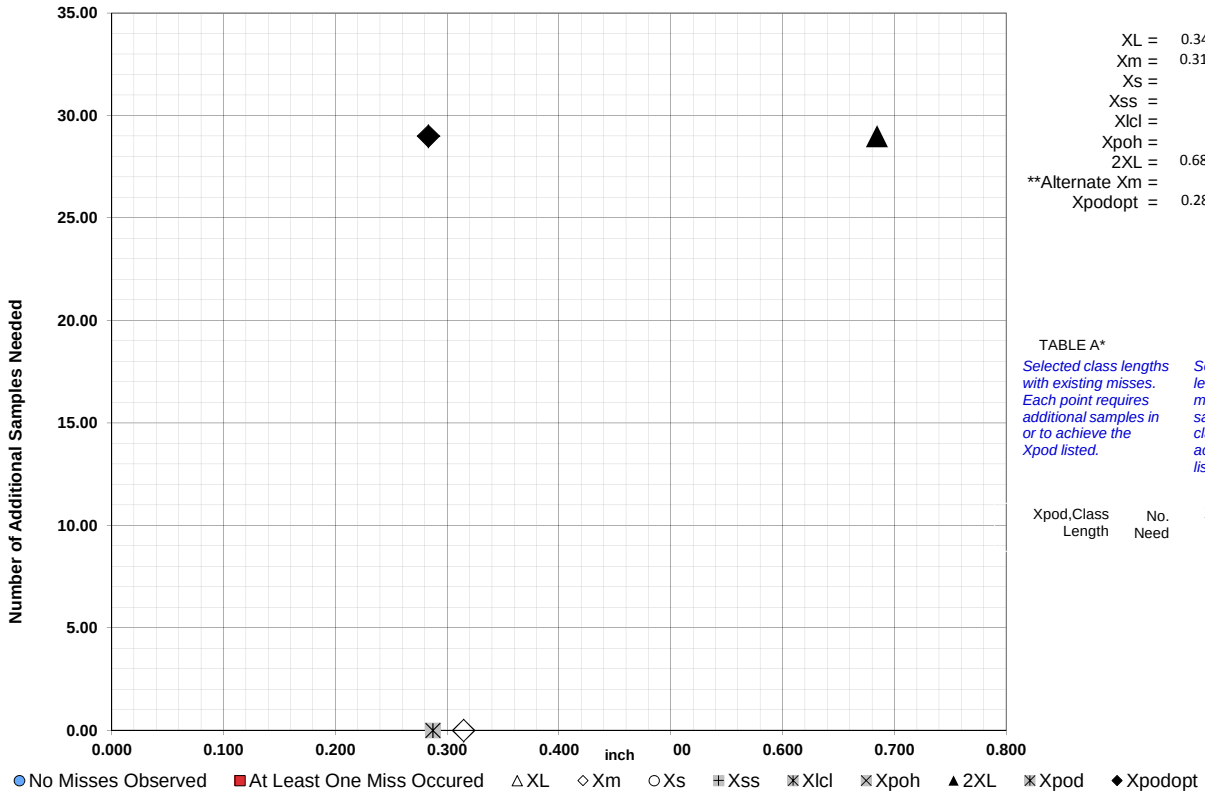



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | |
| Xm = | 0.315 | 0 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.684 | 1 |
| **Alternate Xm = | | |
| Xpodopt = | 0.283 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

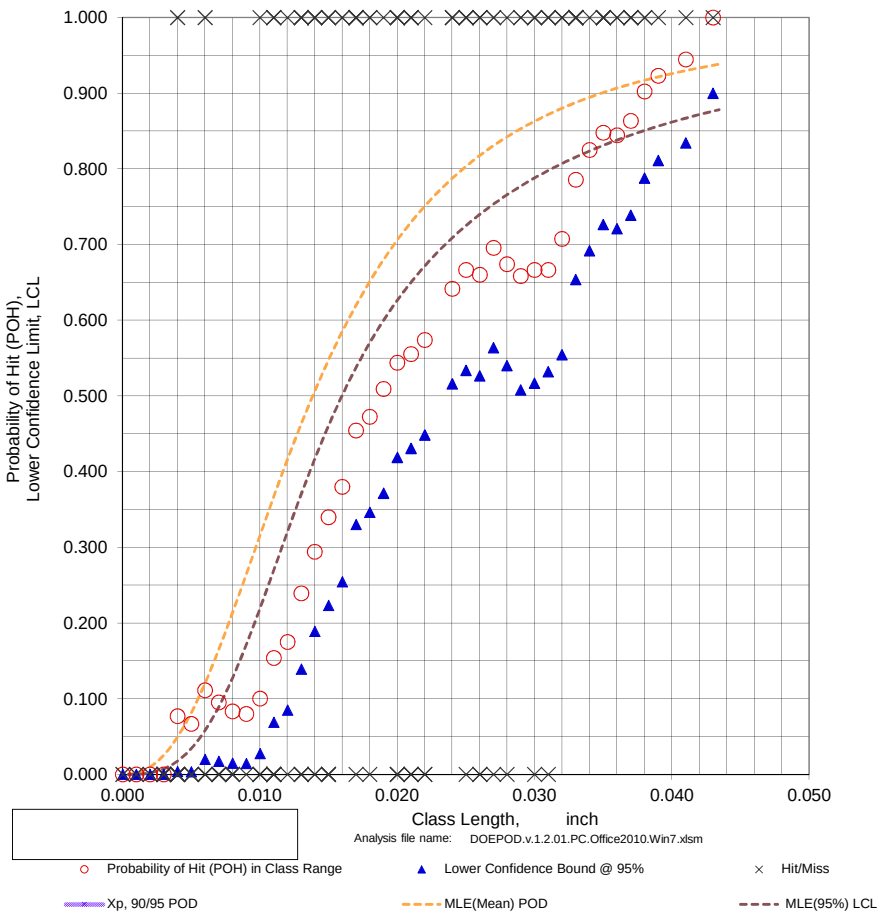
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.129.**

**Note: Xpodopt is within one class width of Xpod.**

**Warning: No false call analysis.**




File Name = **F10603CD.XLS**

Data Set Name = **F10603CD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:46 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0110 | inch |
| Classlength @ 90/95 Xpod = | 0.0430 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod is reached at XL. Increase flaw sizes to exceed 0.129. Recommend satisfying alternate 90/95 Xpodopt or Optimum Xpoh (if listed).**

Survey/Optimum Xpoh = 0.0330 -0.001 inch 18 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.035 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.050 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.043 | inch |
| Samples Needed @ XL = | 0 | |
| Classlength Mid-point , Xm = | 0.043 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.042 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | | inch |

File Name = F10603CD.XLS
Data Set Name = F10603CD(CRACK #)

## Directed DOE Options

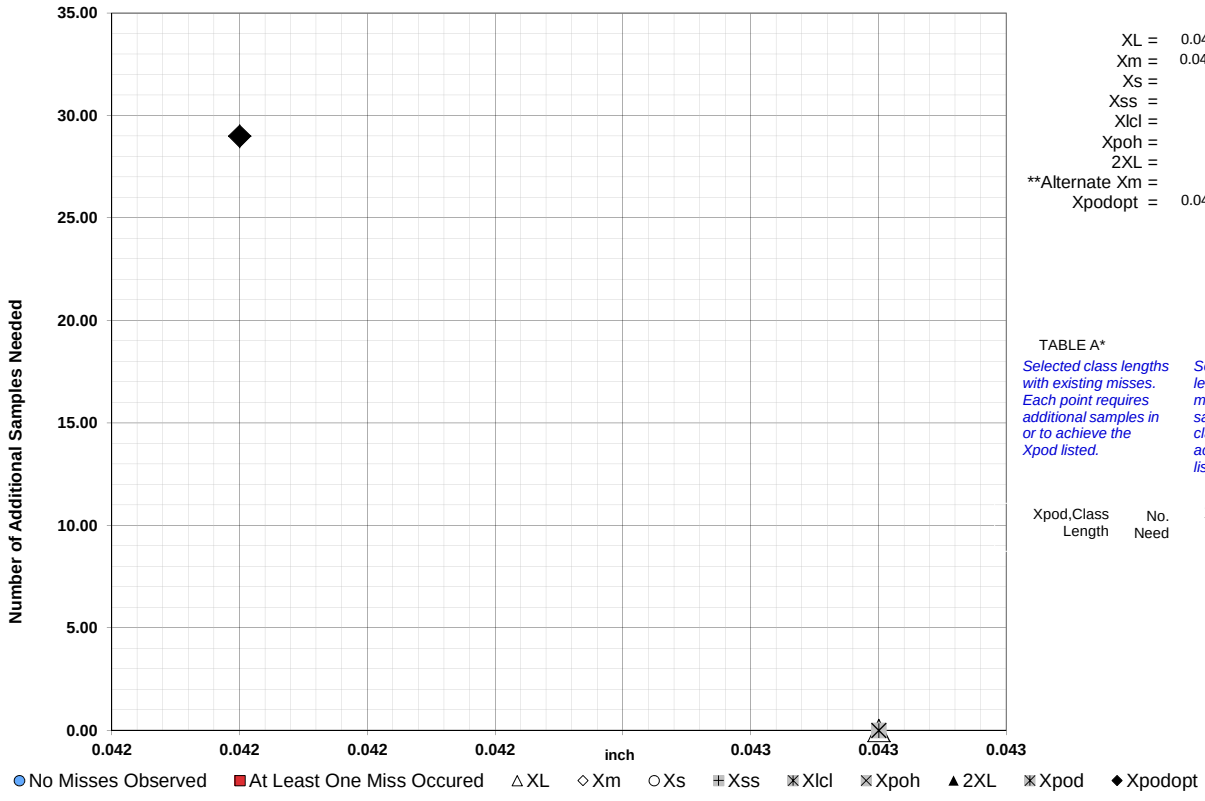



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.043 | 0 |
| Xm = | 0.043 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.042 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

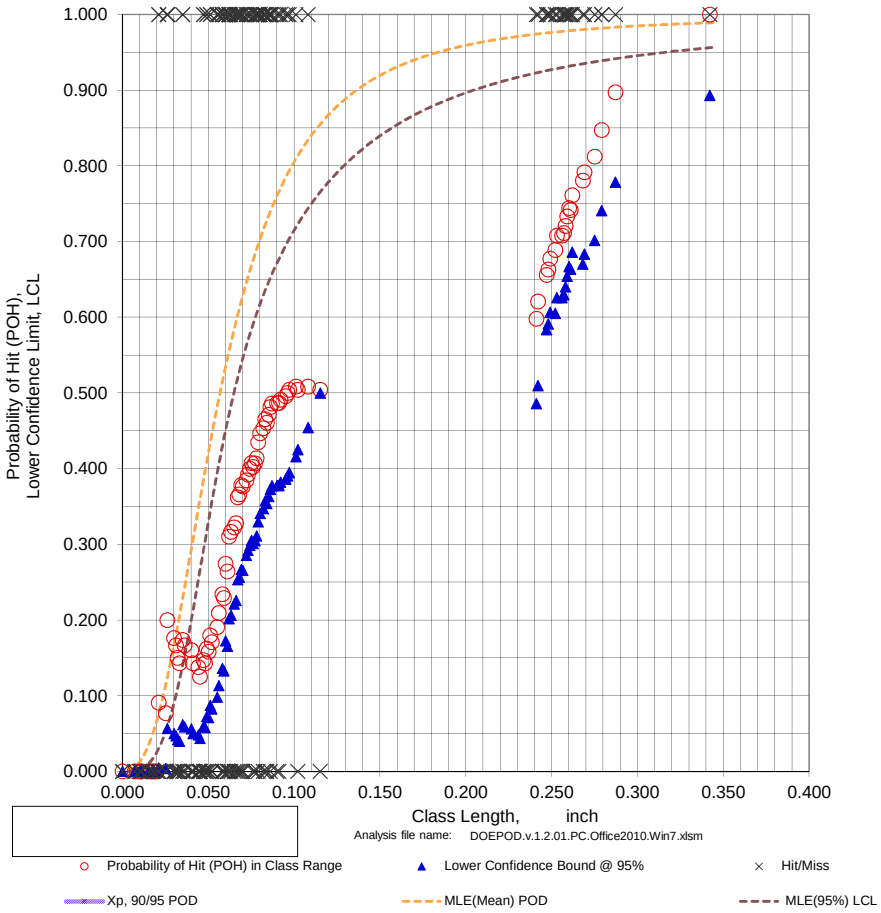
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F10603CL.XLS
Data Set Name = F10603CL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:47 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.3420 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2410 -0.100 inch 28 Samples

NTIAC 90% POD = 0.906 @ 0.140 inch
NTIAC 90/95 POD = 0.901 @ 0.205 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.342 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.342 | inch |
| Samples Needed @ Xlcl = | 2 | |
| POH Classlength, Xpoh = | 0.342 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.684 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F10603CL.XLS
Data Set Name = F10603CL(CRACK #)

## Directed DOE Options

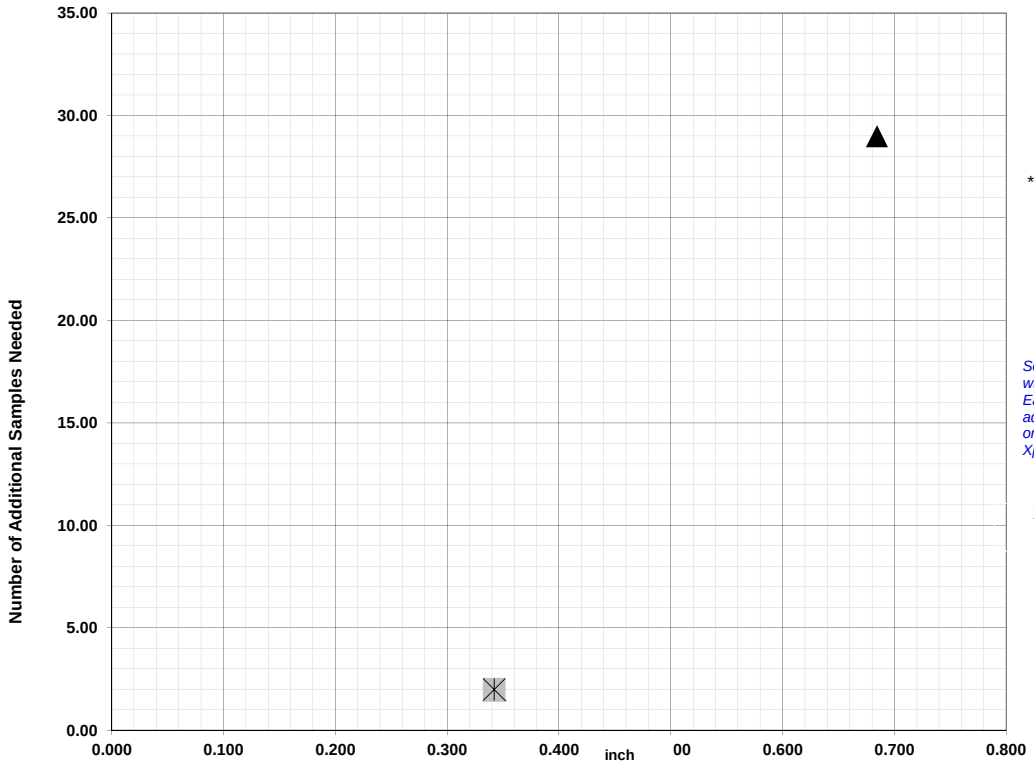



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.342 | 2 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.342 | 2 |
| Xpoh = | 0.342 | |
| 2XL = | 0.684 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

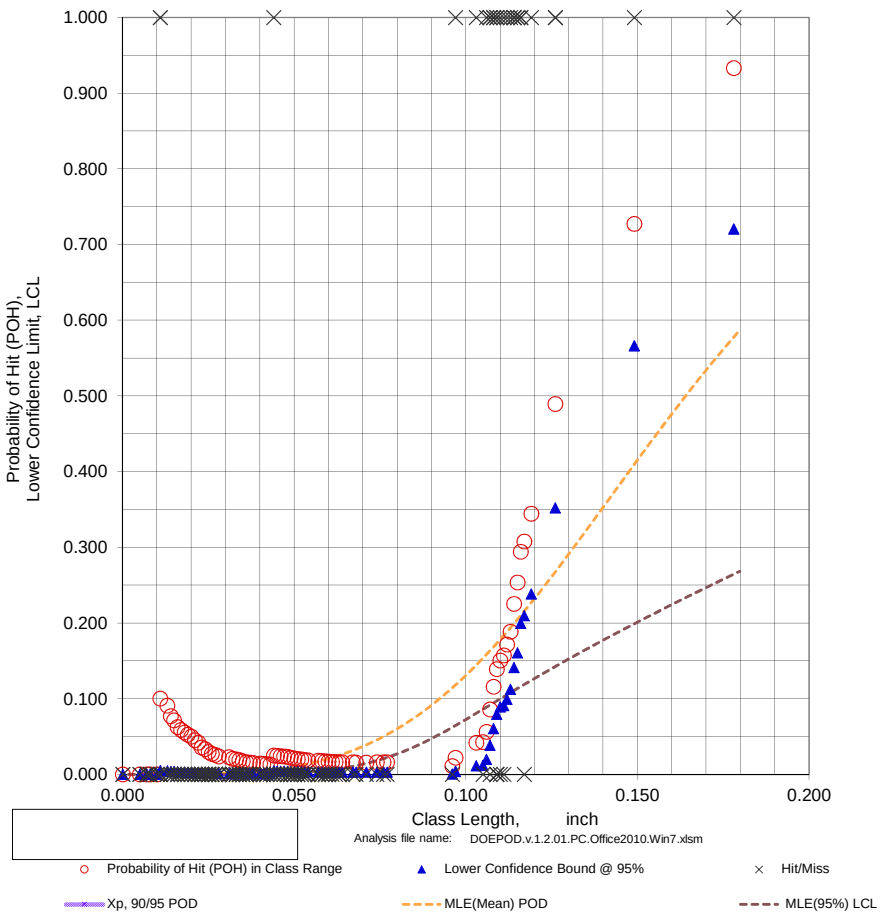
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F12201AD.XLS

Data Set Name = F12201AD(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:48 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7206 | |
| Classwidth @ Best LCL = | 0.0660 | inch |
| Classlength @ Best LCL = | 0.1780 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.1190 -0.001 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12201AD.XLS
Data Set Name = F12201AD(CRACK #)

## Directed DOE Options

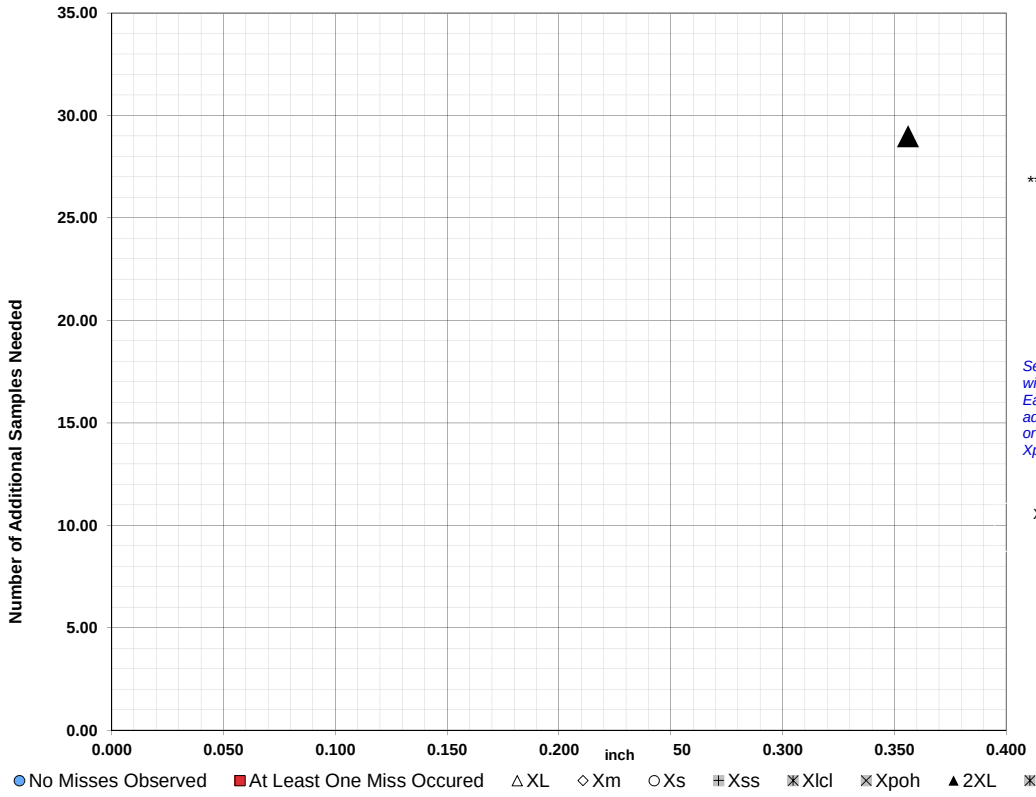



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

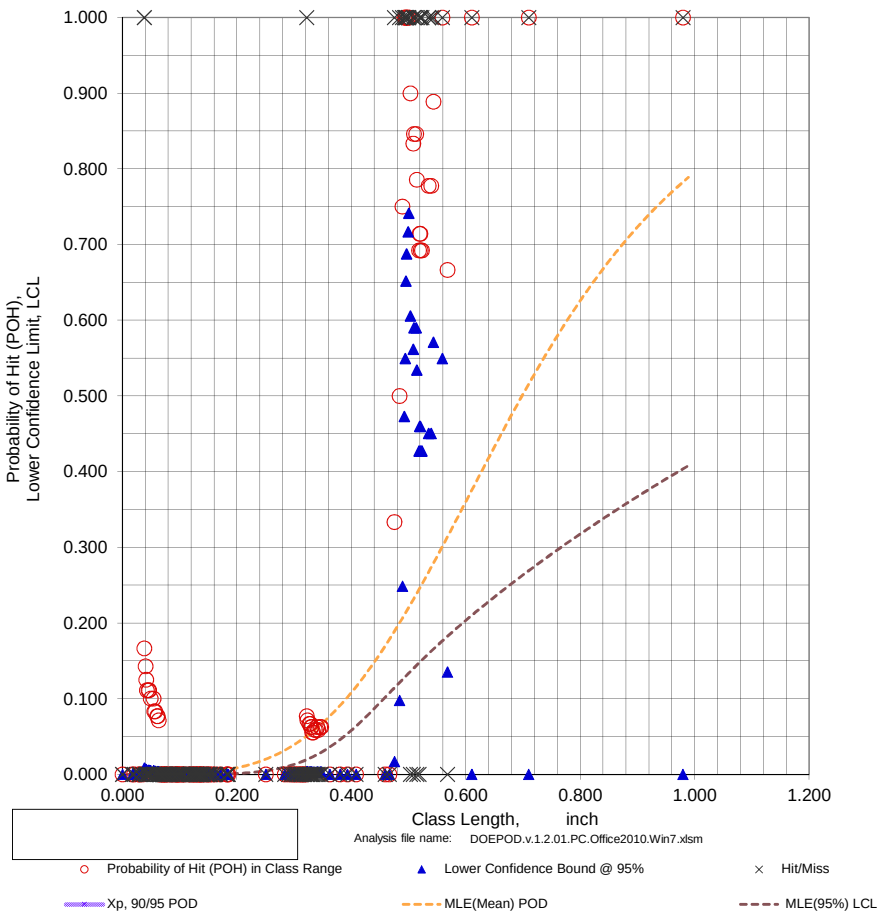
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F12201AL.XLS
Data Set Name = F12201AL(CRACK #)

MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:50 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0250 | inch |
| Classlength @ Best LCL = | 0.5000 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.6100 -0.041 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.610 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.958 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12201AL.XLS
Data Set Name = F12201AL(CRACK #)

## Directed DOE Options

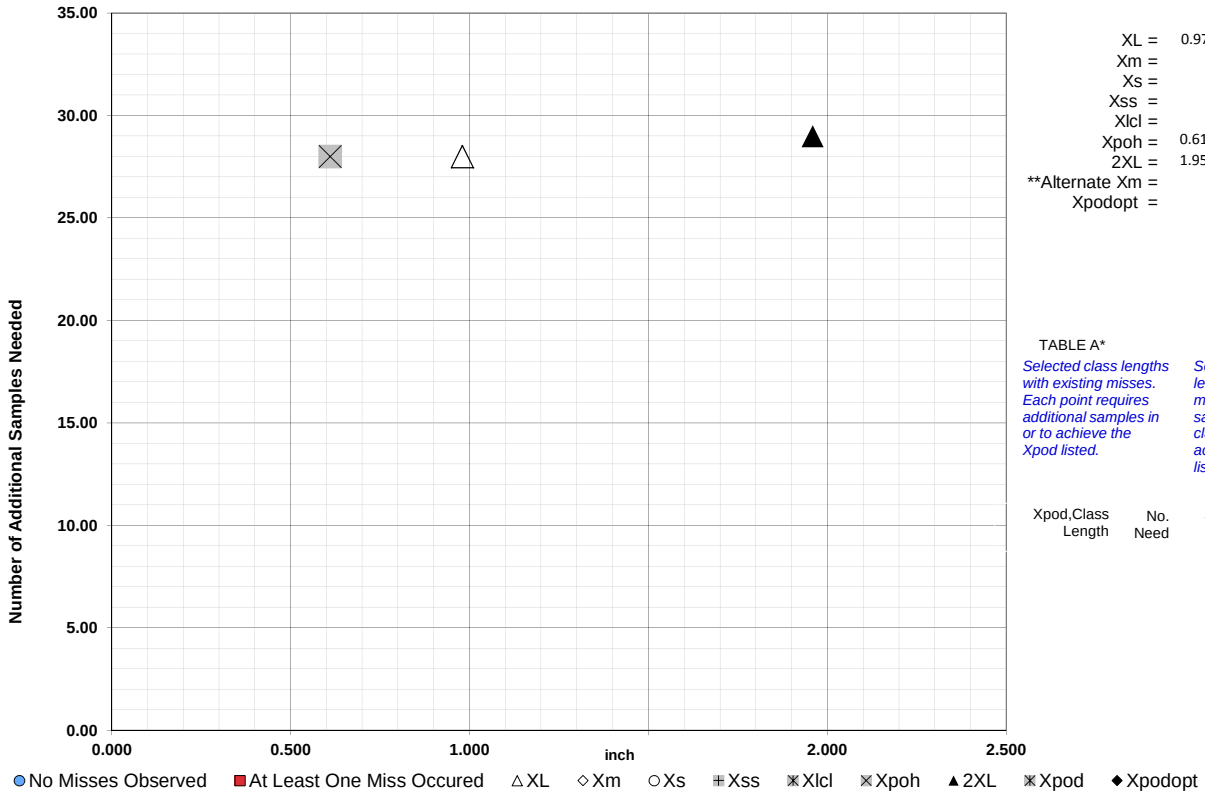



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.610 | 28 |
| 2XL = | 1.958 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

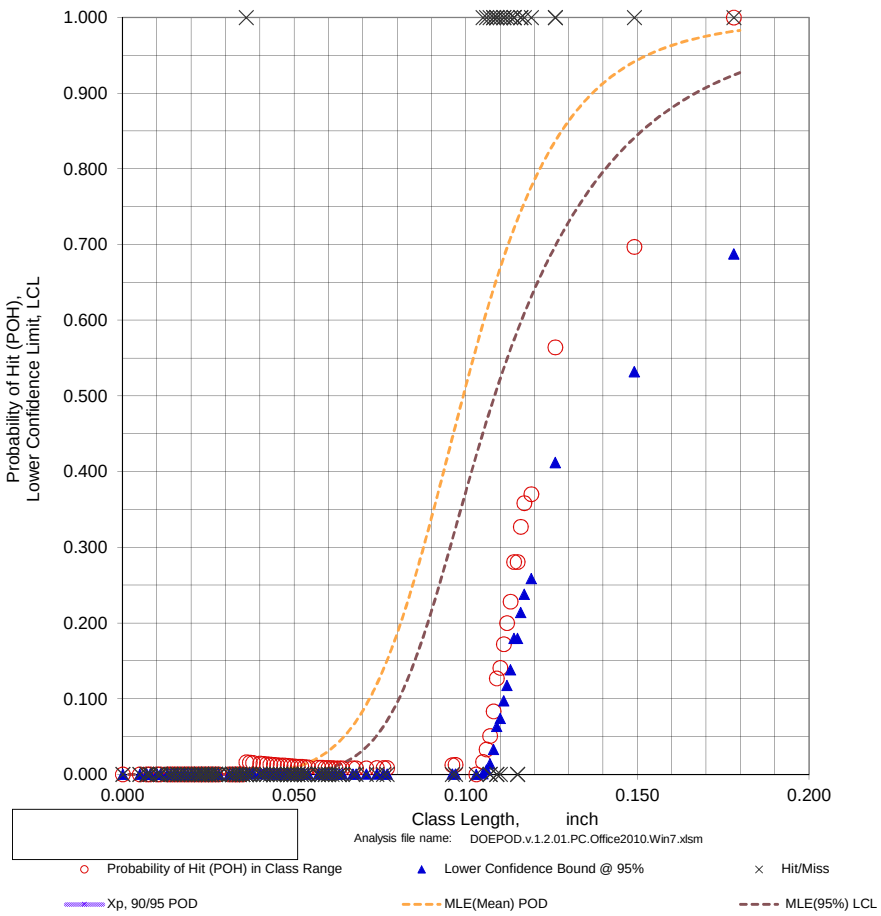
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F122O1BD.XLS
Data Set Name = F122O1BD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:52 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6877 | |
| Classwidth @ Best LCL = | 0.0620 | inch |
| Classlength @ Best LCL = | 0.1780 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1170 -0.001 inch 26 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.913 | @ | 0.140 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.170 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 21 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.178 | inch |
| Samples Needed @ Xlcl = | 21 | |
| POH Classlength, Xpoh = | 0.178 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12201BD.XLS
Data Set Name = F12201BD(CRACK #)

## Directed DOE Options

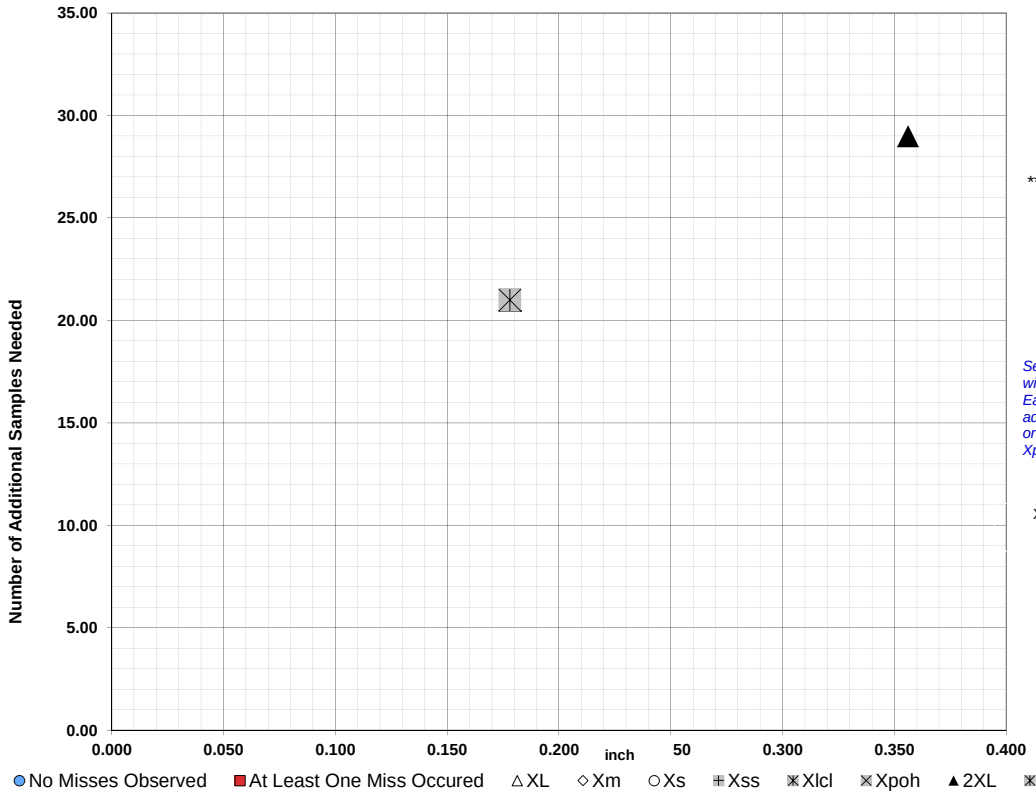



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 21 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.178 | 21 |
| Xpoh = | 0.178 | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

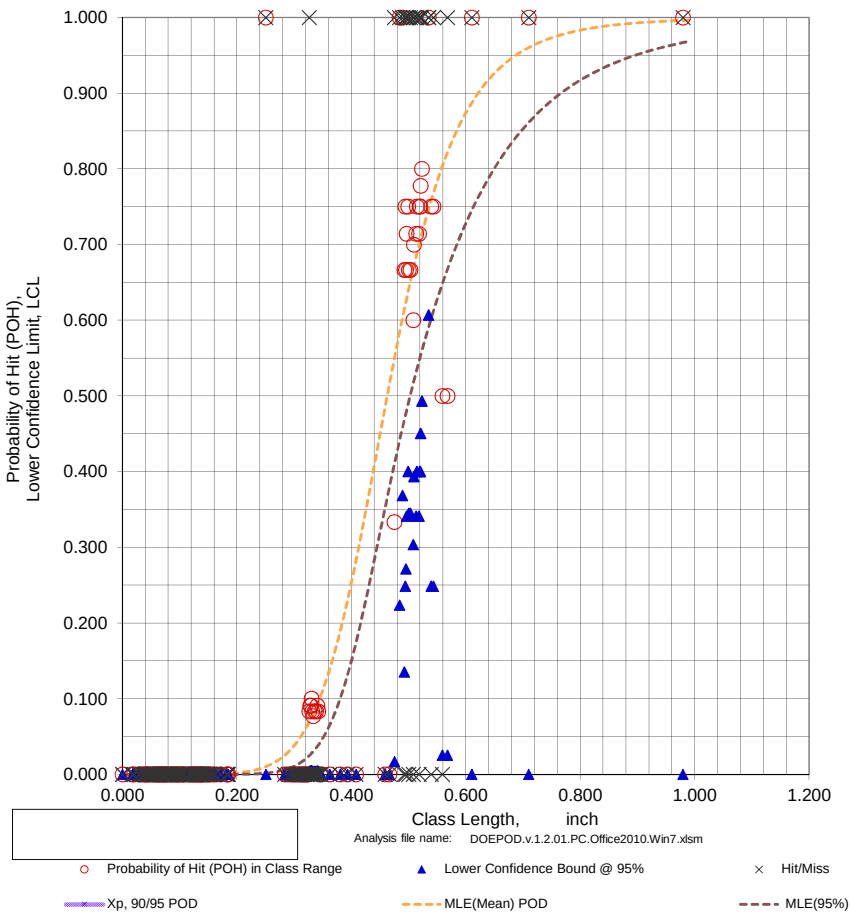
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12201BL.XLS
Data Set Name = F12201BL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:53 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0160 | inch |
| Classlength @ Best LCL = | 0.5350 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.5680 -0.008 inch 28 Samples

NTIAC 90% POD = 0.904 @ 0.625 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.610 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.958 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12201BL.XLS
Data Set Name = F12201BL(CRACK #)

## Directed DOE Options

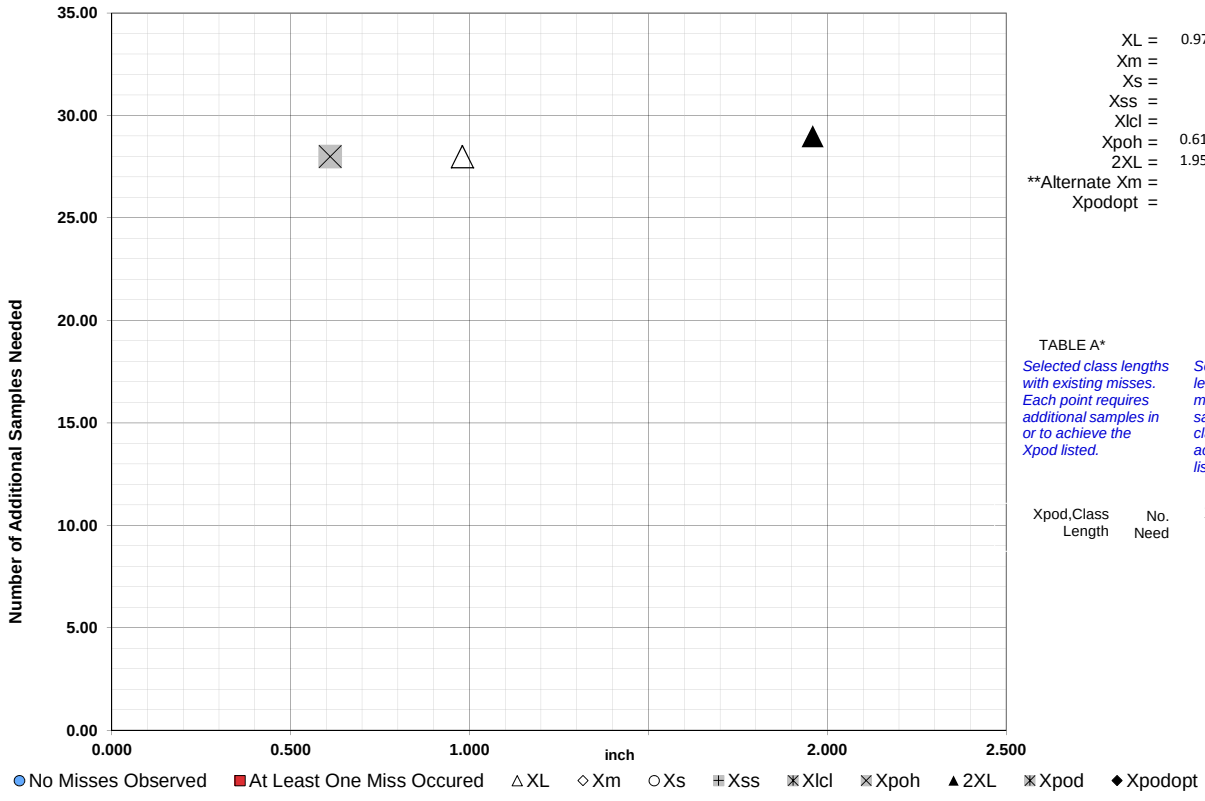



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.610 | 28 |
| 2XL = | 1.958 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

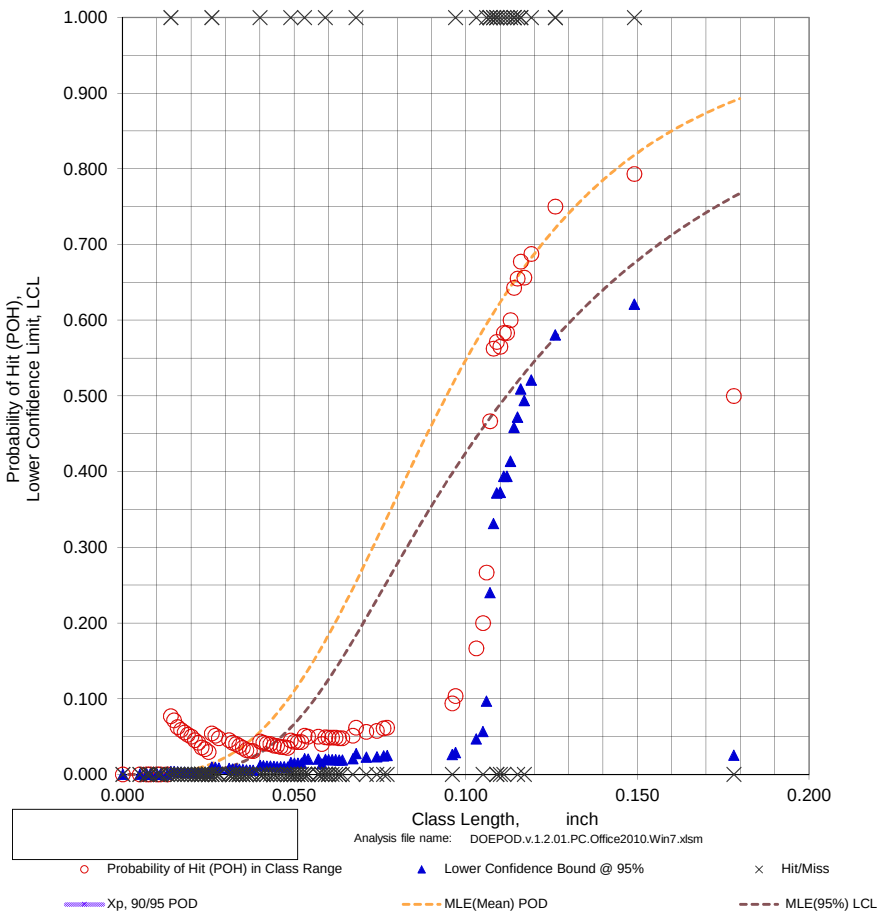
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12201CD.XLS
Data Set Name = F12201CD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:55 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6212 | |
| Classwidth @ Best LCL = | 0.0430 | inch |
| Classlength @ Best LCL = | 0.1490 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.902 @ 0.185 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12201CD.XLS
Data Set Name = F12201CD(CRACK #)

## Directed DOE Options

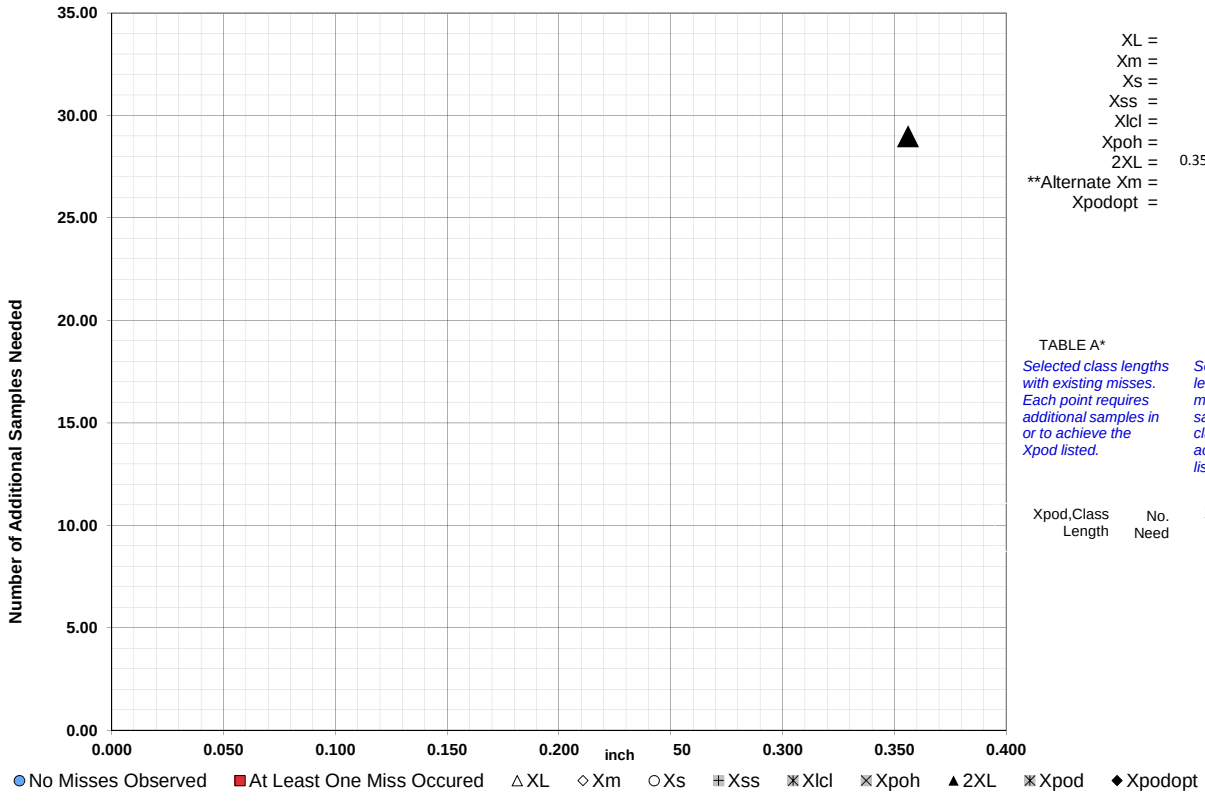



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

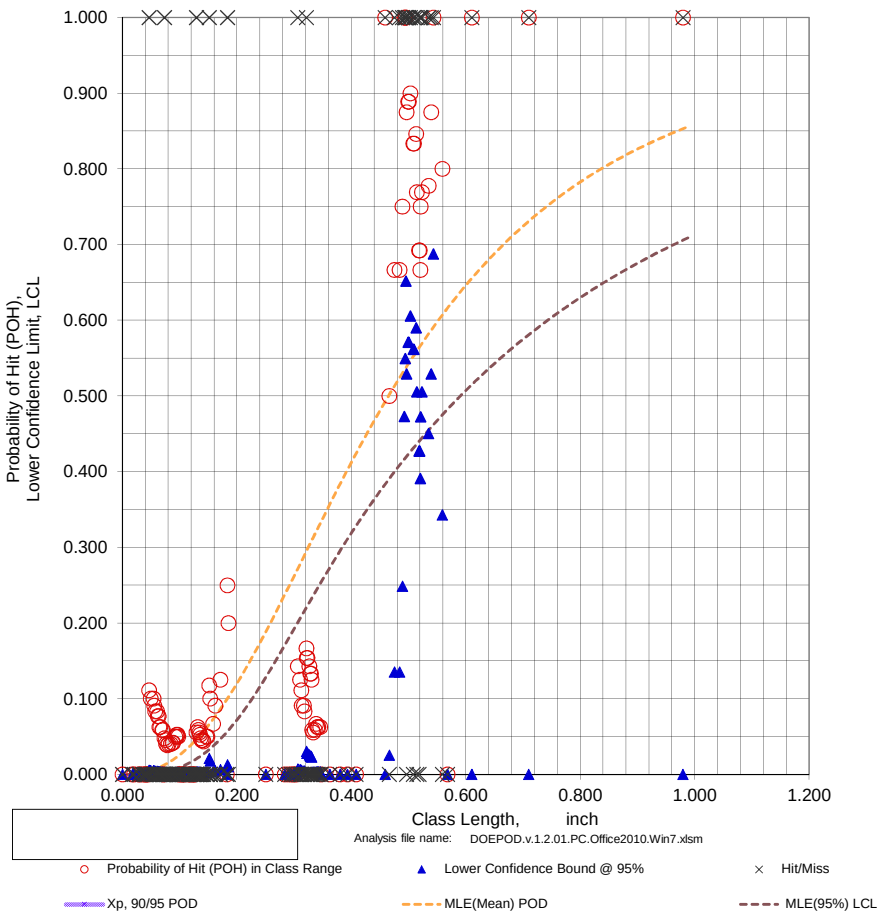
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12201CL.XLS
Data Set Name = F12201CL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:56 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6877 | |
| Classwidth @ Best LCL = | 0.0240 | inch |
| Classlength @ Best LCL = | 0.5430 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.6100 -0.041 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.610 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.958 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12201CL.XLS
Data Set Name = F12201CL(CRACK #)

## Directed DOE Options

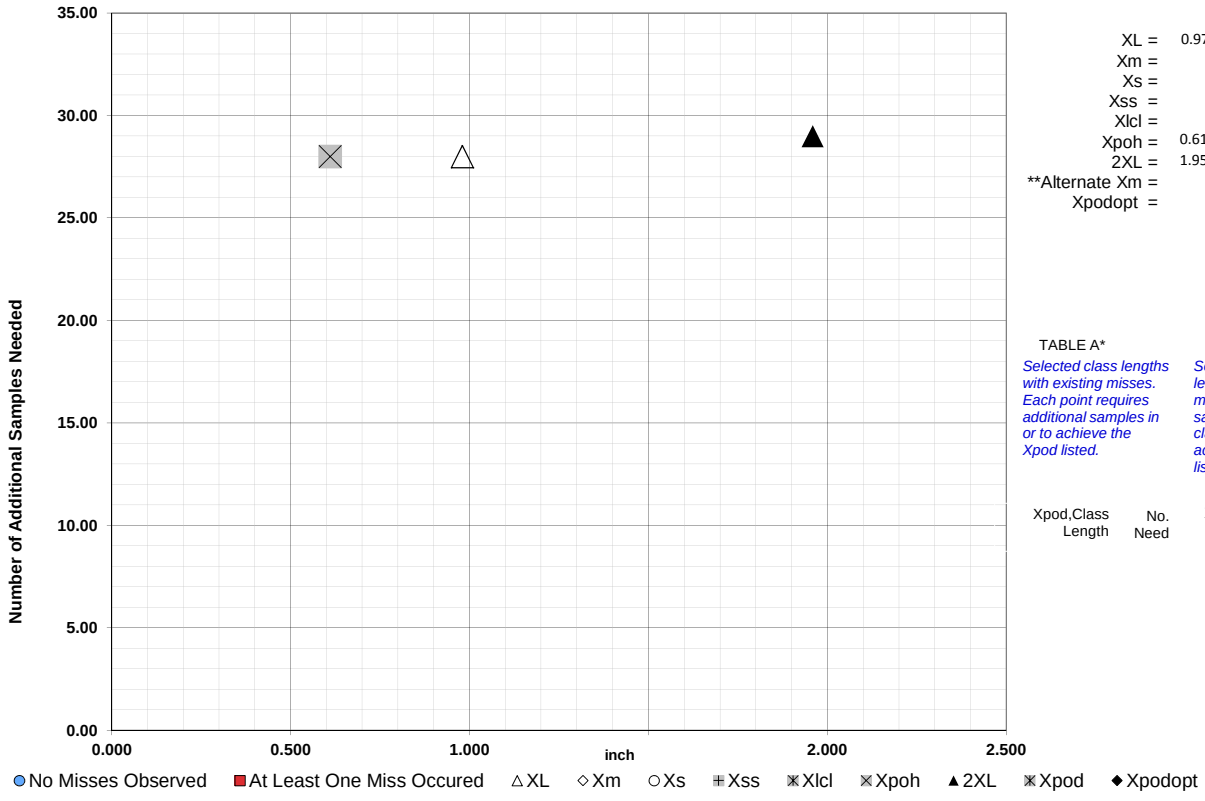



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.610 | 28 |
| 2XL = | 1.958 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

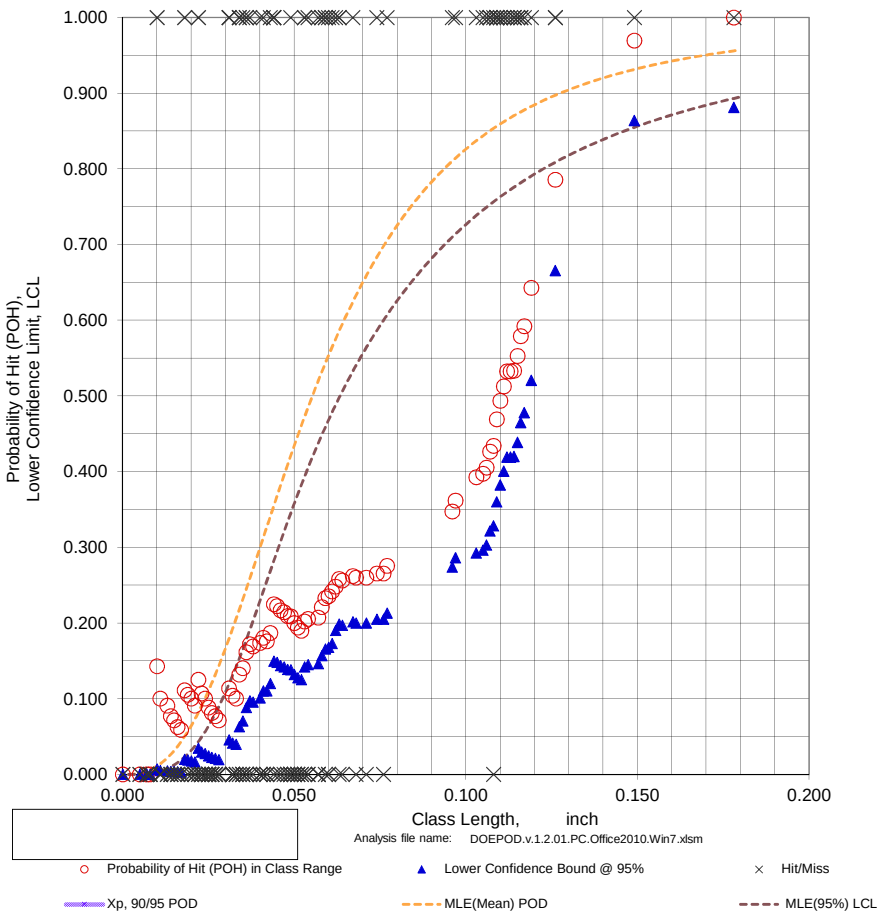
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12202AD.XLS
Data Set Name = F12202AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:58 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.0690 | inch |
| Classlength @ Best LCL = | 0.1780 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1100 -0.001 inch 22 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.130 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.185 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 5 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.178 | inch |
| Samples Needed @ Xlcl = | 5 | |
| POH Classlength, Xpoh = | 0.178 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12202AD.XLS
Data Set Name = F12202AD(CRACK #)

## Directed DOE Options

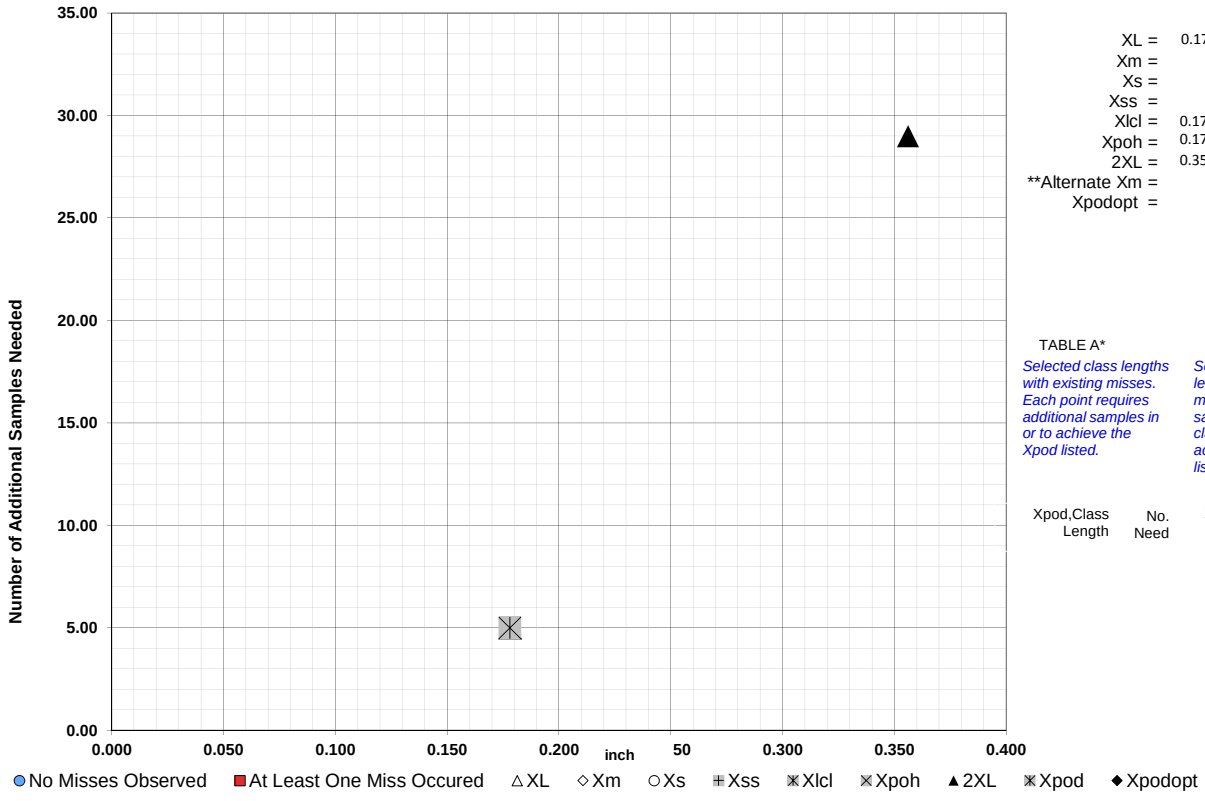



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 5 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.178 | 5 |
| Xpoh = | 0.178 | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

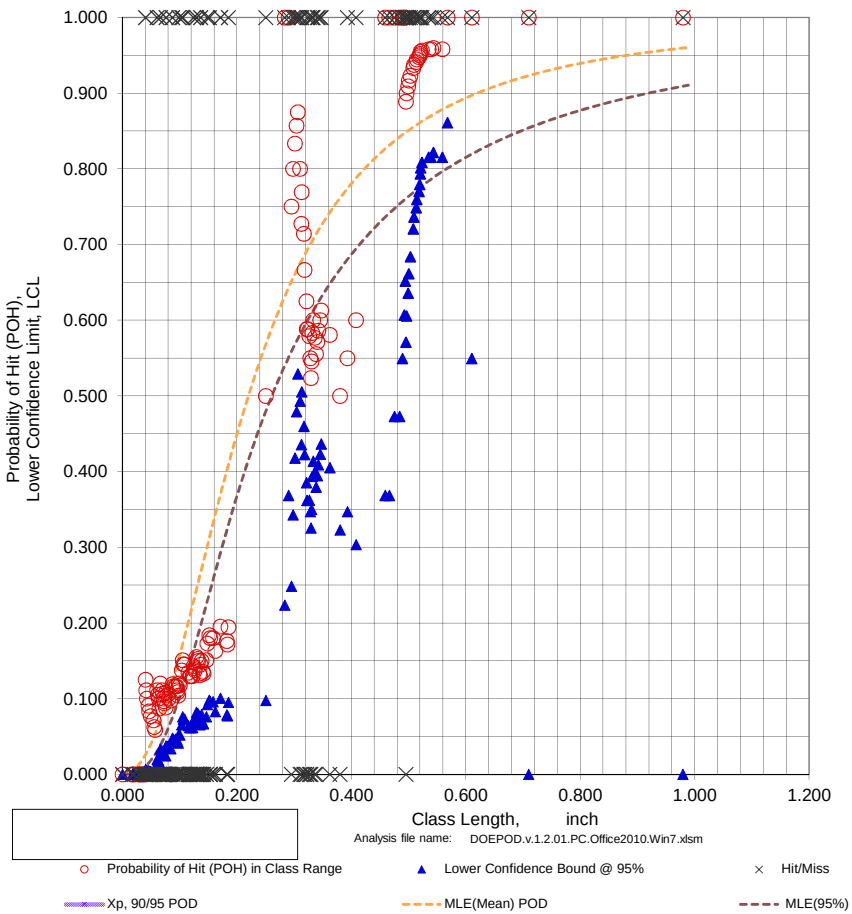
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12202AL.XLS
Data Set Name = F12202AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 3:59 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8609 | |
| Classwidth @ Best LCL = | 0.0720 | inch |
| Classlength @ Best LCL = | 0.5680 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.4990 -0.003 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.620 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.568 | inch |
| Samples Needed @ Xlcl = | 9 | |
| POH Classlength, Xpoh = | 0.568 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12202AL.XLS
Data Set Name = F12202AL(CRACK #)

## Directed DOE Options

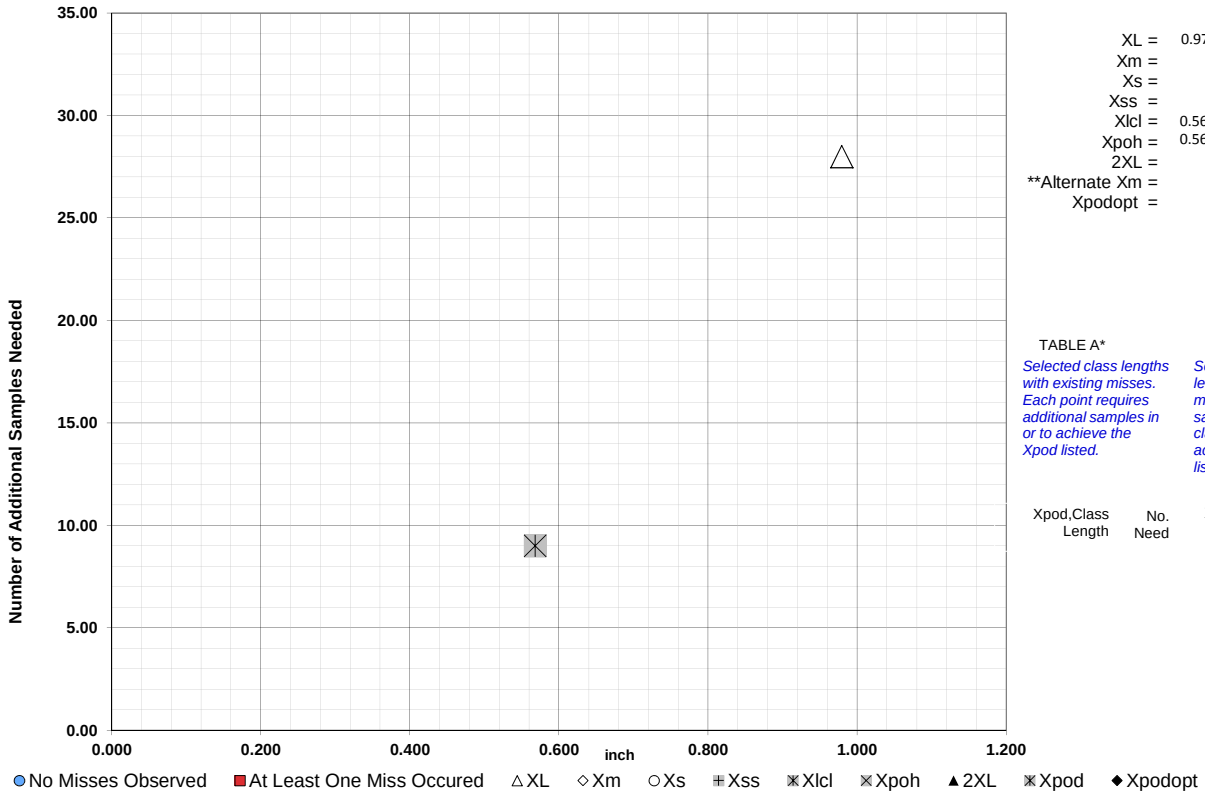



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.568 | 9 |
| Xpoh = | 0.568 | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

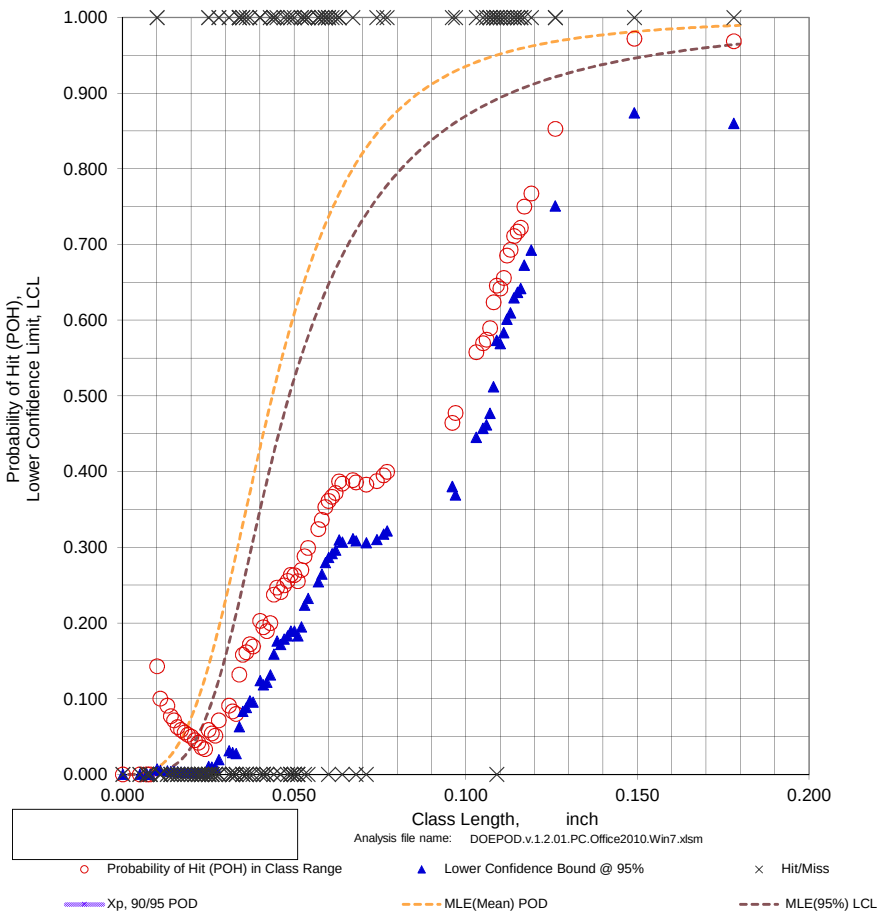
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12202BD.XLS
Data Set Name = F12202BD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:01 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8739 | |
| Classwidth @ Best LCL = | 0.0750 | inch |
| Classlength @ Best LCL = | 0.1490 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.1110 -0.001 inch 25 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.090 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.115 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12202BD.XLS
Data Set Name = F12202BD(CRACK #)

## Directed DOE Options

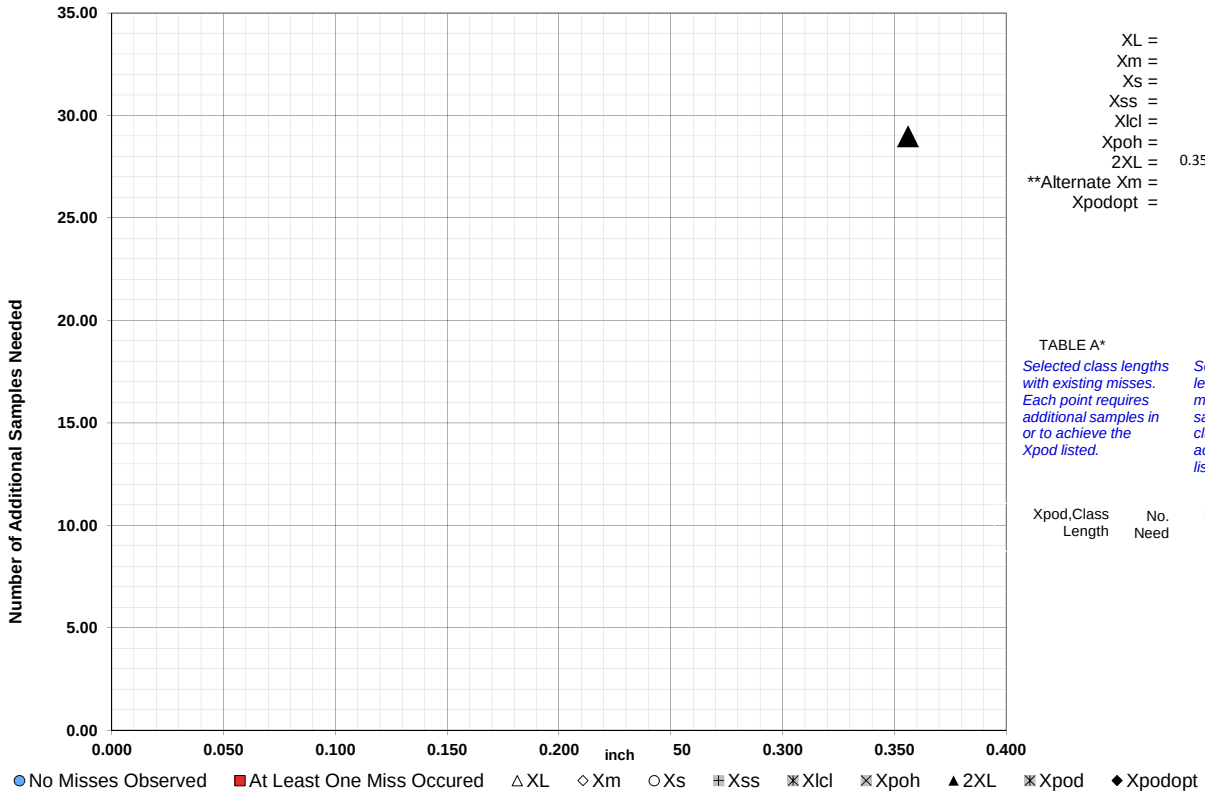



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

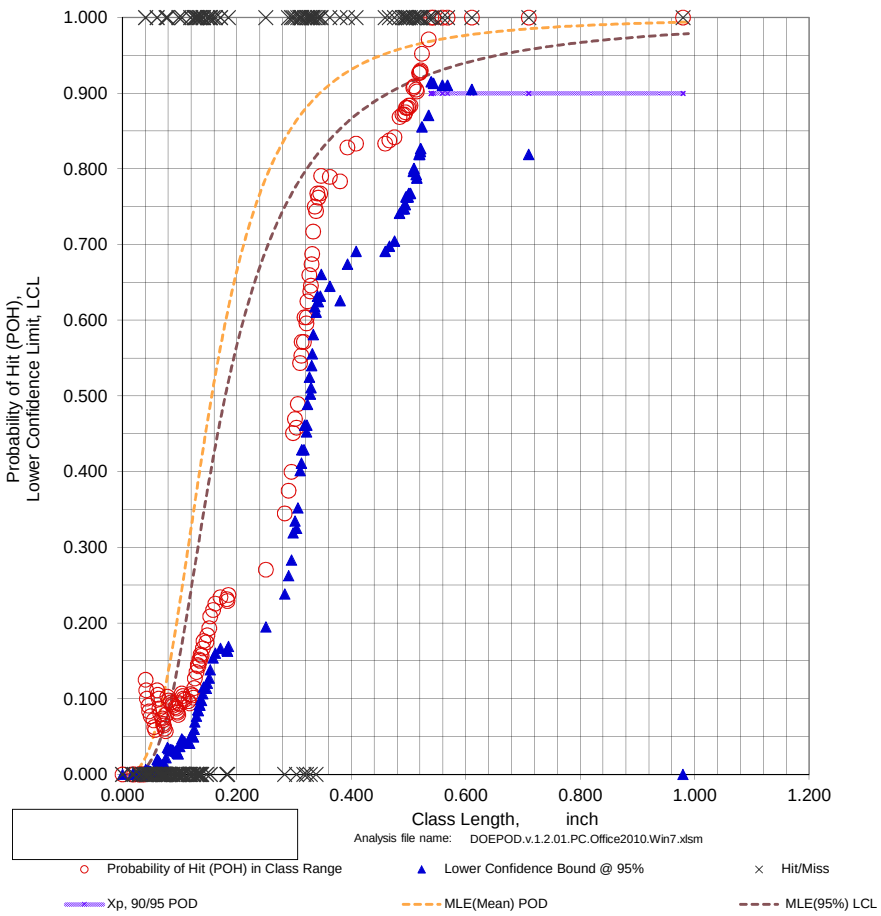
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.617.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F12202BL.XLS**

Data Set Name = **F12202BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:02 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.5390 | inch |
| Lower Confidence Bound = | 0.9152 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.3400 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.345 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.465 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.710 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.537 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.5390 | inch |

File Name = F12202BL.XLS
Data Set Name = F12202BL(CRACK #)

## Directed DOE Options

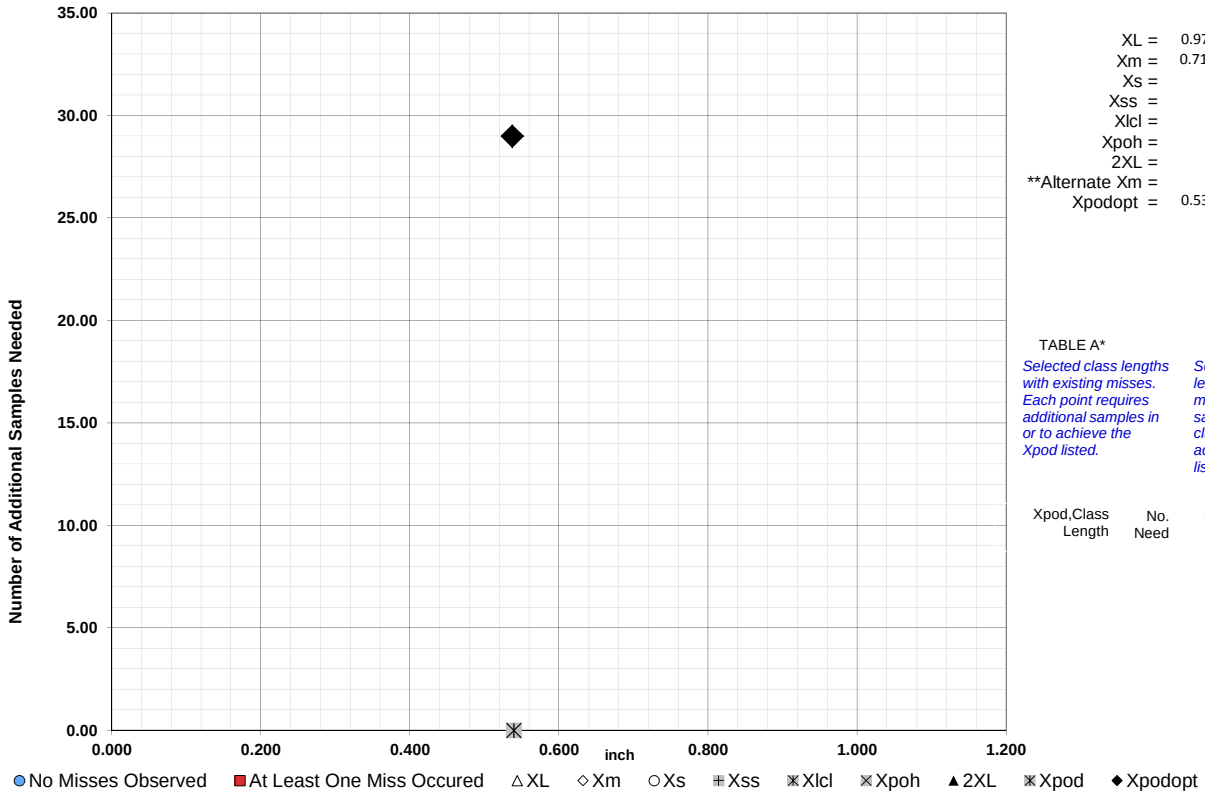



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | |
| Xm = | 0.710 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.537 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

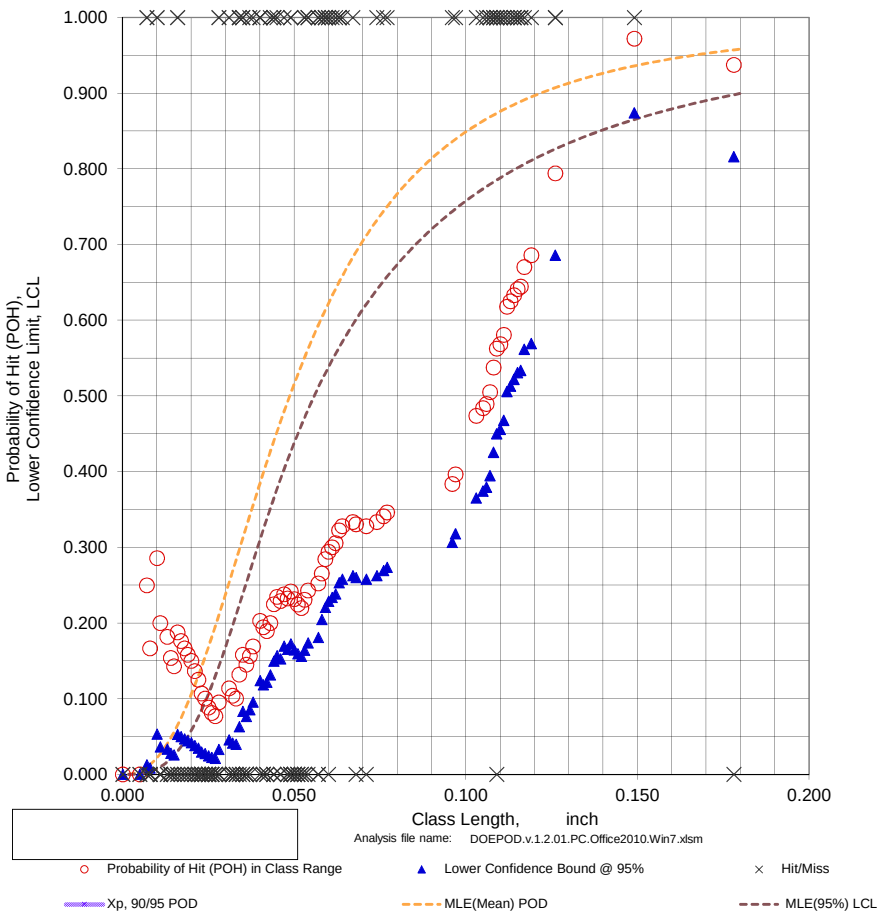
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12202CD.XLS
Data Set Name = F12202CD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:04 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8739 | |
| Classwidth @ Best LCL = | 0.0750 | inch |
| Classlength @ Best LCL = | 0.1490 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.125 | inch |
| NTIAC 90/95 POD = | 0.904 | @ | 0.185 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12202CD.XLS
Data Set Name = F12202CD(CRACK #)

## Directed DOE Options

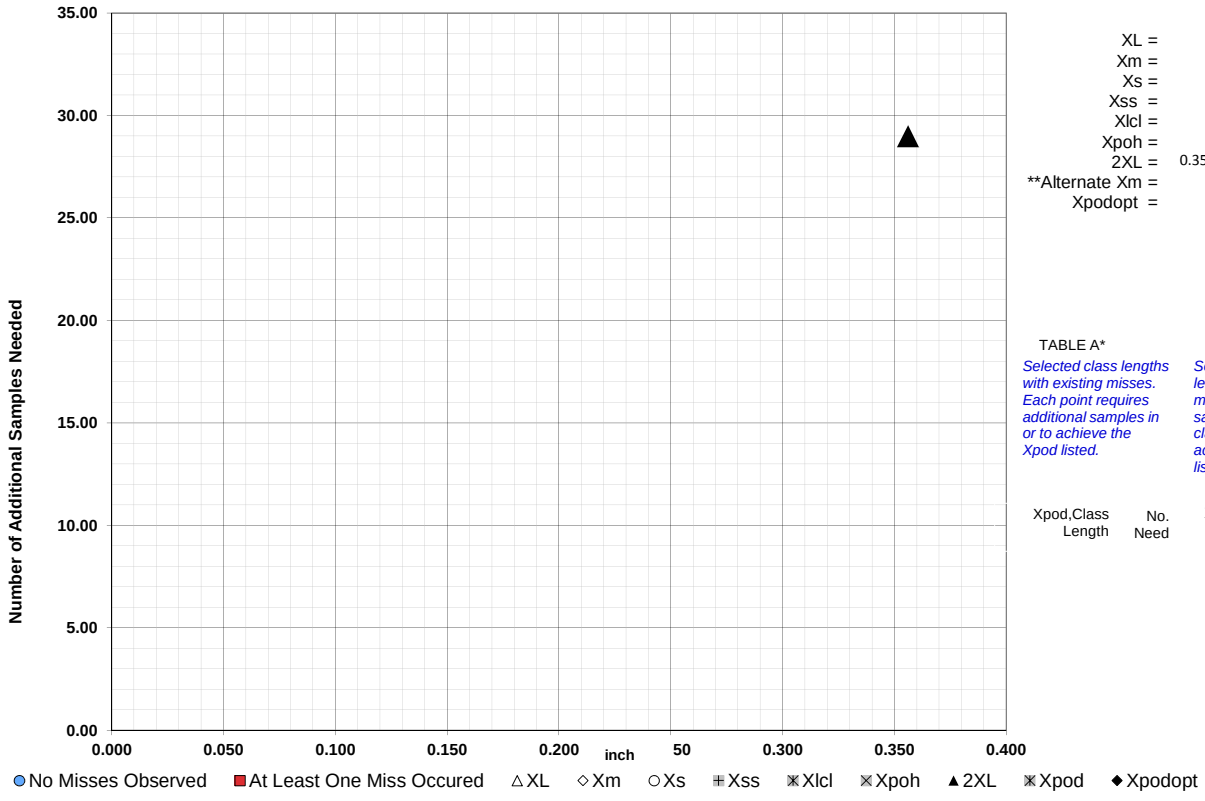



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

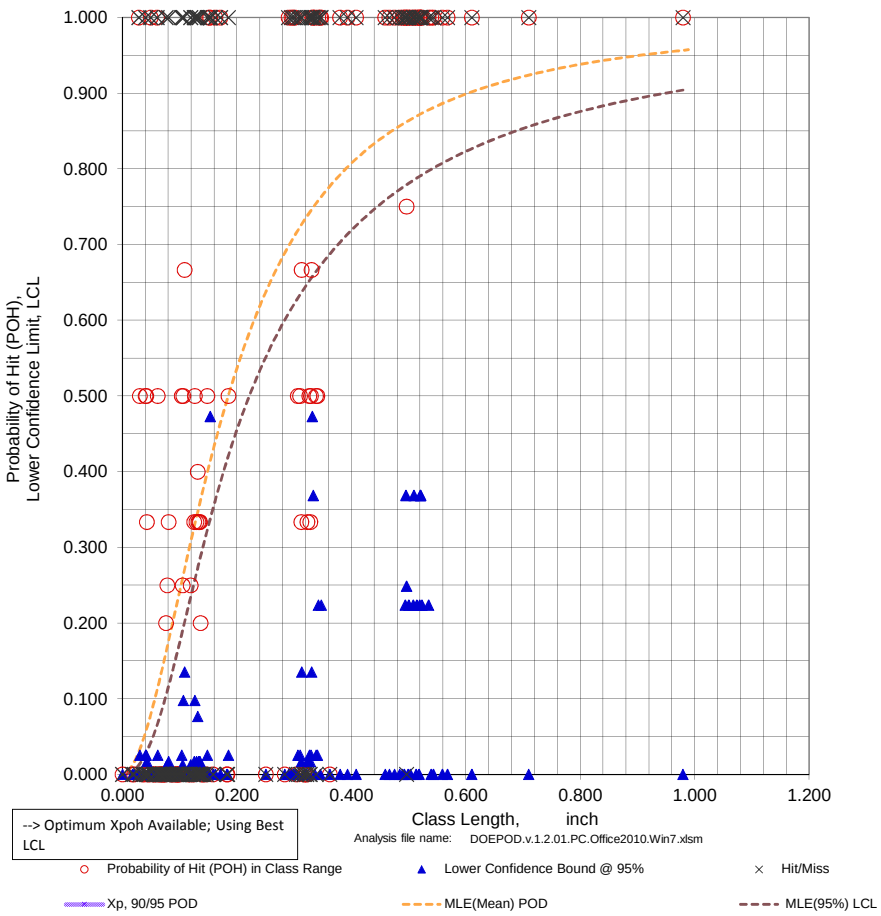
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12202CL.XLS
Data Set Name = F12202CL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:05 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4729 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.1530 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.4990 -0.002 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.605 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.979 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.499 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.958 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12202CL.XLS
Data Set Name = F12202CL(CRACK #)

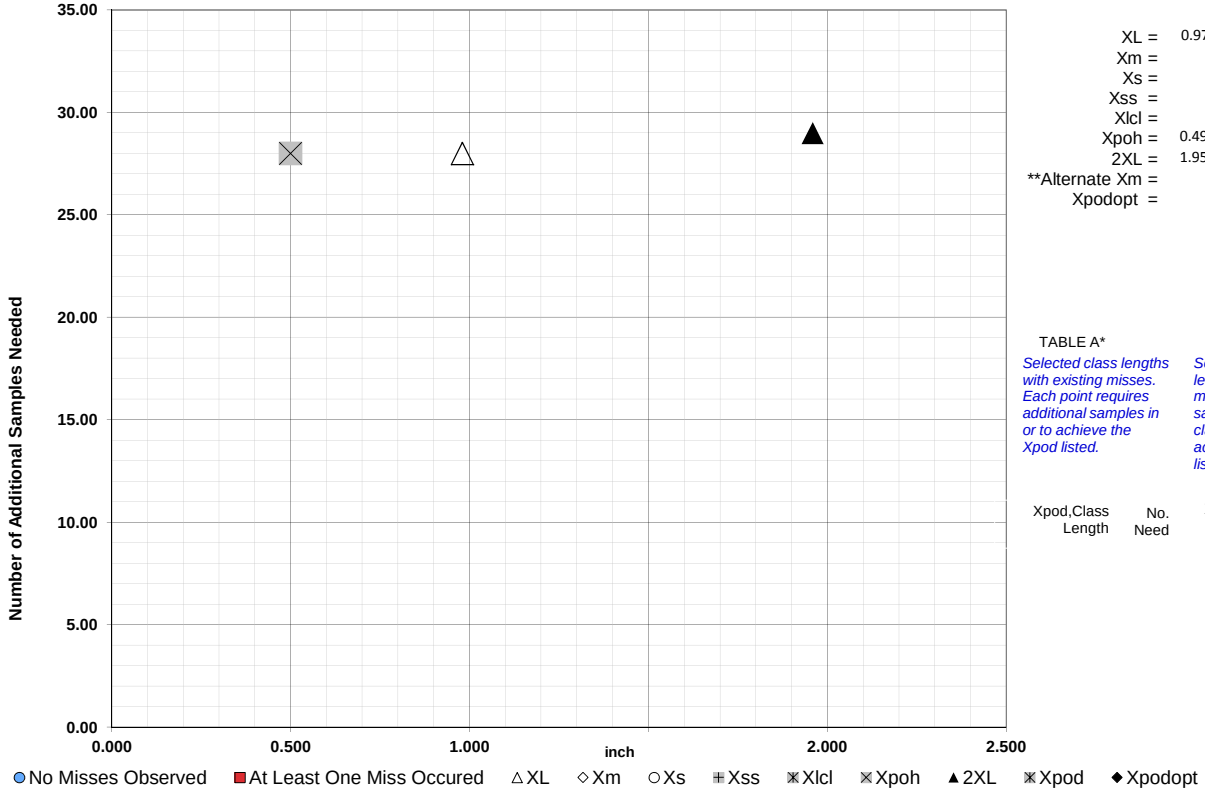



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.979 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.499 | 28 |
| 2XL = | 1.958 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

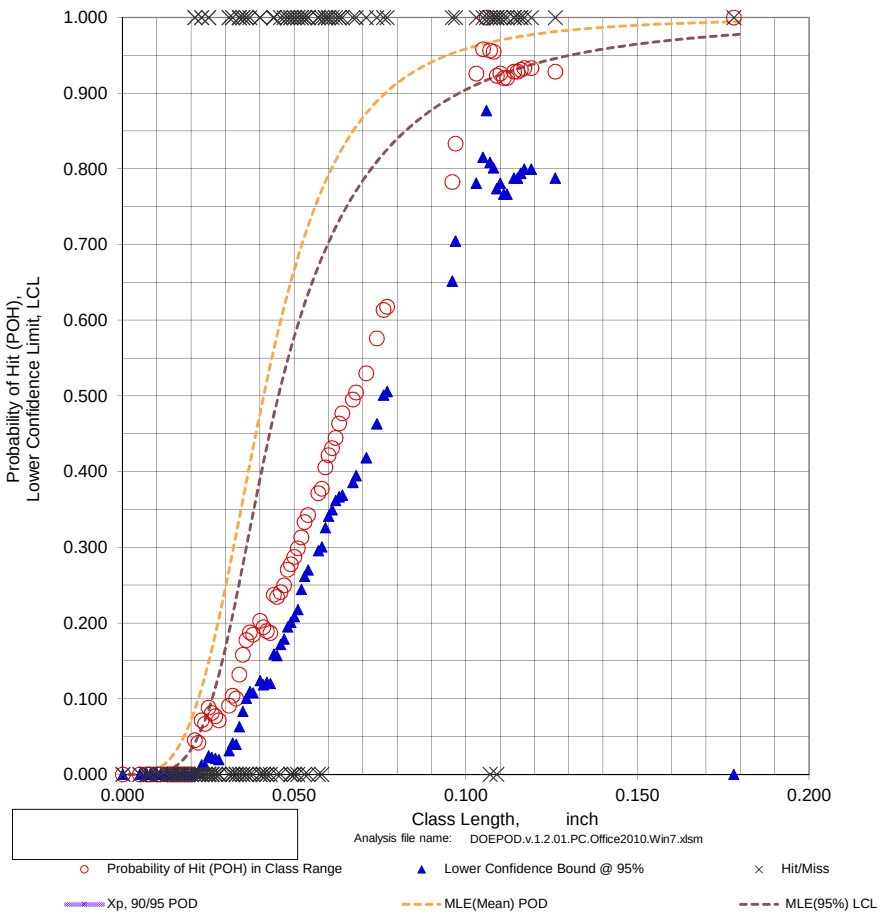
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12203AD.XLS
Data Set Name = F12203AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:07 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8768 | |
| Classwidth @ Best LCL = | 0.0470 | inch |
| Classlength @ Best LCL = | 0.1060 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1110 -0.001 inch 26 Samples

NTIAC 90% POD = 0.913 @ 0.080 inch
NTIAC 90/95 POD = 0.905 @ 0.100 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.178 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12203AD.XLS
Data Set Name = F12203AD(CRACK #)

## Directed DOE Options

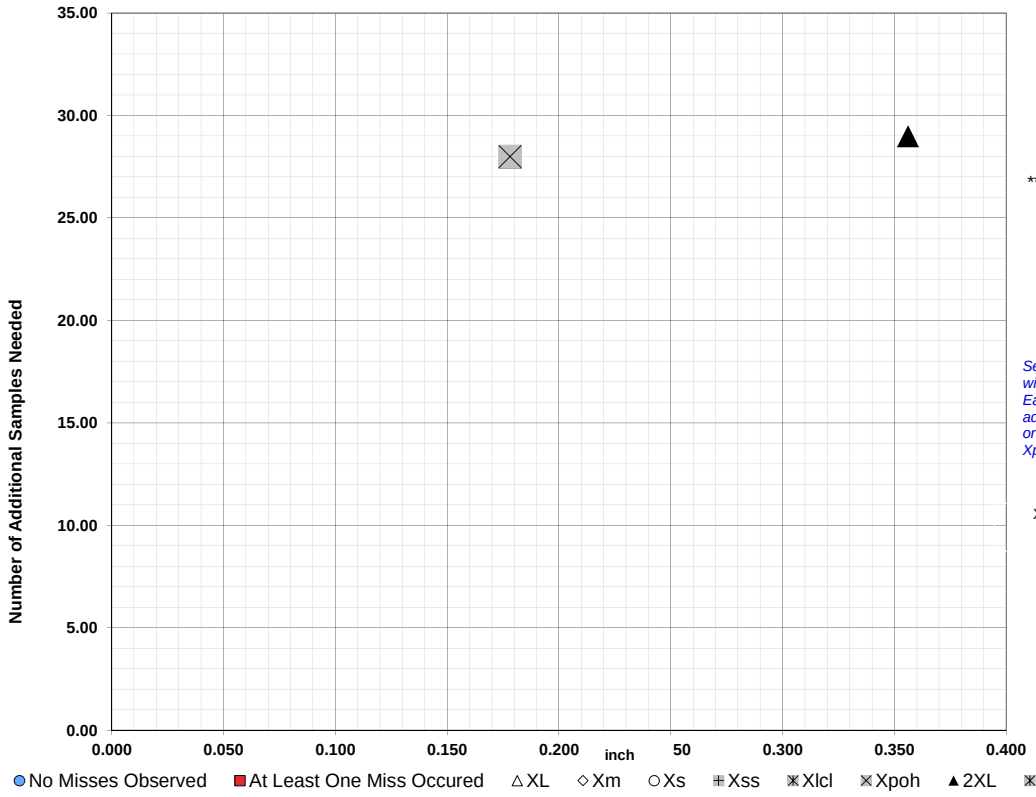



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.178 | 28 |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

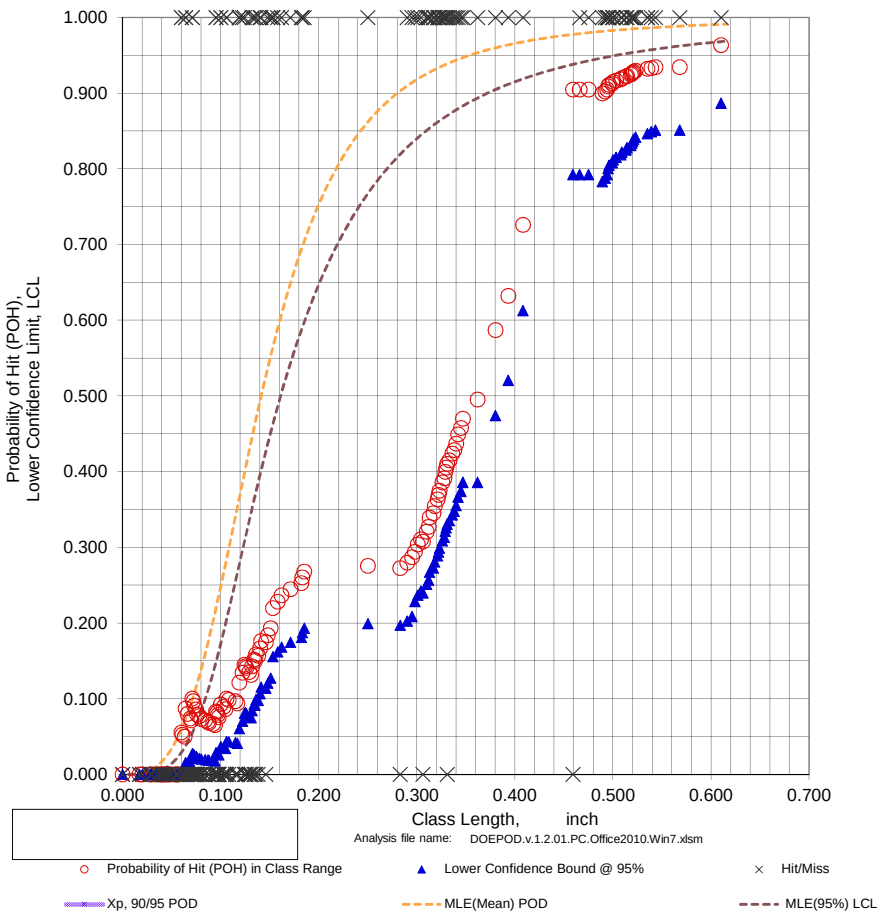
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12203AL.XLS
Data Set Name = F12203AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:08 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8868 | |
| Classwidth @ Best LCL = | 0.3000 | inch |
| Classlength @ Best LCL = | 0.6100 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.4660 -0.006 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.285 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.375 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.220 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12203AL.XLS
Data Set Name = F12203AL(CRACK #)

## Directed DOE Options

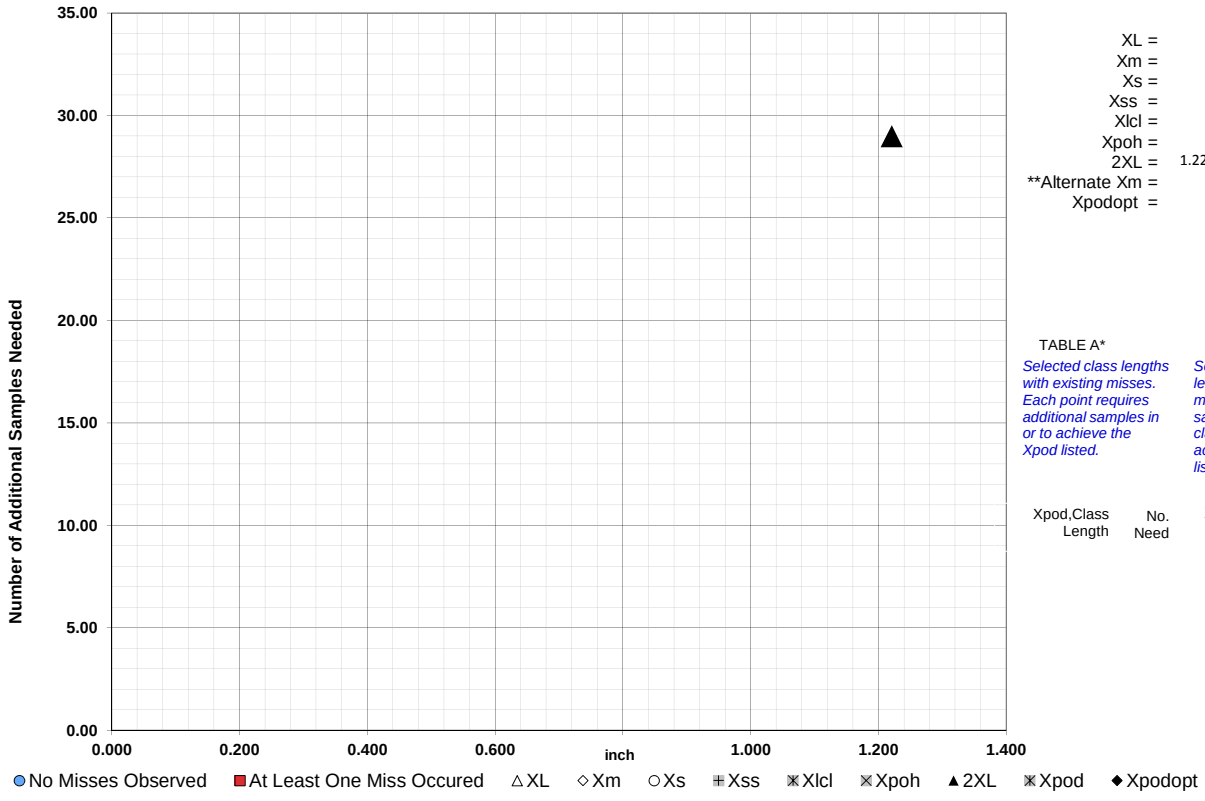



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.220 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

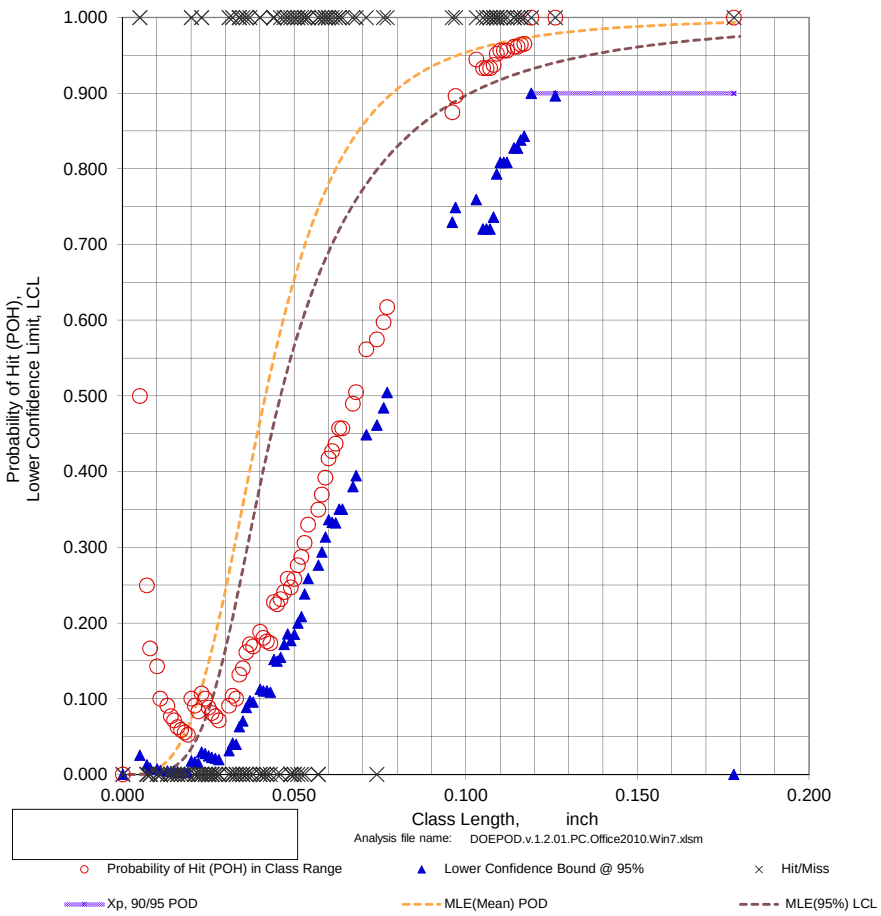
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.357.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F12203BD.XLS**

Data Set Name = **F12203BD(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:10 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0430 | inch |
| Classlength @ 90/95 Xpod = | 0.1190 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL when Xm is satisfied. Xp used to satisfy XL requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0760 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.906 | @ | 0.080 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.105 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.149 | inch |
| Samples Needed @ Xm = | 29 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.118 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.1190 | inch |

File Name = F12203BD.XLS
Data Set Name = F12203BD(CRACK #)

## Directed DOE Options

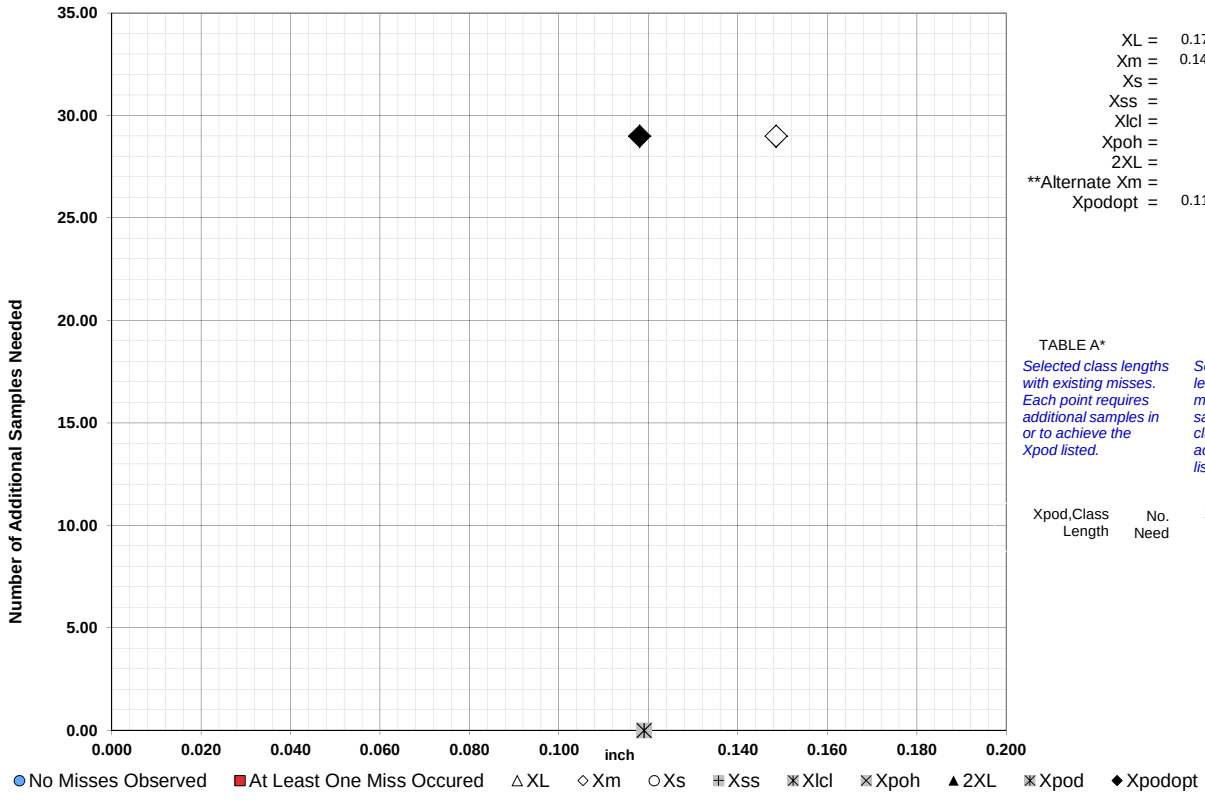



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | |
| Xm = | 0.149 | 29 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.118 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

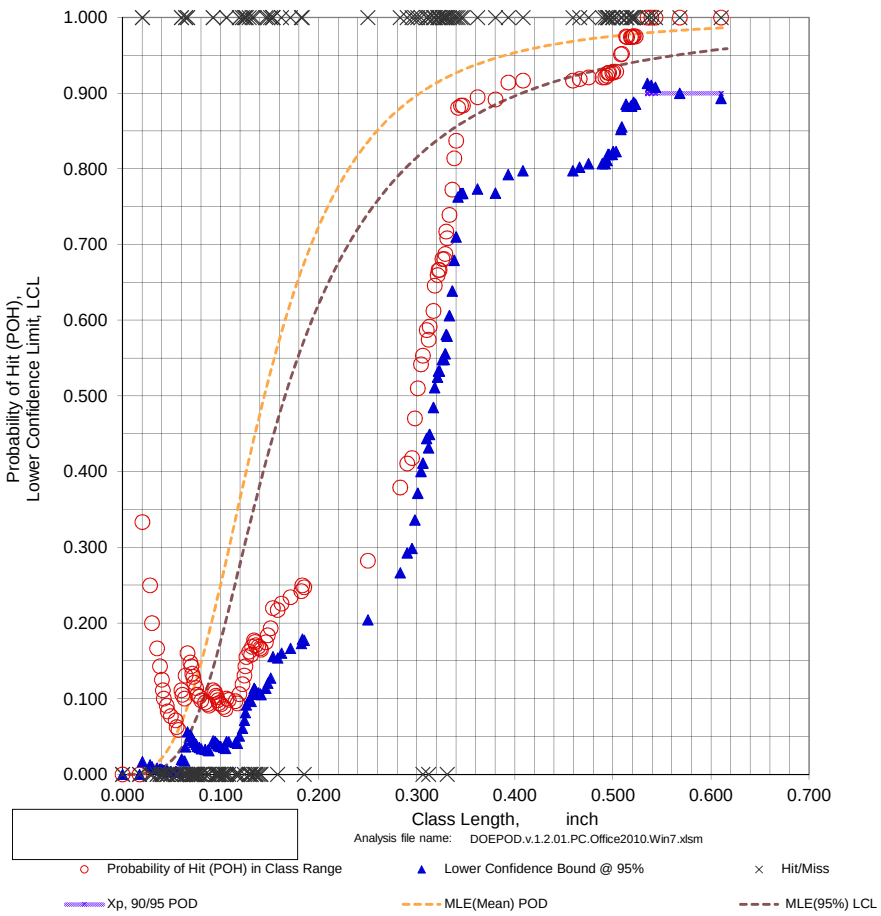
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.605.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F12203BL.XLS**

Data Set Name = **F12203BL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:11 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.5350 | inch |
| Lower Confidence Bound = | 0.9129 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.3330 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.305 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.410 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.568 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.529 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.5350 | inch |

File Name = F12203BL.XLS
Data Set Name = F12203BL(CRACK #)

## Directed DOE Options

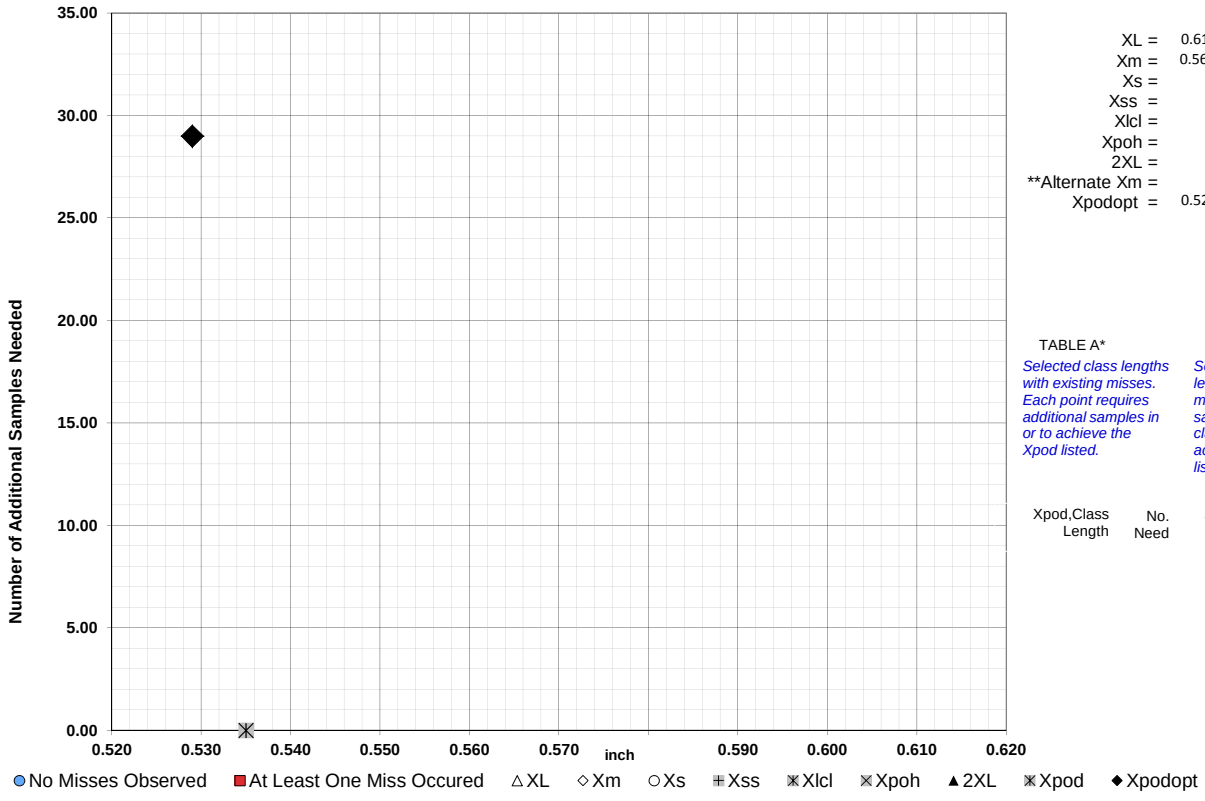



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.610 | |
| Xm = | 0.568 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.529 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

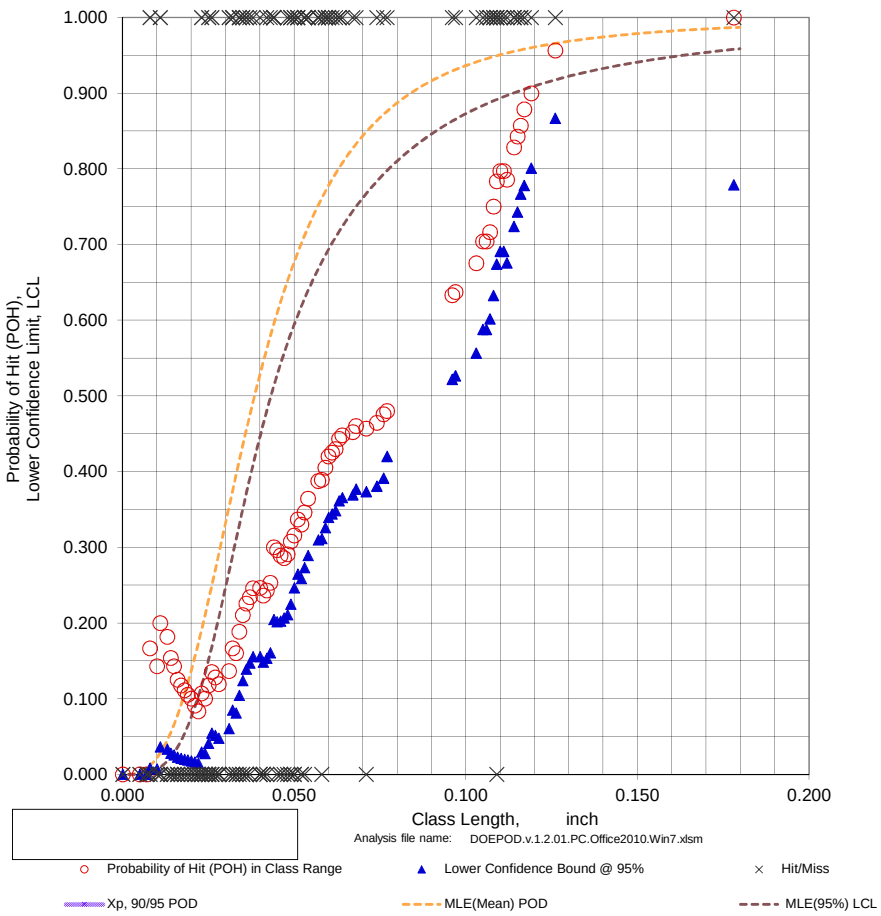
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F12203CD.XLS
Data Set Name = F12203CD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:12 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8668 | |
| Classwidth @ Best LCL = | 0.0670 | inch |
| Classlength @ Best LCL = | 0.1260 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1110 -0.001 inch 26 Samples

NTIAC 90% POD = 0.923 @ 0.055 inch
NTIAC 90/95 POD = 0.929 @ 0.065 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 17 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.178 | inch |
| Samples Needed @ Xpoh = | 17 | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F12203CD.XLS
Data Set Name = F12203CD(CRACK #)

## Directed DOE Options

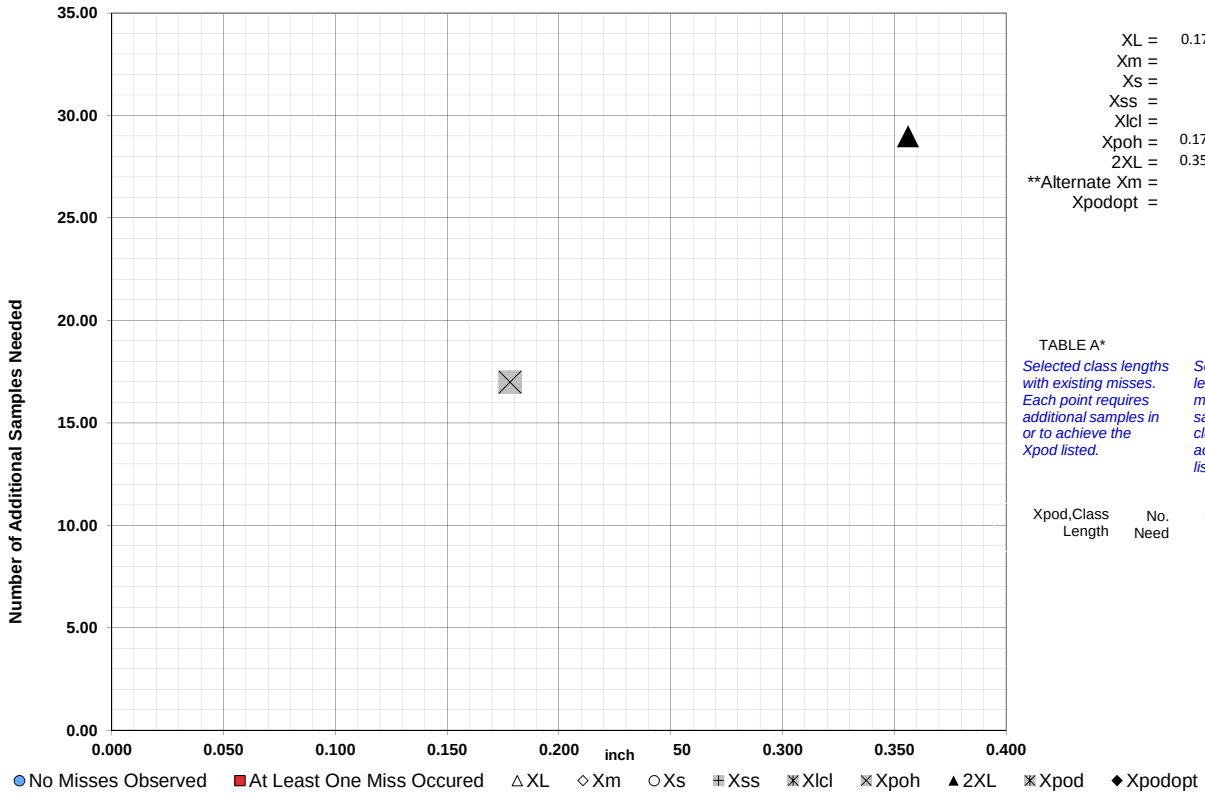



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 17 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.178 | 17 |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

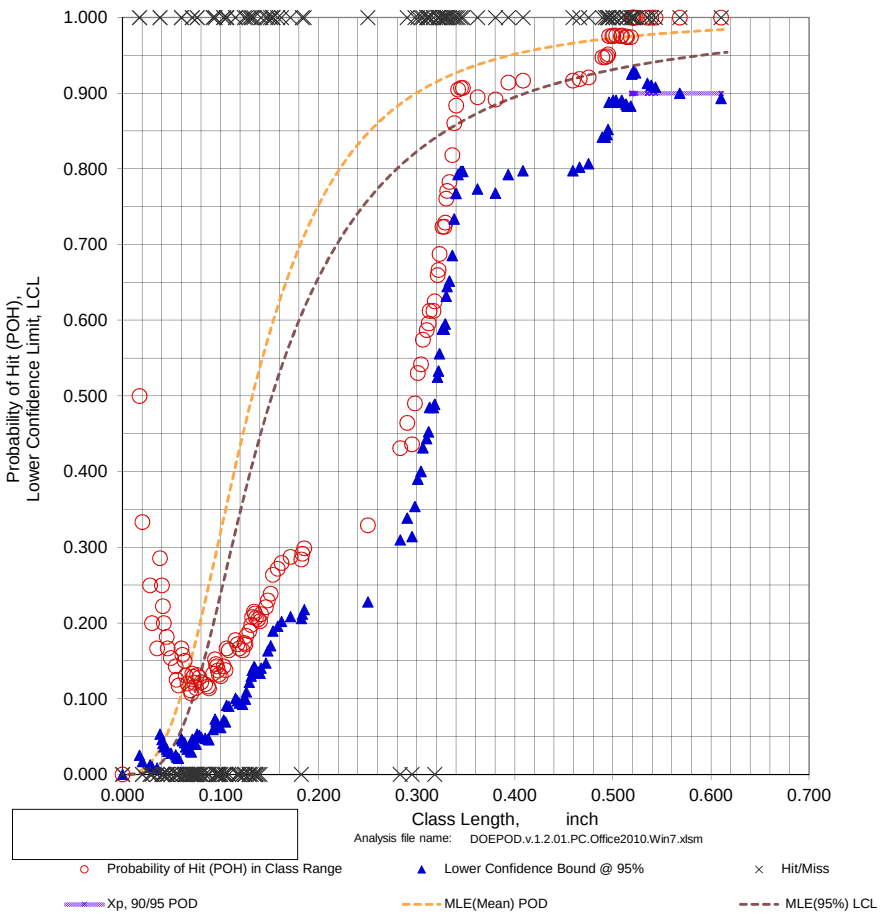
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 1.557.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **F12203CL.XLS**

Data Set Name = **F12203CL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:14 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.2000 | inch |
| Classlength @ 90/95 Xpod = | 0.5190 | inch |
| Lower Confidence Bound = | 0.9253 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.3210 -0.002 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.300 | inch |
| NTIAC 90/95 POD = | 0.902 | @ | 0.415 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.543 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.519 | inch |
| Samples Needed @Xpodopt = | 29 | |
| Xp = | 0.5190 | inch |

File Name = F12203CL.XLS
Data Set Name = F12203CL(CRACK #)

## Directed DOE Options

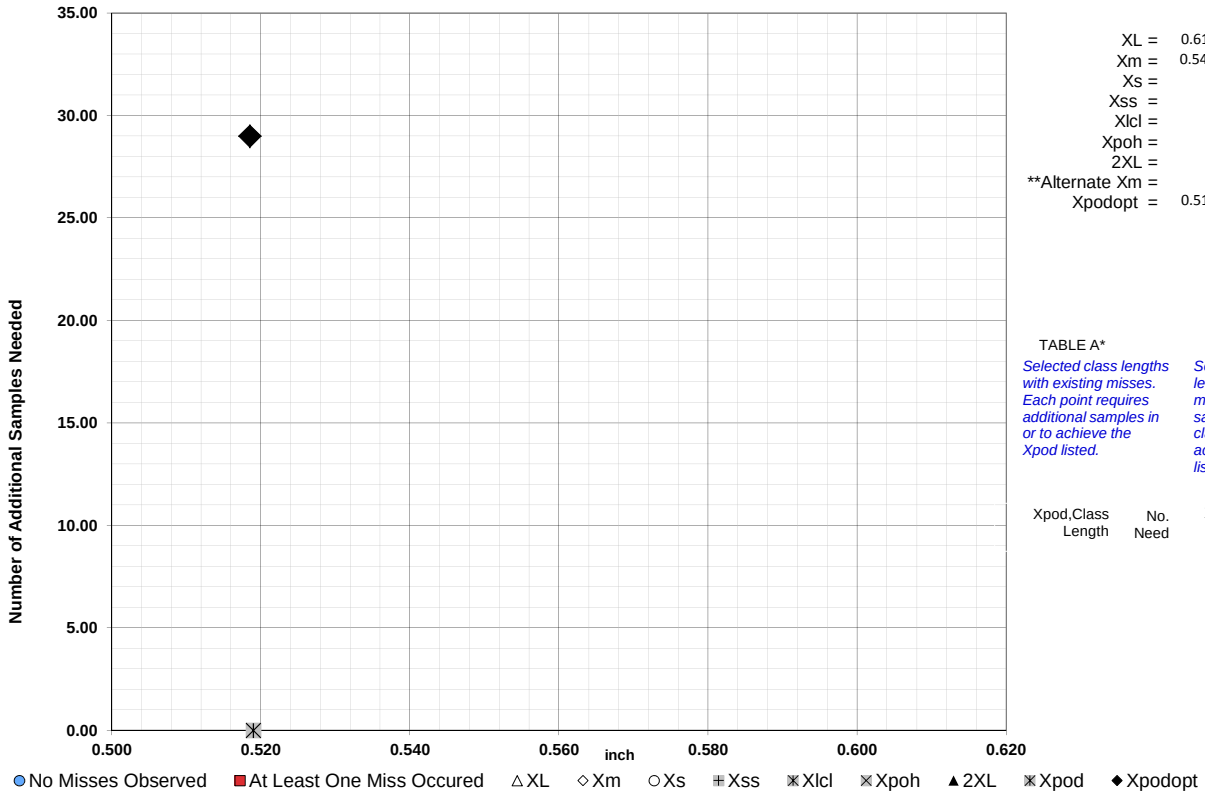



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.610 | |
| Xm = | 0.543 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.519 | 29 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

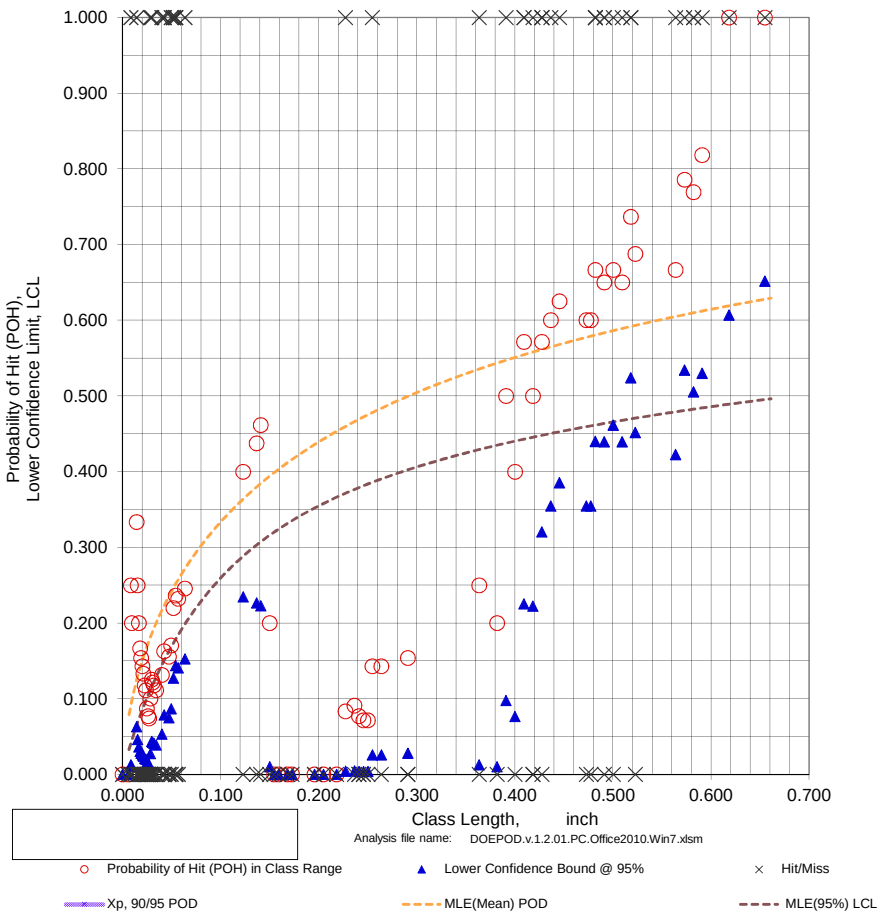
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20002AA.XLS
Data Set Name = F20002AA(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:16 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6518 | |
| Classwidth @ Best LCL = | 0.0910 | inch |
| Classlength @ Best LCL = | 0.6545 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.5636 -0.040 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.655 | inch |
| Samples Needed @ XL = | 22 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.655 | inch |
| Samples Needed @ Xlcl = | 22 | |
| POH Classlength, Xpoh = | 0.618 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 1.309 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20002AA.XLS
Data Set Name = F20002AA(CRACK #)

## Directed DOE Options

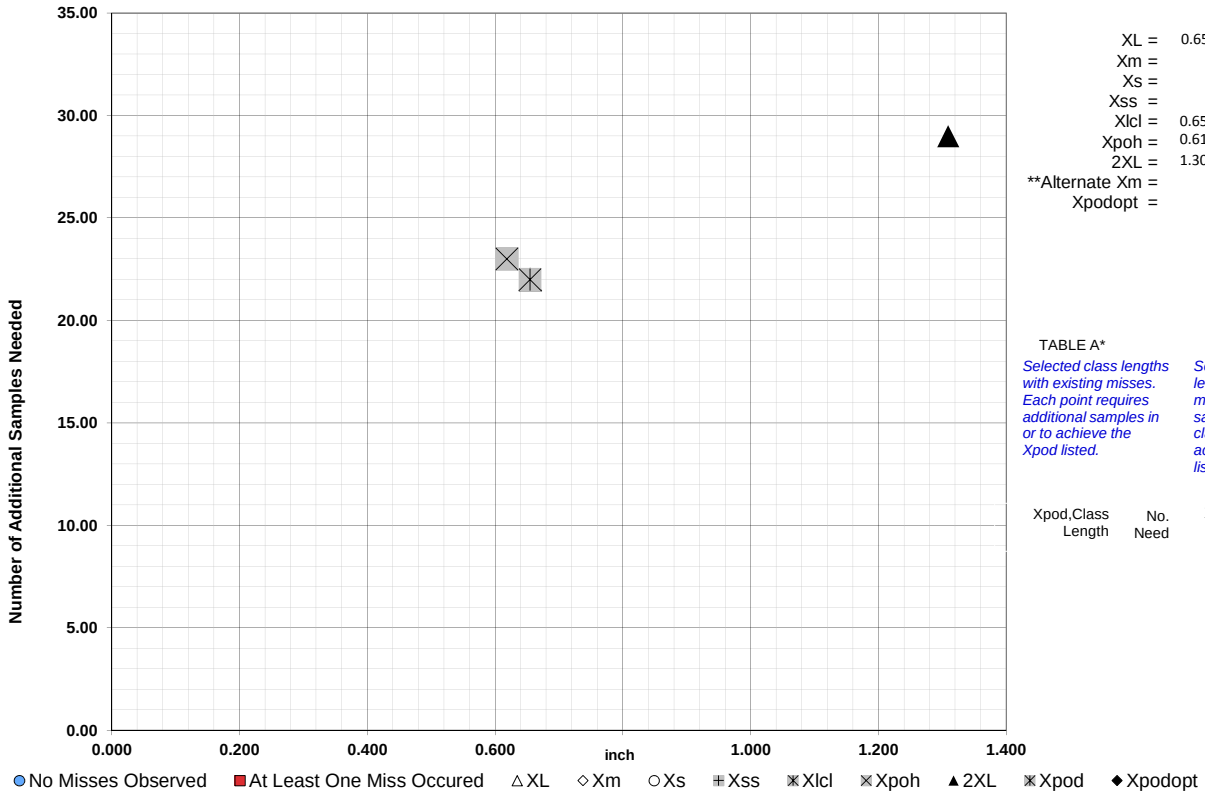



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.655 | 22 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.655 | 22 |
| Xpoh = | 0.618 | 23 |
| 2XL = | 1.309 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

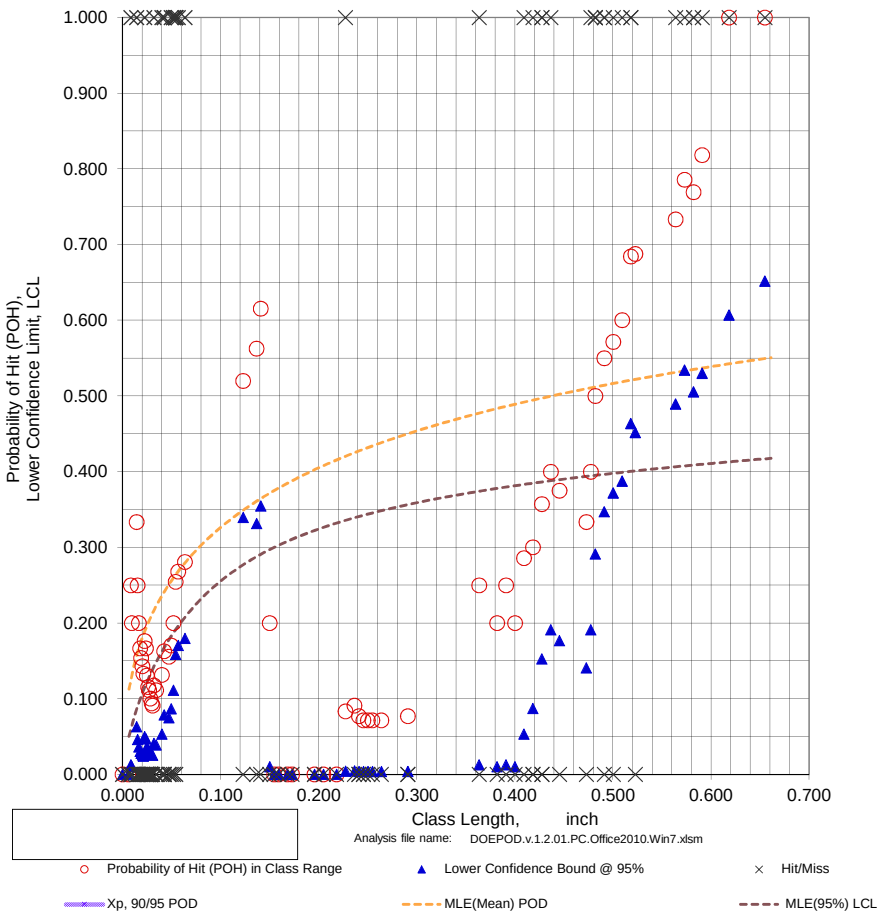
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20002BA.XLS
Data Set Name = F20002BA(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:17 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6518 | |
| Classwidth @ Best LCL = | 0.0910 | inch |
| Classlength @ Best LCL = | 0.6545 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.5636 -0.040 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.655 | inch |
| Samples Needed @ XL = | 22 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.655 | inch |
| Samples Needed @ Xlcl = | 22 | |
| POH Classlength, Xpoh = | 0.618 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 1.309 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20002BA.XLS
Data Set Name = F20002BA(CRACK #)

## Directed DOE Options

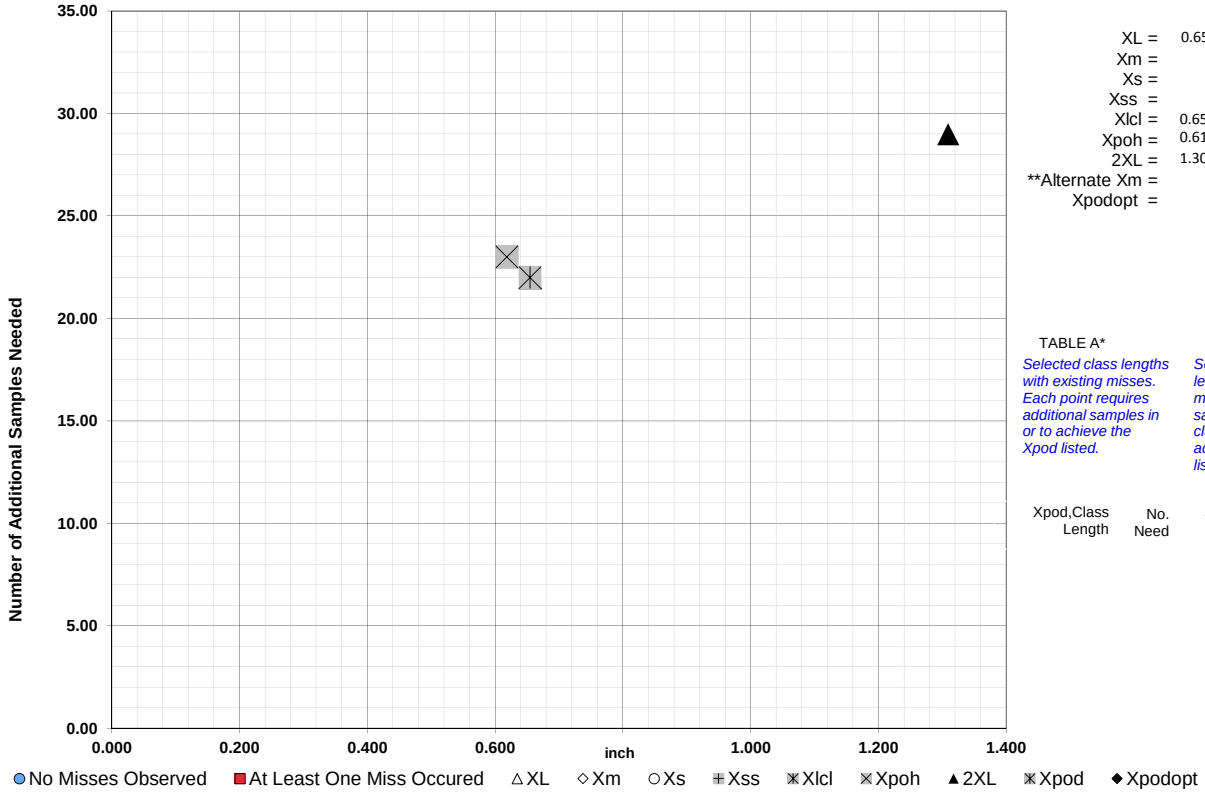



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.655 | 22 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.655 | 22 |
| Xpoh = | 0.618 | 23 |
| 2XL = | 1.309 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

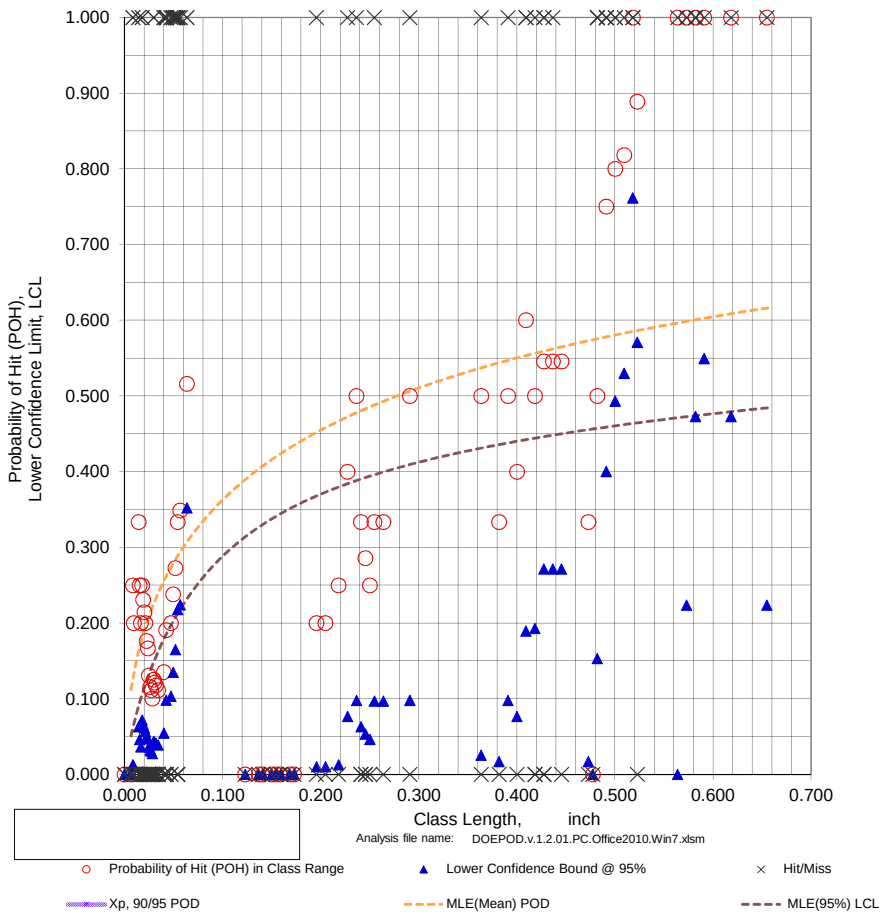
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F20002CA.XLS
Data Set Name = F20002CA(CRACK #)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:18 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7616 | |
| Classwidth @ Best LCL = | 0.0370 | inch |
| Classlength @ Best LCL = | 0.5182 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.5636 -0.040 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |
| Largest Classlength , XL = | 0.655 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.564 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 1.309 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20002CA.XLS
Data Set Name = F20002CA(CRACK #)

## Directed DOE Options

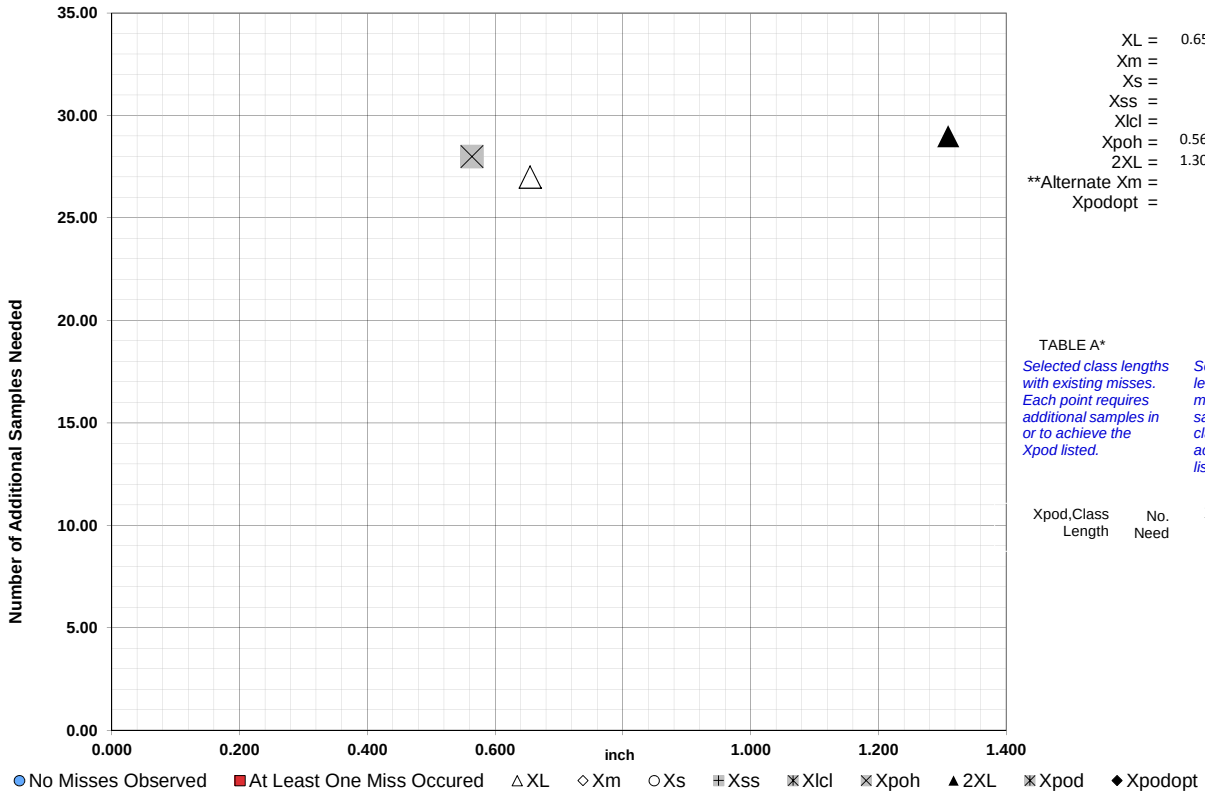



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.655 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.564 | 28 |
| 2XL = | 1.309 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

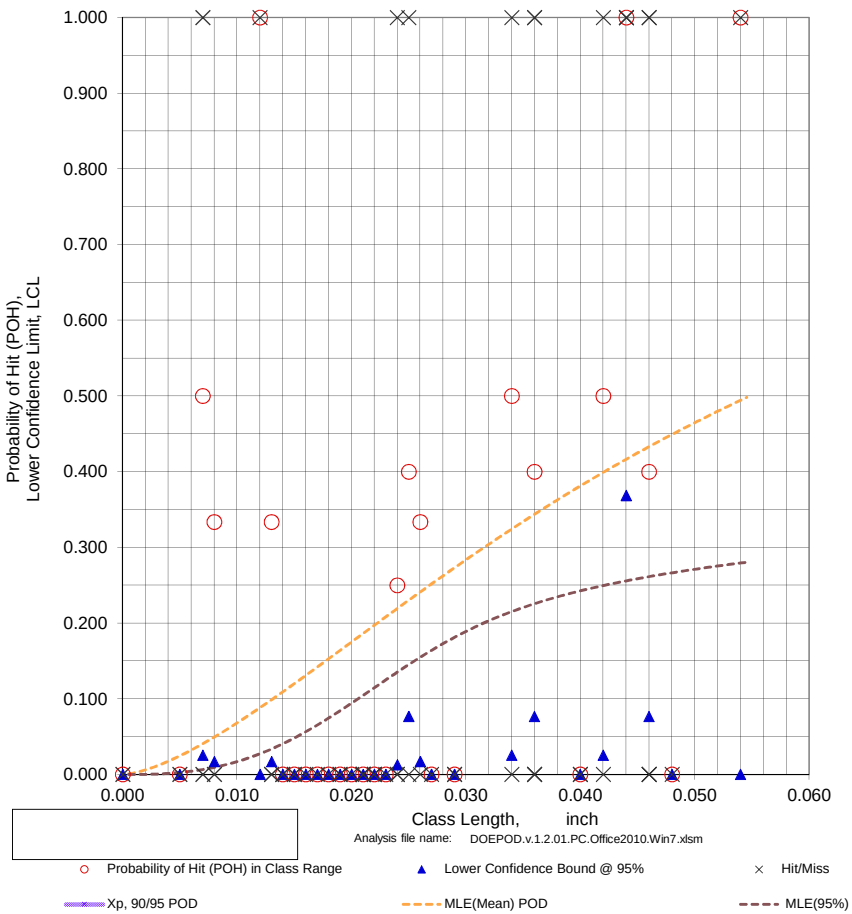
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20852AD.XLS
Data Set Name = F20852AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:20 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0440 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0540 -0.005 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.054 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.054 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.108 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20852AD.XLS
Data Set Name = F20852AD(CRACK #)

## Directed DOE Options

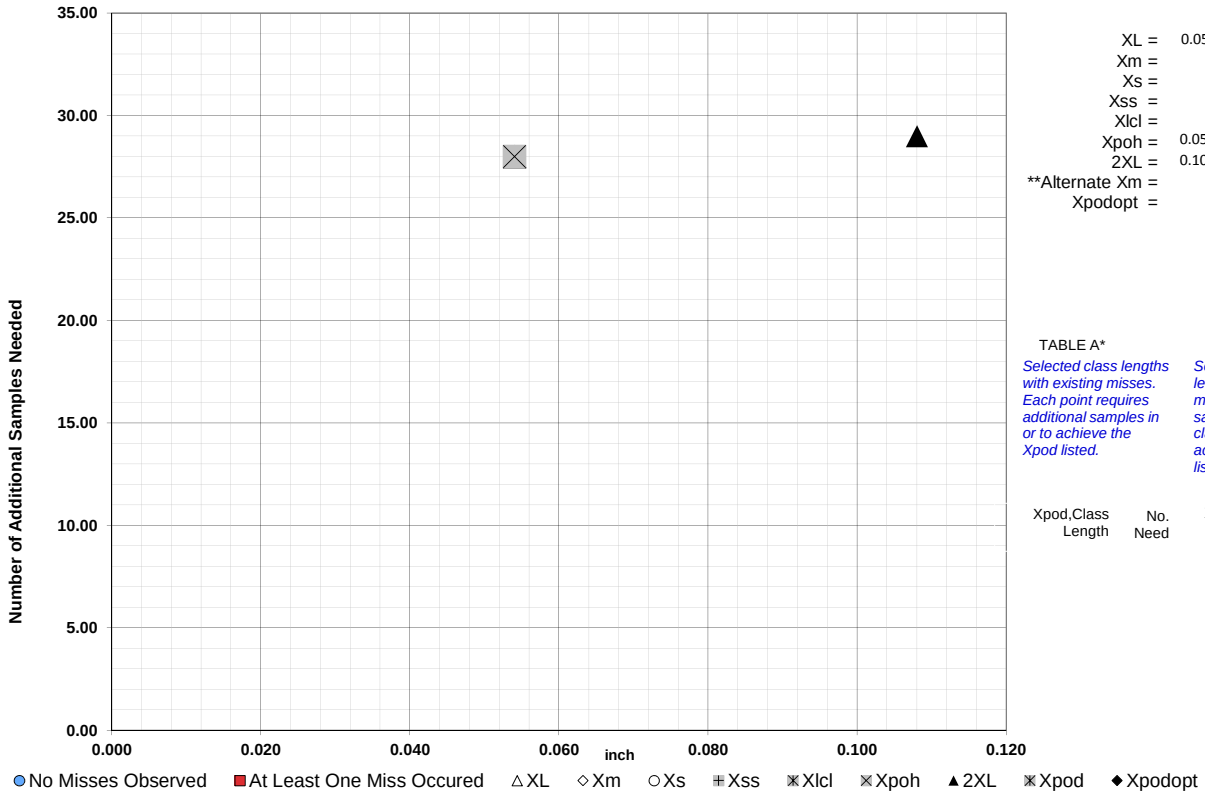



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.054 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.054 | 28 |
| 2XL = | 0.108 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

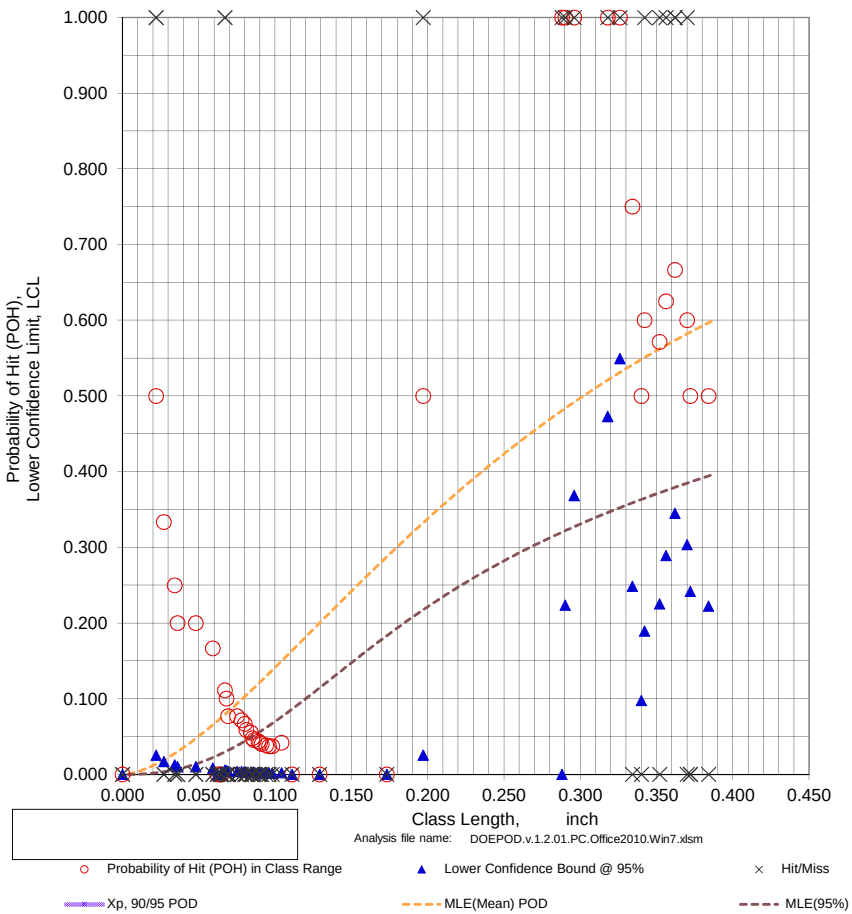
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20852AL.XLS
Data Set Name = F20852AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:20 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0380 | inch |
| Classlength @ Best LCL = | 0.3260 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.768 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20852AL.XLS
Data Set Name = F20852AL(CRACK #)

## Directed DOE Options

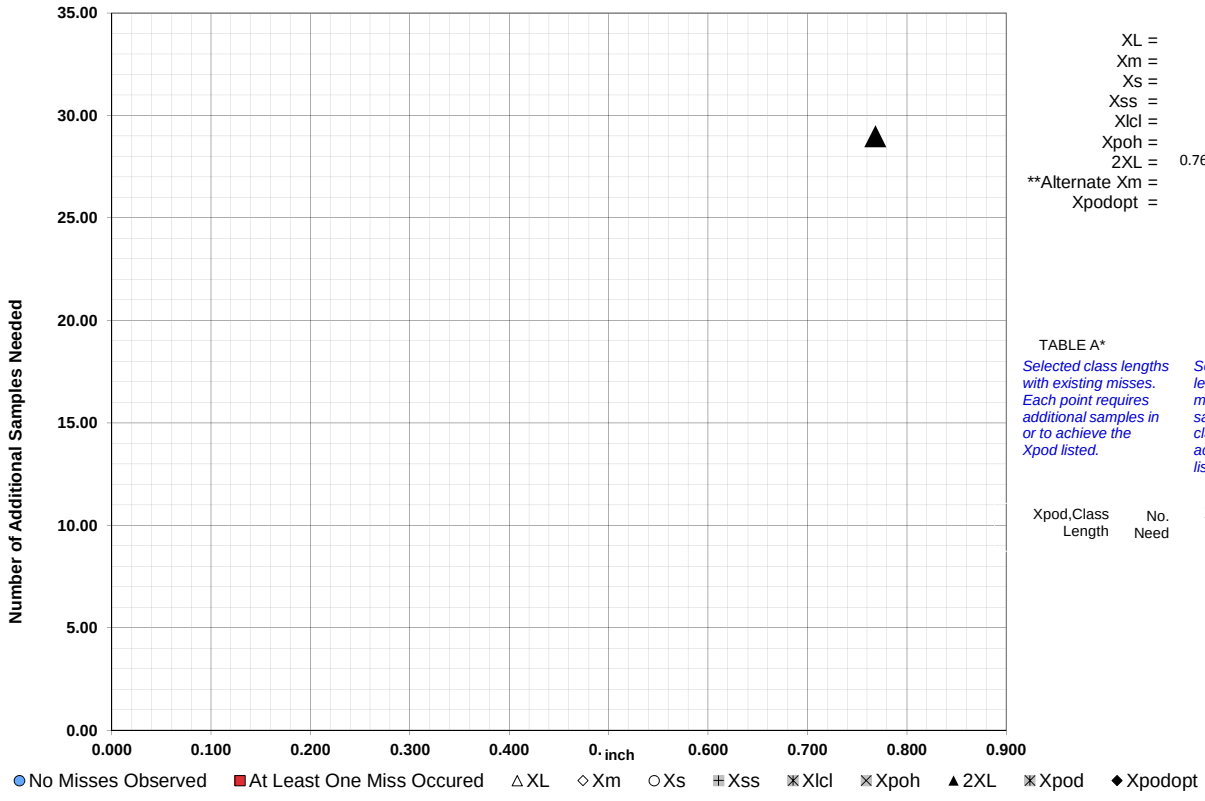



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.768 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

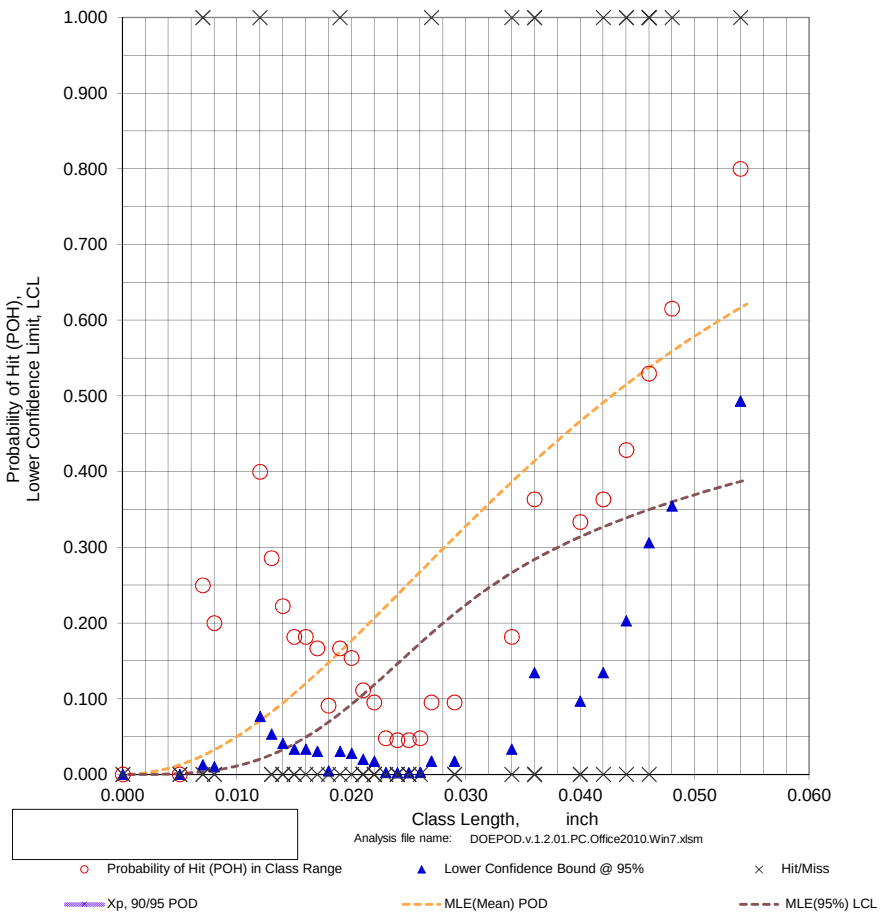
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20852BD.XLS
Data Set Name = F20852BD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:22 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4931 | |
| Classwidth @ Best LCL = | 0.0100 | inch |
| Classlength @ Best LCL = | 0.0540 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0480 -0.001 inch 28 Samples

NTIAC 90% POD = 0.905 @ 0.130 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.108 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20852BD.XLS
Data Set Name = F20852BD(CRACK #)

## Directed DOE Options

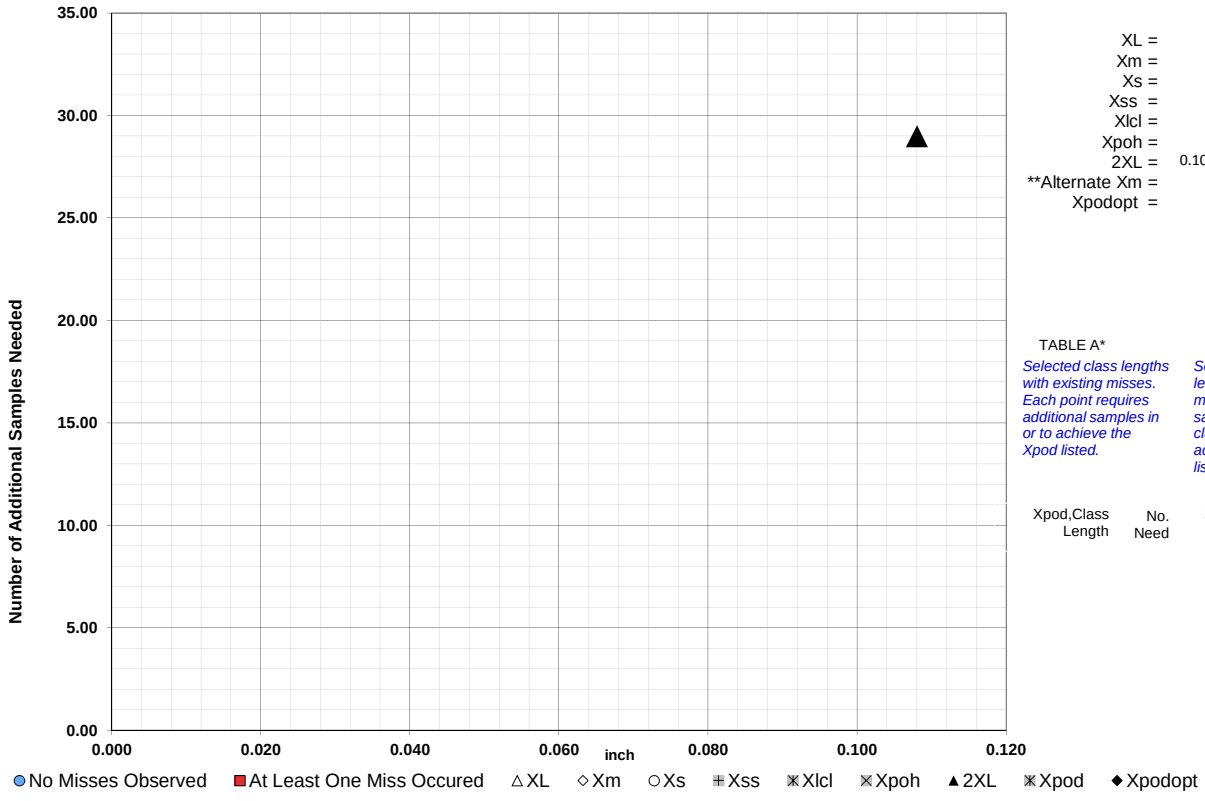



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.108 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

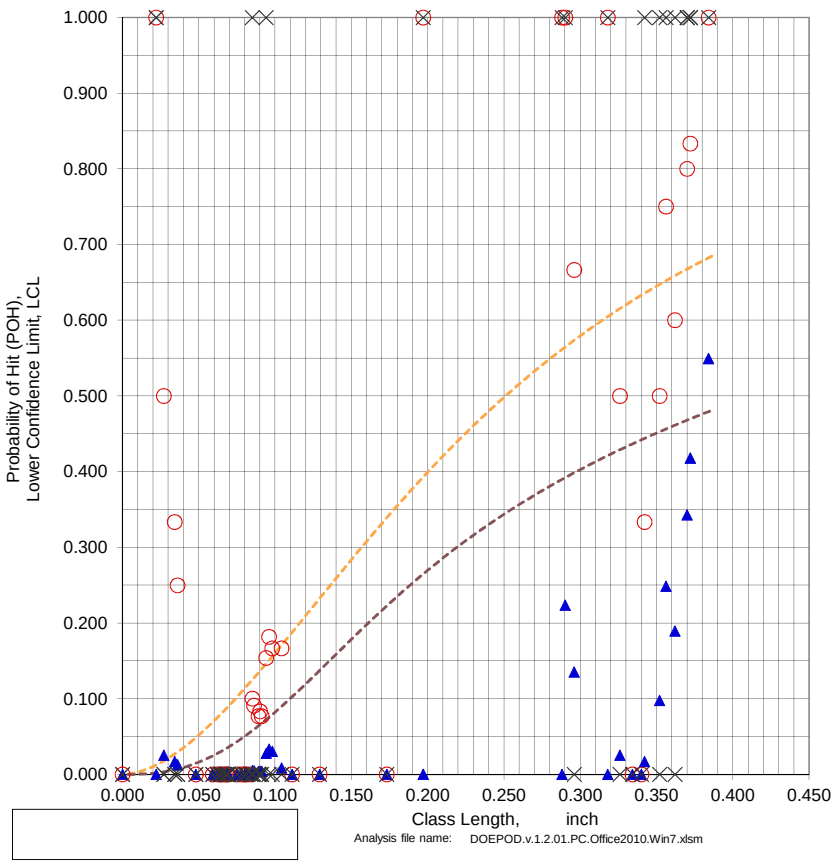
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20852BL.XLS
Data Set Name = F20852BL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:22 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0140 | inch |
| Classlength @ Best LCL = | 0.3840 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.3700 -0.007 inch 27 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | @ | | inch |
| NTIAC 90/95 POD = | @ | | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.384 | inch |
| Samples Needed @ XL = | 24 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.384 | inch |
| Samples Needed @ Xlcl = | 24 | |
| POH Classlength, Xpoh = | 0.384 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.768 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20852BL.XLS
Data Set Name = F20852BL(CRACK #)

## Directed DOE Options

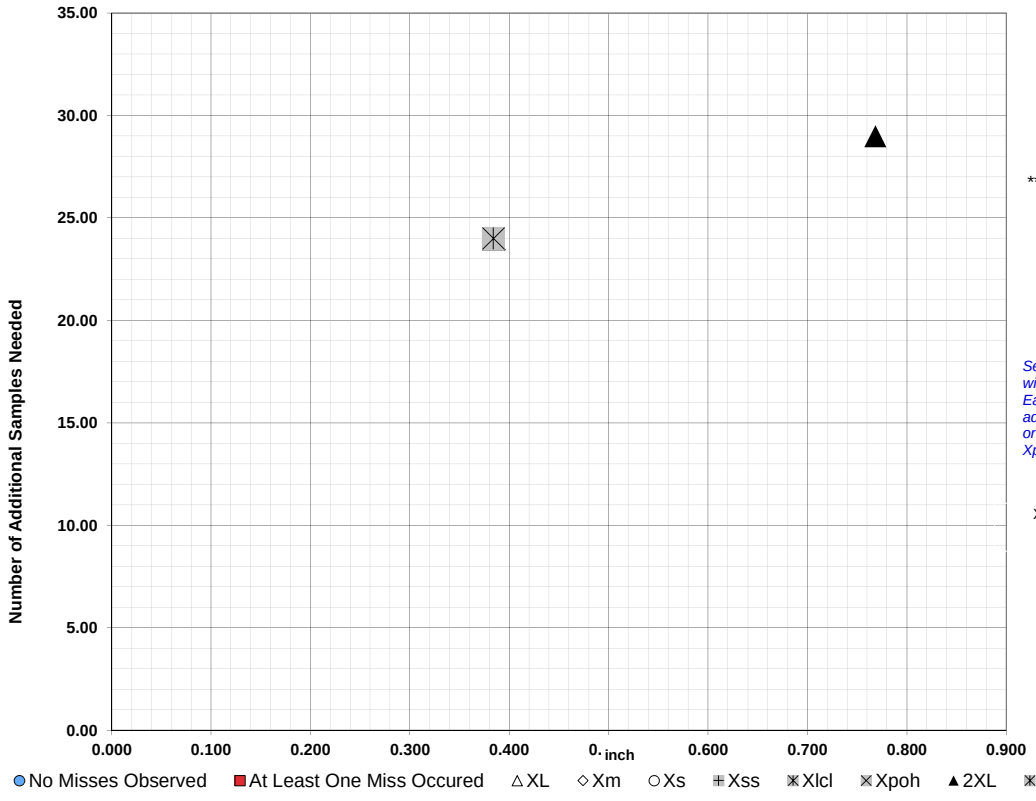



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.384 | 24 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.384 | 24 |
| Xpoh = | 0.384 | |
| 2XL = | 0.768 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

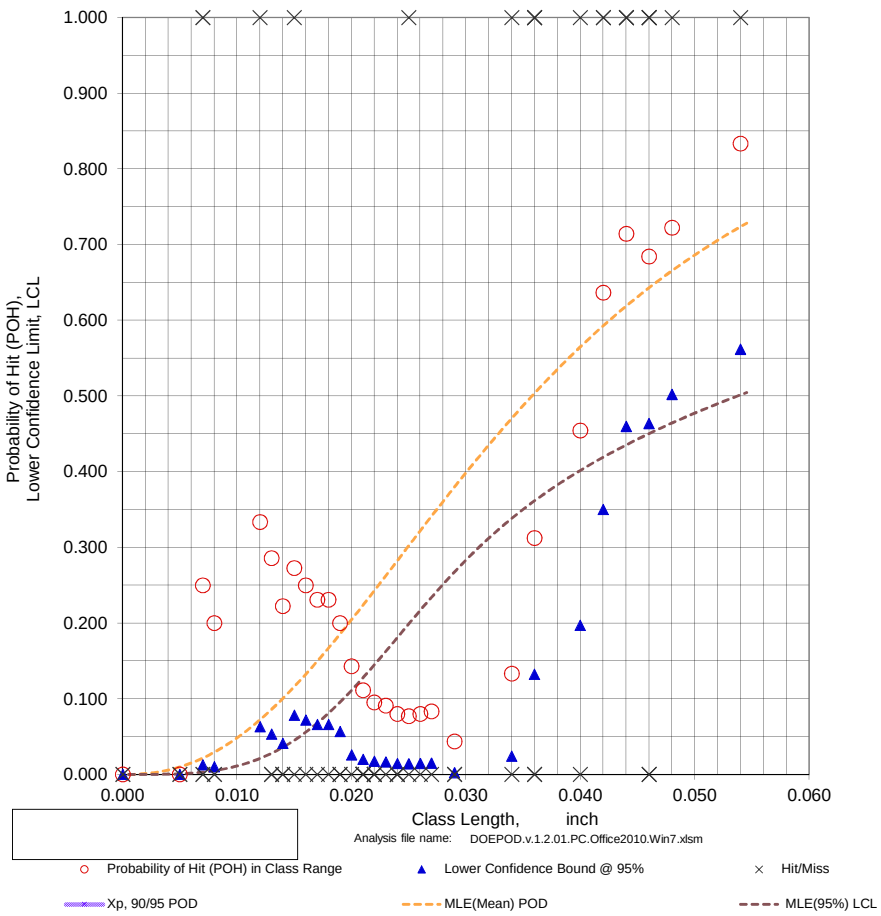
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20852CD.XLS
Data Set Name = F20852CD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:23 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5619 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.0540 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0480 -0.001 inch 28 Samples

NTIAC 90% POD = 0.908 @ 0.095 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.108 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20852CD.XLS
Data Set Name = F20852CD(CRACK #)

## Directed DOE Options

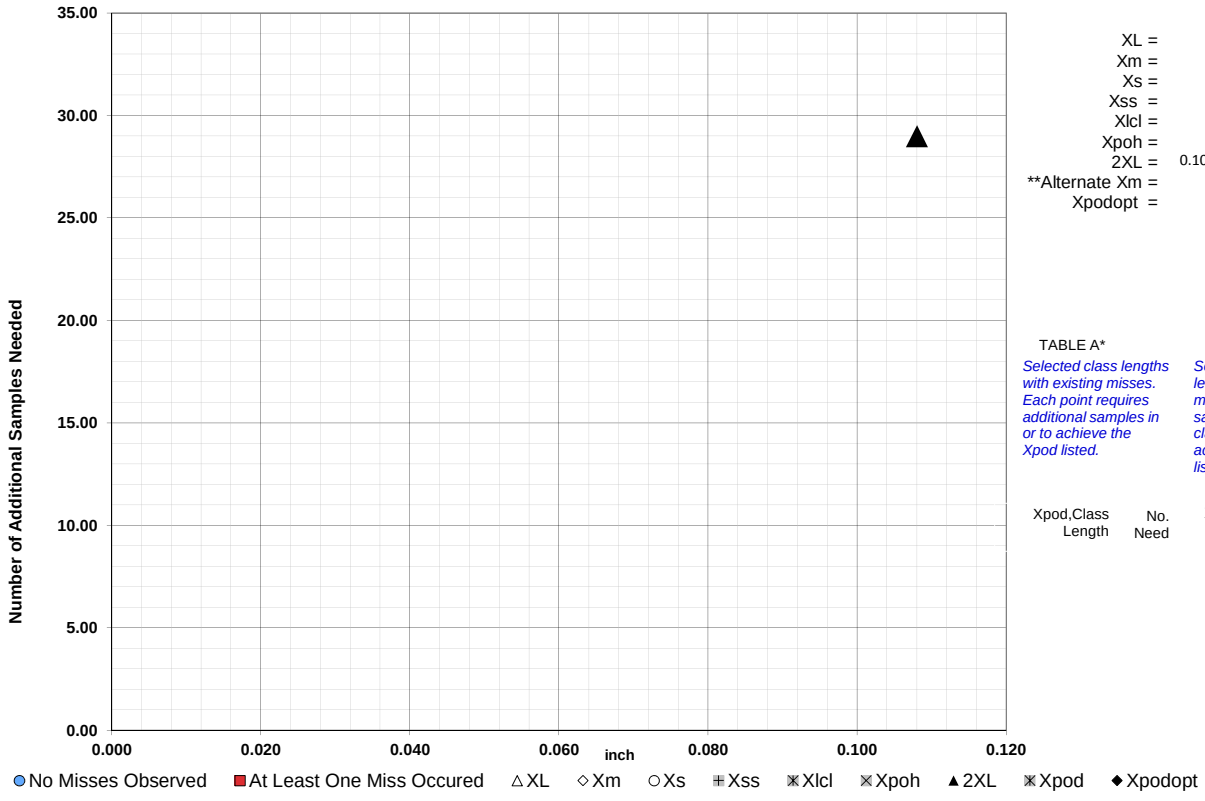



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.108 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

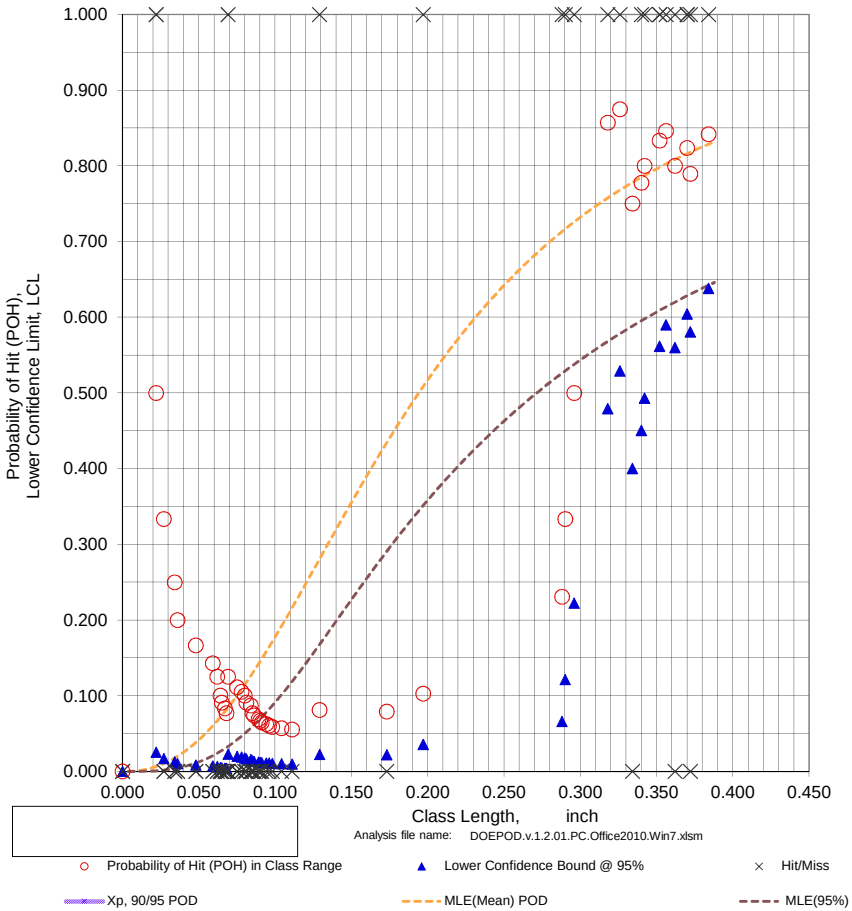
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F20852CL.XLS
Data Set Name = F20852CL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:24 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6383 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.3840 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3840 -0.011 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.505 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.768 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F20852CL.XLS
Data Set Name = F20852CL(CRACK #)

## Directed DOE Options

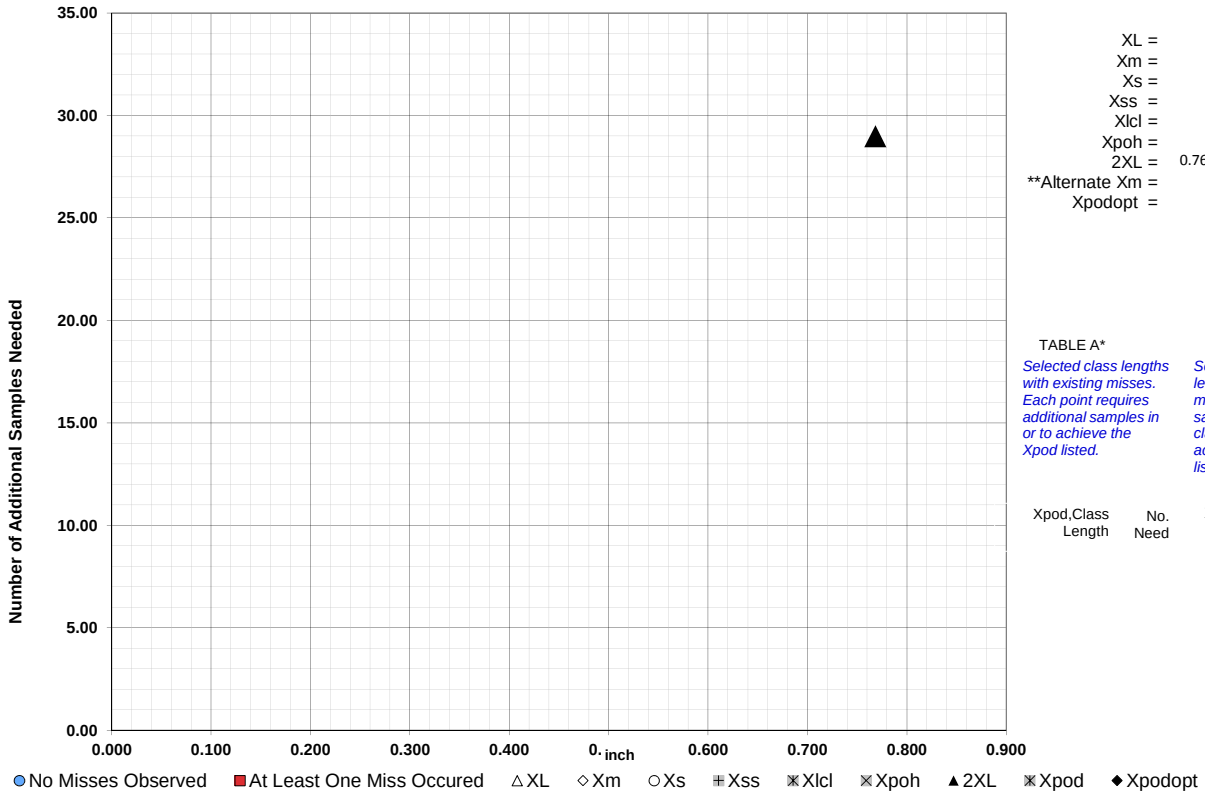



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.768 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

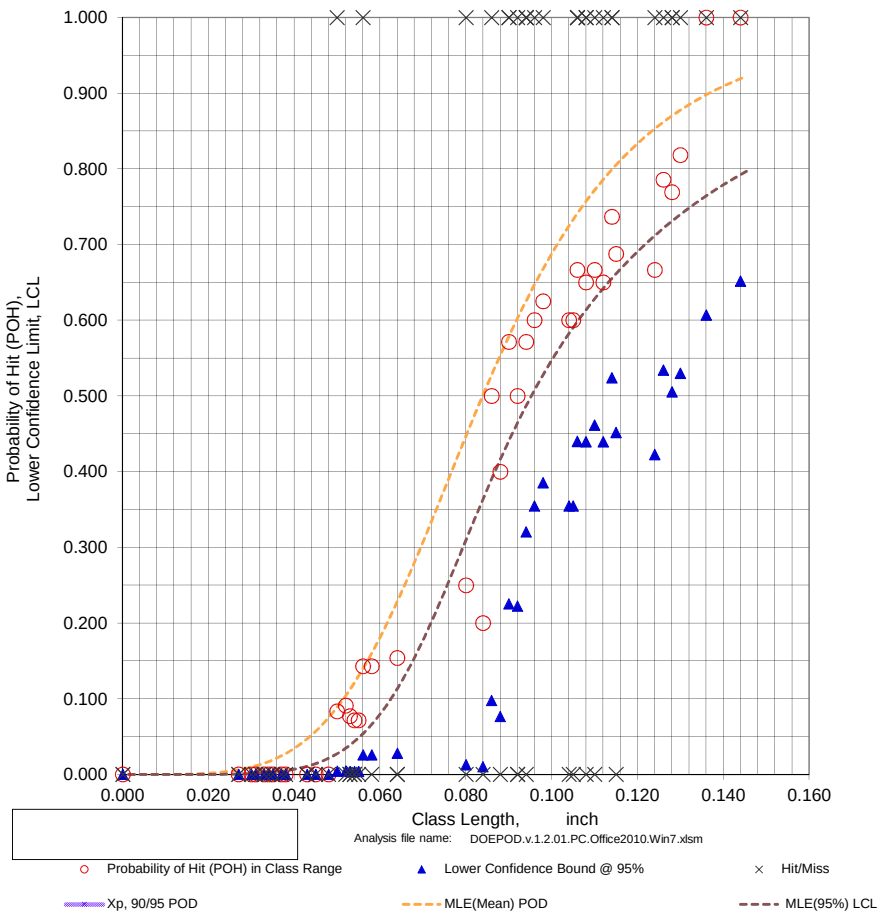
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F22202AD.XLS
Data Set Name = F22202AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:25 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6518 | |
| Classwidth @ Best LCL = | 0.0200 | inch |
| Classlength @ Best LCL = | 0.1440 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1240 -0.008 inch 28 Samples

NTIAC 90% POD = 0.909 @ 0.140 inch
NTIAC 90/95 POD = 0.904 @ 0.200 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.144 | inch |
| Samples Needed @ XL = | 22 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.144 | inch |
| Samples Needed @ Xlcl = | 22 | |
| POH Classlength, Xpoh = | 0.136 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 0.288 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F22202AD.XLS
Data Set Name = F22202AD(CRACK #)

## Directed DOE Options

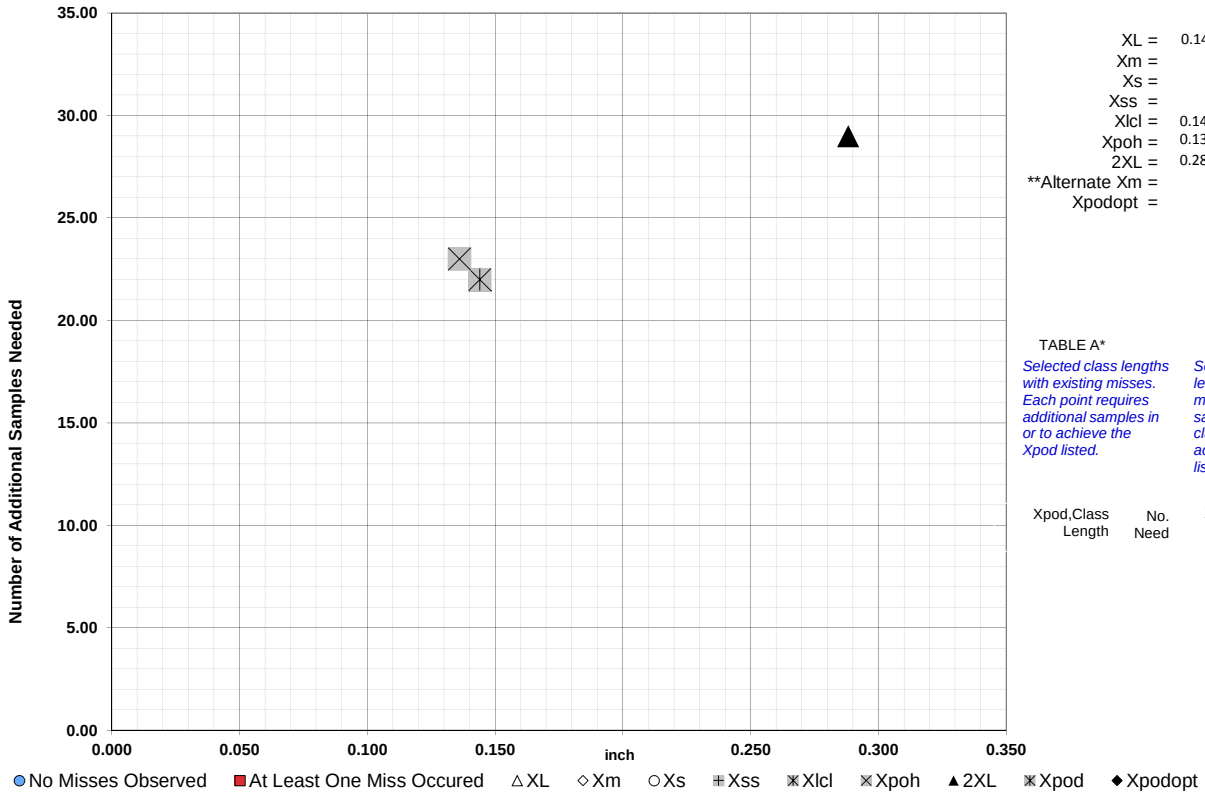



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.144 | 22 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.144 | 22 |
| Xpoh = | 0.136 | 23 |
| 2XL = | 0.288 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

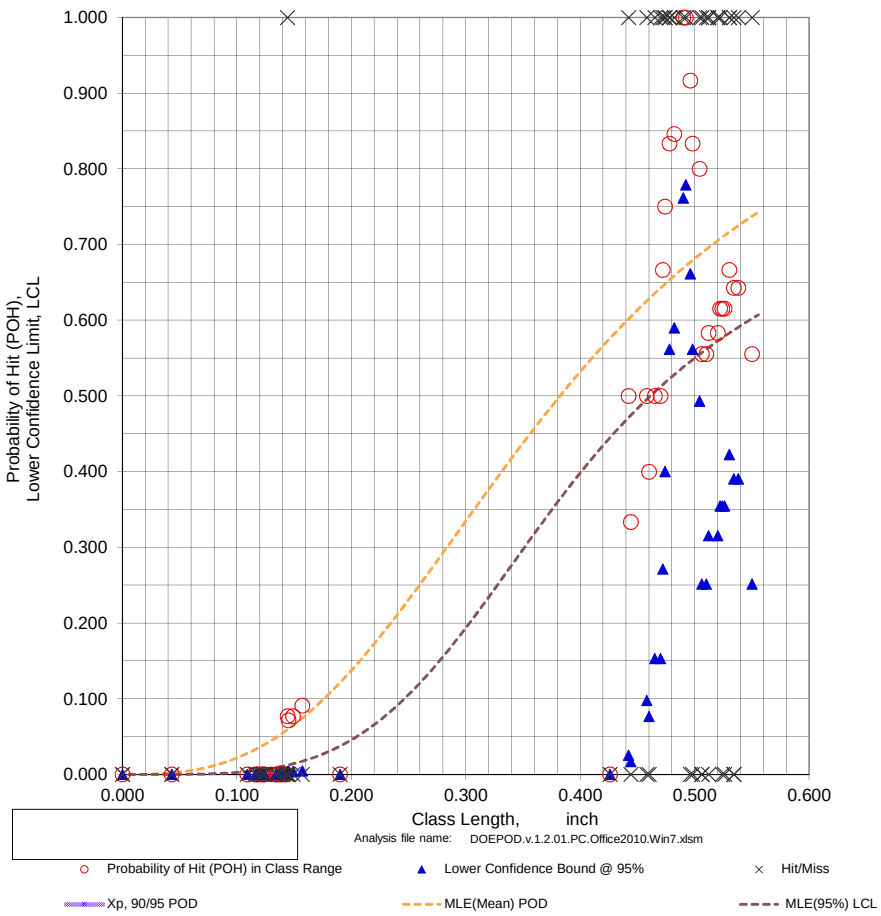
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F22202AL.XLS
Data Set Name = F22202AL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:27 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0270 | inch |
| Classlength @ Best LCL = | 0.4920 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.5380 -0.003 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.100 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F22202AL.XLS
Data Set Name = F22202AL(CRACK #)

## Directed DOE Options

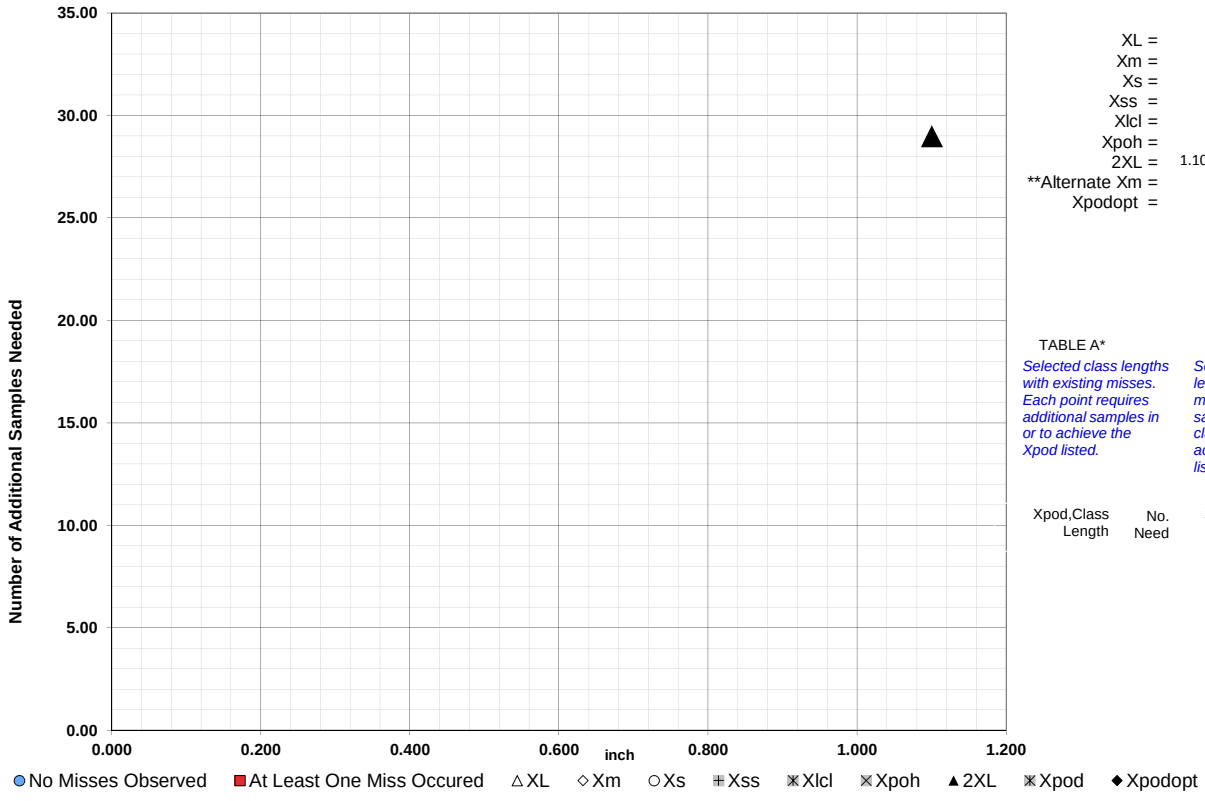



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.100 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

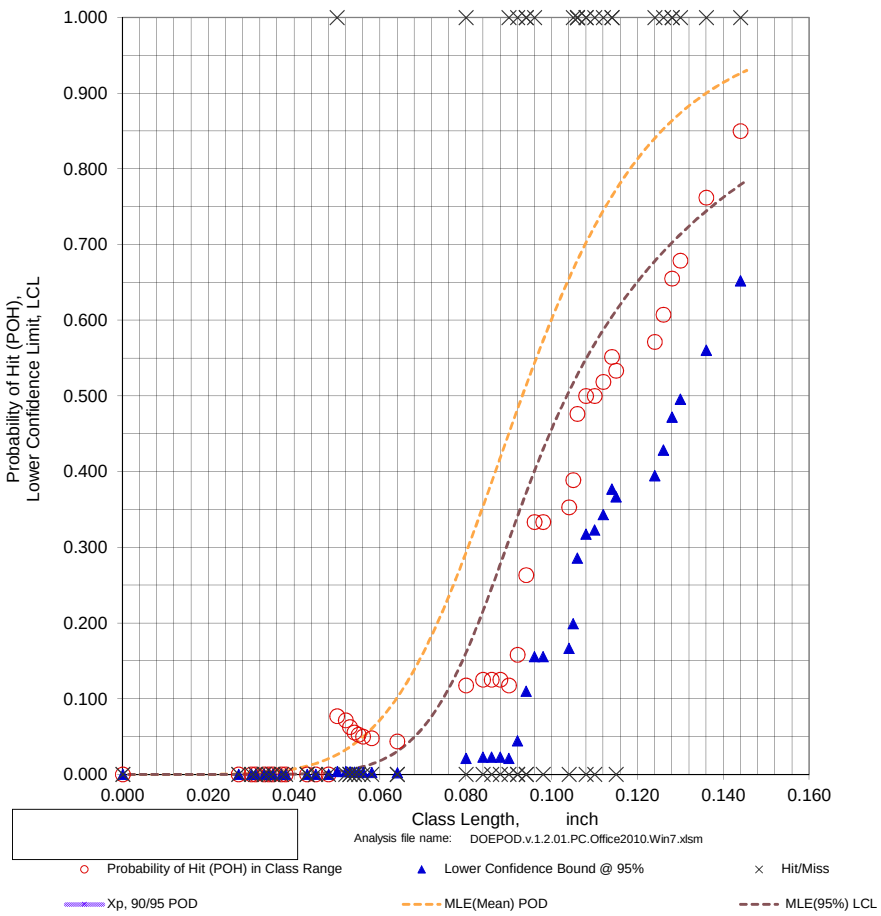
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F22202BD.XLS
Data Set Name = F22202BD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:28 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6522 | |
| Classwidth @ Best LCL = | 0.0390 | inch |
| Classlength @ Best LCL = | 0.1440 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.1240 -0.008 inch 28 Samples

NTIAC 90% POD = 0.914 @ 0.140 inch
NTIAC 90/95 POD = 0.903 @ 0.195 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.288 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F22202BD.XLS
Data Set Name = F22202BD(CRACK #)

## Directed DOE Options

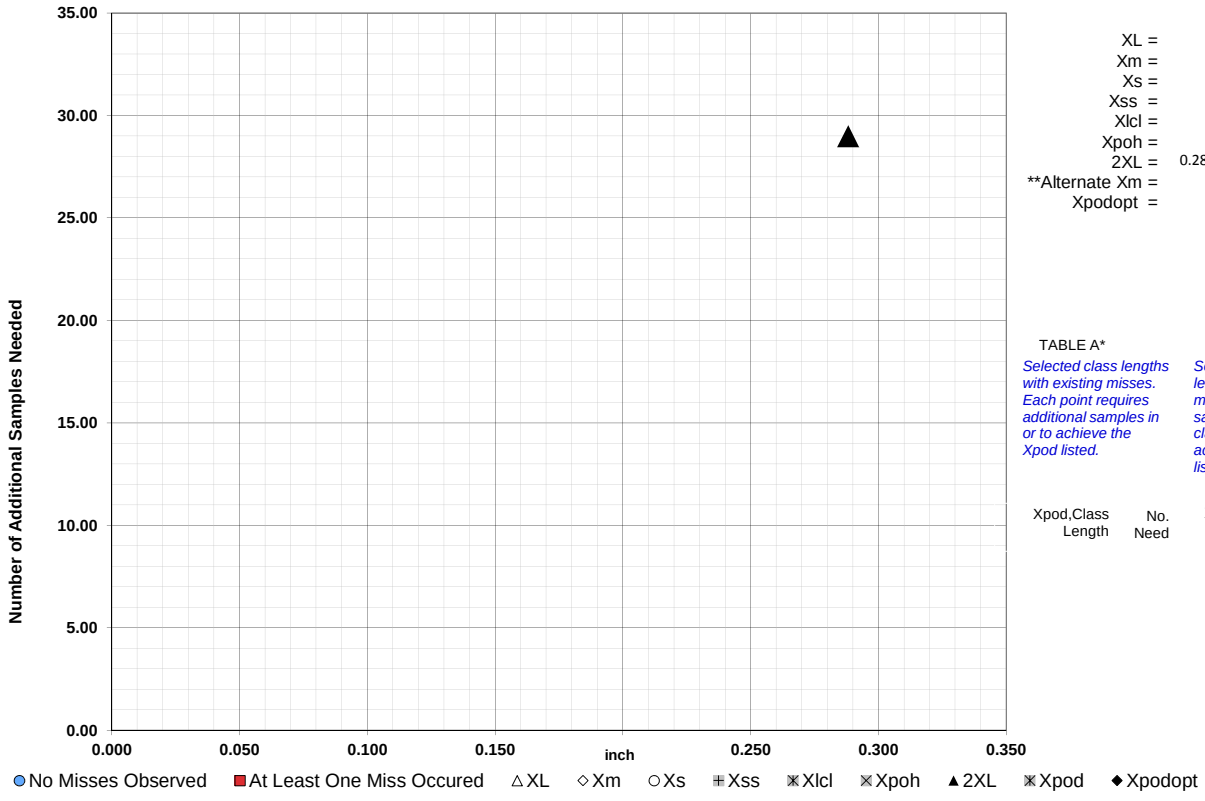



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.288 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

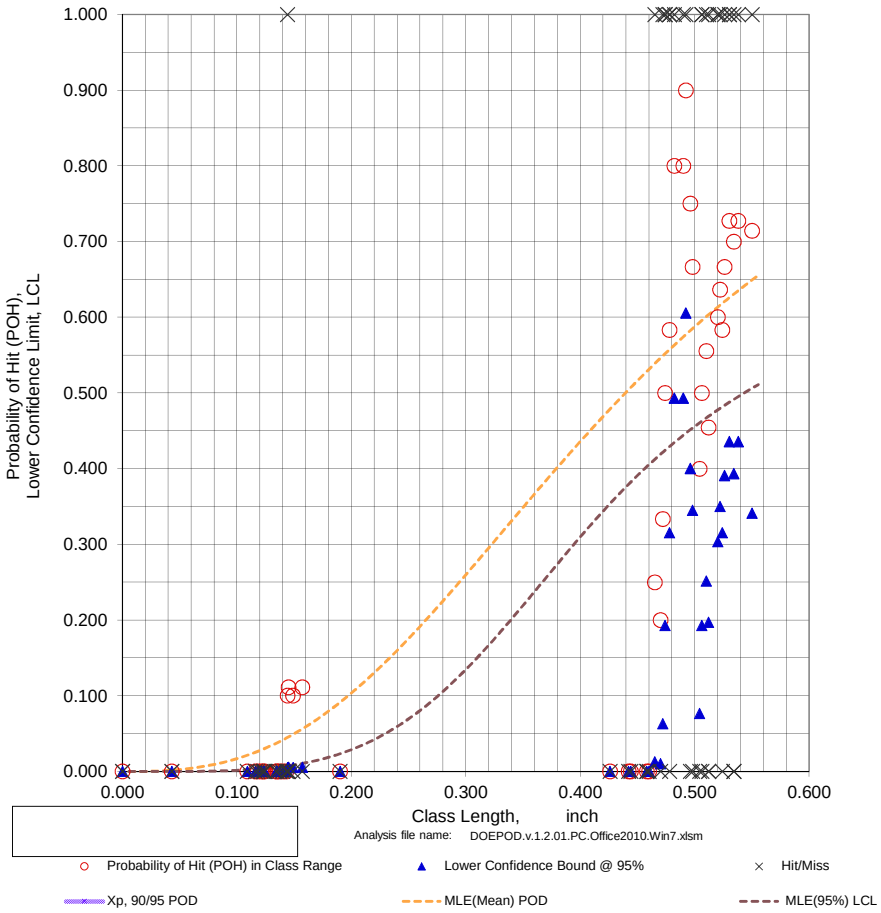
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F22202BL.XLS
Data Set Name = F22202BL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:29 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6058 | |
| Classwidth @ Best LCL = | 0.0200 | inch |
| Classlength @ Best LCL = | 0.4920 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.5380 -0.003 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.100 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F22202BL.XLS
Data Set Name = F22202BL(CRACK #)

## Directed DOE Options

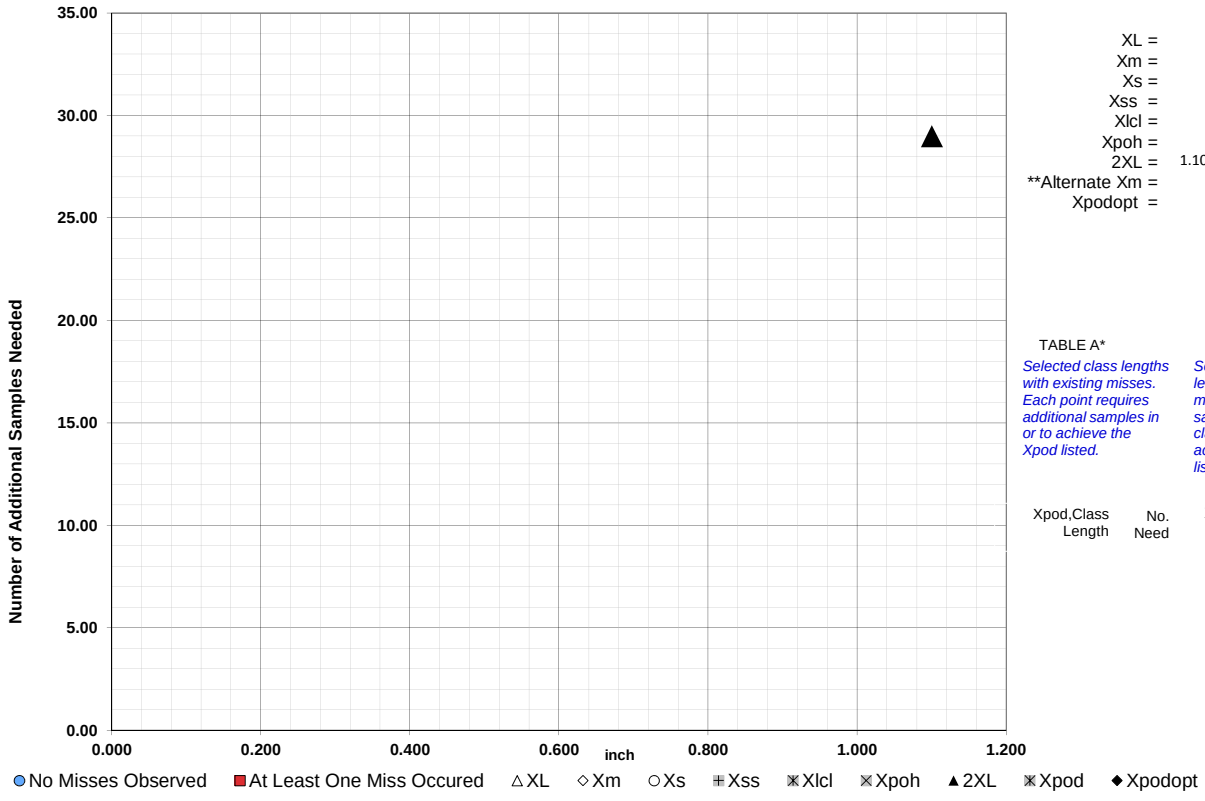



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.100 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

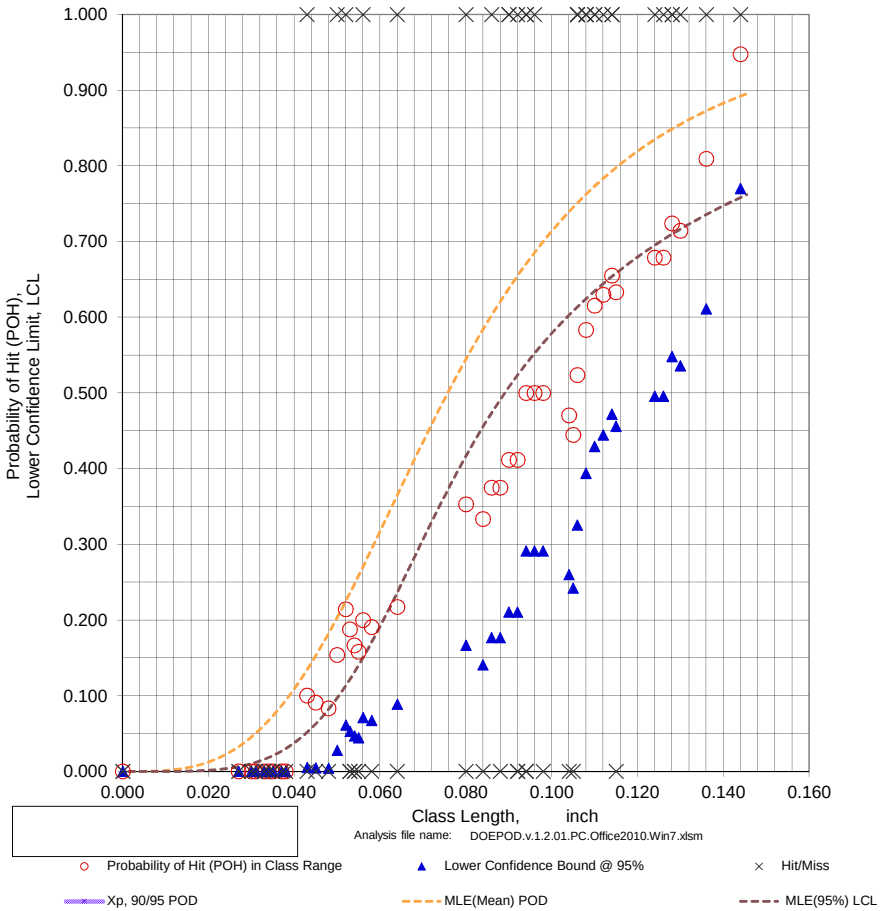
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F22202CD.XLS
Data Set Name = F22202CD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:30 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7699 | |
| Classwidth @ Best LCL = | 0.0380 | inch |
| Classlength @ Best LCL = | 0.1440 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.1240 -0.008 inch 28 Samples

NTIAC 90% POD = 0.904 @ 0.150 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.288 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F22202CD.XLS
Data Set Name = F22202CD(CRACK #)

## Directed DOE Options

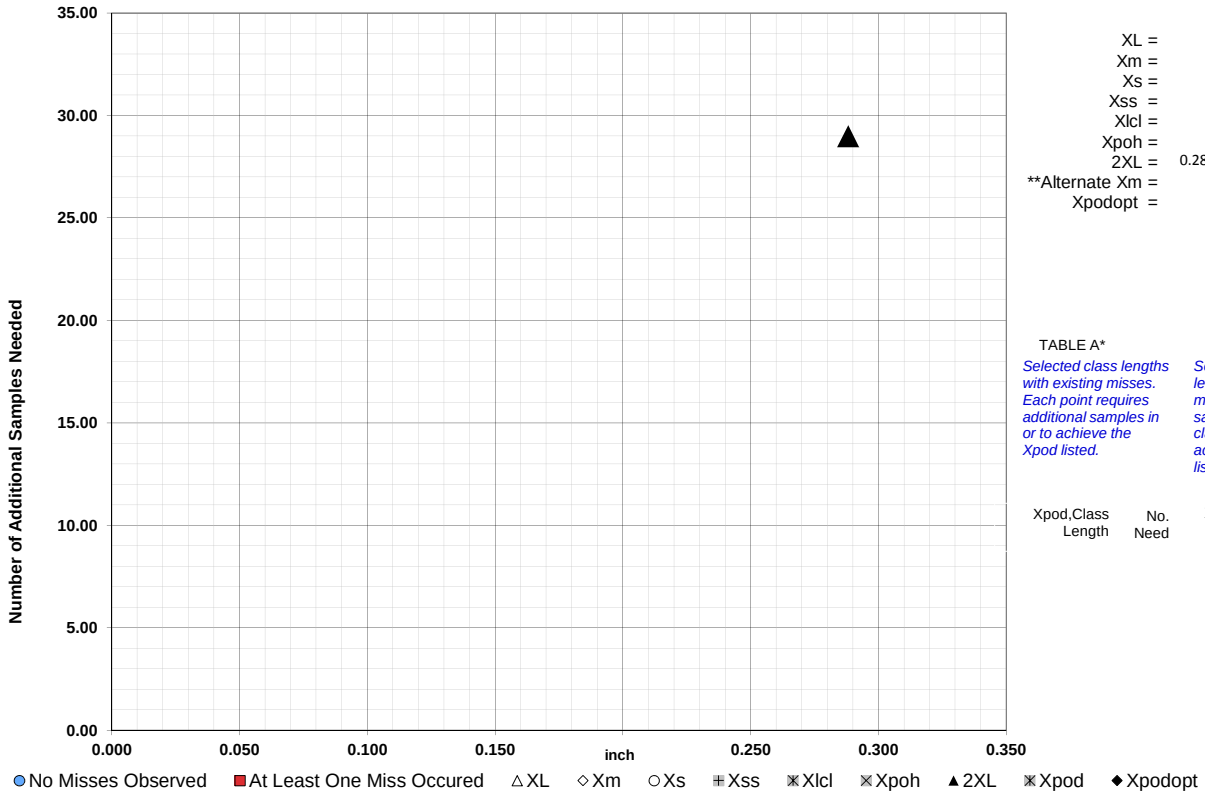



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.288 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

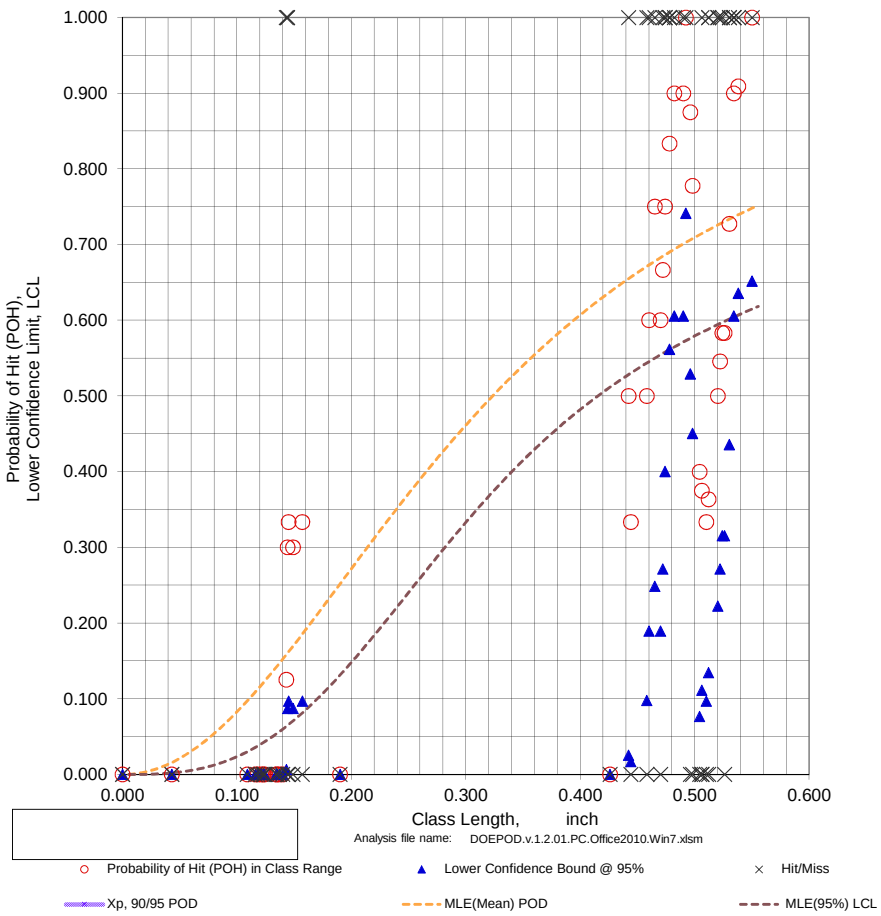
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F22202CL.XLS
Data Set Name = F22202CL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:31 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0200 | inch |
| Classlength @ Best LCL = | 0.4920 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.5300 -0.003 inch 27 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.550 | inch |
| Samples Needed @ XL = | 22 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.550 | inch |
| Samples Needed @ Xpoh = | 22 | |
| New Largest Classlength , 2XL = | 1.100 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F22202CL.XLS
Data Set Name = F22202CL(CRACK #)

## Directed DOE Options

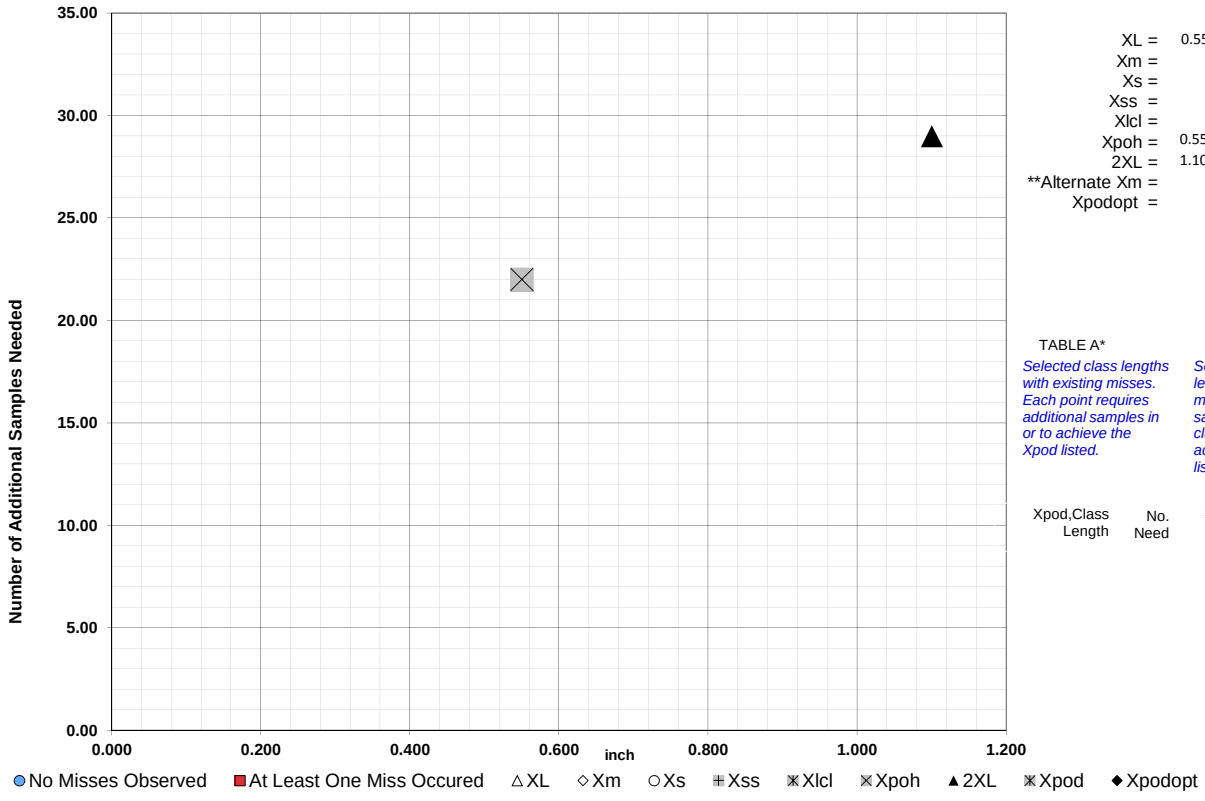



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.550 | 22 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.550 | 22 |
| 2XL = | 1.100 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

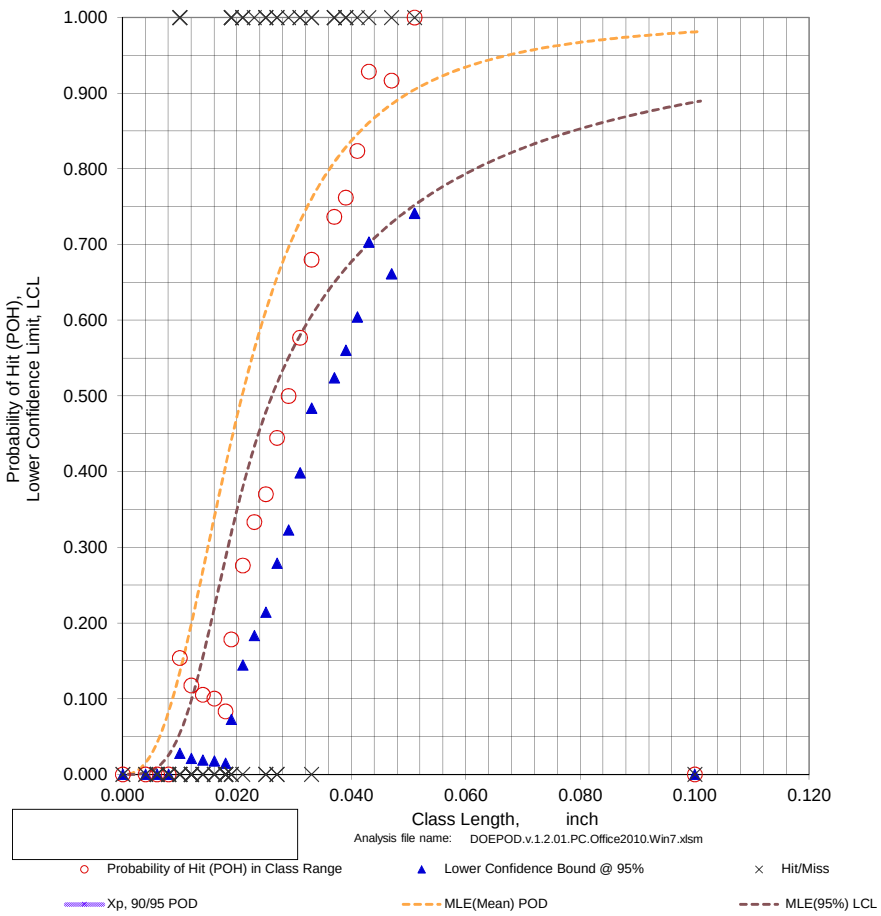
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30651AD.XLS
Data Set Name = F30651AD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:33 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0140 | inch |
| Classlength @ Best LCL = | 0.0510 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.900 | @ | 0.050 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.110 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.200 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30651AD.XLS
Data Set Name = F30651AD(CRK #)

## Directed DOE Options

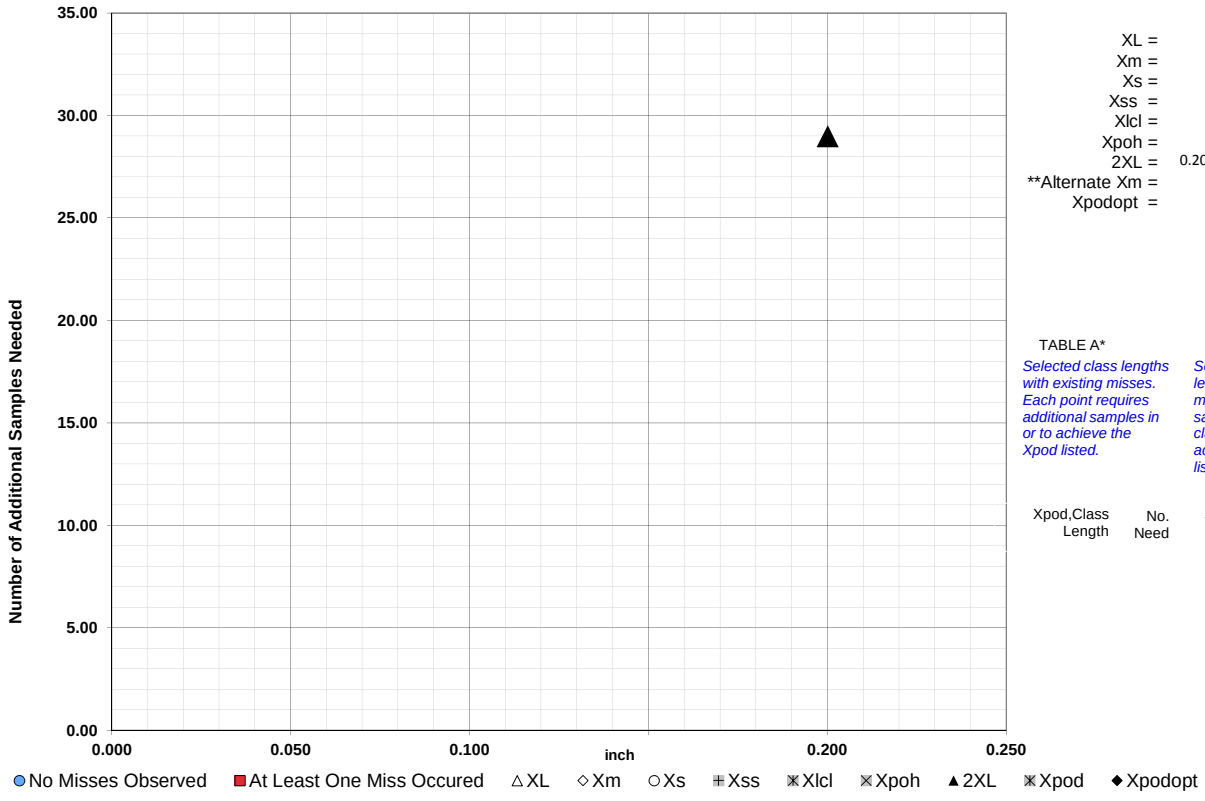



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.200 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

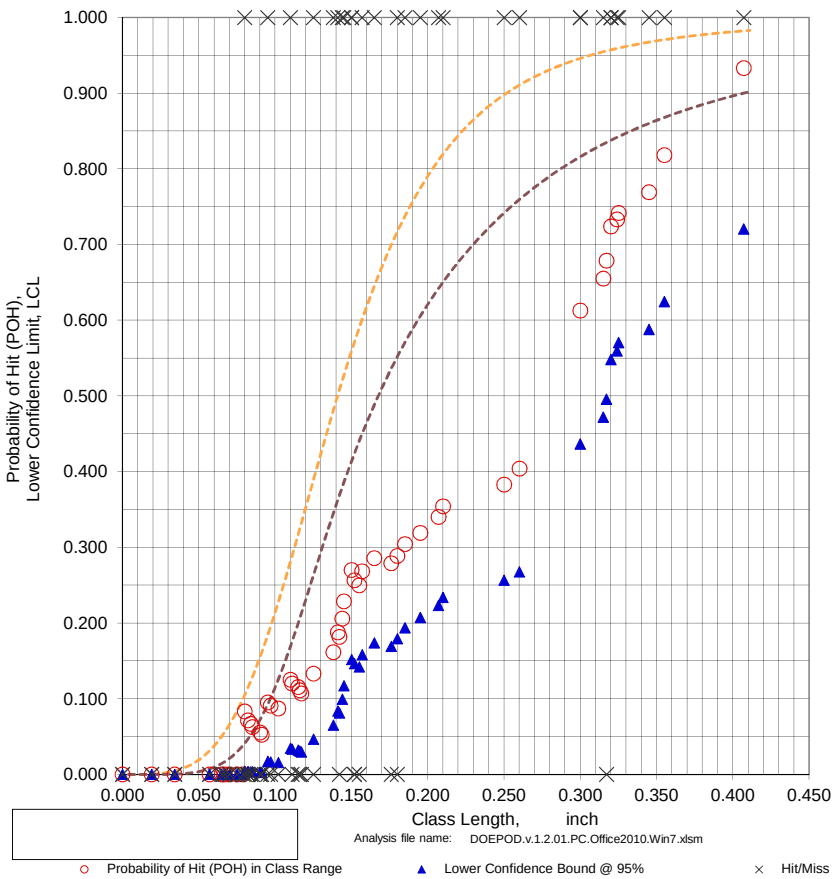
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30651AL.XLS
Data Set Name = F30651AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:34 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7206 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.4070 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3200 -0.002 inch 27 Samples

NTIAC 90% POD = 0.905 @ 0.255 inch
NTIAC 90/95 POD = 0.902 @ 0.410 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30651AL.XLS
Data Set Name = F30651AL(CRK #)

## Directed DOE Options

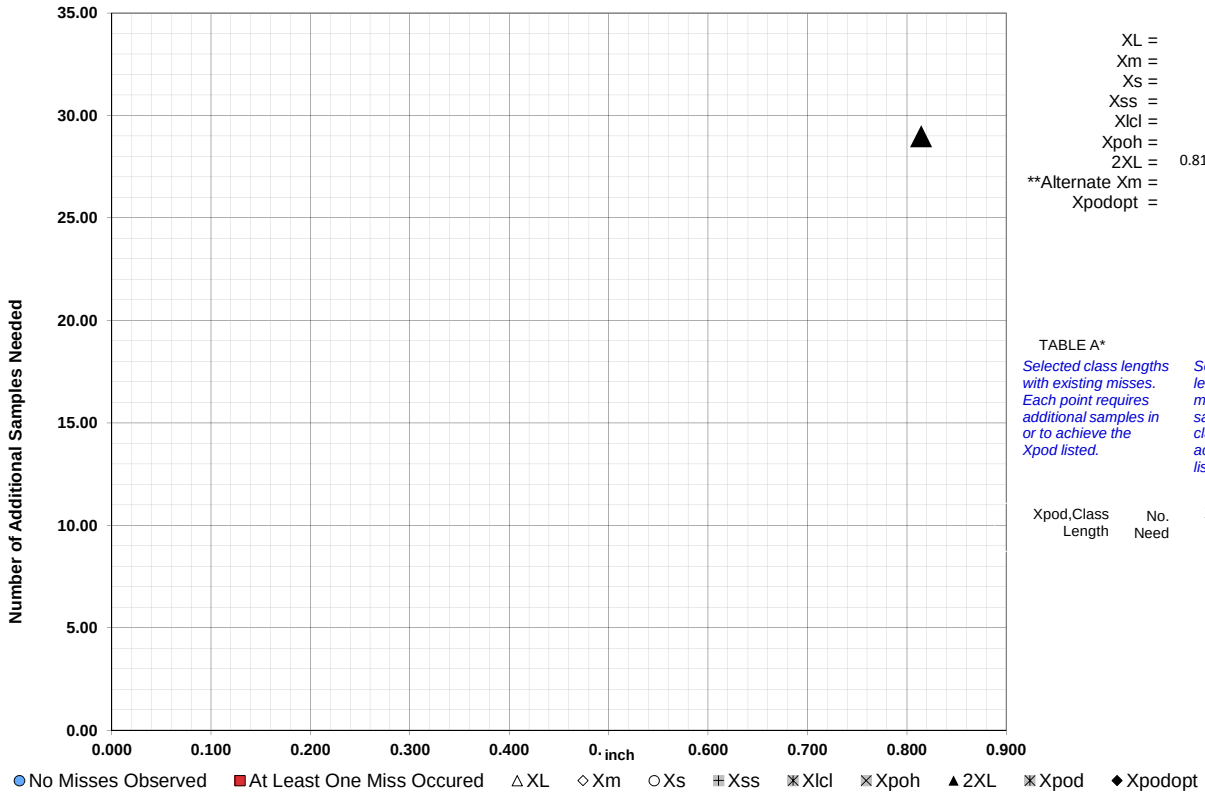



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

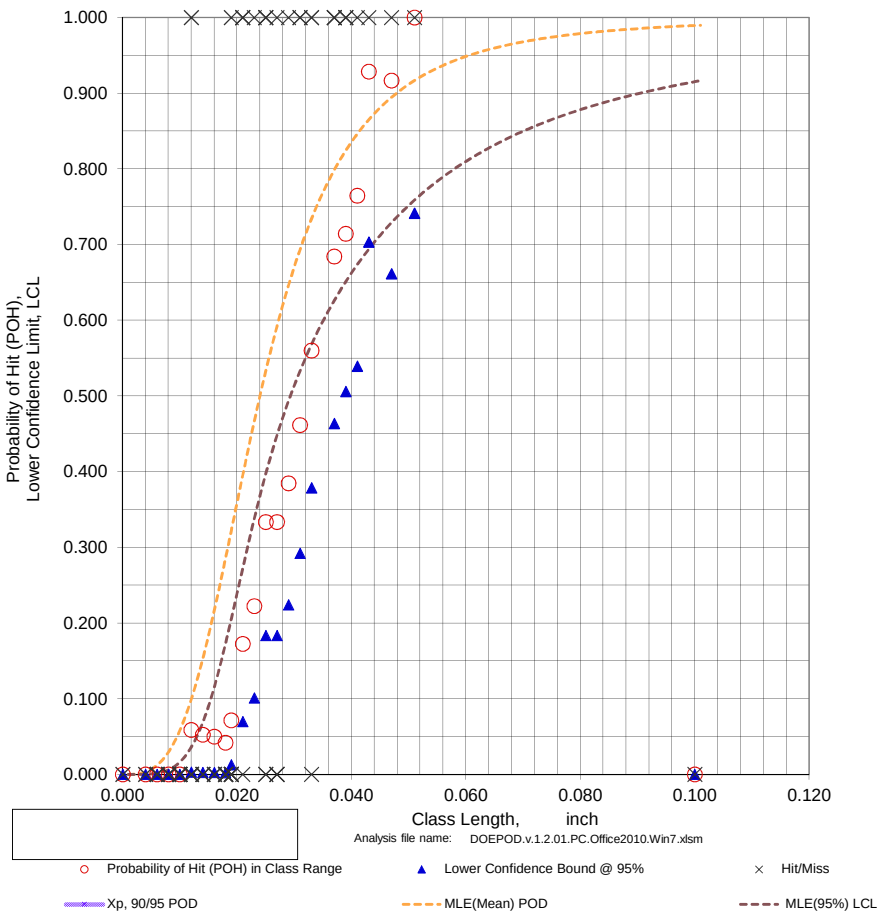
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30651BD.XLS
Data Set Name = F30651BD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:35 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0140 | inch |
| Classlength @ Best LCL = | 0.0510 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.912 | @ | 0.050 | inch |
| NTIAC 90/95 POD = | 0.908 | @ | 0.095 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.200 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30651BD.XLS
Data Set Name = F30651BD(CRK #)

## Directed DOE Options

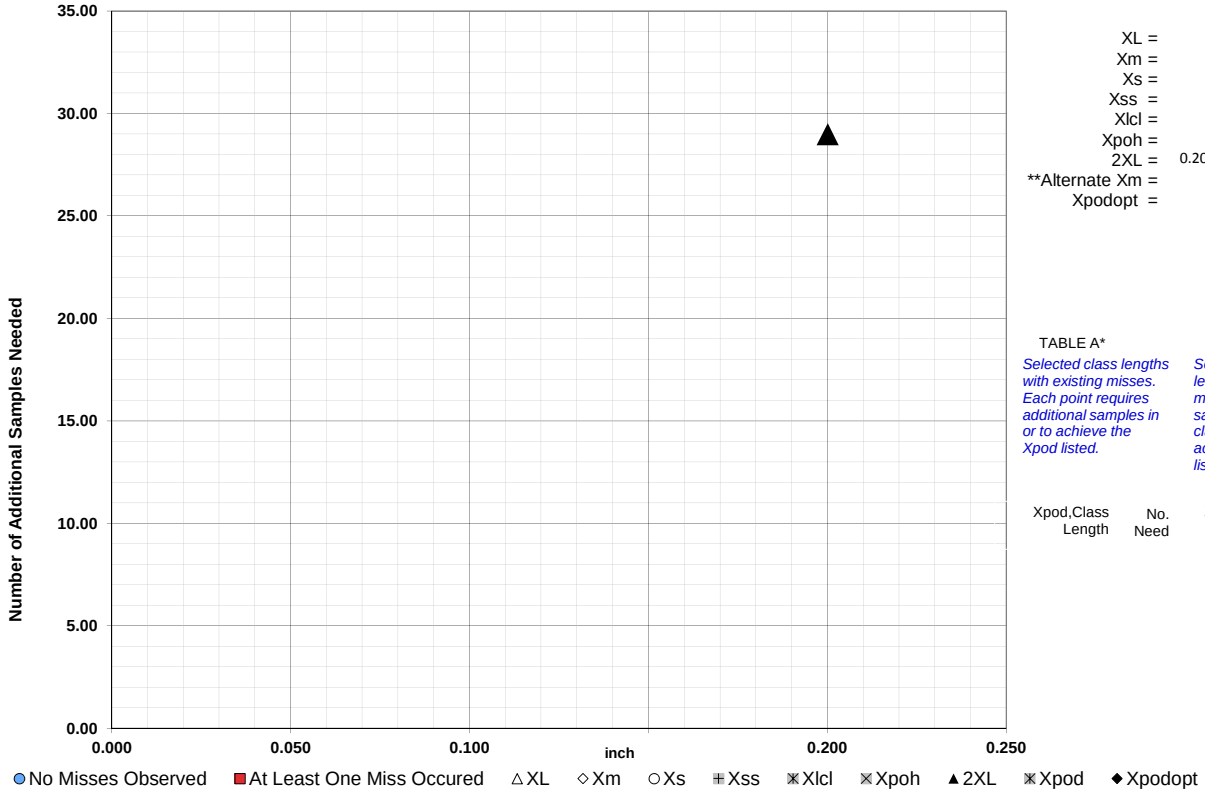



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | |
| Xm = | |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | 0.200 29 |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

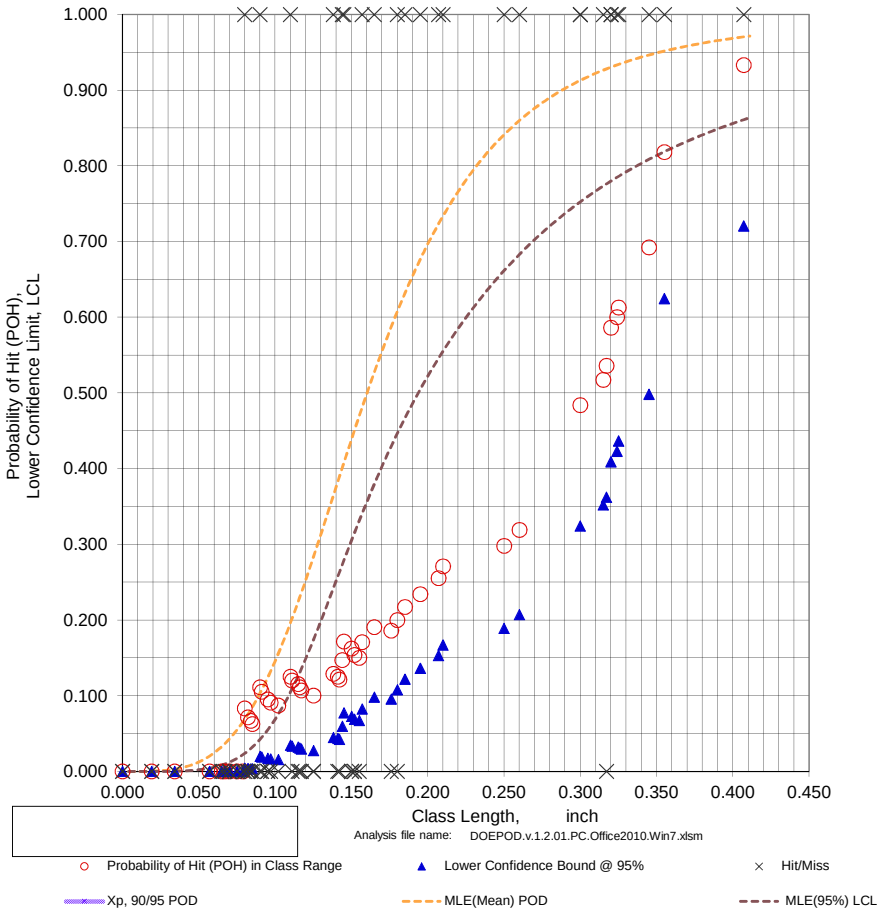
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30651BL.XLS
Data Set Name = F30651BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:36 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7206 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.4070 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3200 -0.002 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.902 | @ | 0.290 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.480 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30651BL.XLS
Data Set Name = F30651BL(CRK #)

## Directed DOE Options

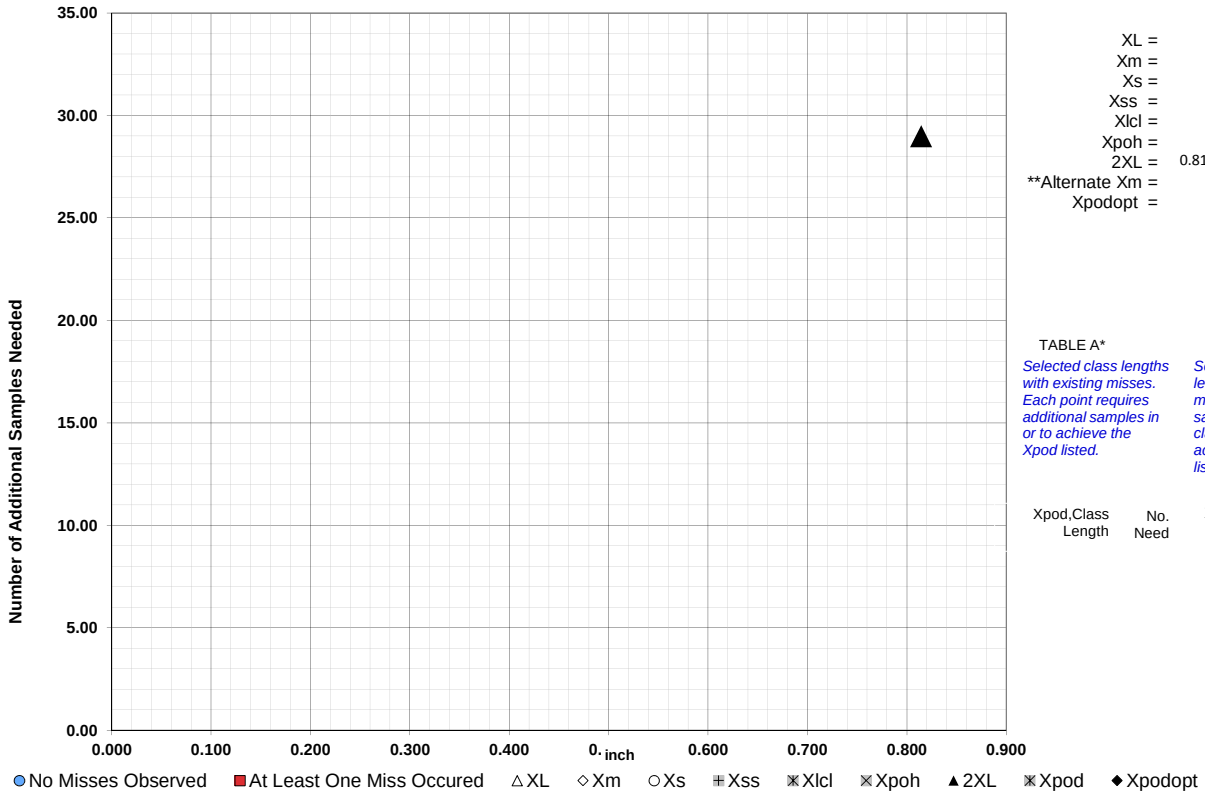



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

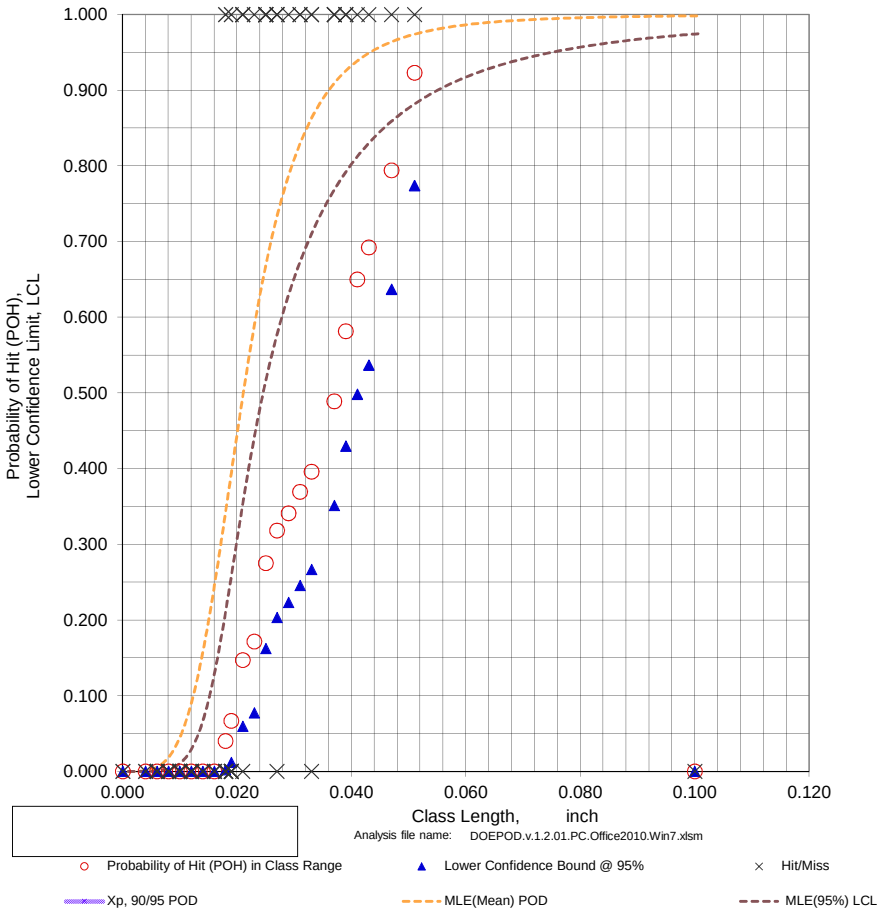
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30651CD.XLS
Data Set Name = F30651CD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:37 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7740 | |
| Classwidth @ Best LCL = | 0.0280 | inch |
| Classlength @ Best LCL = | 0.0510 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.933 | @ | 0.040 | inch |
| NTIAC 90/95 POD = | 0.917 | @ | 0.060 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.200 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30651CD.XLS
Data Set Name = F30651CD(CRK #)

## Directed DOE Options

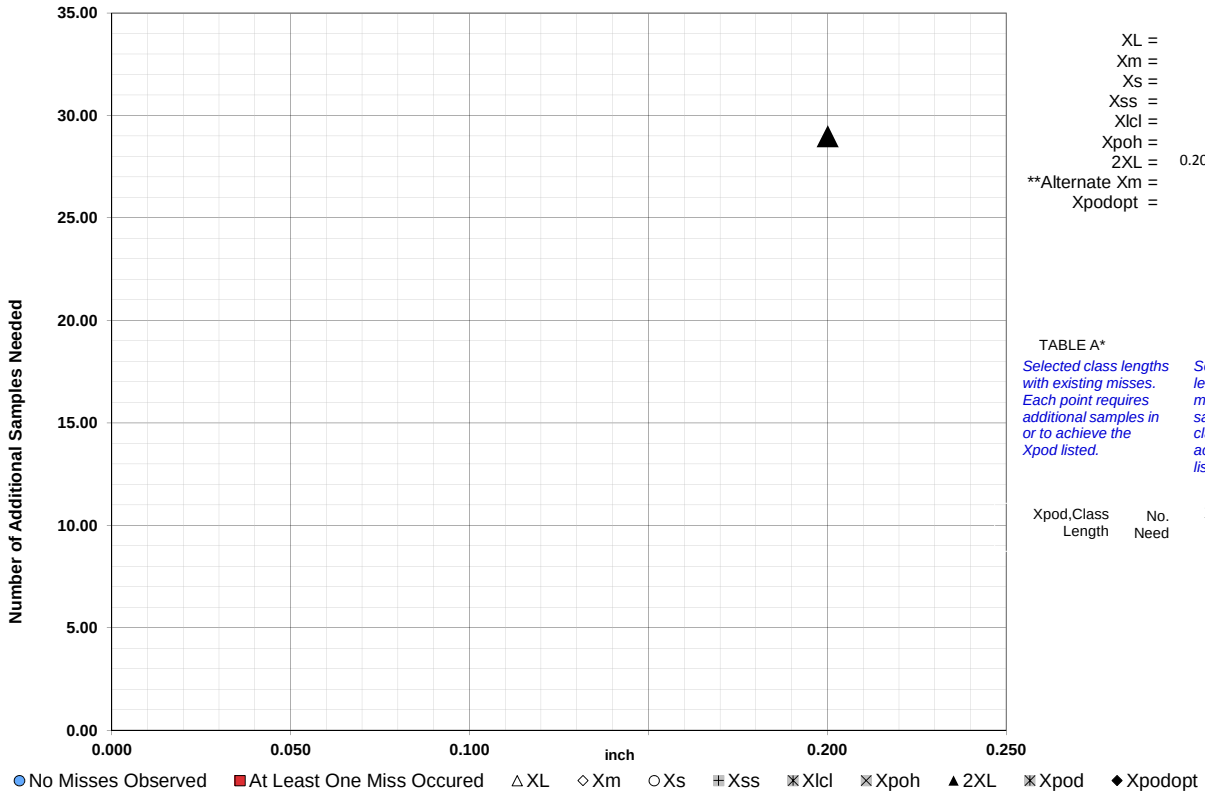



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | |
| Xm = | |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | 0.200 29 |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

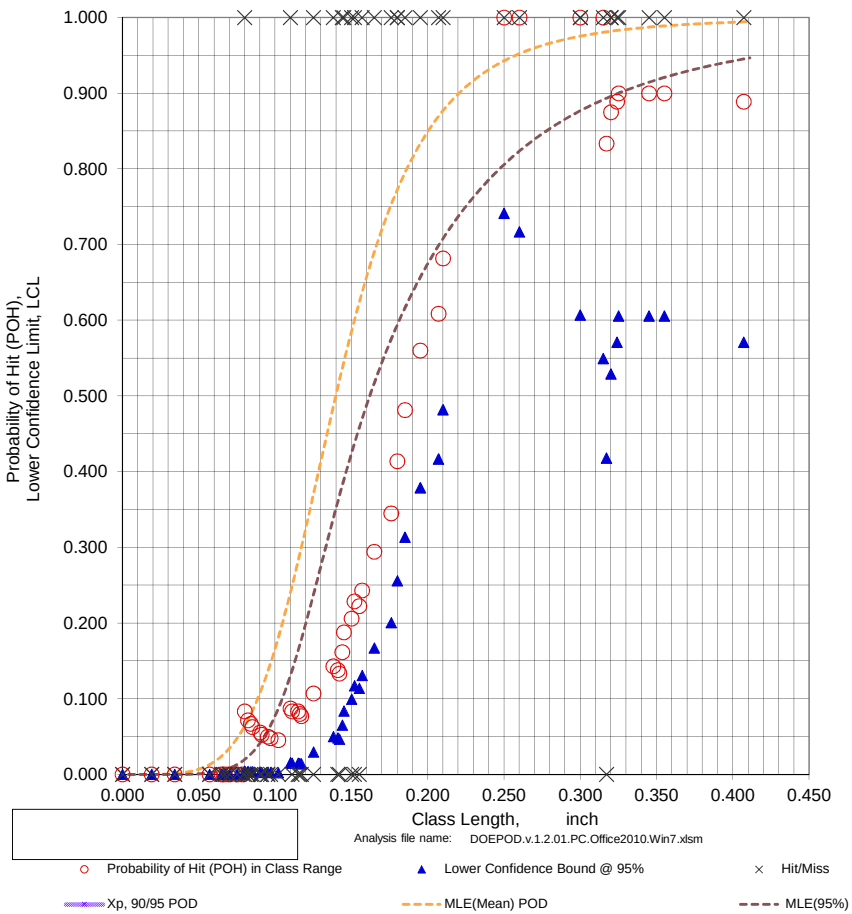
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30651CL.XLS
Data Set Name = F30651CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:39 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0930 | inch |
| Classlength @ Best LCL = | 0.2500 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3200 -0.002 inch 27 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.909 | @ | 0.225 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.325 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30651CL.XLS
Data Set Name = F30651CL(CRK #)

## Directed DOE Options

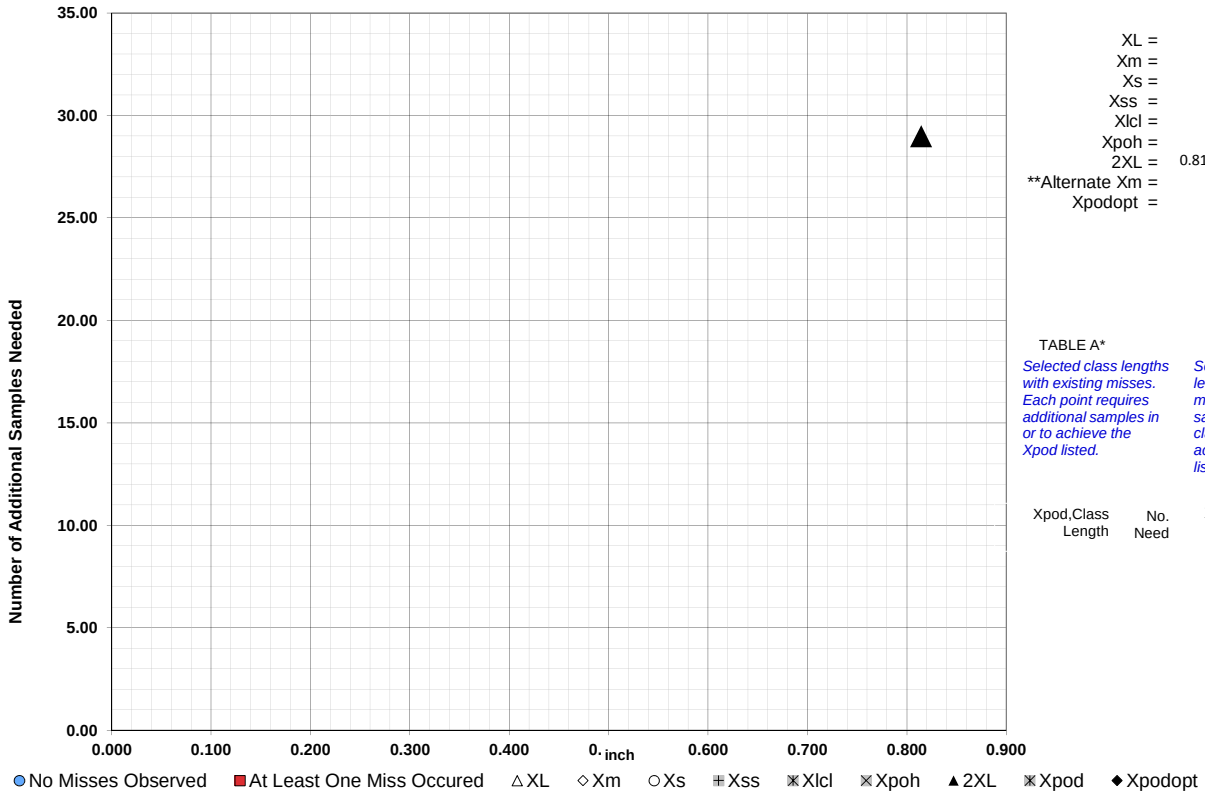



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

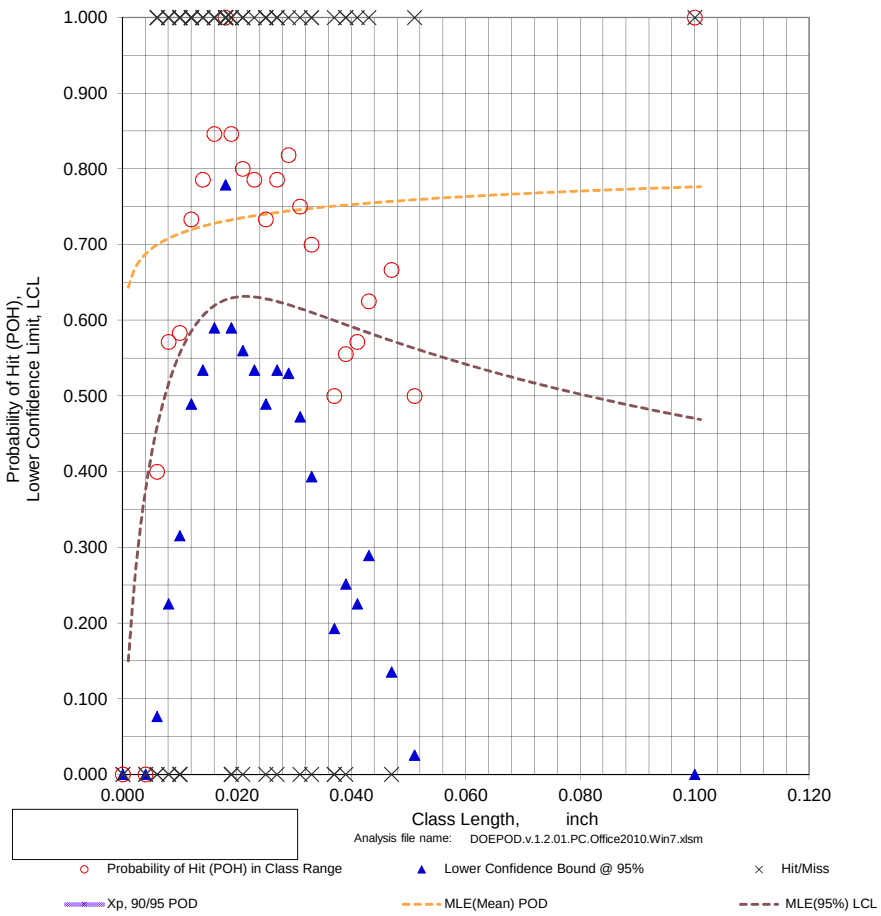
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = F30653AD.XLS
Data Set Name = F30653AD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:40 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7791 | |
| Classwidth @ Best LCL = | 0.0060 | inch |
| Classlength @ Best LCL = | 0.0180 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0510 -0.003 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.100 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.100 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.200 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30653AD.XLS
Data Set Name = F30653AD(CRK #)

## Directed DOE Options

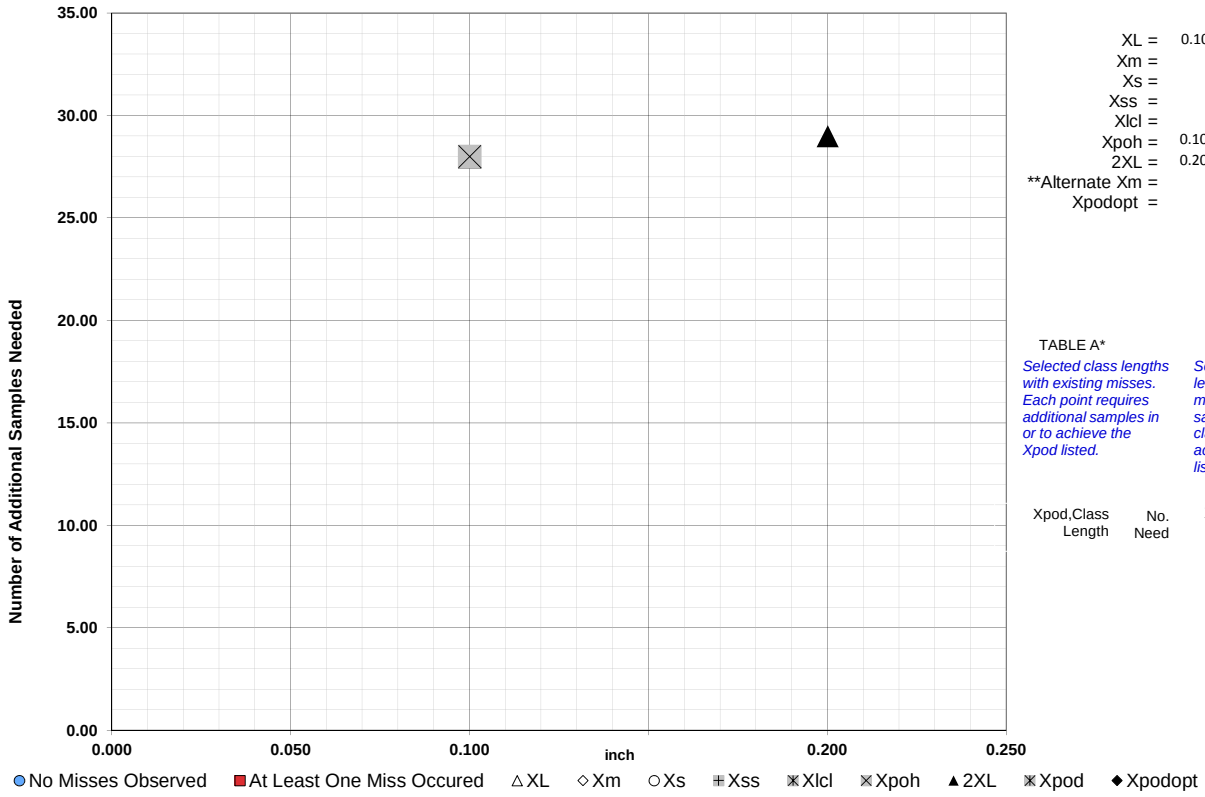



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.100 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.100 | 28 |
| 2XL = | 0.200 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

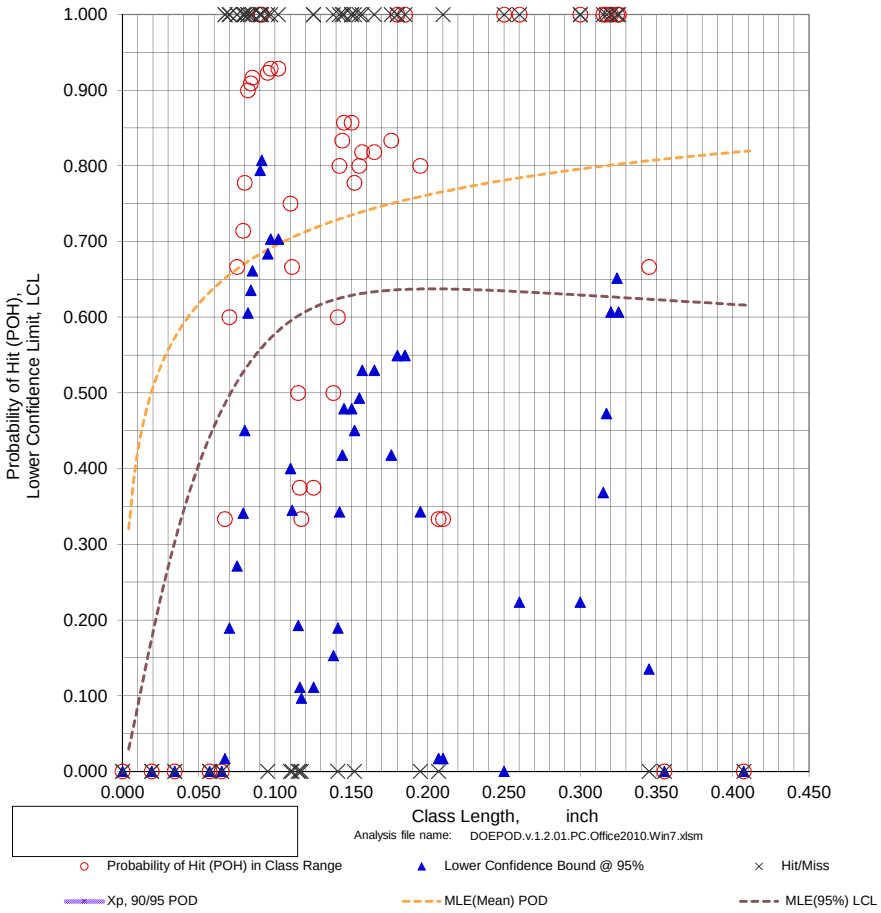
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30653AL.XLS
Data Set Name = F30653AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:41 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8074 | |
| Classwidth @ Best LCL = | 0.0240 | inch |
| Classlength @ Best LCL = | 0.0910 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30653AL.XLS
Data Set Name = F30653AL(CRK #)

## Directed DOE Options

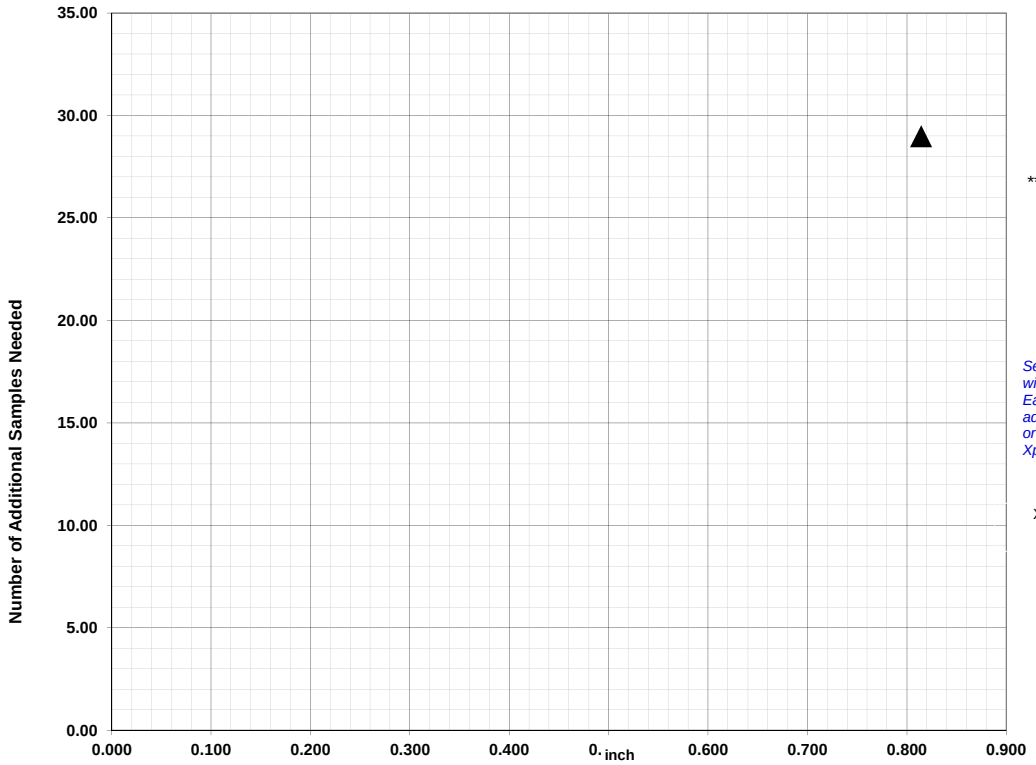



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

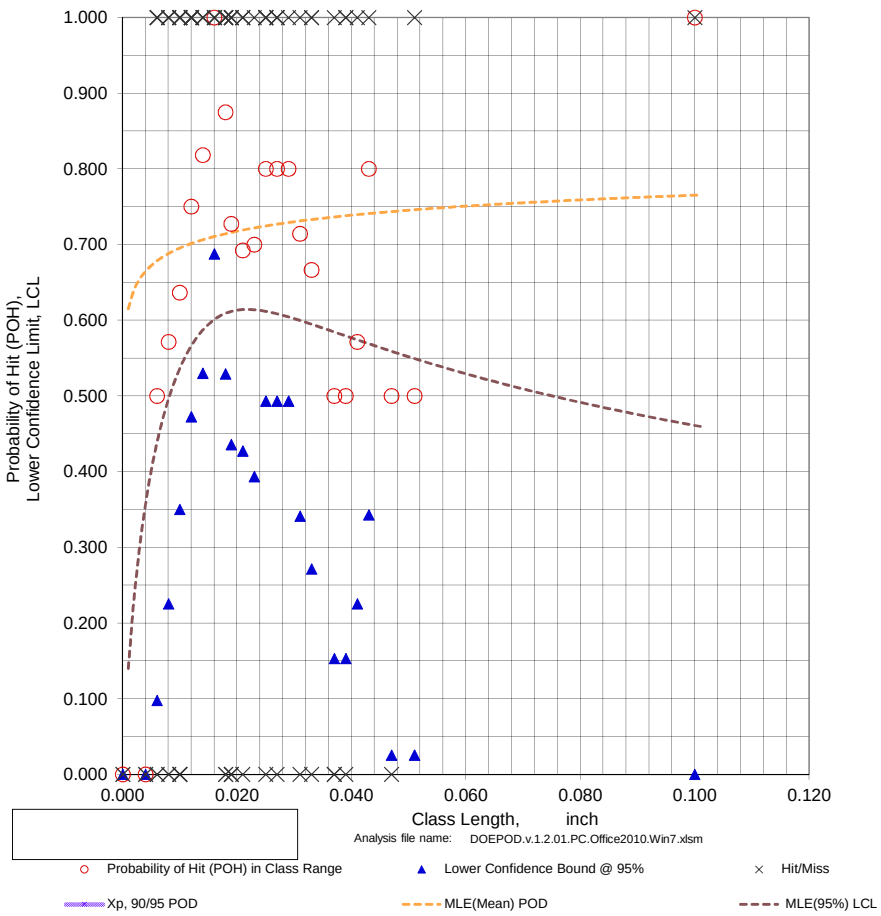
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30653BD.XLS
Data Set Name = F30653BD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:42 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6877 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.0160 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0510 -0.003 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 0.100 | | inch |
| Samples Needed @ XL = | 28 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 0.100 | | inch |
| Samples Needed @ Xpoh = | 28 | | |
| New Largest Classlength , 2XL = | 0.200 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = F30653BD.XLS
Data Set Name = F30653BD(CRK #)

## Directed DOE Options

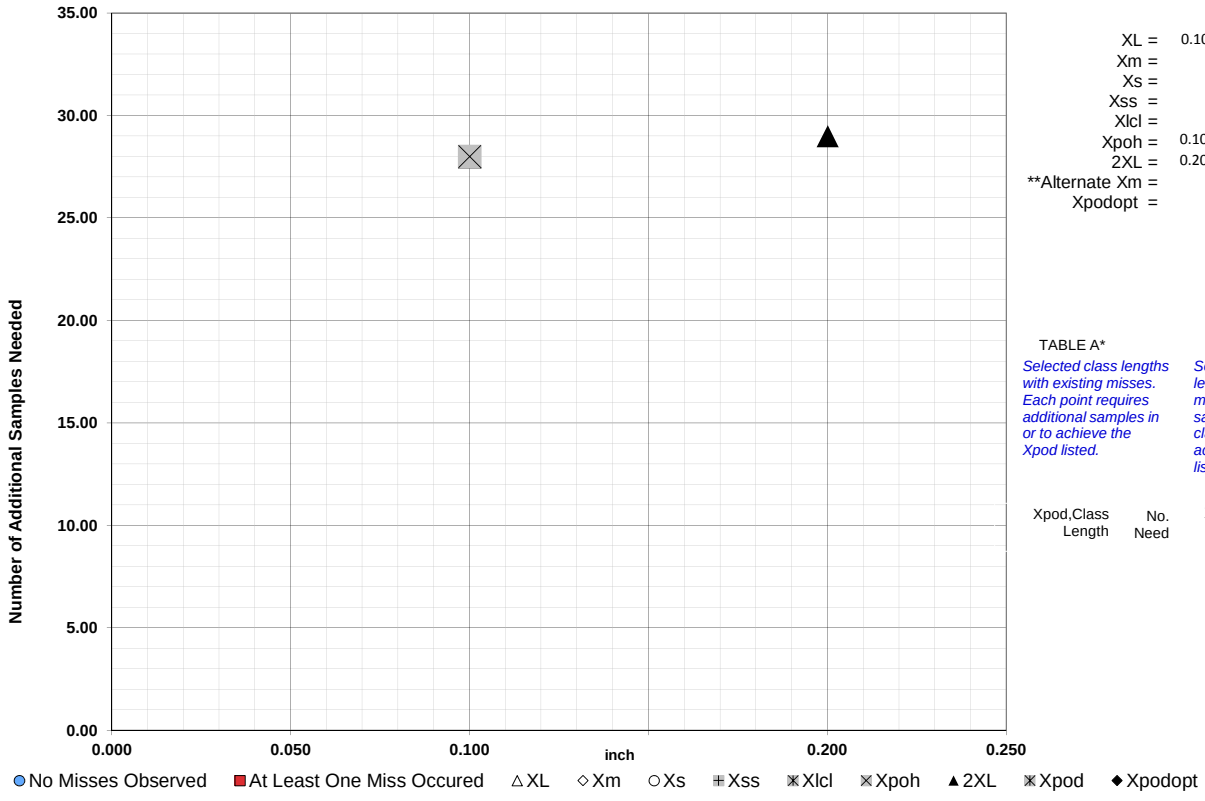



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.100 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.100 | 28 |
| 2XL = | 0.200 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

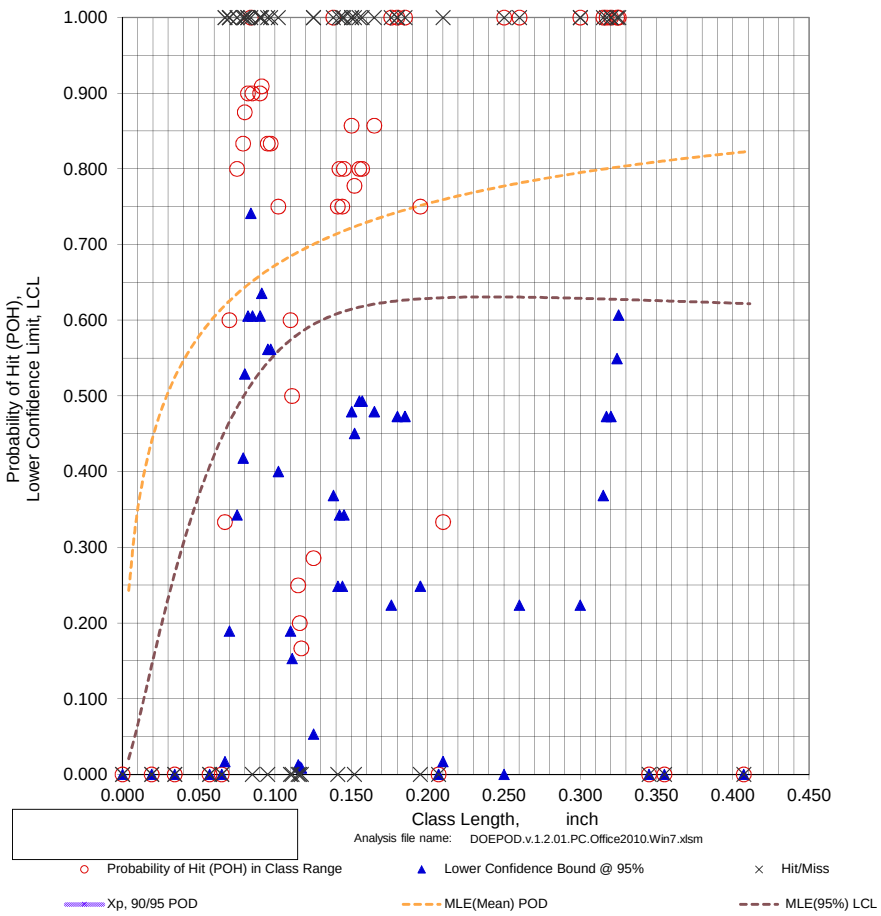
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30653BL.XLS
Data Set Name = F30653BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:43 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0170 | inch |
| Classlength @ Best LCL = | 0.0840 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30653BL.XLS
Data Set Name = F30653BL(CRK #)

## Directed DOE Options

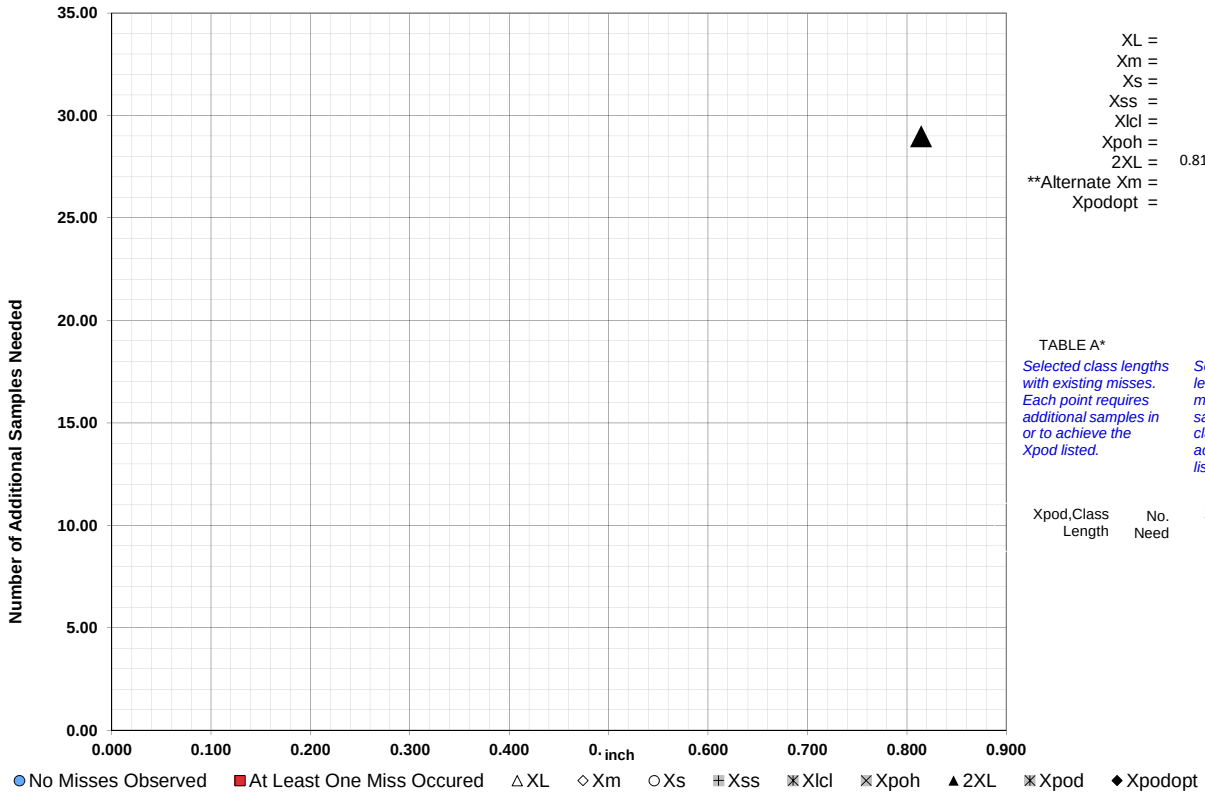



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

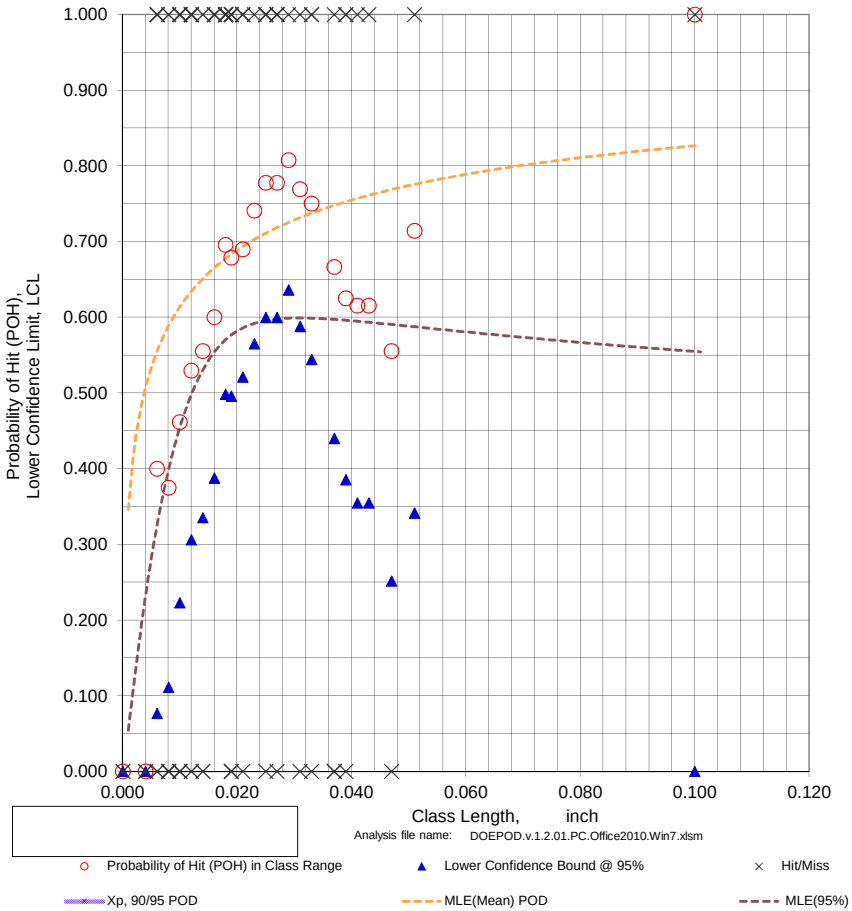
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30653CD.XLS
Data Set Name = F30653CD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:45 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6360 | |
| Classwidth @ Best LCL = | 0.0130 | inch |
| Classlength @ Best LCL = | 0.0290 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.0510 -0.003 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.100 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.100 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.200 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30653CD.XLS
Data Set Name = F30653CD(CRK #)

## Directed DOE Options

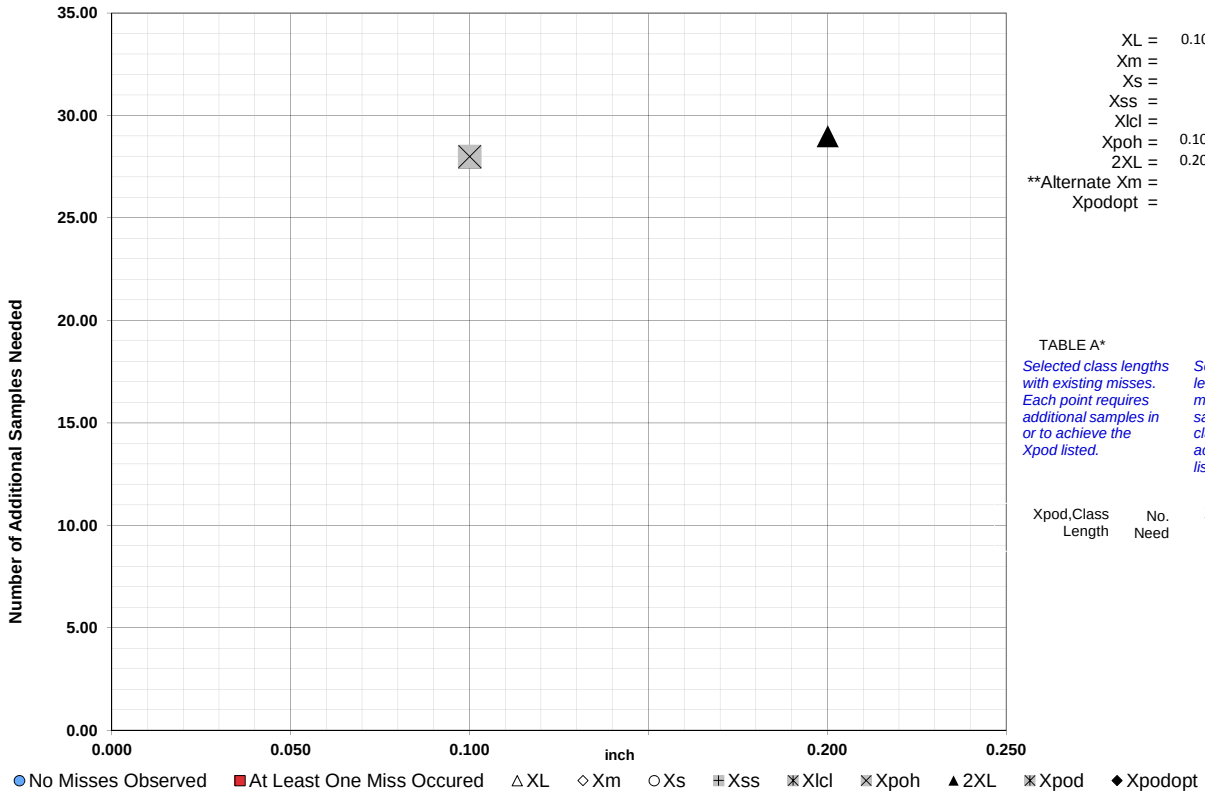



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.100 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.100 | 28 |
| 2XL = | 0.200 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

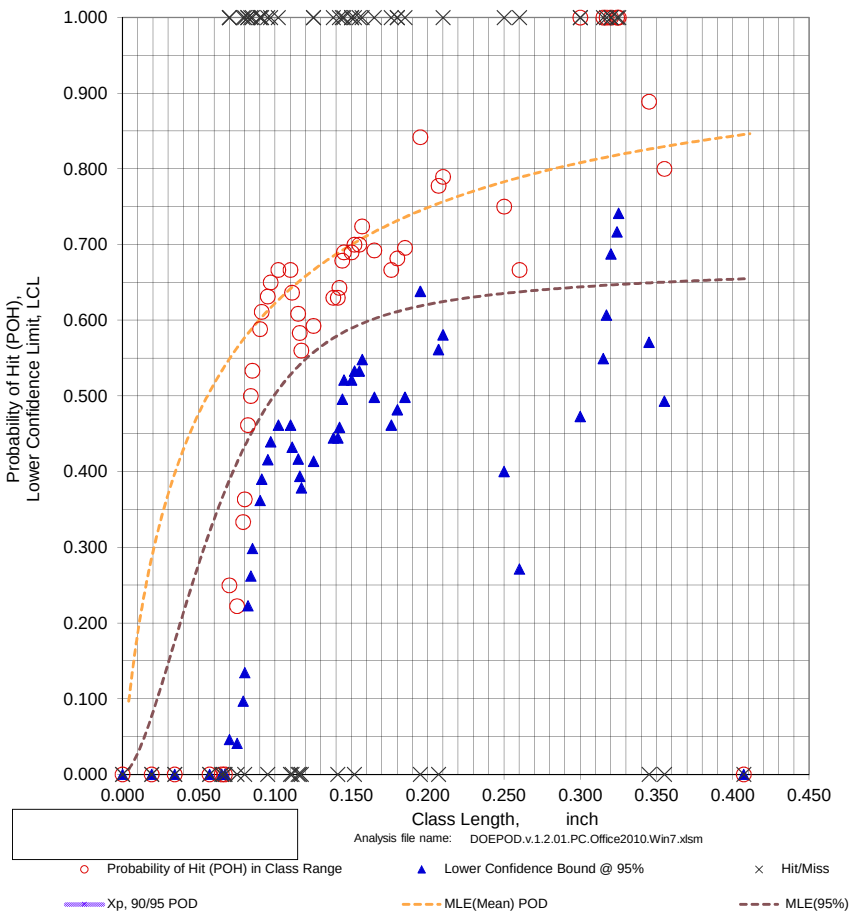
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F30653CL.XLS
Data Set Name = F30653CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:46 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0750 | inch |
| Classlength @ Best LCL = | 0.3250 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.900 @ 0.730 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.814 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F30653CL.XLS
Data Set Name = F30653CL(CRK #)

## Directed DOE Options

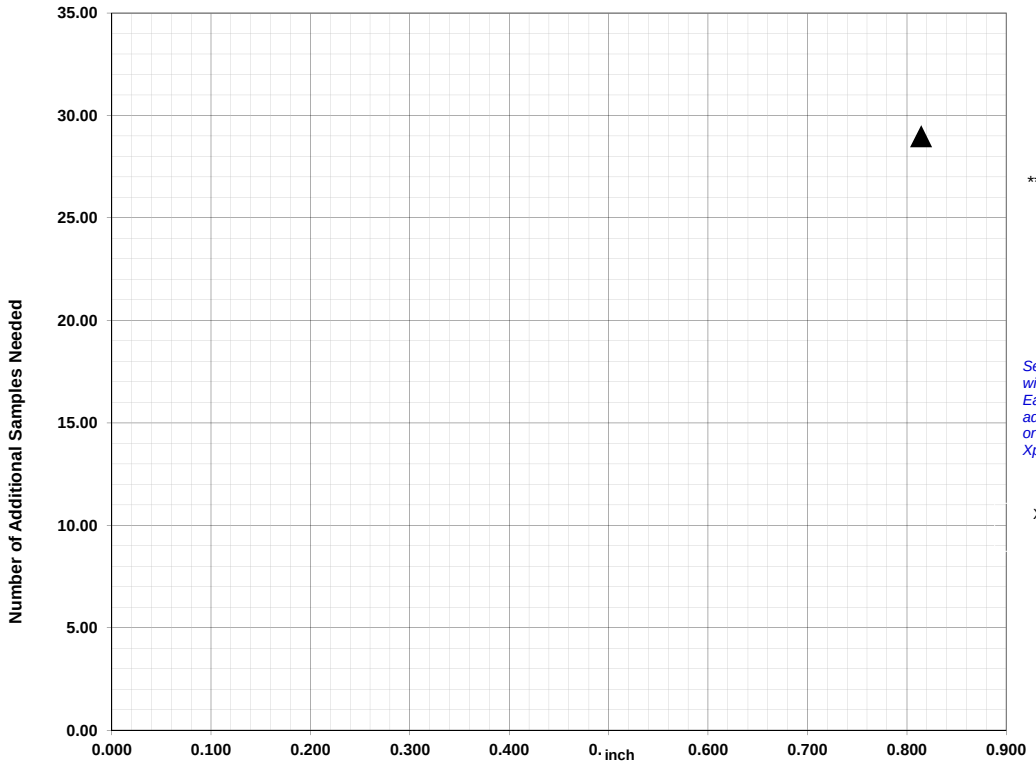



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.814 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

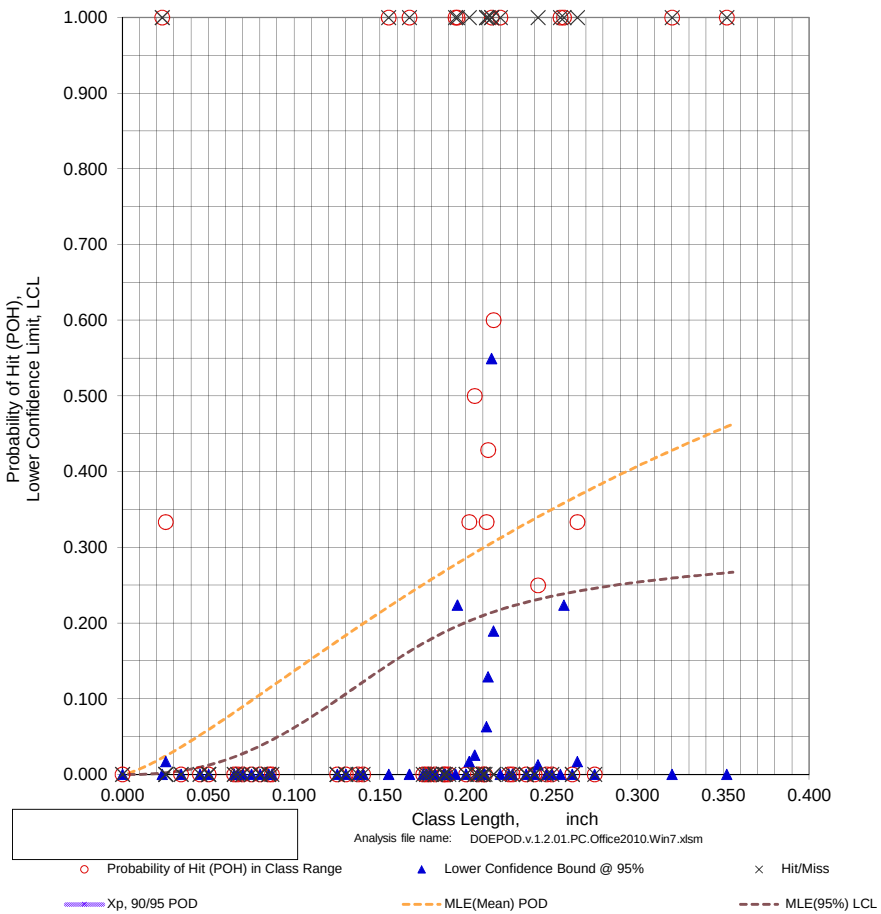
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32251AD.XLS
Data Set Name = F32251AD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:47 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.2150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3200 -0.044 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.352 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.320 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.704 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32251AD.XLS
Data Set Name = F32251AD(CRK #)

## Directed DOE Options

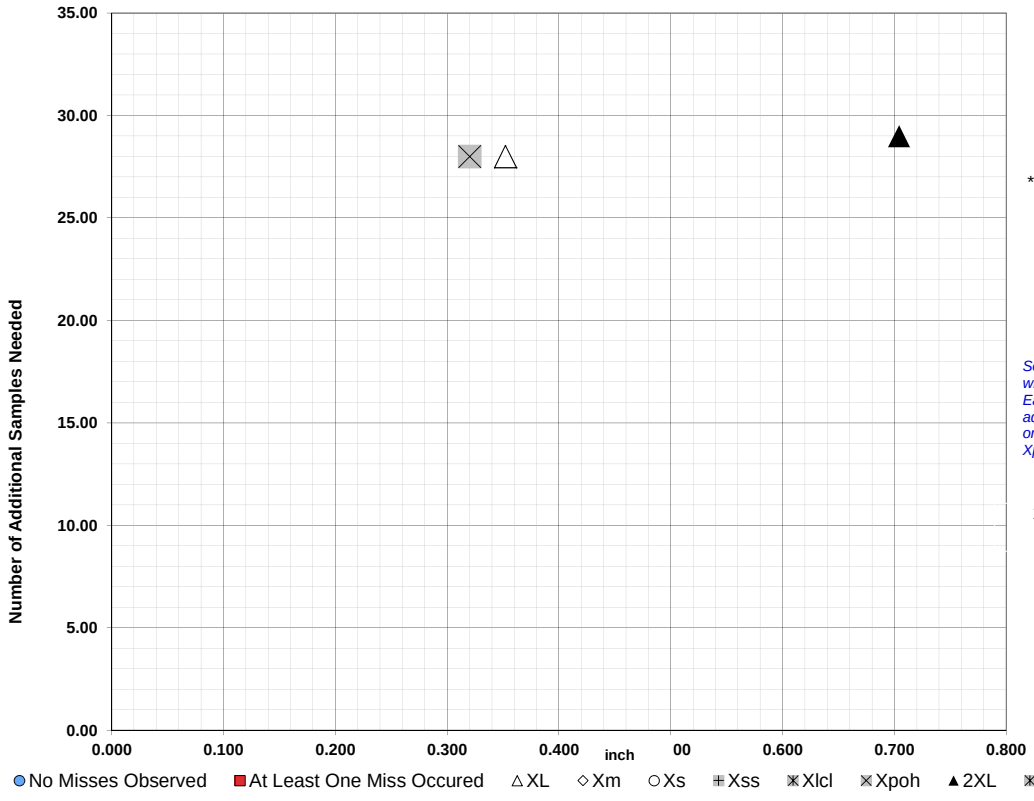



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.352 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.320 | 28 |
| 2XL = | 0.704 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

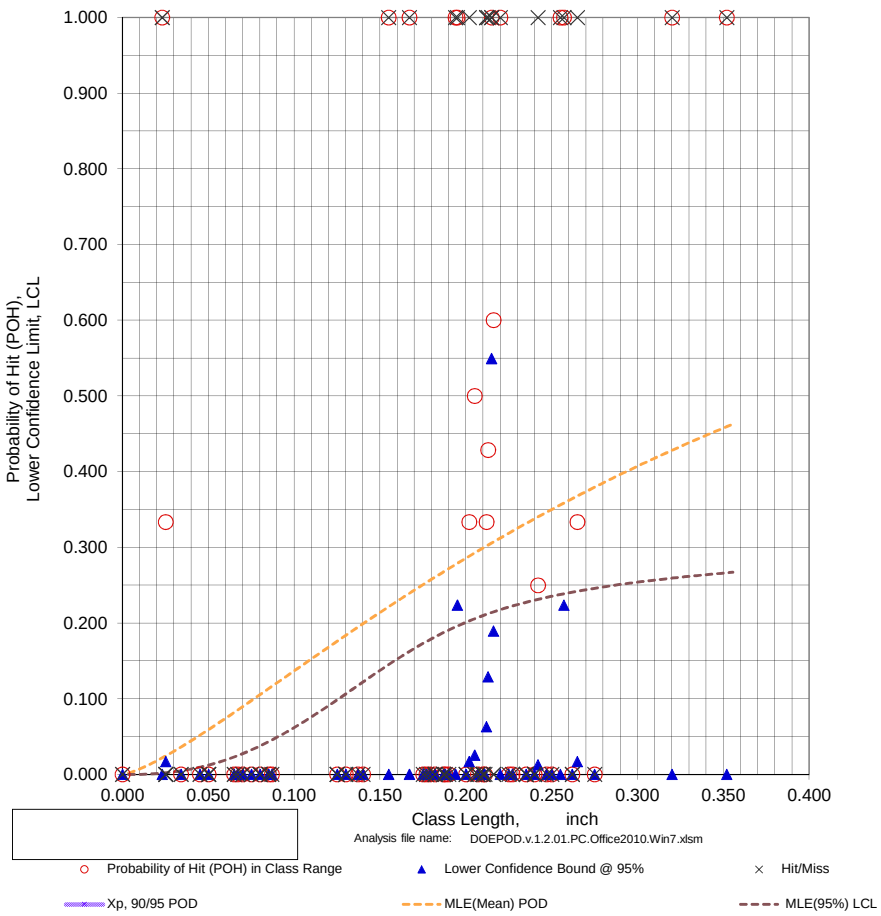
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = F32251AL.XLS
Data Set Name = F32251AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:49 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.2150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3200 -0.044 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.352 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.320 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.704 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32251AL.XLS
Data Set Name = F32251AL(CRK #)

## Directed DOE Options

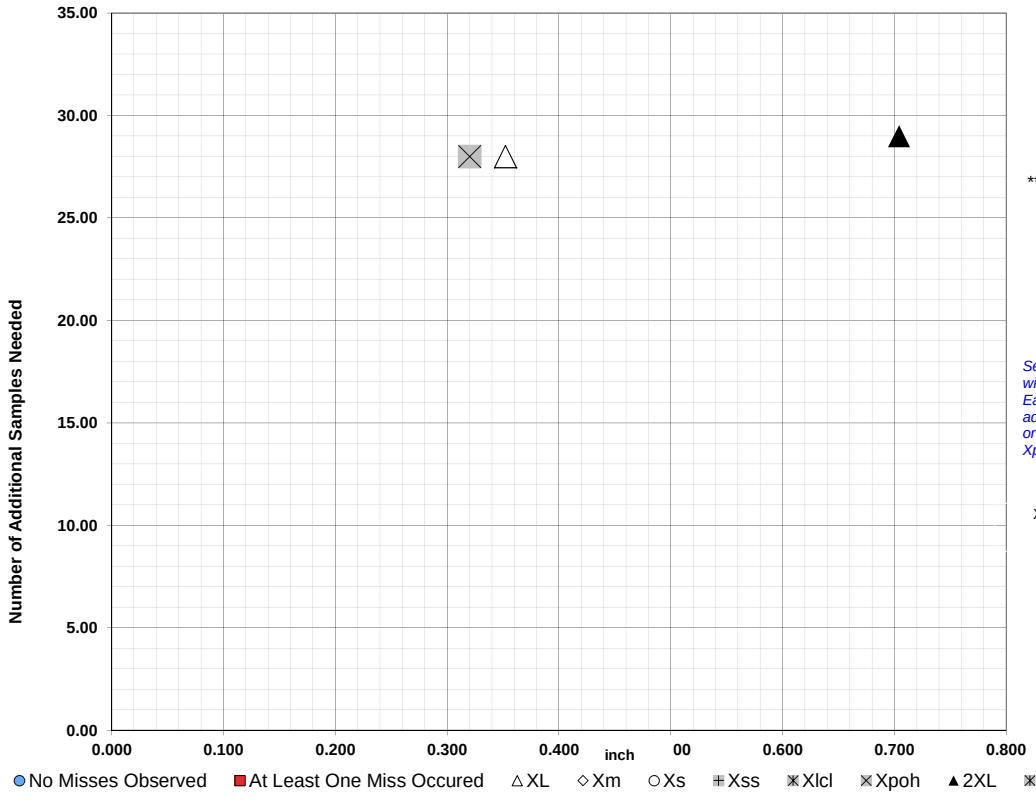



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.352 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.320 | 28 |
| 2XL = | 0.704 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

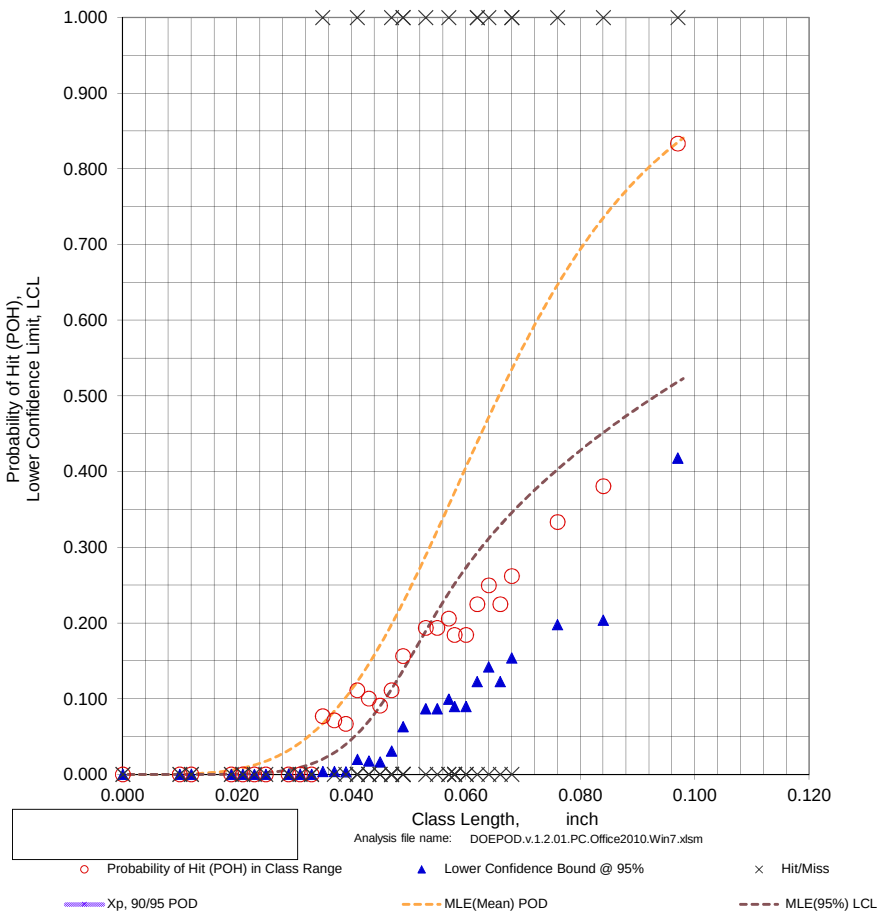
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32251BD.XLS
Data Set Name = F32251BD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:52 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4182 | |
| Classwidth @ Best LCL = | 0.0290 | inch |
| Classlength @ Best LCL = | 0.0970 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0760 -0.007 inch 28 Samples

NTIAC 90% POD = 0.911 @ 0.115 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.194 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32251BD.XLS
Data Set Name = F32251BD(CRK #)

## Directed DOE Options

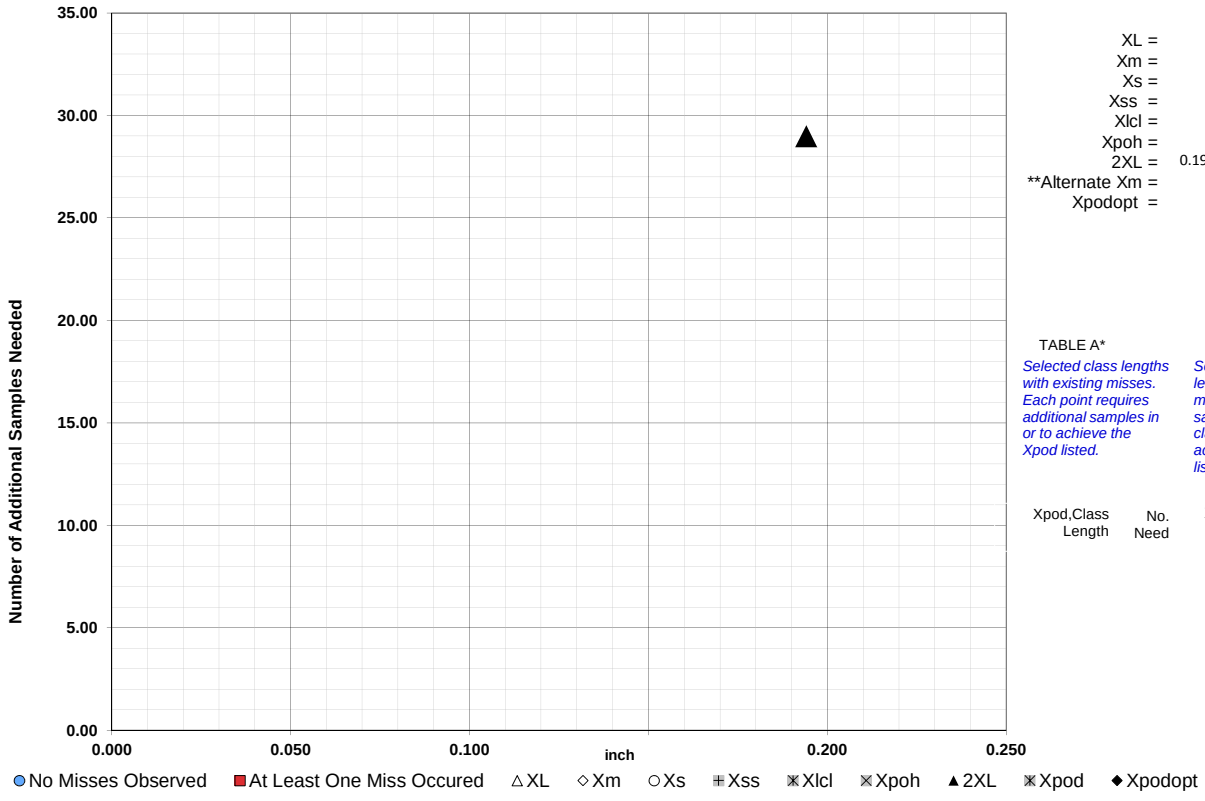



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.194 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

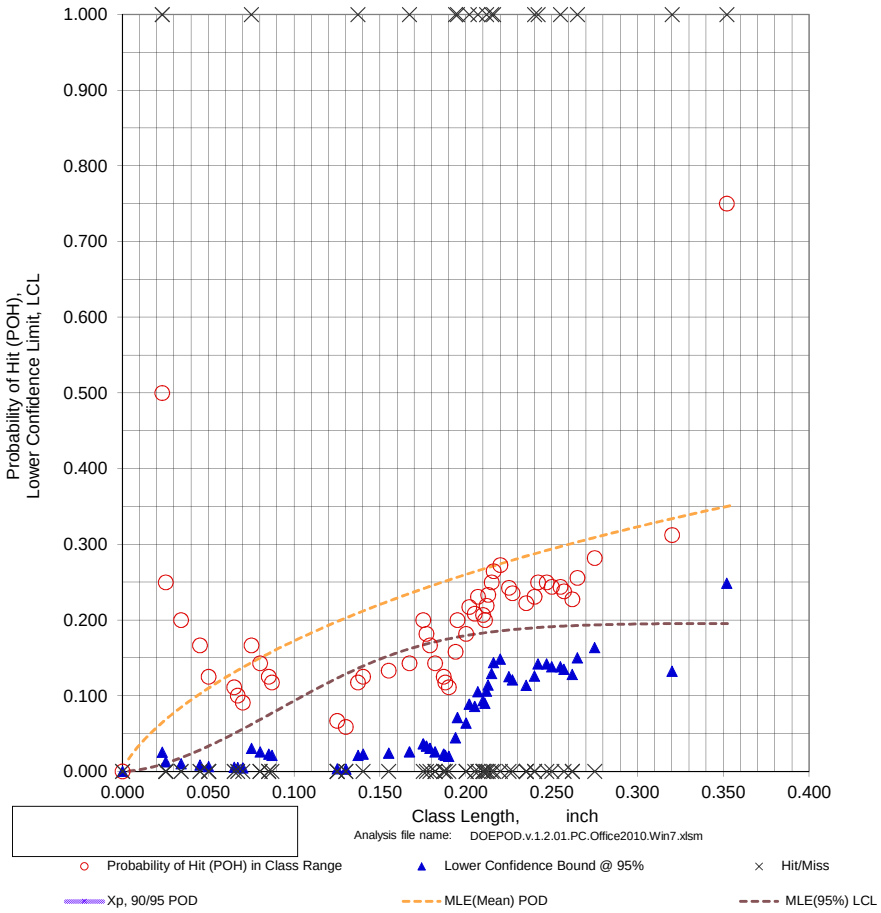
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32251BL.XLS
Data Set Name = F32251BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:53 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2486 | |
| Classwidth @ Best LCL = | 0.0870 | inch |
| Classlength @ Best LCL = | 0.3520 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3200 -0.044 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.704 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32251BL.XLS
Data Set Name = F32251BL(CRK #)

## Directed DOE Options

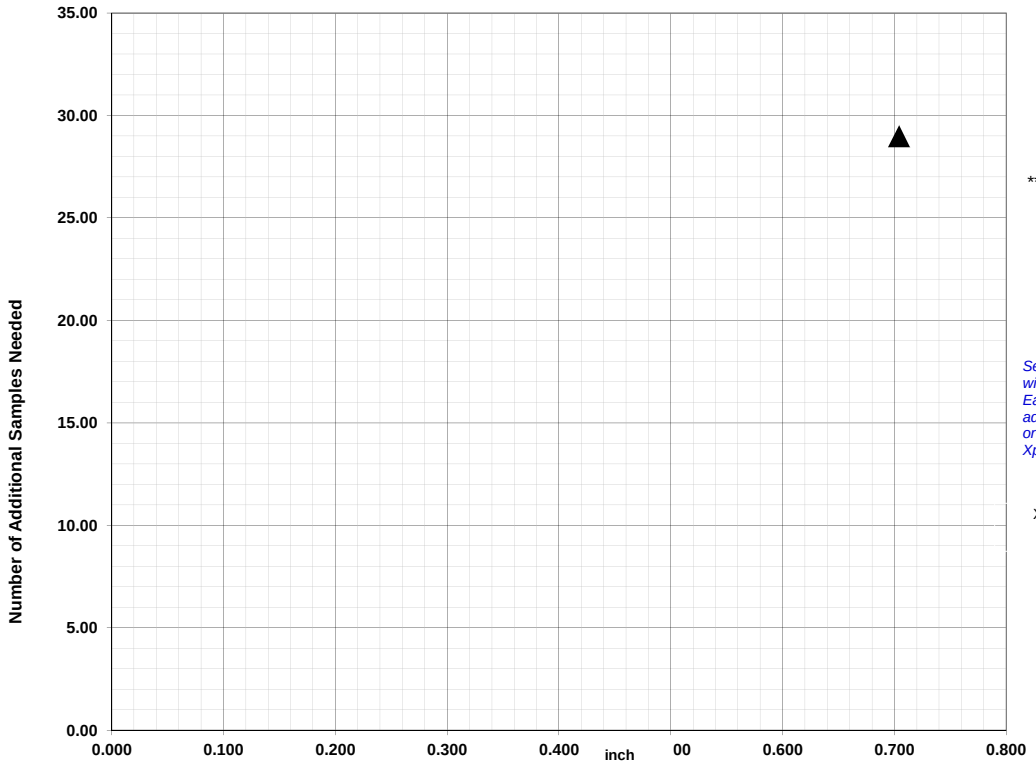



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.704 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

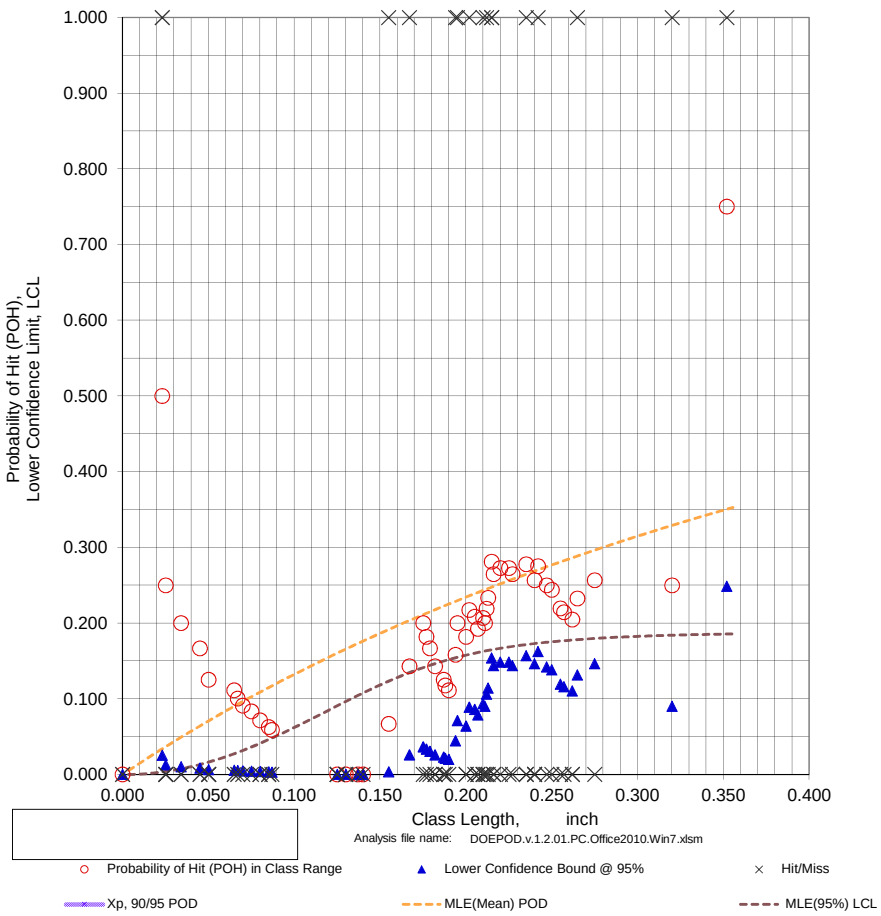
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32251CD.XLS
Data Set Name = F32251CD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:54 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2486 | |
| Classwidth @ Best LCL = | 0.0870 | inch |
| Classlength @ Best LCL = | 0.3520 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3200 -0.044 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.704 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32251CD.XLS
Data Set Name = F32251CD(CRK #)

## Directed DOE Options

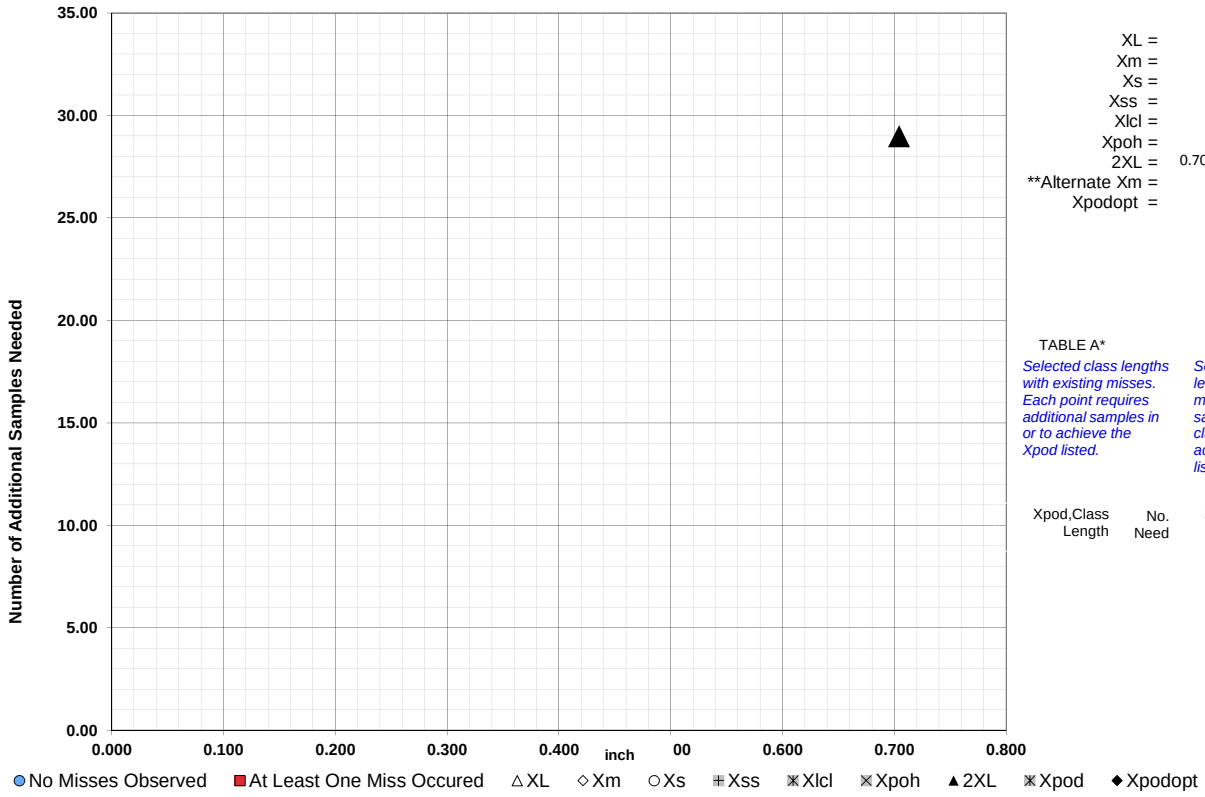



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.704 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

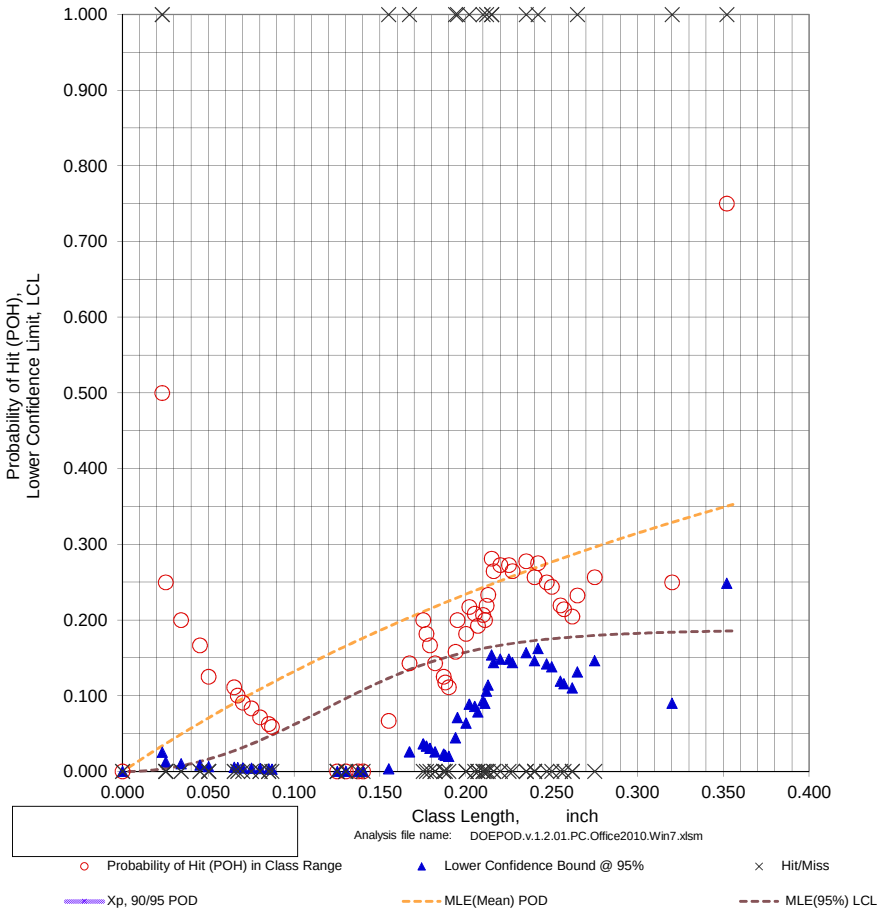
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32251CL.XLS
Data Set Name = F32251CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:55 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2486 | |
| Classwidth @ Best LCL = | 0.0870 | inch |
| Classlength @ Best LCL = | 0.3520 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.3200 -0.044 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.704 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32251CL.XLS
Data Set Name = F32251CL(CRK #)

## Directed DOE Options

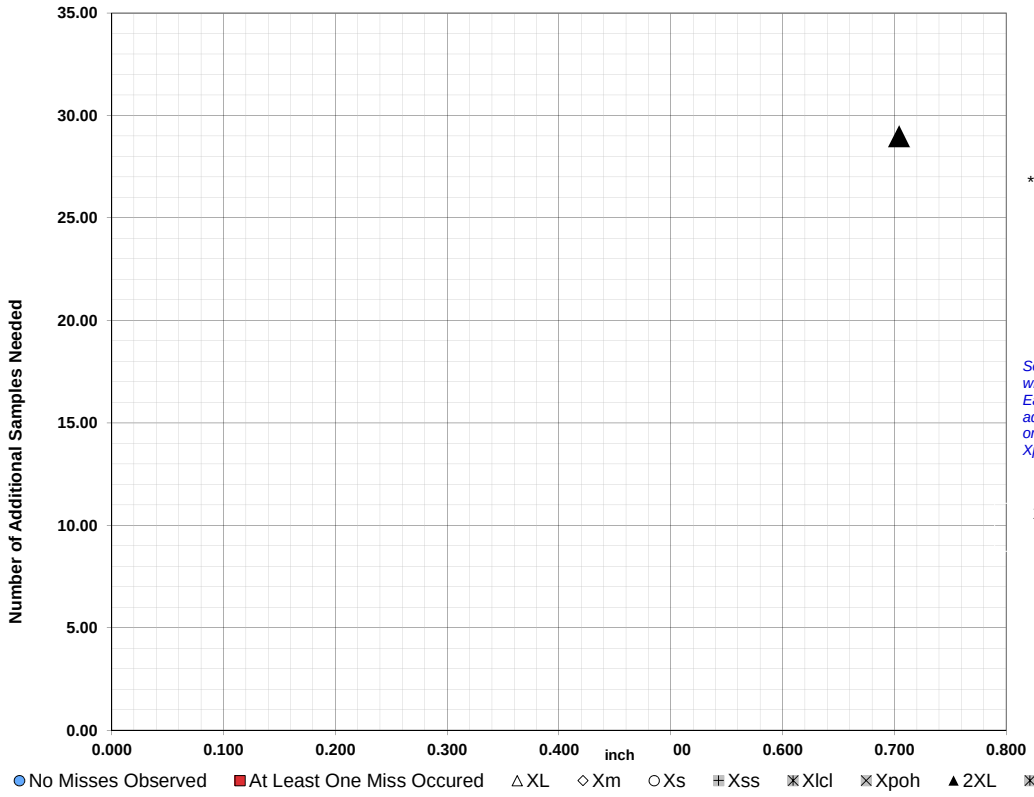



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.704 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

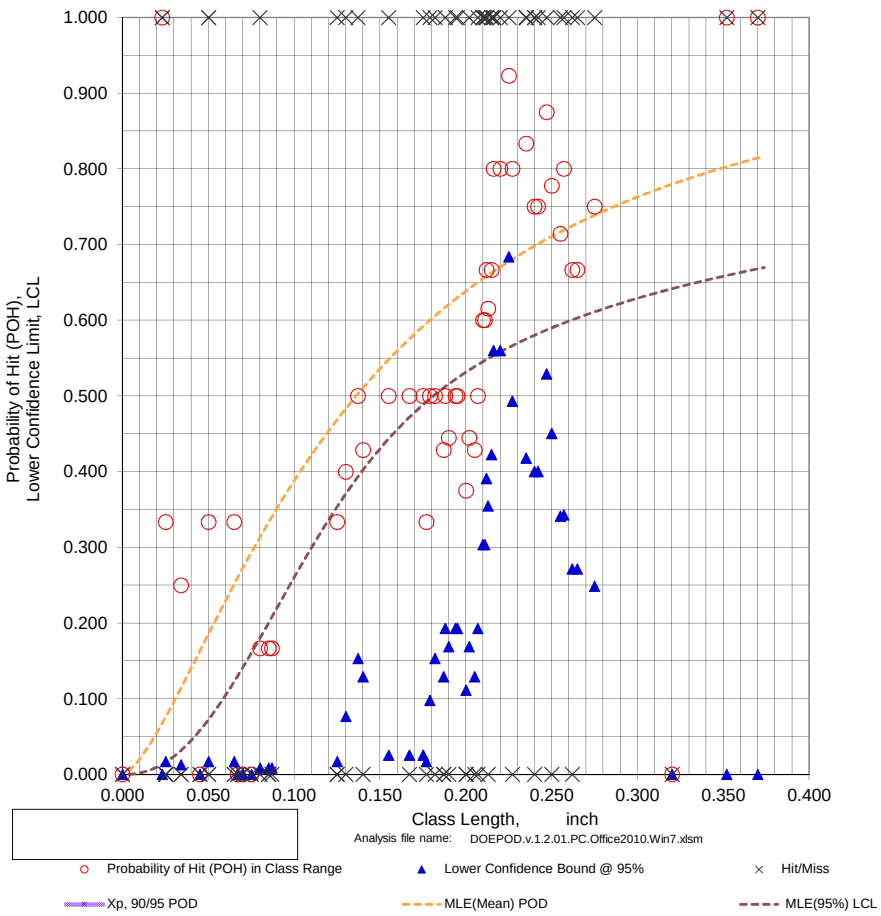
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32253AD.XLS
Data Set Name = F32253AD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:56 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6837 | |
| Classwidth @ Best LCL = | 0.0150 | inch |
| Classlength @ Best LCL = | 0.2250 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3520 -0.031 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.370 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.352 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.740 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32253AD.XLS
Data Set Name = F32253AD(CRK #)

## Directed DOE Options

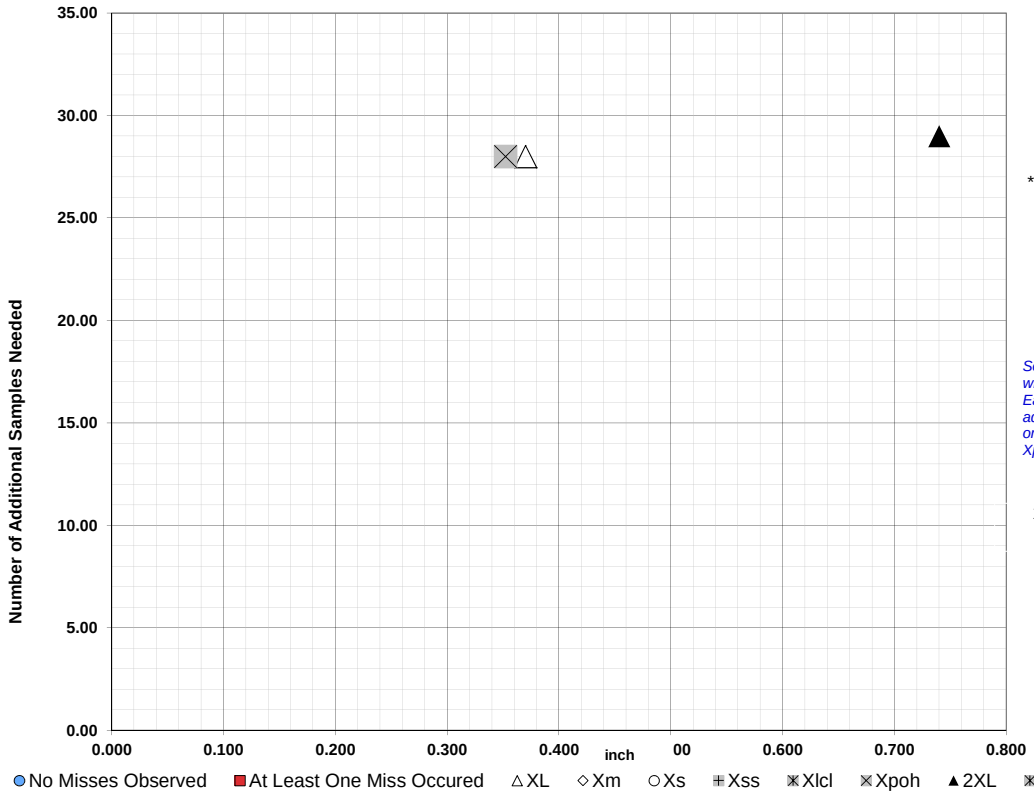



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.370 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.352 | 28 |
| 2XL = | 0.740 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

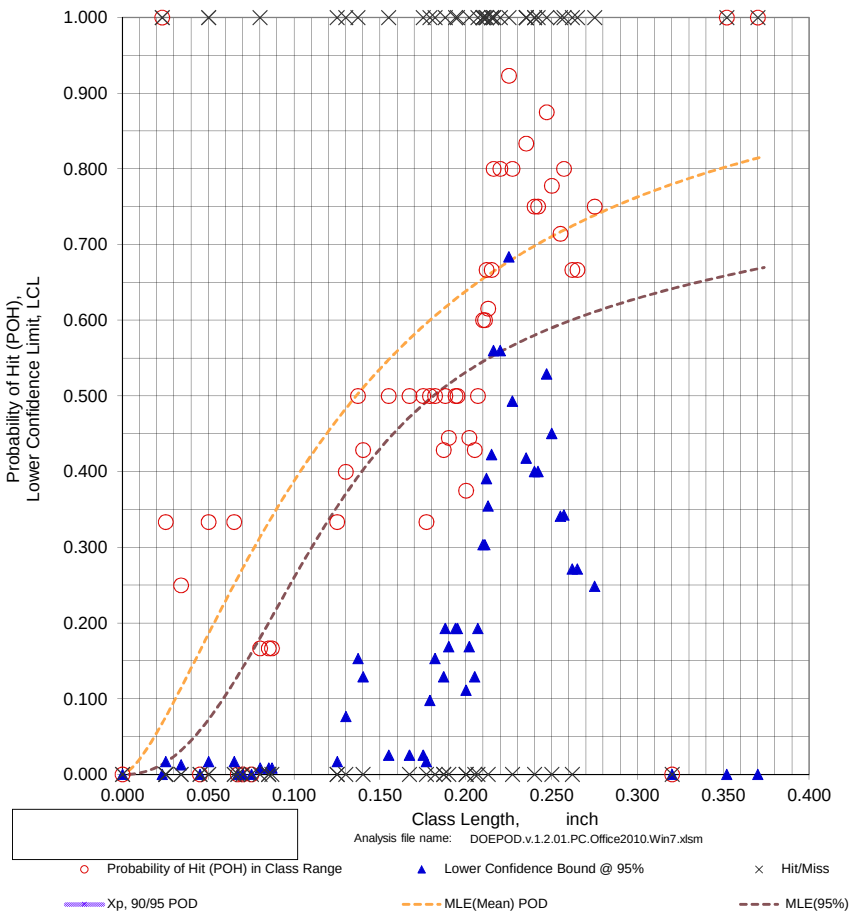
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32253AL.XLS
Data Set Name = F32253AL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:58 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6837 | |
| Classwidth @ Best LCL = | 0.0150 | inch |
| Classlength @ Best LCL = | 0.2250 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3520 -0.031 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.605 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.370 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.352 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.740 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32253AL.XLS
Data Set Name = F32253AL(CRK #)

## Directed DOE Options

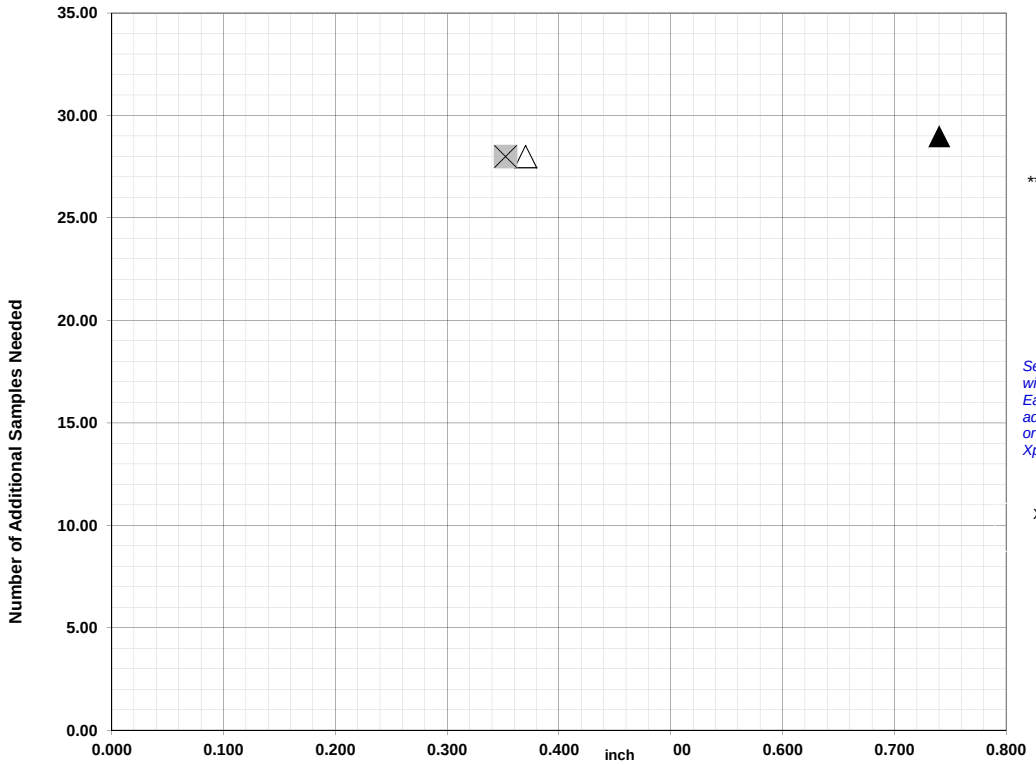



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.370 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.352 | 28 |
| 2XL = | 0.740 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

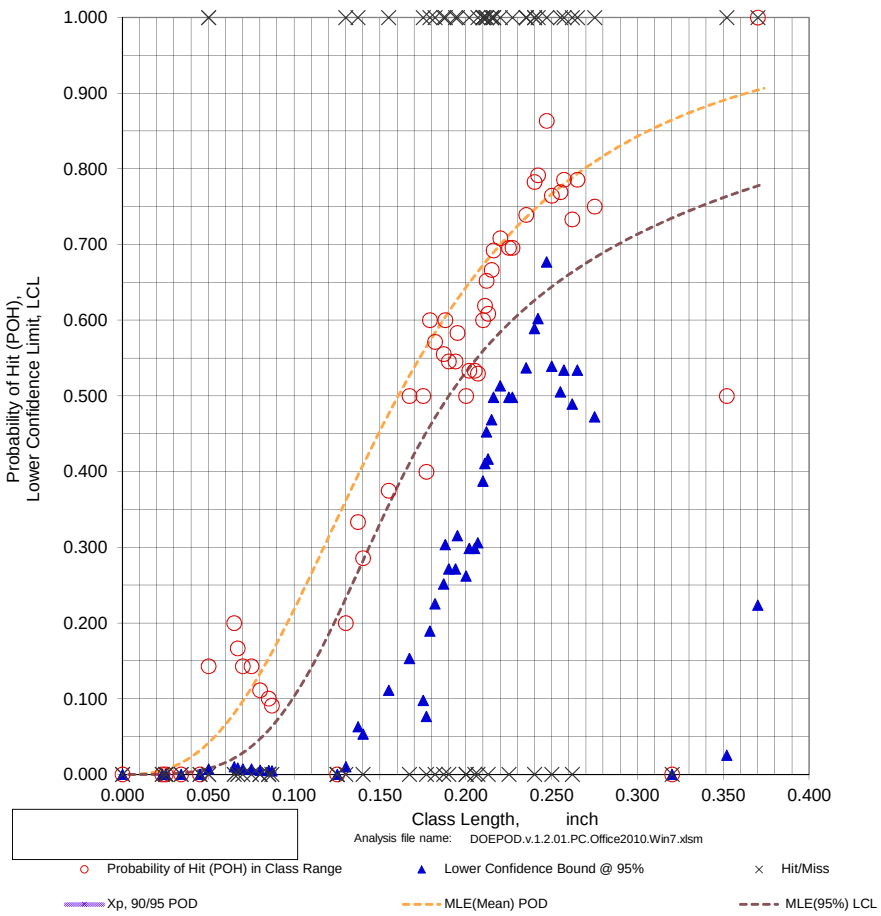
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32253BD.XLS
Data Set Name = F32253BD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 4:59 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6770 | |
| Classwidth @ Best LCL = | 0.0370 | inch |
| Classlength @ Best LCL = | 0.2470 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3520 -0.031 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.370 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.370 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | 0.740 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32253BD.XLS
Data Set Name = F32253BD(CRK #)

## Directed DOE Options

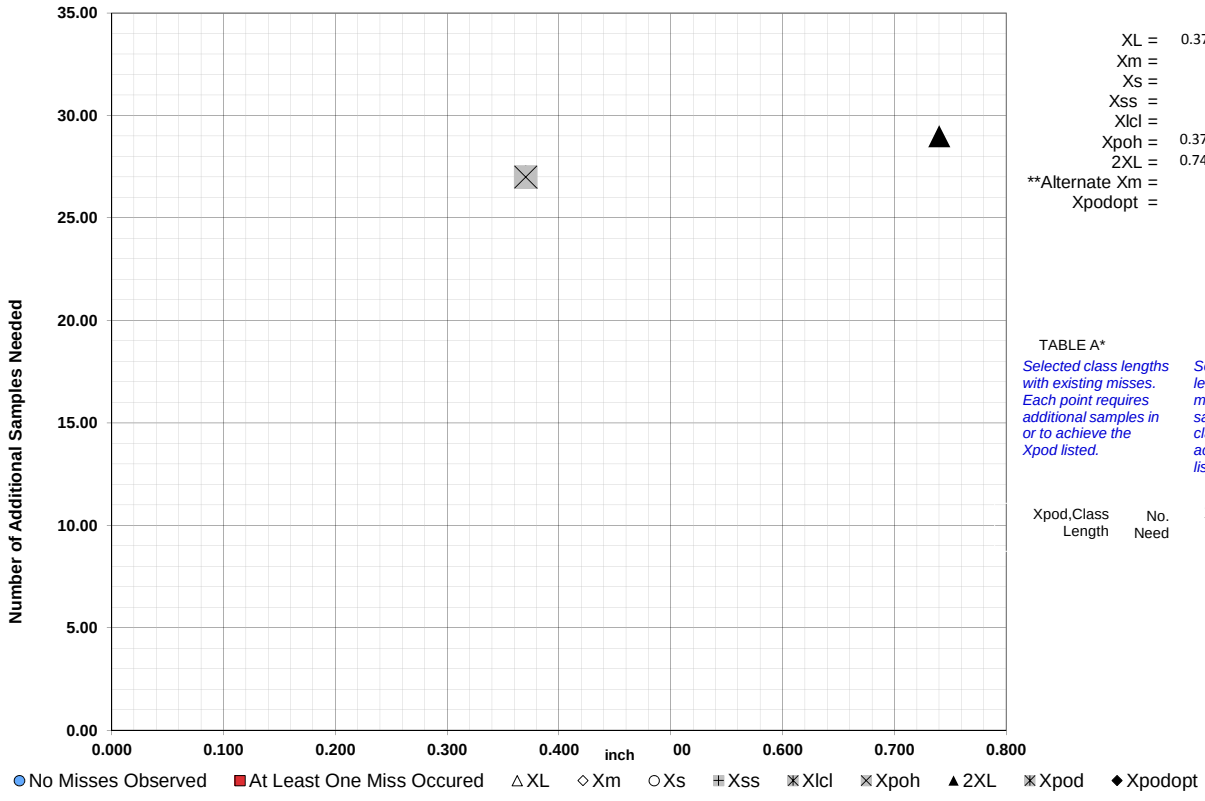



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.370 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.370 | 27 |
| 2XL = | 0.740 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

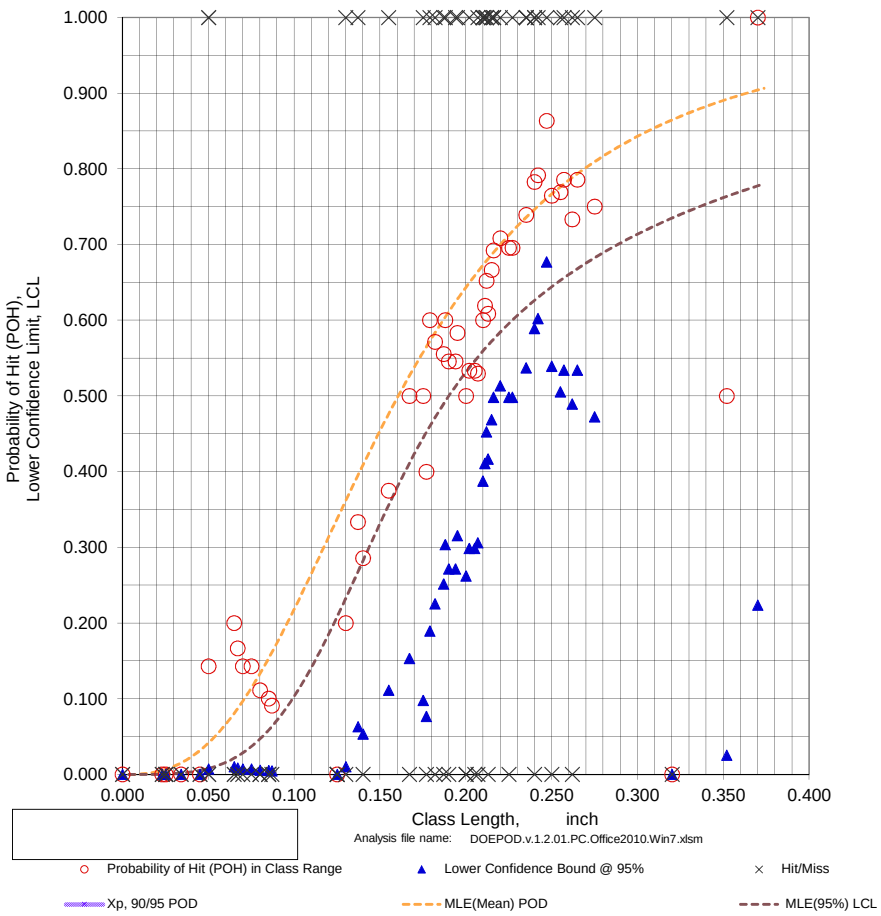
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32253BL.XLS
Data Set Name = F32253BL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:00 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6770 | |
| Classwidth @ Best LCL = | 0.0370 | inch |
| Classlength @ Best LCL = | 0.2470 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3520 -0.031 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.365 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.695 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.370 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.370 | inch |
| Samples Needed @ Xpoh = | 27 | |
| New Largest Classlength , 2XL = | 0.740 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32253BL.XLS
Data Set Name = F32253BL(CRK #)

## Directed DOE Options

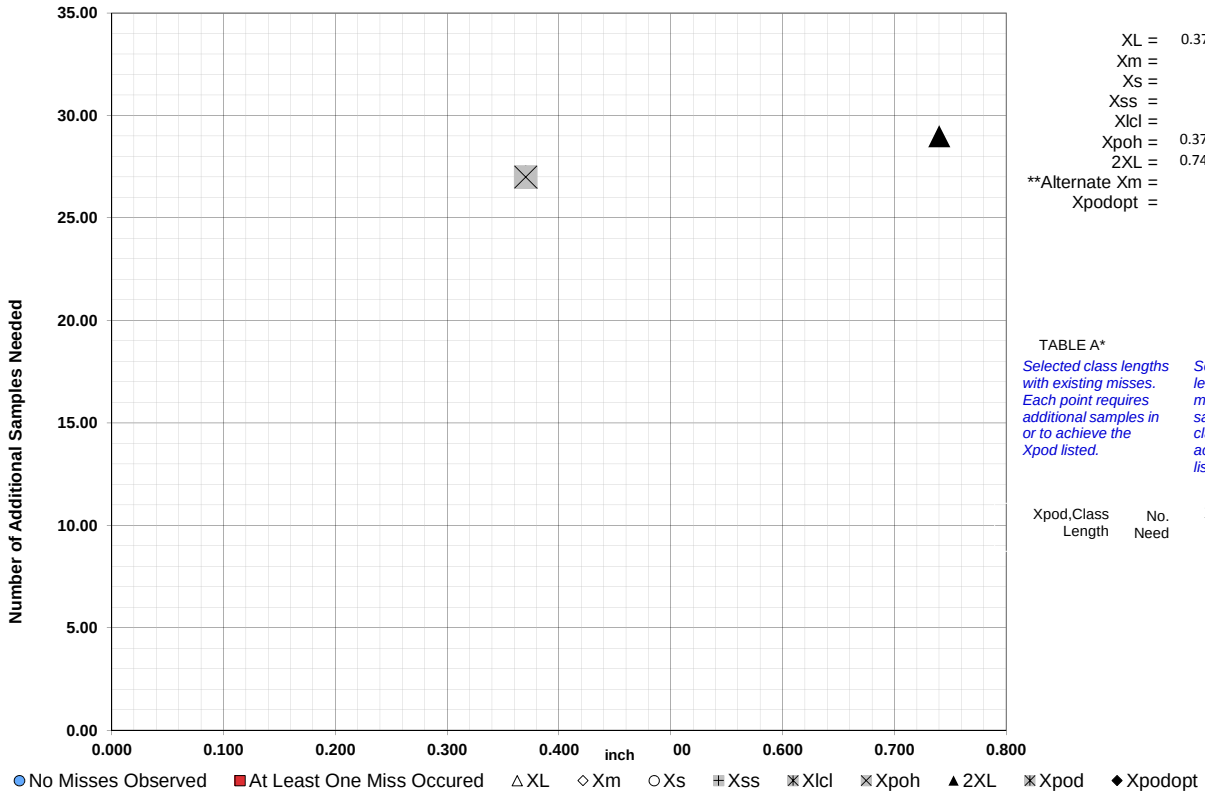



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.370 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.370 | 27 |
| 2XL = | 0.740 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

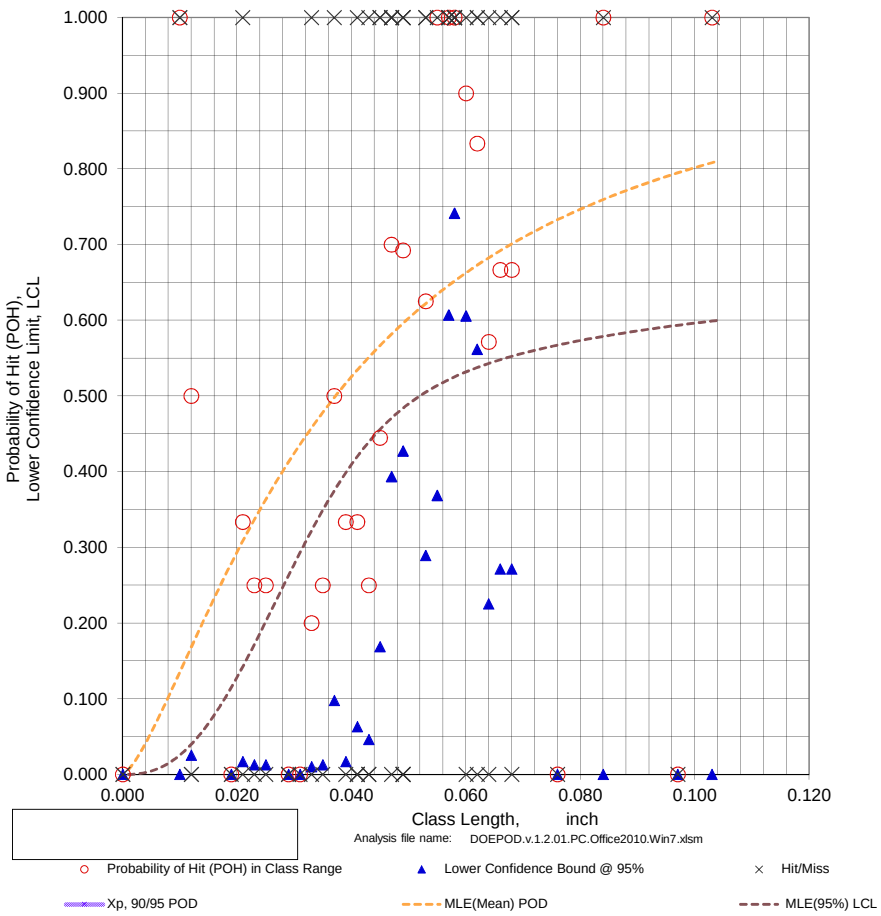
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32253CD.XLS
Data Set Name = F32253CD(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:01 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7411 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.0580 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1030 -0.005 inch 28 Samples

NTIAC 90% POD = 0.903 @ 0.180 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.103 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.103 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.206 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32253CD.XLS
Data Set Name = F32253CD(CRK #)

## Directed DOE Options

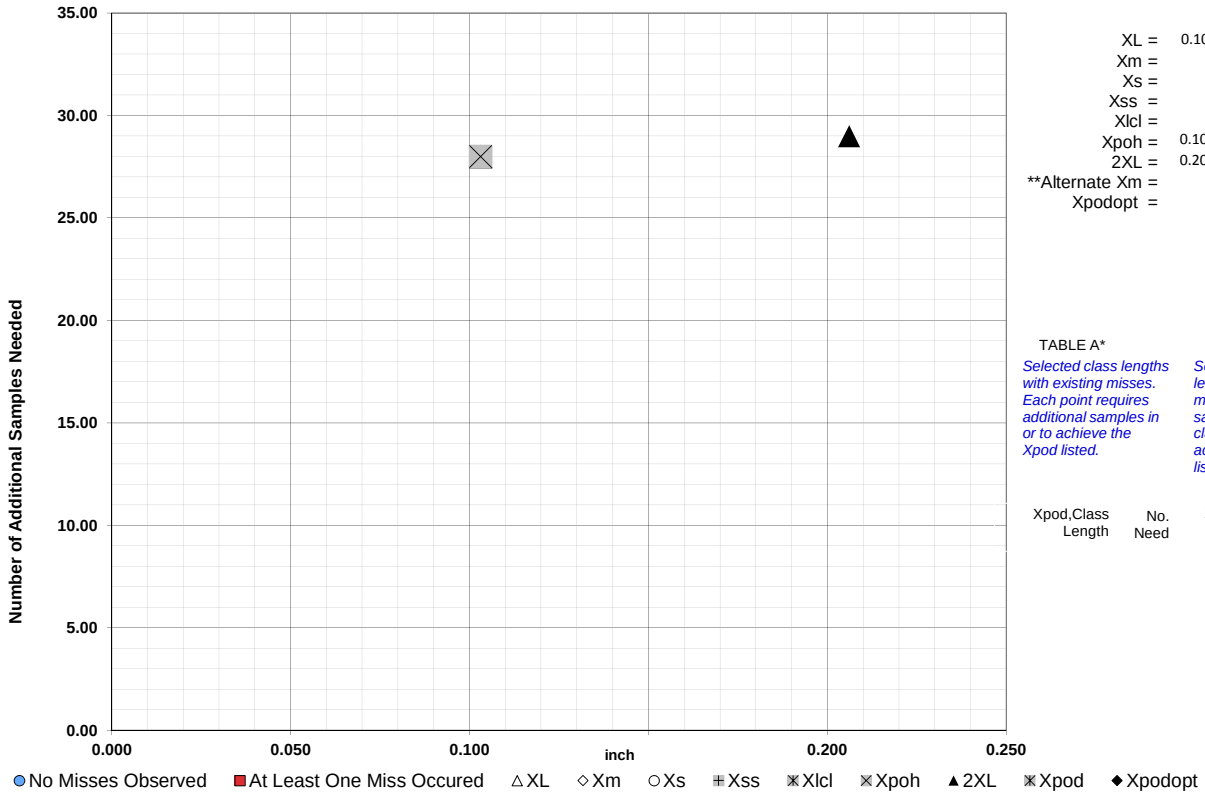



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.103 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.103 | 28 |
| 2XL = | 0.206 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

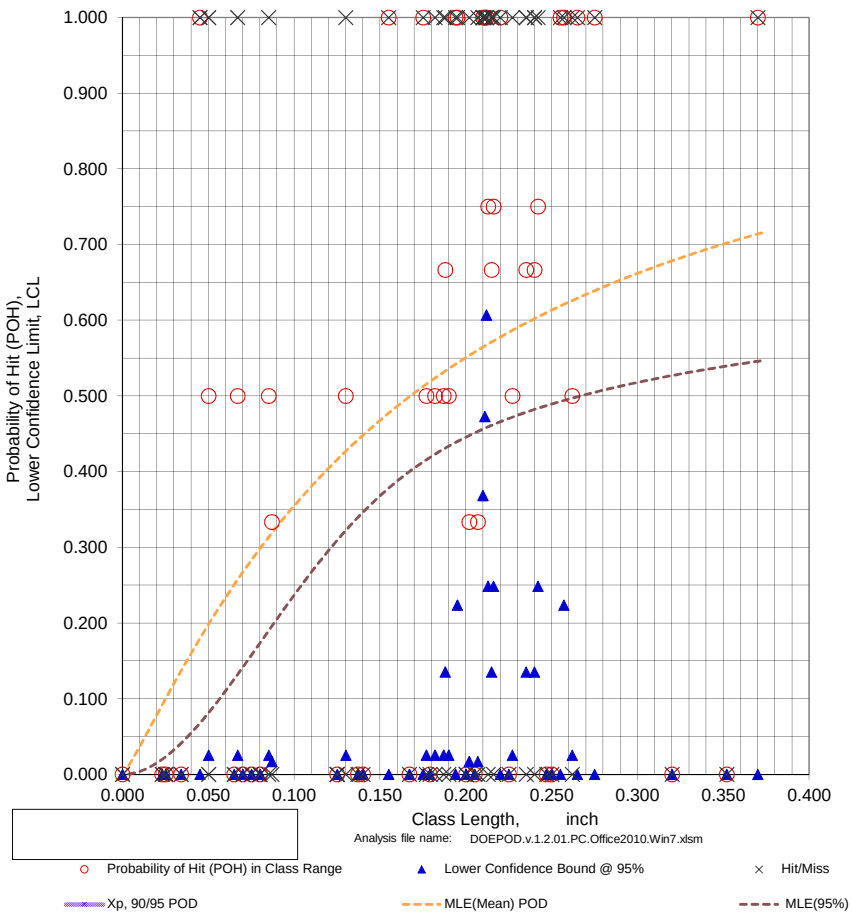
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F32253CL.XLS
Data Set Name = F32253CL(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:03 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0020 | inch |
| Classlength @ Best LCL = | 0.2120 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.3700 -0.017 inch 28 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |
| Largest Classlength , XL = | 0.370 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.370 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.740 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F32253CL.XLS
Data Set Name = F32253CL(CRK #)

## Directed DOE Options

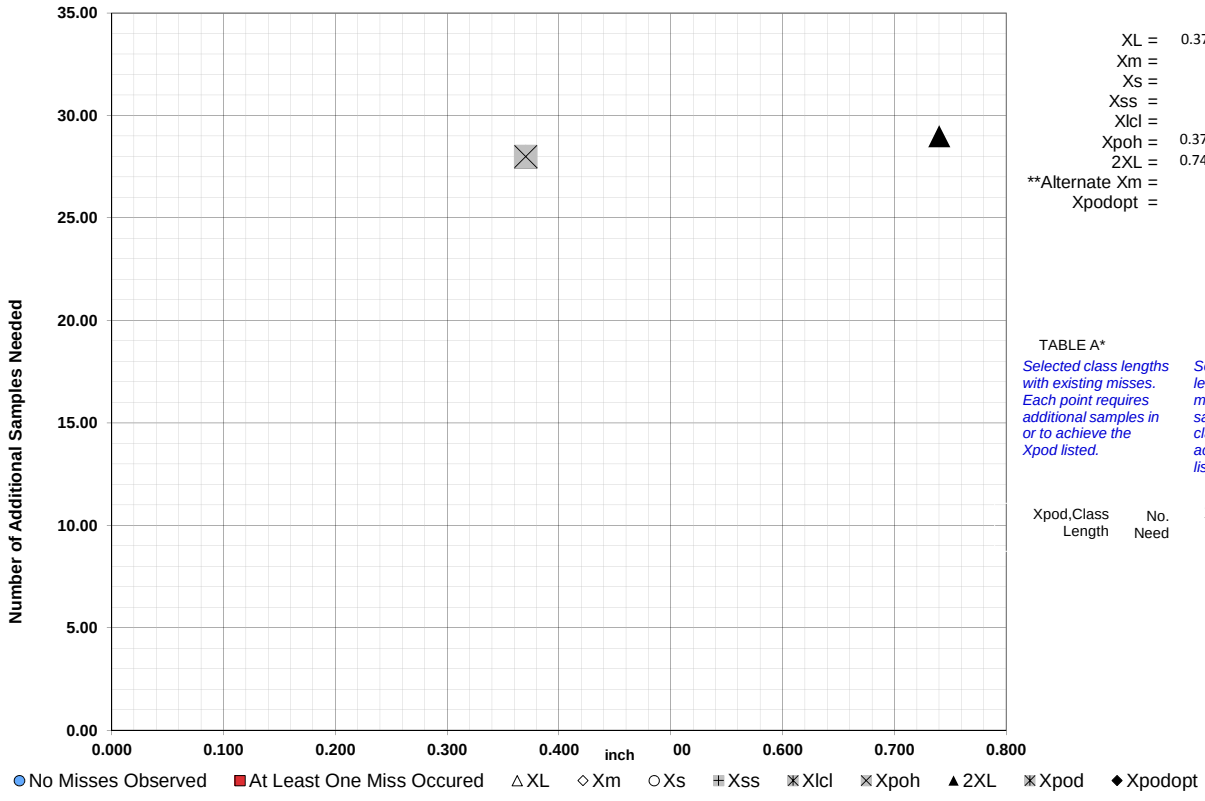



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.370 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.370 | 28 |
| 2XL = | 0.740 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

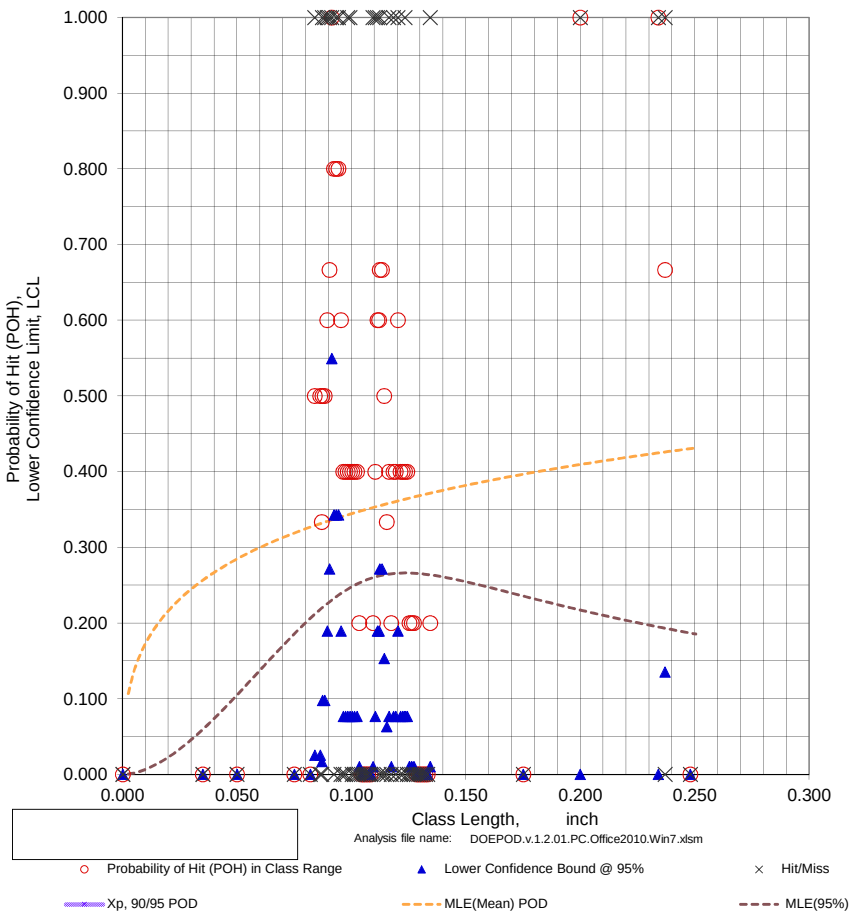
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F40601A.XLS
Data Set Name = F40601A(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:04 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5493 | |
| Classwidth @ Best LCL = | 0.0040 | inch |
| Classlength @ Best LCL = | 0.0913 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.496 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F40601A.XLS
Data Set Name = F40601A(CRK #)

## Directed DOE Options

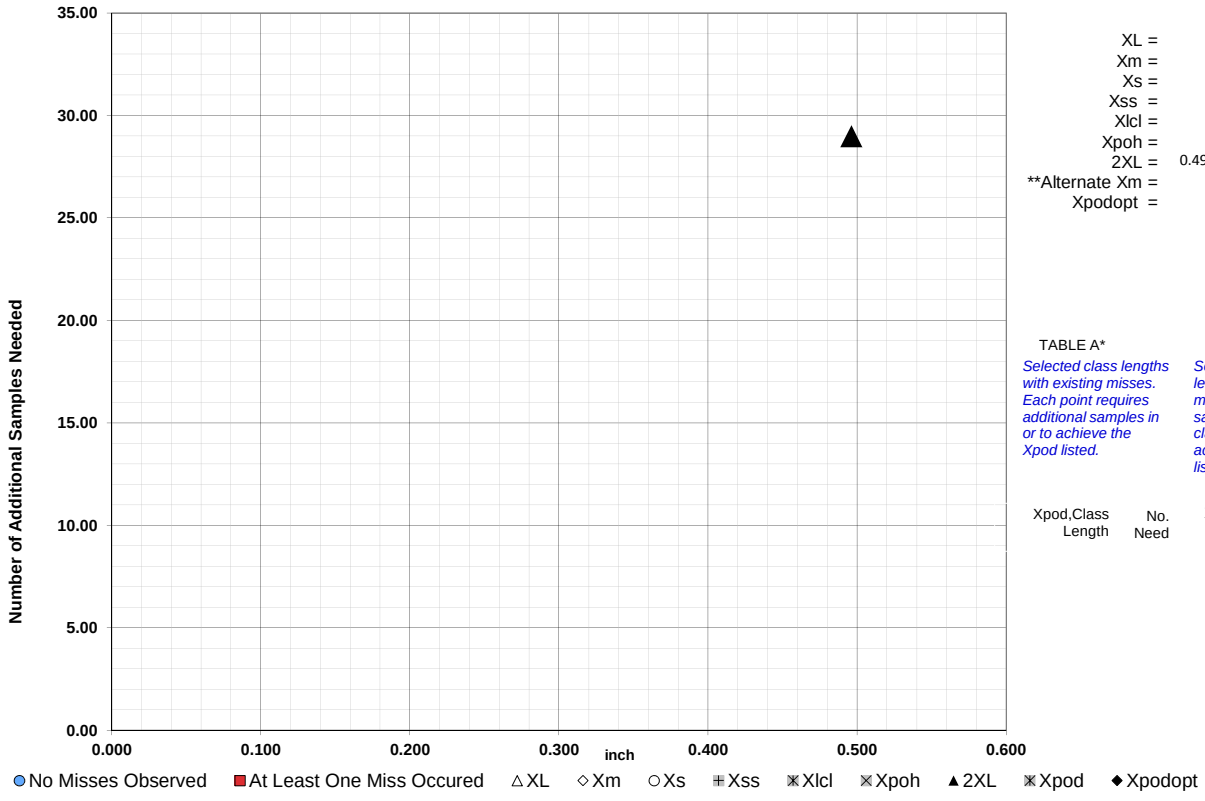



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.496 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

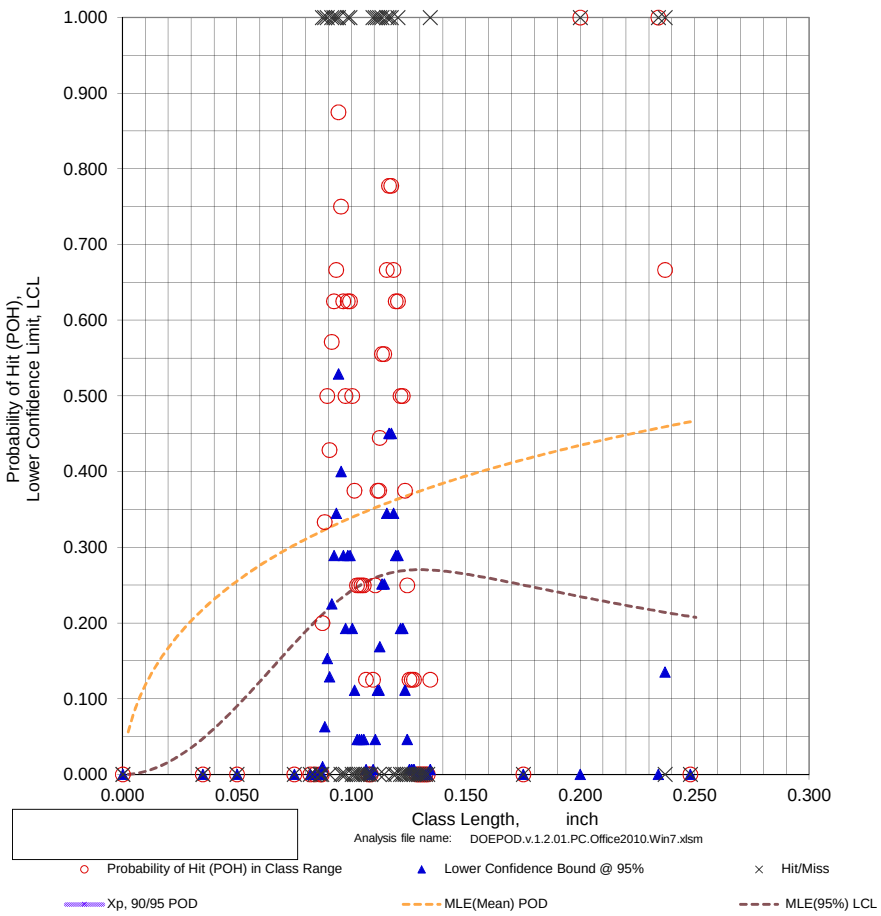
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F40601B.XLS
Data Set Name = F40601B(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:05 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5293 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0943 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.496 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F40601B.XLS
Data Set Name = F40601B(CRK #)

## Directed DOE Options

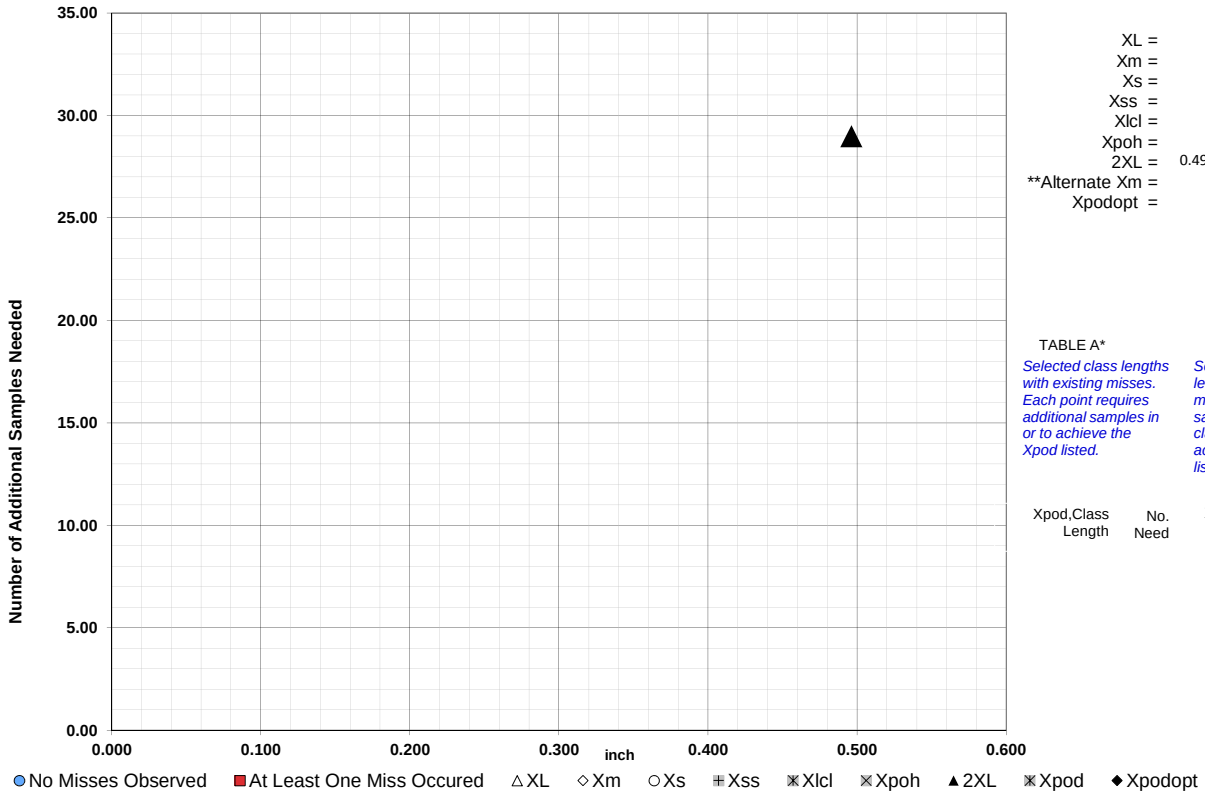



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.496 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

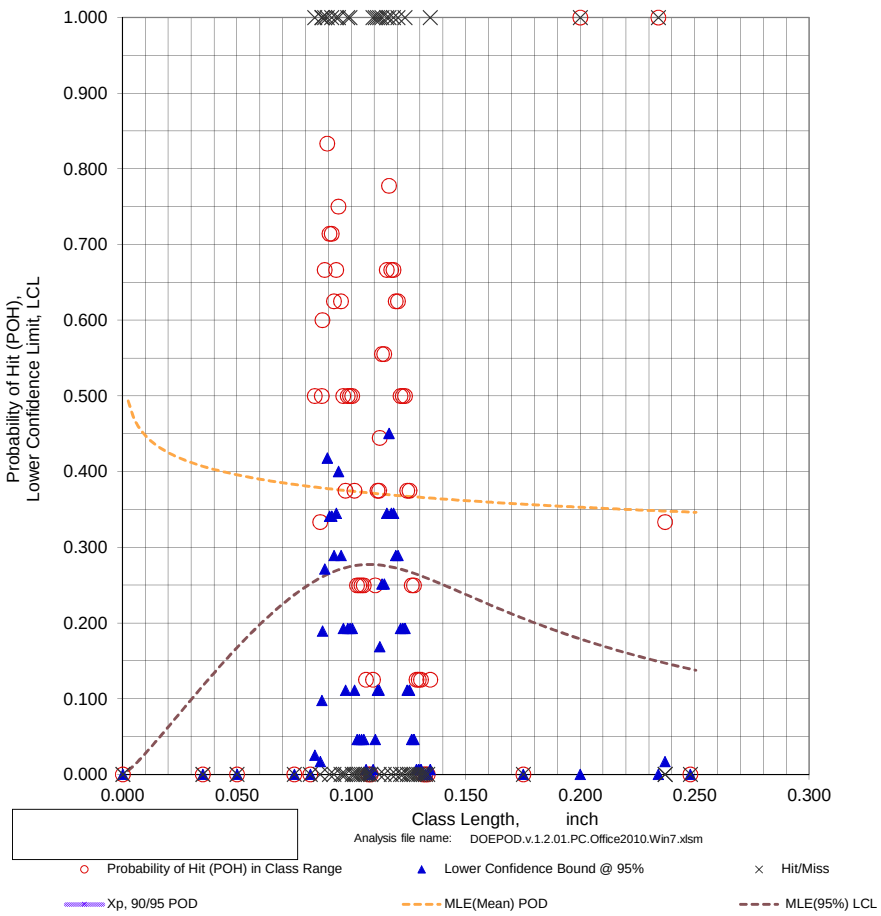
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F40601C.XLS
Data Set Name = F40601C(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:06 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.4504 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.1163 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.496 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F40601C.XLS
Data Set Name = F40601C(CRK #)

## Directed DOE Options

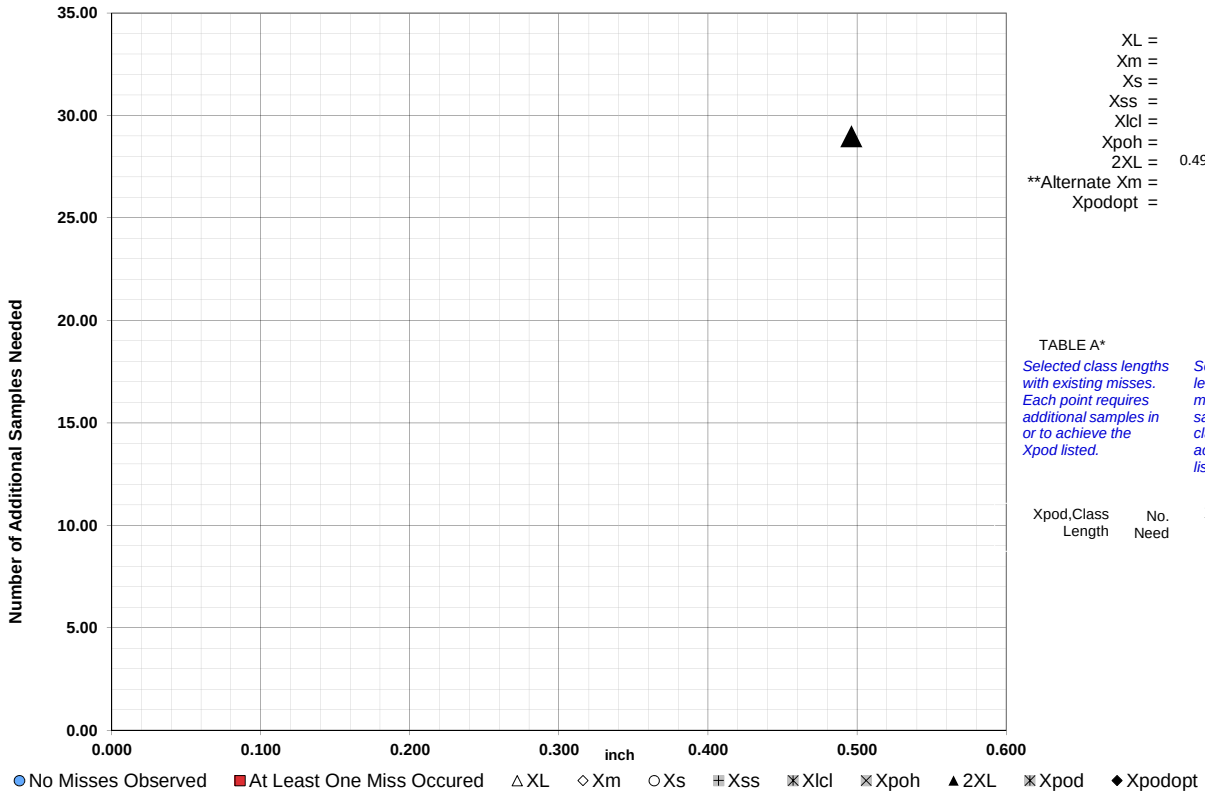



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.496 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

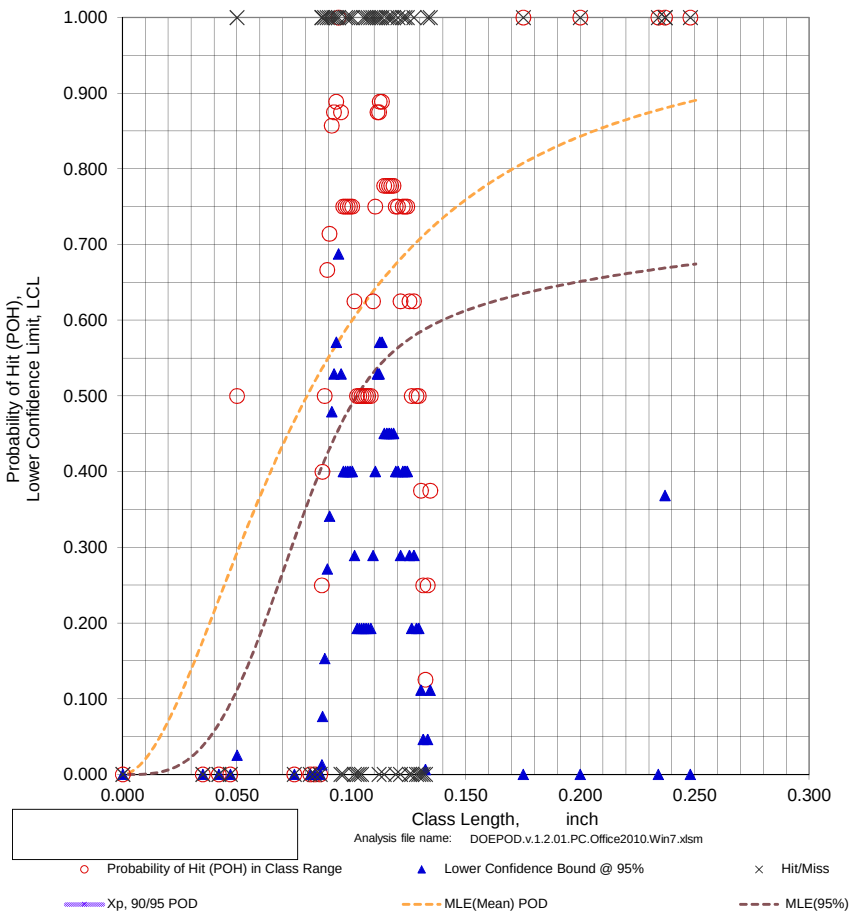
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F40603A.XLS
Data Set Name = F40603A(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:08 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6877 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0943 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1343 -0.001 inch 27 Samples

NTIAC 90% POD = 0.900 @ 0.265 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.248 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.175 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.496 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F40603A.XLS
Data Set Name = F40603A(CRK # )

## Directed DOE Options

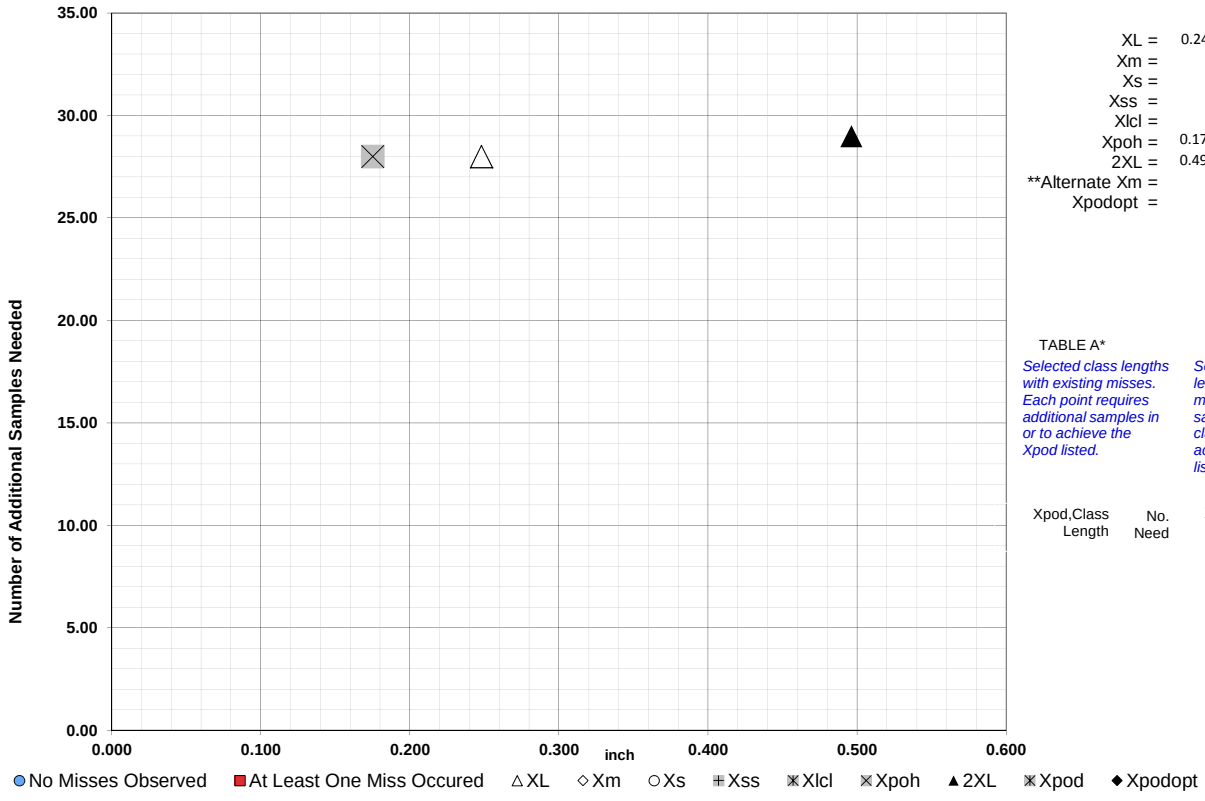



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.248 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.175 | 28 |
| 2XL = | 0.496 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

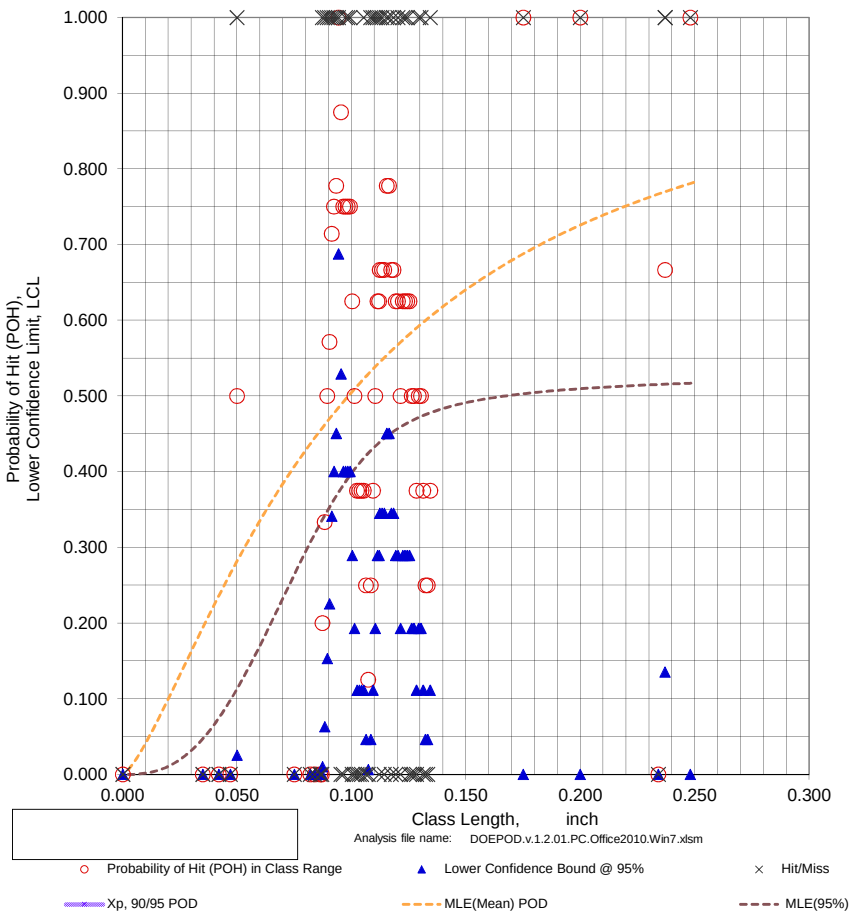
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F40603B.XLS
Data Set Name = F40603B(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:09 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6877 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0943 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2370 -0.002 inch 27 Samples

NTIAC 90% POD = 0.901 @ 0.490 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.248 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.248 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.496 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F40603B.XLS
Data Set Name = F40603B(CRK # )

## Directed DOE Options

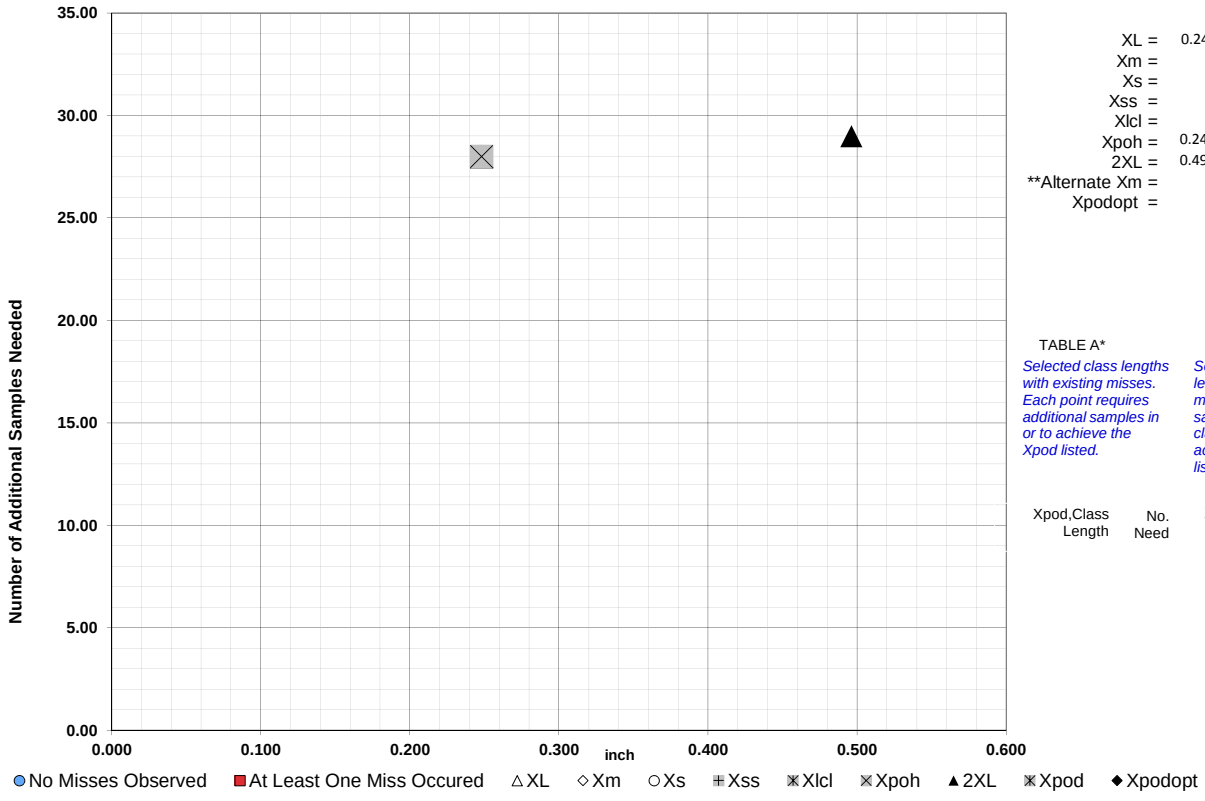



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.248 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.248 | 28 |
| 2XL = | 0.496 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

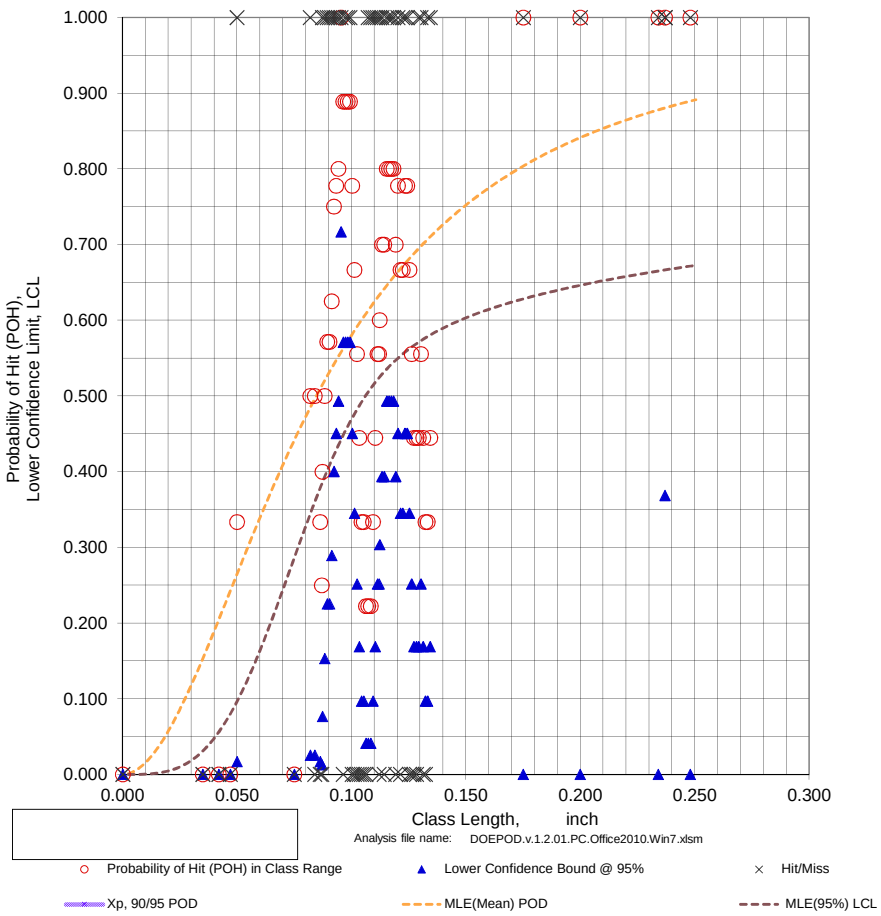
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F40603C.XLS
Data Set Name = F40603C(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:10 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7169 | |
| Classwidth @ Best LCL = | 0.0080 | inch |
| Classlength @ Best LCL = | 0.0953 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1343 -0.001 inch 27 Samples

NTIAC 90% POD = 0.902 @ 0.265 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.248 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.175 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 0.496 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F40603C.XLS
Data Set Name = F40603C(CRK # )

## Directed DOE Options

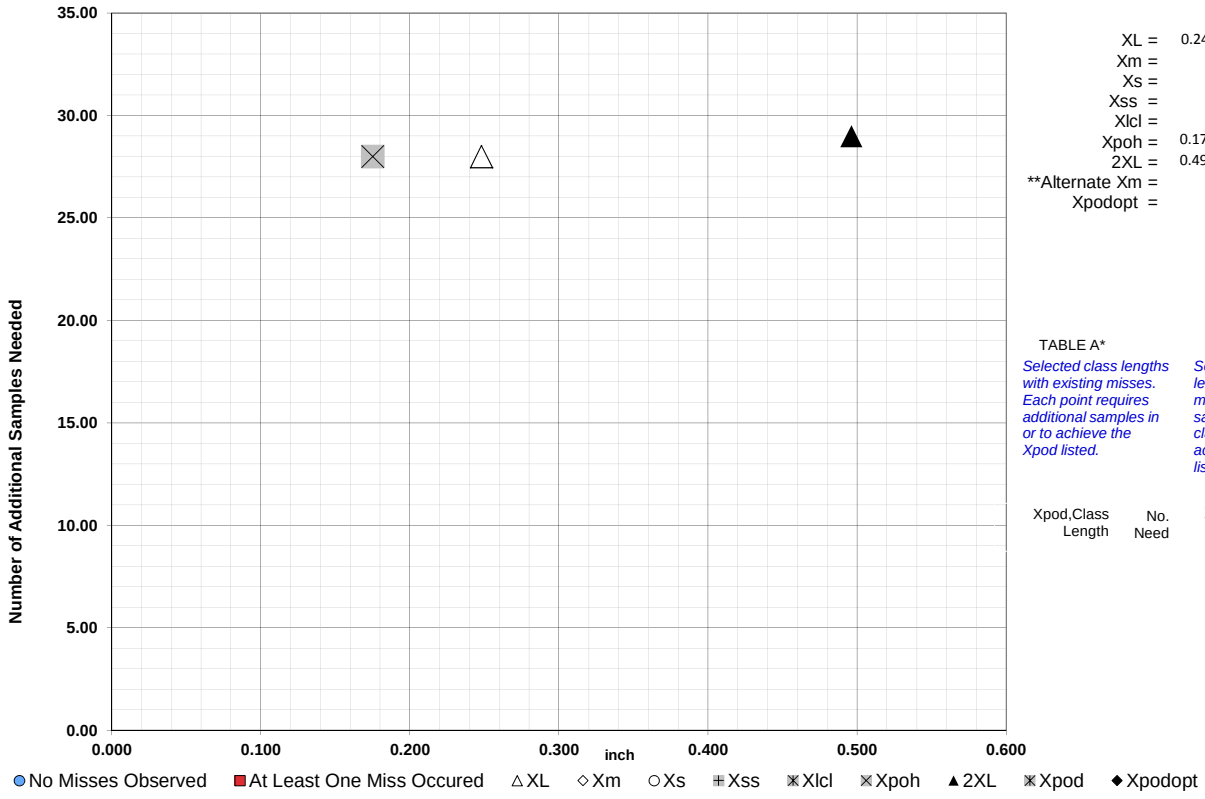



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.248 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.175 | 28 |
| 2XL = | 0.496 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

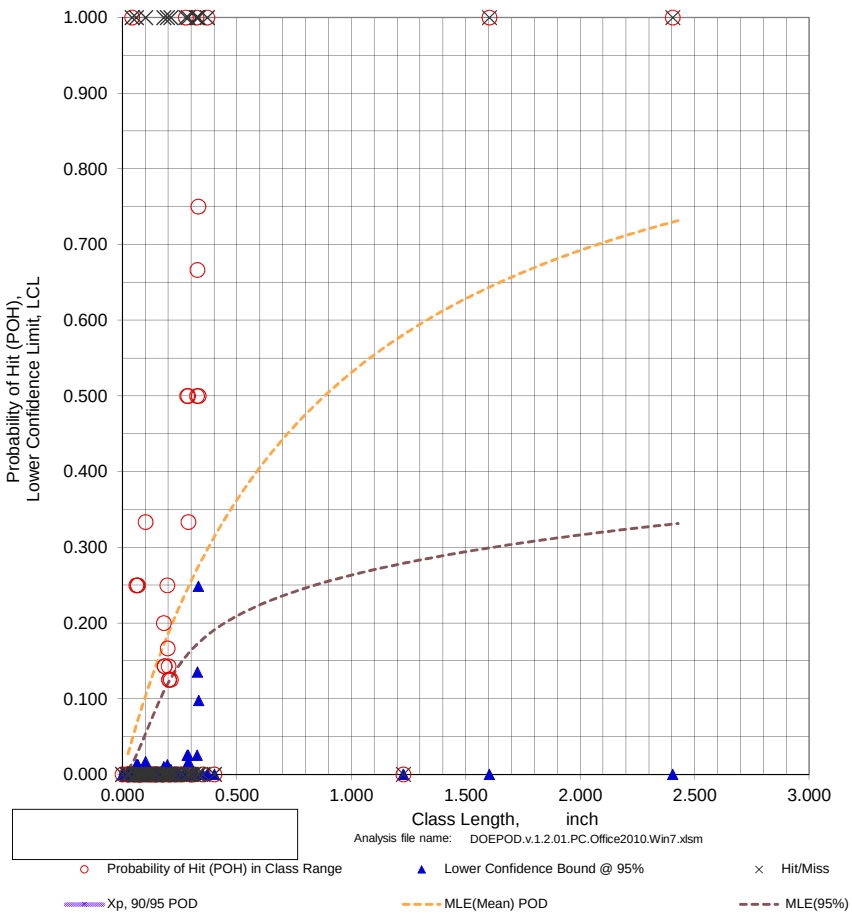
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F42501A.XLS
Data Set Name = F42501A(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:12 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2486 | |
| Classwidth @ Best LCL = | 0.0080 | inch |
| Classlength @ Best LCL = | 0.3300 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F42501A.XLS
Data Set Name = F42501A(CRK #)

## Directed DOE Options

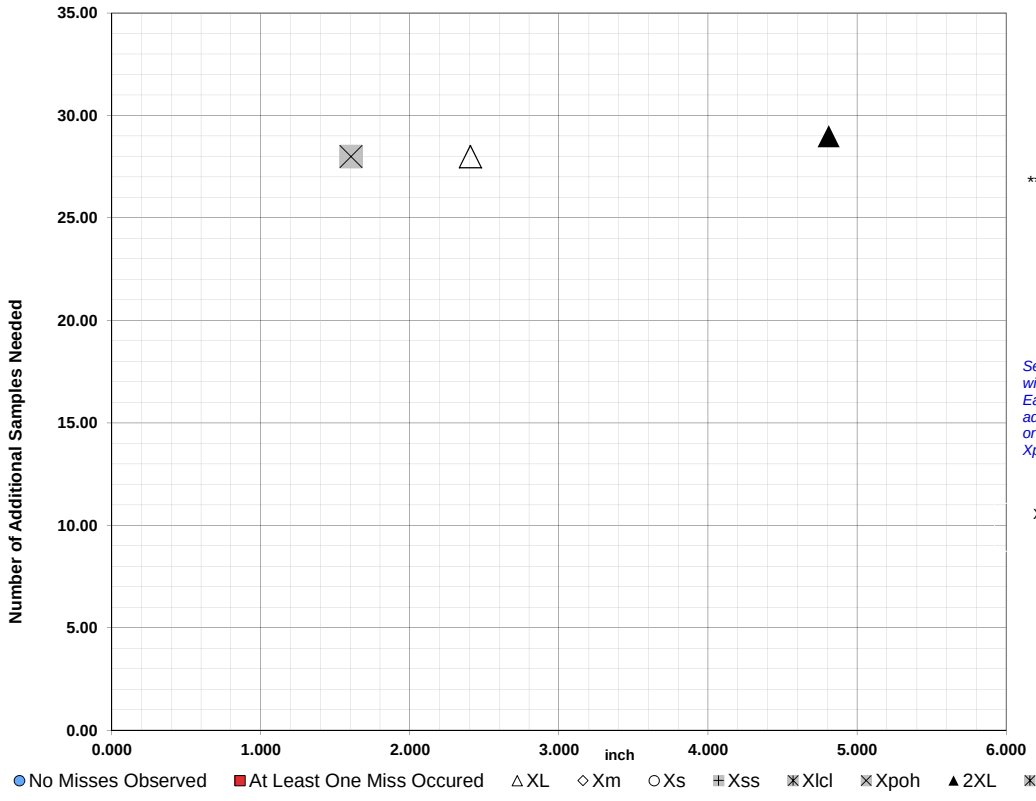



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

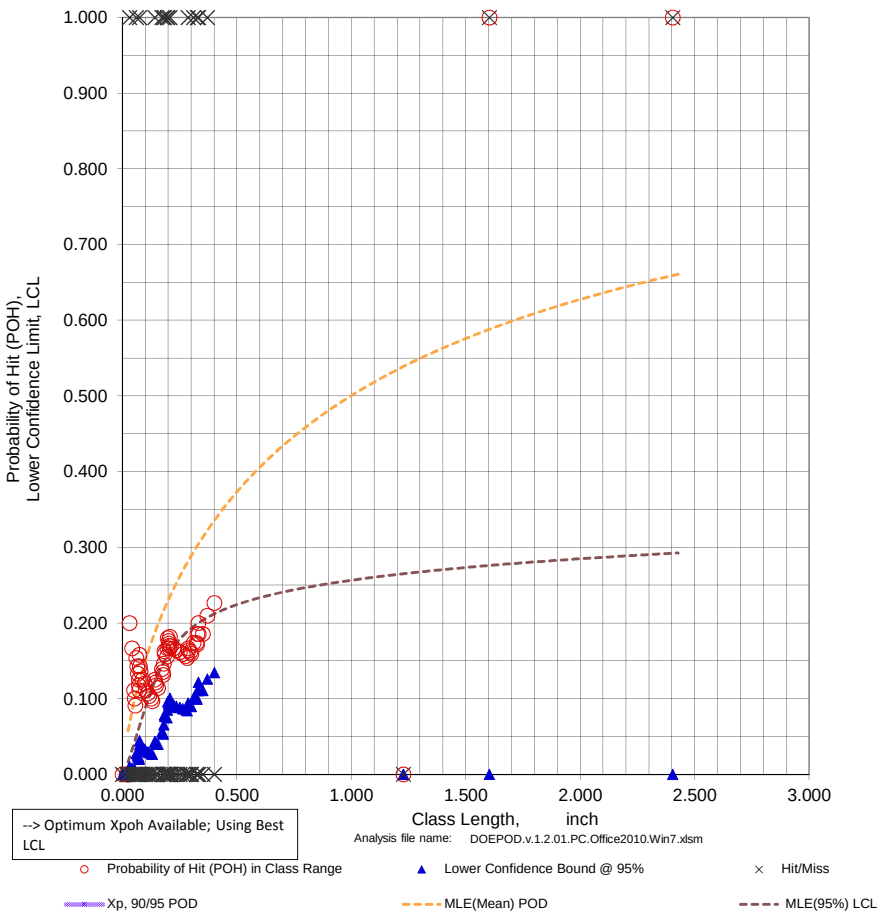
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F42501B.XLS
Data Set Name = F42501B(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:13 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.1343 | |
| Classwidth @ Best LCL = | 0.3000 | inch |
| Classlength @ Best LCL = | 0.4000 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F42501B.XLS
Data Set Name = F42501B(CRK #)

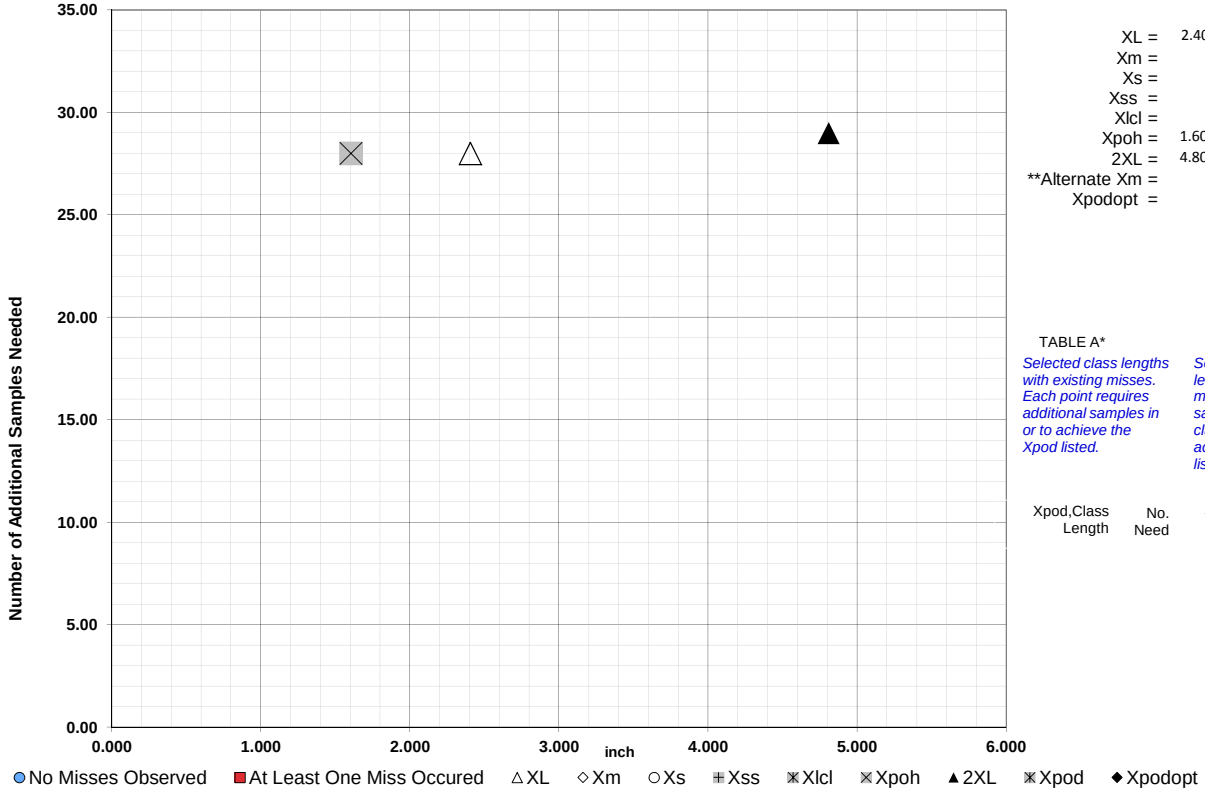



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

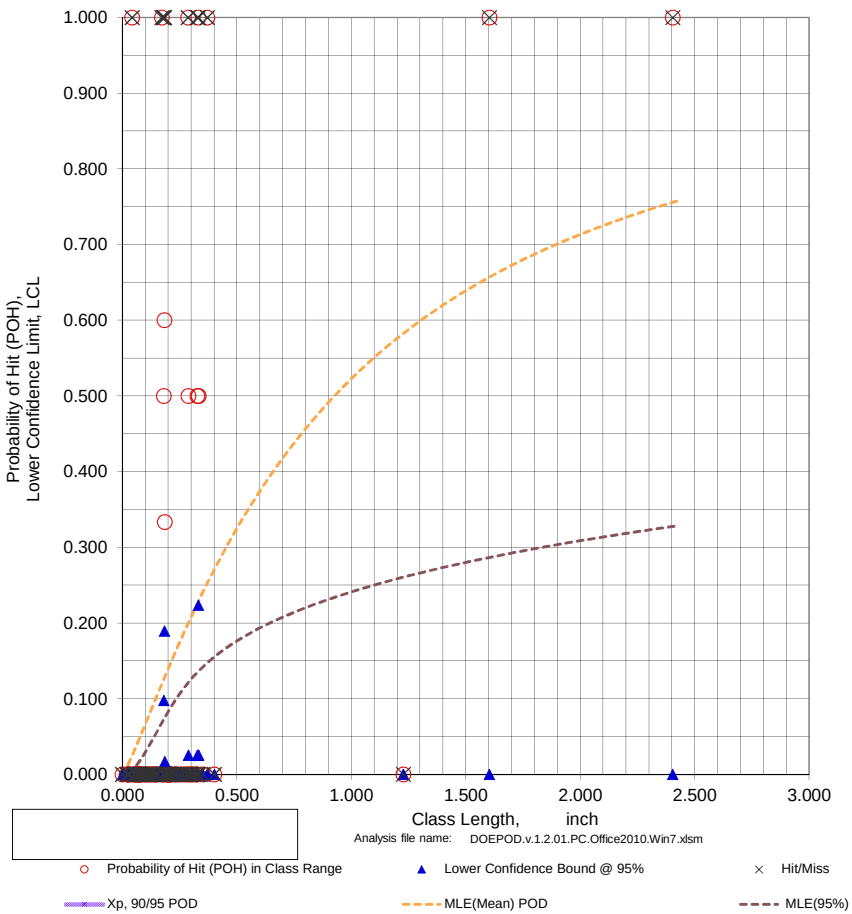
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F42501C.XLS
Data Set Name = F42501C(CRK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:16 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.2236 | |
| Classwidth @ Best LCL = | 0.0030 | inch |
| Classlength @ Best LCL = | 0.3300 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 2.403 | | inch |
| Samples Needed @ XL = | 28 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | | | inch |
| Samples Needed @ Xlcl = | | | |
| POH Classlength, Xpoh = | 1.603 | | inch |
| Samples Needed @ Xpoh = | 28 | | |
| New Largest Classlength , 2XL = | 4.806 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = F42501C.XLS
Data Set Name = F42501C(CRK #)

## Directed DOE Options

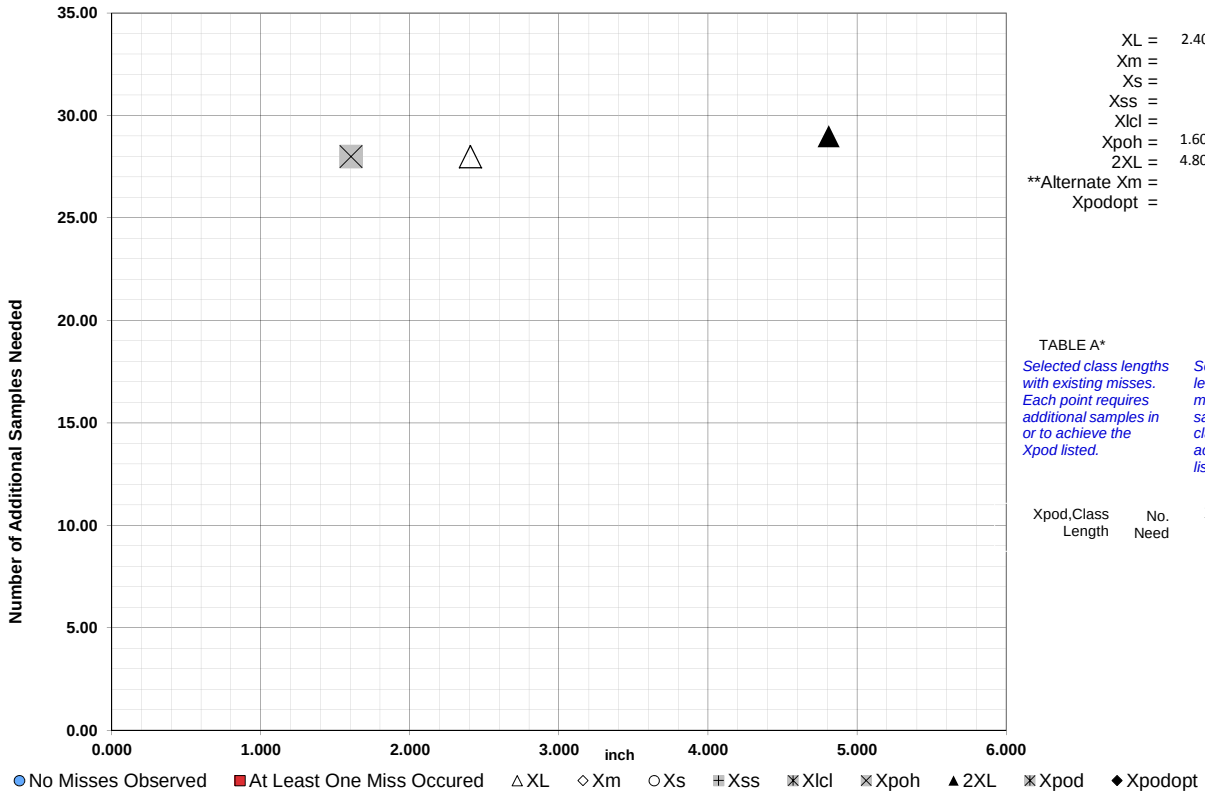



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

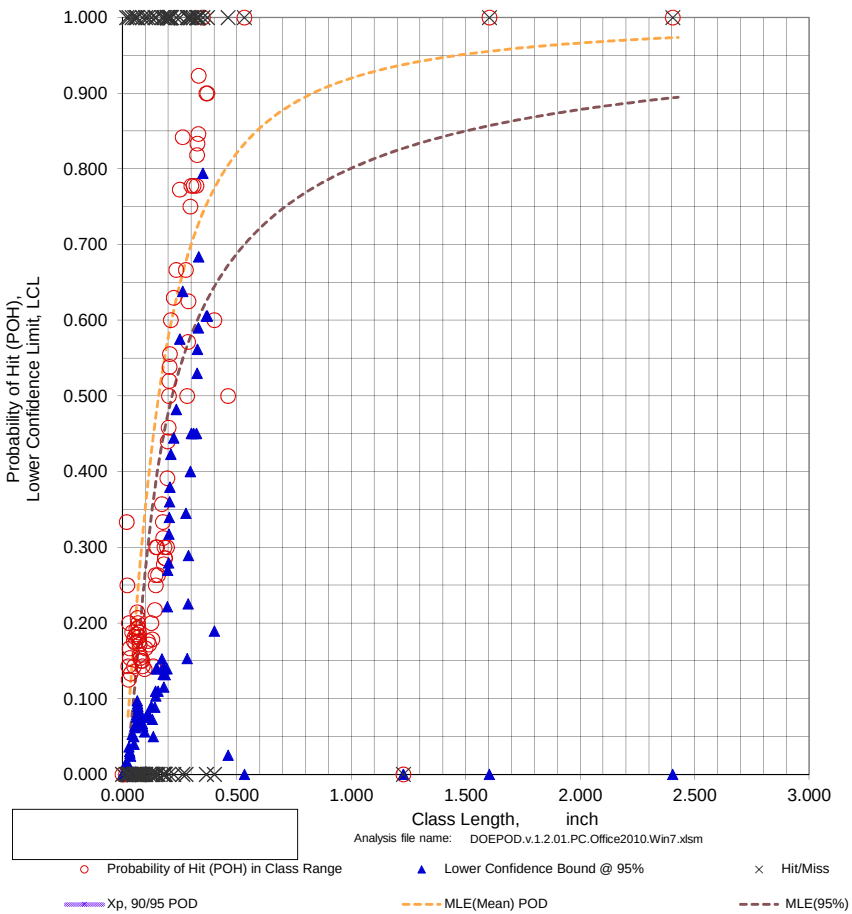
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F42503A.XLS
Data Set Name = F42503A(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:17 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0680 | inch |
| Classlength @ Best LCL = | 0.3500 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.6030 -0.300 inch 28 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.603 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | 4.806 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F42503A.XLS
Data Set Name = F42503A(CRK # )

## Directed DOE Options

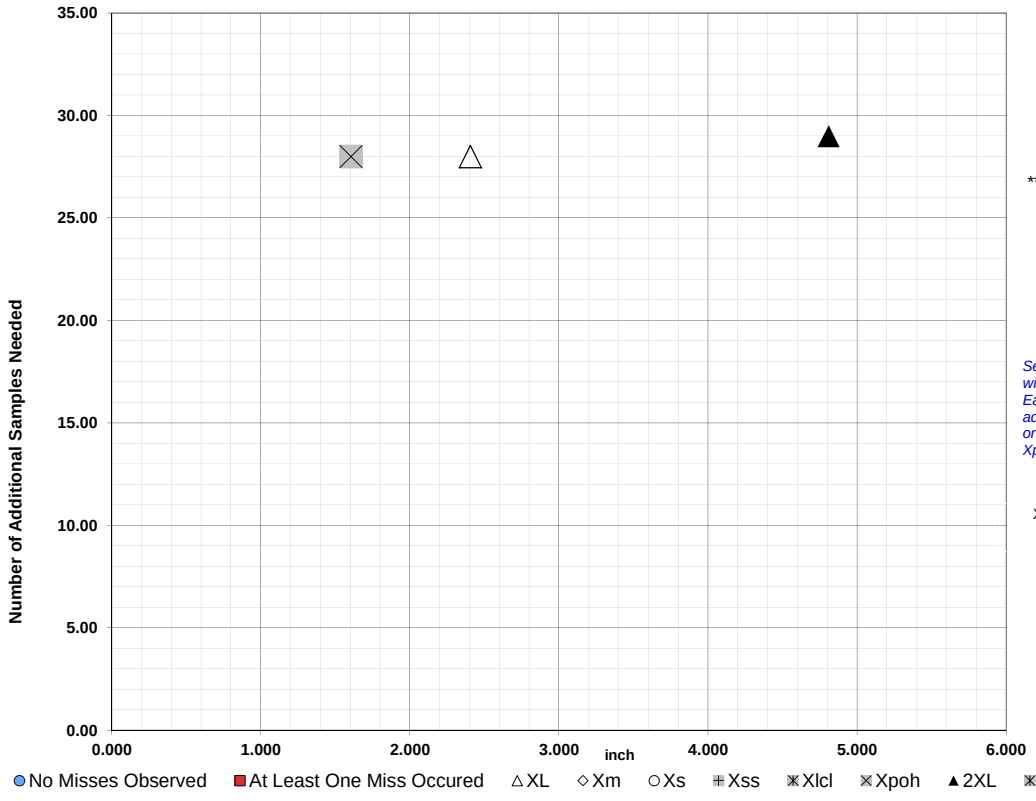



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.603 | 28 |
| 2XL = | 4.806 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

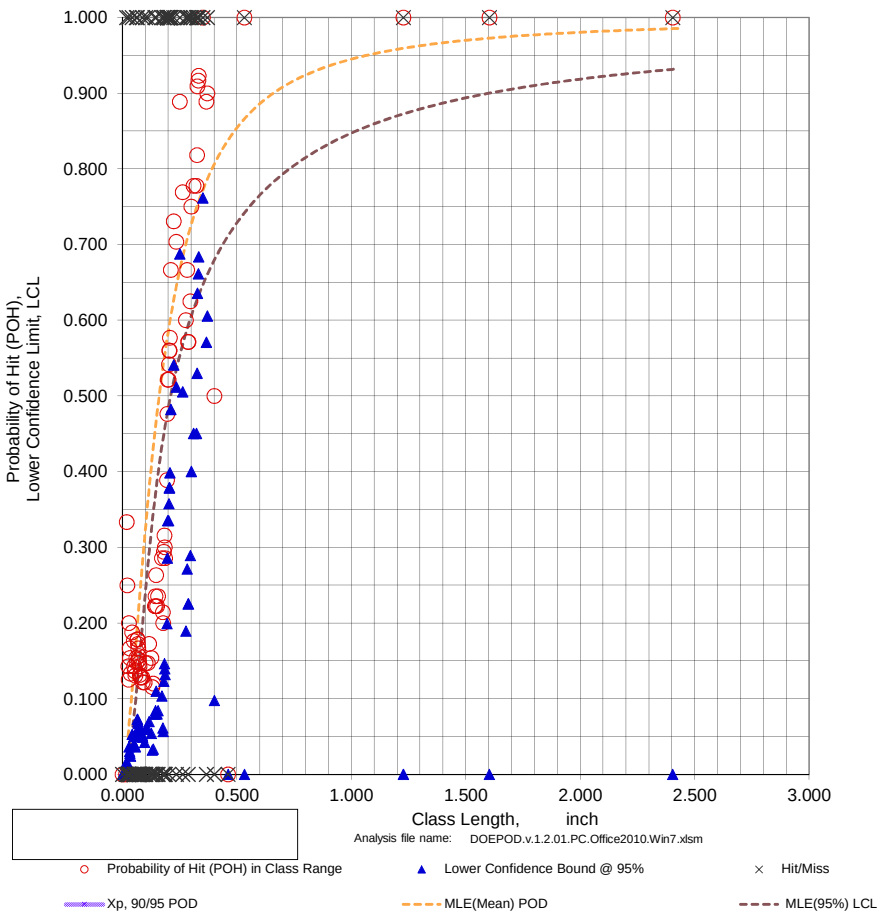
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F42503B.XLS
Data Set Name = F42503B(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:19 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7616 | |
| Classwidth @ Best LCL = | 0.0630 | inch |
| Classlength @ Best LCL = | 0.3500 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.5320 -0.071 inch 28 Samples

NTIAC 90% POD = 0.900 @ 0.660 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.532 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F42503B.XLS
Data Set Name = F42503B(CRK # )

## Directed DOE Options

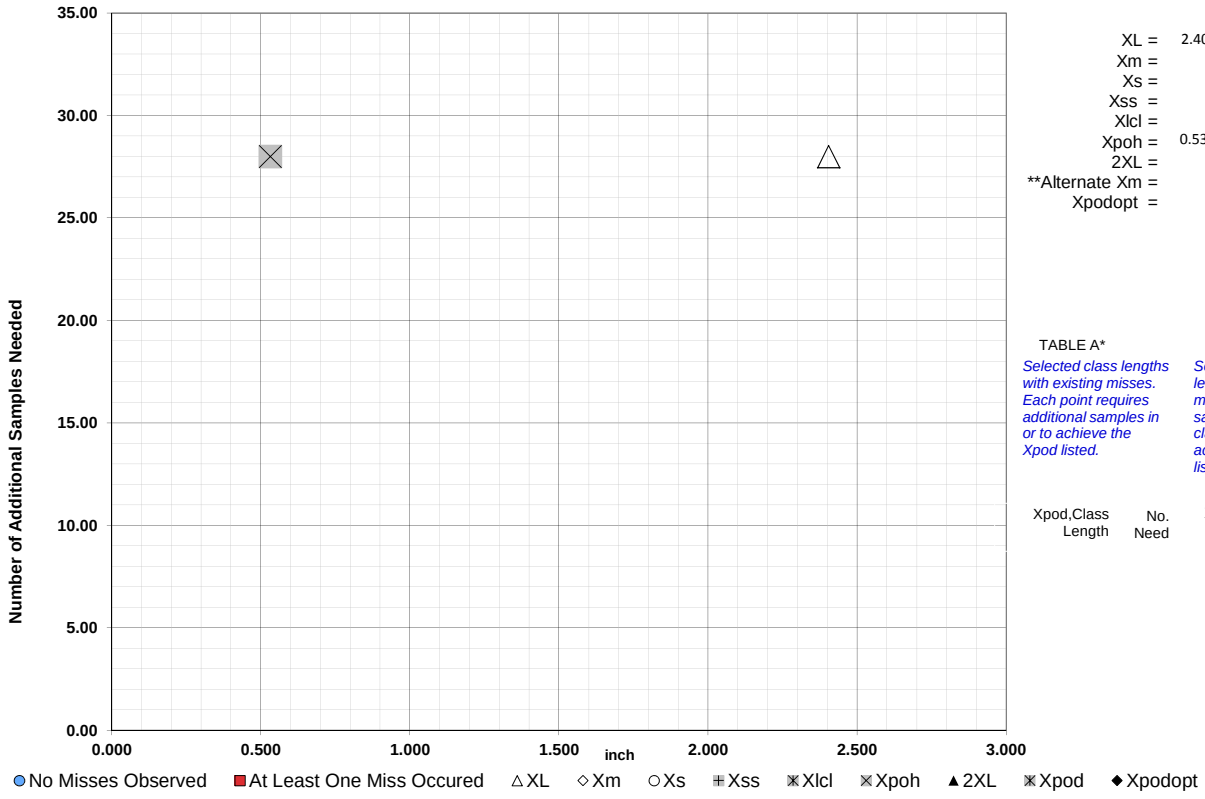



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.532 | 28 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

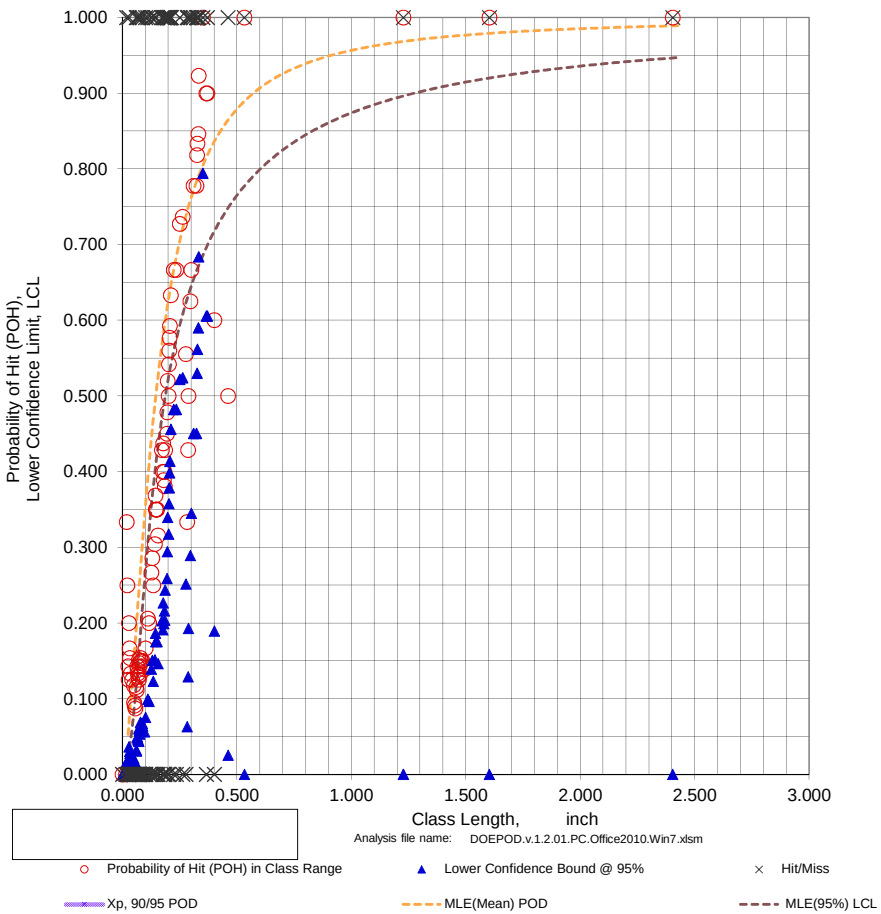
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = F42503C.XLS
Data Set Name = F42503C(CRK # )

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:20 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7942 | |
| Classwidth @ Best LCL = | 0.0680 | inch |
| Classlength @ Best LCL = | 0.3500 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 5 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and Xpoh.

Survey/Optimum Xpoh = 0.4600 -0.059 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.575 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 2.403 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.532 | inch |
| Samples Needed @ Xpoh = | 28 | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F42503C.XLS
Data Set Name = F42503C(CRK # )

## Directed DOE Options

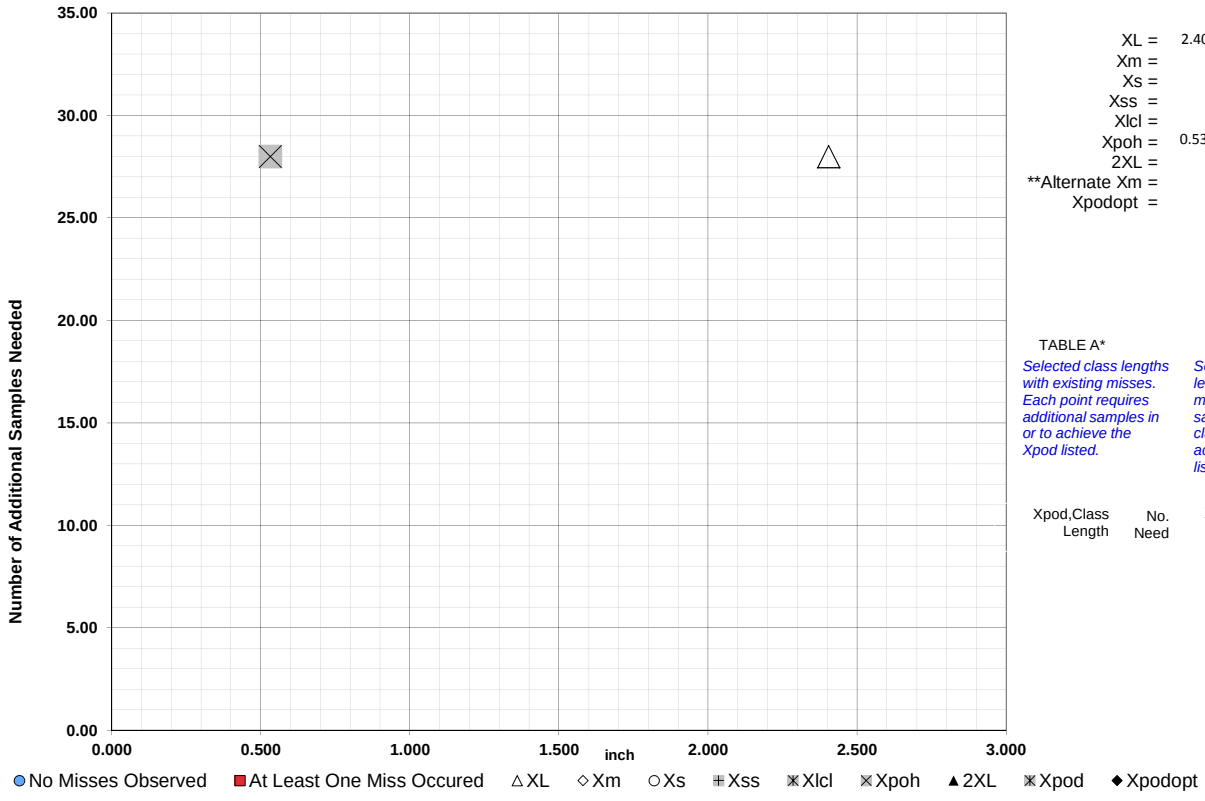



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 2.403 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.532 | 28 |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

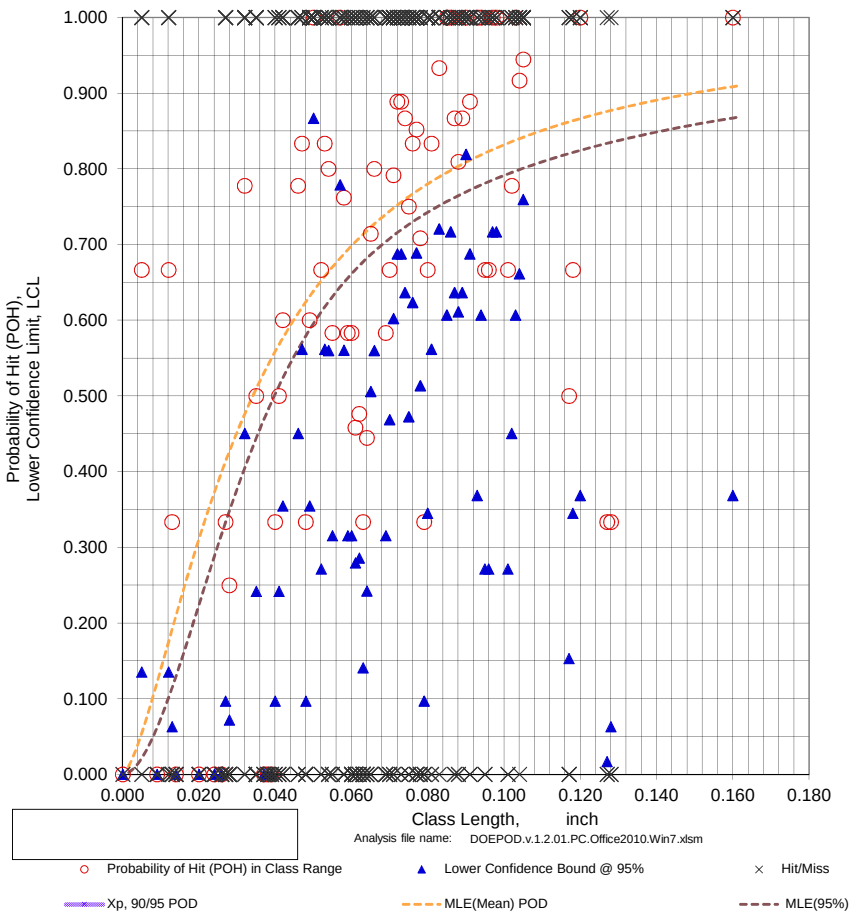
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F5001(3)D.xls
Data Set Name = F5001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:22 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.0500 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.1600 -0.031 inch 26 Samples

NTIAC 90% POD = 0.900 @ 0.150 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.160 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.160 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.320 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F5001(3)D.xls
Data Set Name = F5001(3)D(CK. NO.)

## Directed DOE Options

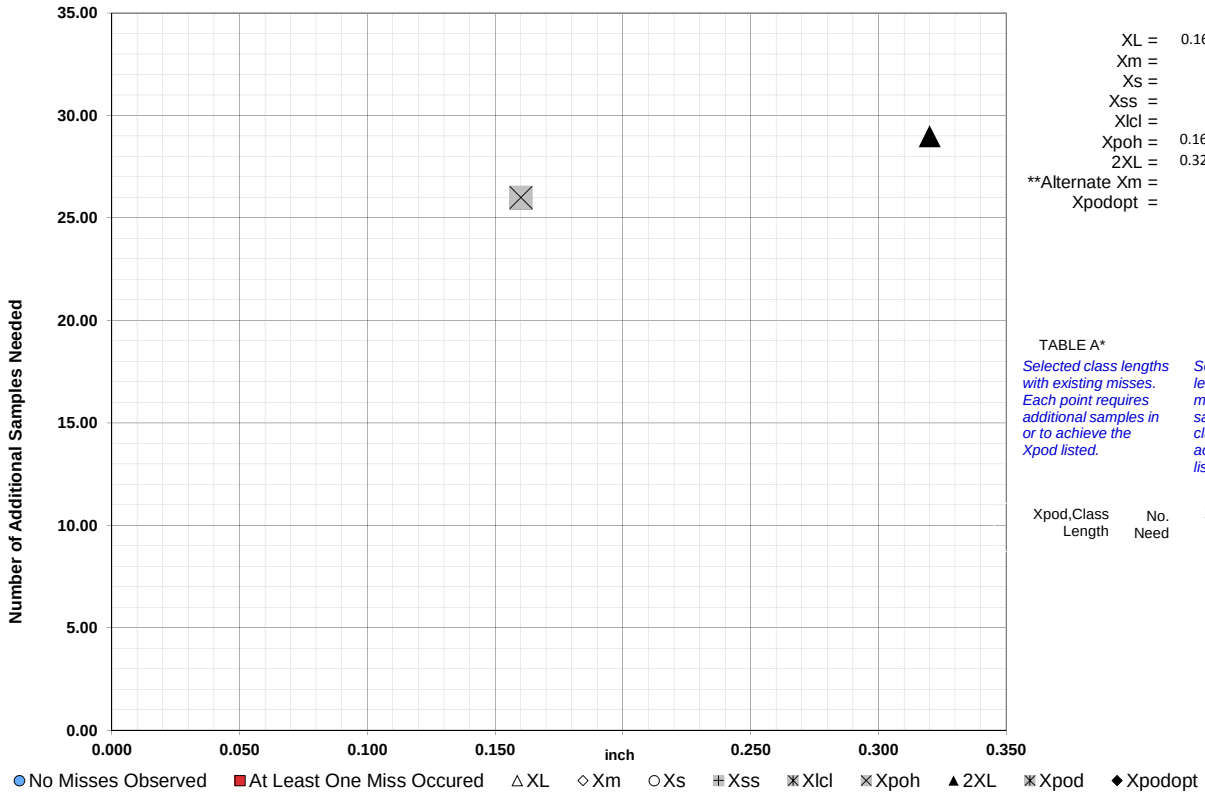



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.160 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.160 | 26 |
| 2XL = | 0.320 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

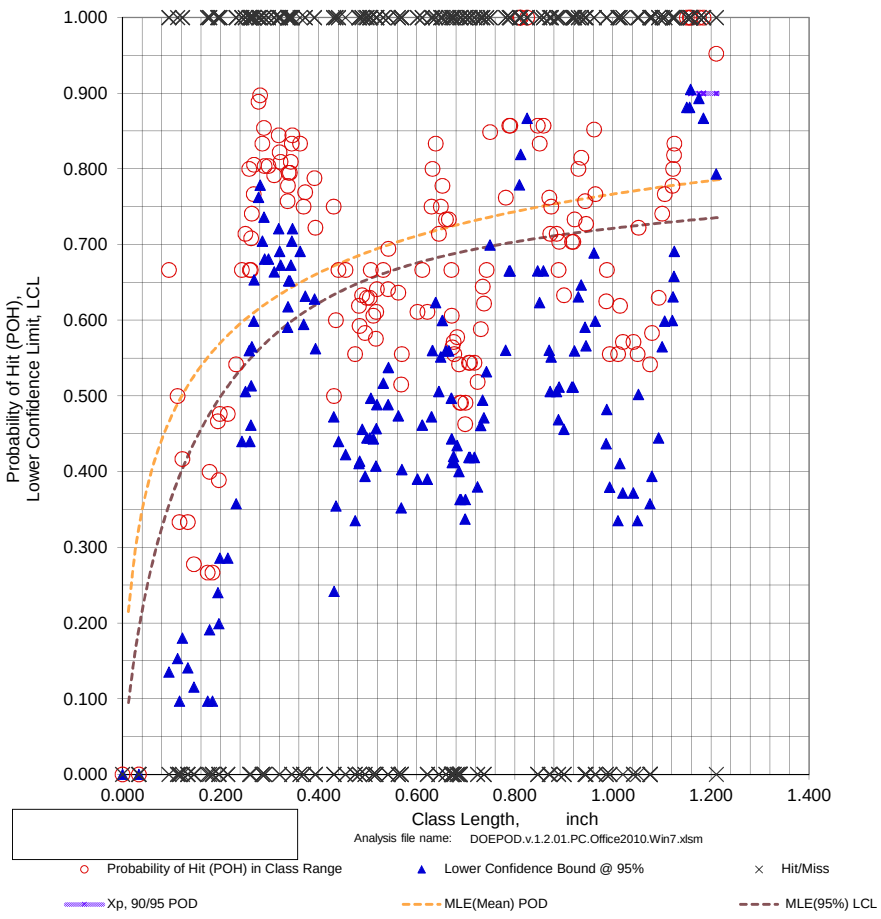
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 3.474.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **F5001(3)L.xls**

Data Set Name = **F5001(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:24 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0580 | inch |
| Classlength @ 90/95 Xpod = | 1.1580 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.210 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.175 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 1.1580 | inch |

File Name = F5001(3)L.xls
Data Set Name = F5001(3)L(CK. NO.)

## Directed DOE Options

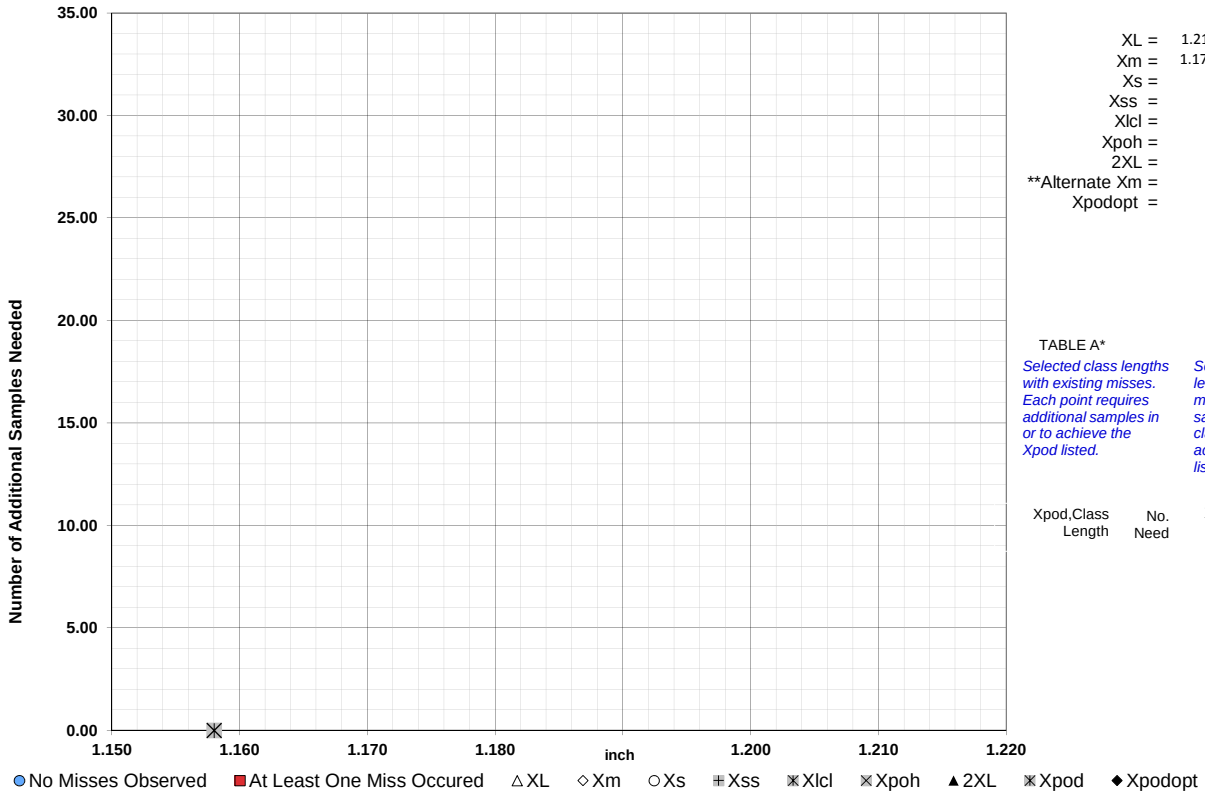



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 1.210 |
| Xm = | 1.175 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

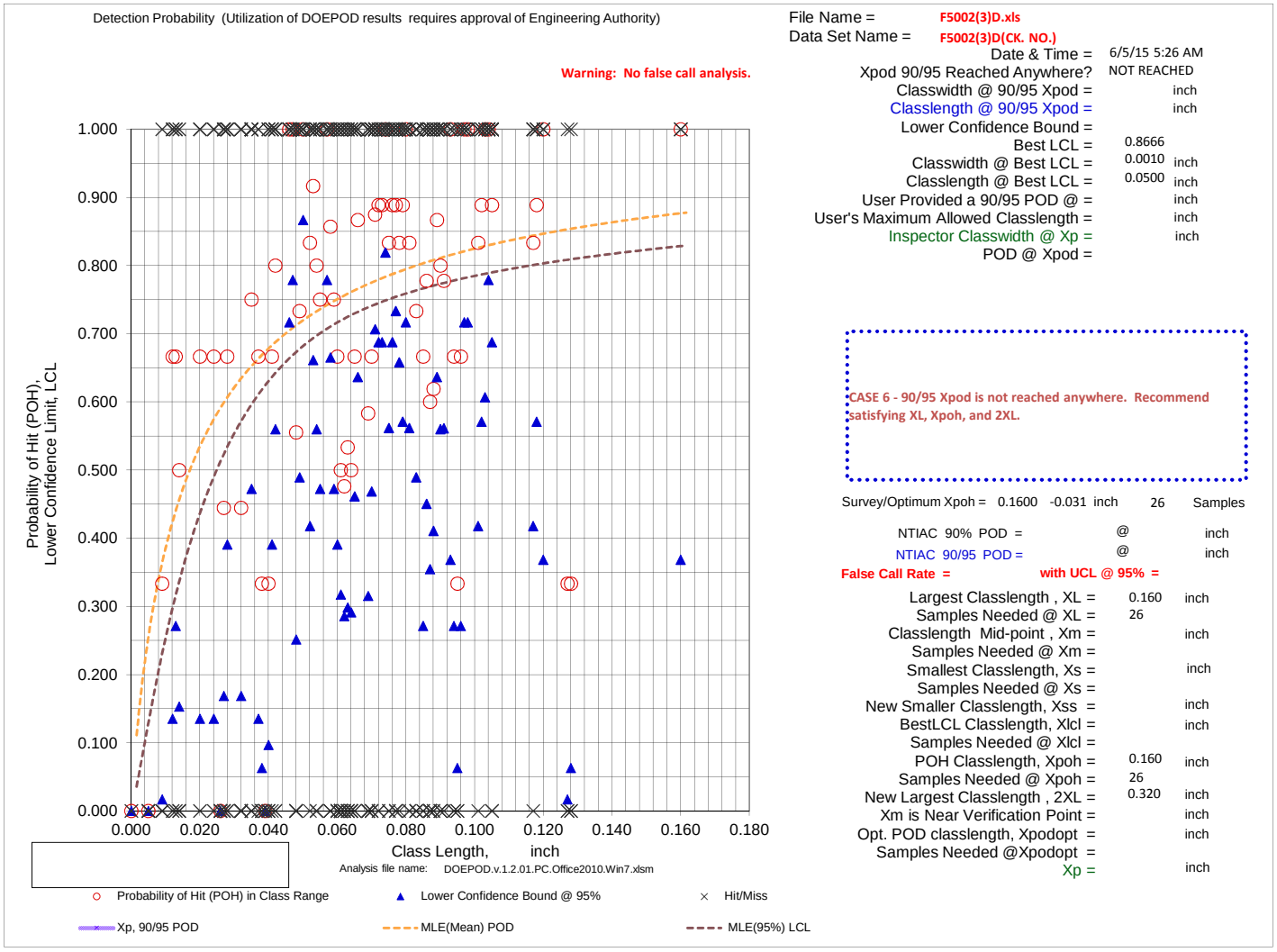
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
Warning: No false call analysis.
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000 0.020 0.040 0.060 0.080 0.100 0.120 0.140 0.160 0.180
Class Length, inch
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL
File Name = F5002(3)D.xls
Data Set Name = F5002(3)D(CK. NO.)
Date & Time = 6/5/15 5:26 AM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.8666
Classwidth @ Best LCL = 0.0010 inch
Classlength @ Best LCL = 0.0500 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.
Survey/Optimum Xpoh = 0.1600 -0.031 inch 26 Samples
NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = 0.160 inch
Samples Needed @ XL = 26
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = 0.160 inch
Samples Needed @ Xpoh = 26
New Largest Classlength , 2XL = 0.320 inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch

File Name = F5002(3)D.xls
Data Set Name = F5002(3)D(CK. NO.)

## Directed DOE Options

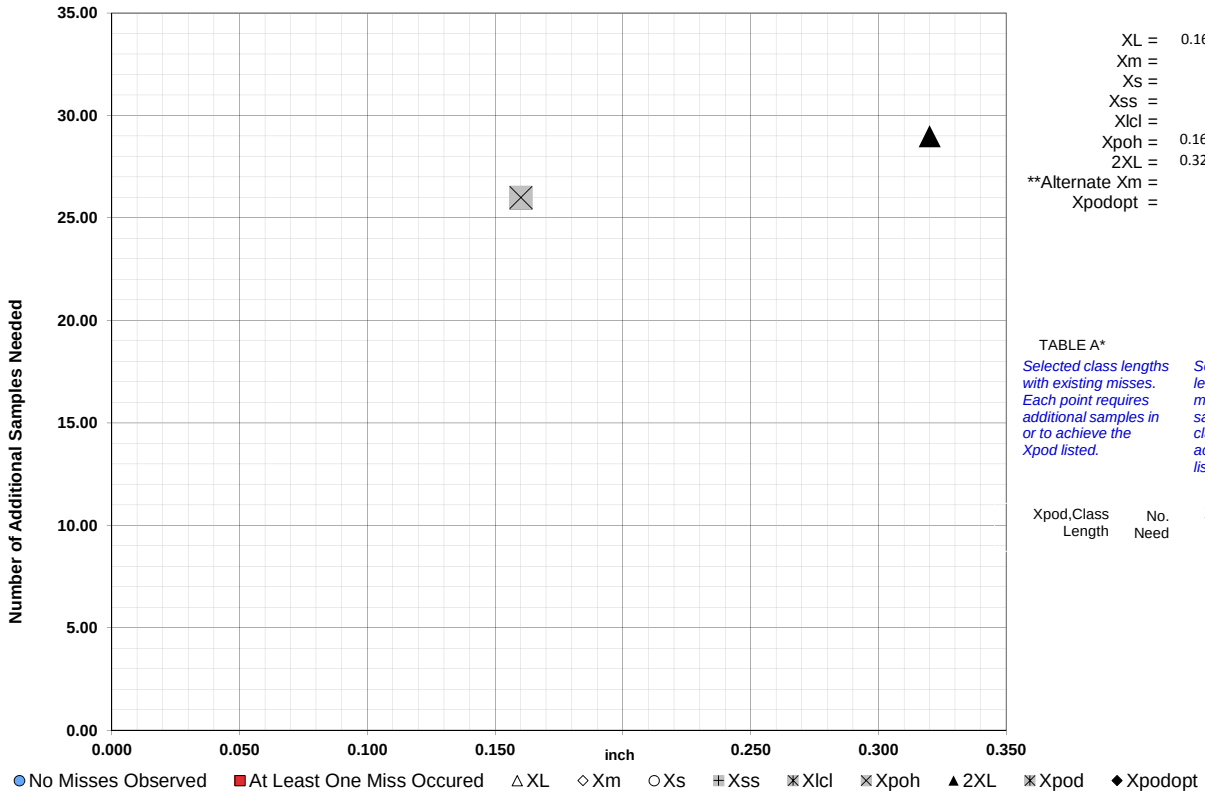



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.160 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.160 | 26 |
| 2XL = | 0.320 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

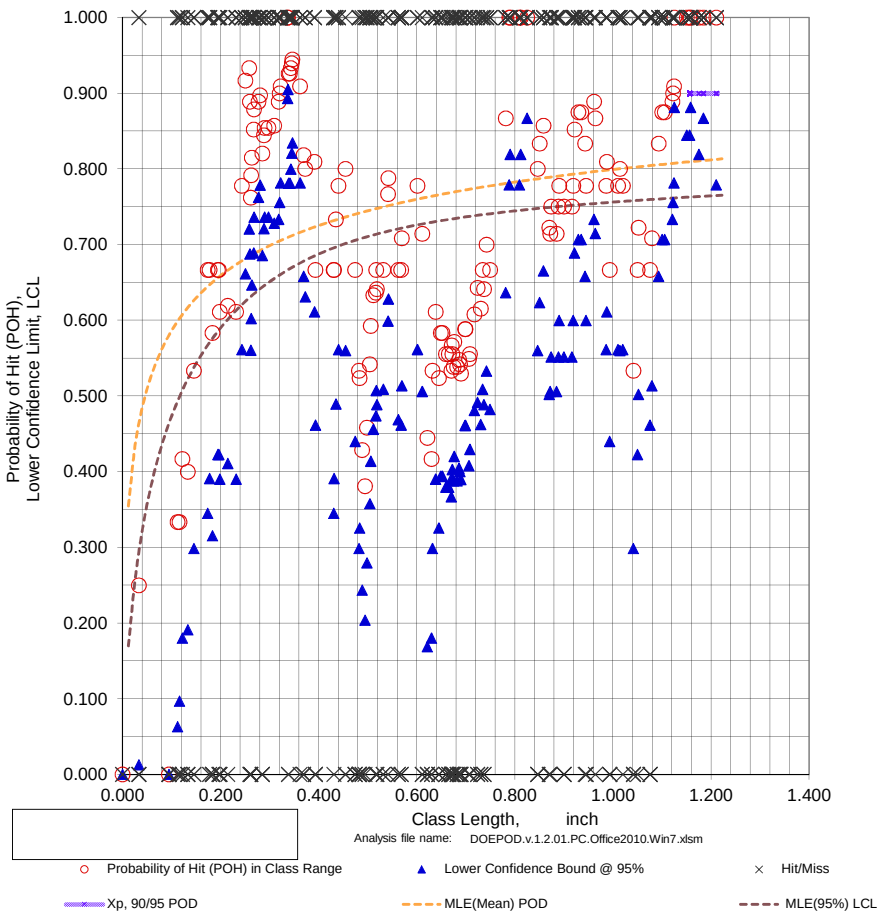
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation successful.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **F5002(3)L.xls**

Data Set Name = **F5002(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:28 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0490 | inch |
| Classlength @ 90/95 Xpod = | 0.3370 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to satisfy XL requirements. Further VALIDATION is required. Recommend satisfying Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in T**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.210 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.825 | inch |
| Samples Needed @ Xm = | 8 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 1.1560 | inch |

File Name = F5002(3)L.xls
Data Set Name = F5002(3)L(CK. NO.)

## Directed DOE Options

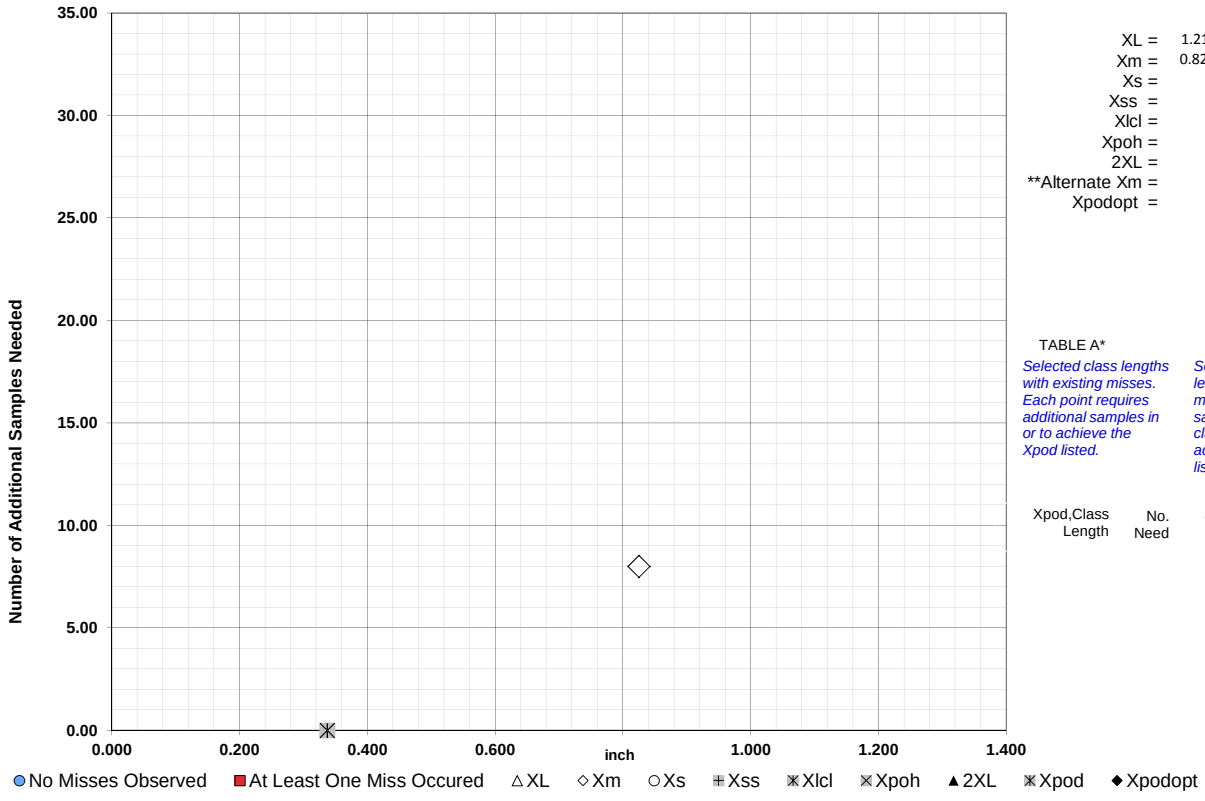



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.210 | |
| Xm = | 0.825 | 8 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.216.**

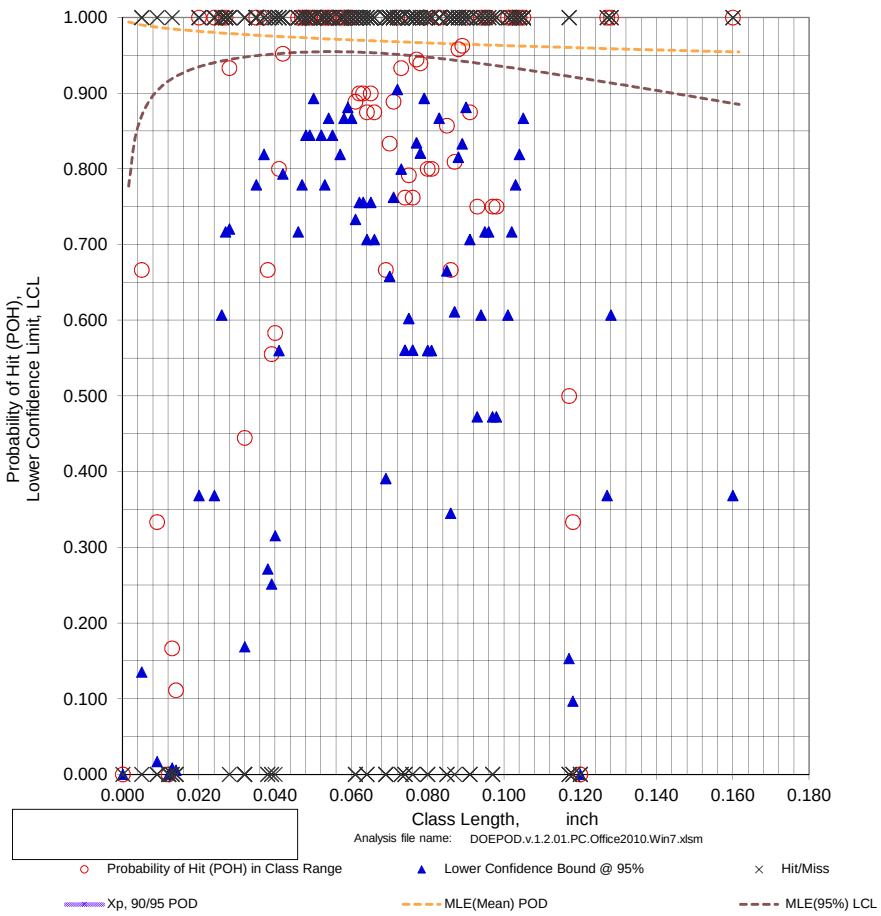
**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **F5003(3)D.xls**

Data Set Name = **F5003(3)D(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:30 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0020 | inch |
| Classlength @ 90/95 Xpod = | 0.0720 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |




**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.995 | @ | 0.005 | inch |
| NTIAC 90/95 POD = | 0.910 | @ | 0.005 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.160 | inch |
| Samples Needed @ XL = | 20 | |
| Classlength Mid-point , Xm = | 0.105 | inch |
| Samples Needed @ Xm = | 8 | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F5003(3)D.xls
Data Set Name = F5003(3)D(CK. NO.)

## Directed DOE Options

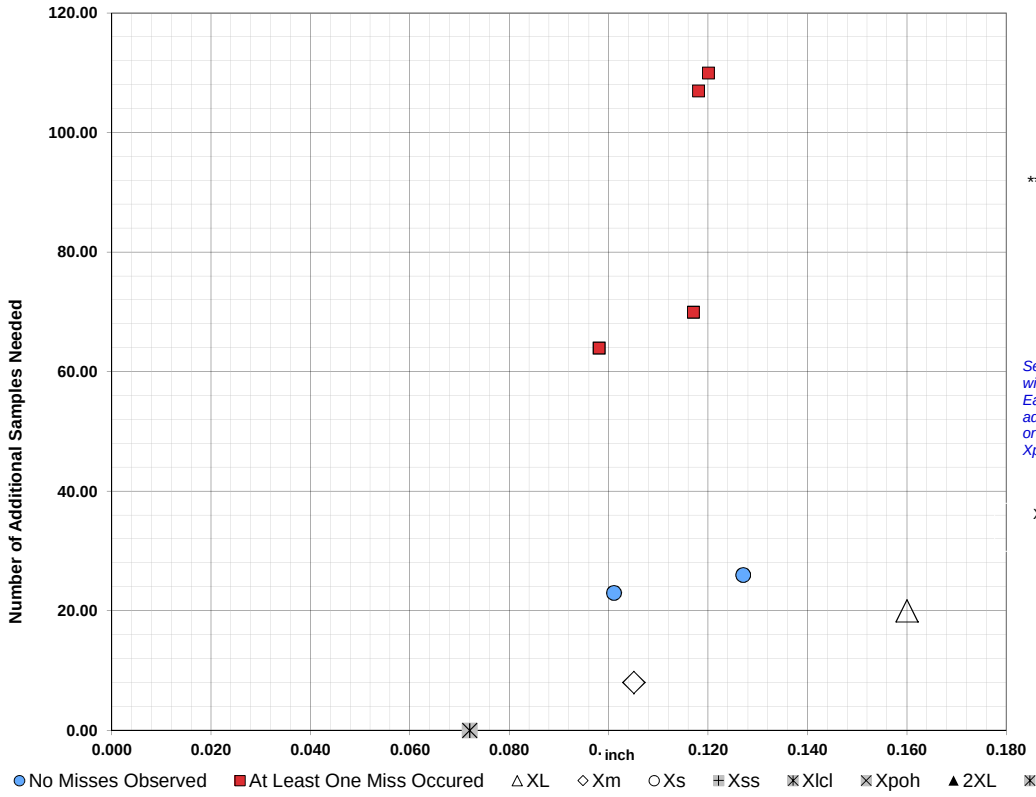



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.160 | 20 |
| Xm = | 0.105 | 8 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1200 | 110 |
| 0.1180 | 107 |
| 0.1170 | 70 |
| 0.0980 | 64 |

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 0.1270 | 26 |
| 0.1010 | 23 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 2.064.**

**MLE Divergence Warning: Initial results listed.**

**Warning: No false call analysis.**

File Name = **F5003(3)L.xls**

Data Set Name = **F5003(3)L(CK. NO.)**

Date & Time = 6/5/15 5:41 AM

Xpod 90/95 Reached Anywhere? REACHED

Classwidth @ 90/95 Xpod = 0.0170 inch

Classlength @ 90/95 Xpod = 0.6880 inch

Lower Confidence Bound = 0.9050

Best LCL =

Classwidth @ Best LCL = inch

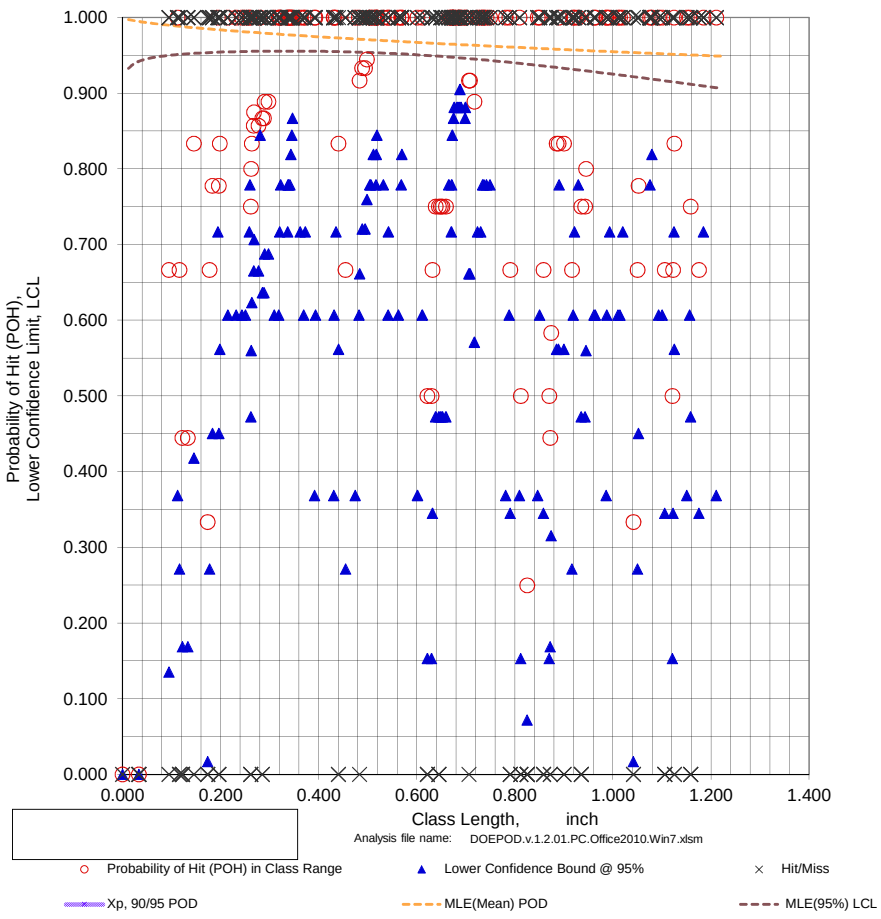
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000




**CASE 2 - 90/95 Xpod is reached at a class length. Xp used to reduce XL requirements. Recommend satisfying XL, Xm and the smallest Xpod in TABLE B that is greater than the largest Xpod in TABLE A, and/or the largest Xpod in Table A.**

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = 0.998 @ 0.005 inch

NTIAC 90/95 POD = 0.911 @ 0.005 inch

**False Call Rate = with UCL @ 95% =**

Largest Classlength , XL = 1.210 inch

Samples Needed @ XL = 16

Classlength Mid-point , Xm = 1.079 inch

Samples Needed @ Xm = 14

Smallest Classlength, Xs = inch

Samples Needed @ Xs =

New Smaller Classlength, Xss = inch

BestLCL Classlength, Xlcl = inch

Samples Needed @ Xlcl =

POH Classlength, Xpoh = inch

Samples Needed @ Xpoh =

New Largest Classlength , 2XL = inch

Xm is Near Verification Point = inch

Opt. POD classlength, Xpodopt = inch

Samples Needed @Xpodopt =

Xp = inch

File Name = F5003(3)L.xls
Data Set Name = F5003(3)L(CK. NO.)

## Directed DOE Options

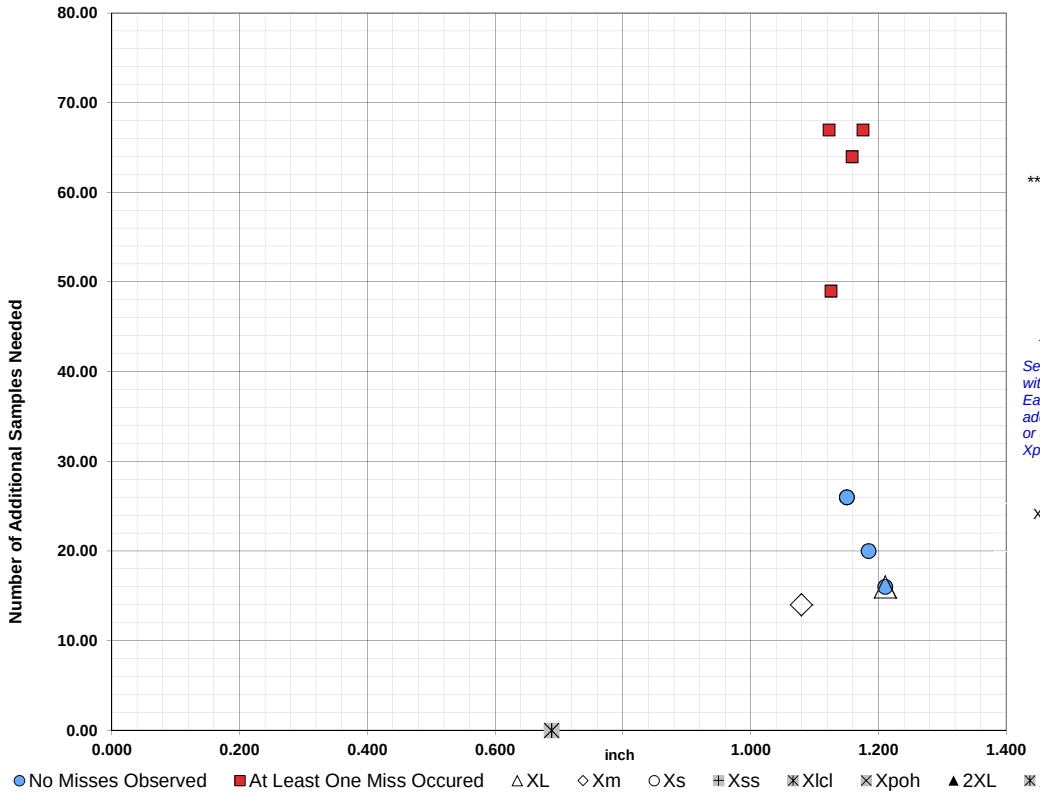



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.210 | 16 |
| Xm = | 1.079 | 14 |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.1750 | 67 |
| 1.1580 | 64 |
| 1.1250 | 49 |
| 1.1220 | 67 |

TABLE B*

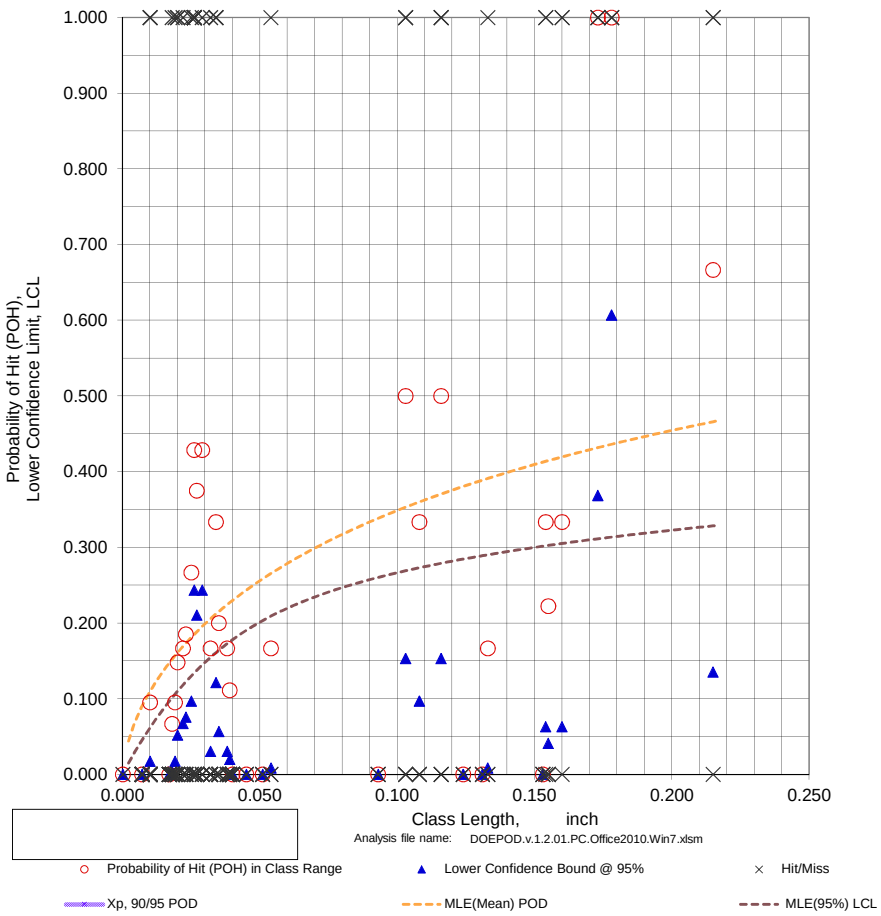
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|
| 1.2100 | 16 |
| 1.1840 | 20 |
| 1.1500 | 26 |
| 1.1500 | 26 |

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F6001(3)D.xls
Data Set Name = F6001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:49 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.1780 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F6001(3)D.xls
Data Set Name = F6001(3)D(CK. NO.)

## Directed DOE Options

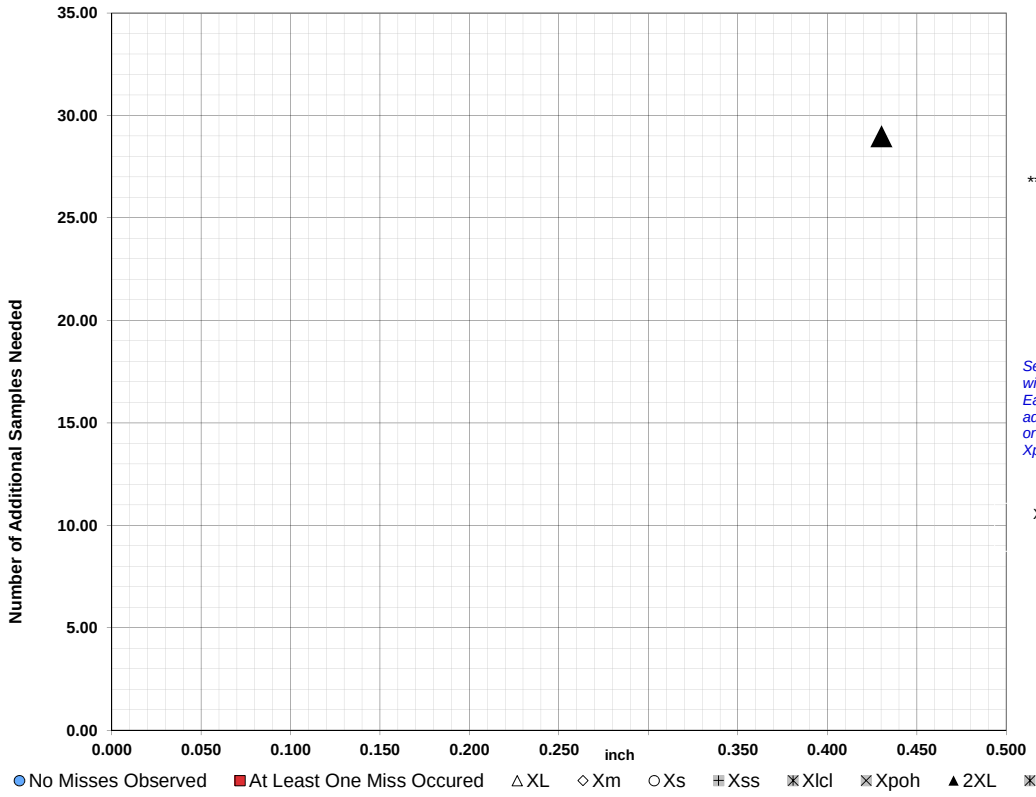



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

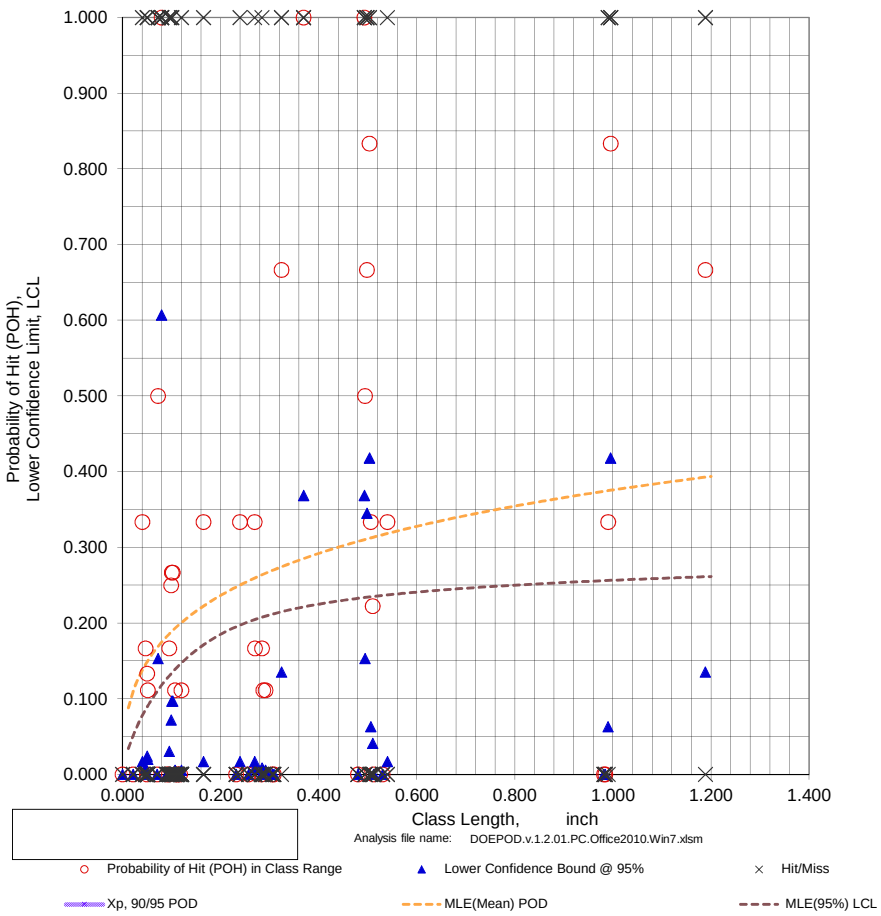
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F6001(3)L.xls
Data Set Name = F6001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:50 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0070 | inch |
| Classlength @ Best LCL = | 0.0790 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 2.376 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F6001(3)L.xls
Data Set Name = F6001(3)L(CK. NO.)

## Directed DOE Options

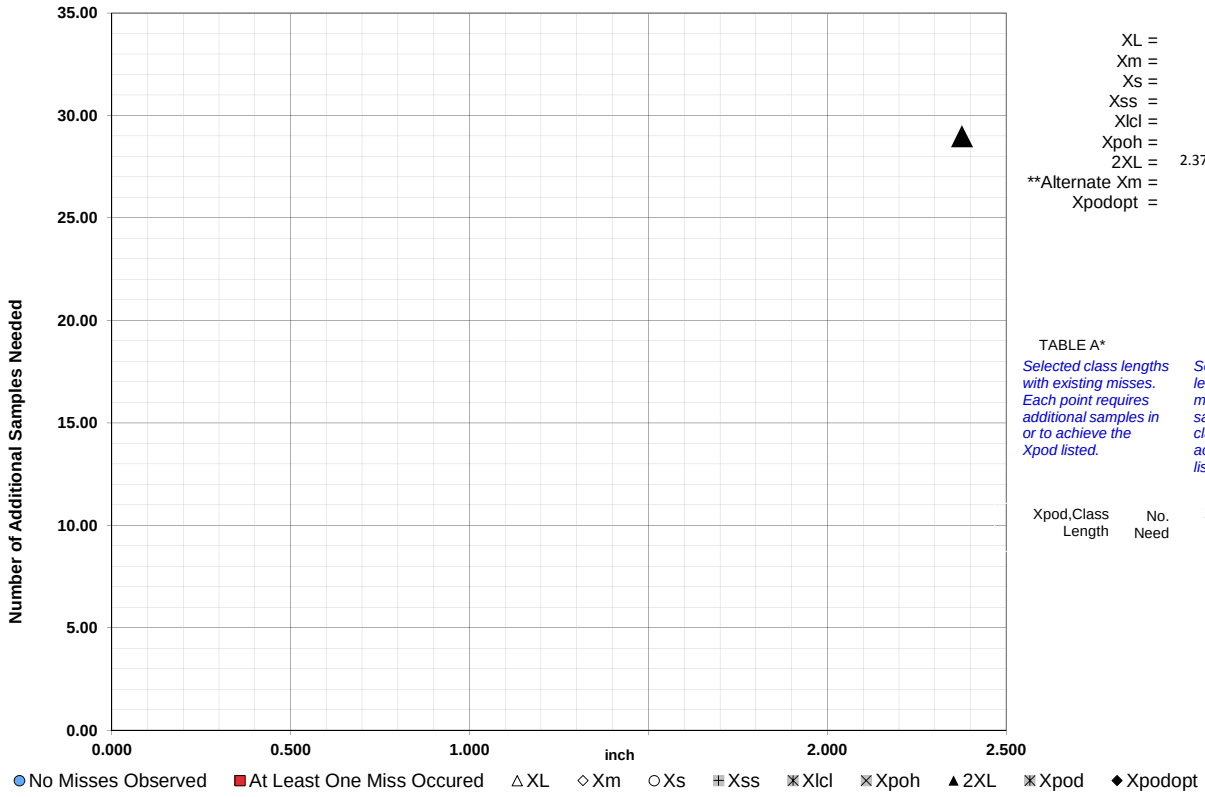



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

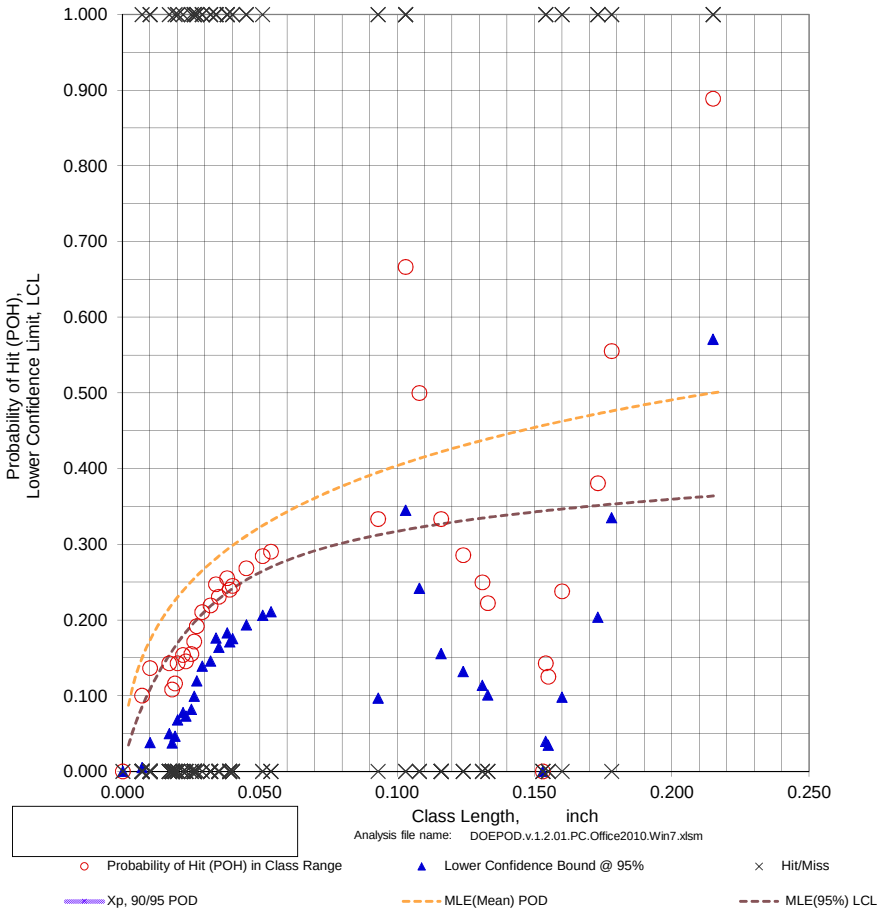
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F6002(3)D.xls
Data Set Name = F6002(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:52 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5709 | |
| Classwidth @ Best LCL = | 0.0420 | inch |
| Classlength @ Best LCL = | 0.2150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.2150 -0.036 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F6002(3)D.xls
Data Set Name = F6002(3)D(CK. NO.)

## Directed DOE Options

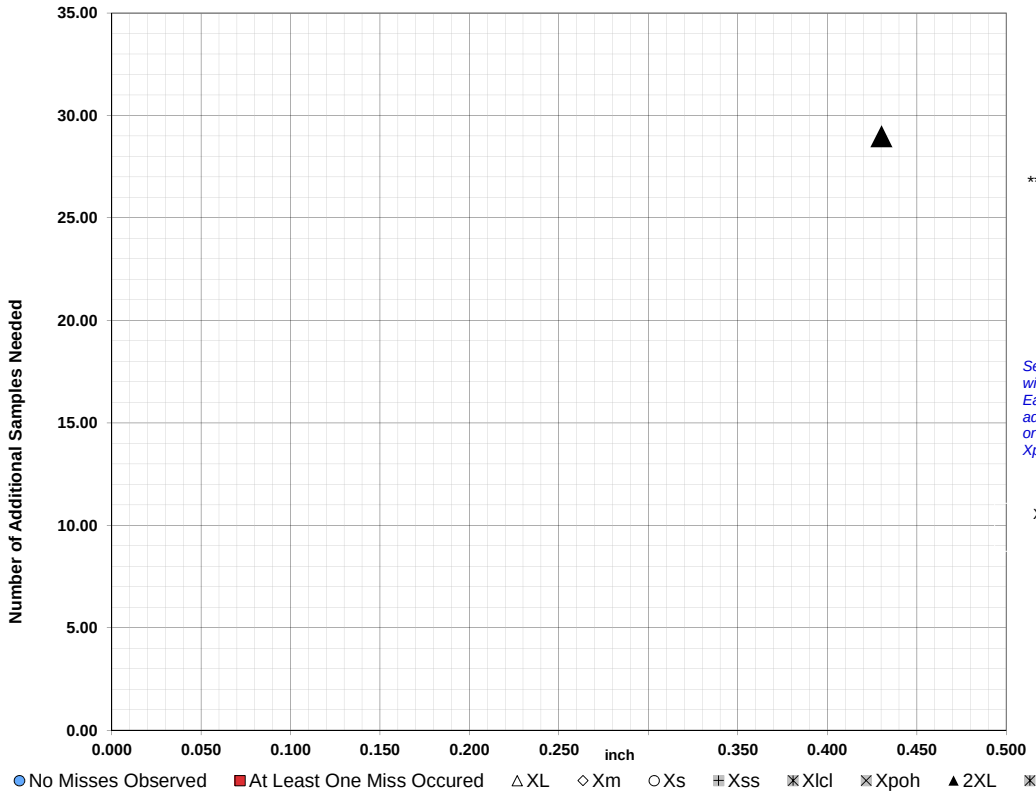



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

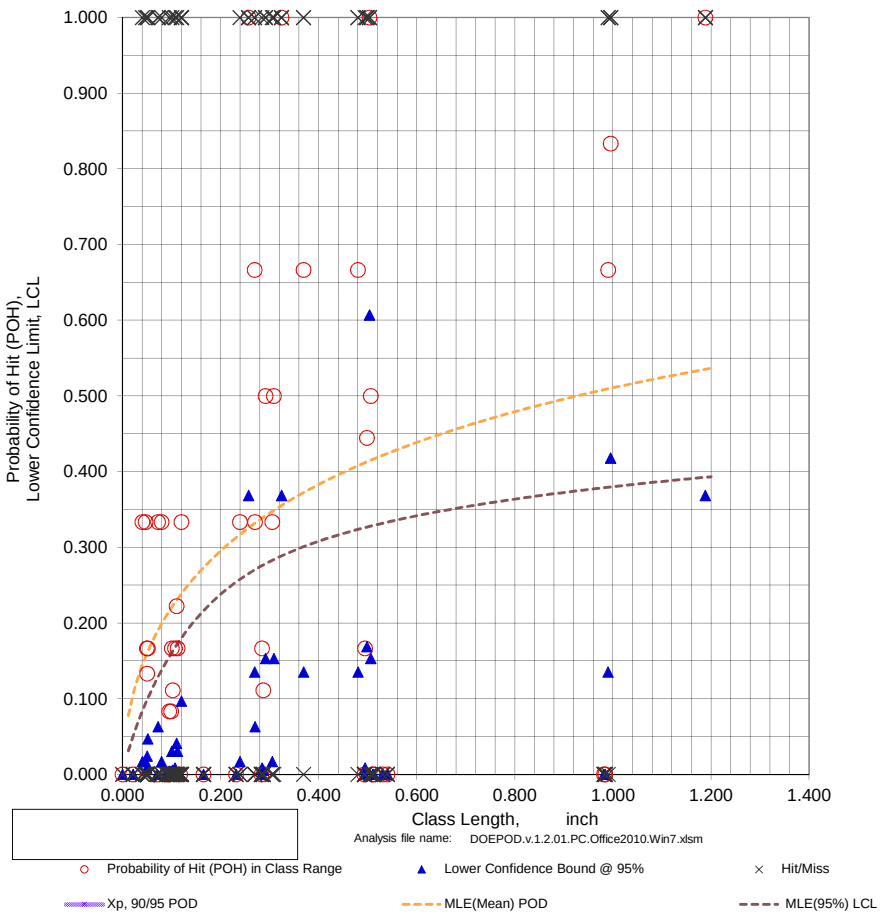
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F6002(3)L.xls
Data Set Name = F6002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:53 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.5030 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.9950 -0.004 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.188 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.188 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.376 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F6002(3)L.xls
Data Set Name = F6002(3)L(CK. NO.)

## Directed DOE Options

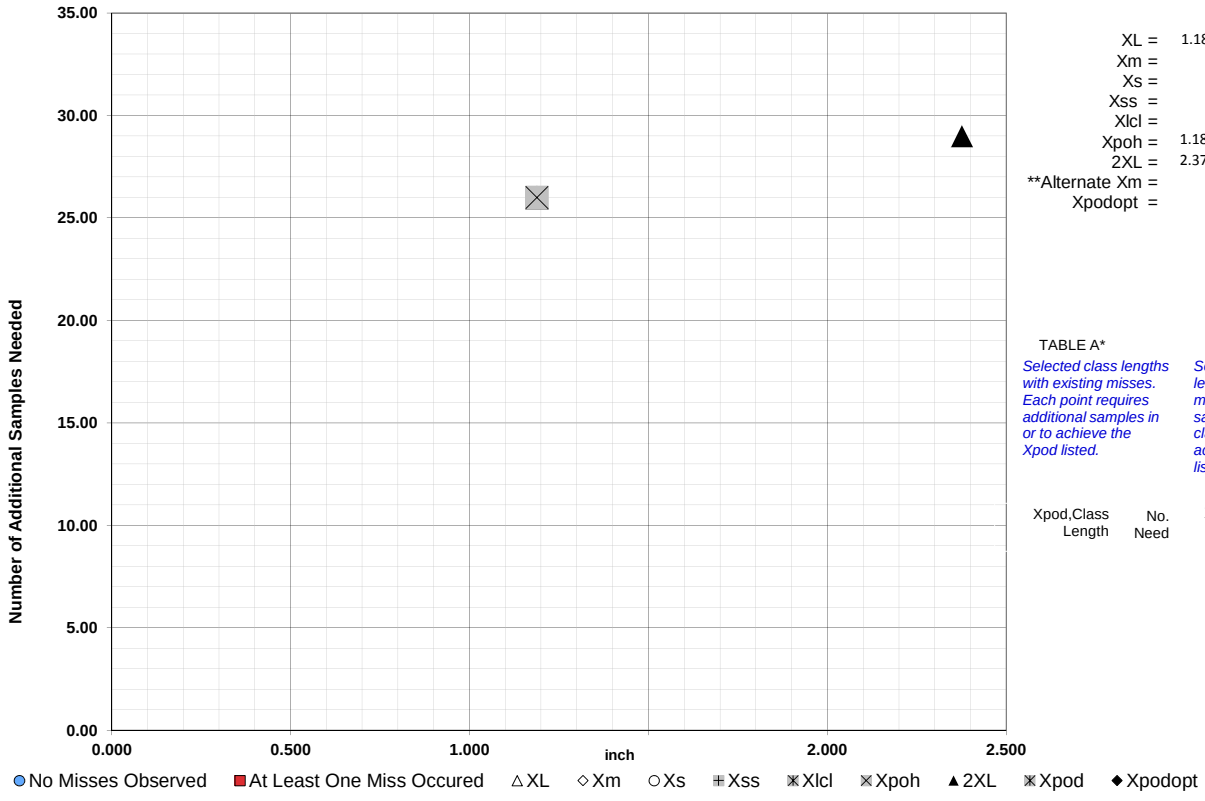



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.188 | 26 |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

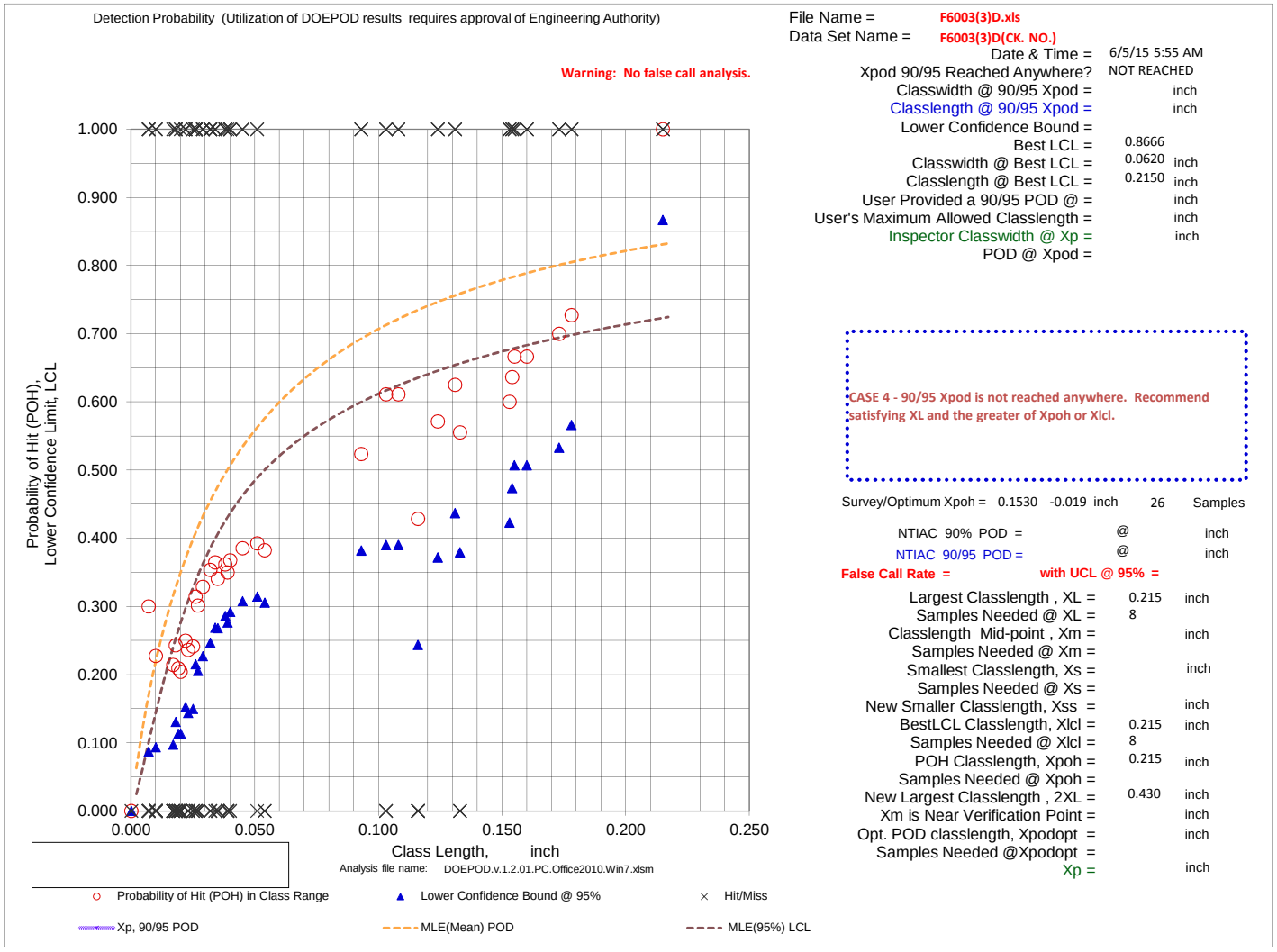
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart




File Name = F6003(3)D.xls
Data Set Name = F6003(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:55 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8666 | |
| Classwidth @ Best LCL = | 0.0620 | inch |
| Classlength @ Best LCL = | 0.2150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1530 -0.019 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.2158 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.2158 | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.215 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F6003(3)D.xls
Data Set Name = F6003(3)D(CK. NO.)

## Directed DOE Options

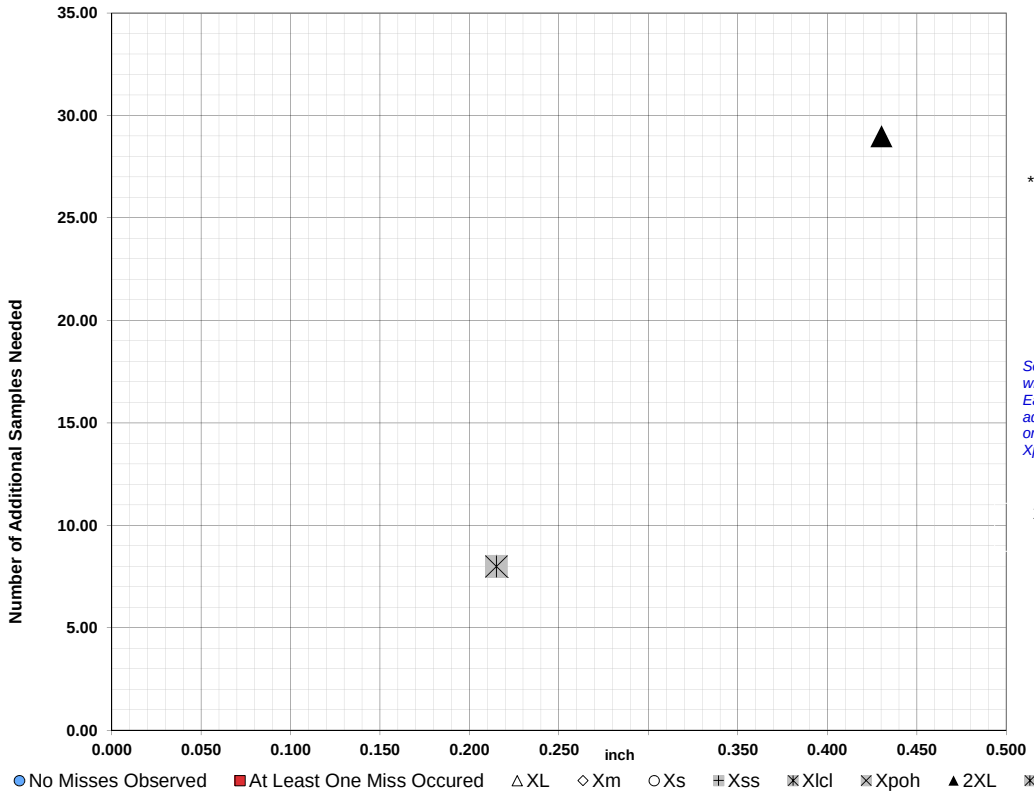



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 8 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.215 | 8 |
| Xpoh = | 0.215 | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

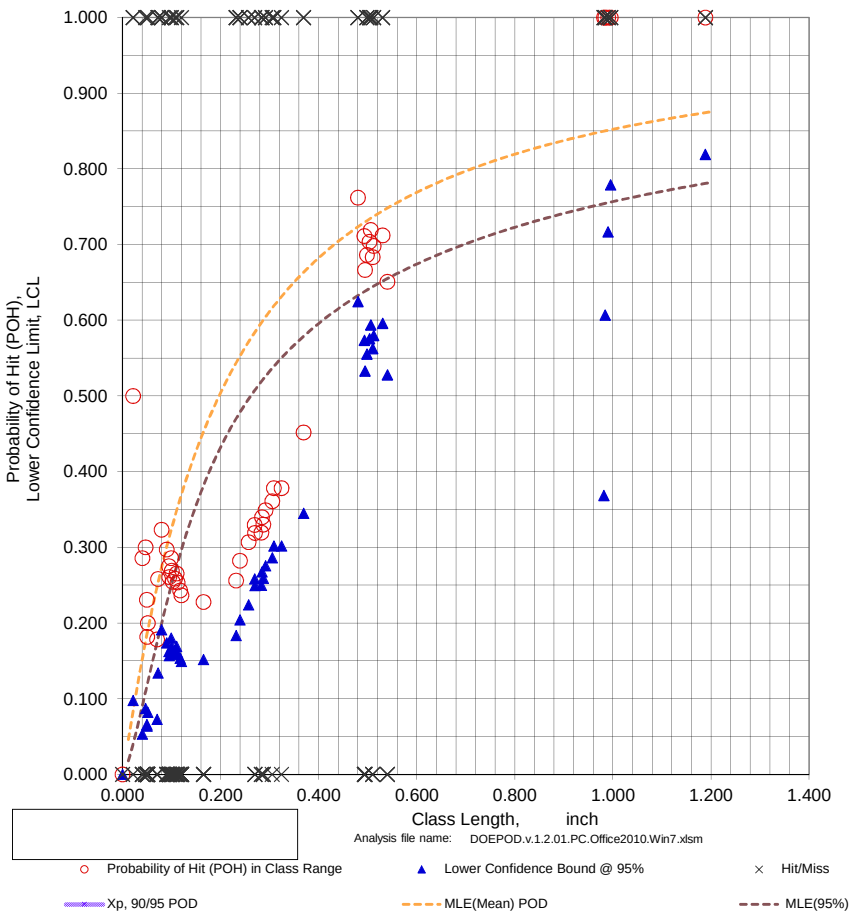
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F6003(3)L.xls
Data Set Name = F6003(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:56 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.3000 | inch |
| Classlength @ Best LCL = | 1.1880 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.9810 -0.400 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | @ | | inch |
| NTIAC 90/95 POD = | @ | | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 1.188 | inch | |
| Samples Needed @ XL = | 14 | | |
| Classlength Mid-point , Xm = | | inch | |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | inch | |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | inch | |
| BestLCL Classlength, Xlcl = | 1.188 | inch | |
| Samples Needed @ Xlcl = | 14 | | |
| POH Classlength, Xpoh = | 0.981 | inch | |
| Samples Needed @ Xpoh = | 26 | | |
| New Largest Classlength , 2XL = | 2.376 | inch | |
| Xm is Near Verification Point = | | inch | |
| Opt. POD classlength, Xpodopt = | | inch | |
| Samples Needed @Xpodopt = | | | |
| Xp = | | inch | |

File Name = F6003(3)L.xls
Data Set Name = F6003(3)L(CK. NO.)

## Directed DOE Options

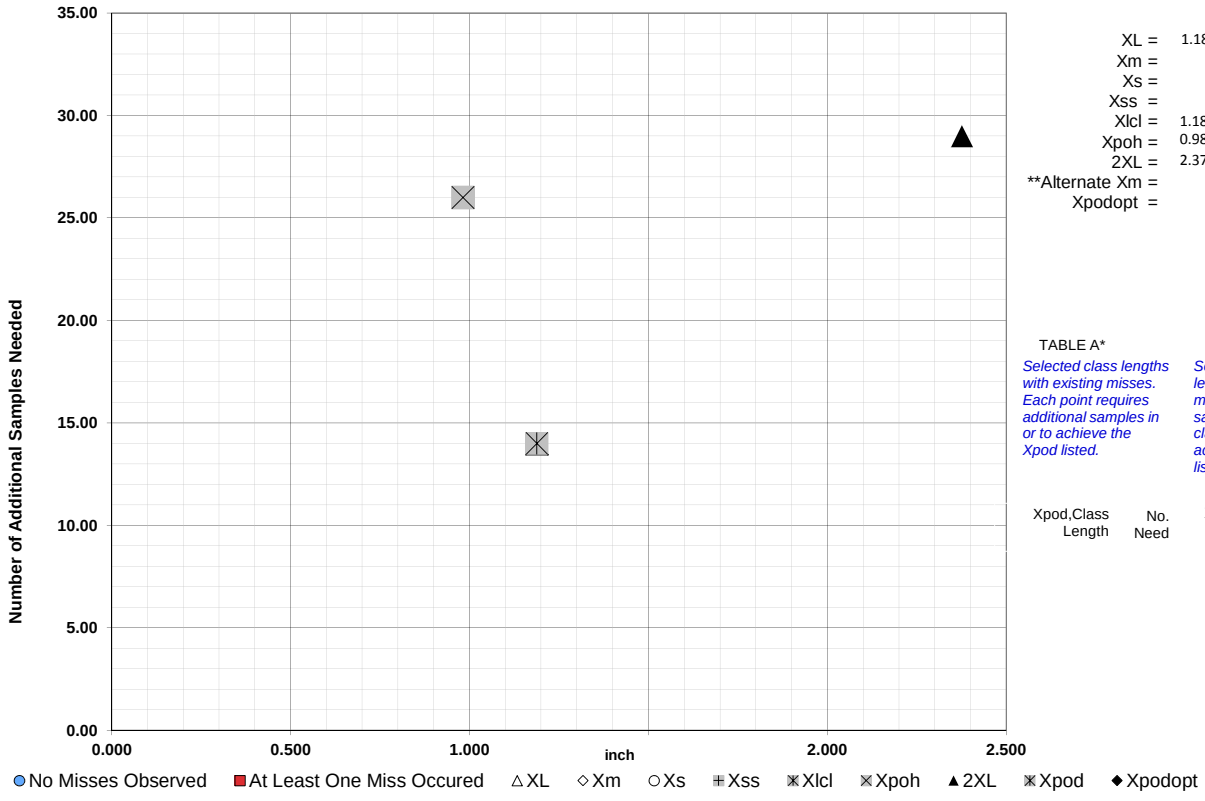



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.188 | 14 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 1.188 | 14 |
| Xpoh = | 0.981 | 26 |
| 2XL = | 2.376 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

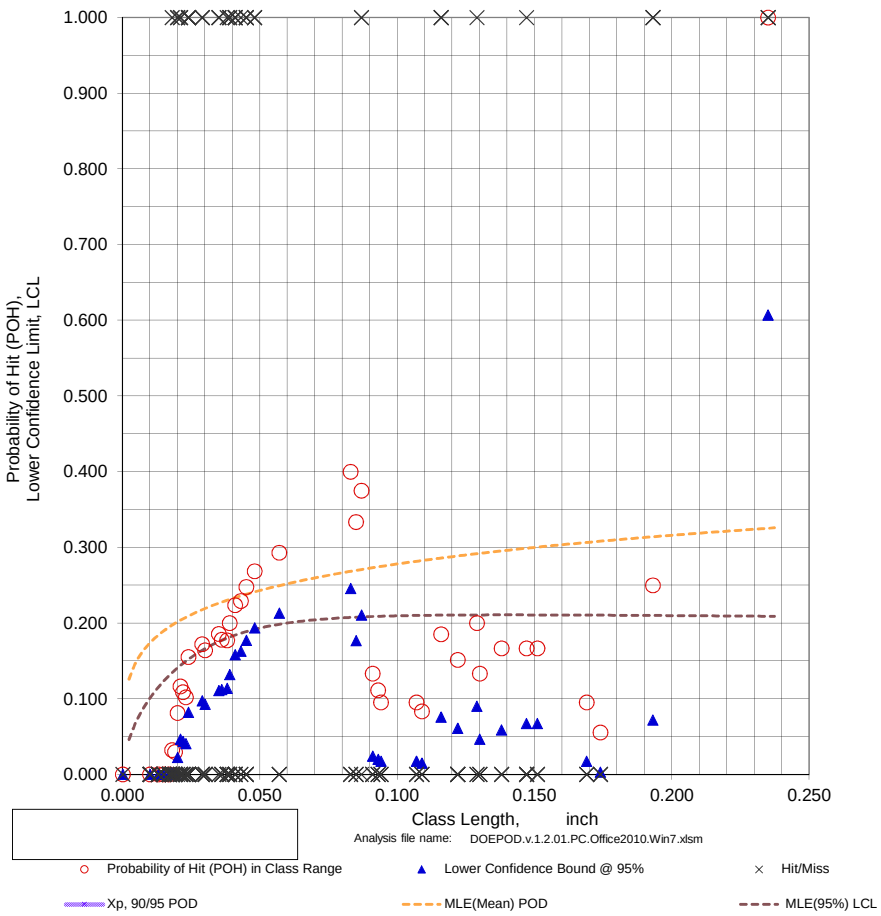
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F7001(3)D.xls
Data Set Name = F7001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:58 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0420 | inch |
| Classlength @ Best LCL = | 0.2350 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1930 -0.018 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.235 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.235 | inch |
| Samples Needed @ Xlcl = | 23 | |
| POH Classlength, Xpoh = | 0.235 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.470 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F7001(3)D.xls
Data Set Name = F7001(3)D(CK. NO.)

## Directed DOE Options

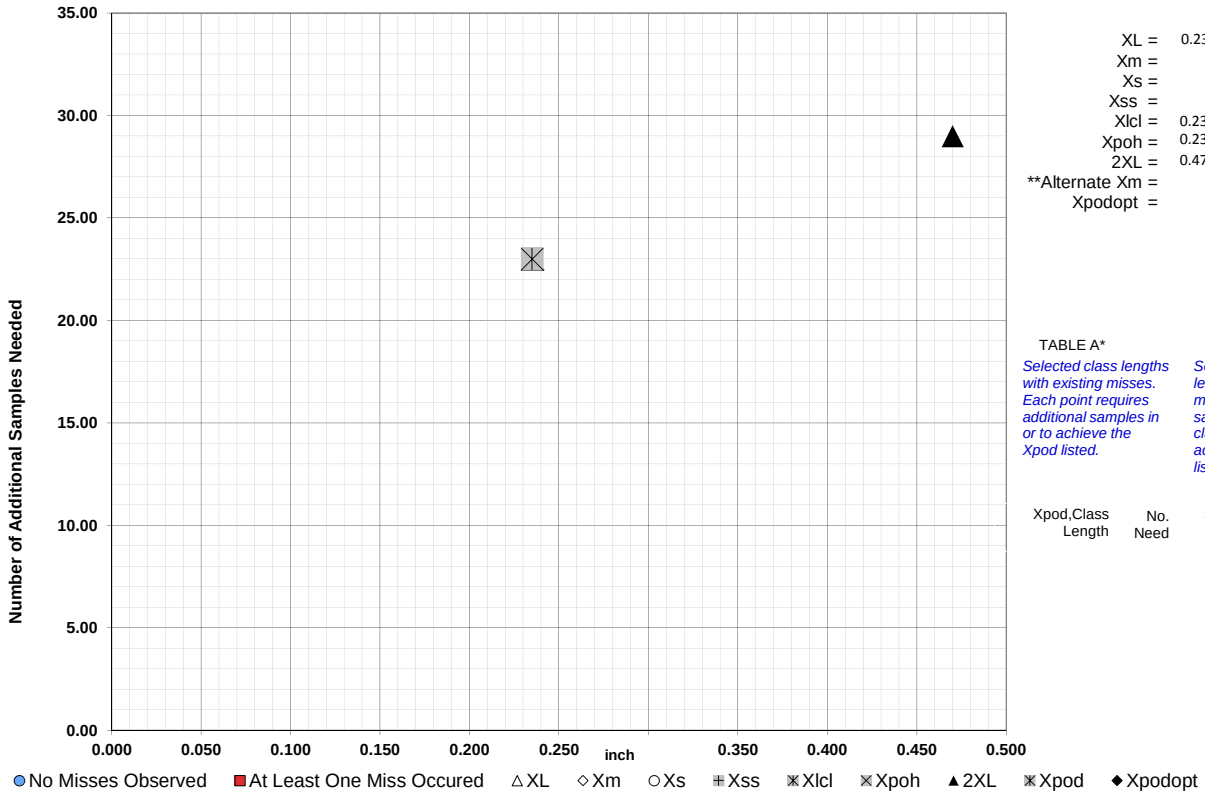



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.235 | 23 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.235 | 23 |
| Xpoh = | 0.235 | |
| 2XL = | 0.470 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

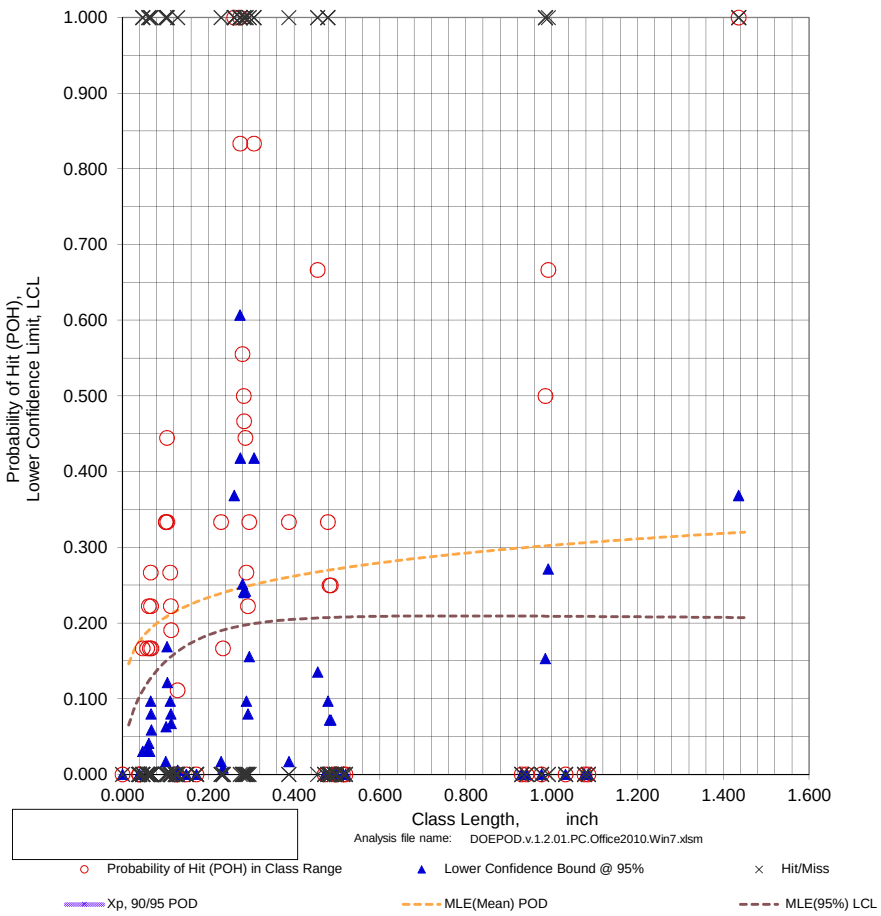
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F7001(3)L.xls
Data Set Name = F7001(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 5:59 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0130 | inch |
| Classlength @ Best LCL = | 0.2730 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.4350 -0.300 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.435 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F7001(3)L.xls
Data Set Name = F7001(3)L(CK. NO.)

## Directed DOE Options

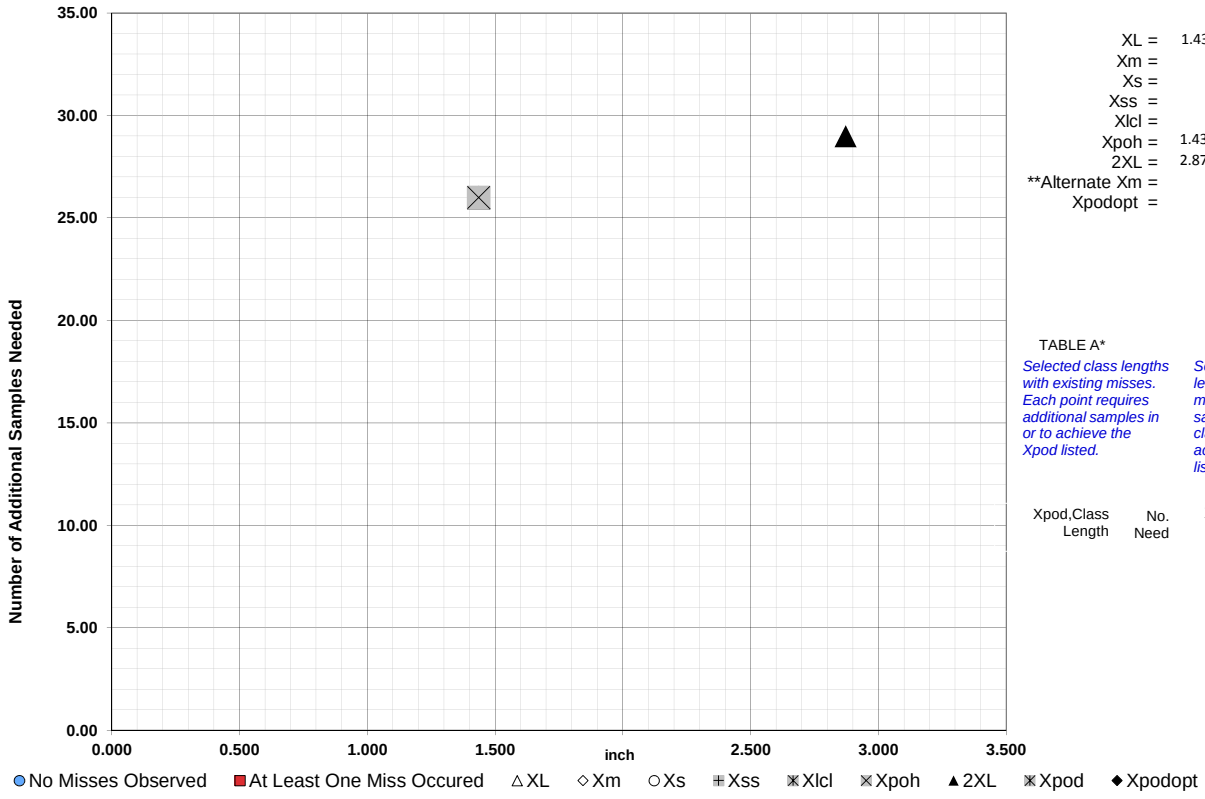



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.435 | 26 |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

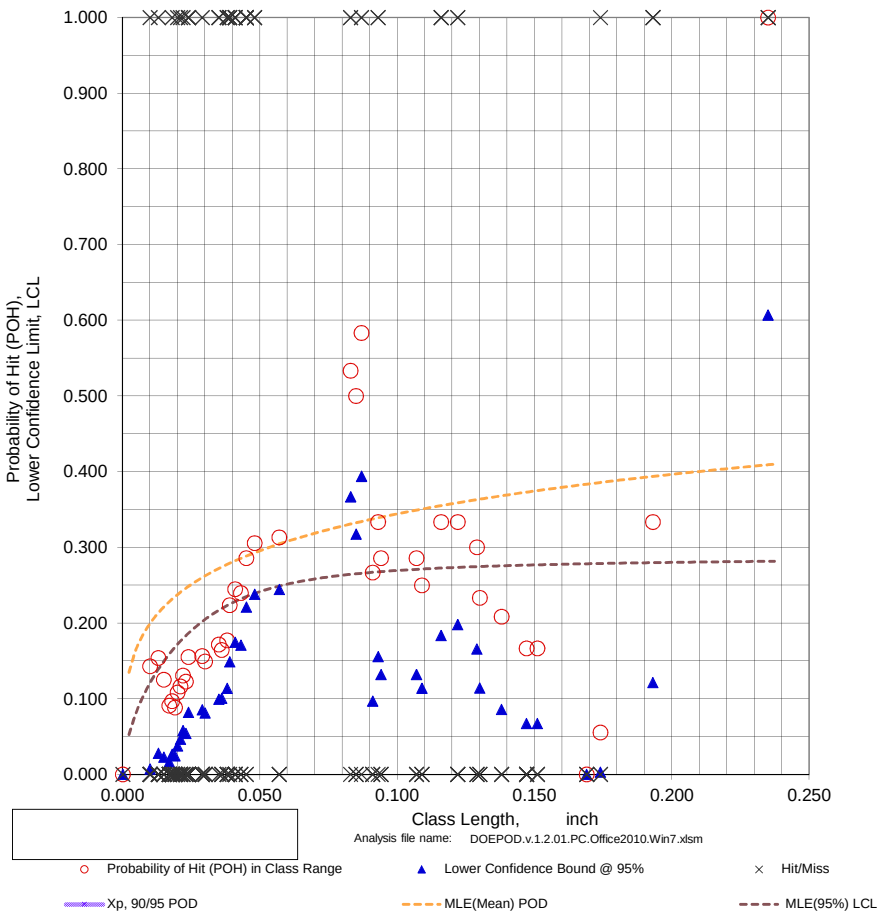
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F7002(3)D.xls
Data Set Name = F7002(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:01 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0420 | inch |
| Classlength @ Best LCL = | 0.2350 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.1930 -0.018 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | @ | | inch |
| NTIAC 90/95 POD = | @ | | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.235 | inch |
| Samples Needed @ XL = | 23 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.235 | inch |
| Samples Needed @ Xlcl = | 23 | |
| POH Classlength, Xpoh = | 0.235 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.470 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F7002(3)D.xls
Data Set Name = F7002(3)D(CK. NO.)

## Directed DOE Options

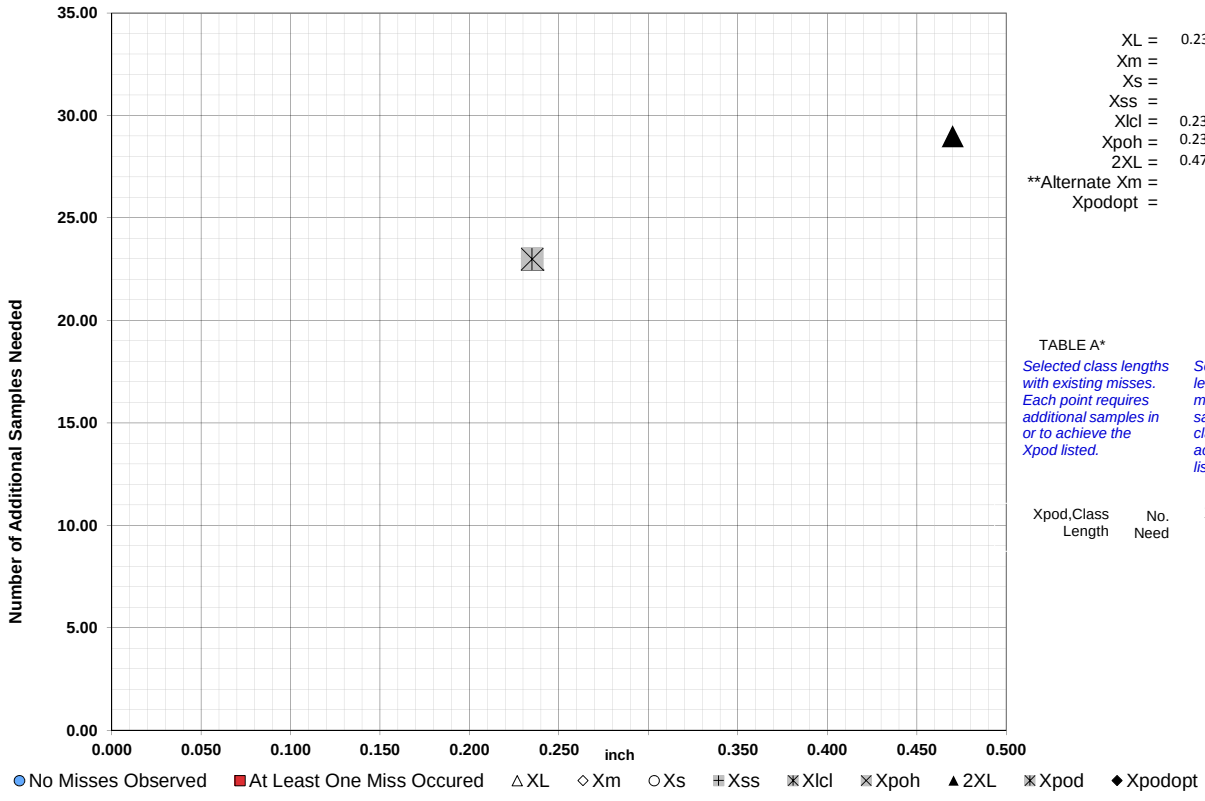



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.235 | 23 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.235 | 23 |
| Xpoh = | 0.235 | |
| 2XL = | 0.470 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

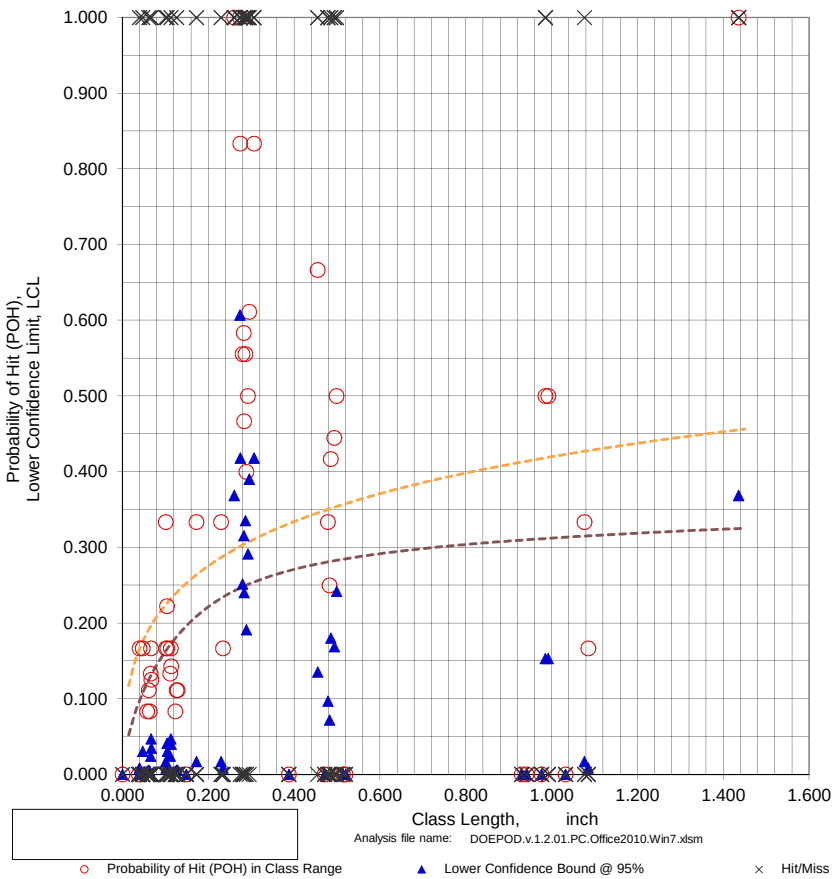
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F7002(3)L.xls
Data Set Name = F7002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:03 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6070 | |
| Classwidth @ Best LCL = | 0.0130 | inch |
| Classlength @ Best LCL = | 0.2730 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.4350 -0.300 inch 26 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.435 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F7002(3)L.xls
Data Set Name = F7002(3)L(CK. NO.)

## Directed DOE Options

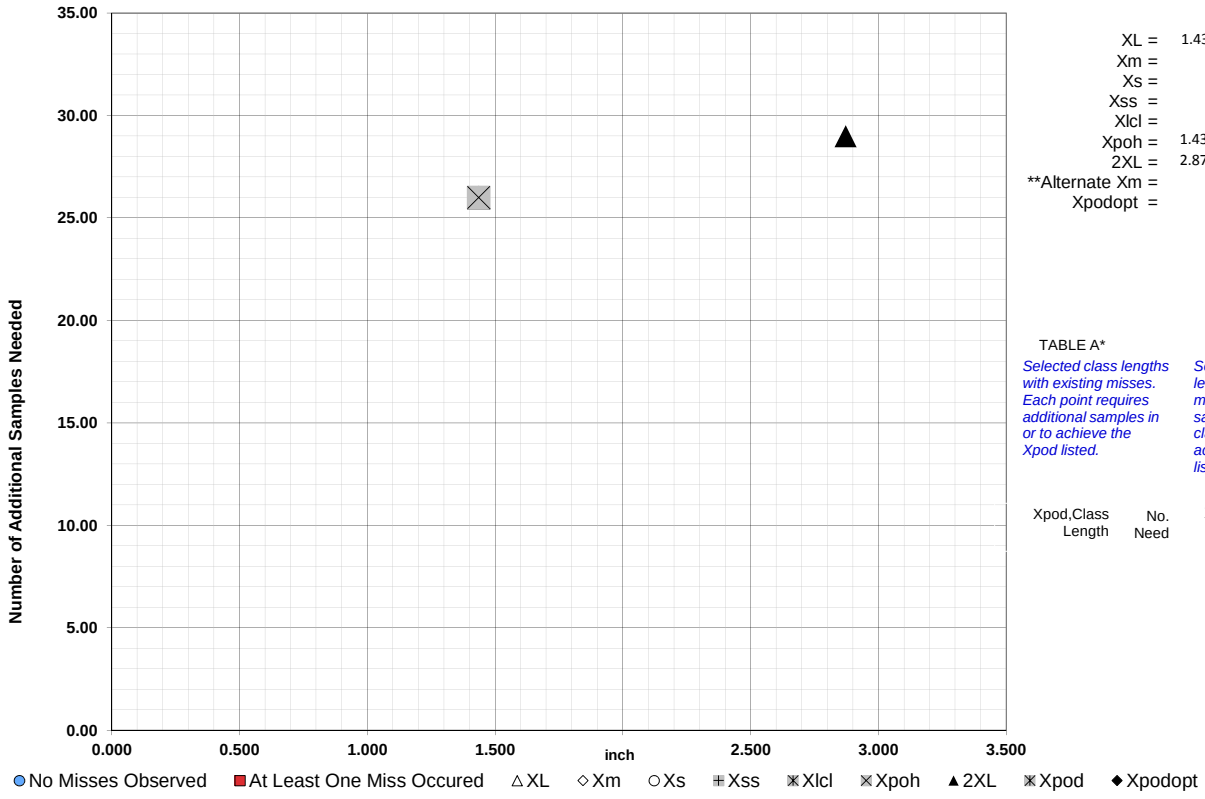



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.435 | 26 |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

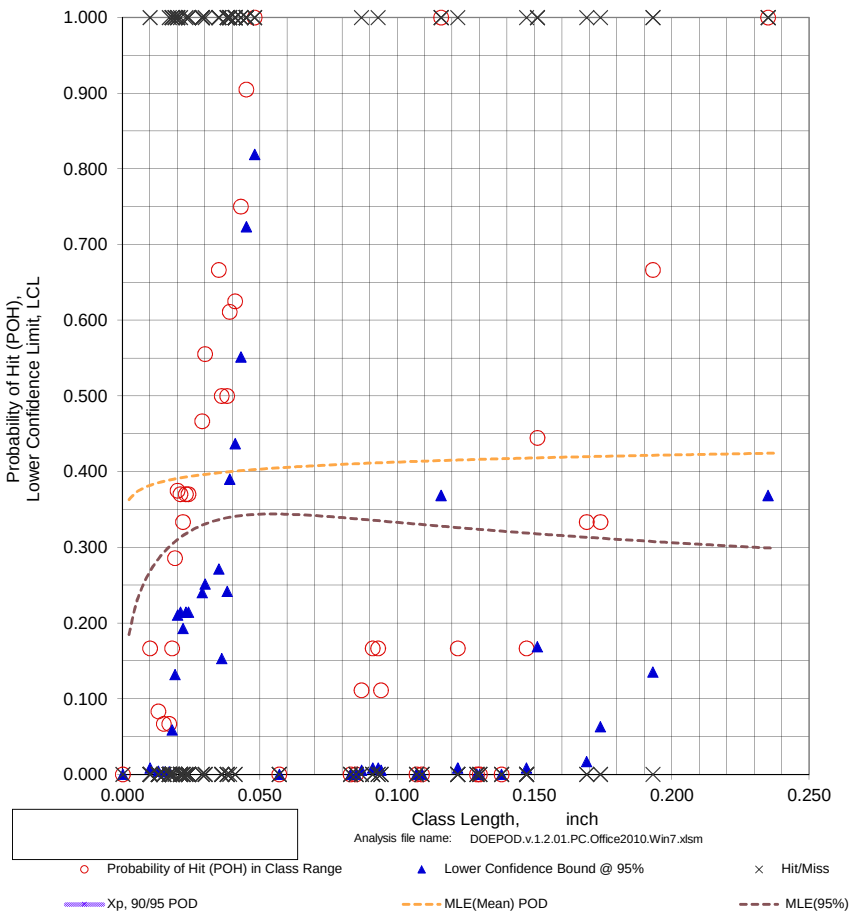
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F7003(3)D.xls
Data Set Name = F7003(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:05 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.0050 | inch |
| Classlength @ Best LCL = | 0.0480 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.2350 -0.041 inch 26 Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.235 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.235 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 0.470 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F7003(3)D.xls
Data Set Name = F7003(3)D(CK. NO.)

## Directed DOE Options

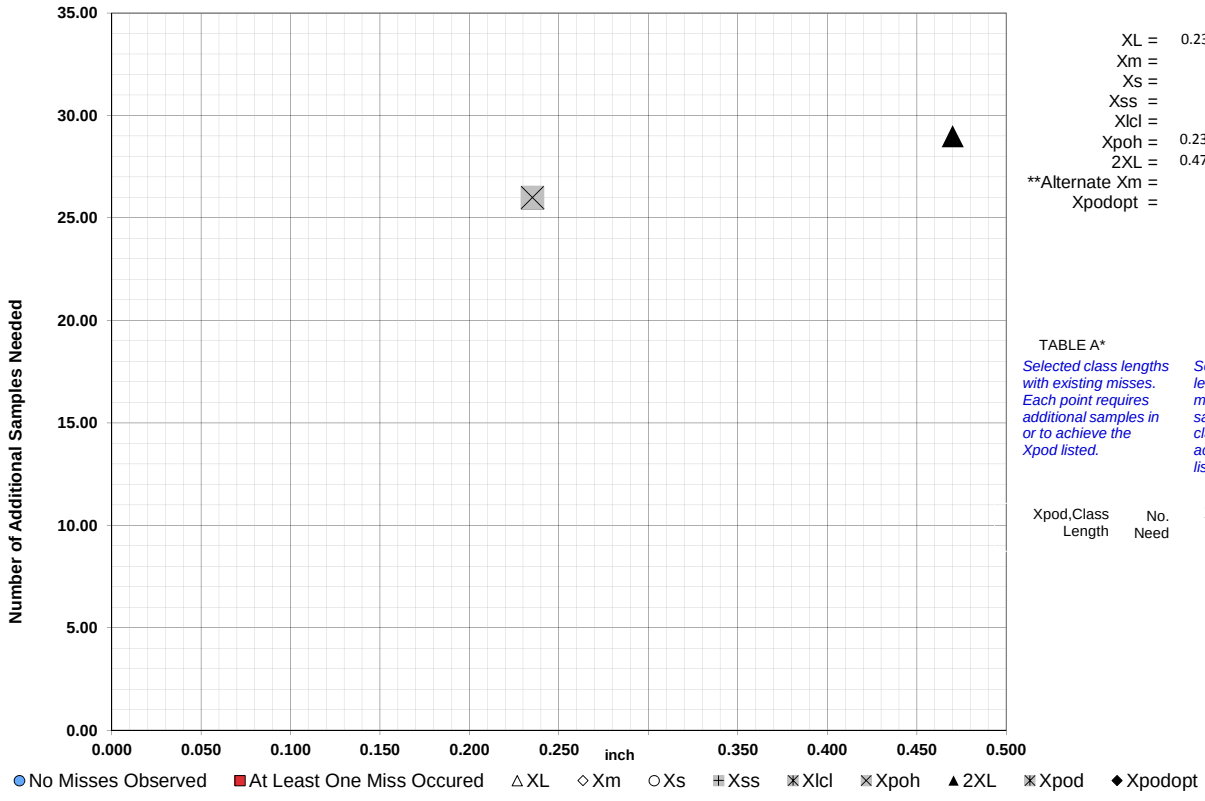



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.235 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.235 | 26 |
| 2XL = | 0.470 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

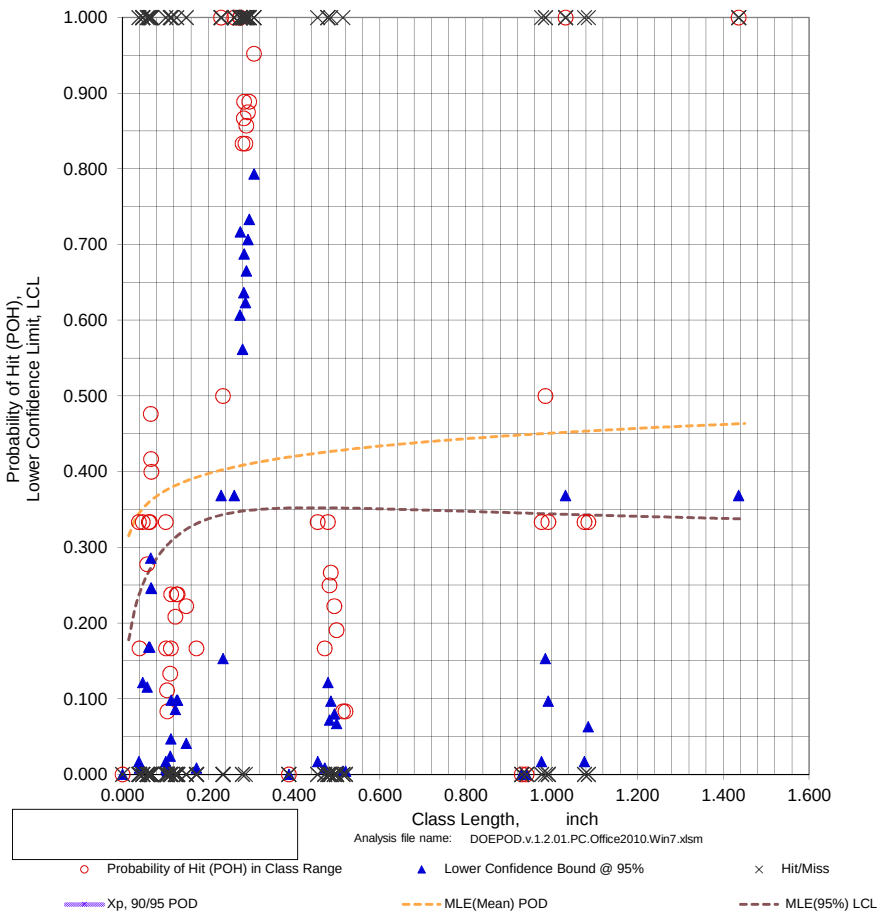
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F7003(3)L.xls
Data Set Name = F7003(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:06 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7933 | |
| Classwidth @ Best LCL = | 0.0240 | inch |
| Classlength @ Best LCL = | 0.3060 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 1.4350 -0.300 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.435 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 1.435 | inch |
| Samples Needed @ Xpoh = | 26 | |
| New Largest Classlength , 2XL = | 2.870 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F7003(3)L.xls
Data Set Name = F7003(3)L(CK. NO.)

## Directed DOE Options

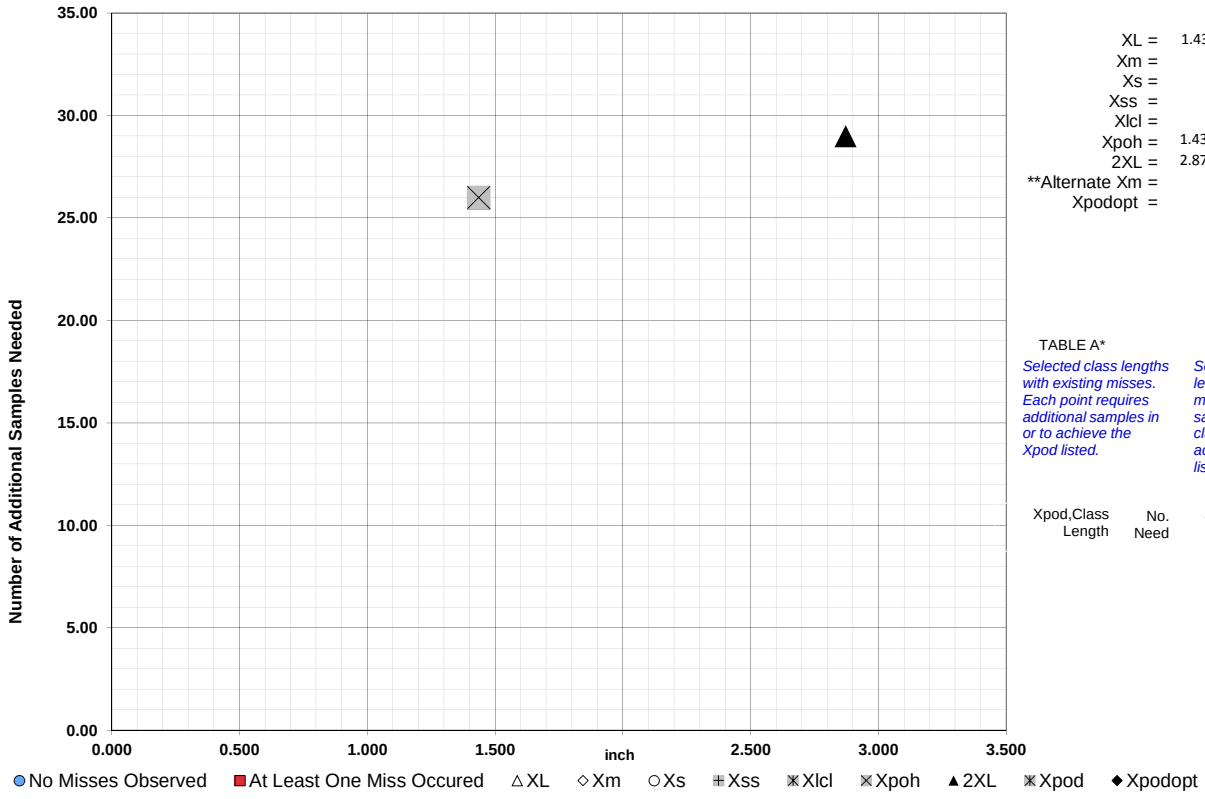



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.435 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 1.435 | 26 |
| 2XL = | 2.870 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

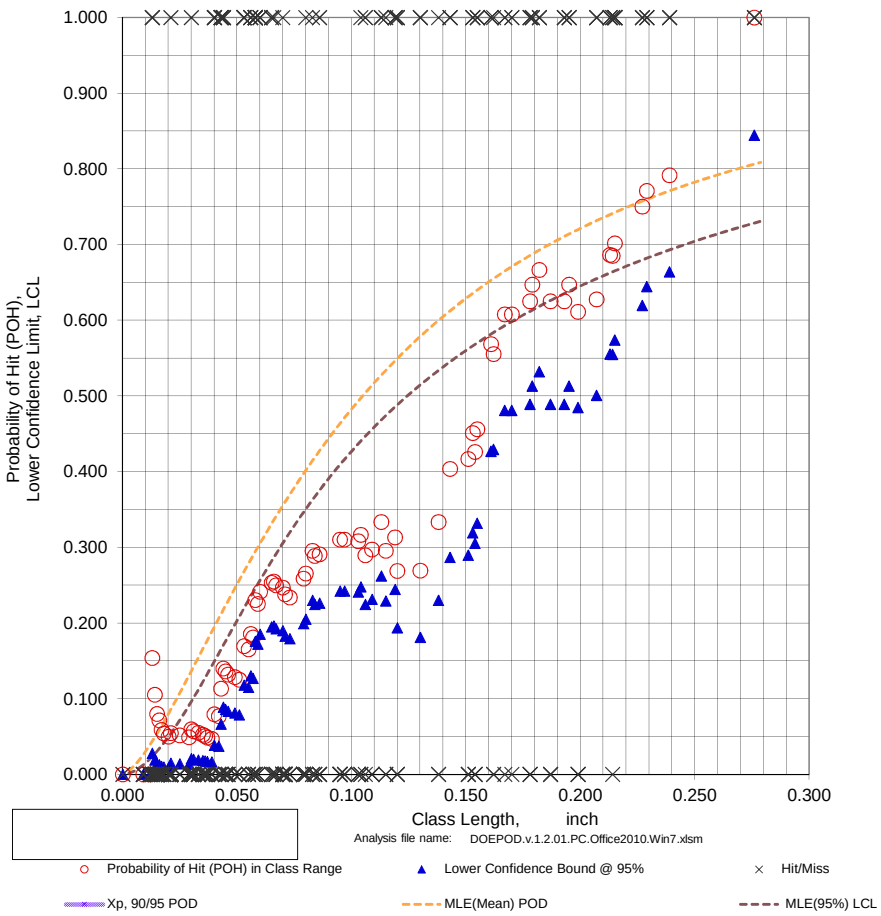
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = F8001(3)D.xls
Data Set Name = F8001(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:08 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8444 | |
| Classwidth @ Best LCL = | 0.0610 | inch |
| Classlength @ Best LCL = | 0.2760 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2270 -0.012 inch 26 Samples

NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.276 | inch |
| Samples Needed @ XL = | 11 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.276 | inch |
| Samples Needed @ Xlcl = | 11 | |
| POH Classlength, Xpoh = | 0.276 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.552 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F8001(3)D.xls
Data Set Name = F8001(3)D(CK. NO.)

## Directed DOE Options

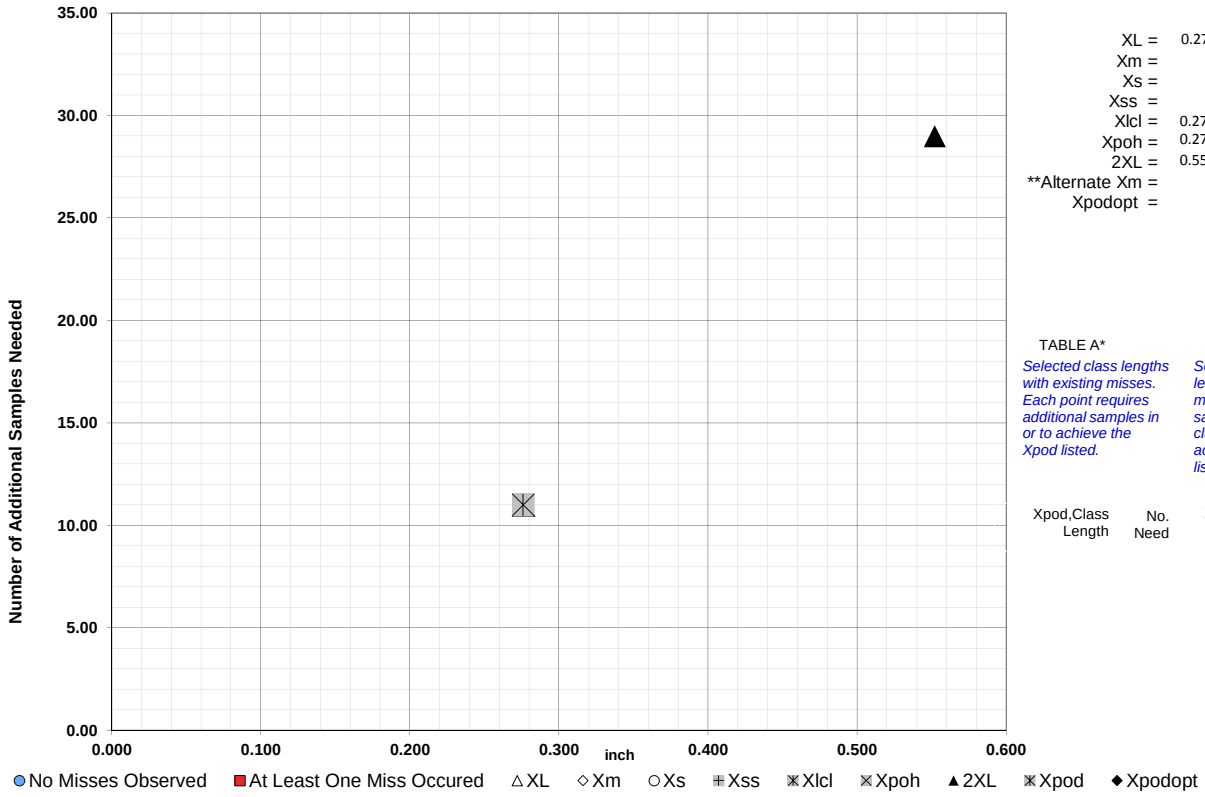



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.276 | 11 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.276 | 11 |
| Xpoh = | 0.276 | |
| 2XL = | 0.552 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

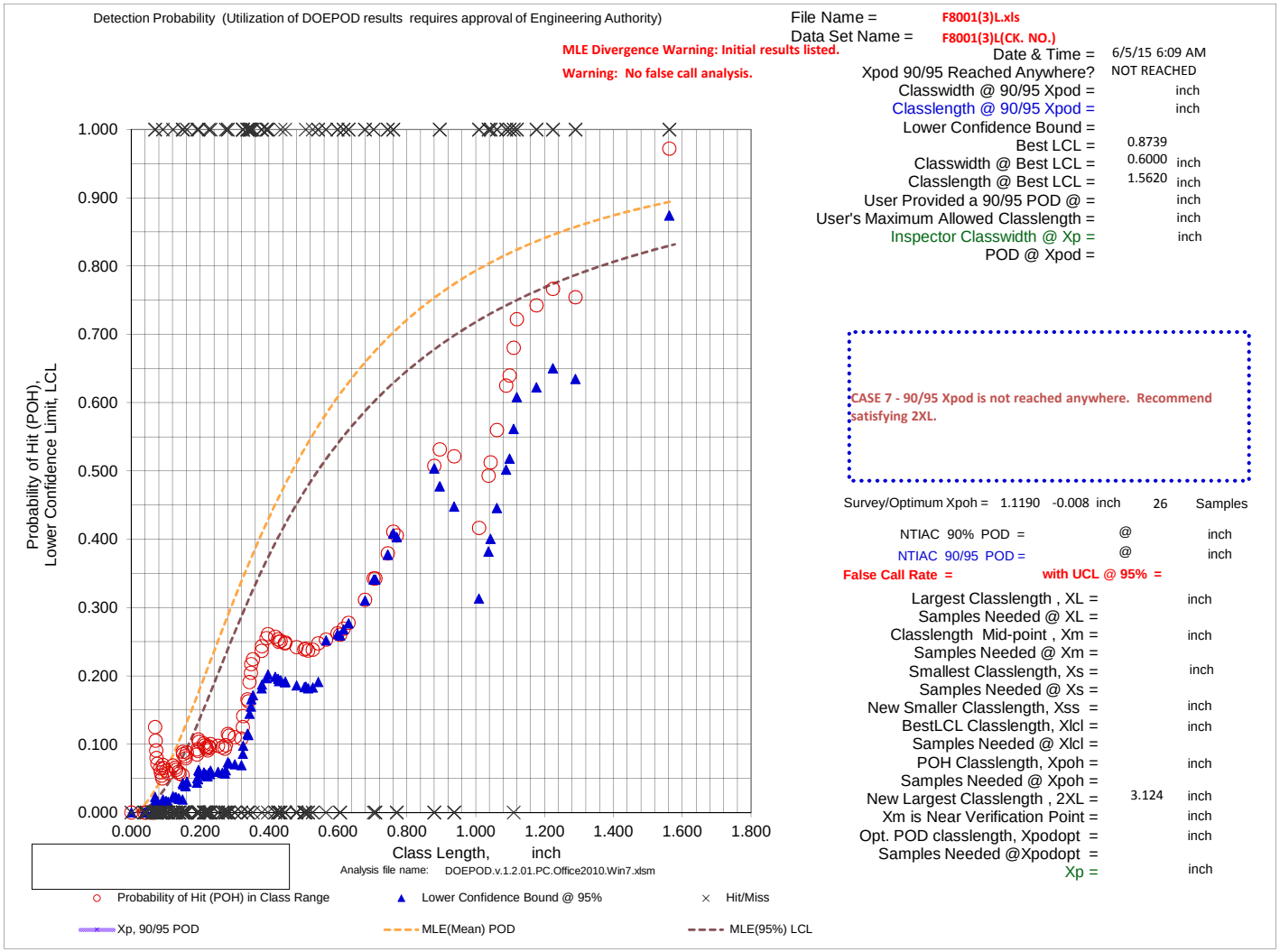
| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart


Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)
File Name = F8001(3)L.xls
Data Set Name = F8001(3)L(CK. NO.)
MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.
Date & Time = 6/5/15 6:09 AM
Xpod 90/95 Reached Anywhere? NOT REACHED
Classwidth @ 90/95 Xpod = inch
Classlength @ 90/95 Xpod = inch
Lower Confidence Bound =
Best LCL = 0.8739
Classwidth @ Best LCL = 0.6000 inch
Classlength @ Best LCL = 1.5620 inch
User Provided a 90/95 POD @ = inch
User's Maximum Allowed Classlength = inch
Inspector Classwidth @ Xp = inch
POD @ Xpod =
CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.
Survey/Optimum Xpoh = 1.1190 -0.008 inch 26 Samples
NTIAC 90% POD = @ inch
NTIAC 90/95 POD = @ inch
False Call Rate = with UCL @ 95% =
Largest Classlength , XL = inch
Samples Needed @ XL =
Classlength Mid-point , Xm = inch
Samples Needed @ Xm =
Smallest Classlength, Xs = inch
Samples Needed @ Xs =
New Smaller Classlength, Xss = inch
BestLCL Classlength, Xlcl = inch
Samples Needed @ Xlcl =
POH Classlength, Xpoh = inch
Samples Needed @ Xpoh =
New Largest Classlength , 2XL = 3.124 inch
Xm is Near Verification Point = inch
Opt. POD classlength, Xpodopt = inch
Samples Needed @Xpodopt =
Xp = inch
Probability of Hit (POH), Lower Confidence Limit, LCL
1.000
0.900
0.800
0.700
0.600
0.500
0.400
0.300
0.200
0.100
0.000
0.000 0.200 0.400 0.600 0.800 1.000 1.200 1.400 1.600 1.800
Class Length, inch
Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm
Probability of Hit (POH) in Class Range
Lower Confidence Bound @ 95%
Hit/Miss
Xp, 90/95 POD
MLE(Mean) POD
MLE(95%) LCL

File Name = F8001(3)L.xls
Data Set Name = F8001(3)L(CK. NO.)

## Directed DOE Options

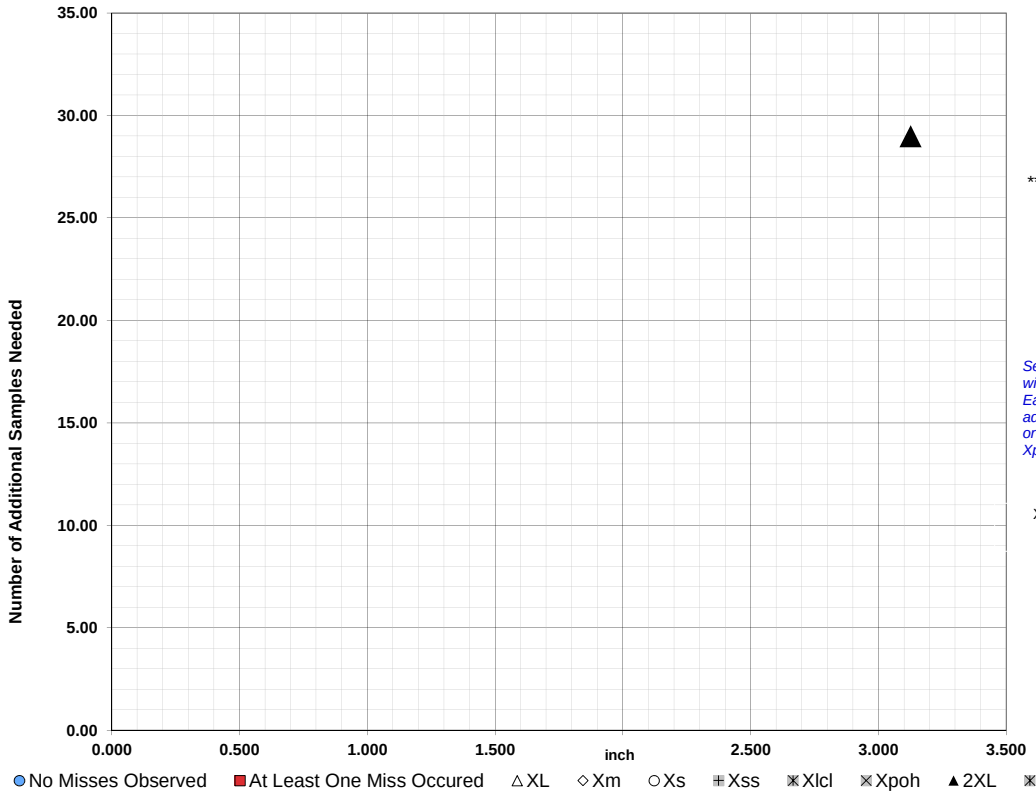



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 3.124 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

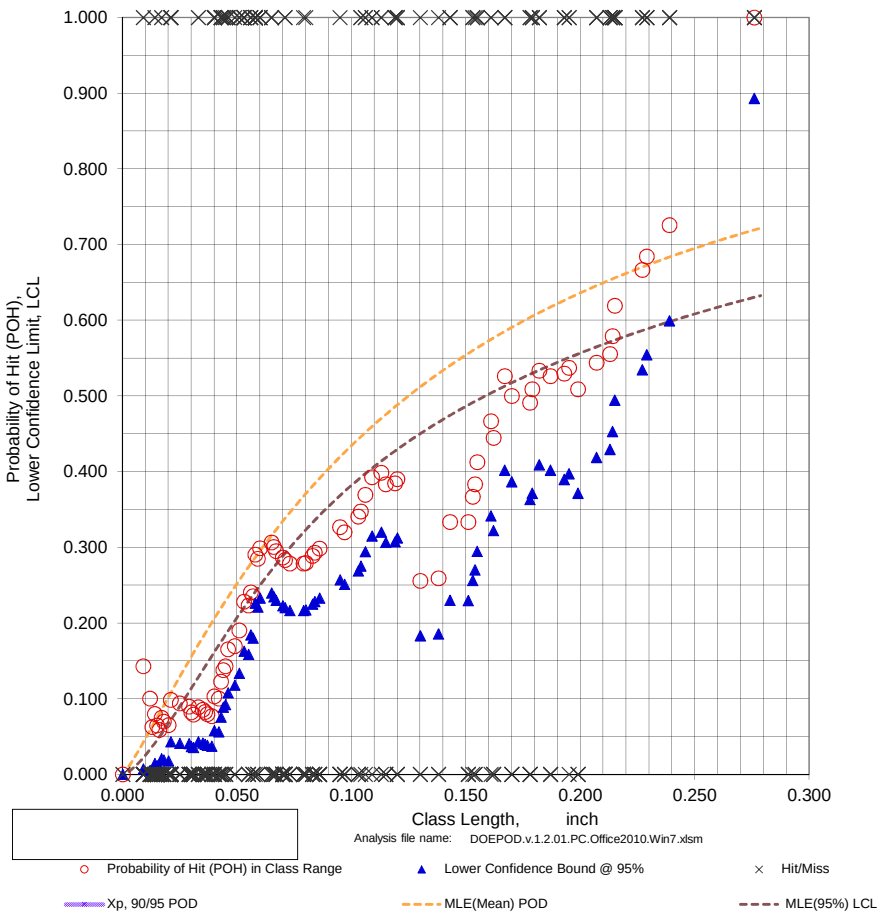
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F8002(3)D.xls
Data Set Name = F8002(3)D(CK. NO.)

MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:11 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0690 | inch |
| Classlength @ Best LCL = | 0.2760 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2070 -0.007 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.276 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.276 | inch |
| Samples Needed @ Xlcl = | 2 | |
| POH Classlength, Xpoh = | 0.276 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.552 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F8002(3)D.xls
Data Set Name = F8002(3)D(CK. NO.)

## Directed DOE Options

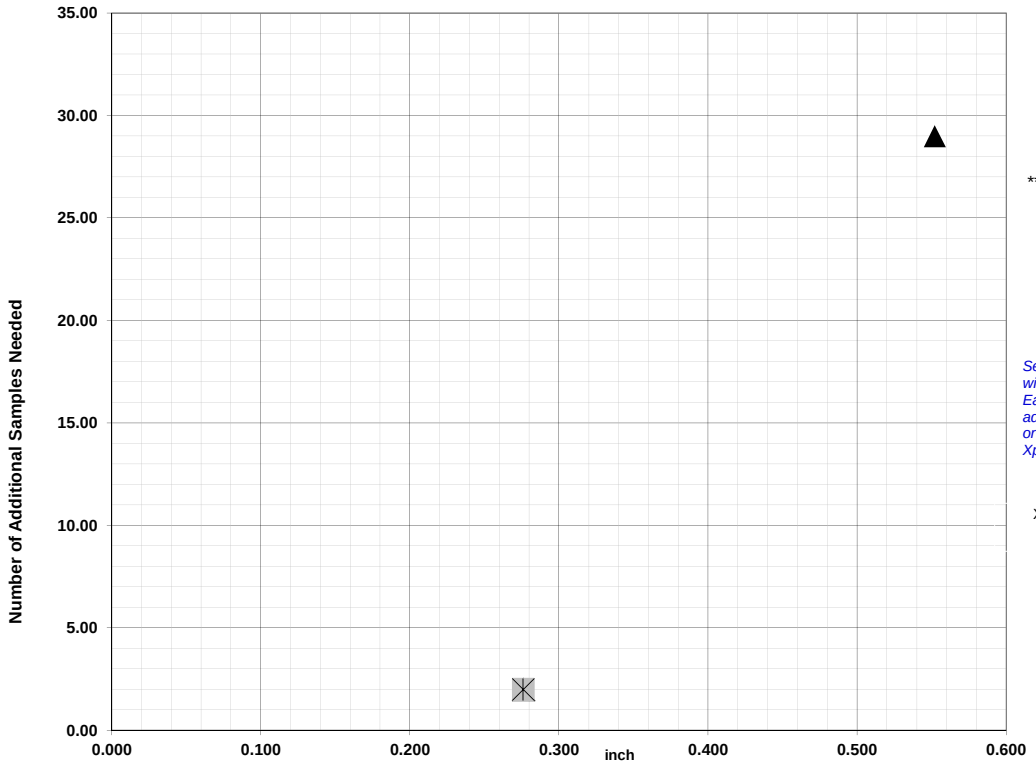



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.276 | 2 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.276 | 2 |
| Xpoh = | 0.276 | |
| 2XL = | 0.552 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

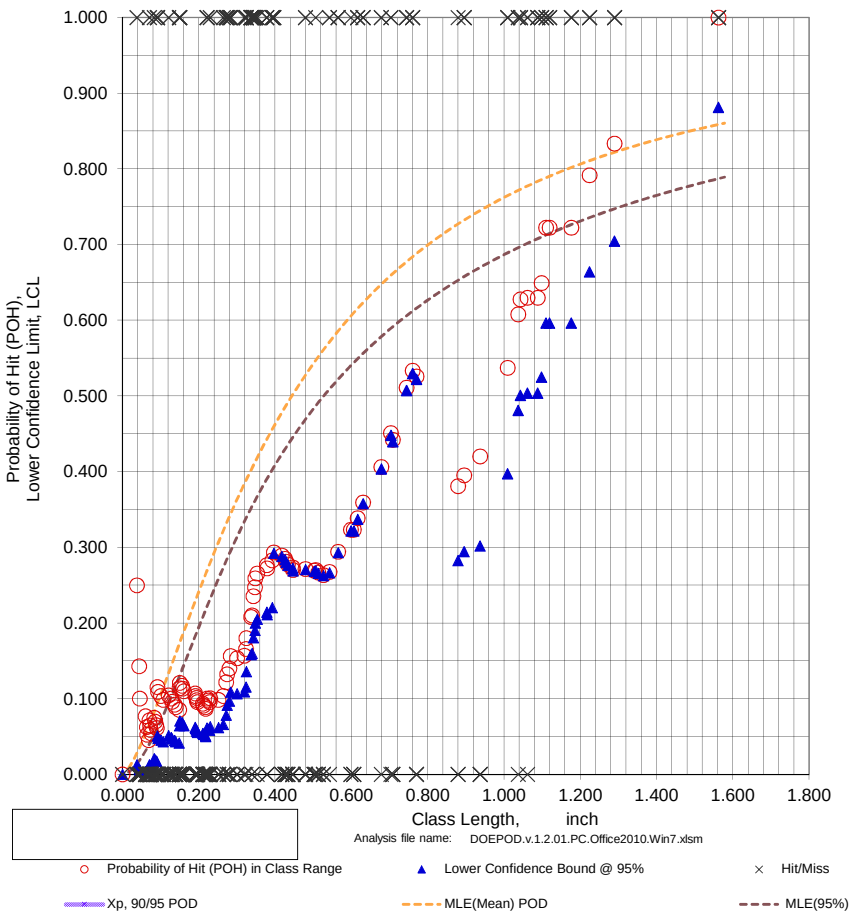
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F8002(3)L.xls
Data Set Name = F8002(3)L(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:12 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8813 | |
| Classwidth @ Best LCL = | 0.5000 | inch |
| Classlength @ Best LCL = | 1.5620 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 1.0880 -0.026 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | 5 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 1.562 | inch |
| Samples Needed @ Xlcl = | 5 | |
| POH Classlength, Xpoh = | 1.562 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 3.124 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F8002(3)L.xls
Data Set Name = F8002(3)L(CK. NO.)

## Directed DOE Options

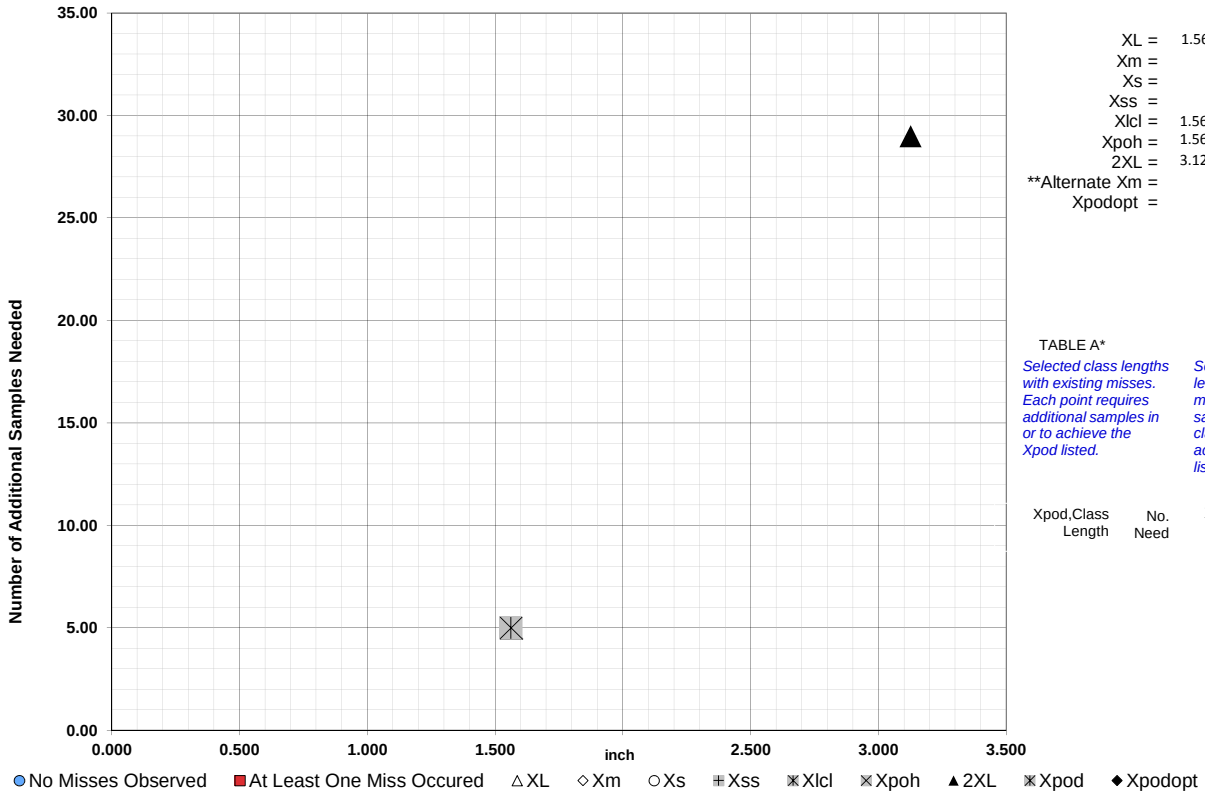



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | 5 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 1.562 | 5 |
| Xpoh = | 1.562 | |
| 2XL = | 3.124 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

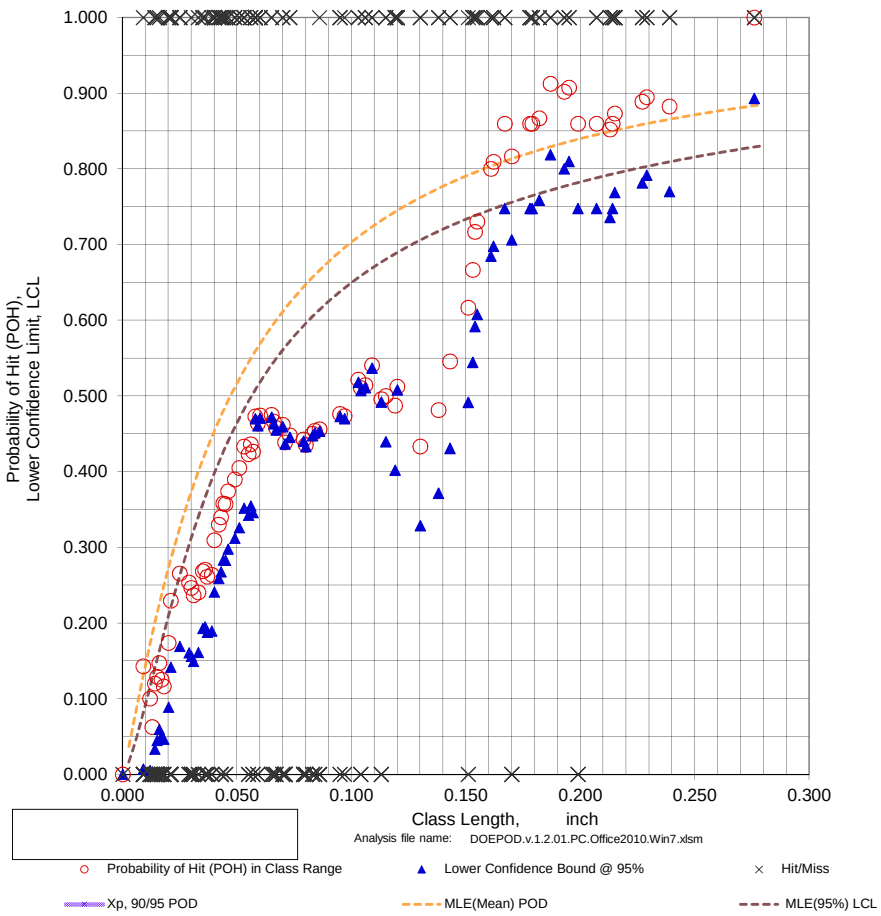
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F8003(3)D.xls
Data Set Name = F8003(3)D(CK. NO.)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:15 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8931 | |
| Classwidth @ Best LCL = | 0.0690 | inch |
| Classlength @ Best LCL = | 0.2760 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2070 -0.007 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | @ | | inch |
| NTIAC 90/95 POD = | @ | | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.276 | inch |
| Samples Needed @ XL = | 2 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.276 | inch |
| Samples Needed @ Xlcl = | 2 | |
| POH Classlength, Xpoh = | 0.276 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.552 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F8003(3)D.xls
Data Set Name = F8003(3)D(CK. NO.)

## Directed DOE Options

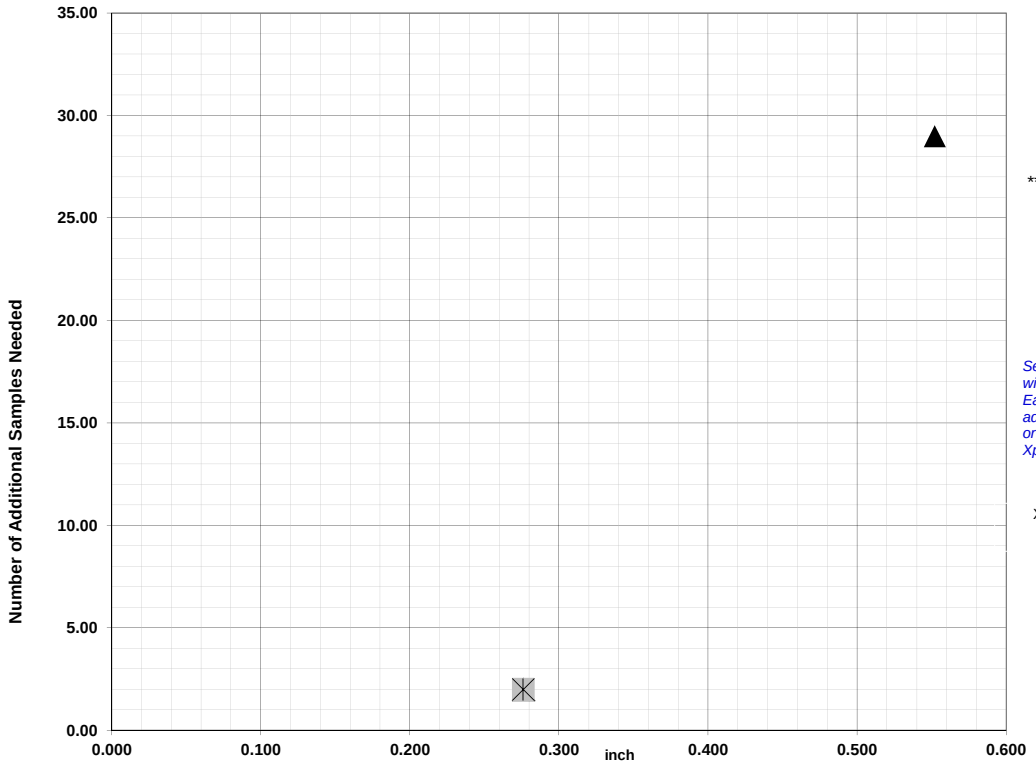



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.276 | 2 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.276 | 2 |
| Xpoh = | 0.276 | |
| 2XL = | 0.552 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

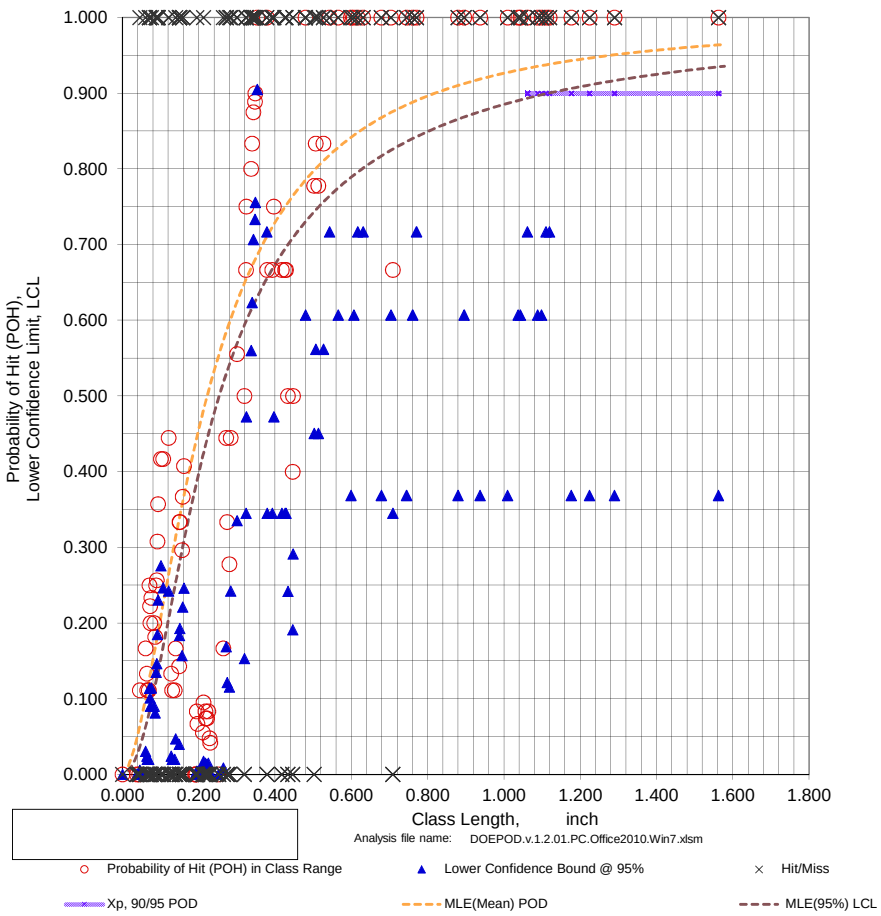
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Need 7 more large flaws.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **F8003(3)L.xls**

Data Set Name = **F8003(3)L(CK. NO.)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:17 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0300 | inch |
| Classlength @ 90/95 Xpod = | 0.3530 | inch |
| Lower Confidence Bound = | 0.9050 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 1.562 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 1.119 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 1.0610 | inch |

File Name = F8003(3)L.xls
Data Set Name = F8003(3)L(CK. NO.)

## Directed DOE Options

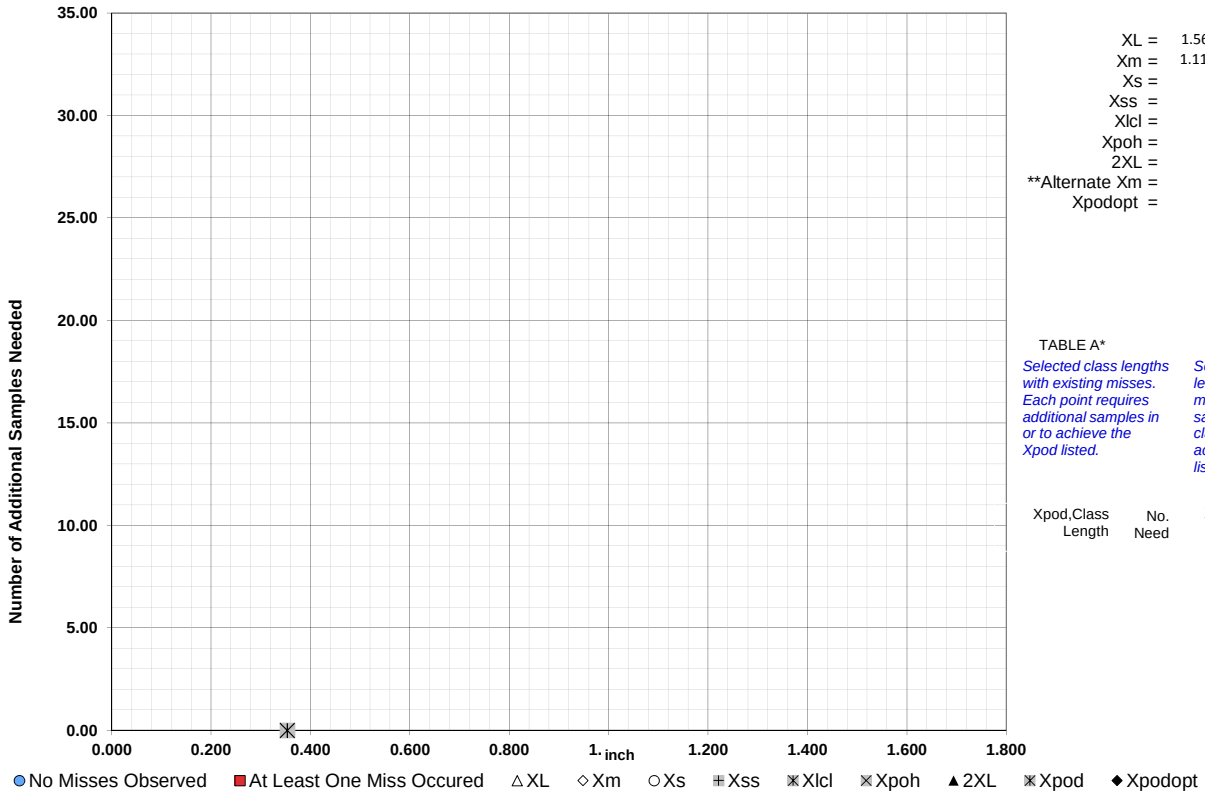



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 1.562 | |
| Xm = | 1.119 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

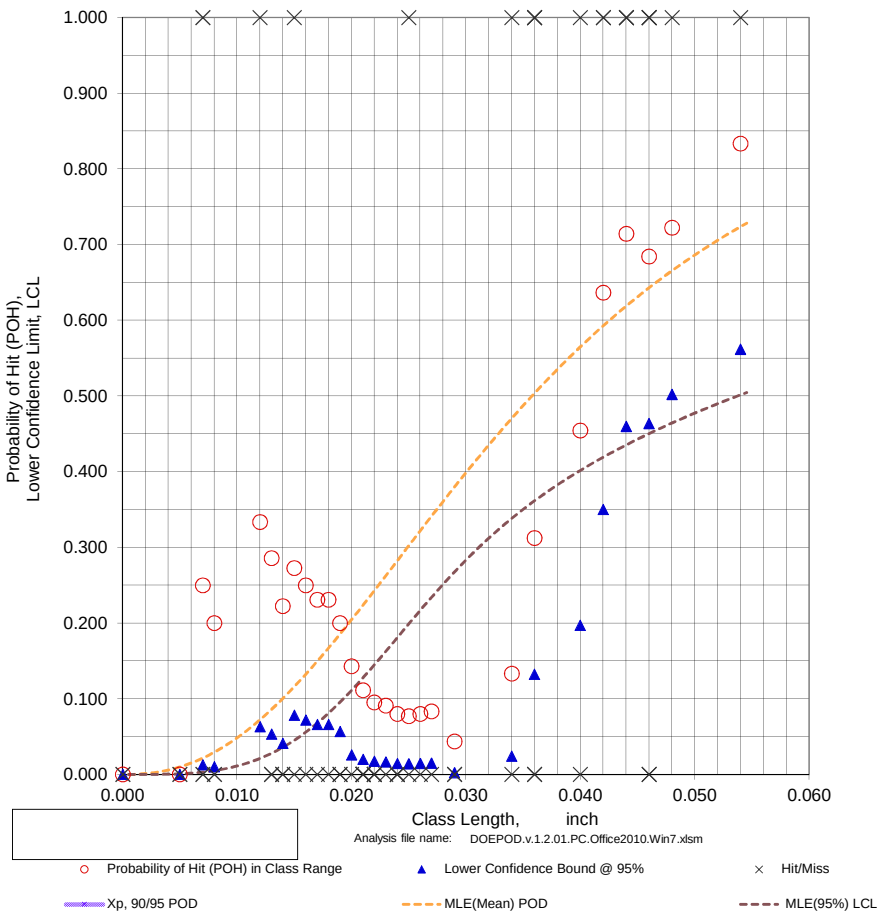
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = F9000CD.XLS
Data Set Name = F9000CD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:18 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.5619 | |
| Classwidth @ Best LCL = | 0.0120 | inch |
| Classlength @ Best LCL = | 0.0540 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.0480 -0.001 inch 28 Samples

NTIAC 90% POD = 0.908 @ 0.095 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.108 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F9000CD.XLS
Data Set Name = F9000CD(CRACK #)

## Directed DOE Options

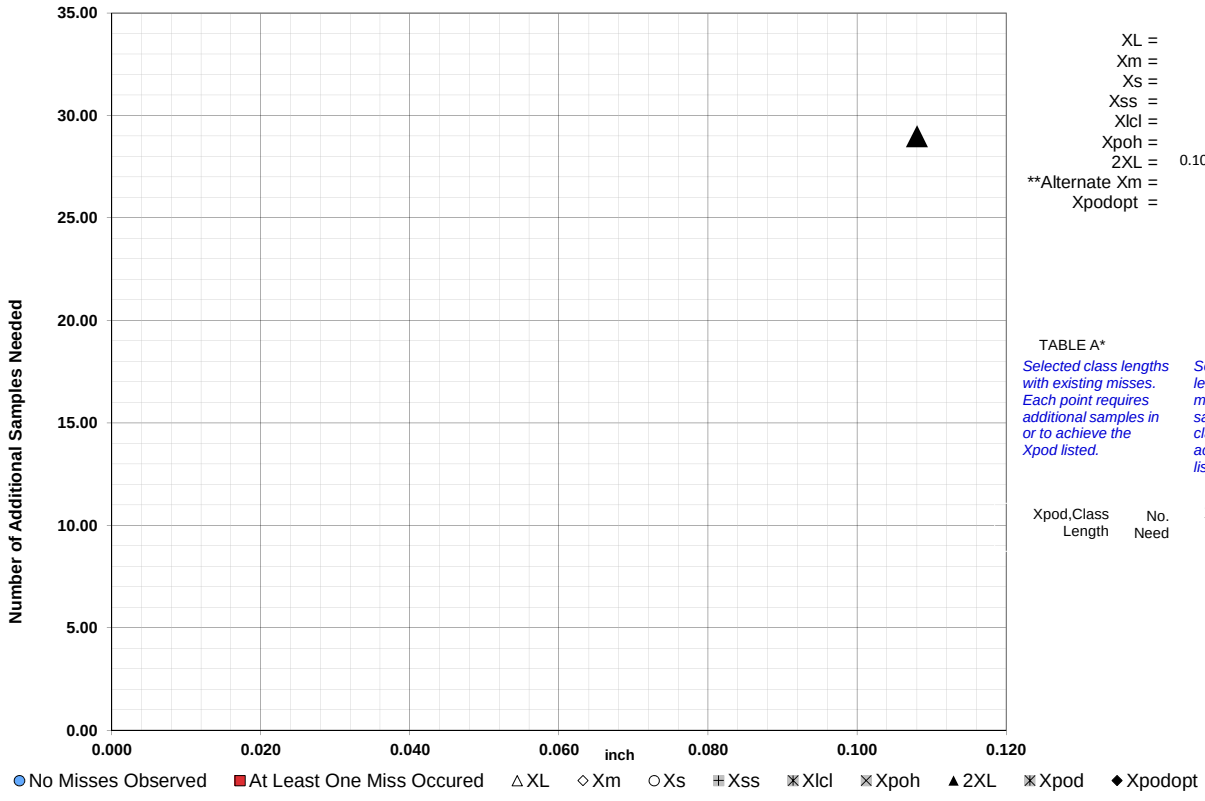



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.108 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

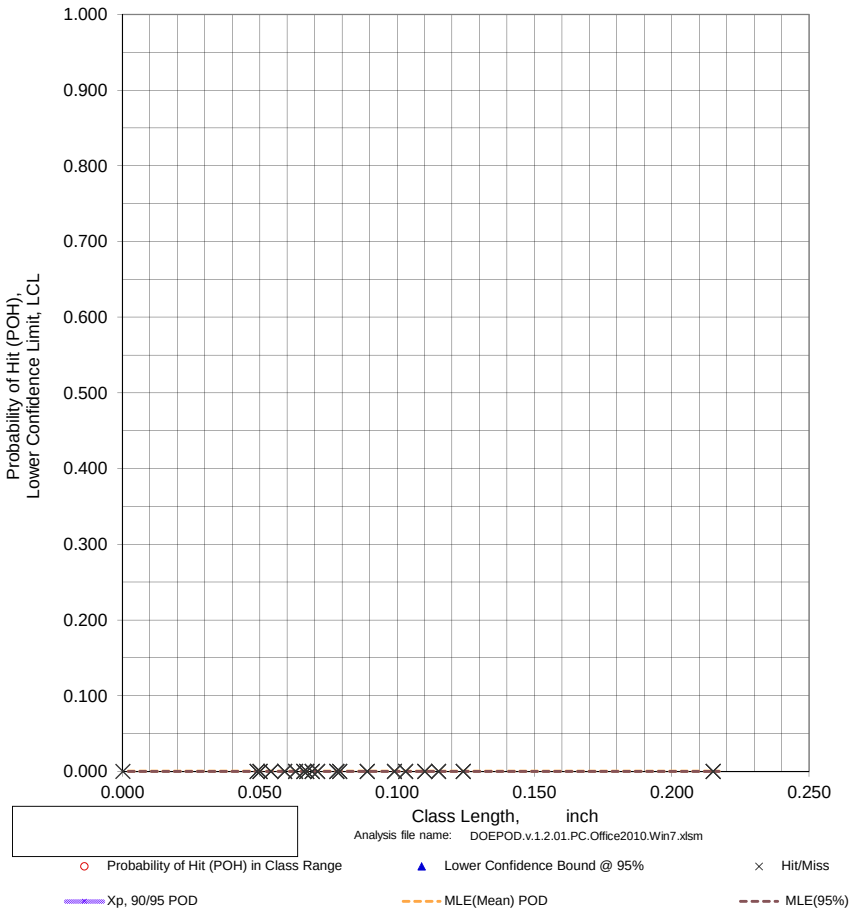
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F9001(3)D.xls

Data Set Name = F9001(3)D(CK. NO. )

MLE Divergence Warning: Initial results listed.




| | | |
|---|---|---|
| Date & Time = | | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - No hits anywhere. Recommend satisfying 2XL

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F9001(3)D.xls
Data Set Name = F9001(3)D(CK. NO. )

## Directed DOE Options

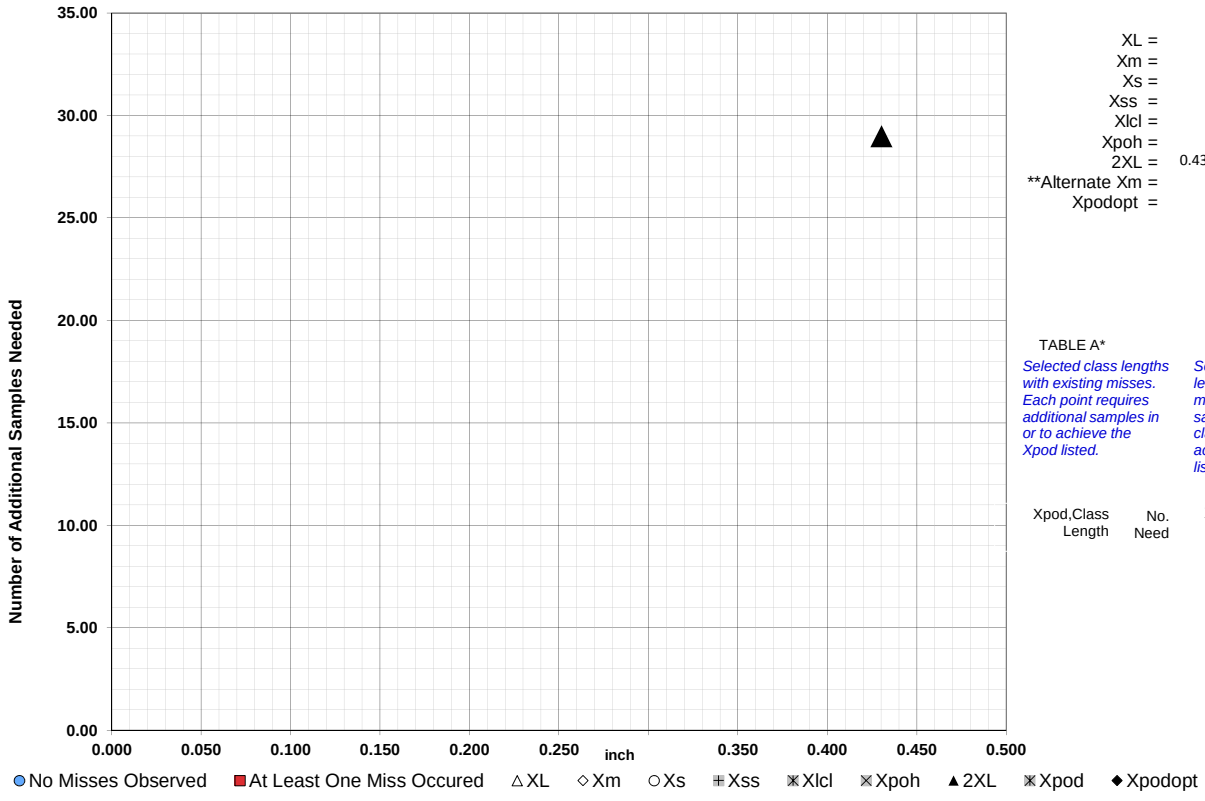



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

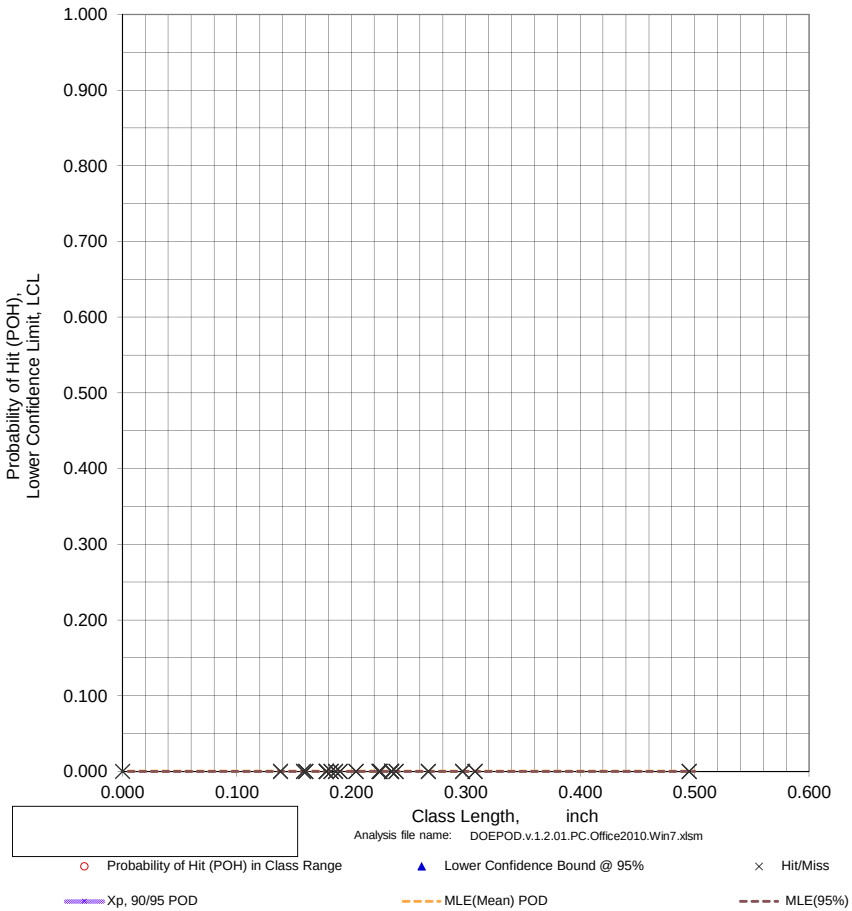
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F9001(3)L.xls

Data Set Name = F9001(3)L(CK. NO. )

MLE Divergence Warning: Initial results listed.




| | | |
|---|---|---|
| Date & Time = | | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - No hits anywhere. Recommend satisfying 2XL

Survey/Optimum Xpoh = 0.000 inch Samples

NTIAC 90% POD = @ inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.990 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F9001(3)L.xls
Data Set Name = F9001(3)L(CK. NO. )

## Directed DOE Options

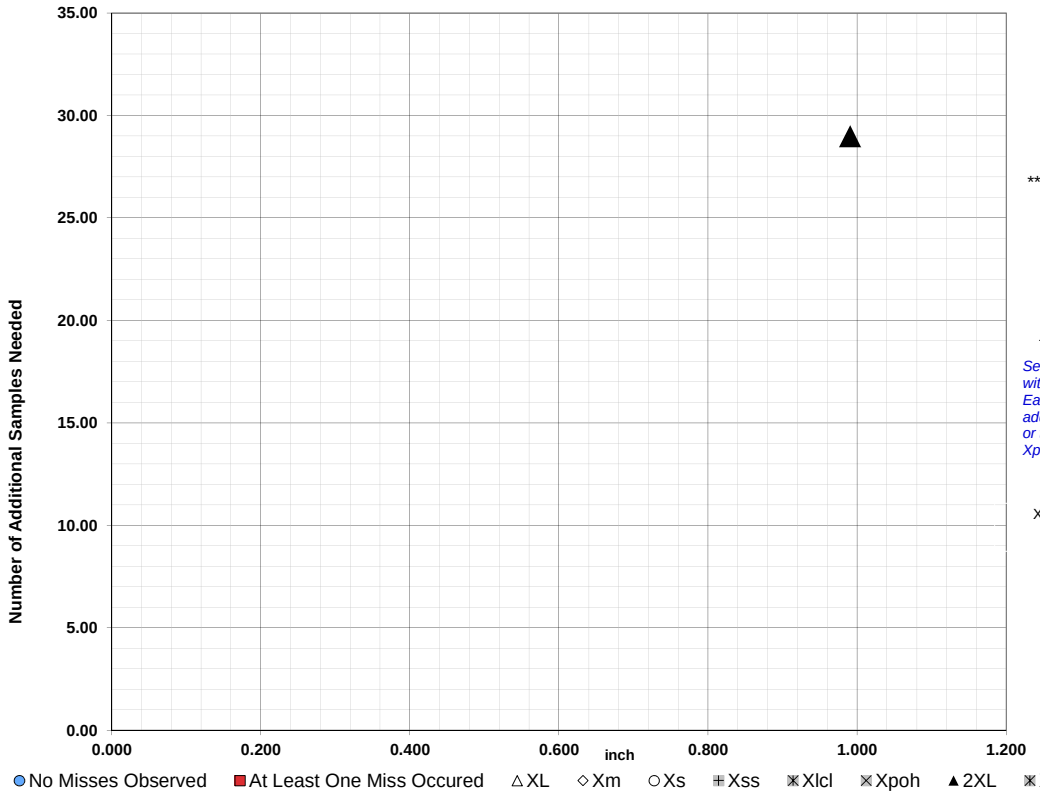



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.990 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

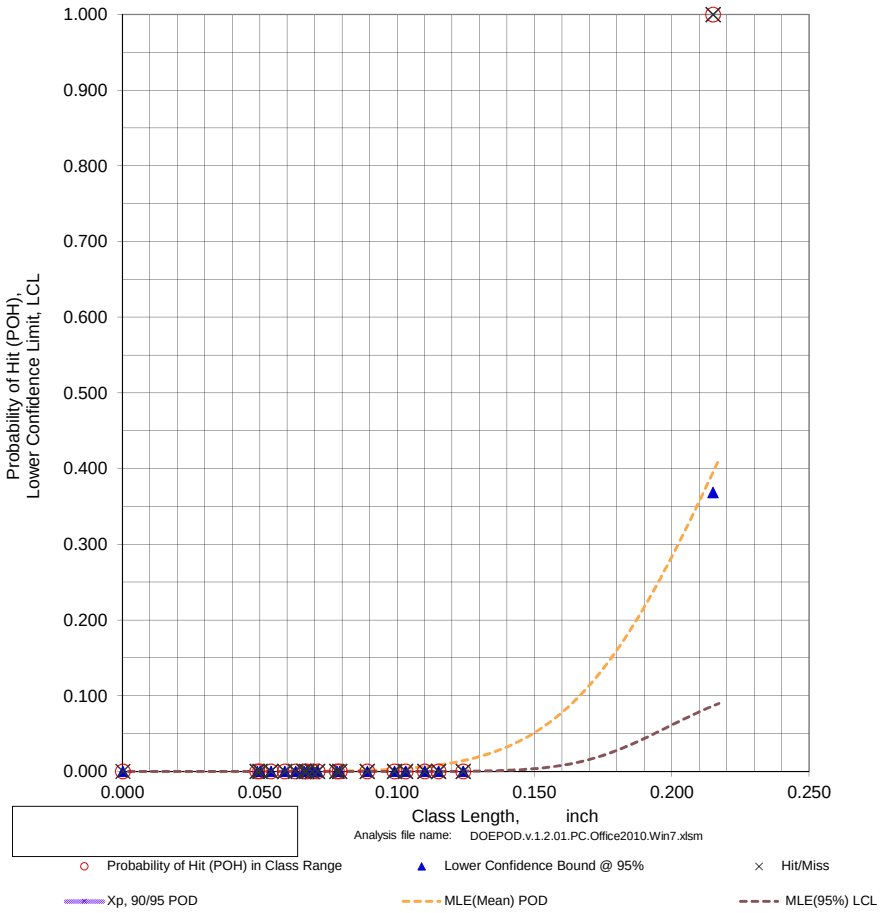
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F9002(3)D.xls

Data Set Name = F9002(3)D(CK. NO. )

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:19 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.2150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2150 -0.090 inch 26 Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | | @ | inch |
| NTIAC 90/95 POD = | | @ | inch |
| False Call Rate = | with UCL @ 95% = | | |
| Largest Classlength , XL = | 0.215 | | inch |
| Samples Needed @ XL = | 26 | | |
| Classlength Mid-point , Xm = | | | inch |
| Samples Needed @ Xm = | | | |
| Smallest Classlength, Xs = | | | inch |
| Samples Needed @ Xs = | | | |
| New Smaller Classlength, Xss = | | | inch |
| BestLCL Classlength, Xlcl = | 0.215 | | inch |
| Samples Needed @ Xlcl = | 26 | | |
| POH Classlength, Xpoh = | 0.215 | | inch |
| Samples Needed @ Xpoh = | | | |
| New Largest Classlength , 2XL = | 0.430 | | inch |
| Xm is Near Verification Point = | | | inch |
| Opt. POD classlength, Xpodopt = | | | inch |
| Samples Needed @Xpodopt = | | | |
| Xp = | | | inch |

File Name = F9002(3)D.xls
Data Set Name = F9002(3)D(CK. NO. )

## Directed DOE Options

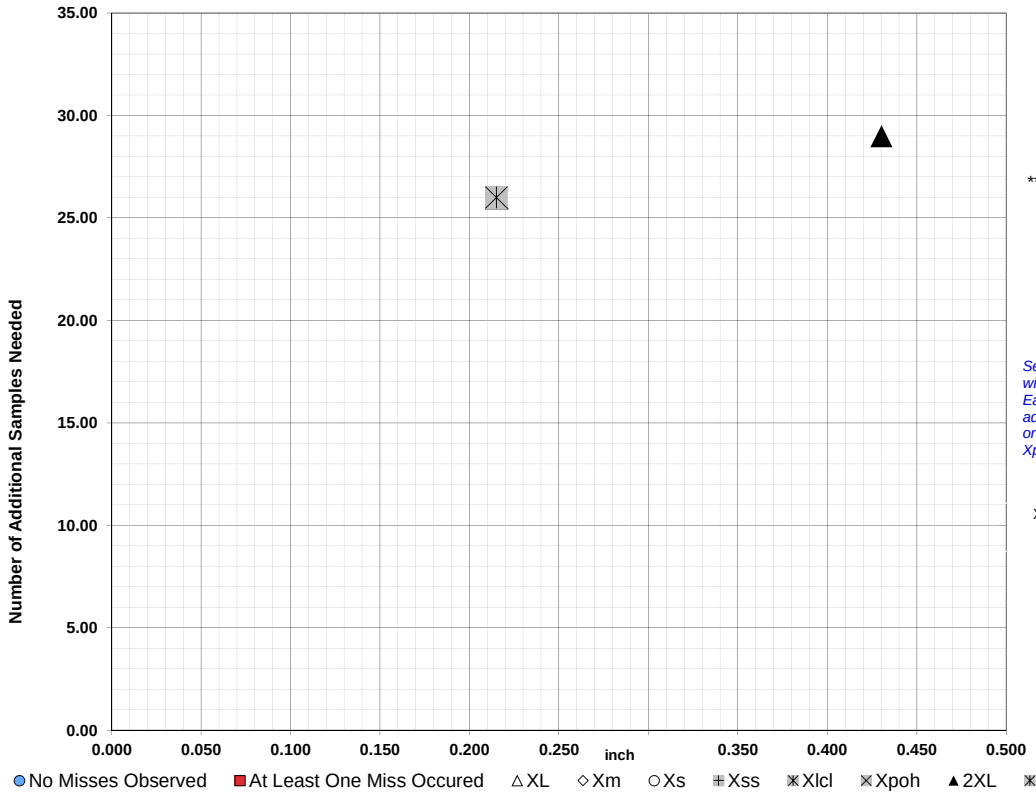



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.215 | 26 |
| Xpoh = | 0.215 | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

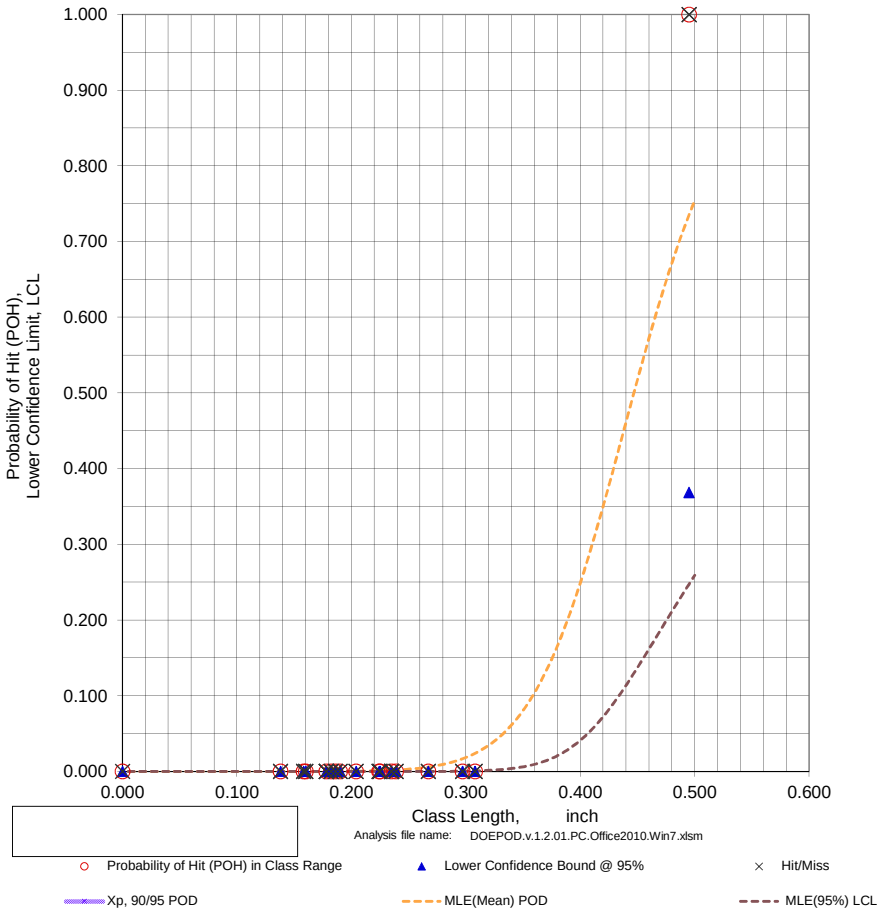
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F9002(3)L.xls

Data Set Name = F9002(3)L(CK. NO. )

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.




| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:20 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.4950 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.4950 -0.100 inch 26 Samples

NTIAC 90% POD = 0.905 @ 0.560 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.495 | inch |
| Samples Needed @ Xlcl = | 26 | |
| POH Classlength, Xpoh = | 0.495 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.990 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F9002(3)L.xls
Data Set Name = F9002(3)L(CK. NO. )

## Directed DOE Options

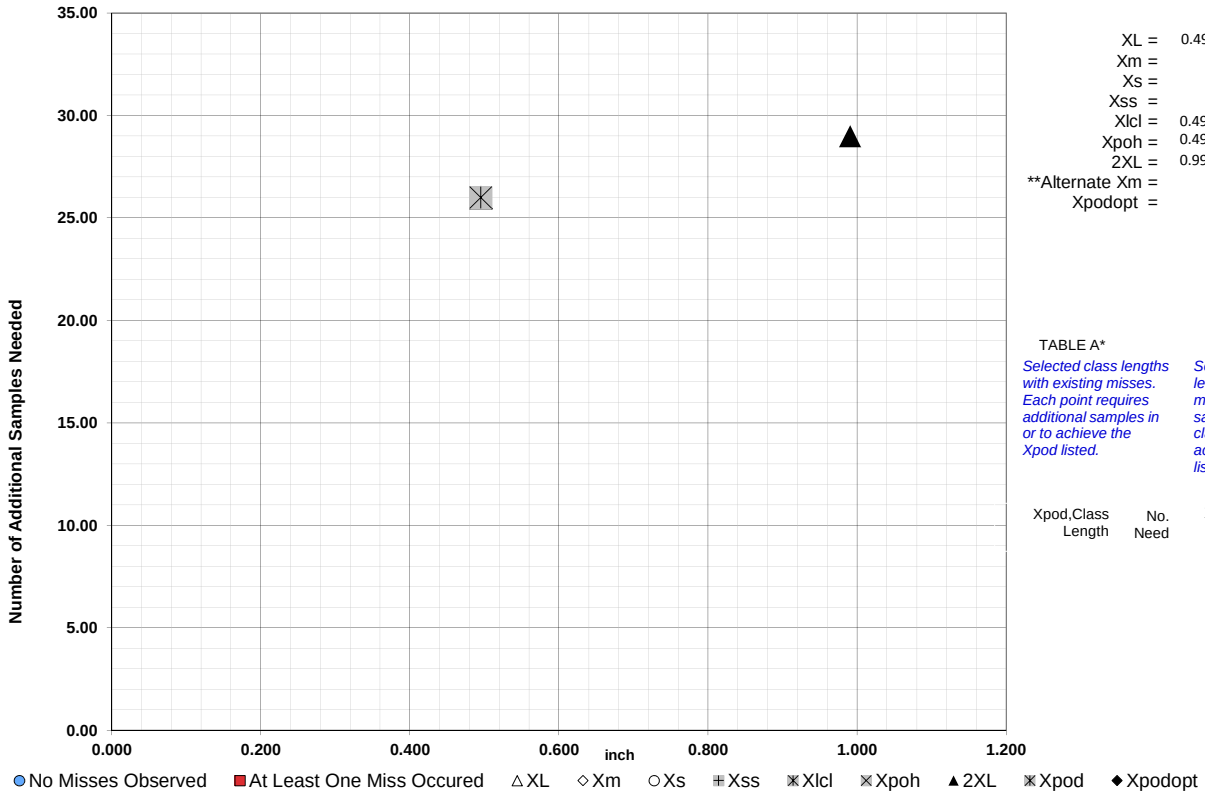



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.495 | 26 |
| Xpoh = | 0.495 | |
| 2XL = | 0.990 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

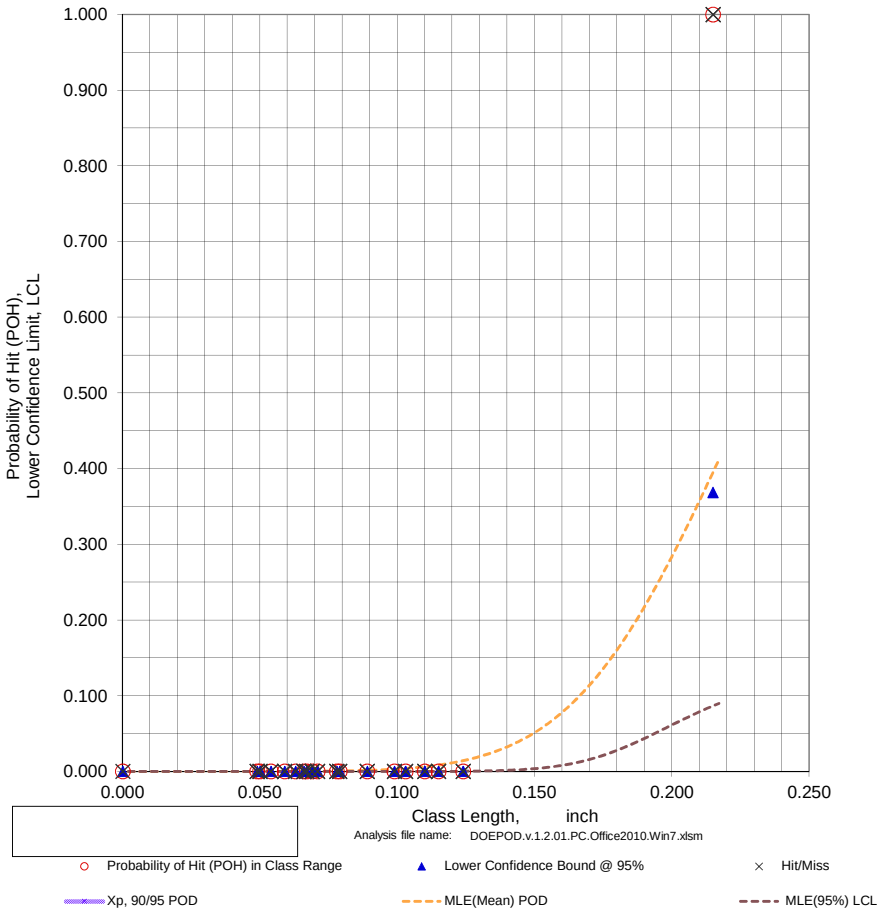
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

File Name = F9003(3)D.xls
Data Set Name = F9003(3)D(CK. NO. )

MLE Divergence Warning: Initial results listed.
Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:21 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.2150 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.2150 -0.090 inch 26 Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |
| False Call Rate = | with UCL @ 95% = | |

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.215 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.215 | inch |
| Samples Needed @ Xlcl = | 26 | |
| POH Classlength, Xpoh = | 0.215 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.430 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F9003(3)D.xls
Data Set Name = F9003(3)D(CK. NO. )

## Directed DOE Options

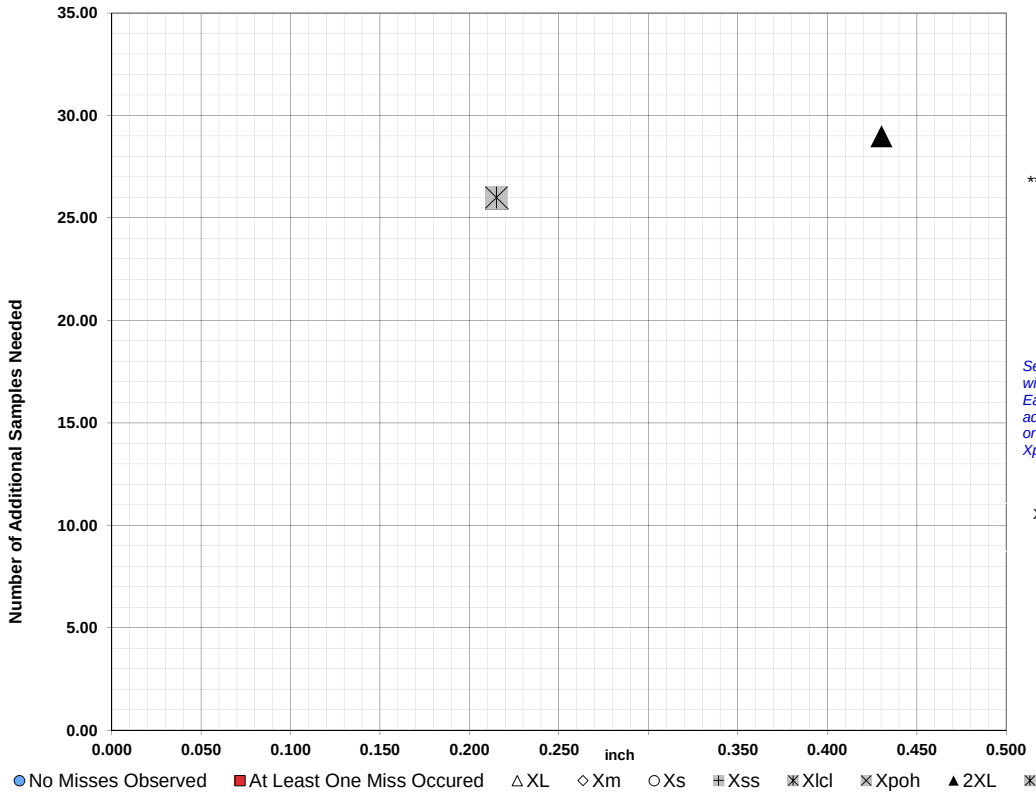



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.215 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.215 | 26 |
| Xpoh = | 0.215 | |
| 2XL = | 0.430 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

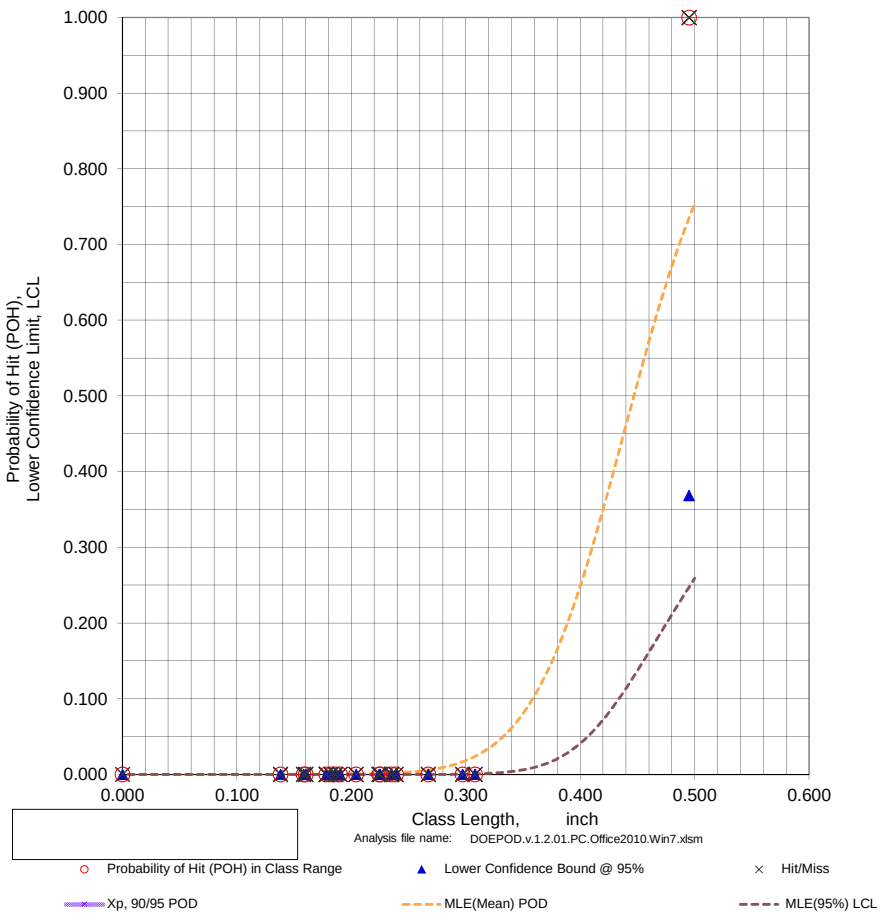
File Name = F9003(3)L.xls

Data Set Name = F9003(3)L(CK. NO. )

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:22 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.3684 | |
| Classwidth @ Best LCL = | 0.0010 | inch |
| Classlength @ Best LCL = | 0.4950 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |




CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.4950 -0.100 inch 26 Samples

NTIAC 90% POD = 0.905 @ 0.560 inch

NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.495 | inch |
| Samples Needed @ XL = | 26 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.495 | inch |
| Samples Needed @ Xlcl = | 26 | |
| POH Classlength, Xpoh = | 0.495 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.990 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = F9003(3)L.xls
Data Set Name = F9003(3)L(CK. NO. )

## Directed DOE Options

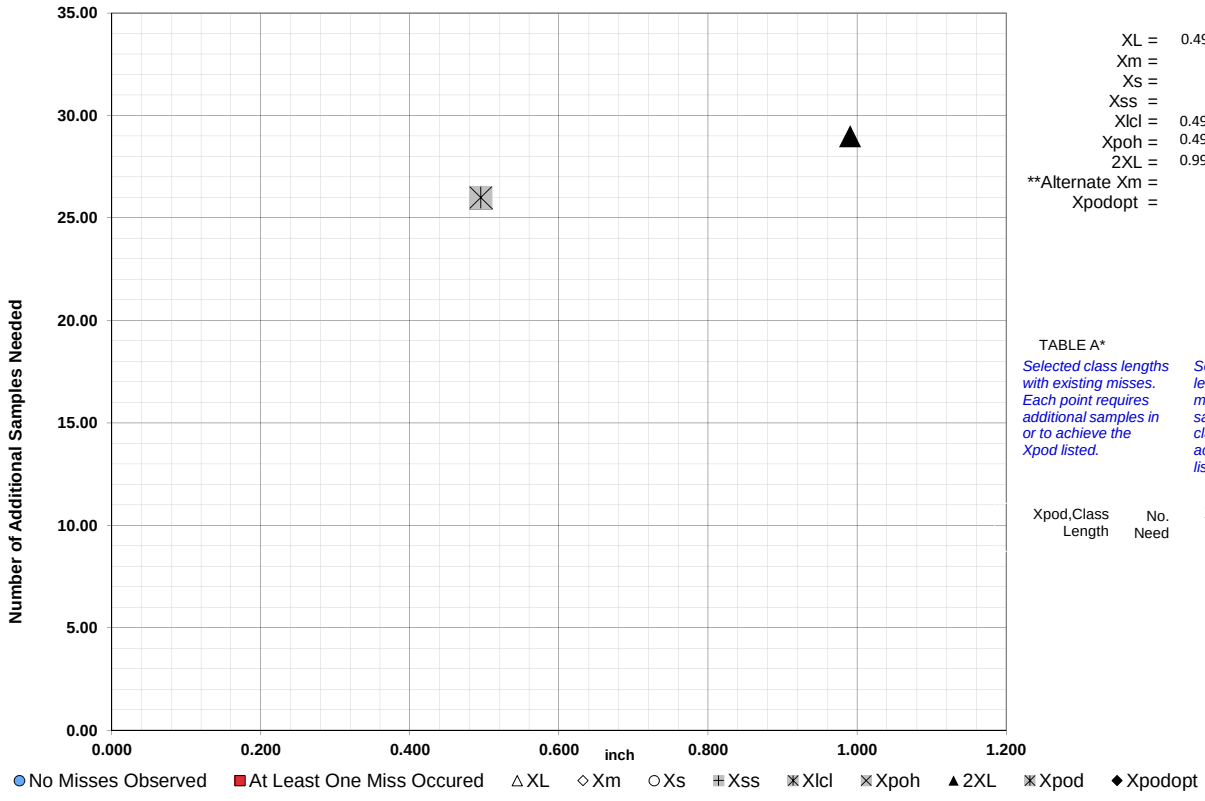



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.495 | 26 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.495 | 26 |
| Xpoh = | 0.495 | |
| 2XL = | 0.990 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

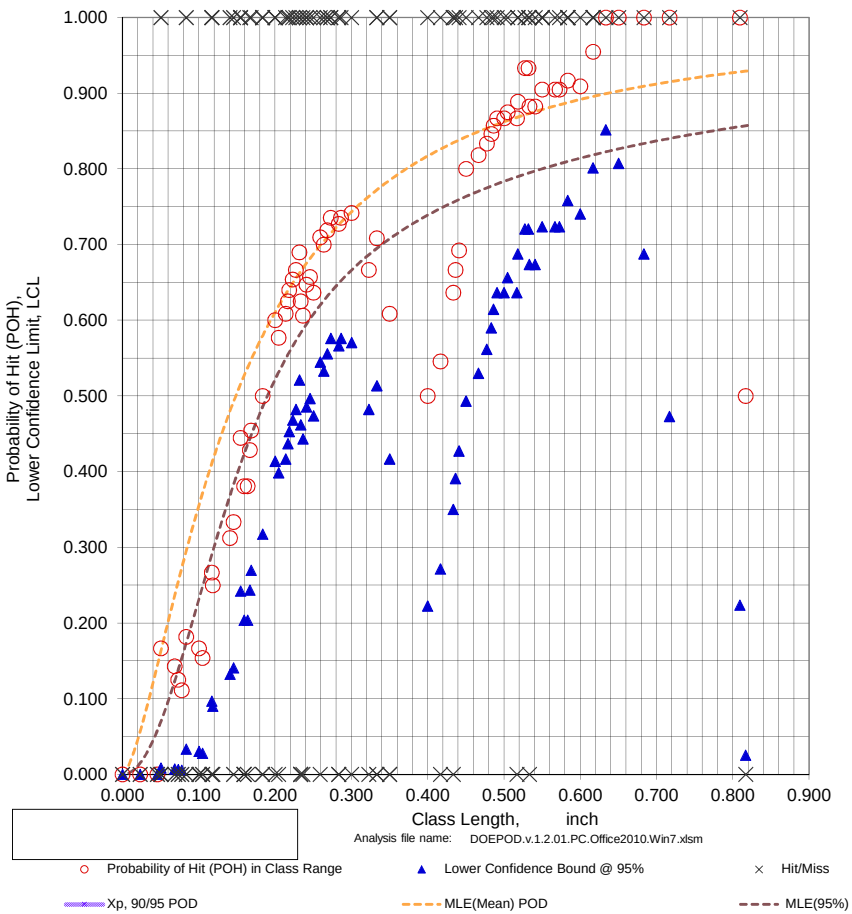
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = G10003AA.XLS
Data Set Name = G10003AA(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:23 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8514 | |
| Classwidth @ Best LCL = | 0.0930 | inch |
| Classlength @ Best LCL = | 0.6333 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | |
|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ 0.640 | inch |
| NTIAC 90/95 POD = | | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.633 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = G10003AA.XLS
Data Set Name = G10003AA(CRACK #)

## Directed DOE Options

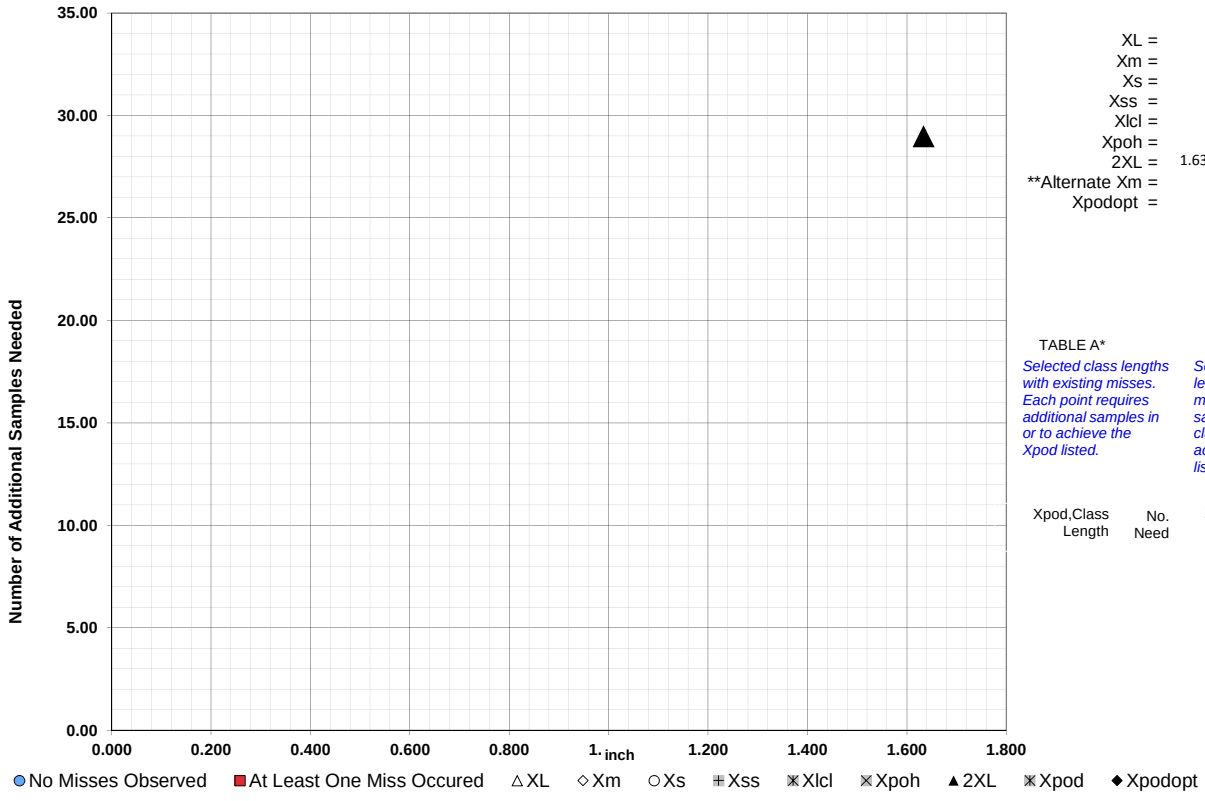



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.633 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

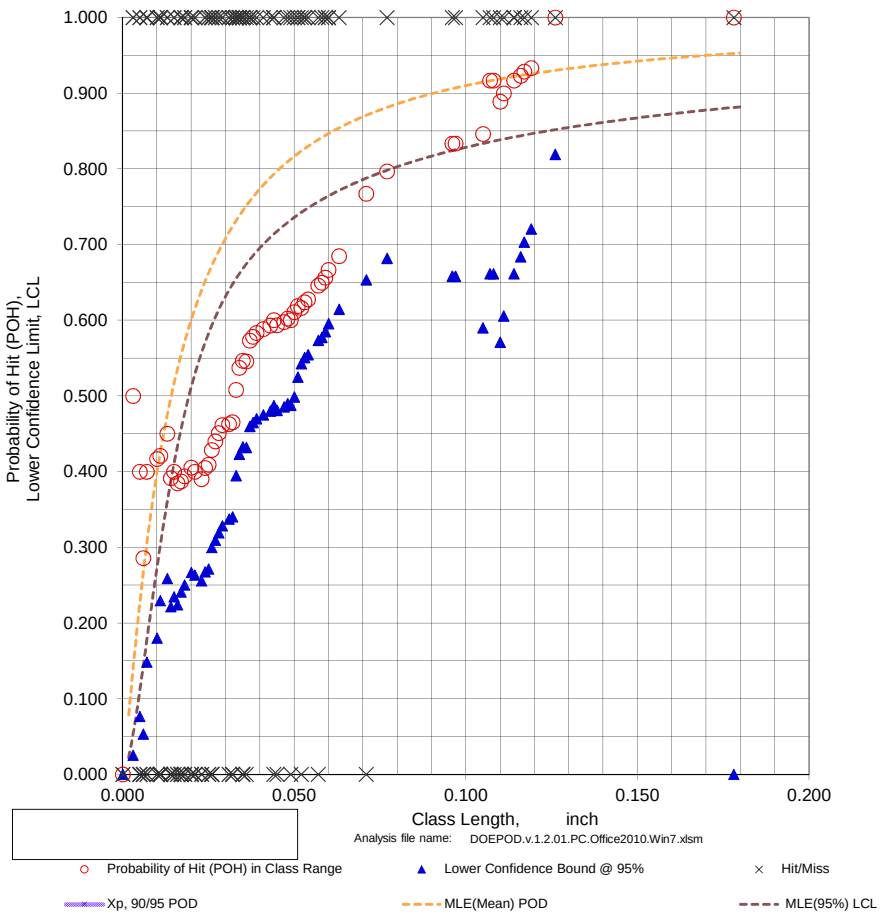
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = G10003AD.XLS
Data Set Name = G10003AD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:25 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8190 | |
| Classwidth @ Best LCL = | 0.0490 | inch |
| Classlength @ Best LCL = | 0.1260 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 4 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL and the greater of Xpoh or Xlcl.

Survey/Optimum Xpoh = 0.0770 -0.005 inch 28 Samples

NTIAC 90% POD = 0.905 @ 0.095 inch
NTIAC 90/95 POD = @ inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.178 | inch |
| Samples Needed @ XL = | 28 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | 0.126 | inch |
| Samples Needed @ Xlcl = | 14 | |
| POH Classlength, Xpoh = | 0.126 | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = G10003AD.XLS
Data Set Name = G10003AD(CRACK #)

## Directed DOE Options

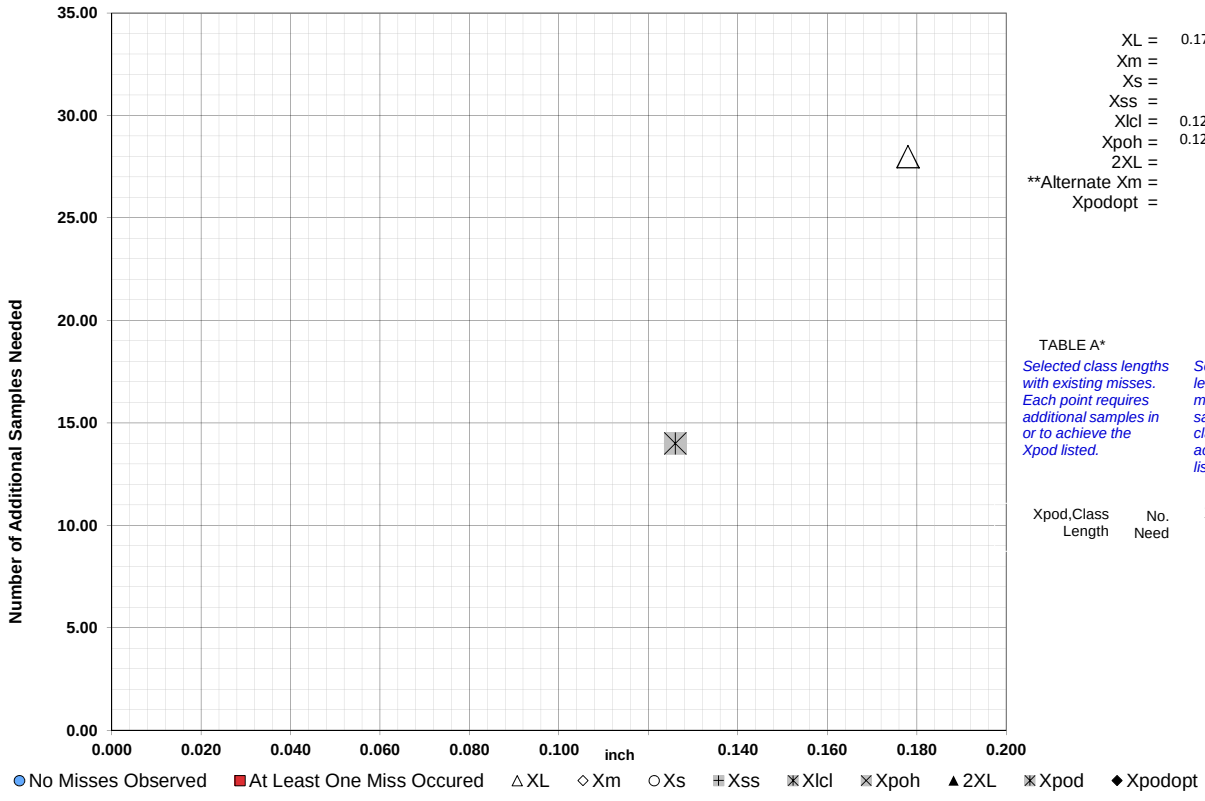



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.178 | 28 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | 0.126 | 14 |
| Xpoh = | 0.126 | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

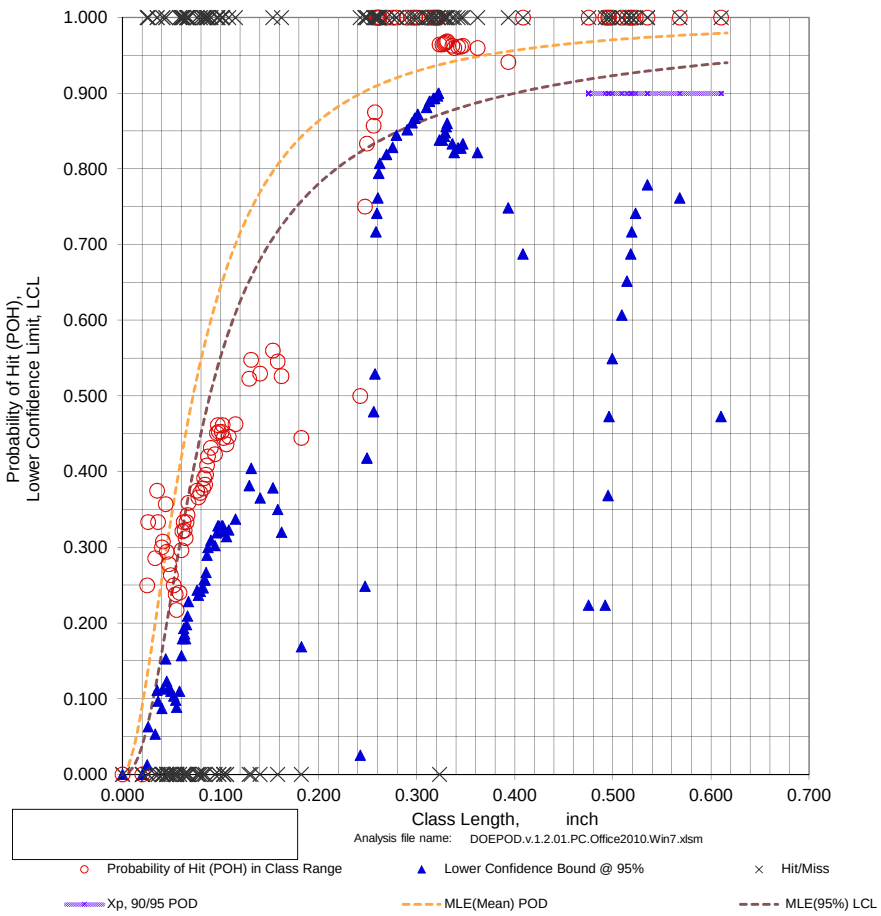
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.966.**

**Any highlighted Misses are RED and shown in Column A of this data sheet**

**Warning: No false call analysis.**




File Name = **G10003AL.XLS**

Data Set Name = **G10003AL(CRACK #)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:26 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0750 | inch |
| Classlength @ 90/95 Xpod = | 0.3220 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. VALIDATION GAP exists. Xp may VALIDATE between Xp and XL when causes of Misses are understood and corrected.**

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.901 | @ | 0.245 | inch |
| NTIAC 90/95 POD = | 0.900 | @ | 0.400 | inch |

**False Call Rate = with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.535 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | 0.4750 | inch |

File Name = G10003AL.XLS
Data Set Name = G10003AL(CRACK #)

## Directed DOE Options

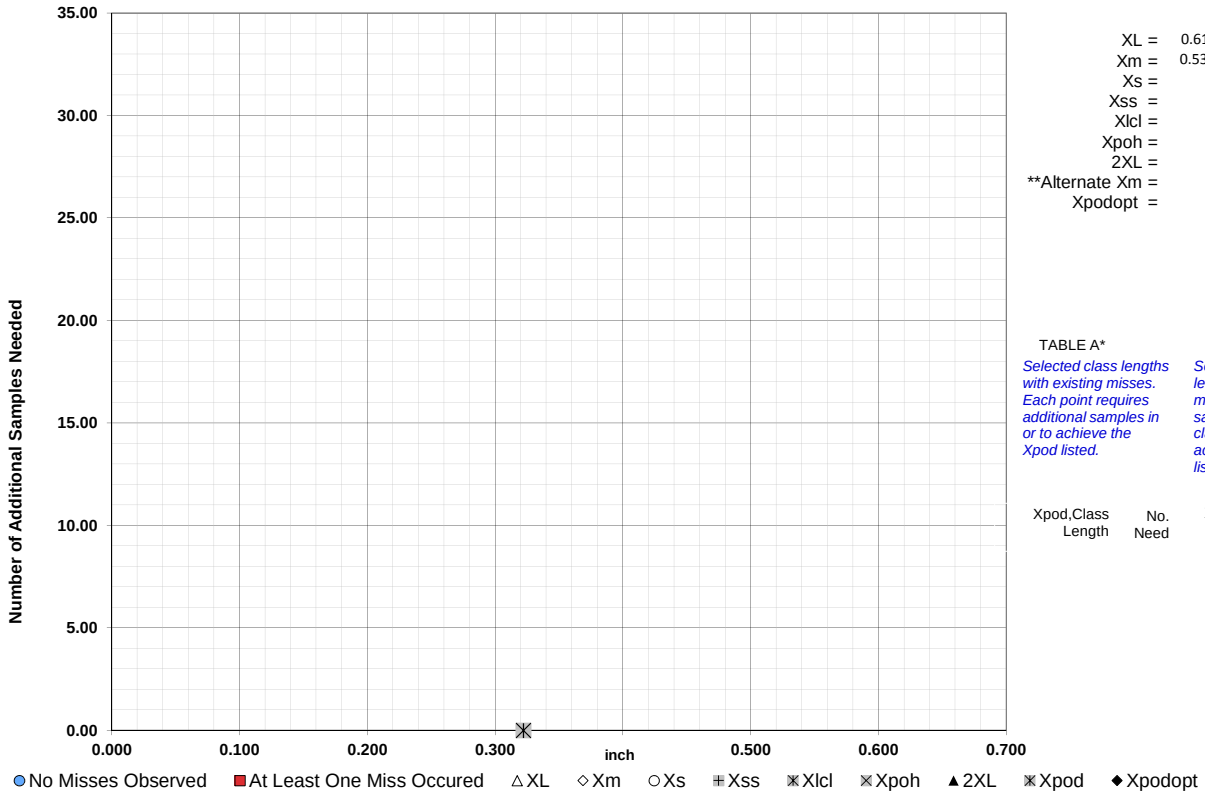



TABLE C

| Class Length | Additional Samples |
|---|---|
| XL = | 0.610 |
| Xm = | 0.535 |
| Xs = | |
| Xss = | |
| Xlcl = | |
| Xpoh = | |
| 2XL = | |
| **Alternate Xm = | |
| Xpodopt = | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

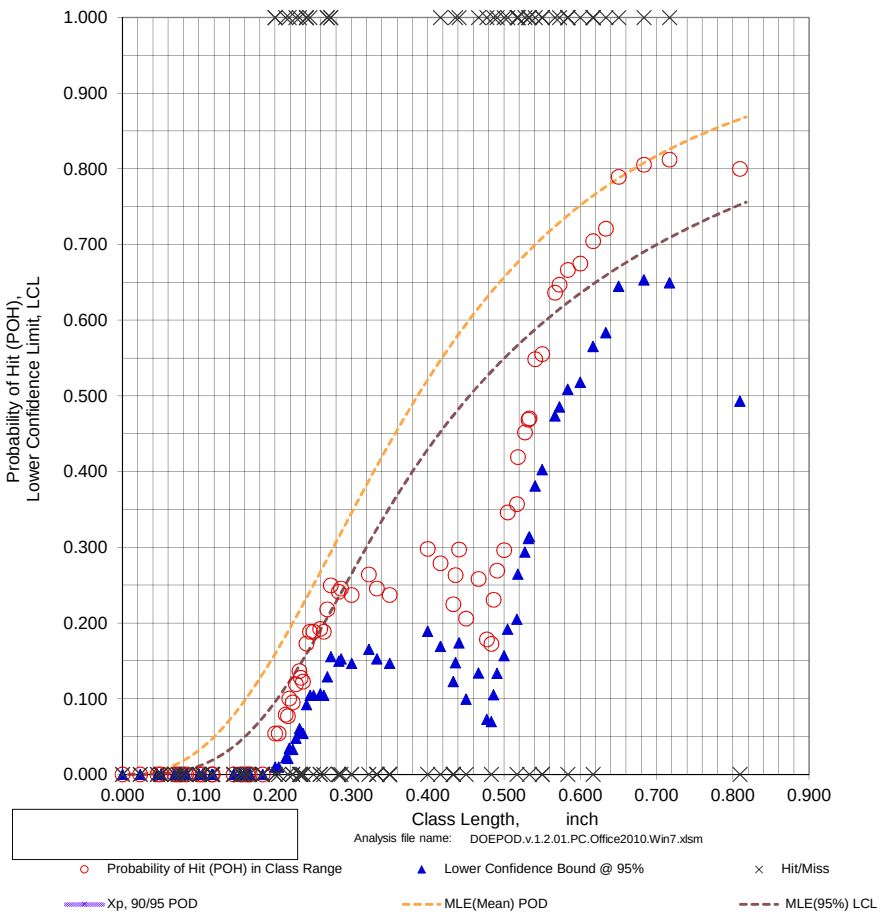
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = G10003BA.XLS
Data Set Name = G10003BA(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:27 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.6532 | |
| Classwidth @ Best LCL = | 0.2000 | inch |
| Classlength @ Best LCL = | 0.6833 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | |
|---|---|---|
| NTIAC 90% POD = | @ | inch |
| NTIAC 90/95 POD = | @ | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 1.618 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = G10003BA.XLS
Data Set Name = G10003BA(CRACK #)

## Directed DOE Options

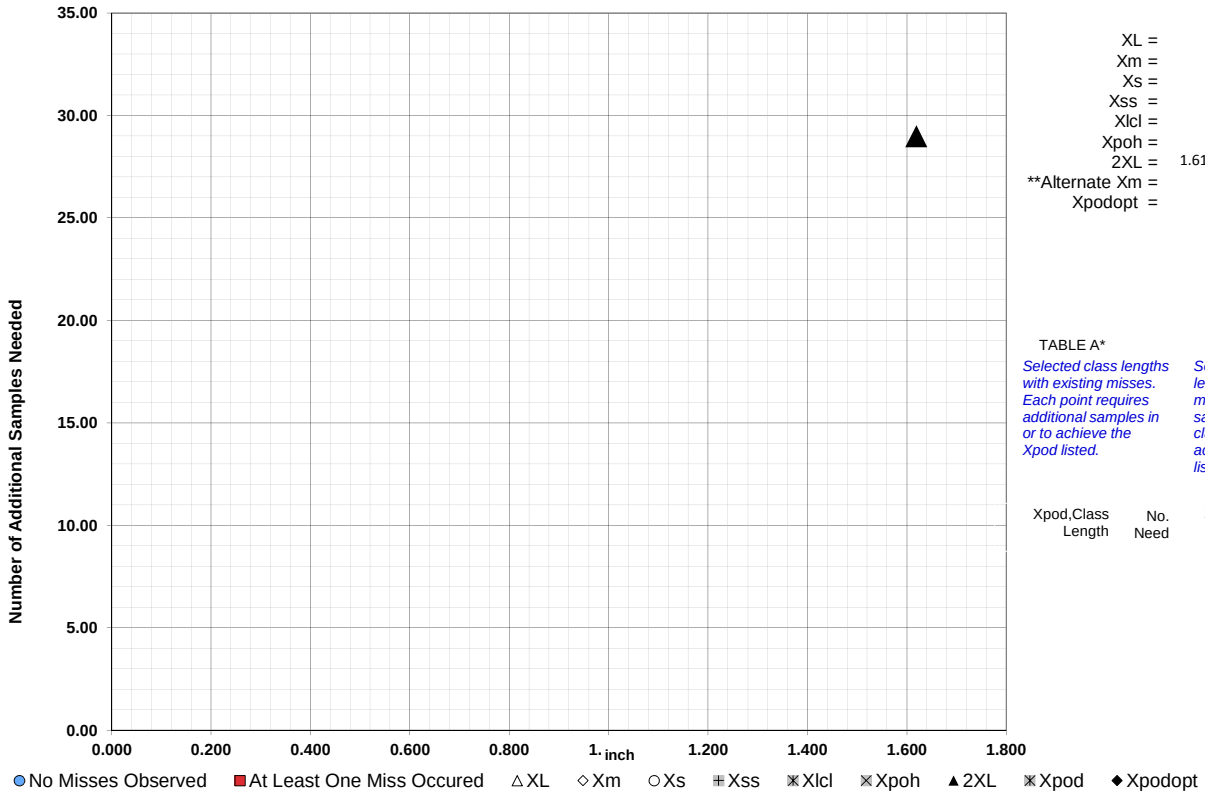



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 1.618 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

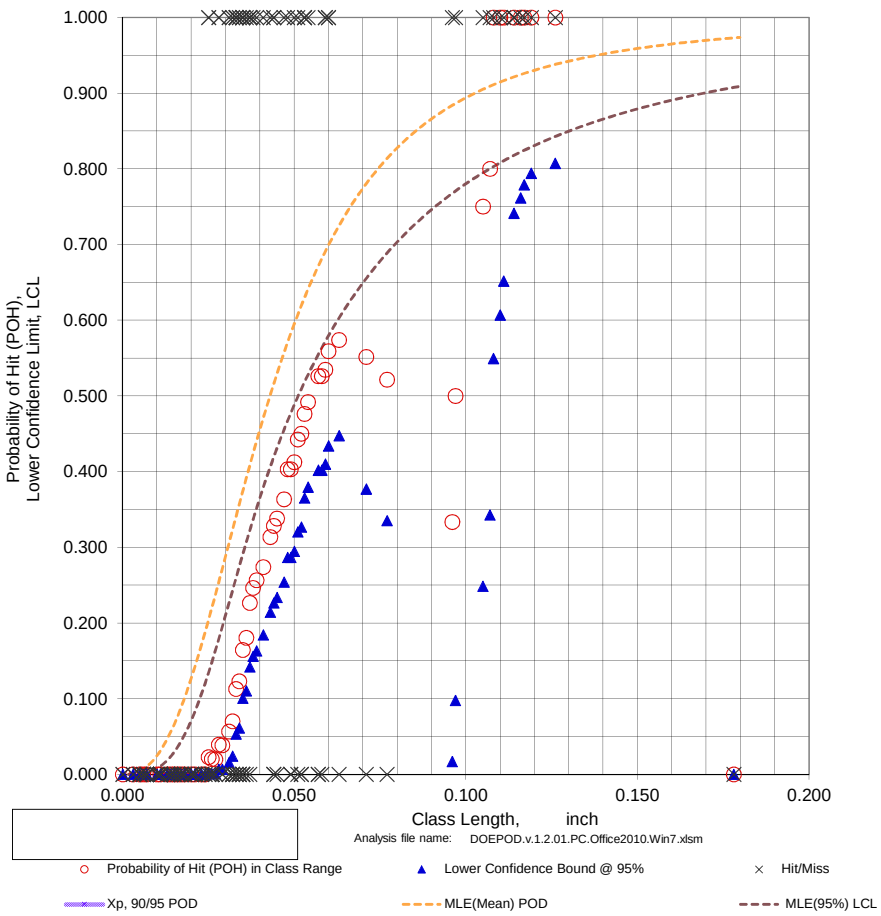
*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Warning: No false call analysis.




File Name = G10003BD.XLS
Data Set Name = G10003BD(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:29 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.8074 | |
| Classwidth @ Best LCL = | 0.0300 | inch |
| Classlength @ Best LCL = | 0.1260 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 7 - 90/95 Xpod is not reached anywhere. Recommend satisfying 2XL.

Survey/Optimum Xpoh = 0.000 inch Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.905 | @ | 0.105 | inch |
| NTIAC 90/95 POD = | 0.901 | @ | 0.170 | inch |

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | 0.356 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = G10003BD.XLS
Data Set Name = G10003BD(CRACK #)

## Directed DOE Options

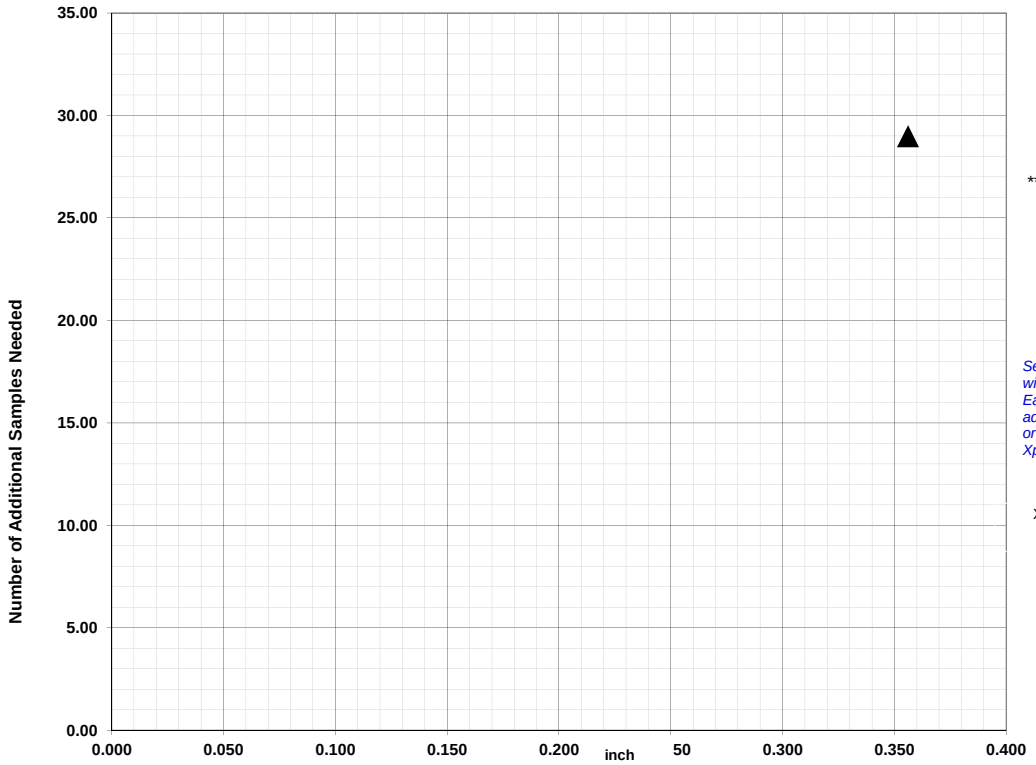



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | | |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | 0.356 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

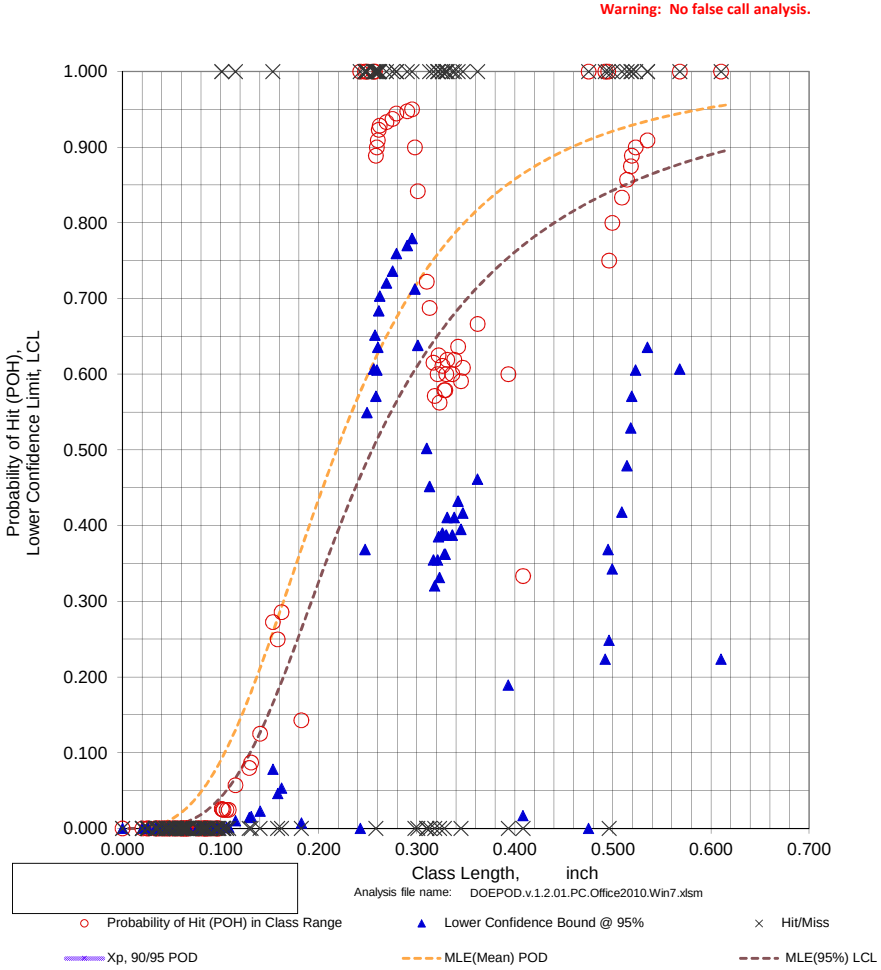
TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)




File Name = G10003BL.XLS
Data Set Name = G10003BL(CRACK #)

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:30 AM | |
| Xpod 90/95 Reached Anywhere? | NOT REACHED | |
| Classwidth @ 90/95 Xpod = | | inch |
| Classlength @ 90/95 Xpod = | | inch |
| Lower Confidence Bound = | | |
| Best LCL = | 0.7794 | |
| Classwidth @ Best LCL = | 0.0530 | inch |
| Classlength @ Best LCL = | 0.2950 | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | | |

CASE 6 - 90/95 Xpod is not reached anywhere. Recommend satisfying XL, Xpoh, and 2XL.

Survey/Optimum Xpoh = 0.4990 -0.002 inch 28 Samples

NTIAC 90% POD = 0.901 @ 0.460 inch
NTIAC 90/95 POD = 0.901 @ 0.630 inch

False Call Rate = with UCL @ 95% =

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.610 | inch |
| Samples Needed @ XL = | 27 | |
| Classlength Mid-point , Xm = | | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | 0.568 | inch |
| Samples Needed @ Xpoh = | 23 | |
| New Largest Classlength , 2XL = | 1.220 | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | | inch |
| Samples Needed @Xpodopt = | | |
| Xp = | | inch |

File Name = G10003BL.XLS
Data Set Name = G10003BL(CRACK #)

## Directed DOE Options

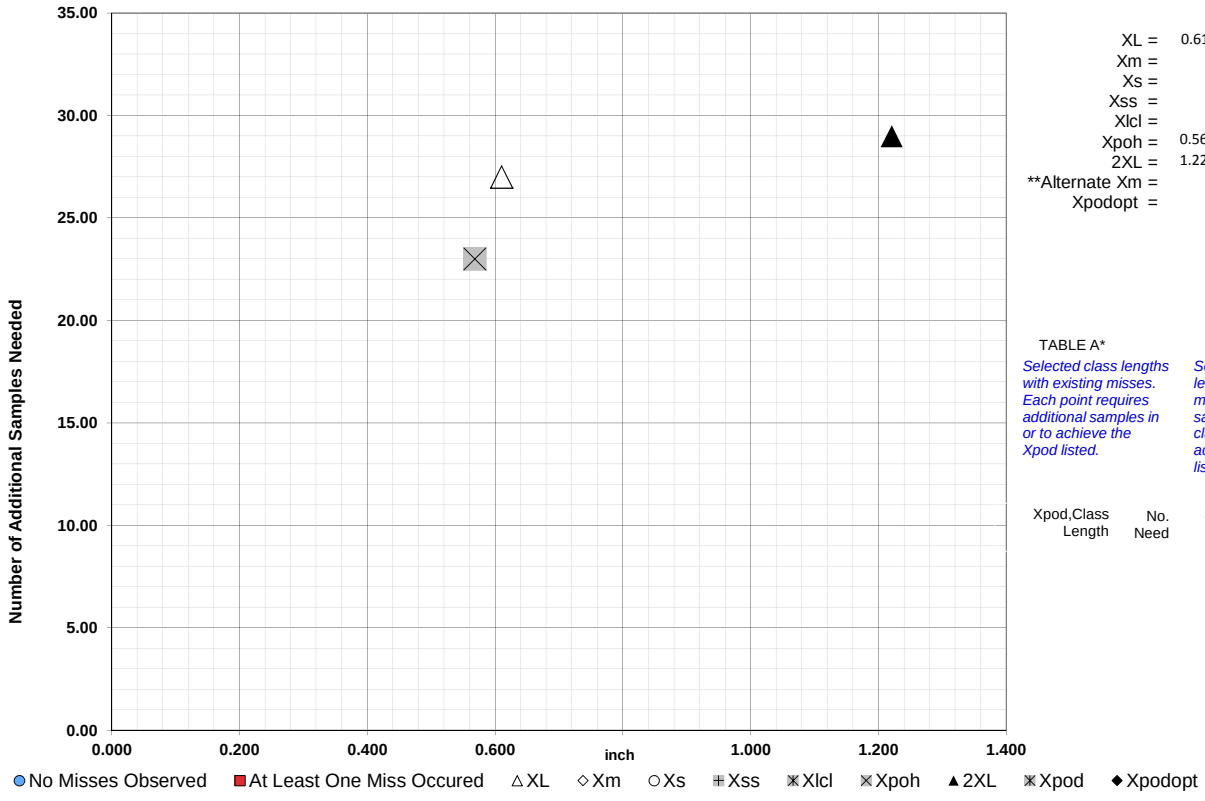



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.610 | 27 |
| Xm = | | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | 0.568 | 23 |
| 2XL = | 1.220 | 29 |
| **Alternate Xm = | | |
| Xpodopt = | | |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

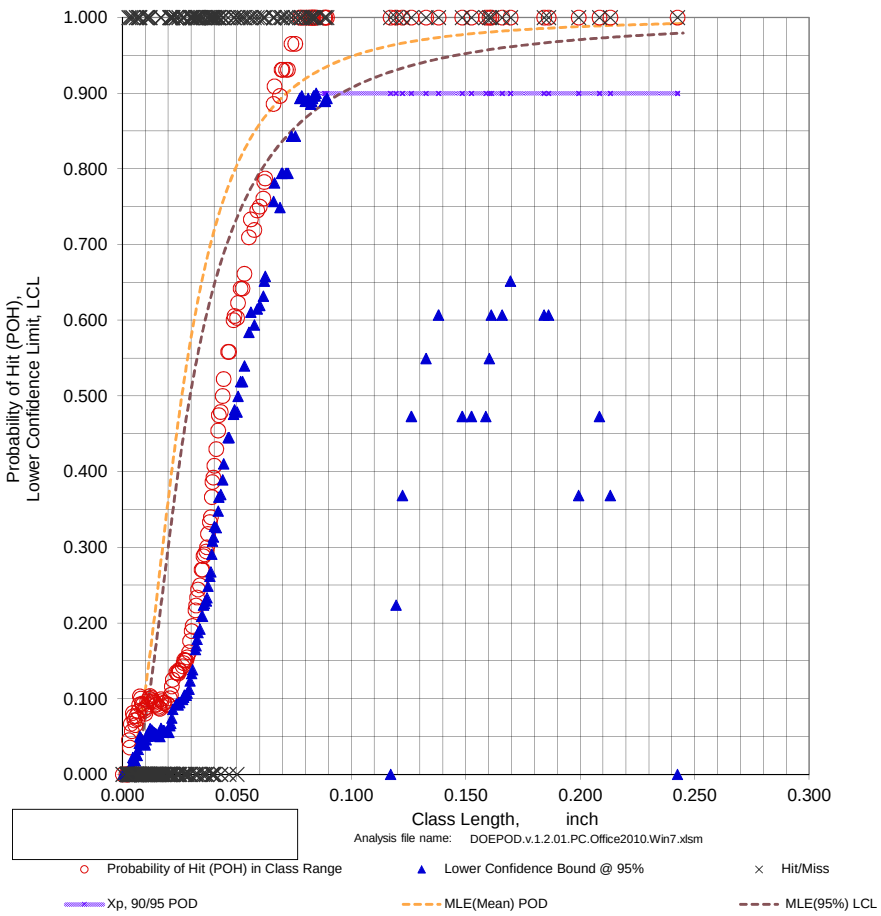
| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

**Large flaw validation failure. Extend flaw size range to 0.25356.**

**Note: Xpodopt is within one class width of Xpod.** **Warning: No false call analysis.**




File Name = **G2001L.XLS**
Data Set Name = **G2001L(EoI-a)**

| | | |
|---|---|---|
| Date & Time = | 6/5/15 6:31 AM | |
| Xpod 90/95 Reached Anywhere? | REACHED | |
| Classwidth @ 90/95 Xpod = | 0.0260 | inch |
| Classlength @ 90/95 Xpod = | 0.0845 | inch |
| Lower Confidence Bound = | 0.9001 | |
| Best LCL = | | |
| Classwidth @ Best LCL = | | inch |
| Classlength @ Best LCL = | | inch |
| User Provided a 90/95 POD @ = | | inch |
| User's Maximum Allowed Classlength = | | inch |
| Inspector Classwidth @ Xp = | | inch |
| POD @ Xpod = | 1.0000 | |

**CASE 1# - 90/95 Xpod may be VALIDATED from Xpod to XL. Xp used to satisfy XL and Xm requirements. An alternate 90/95 Xpod is available if Xpodopt or Optimum Xpoh (if listed) is also satisfied.**

Survey/Optimum Xpoh = 0.0516 -0.001 inch 28 Samples

| | | | | |
|---|---|---|---|---|
| NTIAC 90% POD = | 0.909 | @ | 0.075 | inch |
| NTIAC 90/95 POD = | 0.907 | @ | 0.100 | inch |

**False Call Rate =** **with UCL @ 95% =**

| | | |
|---|---|---|
| Largest Classlength , XL = | 0.242 | inch |
| Samples Needed @ XL = | | |
| Classlength Mid-point , Xm = | 0.169 | inch |
| Samples Needed @ Xm = | | |
| Smallest Classlength, Xs = | | inch |
| Samples Needed @ Xs = | | |
| New Smaller Classlength, Xss = | | inch |
| BestLCL Classlength, Xlcl = | | inch |
| Samples Needed @ Xlcl = | | |
| POH Classlength, Xpoh = | | inch |
| Samples Needed @ Xpoh = | | |
| New Largest Classlength , 2XL = | | inch |
| Xm is Near Verification Point = | | inch |
| Opt. POD classlength, Xpodopt = | 0.077 | inch |
| Samples Needed @Xpodopt = | 2 | |
| Xp = | 0.0845 | inch |

File Name = G2001L.XLS
Data Set Name = G2001L(Eol-a)

## Directed DOE Options

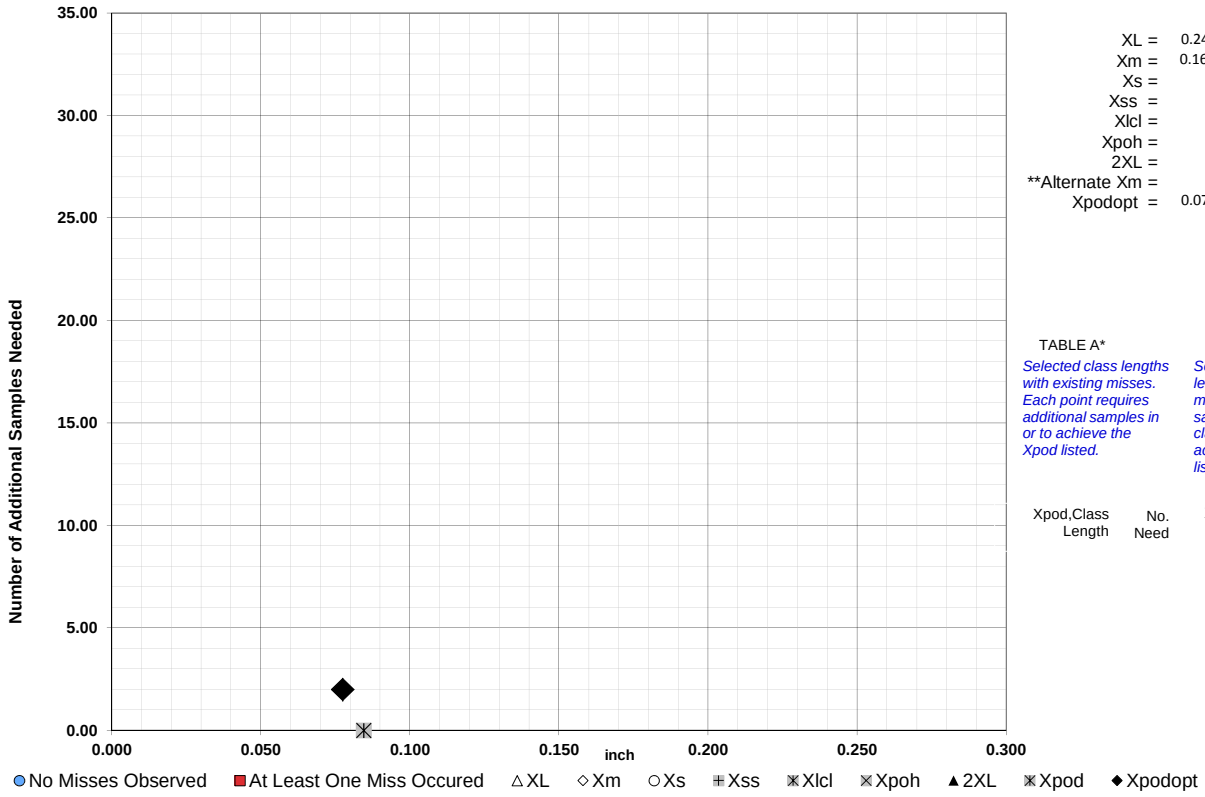



TABLE C

| | Class Length | Additional Samples |
|---|---|---|
| XL = | 0.242 | |
| Xm = | 0.169 | |
| Xs = | | |
| Xss = | | |
| Xlcl = | | |
| Xpoh = | | |
| 2XL = | | |
| **Alternate Xm = | | |
| Xpodopt = | 0.077 | 2 |

TABLE A*

*Selected class lengths with existing misses. Each point requires additional samples in or to achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

TABLE B*

*Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.*

| Xpod,Class Length | No. Need |
|---|---|

* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
**Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined ( human factors, unexpected flaw type, etc) and resloved first.**
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length indicated or smaller to within the class width indicated in the companion chart

# Errata

## NTIAC NDE Capabilities Book, 3rd Edition (November 1997) [NTIAC: DB-97-02]

**DATA sets that do not appear to exist on the NTIAC CD:**

B20011 (appears to be B2001)
B20012 (appears to be B2002)
B20013 (appears to be B2003)

G6001G (appears to be A6001G)
G6001GR (appears to be A6001GR)
G6002G (appears to be A6002G)
G6003G (appears to be A6003G)
G6004G (appears to be A6004G)

F40601AL (appears to be F40601A)
F40601BL (appears to be F40601B)
F40601CL (appears to be F40601C)

F40603AL (appears to be F40603A)
F40603BL (appears to be F40603B)
F40603CL (appears to be F40603C)

F42501AL (appears to be F42501A)
F42501BL (appears to be F42501B)
F42501CL (appears to be F42501C)

F42503AL (appears to be F42503A)
F42503BL (appears to be F42503B)
F42503CL (appears to be F42503C)

A4000(7) is listed in Mag Particle data index – should be B4000(7) with B4001L as the companion data set

**DATA sets on the CD that are not listed in the index:**

B1001AD (POD data not shown in book)
B1001BD (POD data not shown in book)
B1001CD (POD data not shown in book)

B1003AD (POD data not shown in book)
B1003BD (POD data not shown in book)
B1003CD (POD data not shown in book)

B4001L (see above)

B2001 (appears to be the missing B20011 above)
B2002 (appears to be the missing B20012 above)
B2003 (appears to be the missing B20013 above)

*There are an additional 18 data sets (grouped) and not listed in the index:*

DB001(3)D (POD data not shown in book)
DB001(3)L (POD data not shown in book)
DB002(3)D (POD data not shown in book)
DB002(3)L (POD data not shown in book)
DB003(3)D (POD data not shown in book)
DB003(3)L (POD data not shown in book)

DC001(3)D (POD data not shown in book)
DC001(3)L (POD data not shown in book)
DC002(3)D (POD data not shown in book)
DC002(3)L (POD data not shown in book)
DC003(3)D (POD data not shown in book)
DC003(3)L (POD data not shown in book)

DD001(3)D (POD data not shown in book)
DD001(3)L (POD data not shown in book)
DD002(3)D (POD data not shown in book)
DD002(3)L (POD data not shown in book)
DD003(3)D (POD data not shown in book)
DD003(3)L (POD data not shown in book)

**DATA set duplicated:**

F9000CD appears to be a duplicate identical to data file F20852CD

**DATA Analysis integrity:**

During validation of DOEPOD results on the entire NTIAC NDE Capabilities Book "DOEPOD(NTIAC)", some exceptions were noted in the results. There are 437 data sets and exceptions were identified in the 32 data sets listed below. The analysis results shown in the NTIAC NDE Capabilities Book, 3rd Edition (1997) [NTIAC: DB-97-02] for the data sets listed below are incorrect due to a data listing error. These data sets need to be re-run with data sorted.

A1001CL.XLS
A1002CL.XLS

A9003(3)L.xls
AA003(3)L.xls
AC001(3)L.xls
CB003(3)L.xls
CE032(6)D.xls
F10601AD.XLS
F10601BD.XLS
F10601CD.XLS
F10602AD.XLS
F10602BD.XLS
F10602CD.XLS
F10603AD.XLS
F10603BD.XLS
F10603CD.XLS
F12201AD.XLS
F12201BD.XLS
F12201CD.XLS
F12202AD.XLS
F12202BD.XLS
F12202CD.XLS
F12203AD.XLS
F12203BD.XLS
F12203CD.XLS
F32251AD.XLS
F32251CD.XLS
F32253AD.XLS
F32253BD.XLS
F8002(3)L.xls
G10003BD.XLS
G10003BL.XLS

**OTHER:**

C8003(3)L.xls - sample #136 shows 3 trials with -1 in the HIT/MISS column
C8003(3)D.xls - sample #136 shows 3 trials with -1 in the HIT/MISS column

C3002: Sample #16 shows 0.10” in depth. NASA CR 151098 pg 27. shows 0.010”. Since the sample thickness is 0.063” this NTIAC entry is incorrect.

The primary and secondary scales on abscissa axes in Chart 1may be incorrect. Compare actual flaw sizes and inspection data on data sheets available in electronic distributions.

# REPORT DOCUMENTATION PAGE

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**14. ABSTRACT**

This data book contains the Directed Design of Experiments for Validating Probability of Detection (POD) Capability of NDE Systems (DOEPOD) analyses of the nondestructive inspection data presented in the NTIAC, Nondestructive Evaluation (NDE) Capabilities Data Book, 3rd ed., NTIAC DB-97-02. DOEPOD is designed as a decision support system to validate inspection system, personnel, and protocol demonstrating 0.90 POD with 95% confidence at critical flaw sizes, a90/95. The test methodology used in DOEPOD is based on the field of statistical sequential analysis founded by Abraham Wald, "Sequential analysis is a method of statistical inference whose characteristic feature is that the number of observations required by the procedure is not determined in advance of the experiment. The decision to terminate the experiment depends, at each stage, on the results of the observations previously made. A merit of the sequential method, as applied to testing statistical hypotheses, is that test procedures can be constructed which require, on average, a substantially smaller number of observations than equally reliable test procedures based on a predetermined number of observations." A. Wald, 1947.

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