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NASA DOEPOD NDE Capabilities Data Book

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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. Actions: Address any false call warnings.
CASE 1+	●	90/95 POD at X_{pod} has been reached. 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. 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. 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}. 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. 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}. 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. 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**

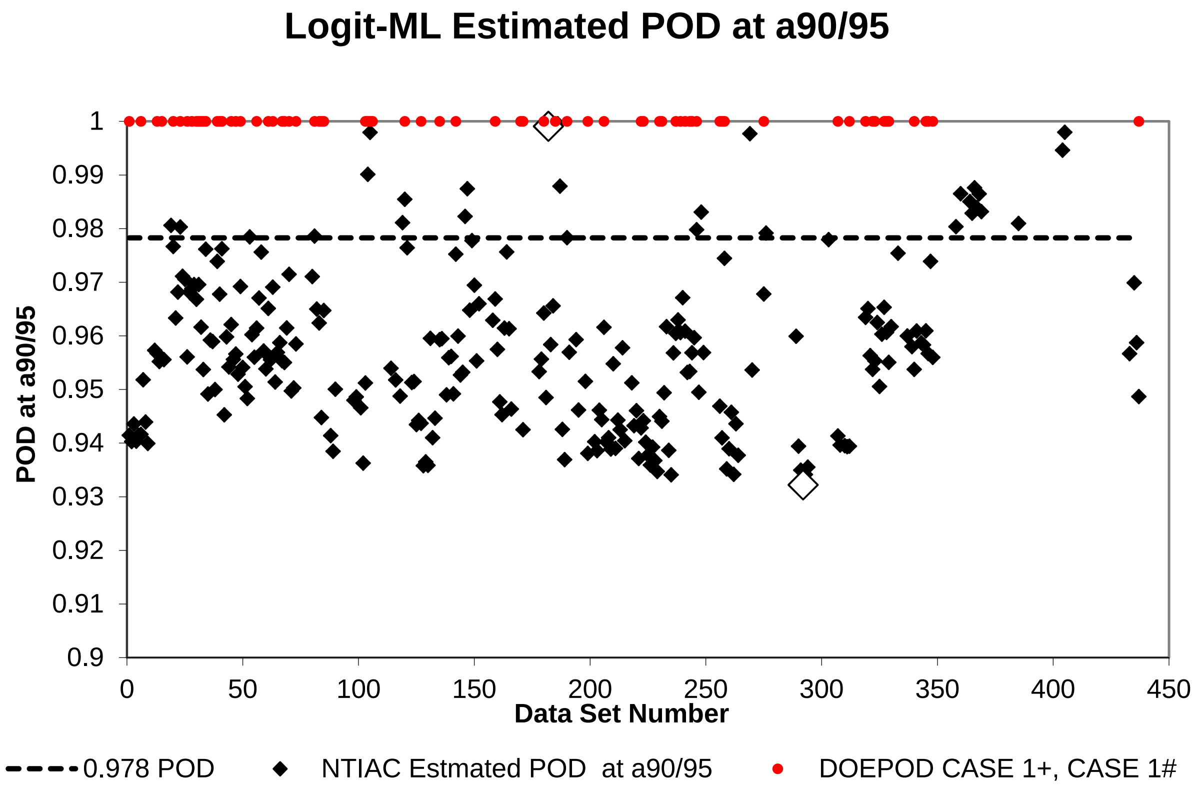

Figure 1. Logit-ML Estimated POD at critical flaw size, a90/95, from NTIAC (1997). Open diamonds refer to data sets each having 325 samples. The horizontal dashed line is the NASA minimum binomial estimated POD (0.978) accepted in practice at a flaw size, Xpod, for failure critical applications. DOEPOD 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 $X_L/3$ <u>and</u> 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. 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$^{\xi}$. 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. $^{\xi}$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 <u>quantitatively measure</u> each of the base parameters, or if the inspection technology is validated to <u>quantitatively measure the new combine parameter</u>. 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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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				0.7206	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 #
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
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								
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
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								
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
STEEL 4340	plate	B1003CL.XLS	6/4/15 8:27 PM	CASE 1*	0.2340	0.0590	0.9001				2.4030		1.6030									
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
SS AMS 355	hole	B2002.XLS	6/4/15 8:30 PM	CASE 1#	0.1031	0.0540	0.9001				0.2575		0.1929									
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		
SS AMS 355	hole	B30011.XLS	6/4/15 8:32 PM	CASE 7				0.8813	0.0190	0.0866											0.1803	29
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
SS AMS 355	hole	B4001L.XLS	6/4/15 8:36 PM	CASE 5				0.4729	0.0010	0.0623	0.3425	28							0.0821	26		
2219 Al T-87	plate	C1001AL.XLS	6/4/15 8:38 PM	CASE 7				0.8609	0.0200	0.2610											1.9580	29
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
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									
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									
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									
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									
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									
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								
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									
2219 Al T-87	plate	C2002AL.XLS	6/4/15 9:01 PM	CASE 7				0.7066	0.0520	0.5300											1.1000	29
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									
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									
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
Ti 6Al4V	plate	C3001BL.XLS	6/4/15 9:06 PM	CASE 2	0.1950	0.0540	0.9001				0.4070		0.3000	17								
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		
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
Ti 6Al4V	plate	C3002BL.XLS	6/4/15 9:10 PM	CASE 2	0.1900	0.0530	0.9001				0.4070		0.3000	17								
Ti 6Al4V	plate	C3002CL.XLS	6/4/15 9:11 PM	CASE 1#	0.2160	0.0340	0.9001				0.4070		0.2650									
Ti 6Al4V	plate	C3003AL.XLS	6/4/15 9:12 PM	CASE 7				0.8965	0.1000	0.3250											0.8140	29
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								
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								
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
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		
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		
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			
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
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
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
SS AMS 355	hole	C500016.XLS	6/4/15 9:26 PM	CASE 7				0.2713	0.0150	0.0606											0.1315	29
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
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
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
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								
STEEL 4340	plate	C6002BL.XLS	6/4/15 9:35 PM	CASE 1*	0.0960	0.0400	0.9001				2.4030		1.6030									
STEEL 4340	plate	C6002CL.XLS	6/4/15 9:36 PM	CASE 1#	0.2370	0.0620	0.9050				2.4030		1.6030									
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								
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								
STEEL 4340	plate	C6003CL.XLS	6/4/15 9:40 PM	CASE 1*	0.2340	0.0590	0.9001				2.4030		1.6030									
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		
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		
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			
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								
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								
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
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								

FILE NAME	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
B1003AD.XLS												Warning: No false call analysis.						MT
B1003AL.XLS												Warning: No false call analysis.		0.26	0.465		1.000	MT
B1003BD.XLS												Warning: No false call analysis.						MT
B1003BL.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.11	0.135		1.000	MT
B1003CD.XLS												Warning: No false call analysis.		0.045				MT
B1003CL.XLS												Warning: No false call analysis.		0.12	0.235	0.234	1.000	MT
B2001.XLS												Warning: No false call analysis.		0.115	0.175			MT
B2002.XLS			0.1004	2								Warning: No false call analysis.		0.04	0.065	0.10314	1.000	MT
B2003.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.045	0.07			MT
B30011.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.24				MT
B30012.XLS												Warning: No false call analysis.		0.075	0.095			MT
B4001L.XLS												Warning: No false call analysis.		0.175	0.26			MT
C1001AL.XLS												Warning: No false call analysis.		0.395	0.63			PT
C1001BL.XLS												Warning: No false call analysis.		0.44	0.695			PT
C1001CL.XLS			0.5370	29								Warning: No false call analysis.		0.315	0.61	0.539	1.000	PT
C1002AL.XLS												Warning: No false call analysis.		0.09	0.115	0.29	1.000	PT
C1002BL.XLS												Warning: No false call analysis.		0.08	0.105	0.261	0.967	PT
C1002CL.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.11	0.145	0.508	1.000	PT
C1003AL.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.02	0.035	0.086	1.000	PT
C1003BL.XLS												Warning: No false call analysis.		0.08	0.095	0.279	1.000	PT
C1003CL.XLS												Warning: No false call analysis.		0.06	0.07	0.086	0.978	PT
C2002AL.XLS												Warning: No false call analysis.						PT
C2002BL.XLS			0.2880	28								Warning: No false call analysis.		0.095	0.17	0.534	1.000	PT
C2002CL.XLS												Warning: No false call analysis.		0.22	0.385		1.000	PT
C3001AL.XLS												Warning: No false call analysis.		0.705				PT
C3001BL.XLS												Warning: No false call analysis.		0.12	0.175	0.32	1.000	PT
C3001CL.XLS												Warning: No false call analysis.		0.14	0.325			PT
C3002AL.XLS												Warning: No false call analysis.		0.13	0.32			PT
C3002BL.XLS												Warning: No false call analysis.		0.12	0.165	0.315	1.000	PT
C3002CL.XLS			0.1300	15								Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.08	0.1	0.216	1.000	PT
C3003AL.XLS												Warning: No false call analysis.		0.185	0.465			PT
C3003BL.XLS												Warning: No false call analysis.		0.155	0.295		1.000	PT
C3003CL.XLS												Warning: No false call analysis.		0.155	0.305		1.000	PT
C400011.XLS												Warning: No false call analysis.		0.13	0.195			PT
C400012.XLS												Warning: No false call analysis.		0.085	0.12			PT
C400013.XLS												Warning: No false call analysis.		0.1	0.185			PT
C400014.XLS												Warning: No false call analysis.		0.135	0.225			PT
C500011.XLS												Warning: No false call analysis.		0.085	0.11			PT
C500012.XLS												Warning: No false call analysis.		0.085	0.105			PT
C500014.XLS												Warning: No false call analysis.		0.095	0.12			PT
C500016.XLS												Warning: No false call analysis.		0.095				PT
C6001AL.XLS												Warning: No false call analysis.						PT
C6001BL.XLS												Warning: No false call analysis.						PT
C6001CL.XLS												Warning: No false call analysis.						PT
C6002AL.XLS												Warning: No false call analysis.		0.1			1.000	PT
C6002BL.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.06	0.08	0.18	1.000	PT
C6002CL.XLS			0.1940	11								Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.085	0.105	0.237	1.000	PT
C6003AL.XLS												Warning: No false call analysis.		0.265	0.6		1.000	PT
C6003BL.XLS												Warning: No false call analysis.		0.155	0.255		1.000	PT
C6003CL.XLS												Warning: No false call analysis.		0.11	0.175	0.234	1.000	PT
C7001L.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.215	0.36			PT
C7002L.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.35	0.58			PT
C7003L.XLS												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.3	0.505			PT
C8001(3)D.xls												Warning: No false call analysis.		0.075	0.12		1.000	PT
C8001(3)L.xls												Warning: No false call analysis.		0.445			1.000	PT
C8002(3)D.xls												Warning: No false call analysis.		0.08				PT
C8002(3)L.xls												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	0.306	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 #
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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									
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
2219 Al T-87	weld flush TFC	F9001(3)D.xls		CASE 7																	0.4300	29
2219 Al T-87	weld flush TFC	F9001(3)L.xls		CASE 7																	0.9900	29
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
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
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
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
2219 Al T-87	plate	G10003AA.XLS	6/5/15 6:23 AM	CASE 7				0.8514	0.0930	0.6333											1.6333	29
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			
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									
2219 Al T-87	plate	G10003BA.XLS	6/5/15 6:27 AM	CASE 7				0.6532	0.2000	0.6833											1.6182	29
2219 Al T-87	plate	G10003BD.XLS	6/5/15 6:29 AM	CASE 7				0.8074	0.0300	0.1260											0.3560	29
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
SS AMS 355	hole	G2001L.XLS	6/5/15 6:31 AM	CASE 1#	0.0845	0.0260	0.9001				0.2425		0.1694									

FILE NAME	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
F6001(3)D.xls												Warning: No false call analysis.						RT
F6001(3)L.xls												Warning: No false call analysis.						RT
F6002(3)D.xls												Warning: No false call analysis.						RT
F6002(3)L.xls												Warning: No false call analysis.						RT
F6003(3)D.xls												Warning: No false call analysis.						RT
F6003(3)L.xls												Warning: No false call analysis.						RT
F7001(3)D.xls												Warning: No false call analysis.						RT
F7001(3)L.xls												Warning: No false call analysis.						RT
F7002(3)D.xls												Warning: No false call analysis.						RT
F7002(3)L.xls												Warning: No false call analysis.						RT
F7003(3)D.xls												Warning: No false call analysis.						RT
F7003(3)L.xls												Warning: No false call analysis.						RT
F8001(3)D.xls												Warning: No false call analysis.						RT
F8001(3)L.xls												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.					RT
F8002(3)D.xls												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.					RT
F8002(3)L.xls												Warning: No false call analysis.						RT
F8003(3)D.xls												Warning: No false call analysis.						RT
F8003(3)L.xls												Warning: No false call analysis.				1.061	1.000	RT
F9000CD.XLS												Warning: No false call analysis.		0.095				RT
F9001(3)D.xls													MLE Divergence Warning: Initial results listed.					RT
F9001(3)L.xls													MLE Divergence Warning: Initial results listed.					RT
F9002(3)D.xls												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.					RT
F9002(3)L.xls												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.56				RT
F9003(3)D.xls												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.					RT
F9003(3)L.xls												Warning: No false call analysis.	MLE Divergence Warning: Initial results listed.	0.56				RT
G10003AA.XLS												Warning: No false call analysis.		0.64				HT
G10003AD.XLS												Warning: No false call analysis.		0.095				HT
G10003AL.XLS												Warning: No false call analysis.		0.245	0.4	0.475	1.000	HT
G10003BA.XLS												Warning: No false call analysis.						HT
G10003BD.XLS												Warning: No false call analysis.		0.105	0.17			HT
G10003BL.XLS												Warning: No false call analysis.		0.46	0.63			HT
G2001L.XLS			0.0774	2								Warning: No false call analysis.		0.075	0.1	0.08452	1.000	HT

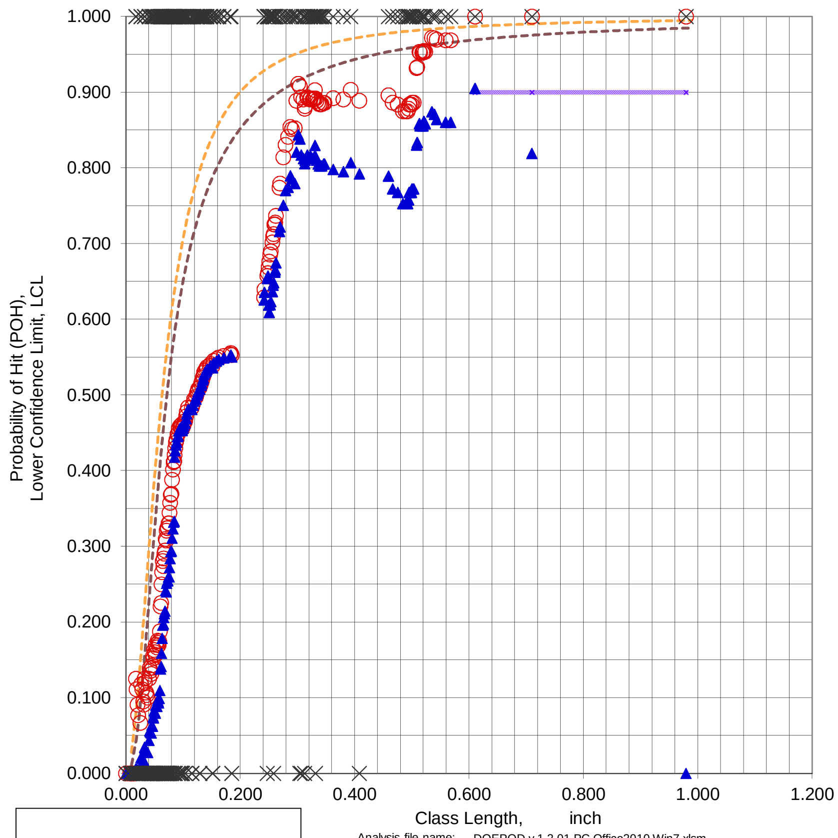
*All lengths are in inches

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.



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 = **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

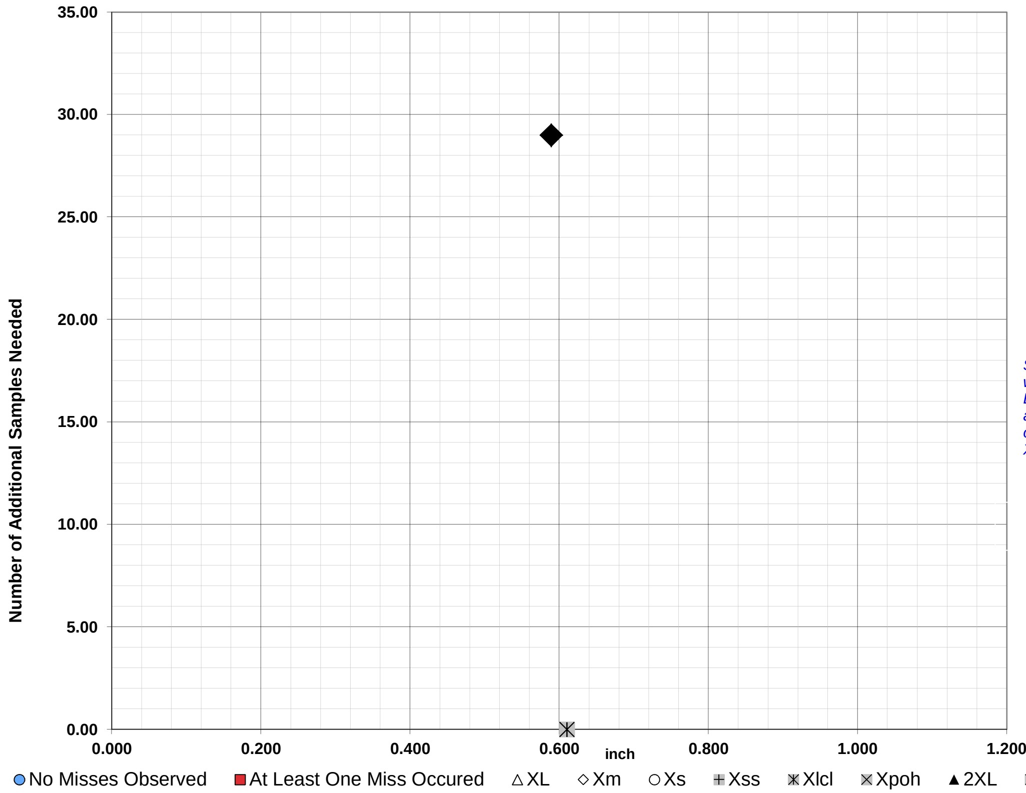


TABLE C

	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.

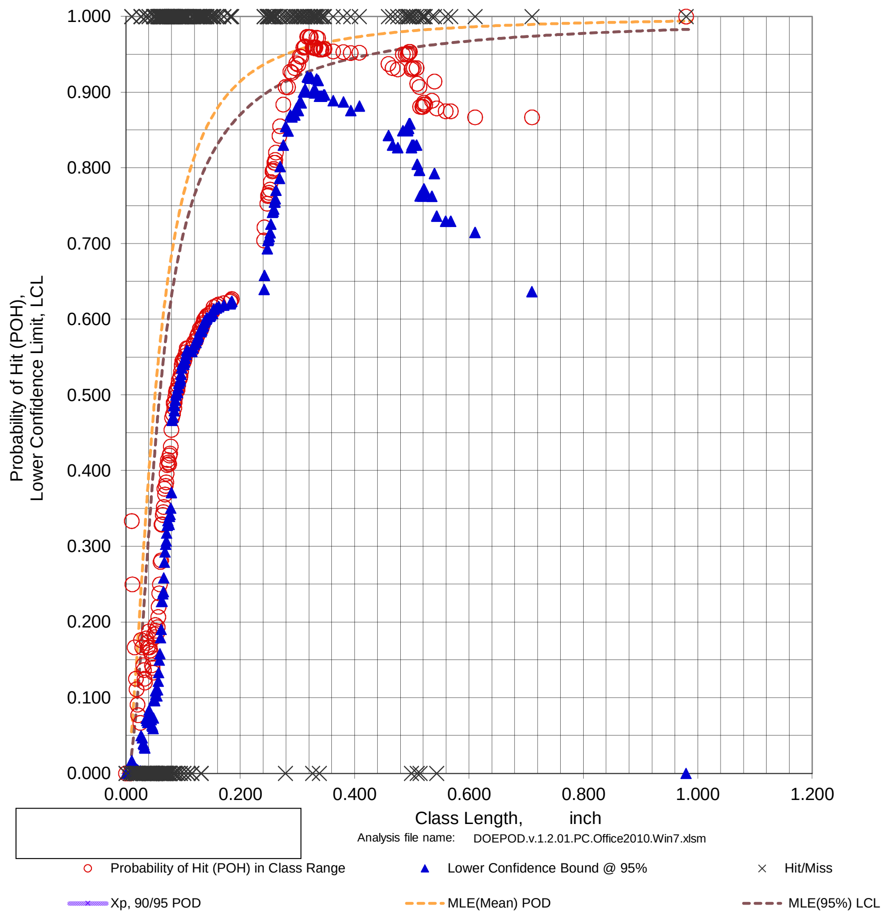
Xpod,Class Length	No. Need

* 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

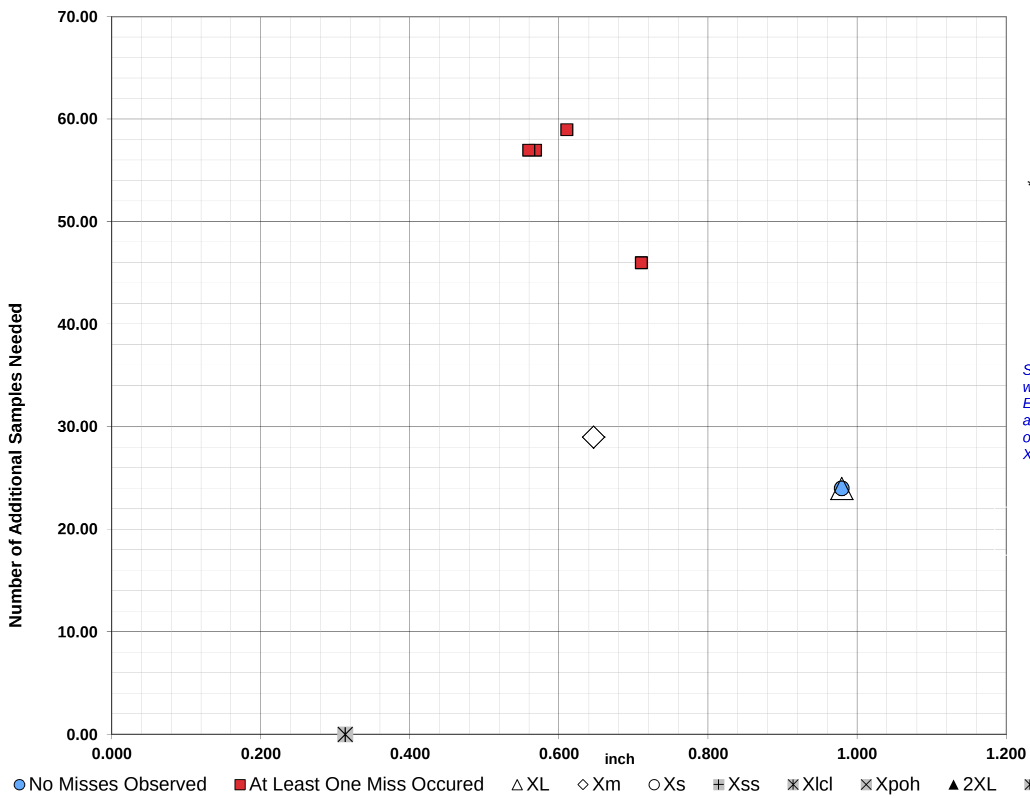


TABLE C

	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

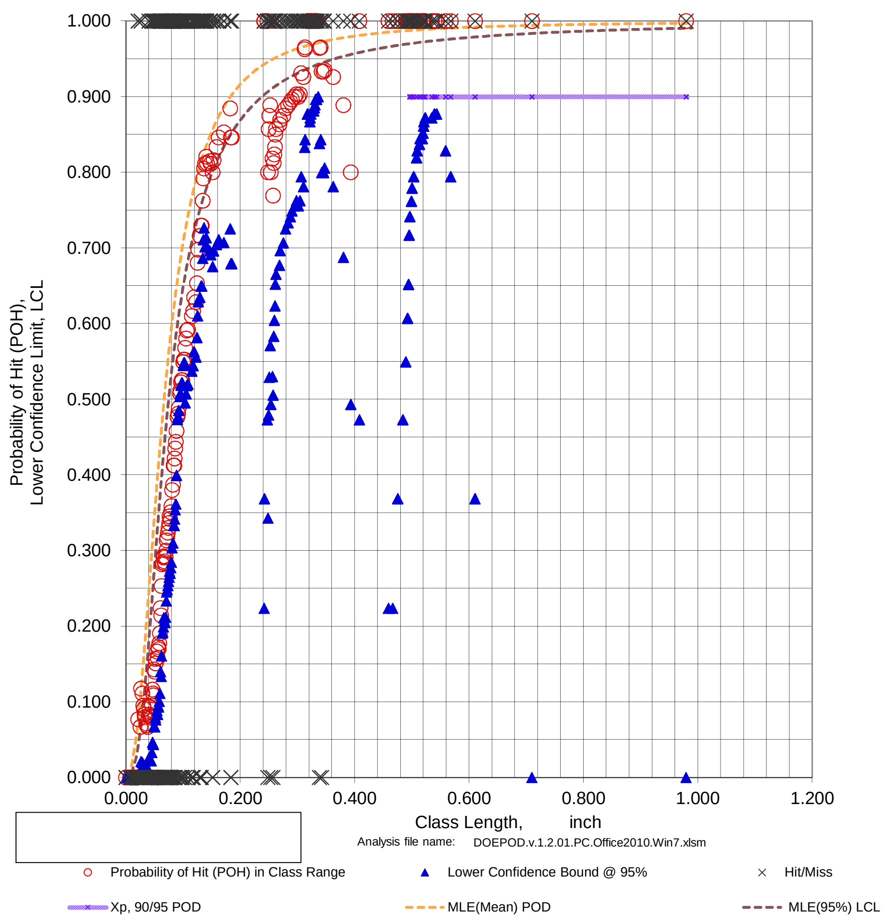
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

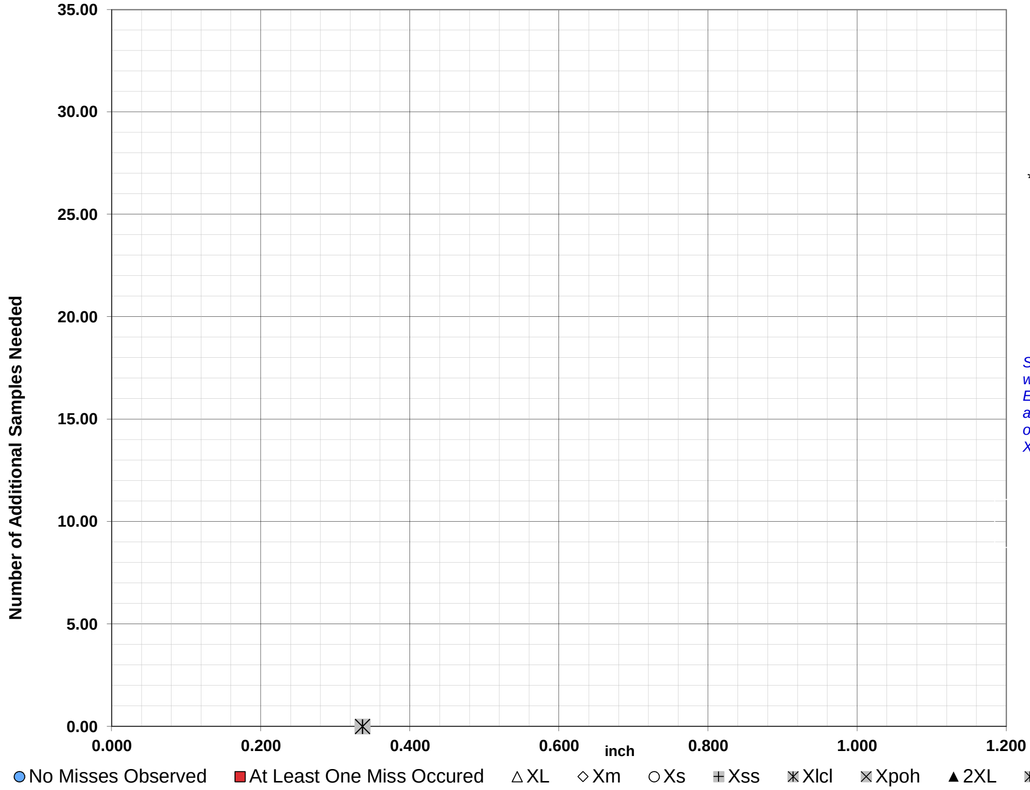


TABLE C

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.

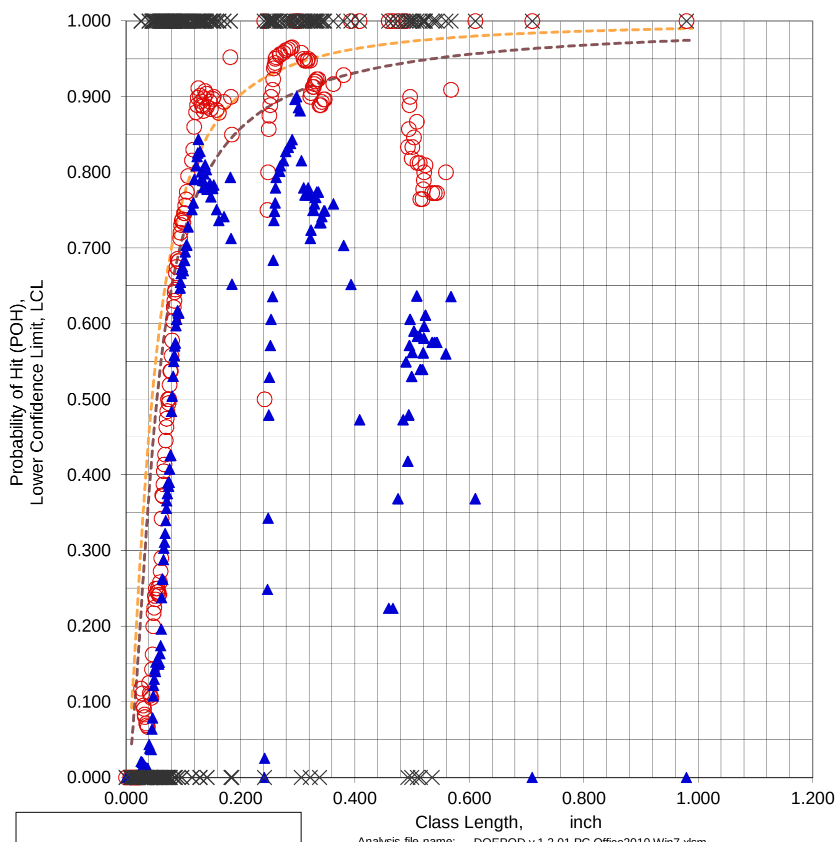
Xpod,Class Length	No. Need

* 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.



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 = **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

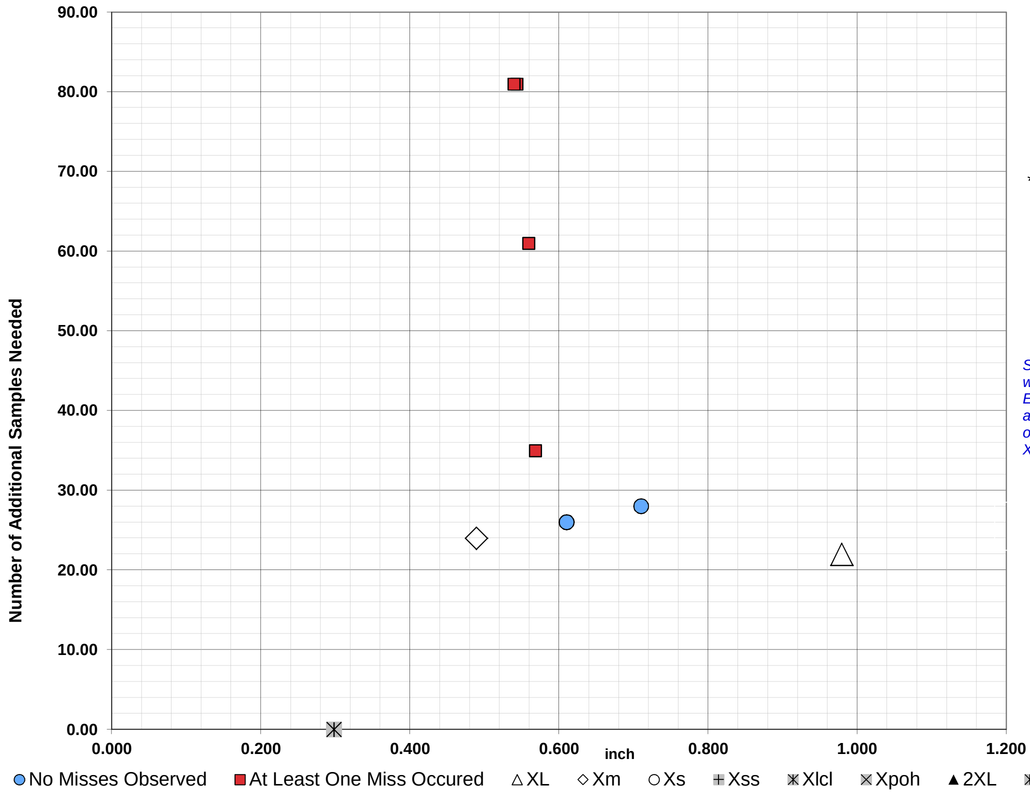


TABLE C

	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

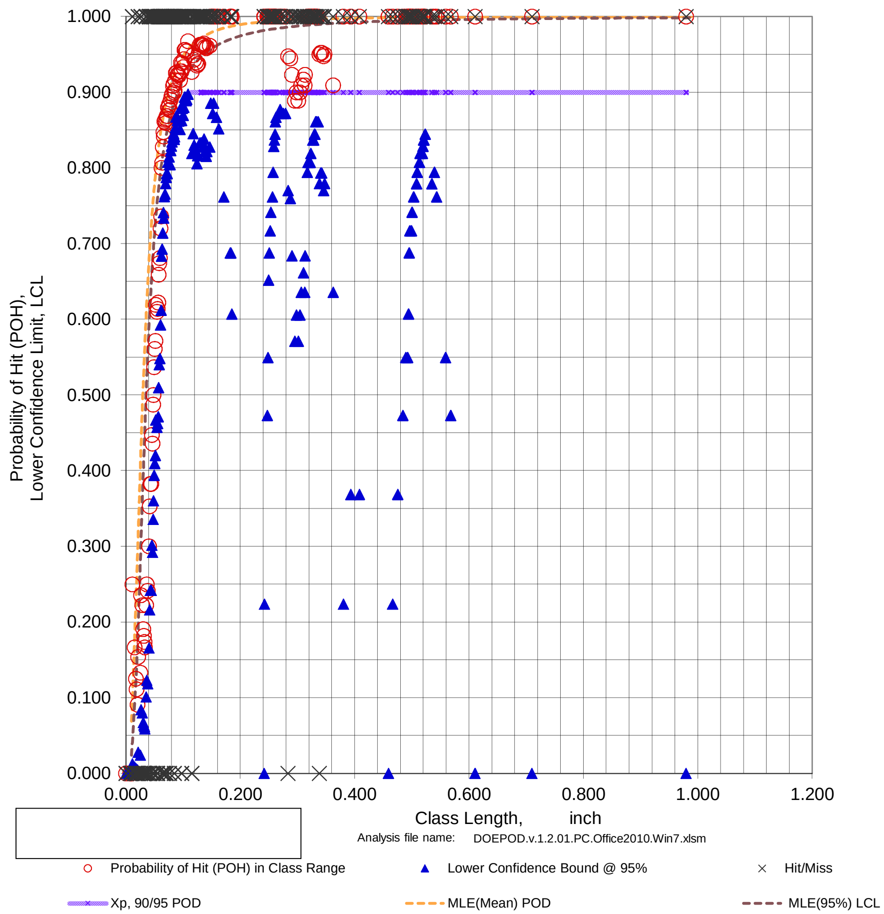
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

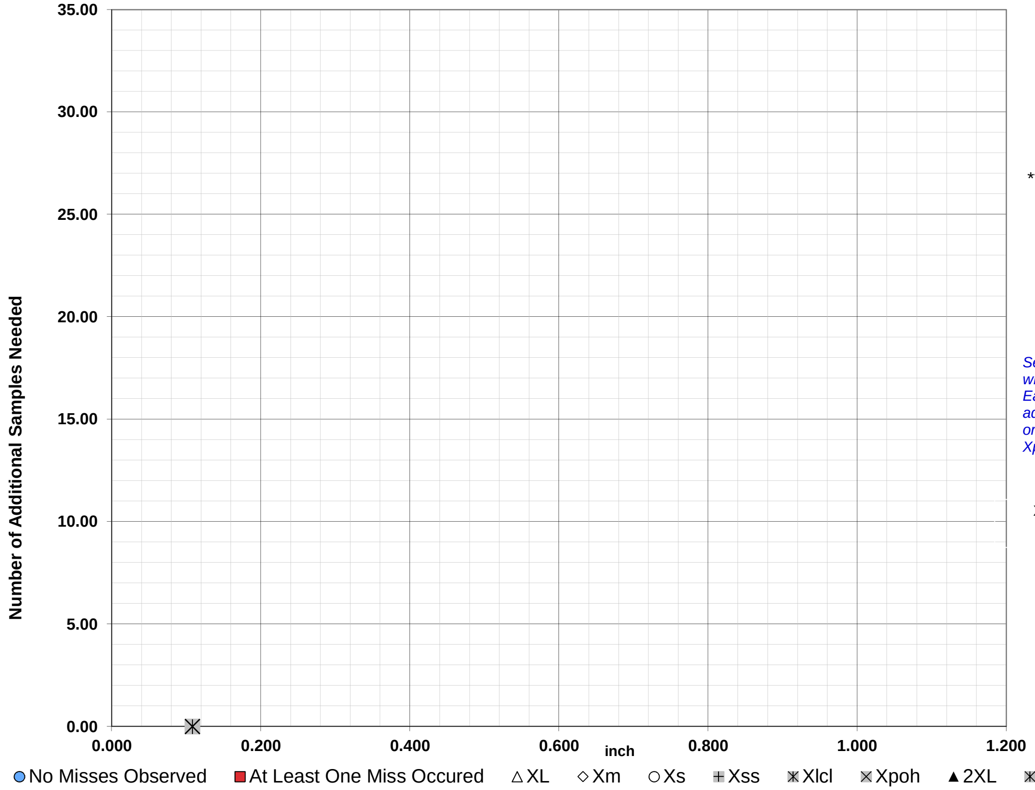


TABLE C

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

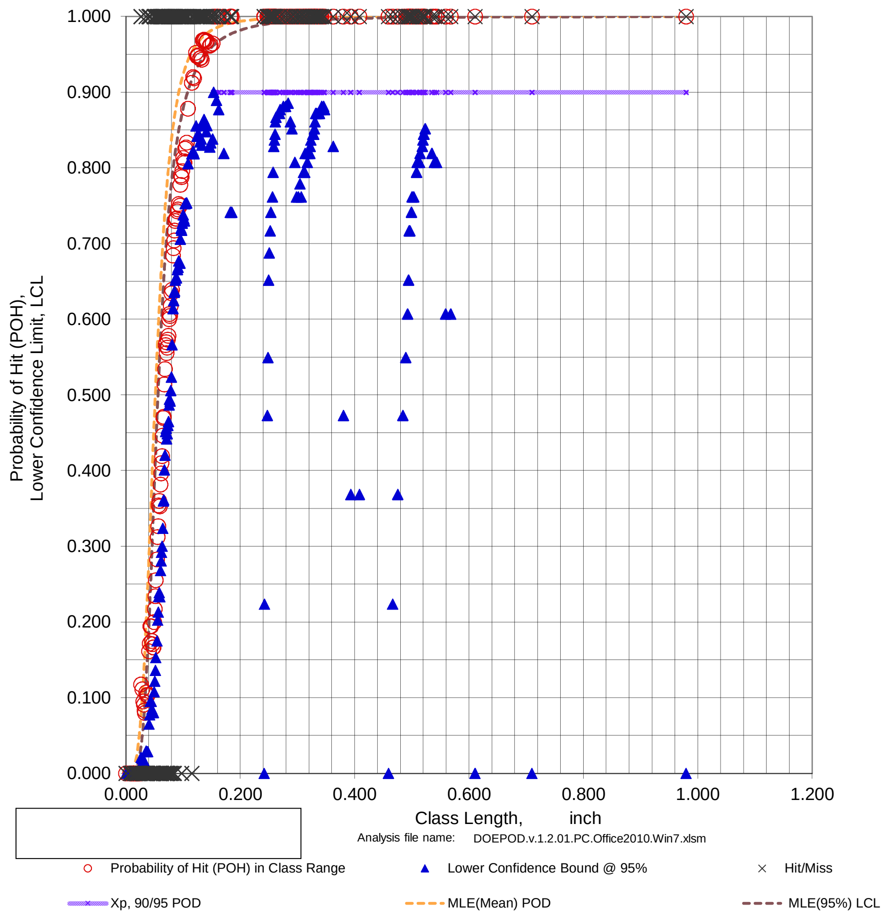
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

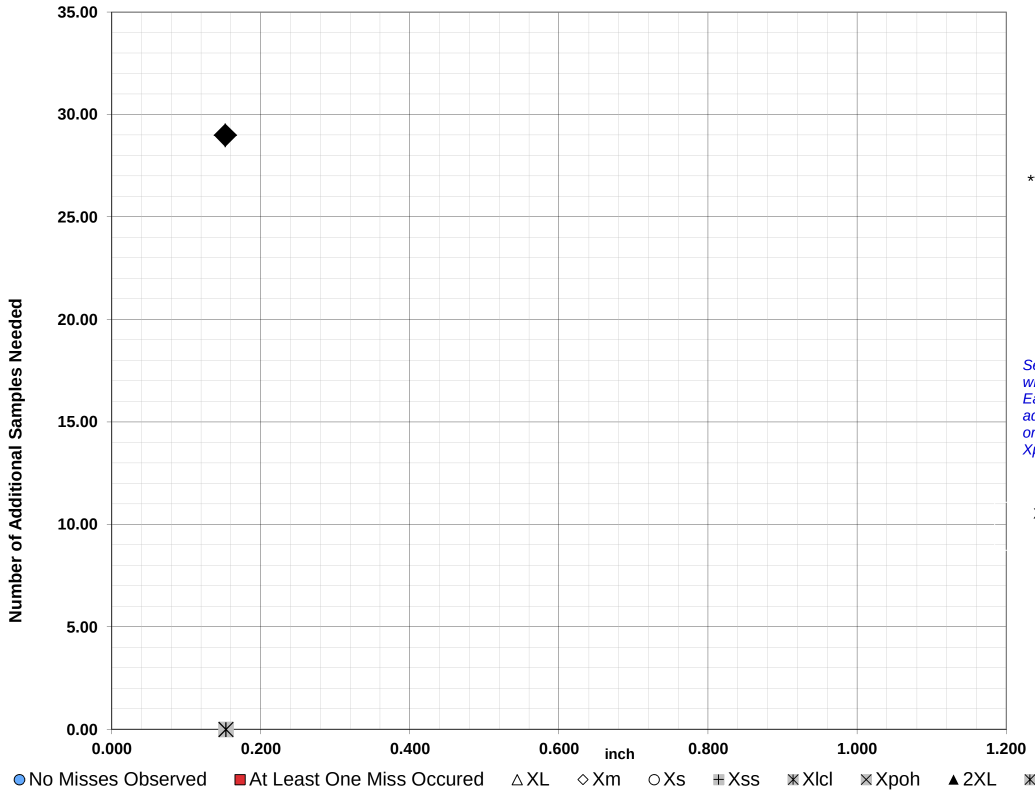


TABLE C

	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

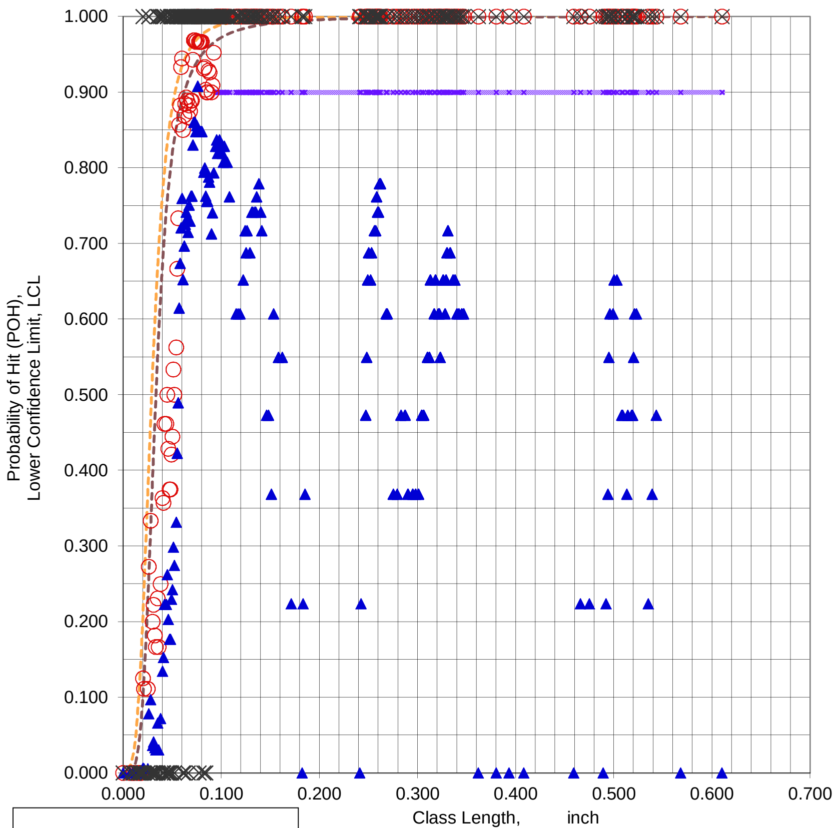
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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



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

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

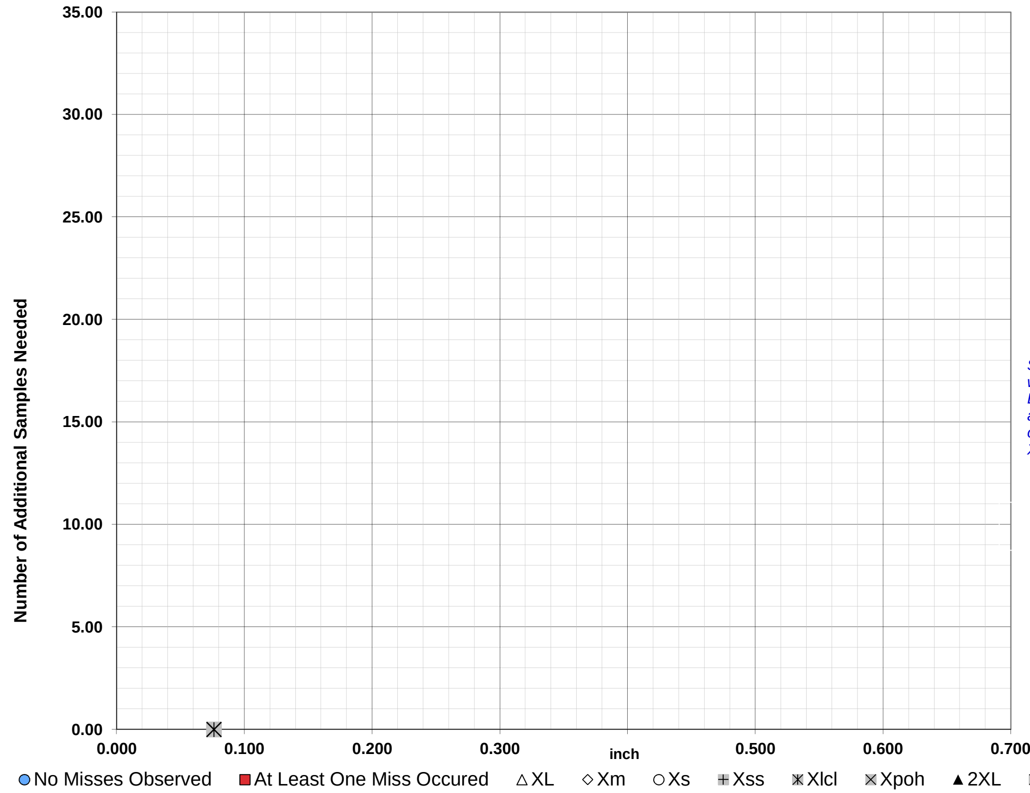


TABLE C

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

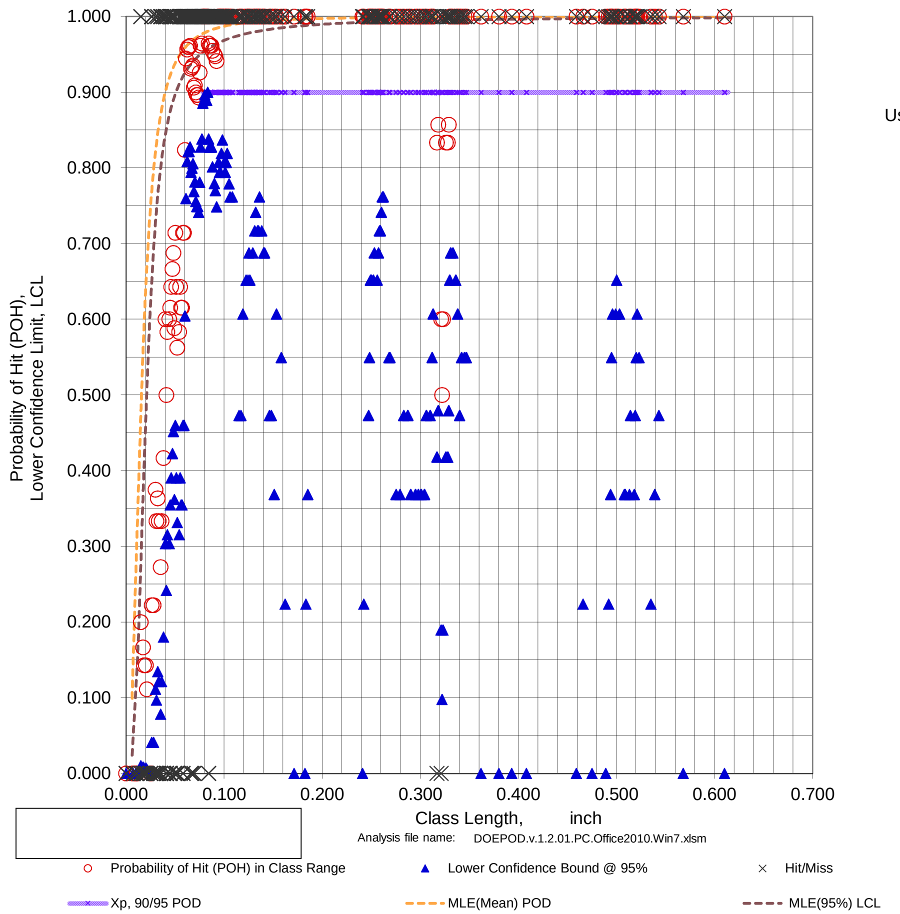
Classlength @ Best LCL = inch

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

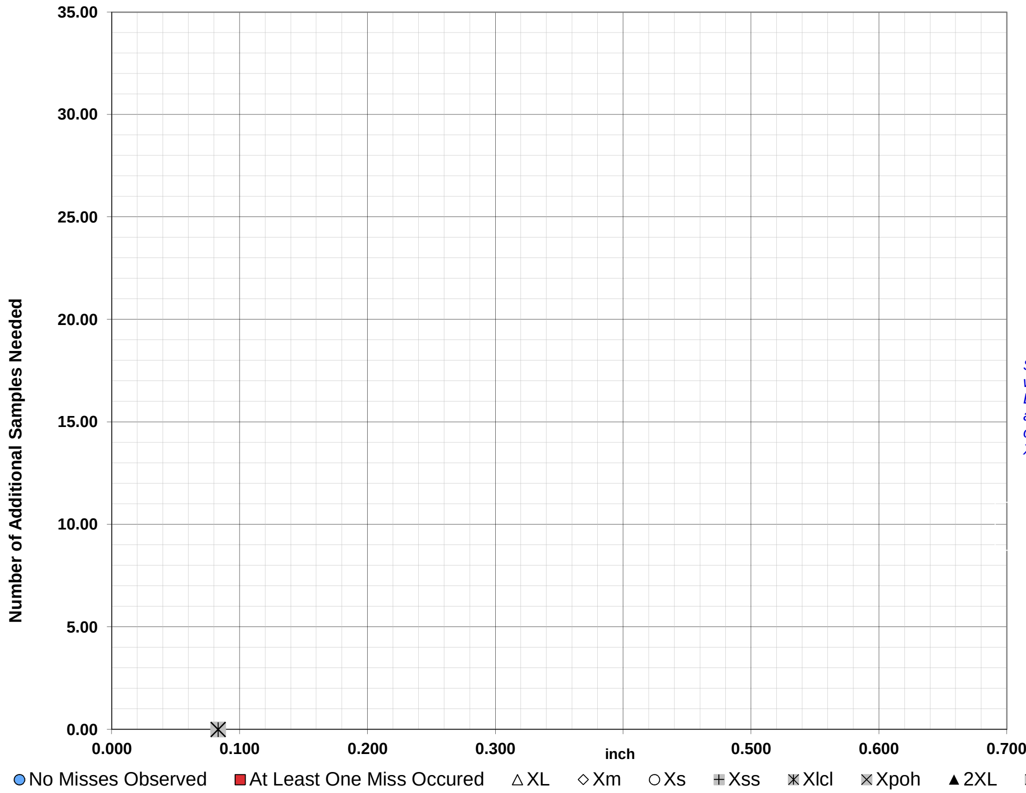


TABLE C

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

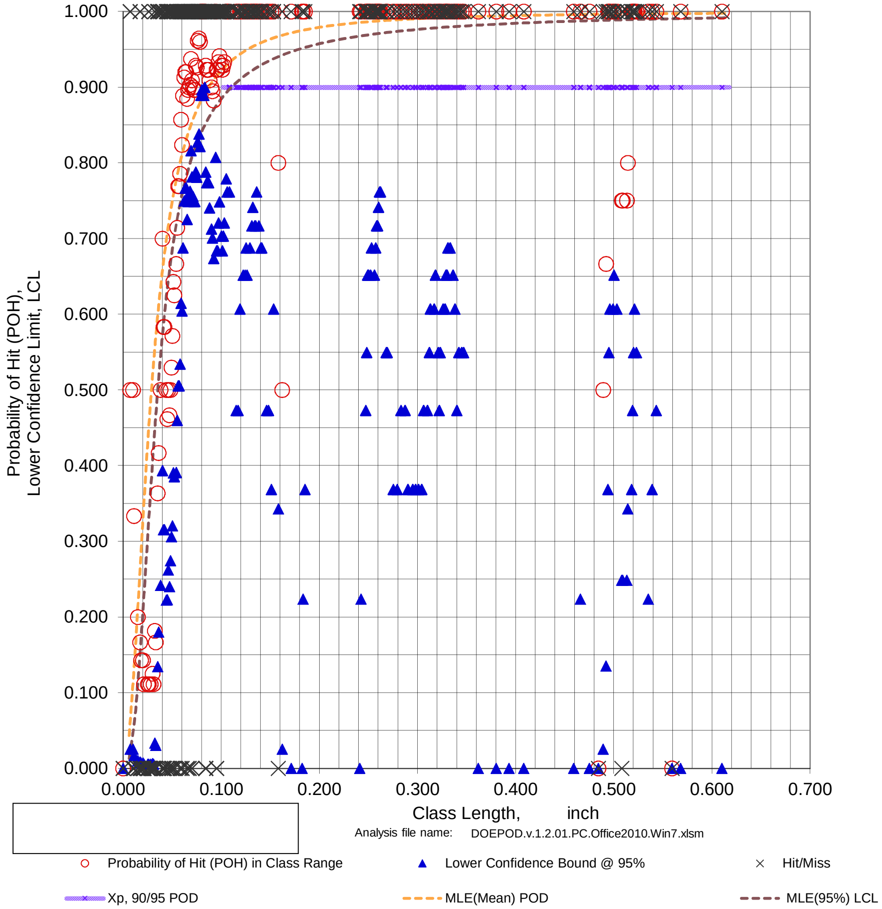
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

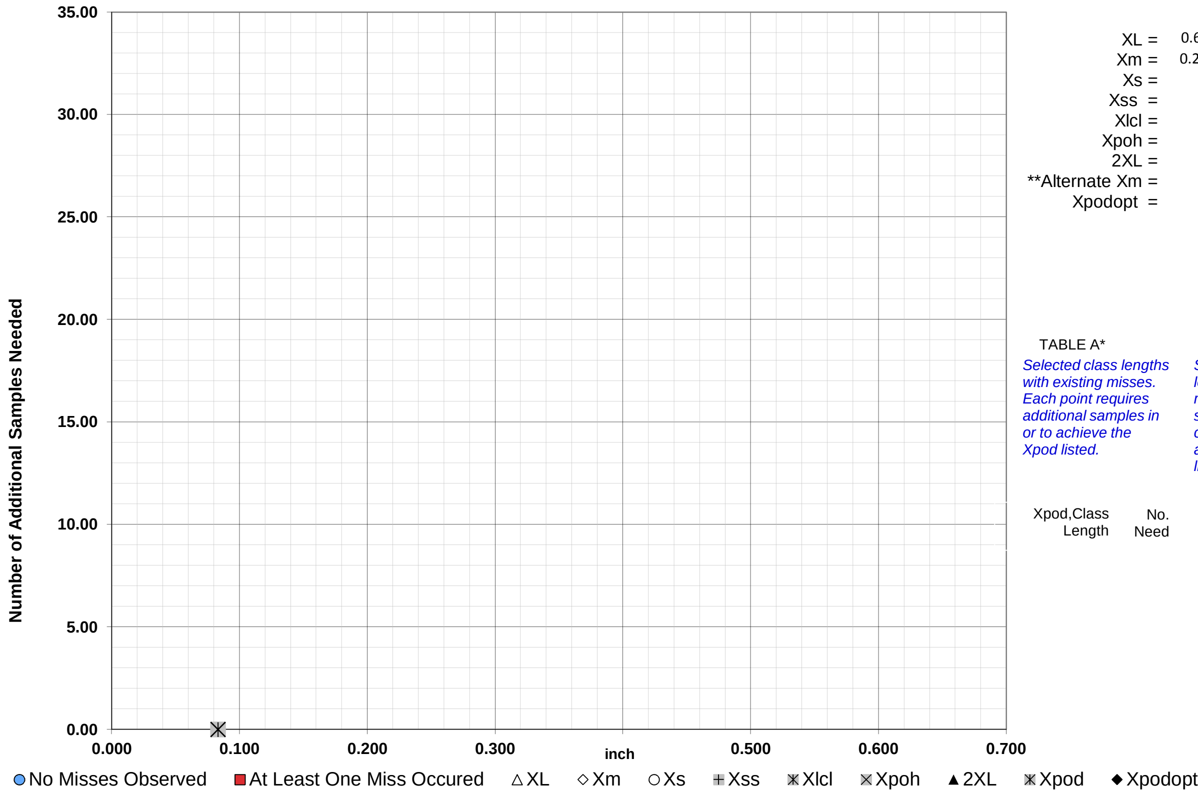


TABLE C

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

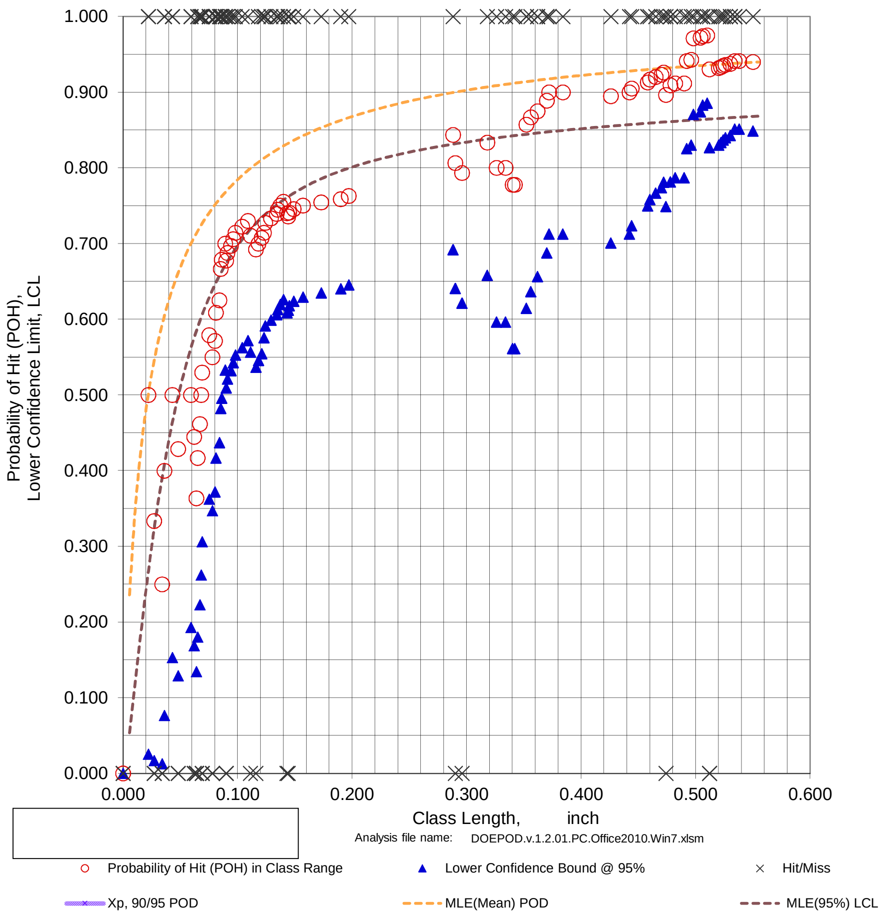
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



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

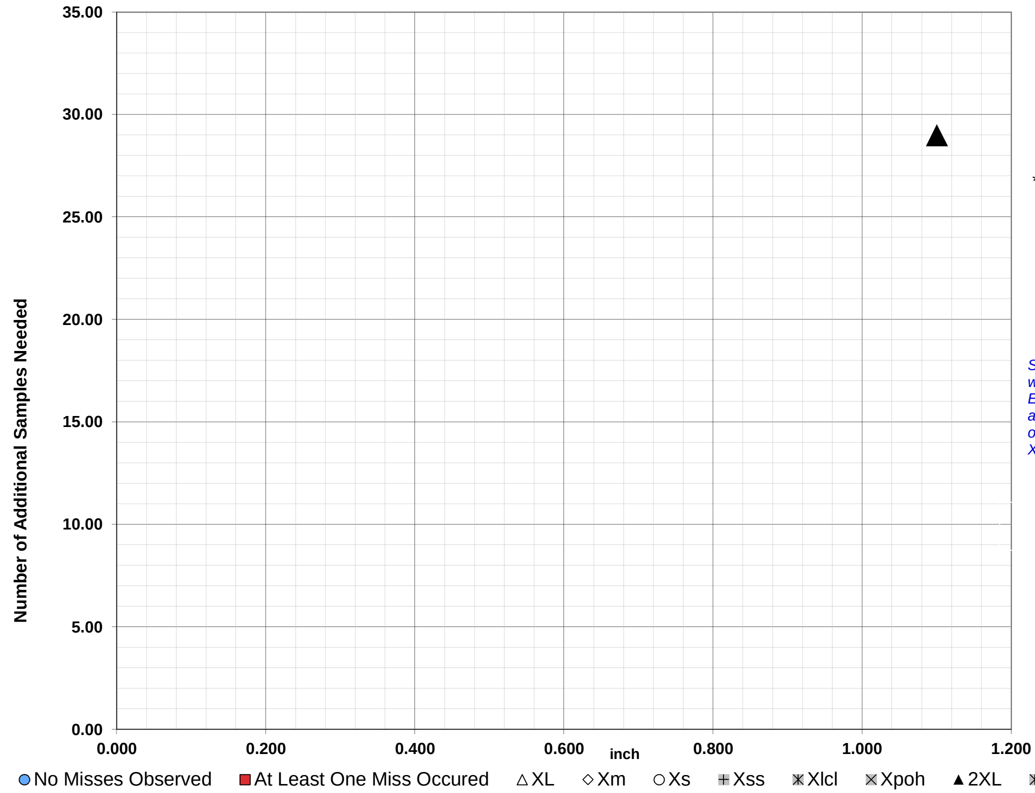


TABLE C

	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.

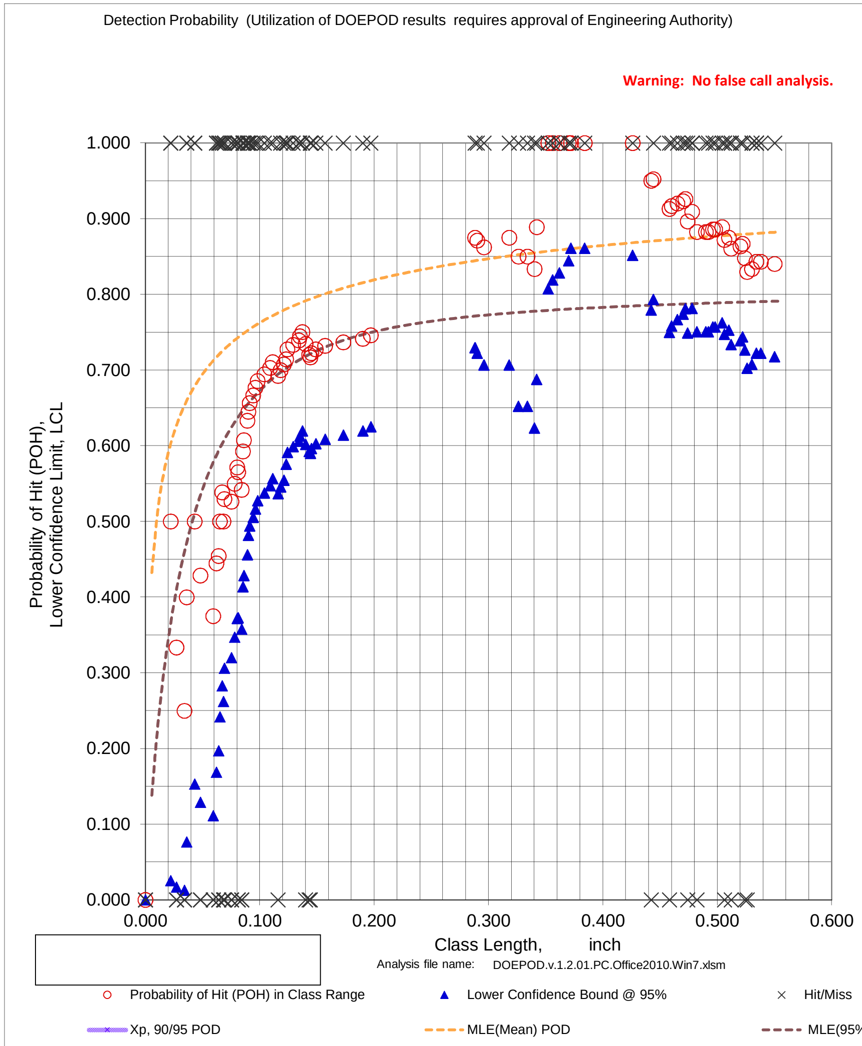
Xpod,Class Length	No. Need

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



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

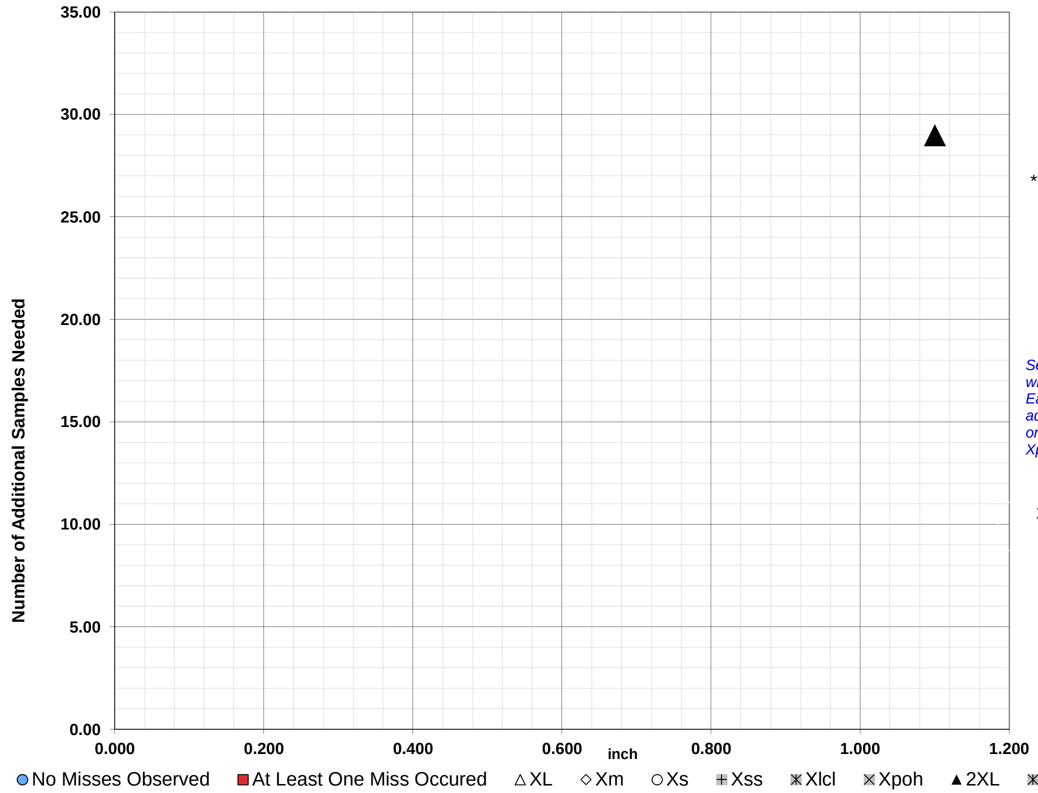


TABLE C

	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*

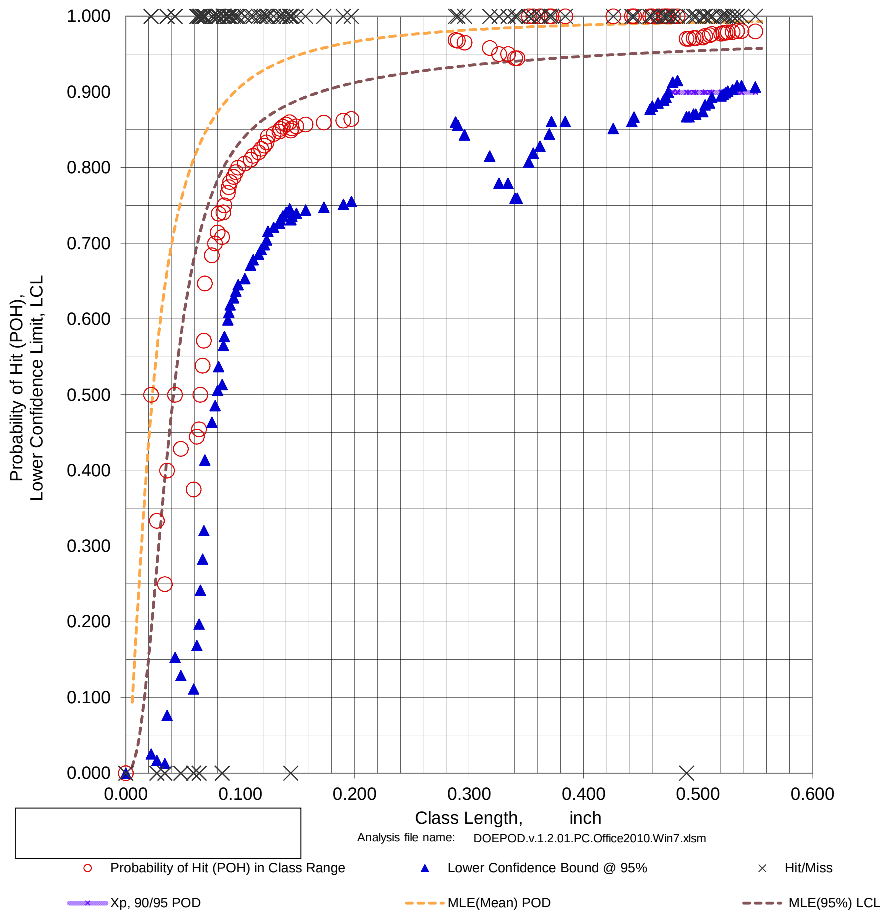
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

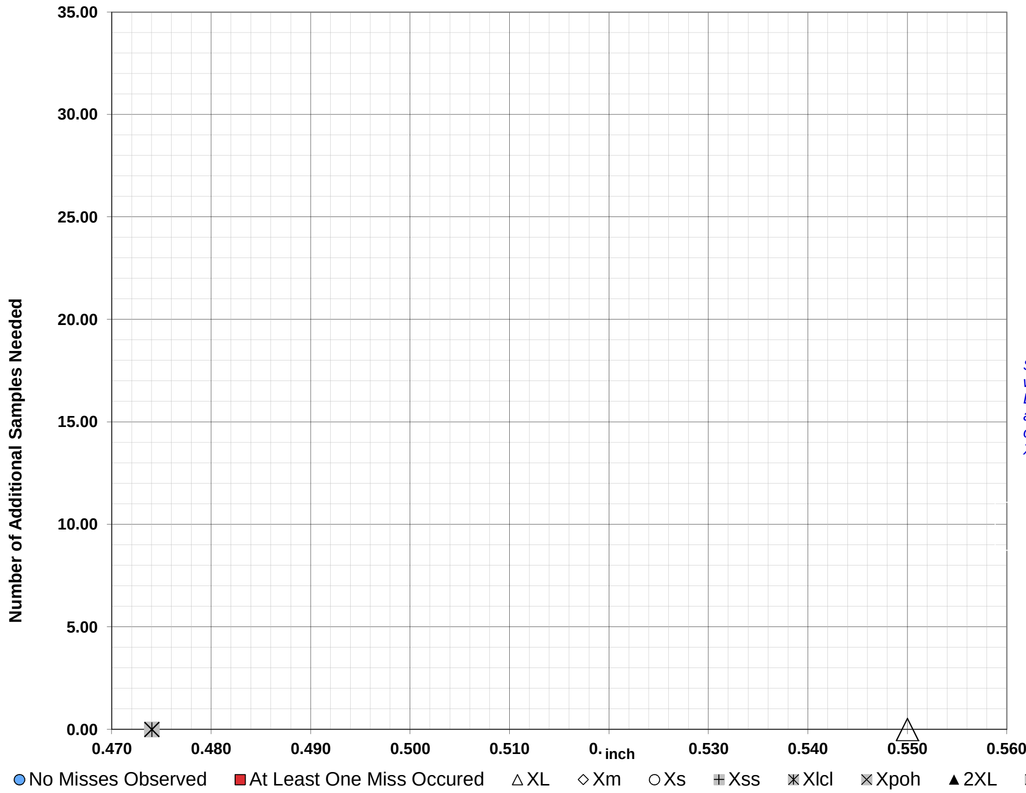


TABLE C

	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

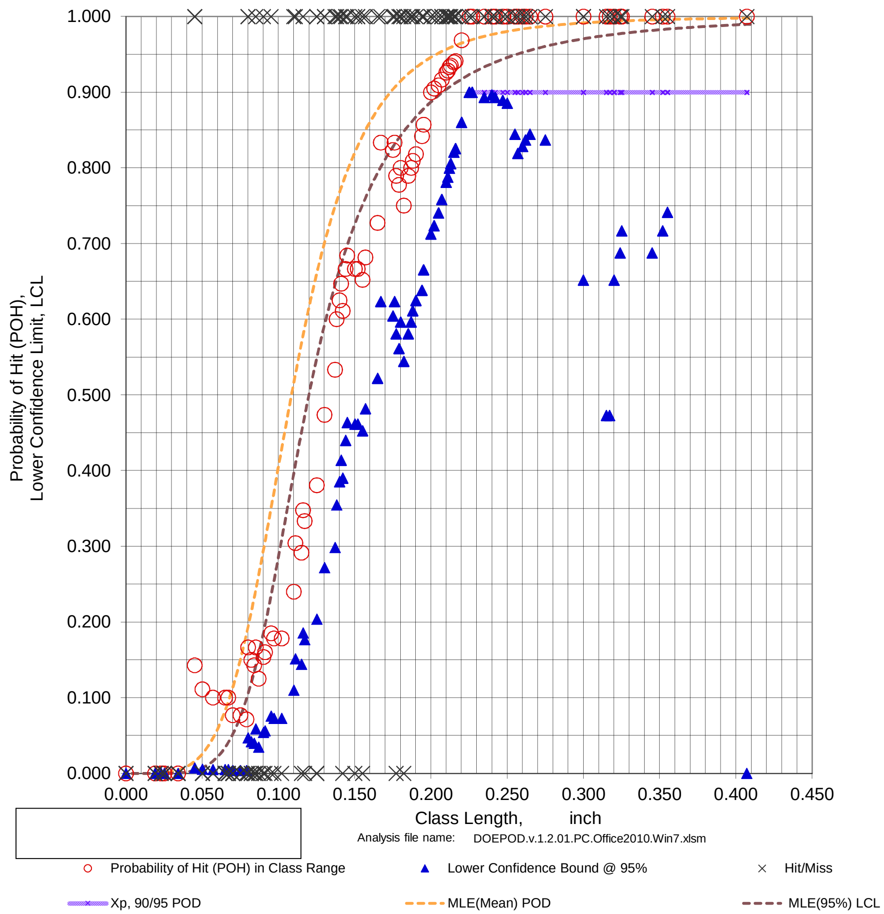
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

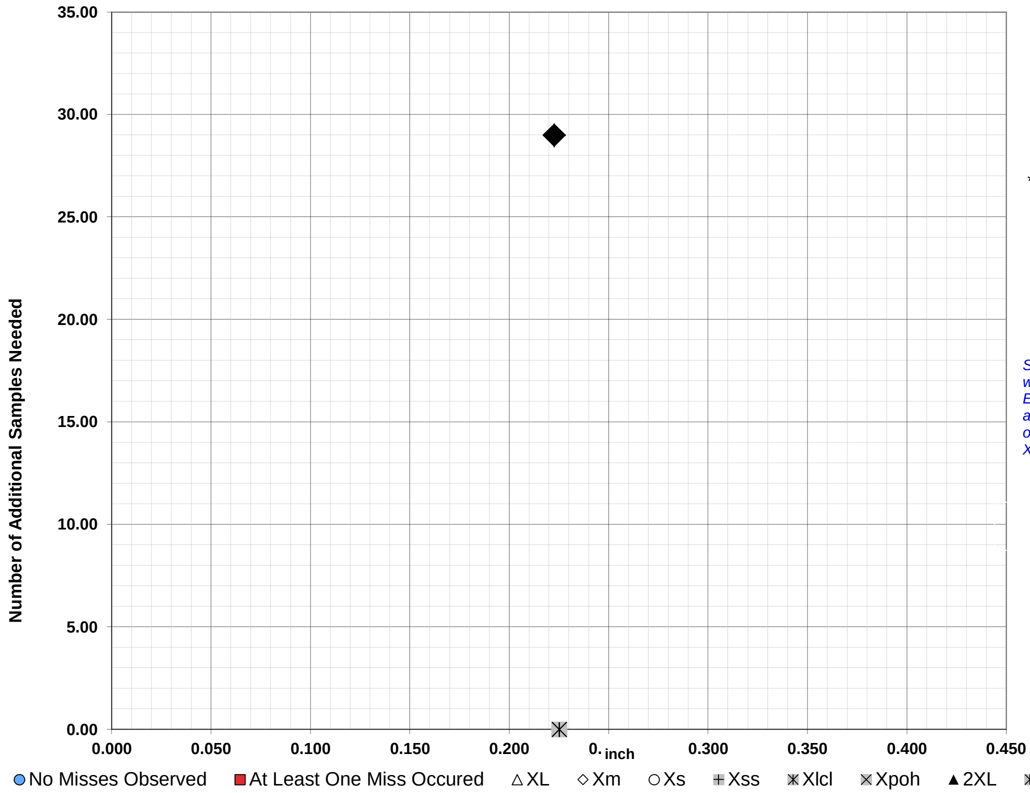


TABLE C

	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.

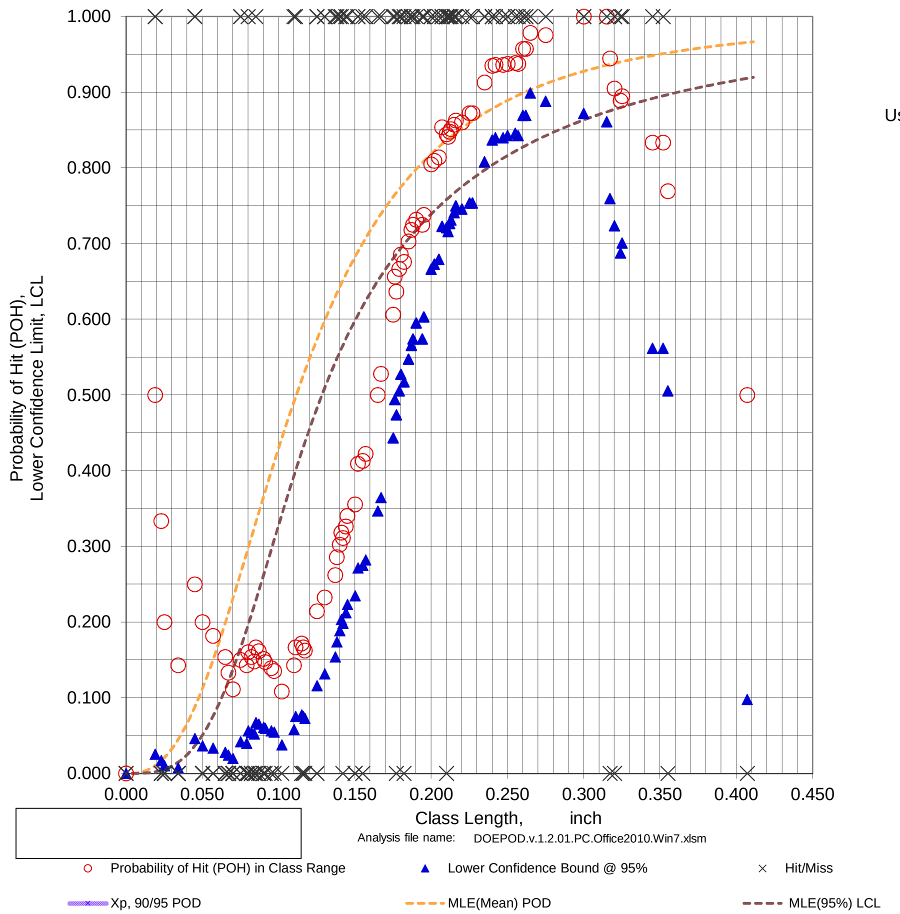
Xpod,Class Length	No. Need

* 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

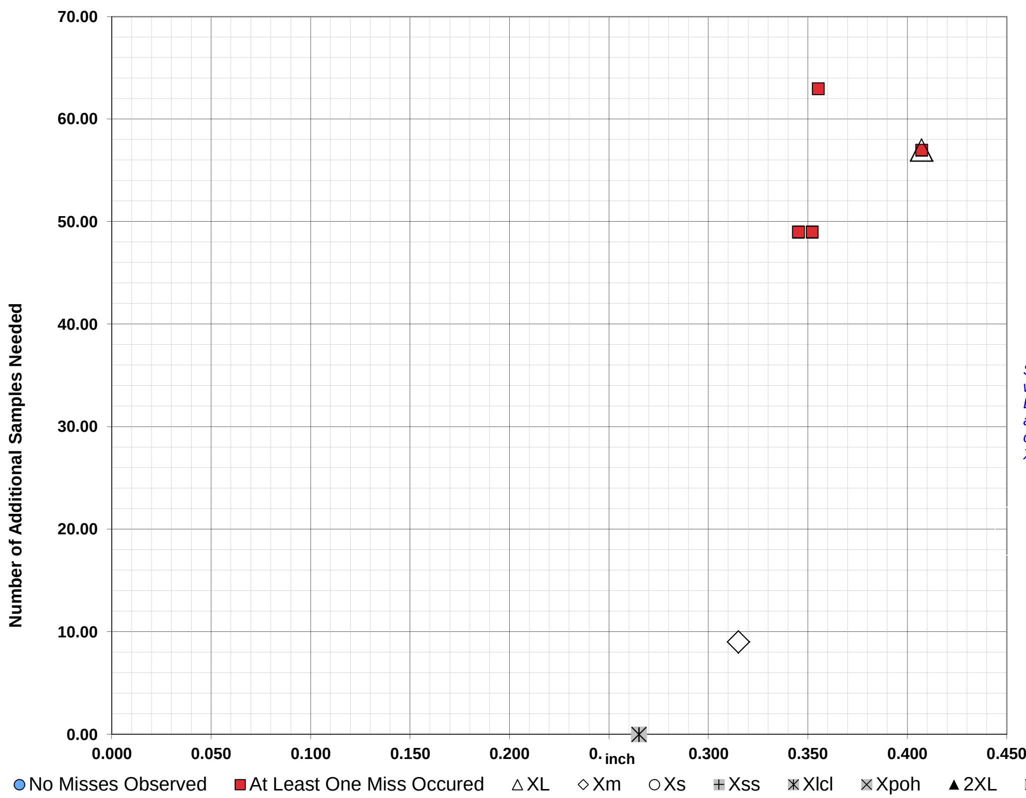


TABLE C

	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

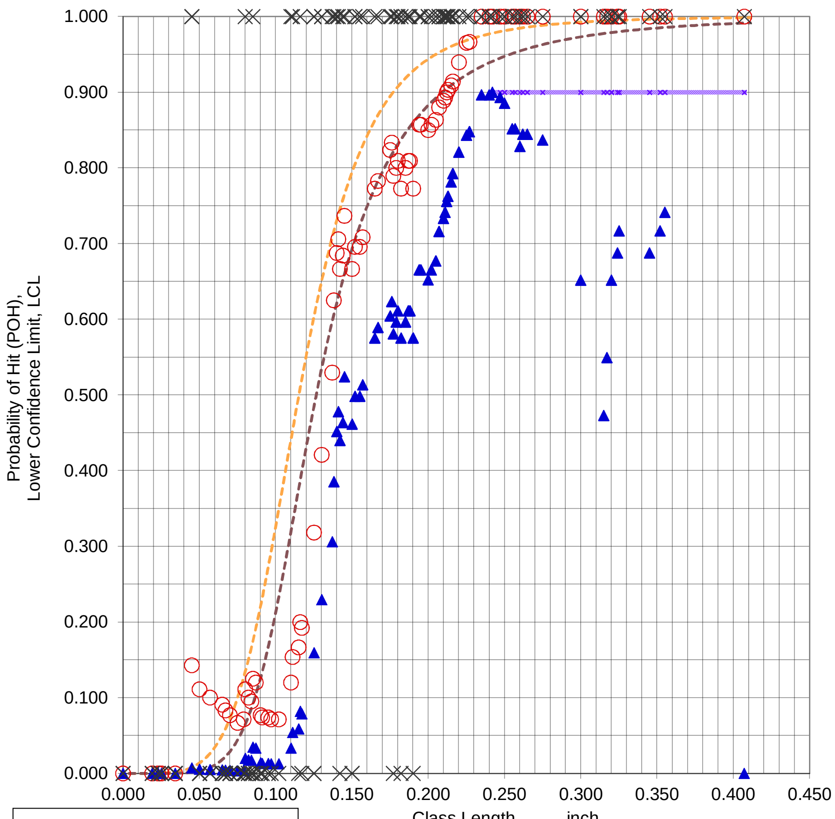
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

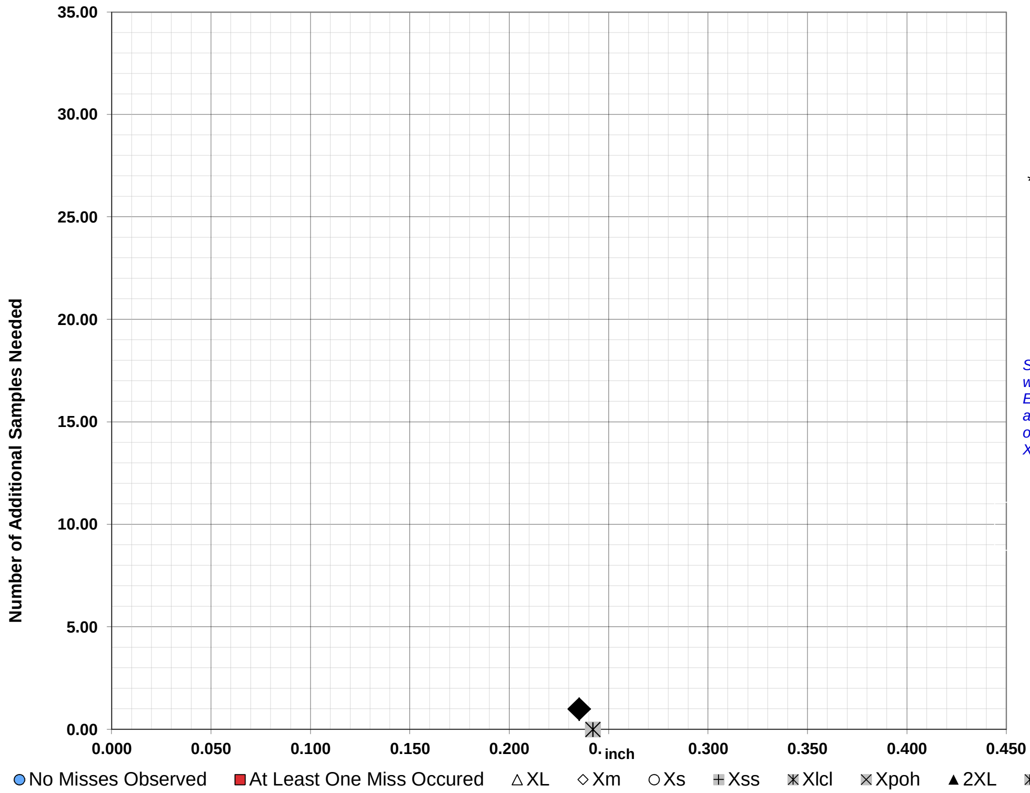


TABLE C

	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*

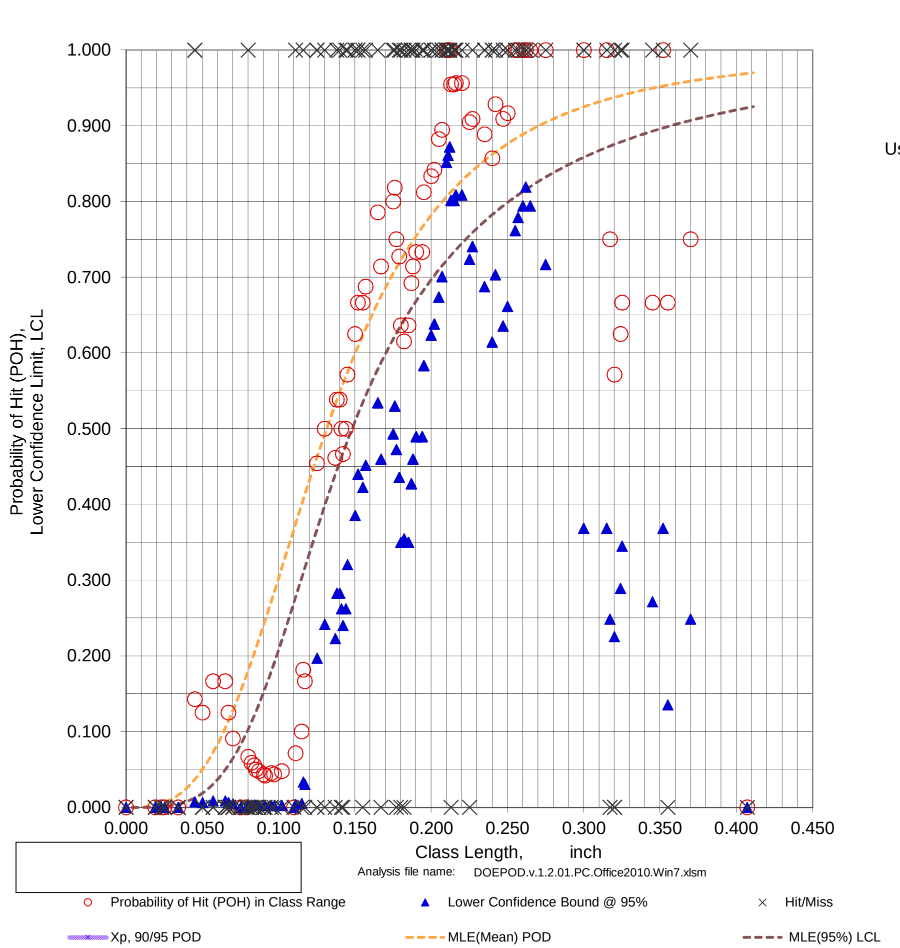
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

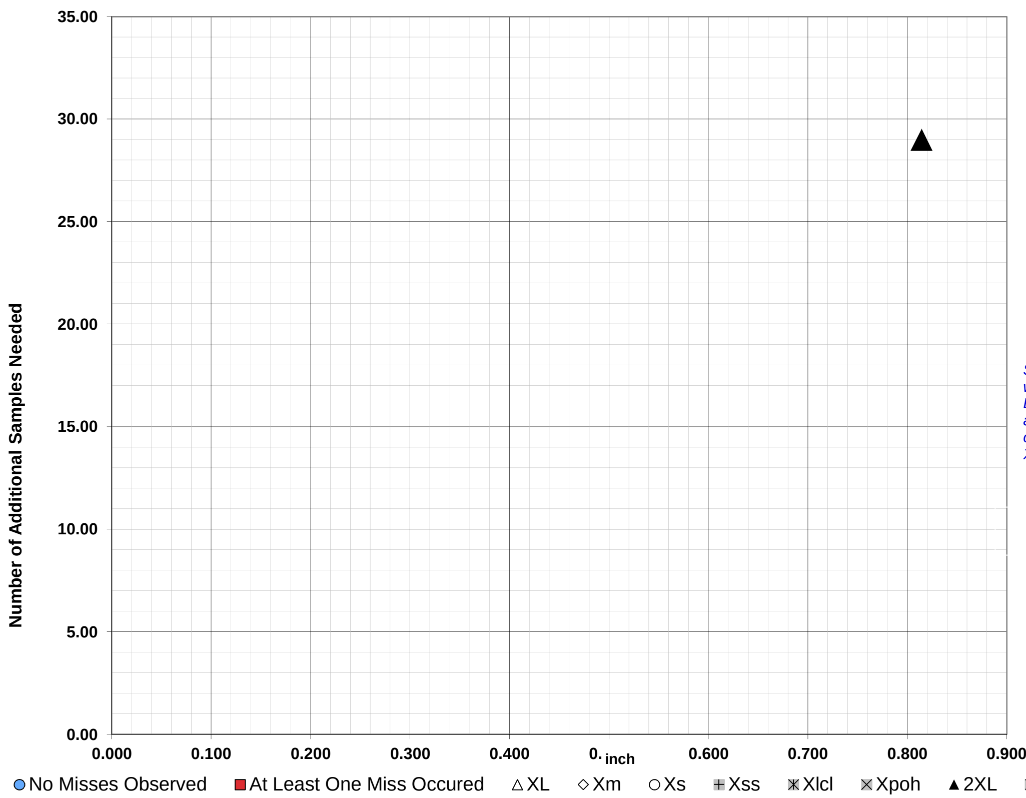


TABLE C

	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*

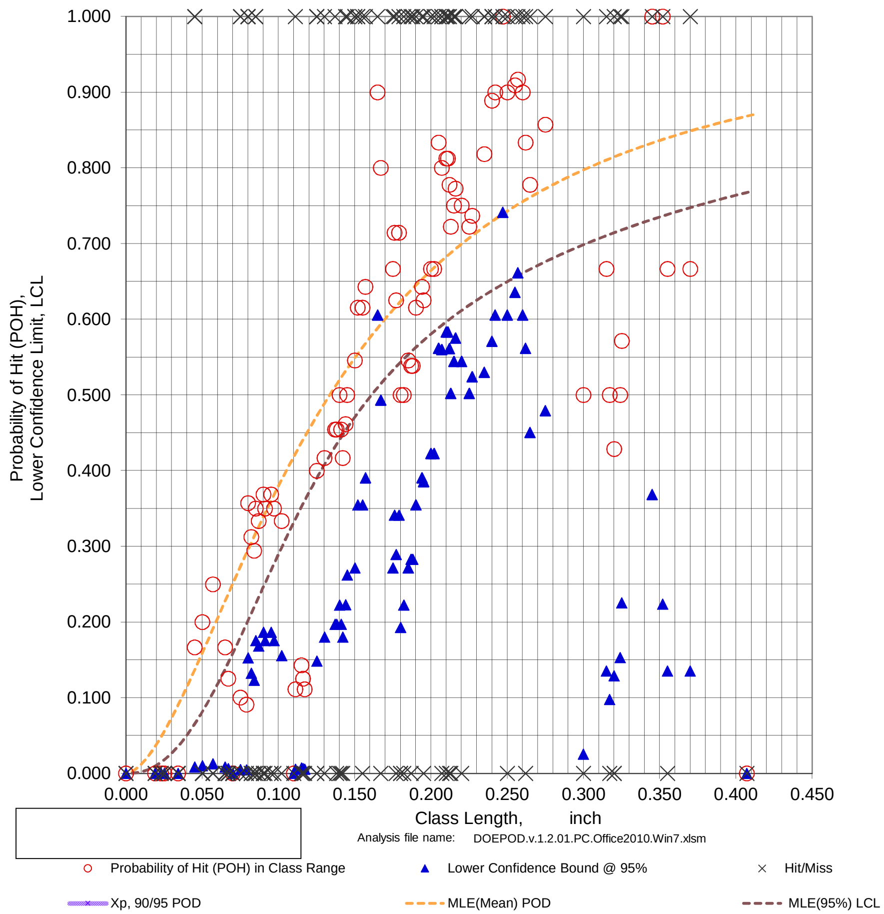
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

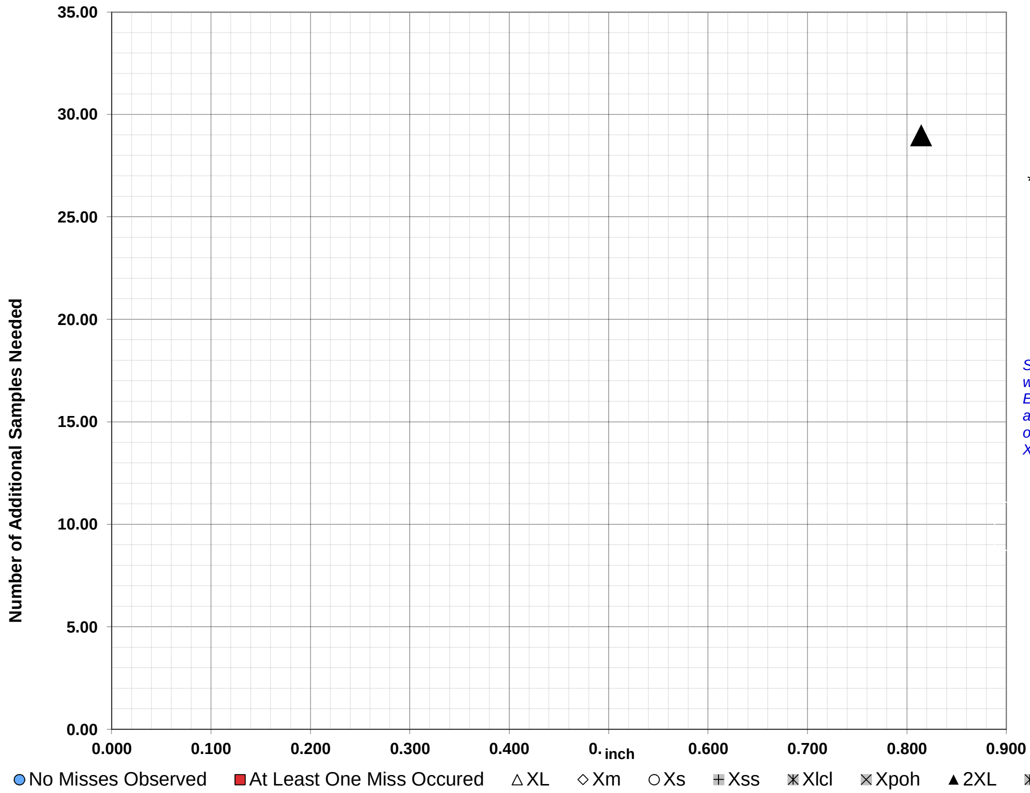


TABLE C

	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*

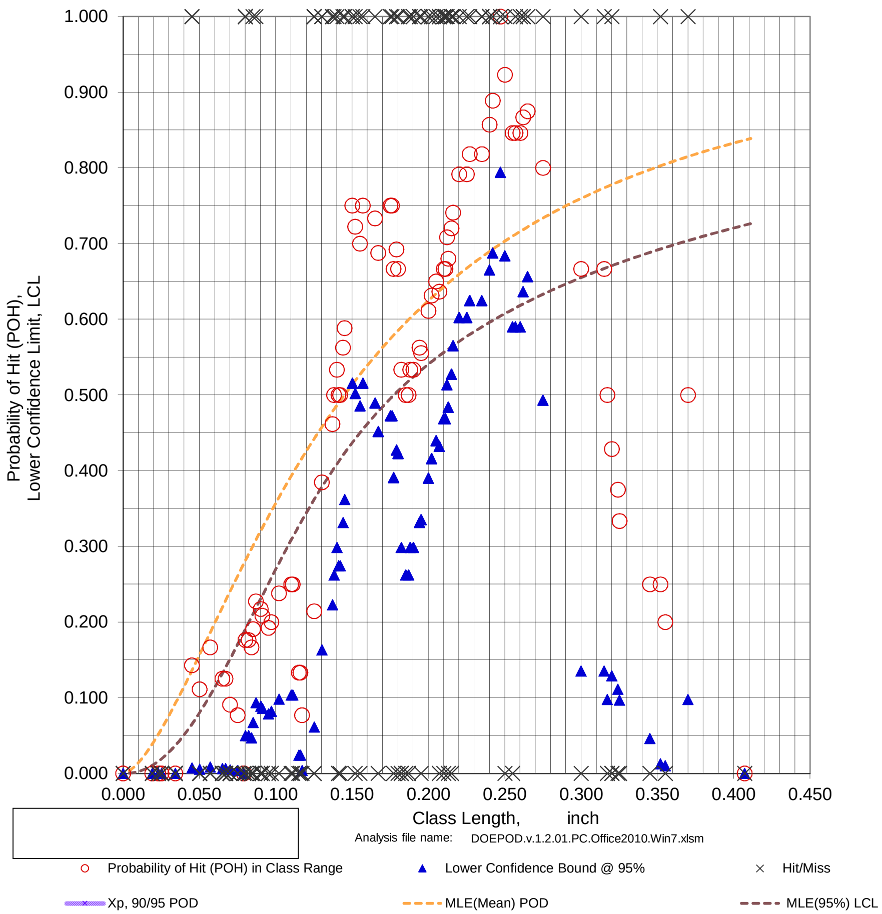
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

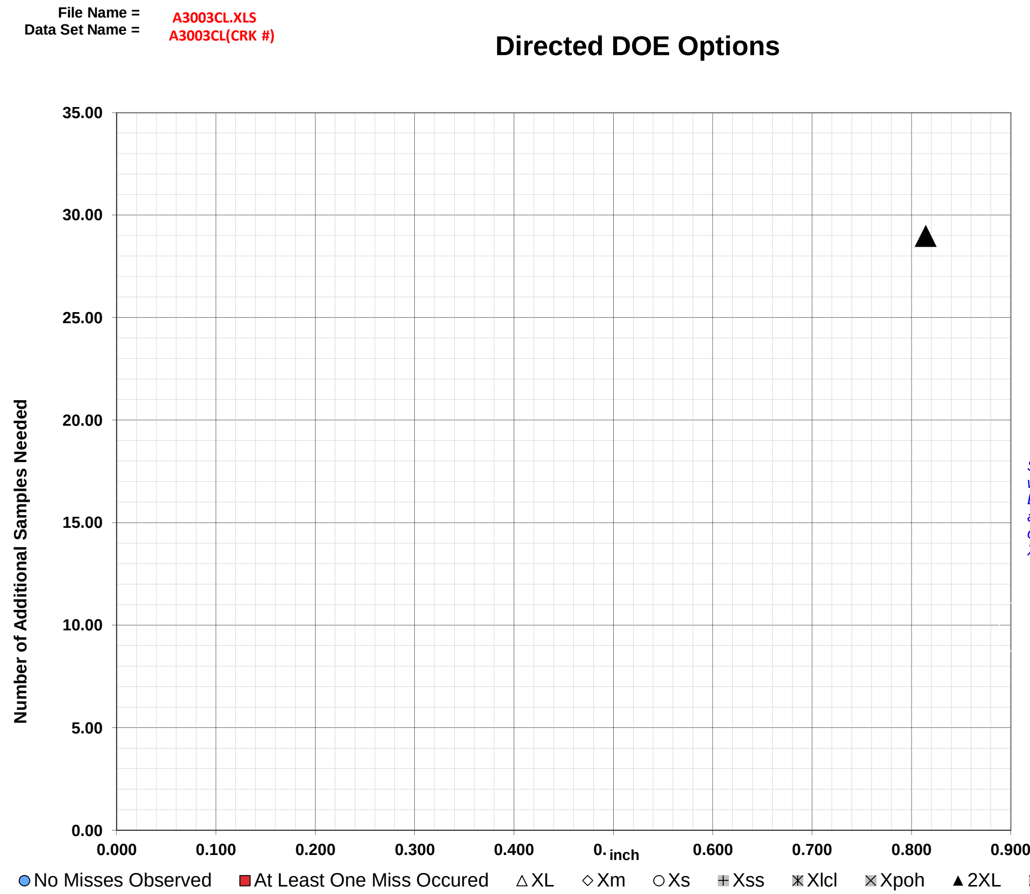


TABLE C

	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*

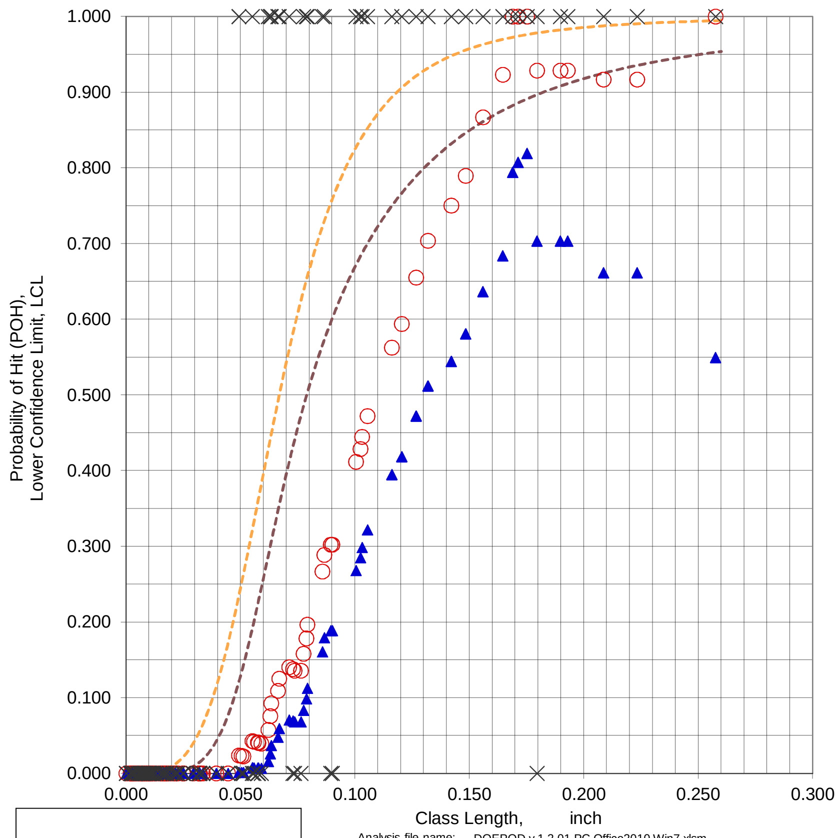
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

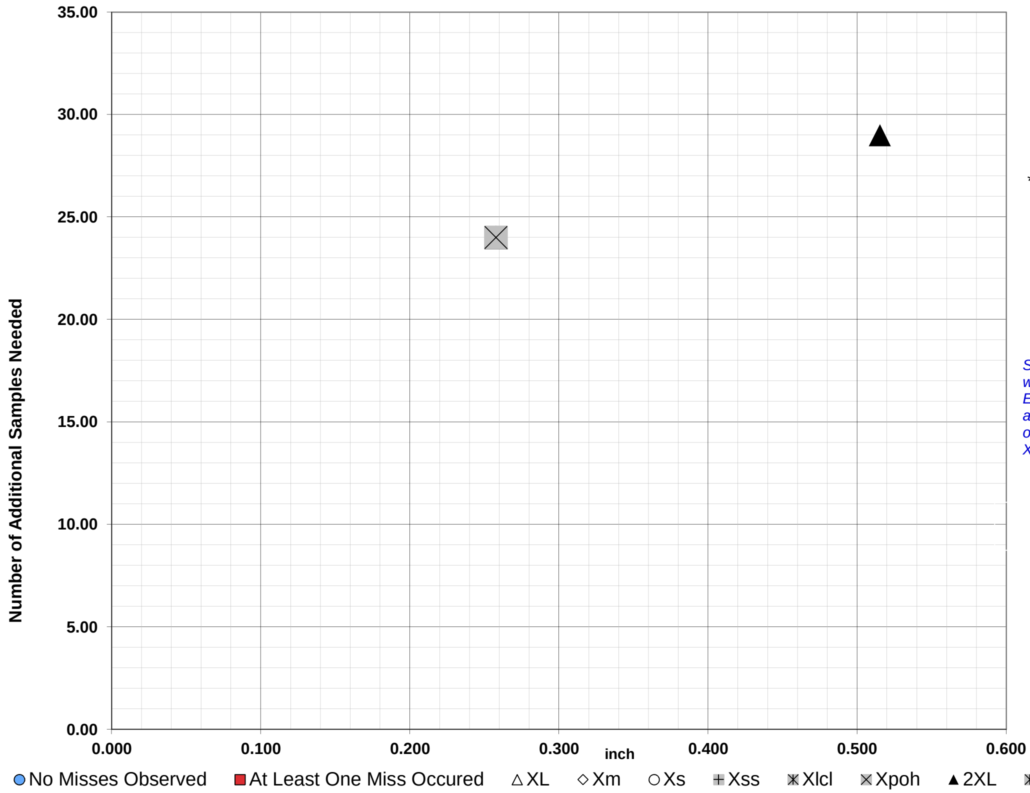


TABLE C

	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

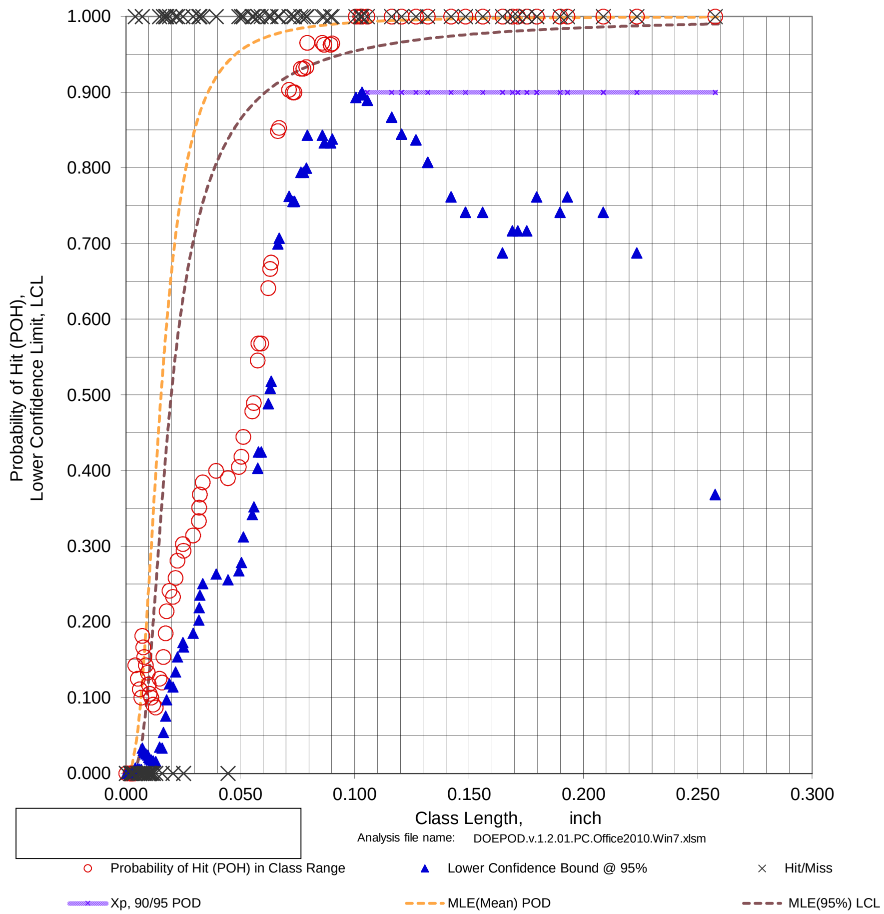
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

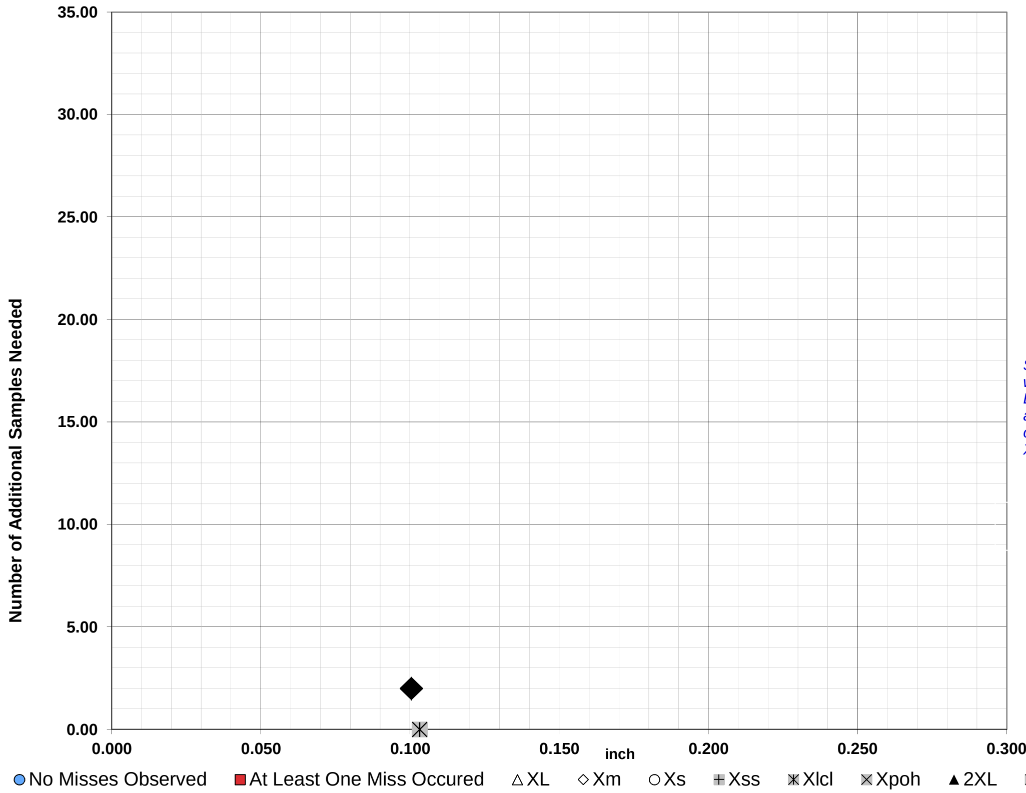


TABLE C

	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*

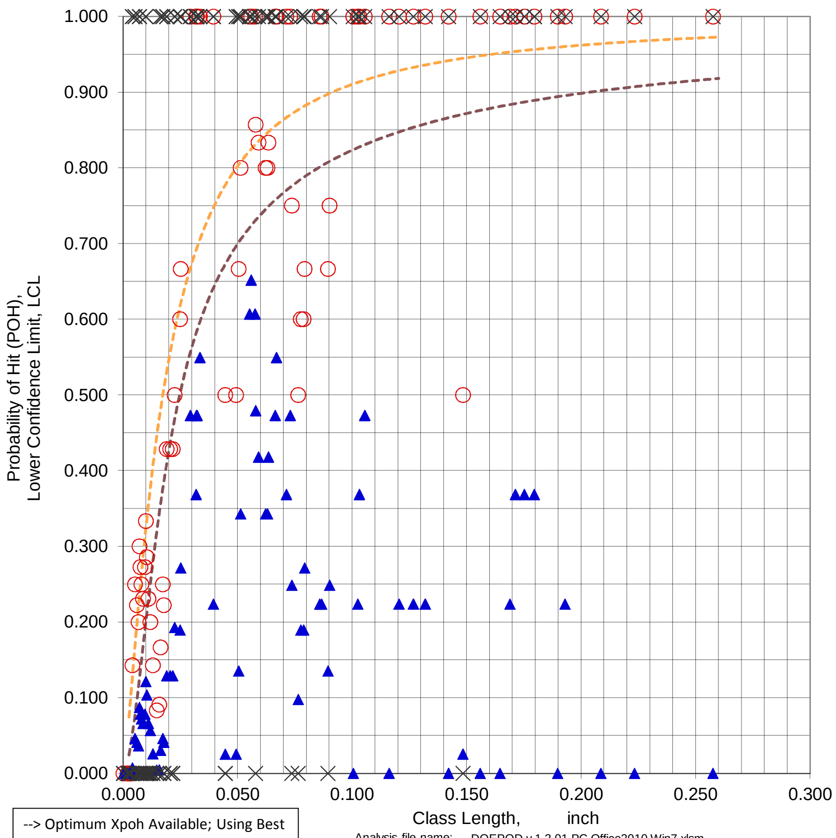
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



--> 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 = 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

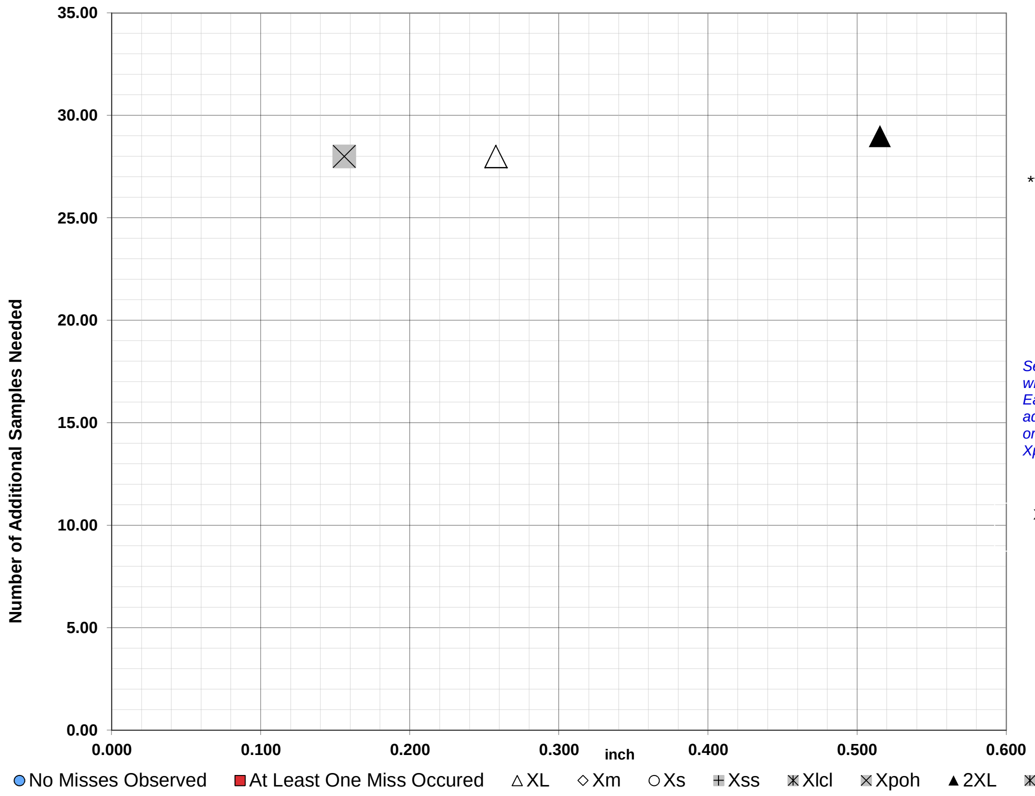


TABLE C

	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*

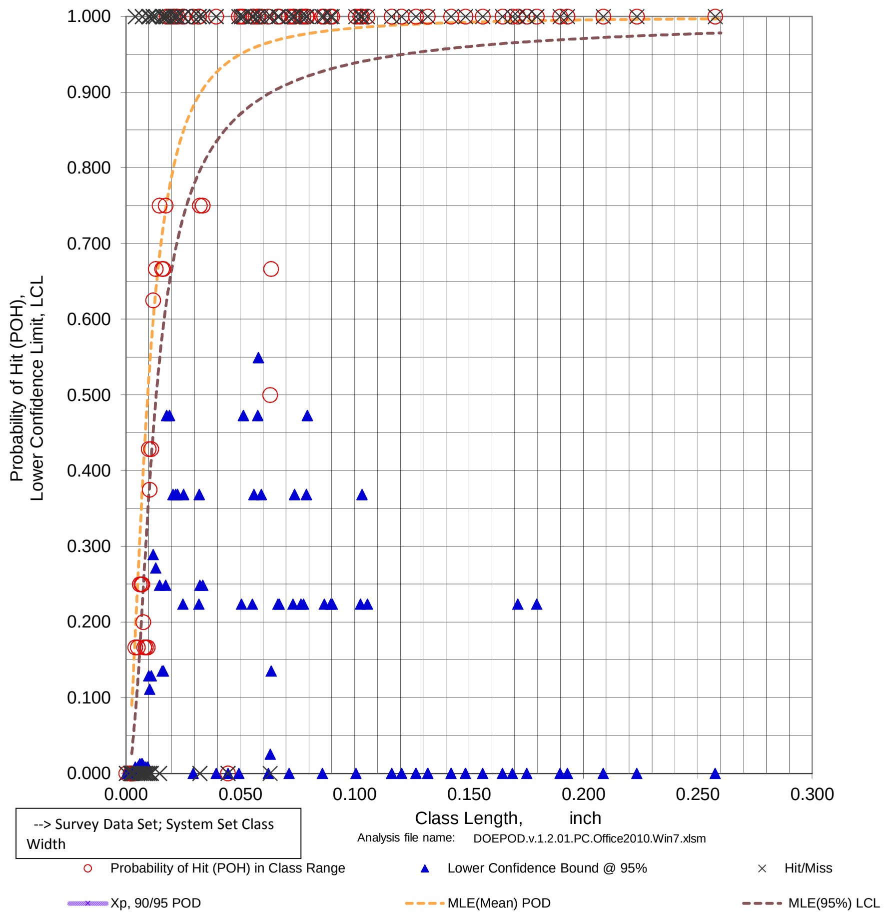
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



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

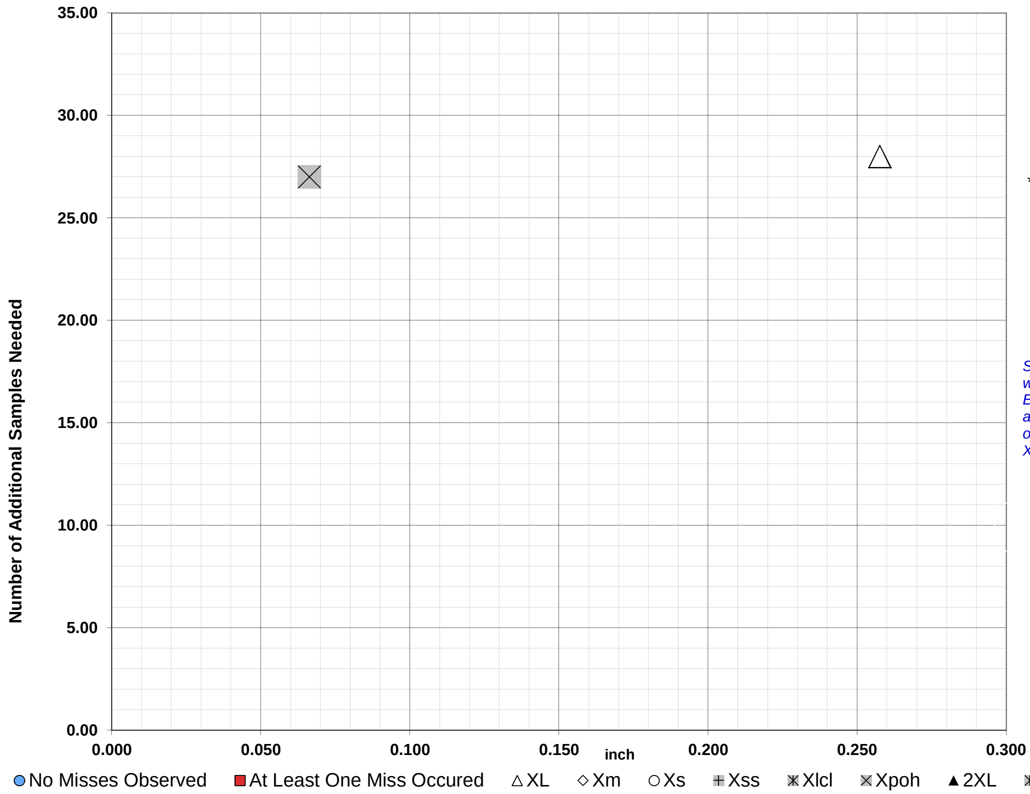


TABLE C

	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

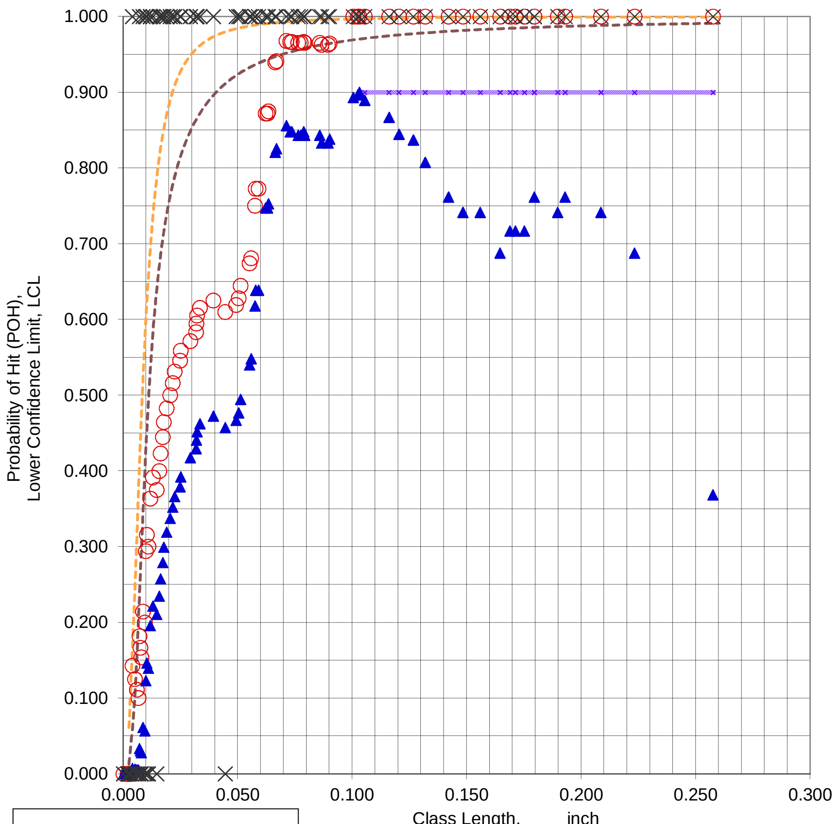
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

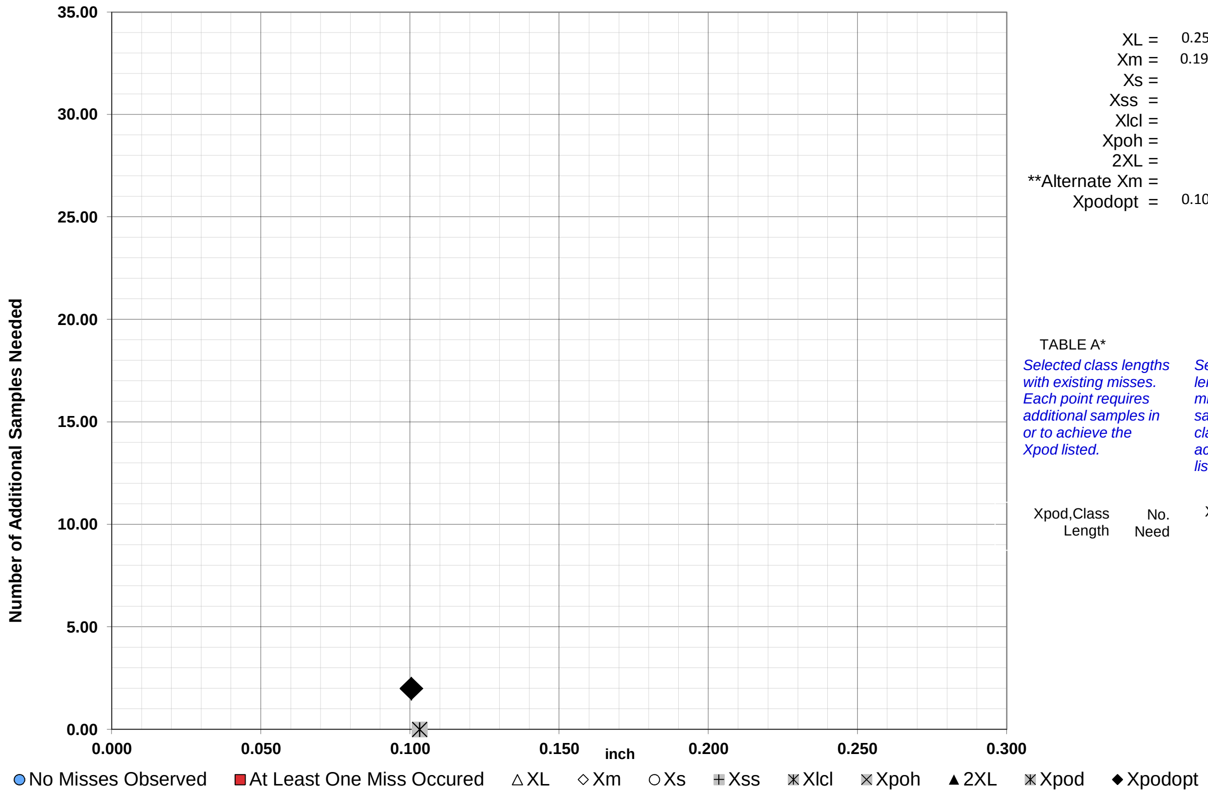


TABLE C

	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*

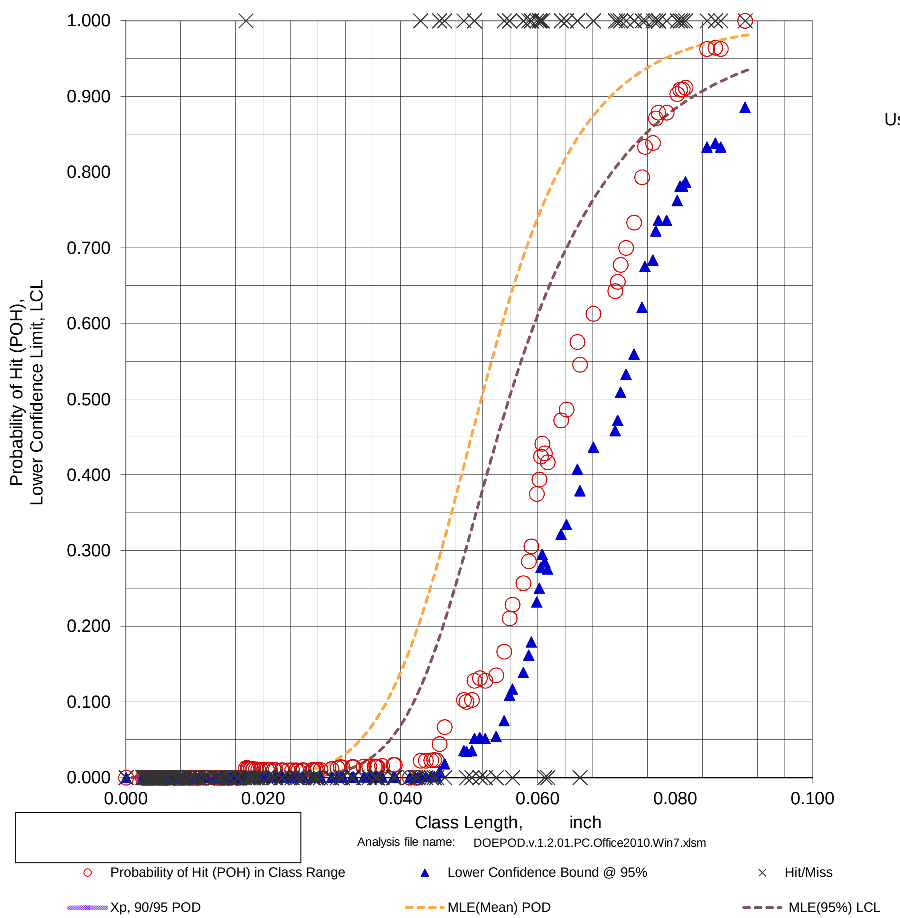
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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

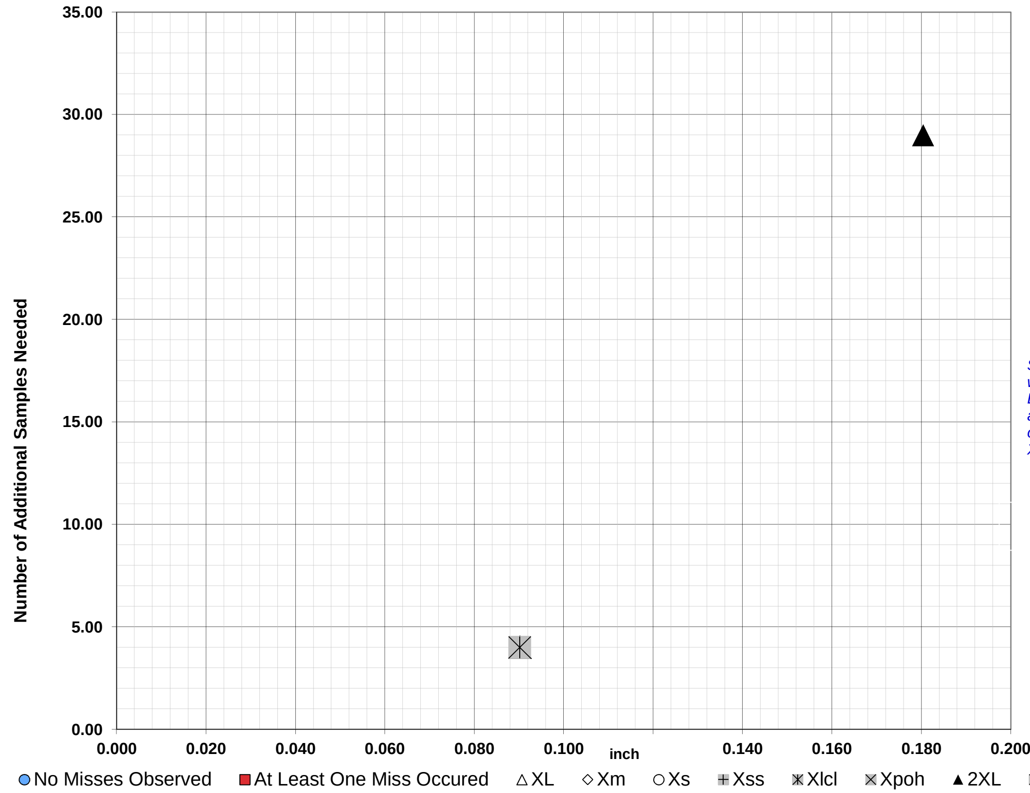


TABLE C

	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*

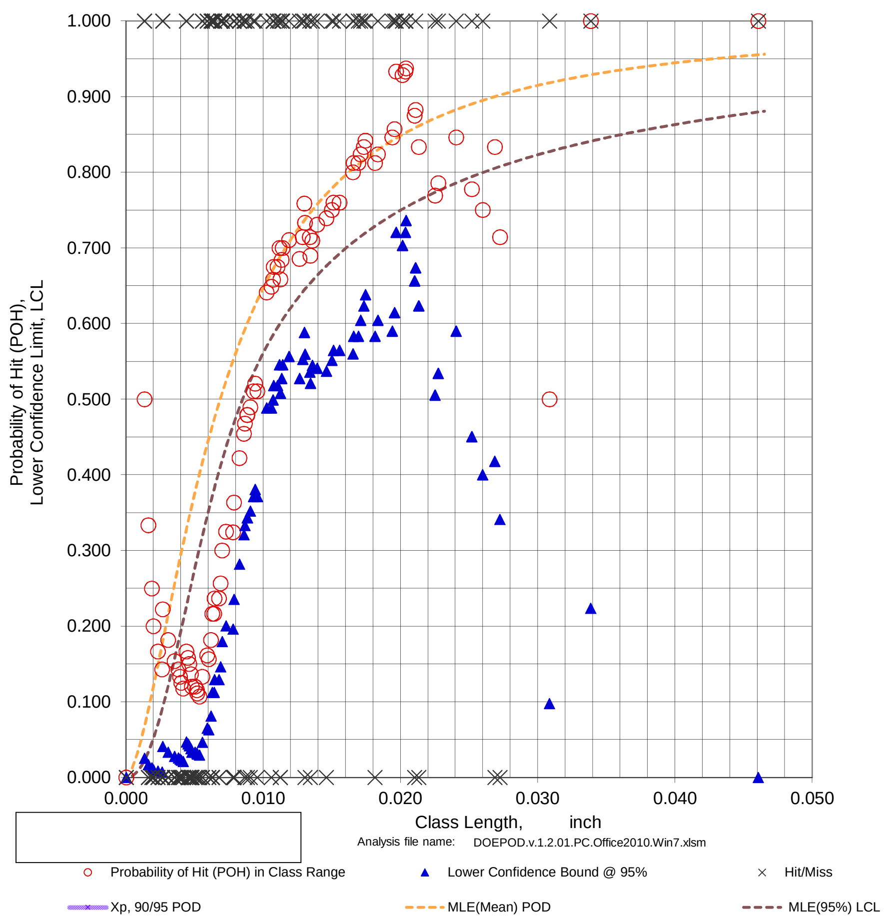
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

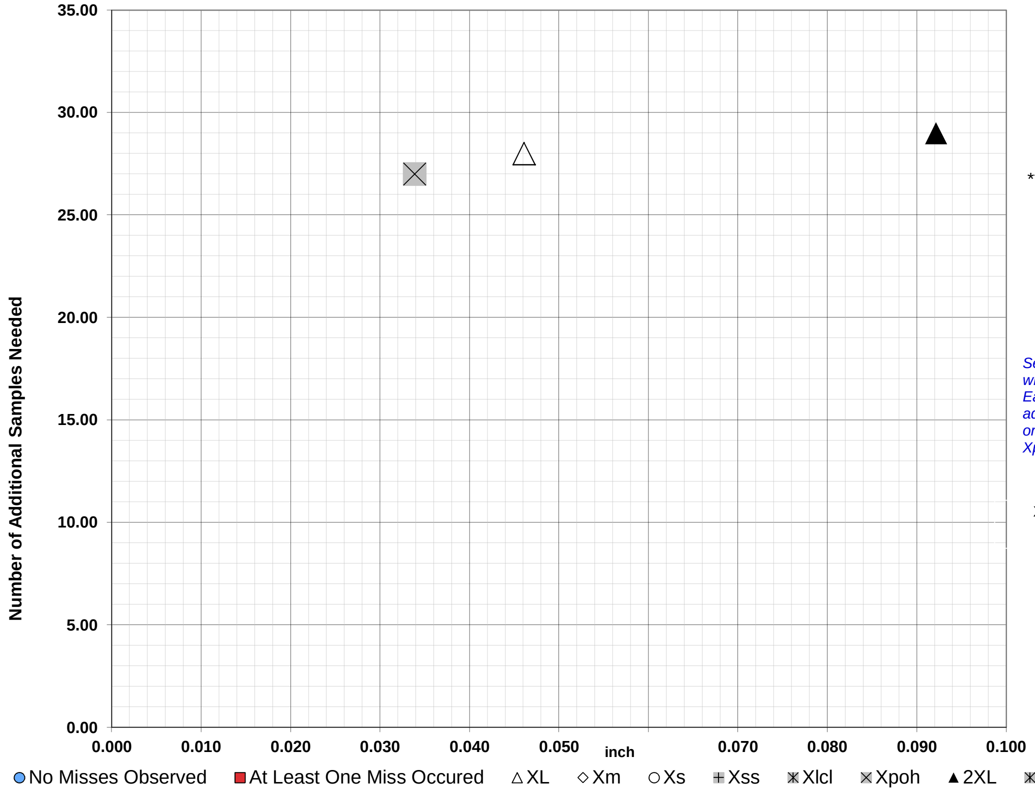


TABLE C

	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

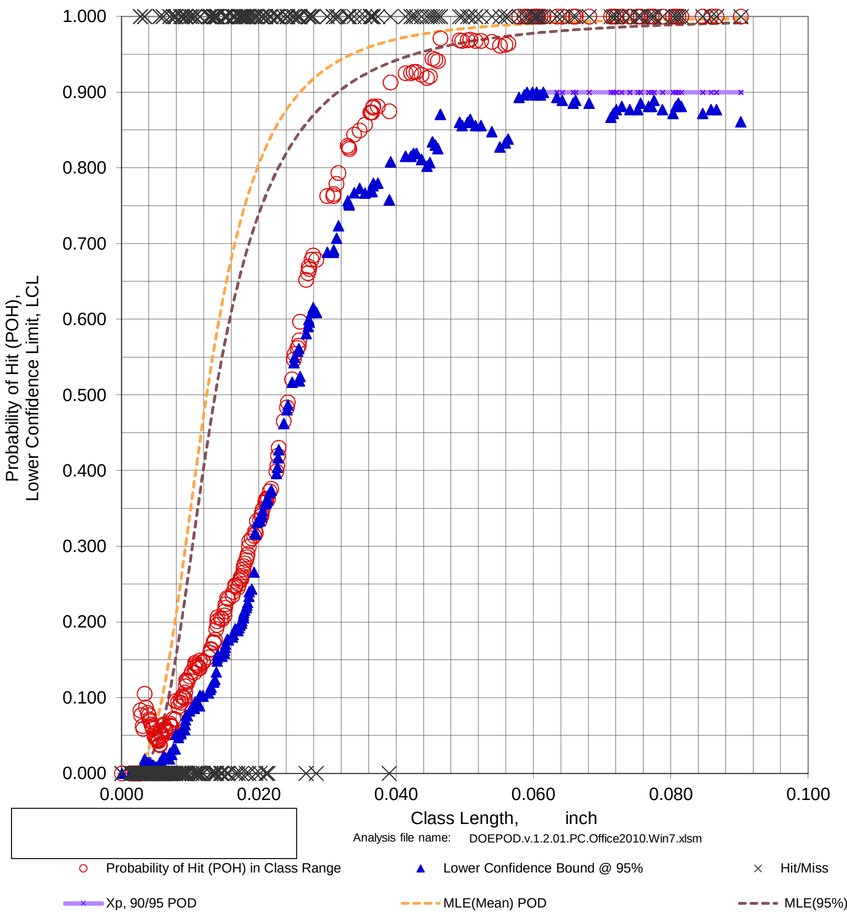
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

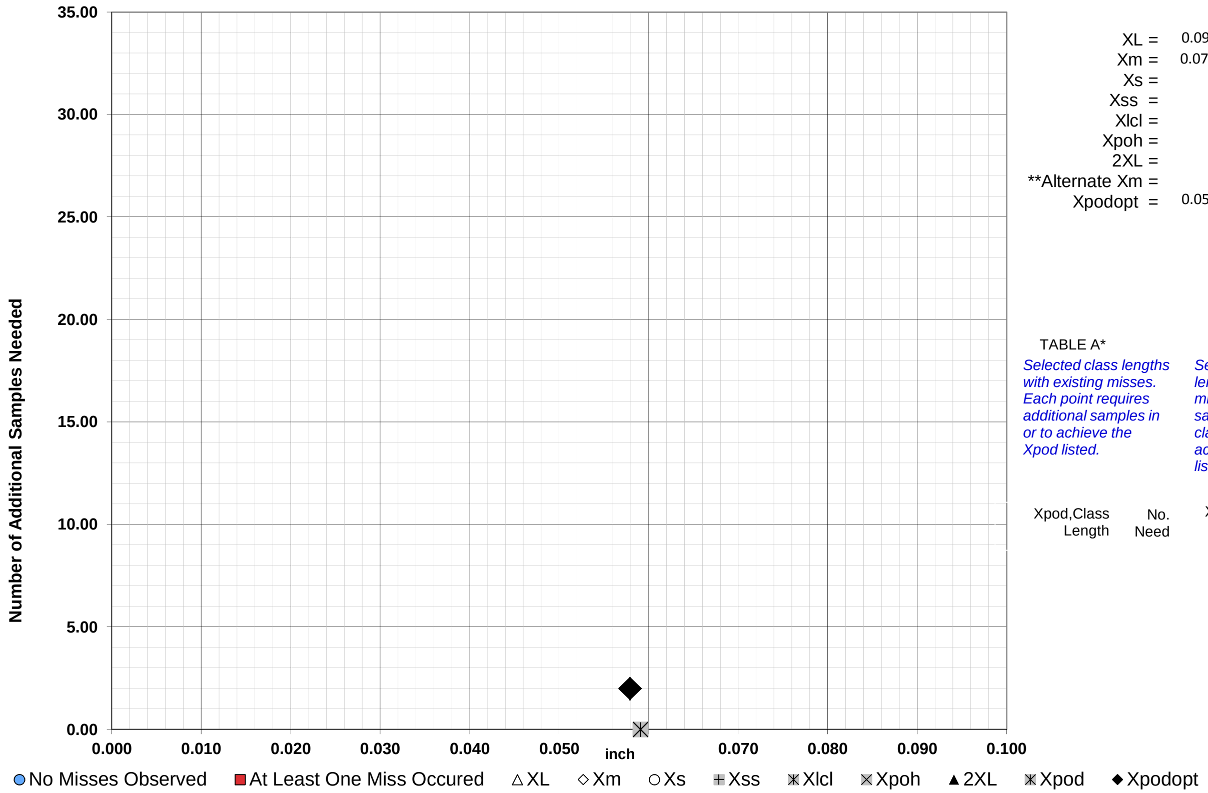


TABLE C

	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.

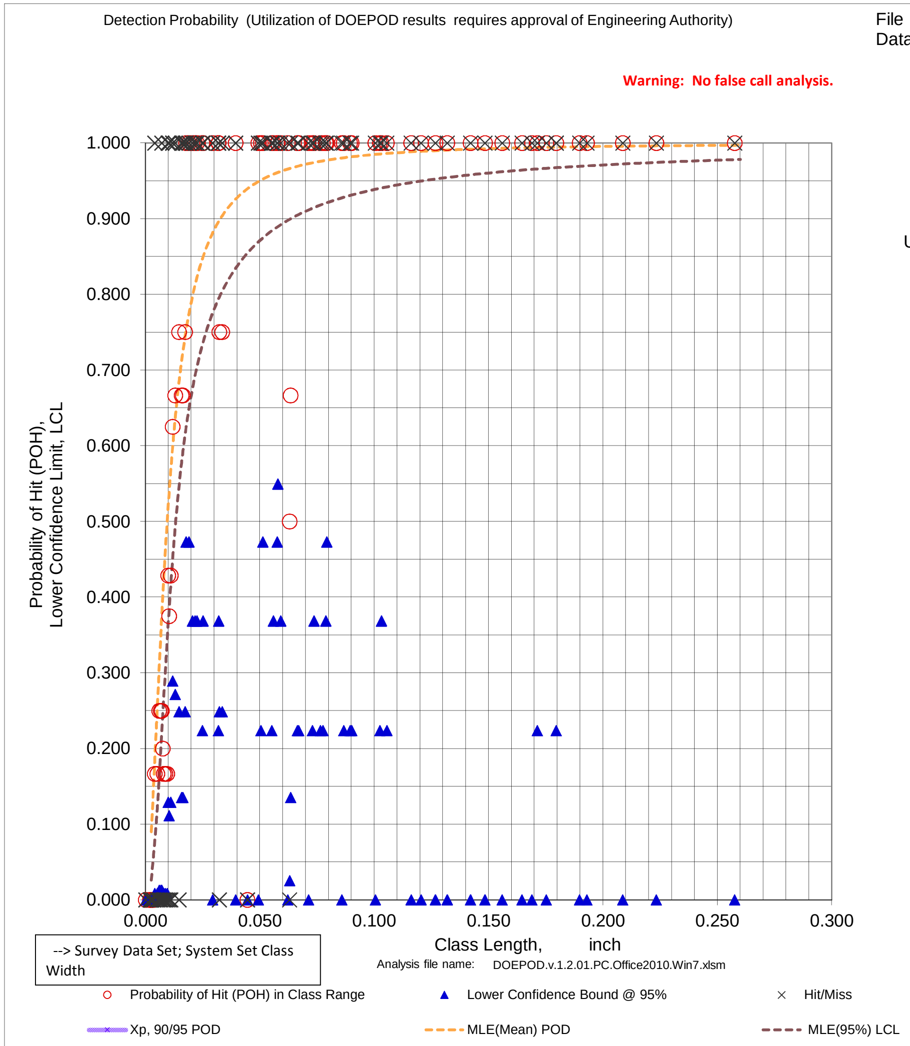
Xpod,Class Length	No. Need

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 #)

Directed DOE Options

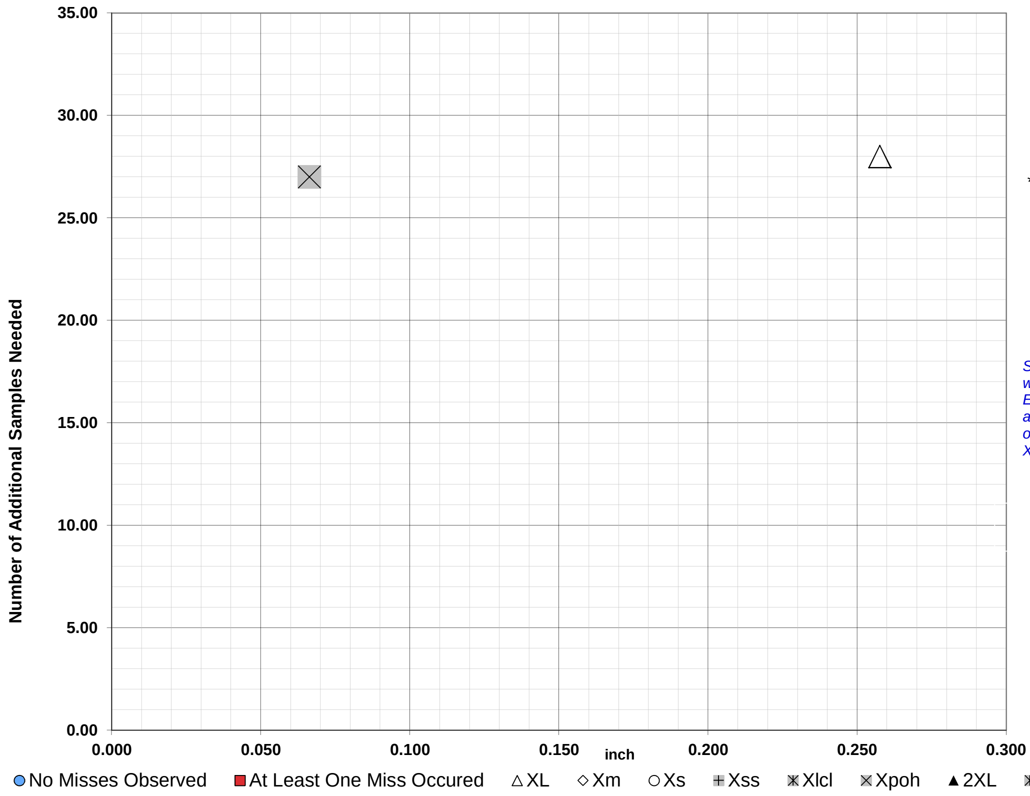


TABLE C

	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

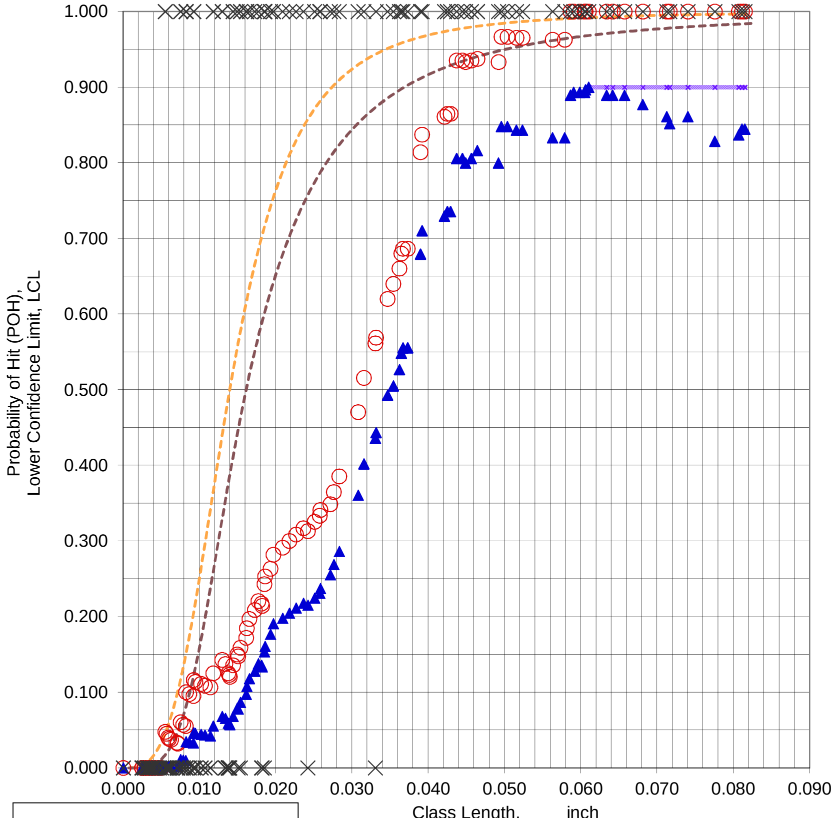
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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 0.18306.

Note: Xpodopt is within one class width of Xpod.

Warning: No false call analysis.



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 =	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

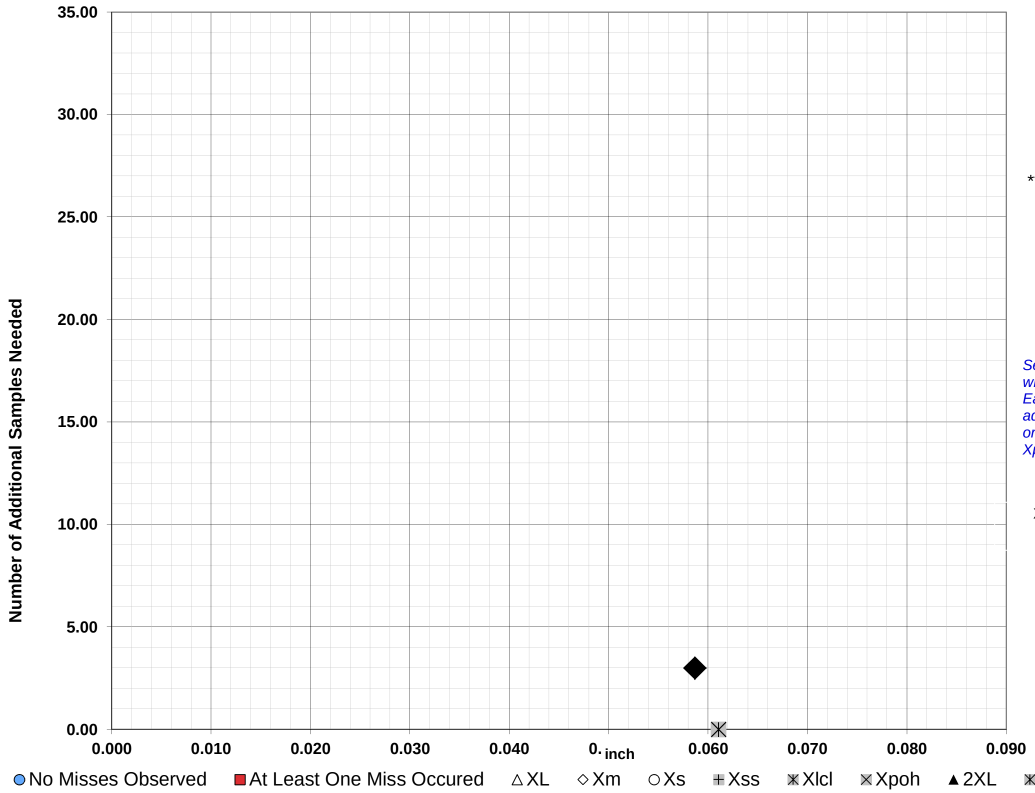


TABLE C

	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

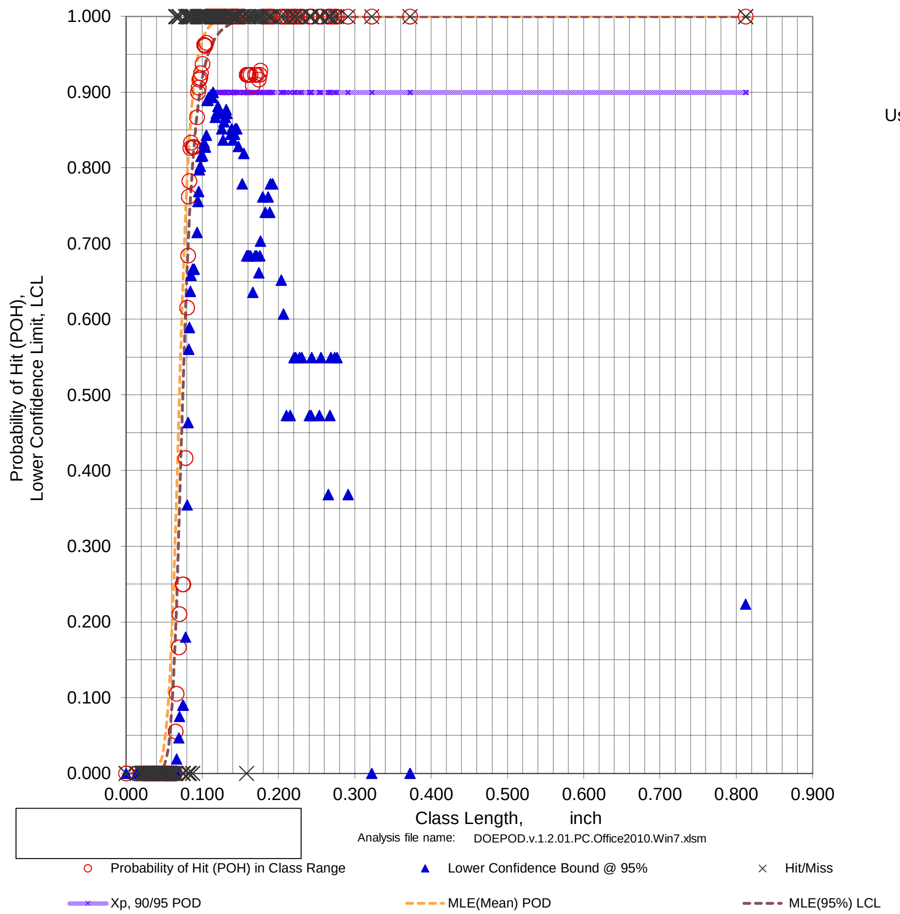
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

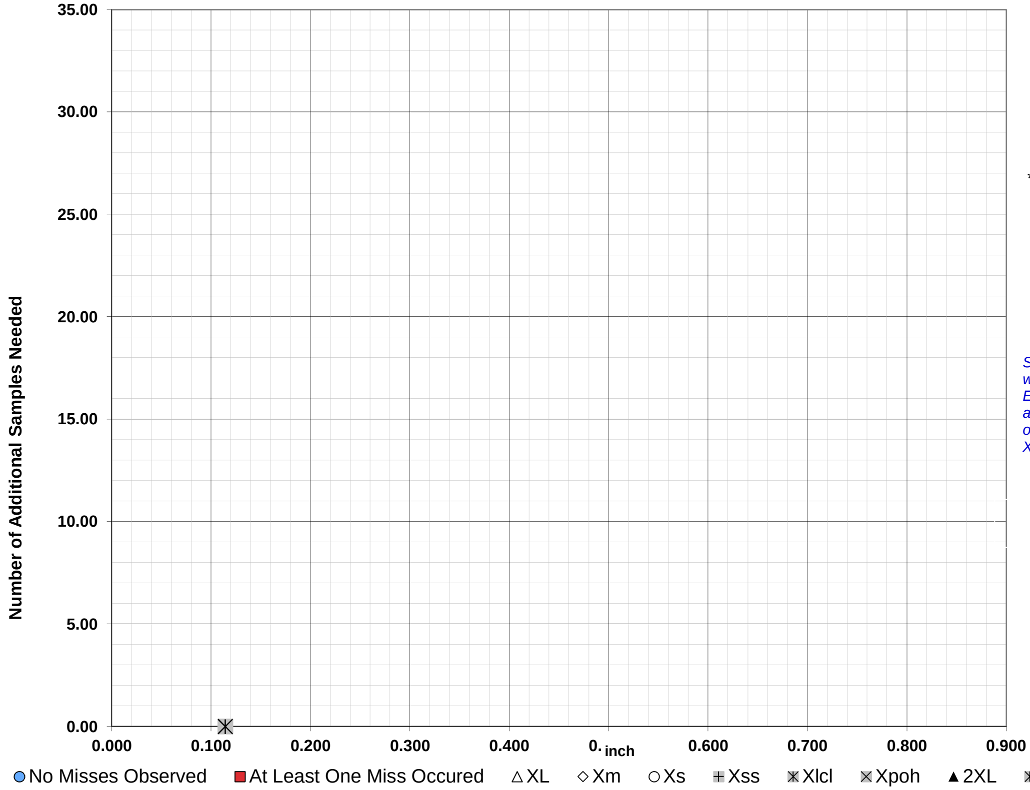


TABLE C

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

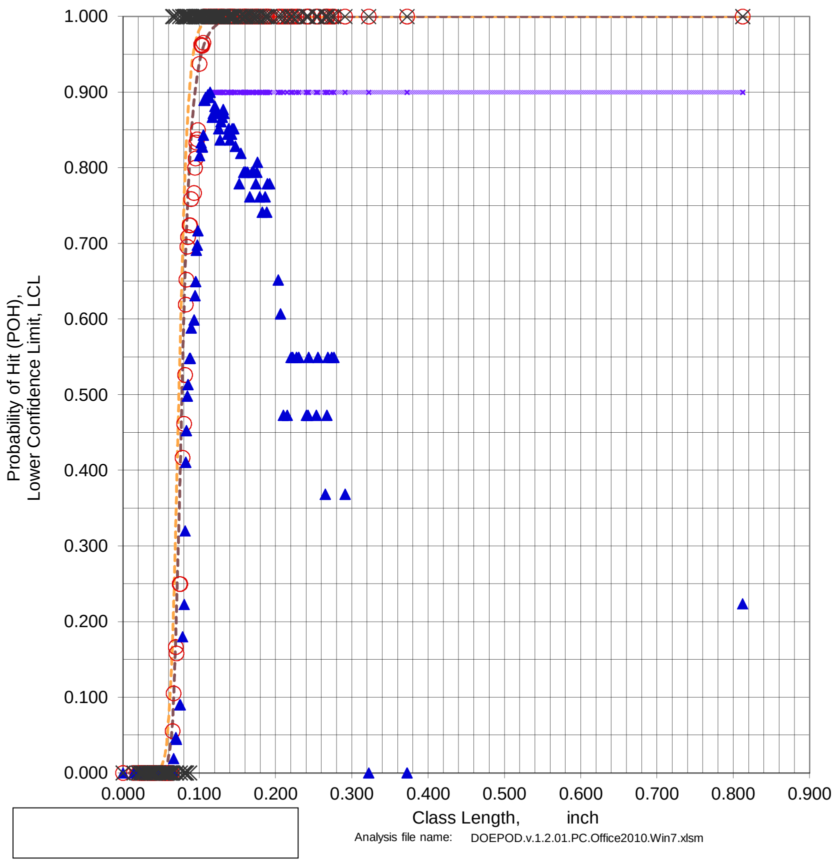
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

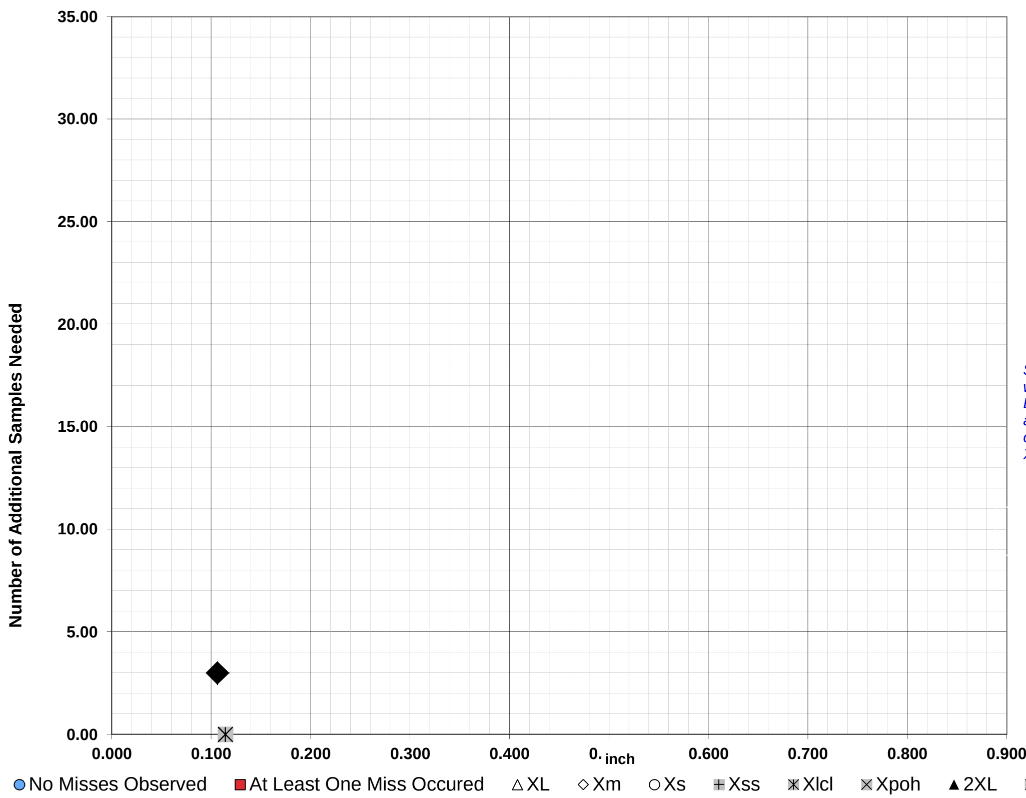


TABLE C

	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

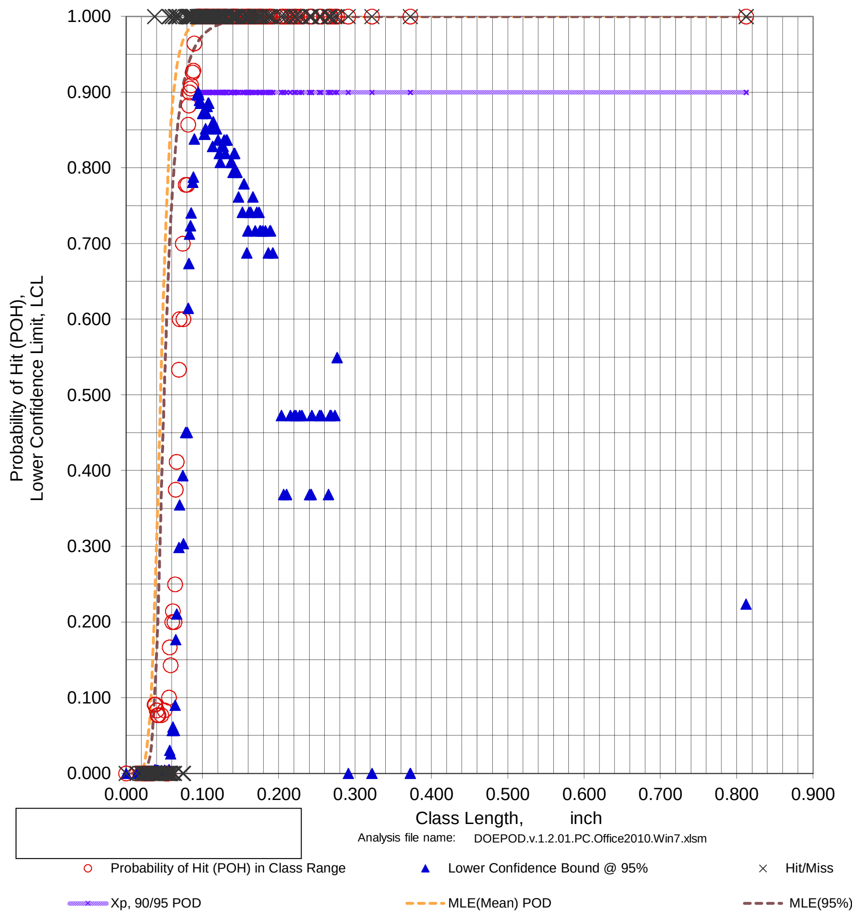
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 15 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

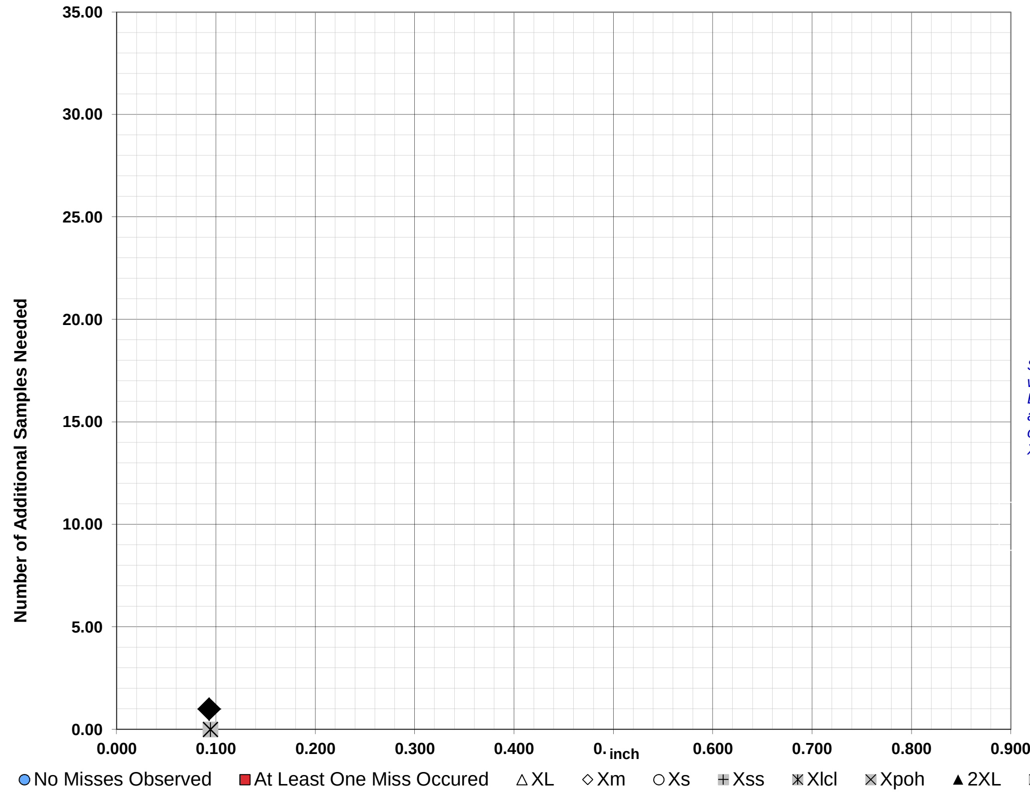


TABLE C

	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.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

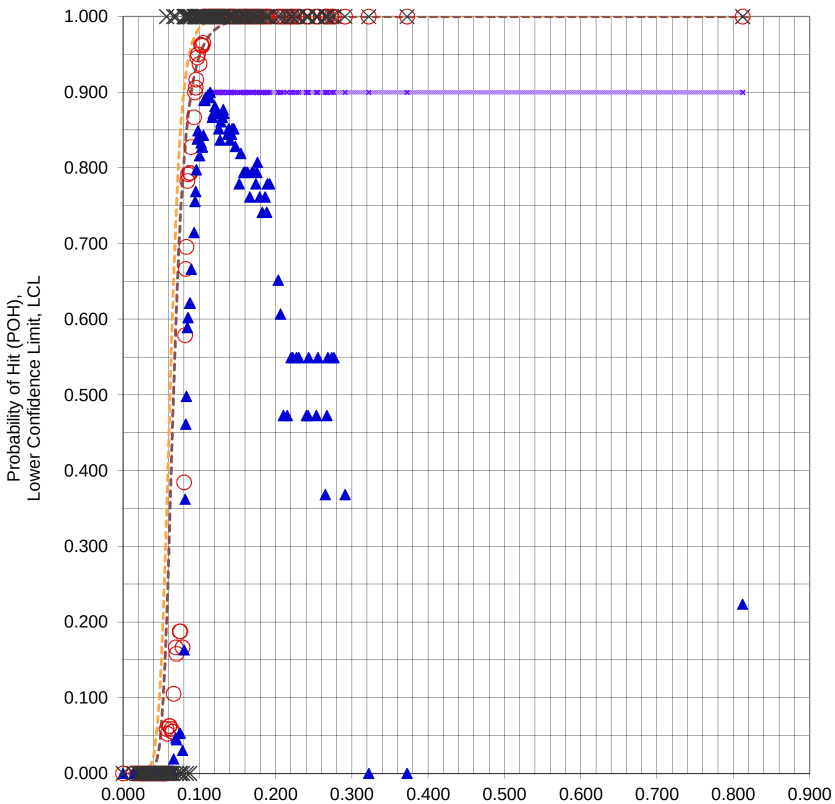
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

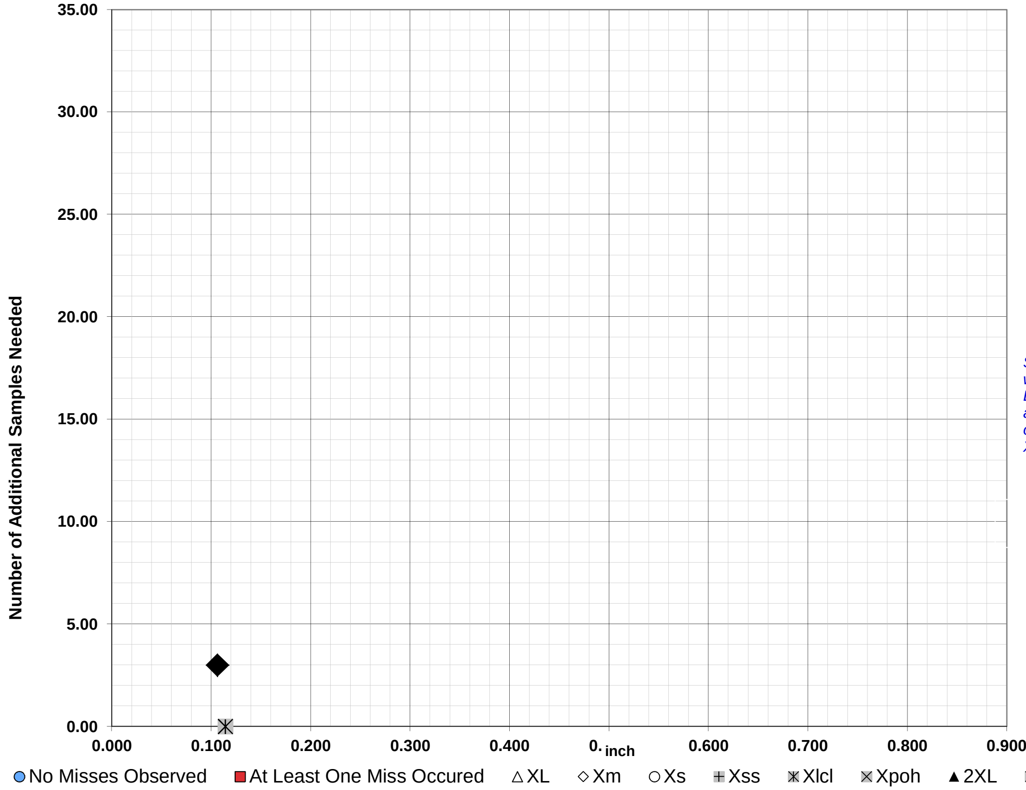


TABLE C

	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

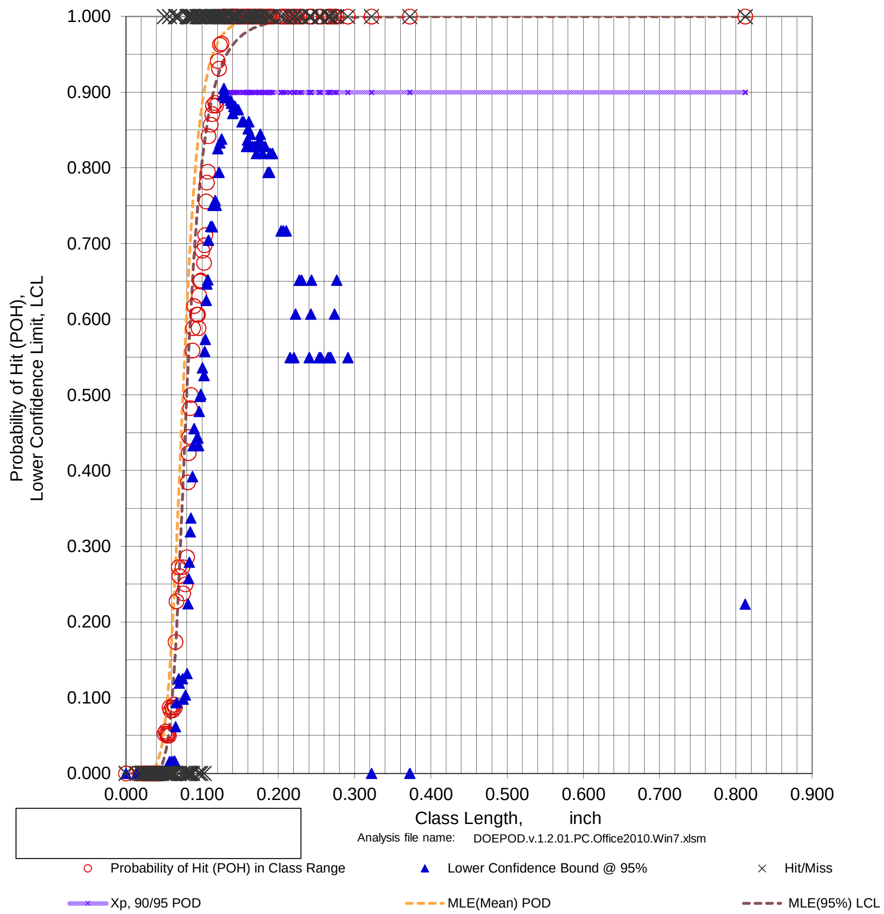
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.

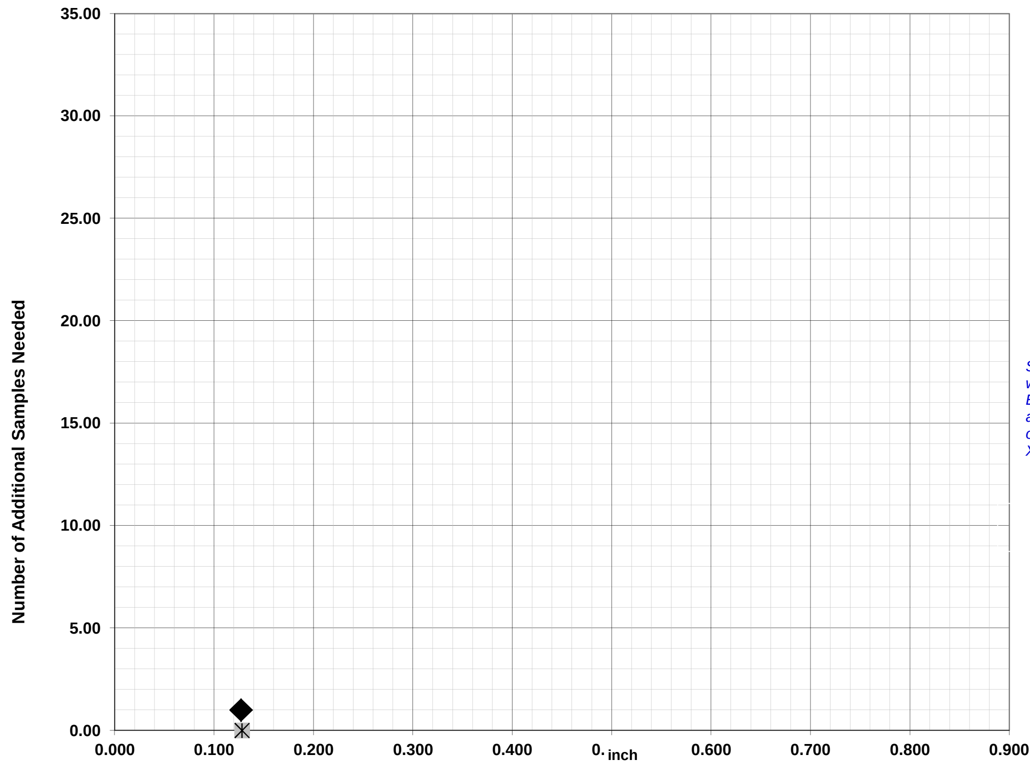
Survey/Optimum Xpoh = 0.1040 -0.001 inch 26 Samples

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



No Misses Observed | At Least One Miss Occured | XL | Xm | Xs | Xss | Xlcl | Xpoh | 2XL | Xpod | Xpodopt

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

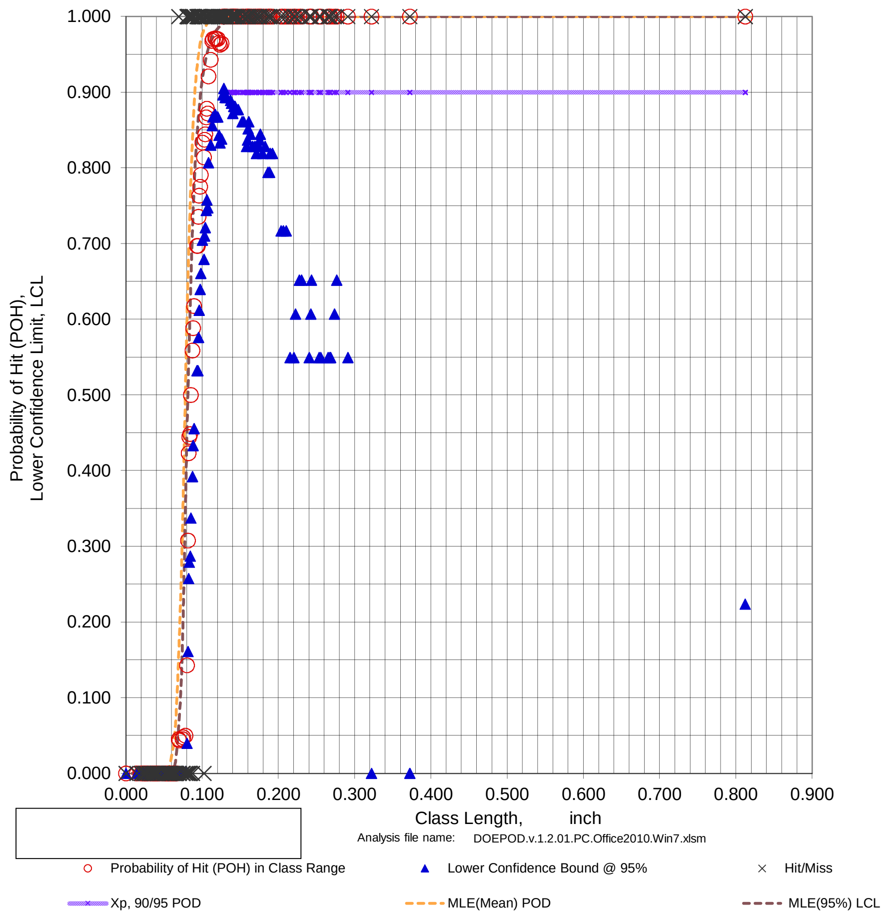
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

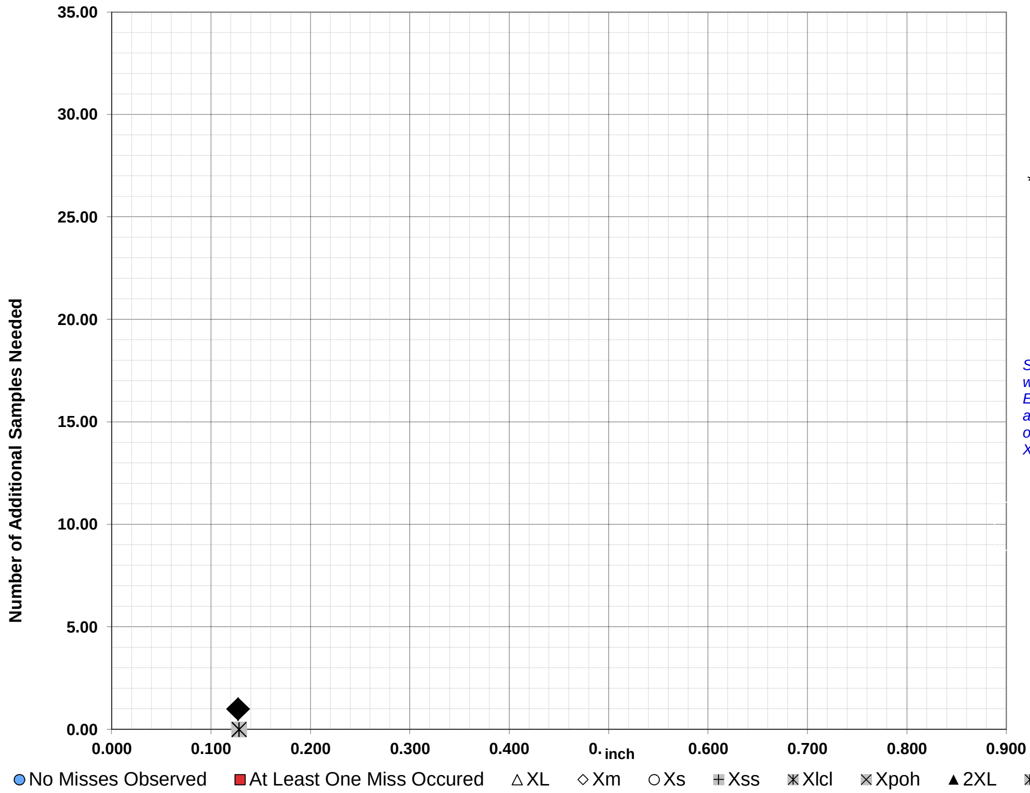


TABLE C

	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)

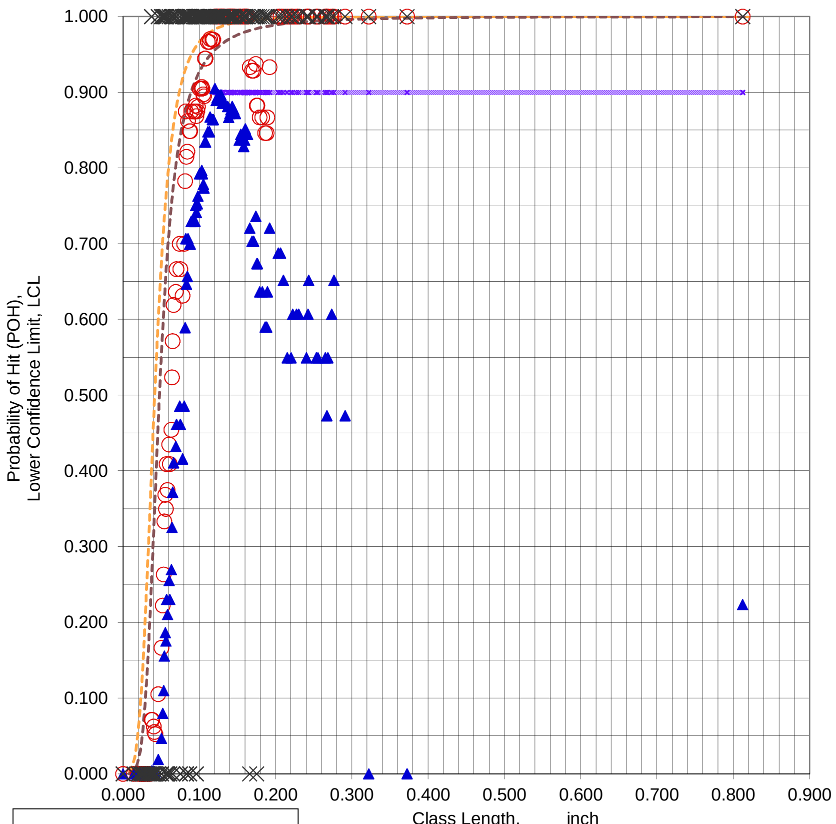
Large flaw validation failure. Need 16 more large flaws.

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	



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

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

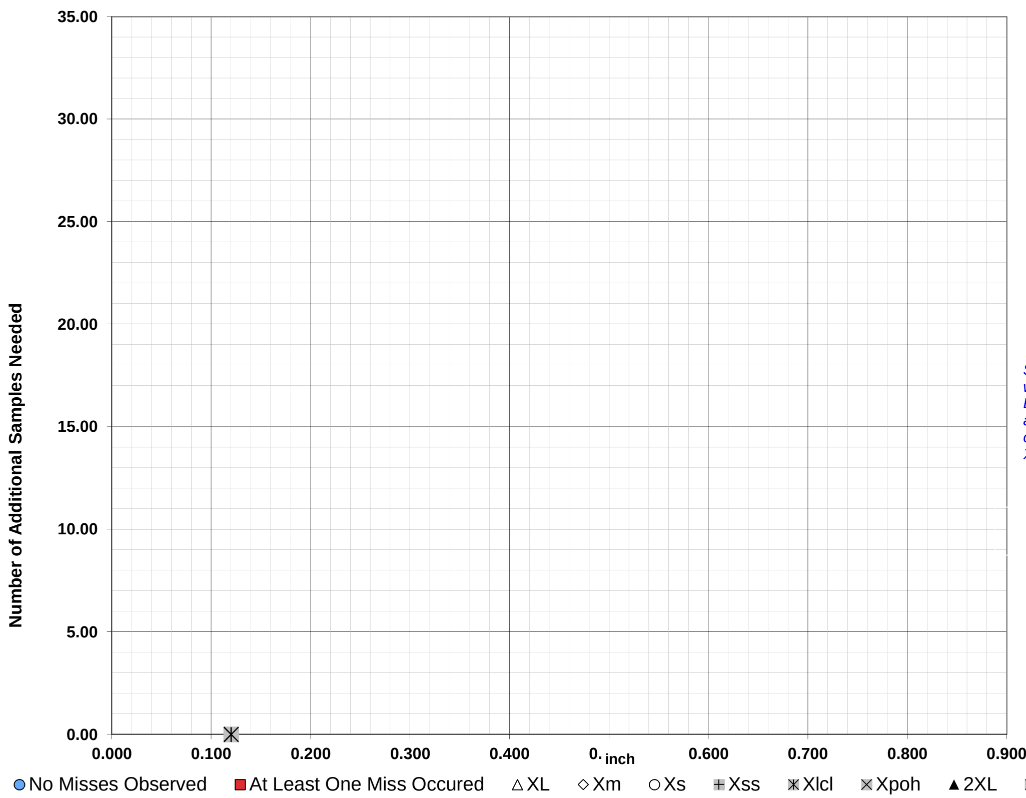


TABLE C

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*

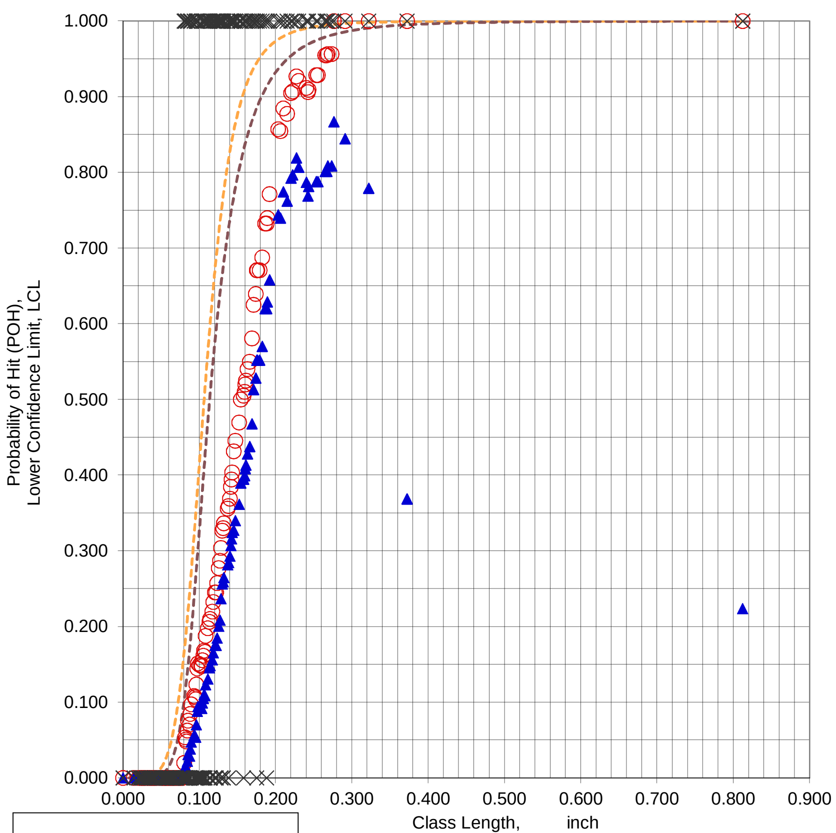
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

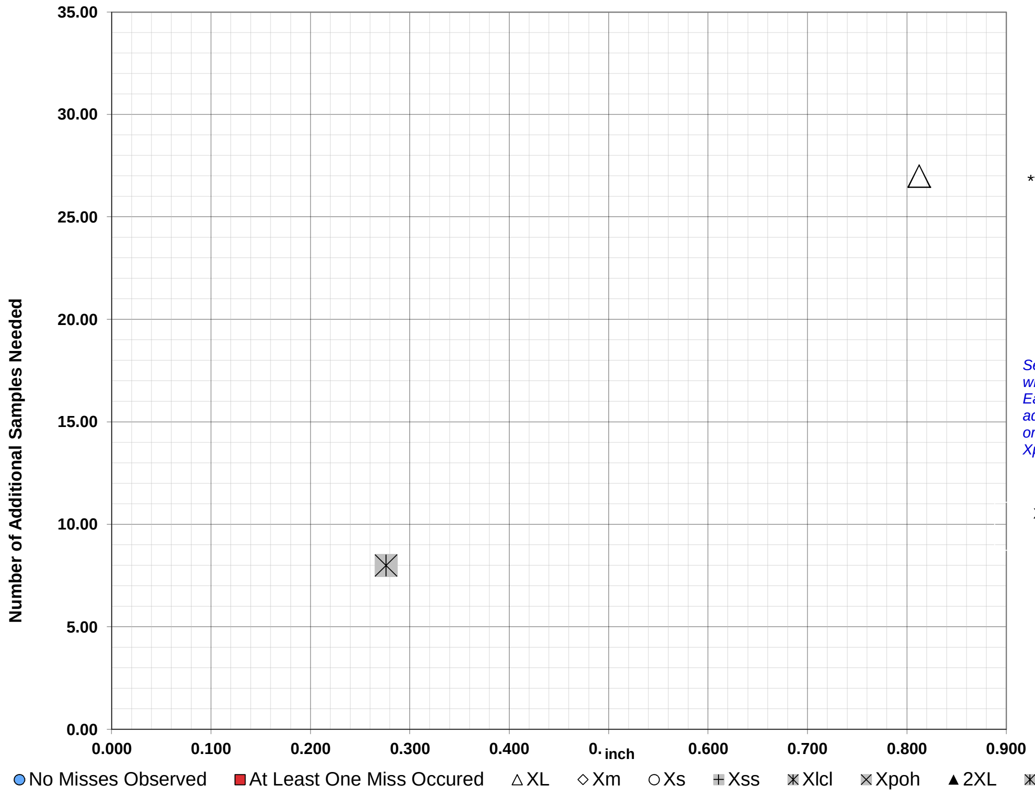


TABLE C

	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*

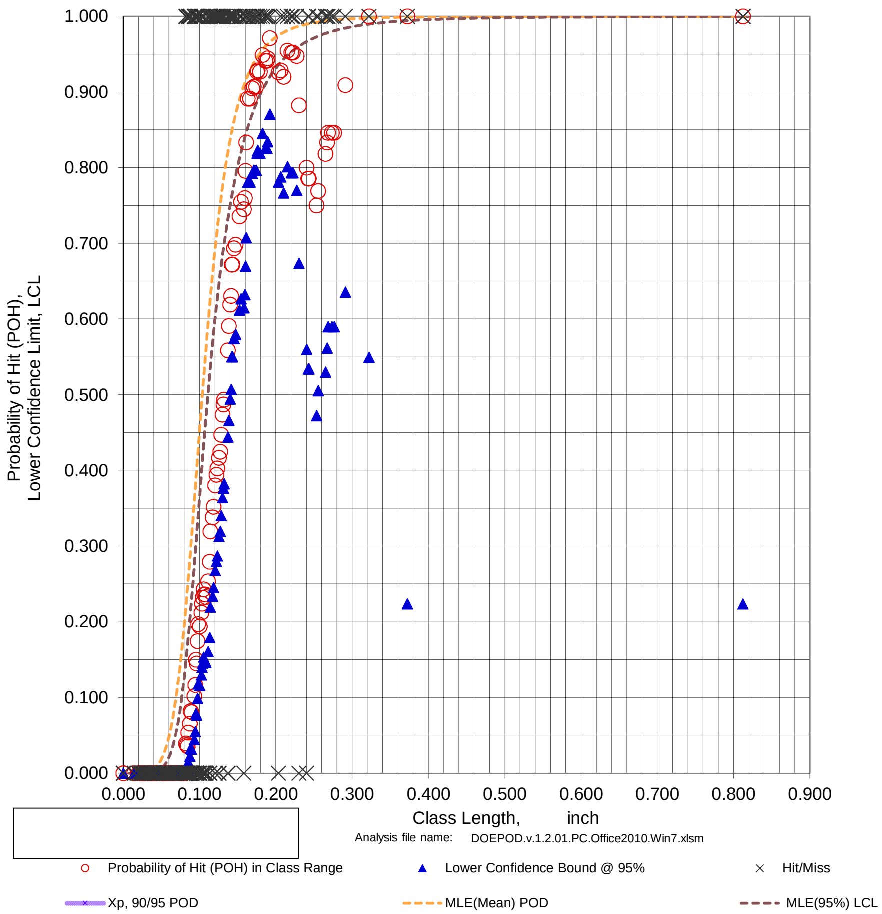
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

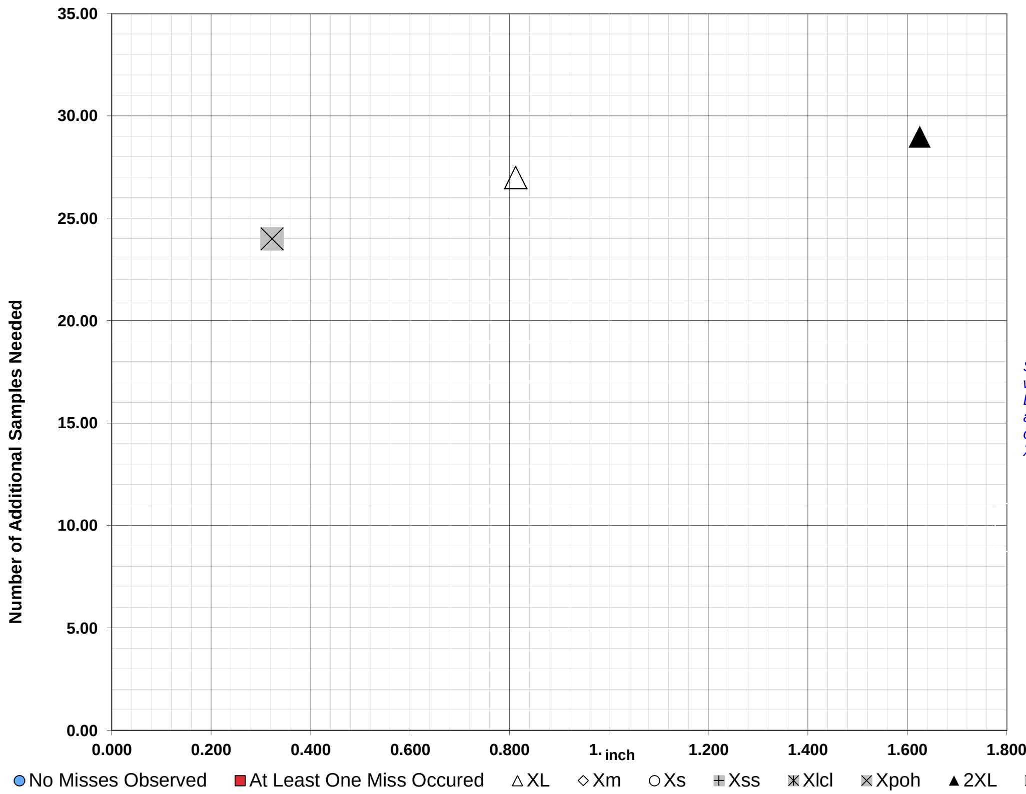


TABLE C

	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

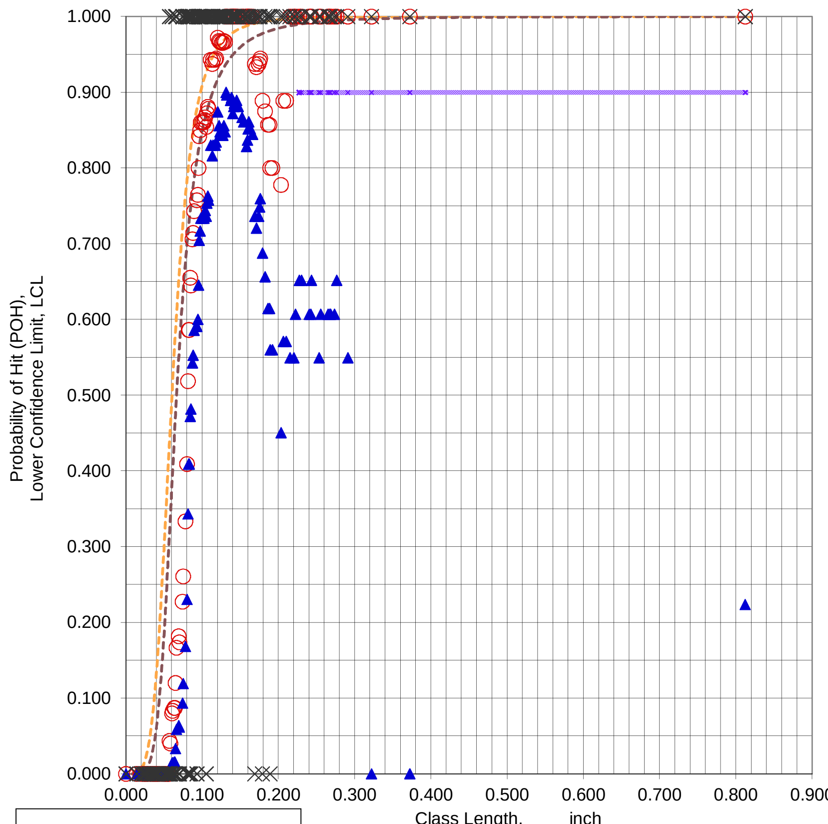
MLE Divergence Warning: Initial results listed.

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	



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

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

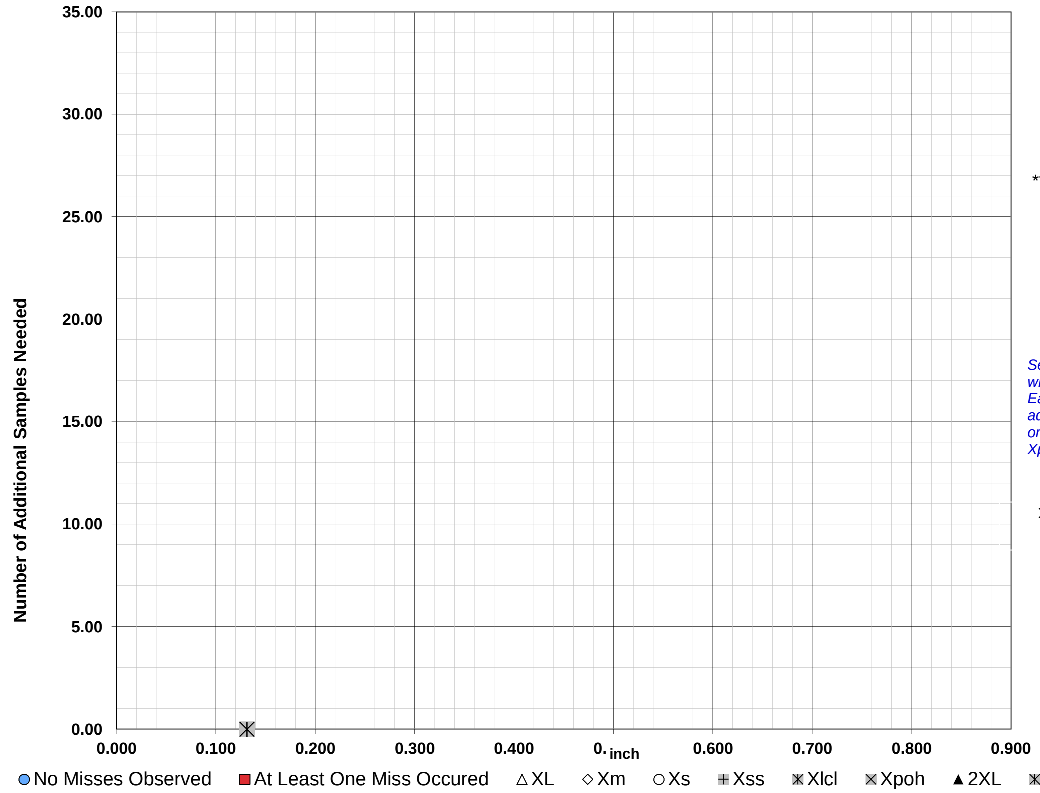


TABLE C

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)

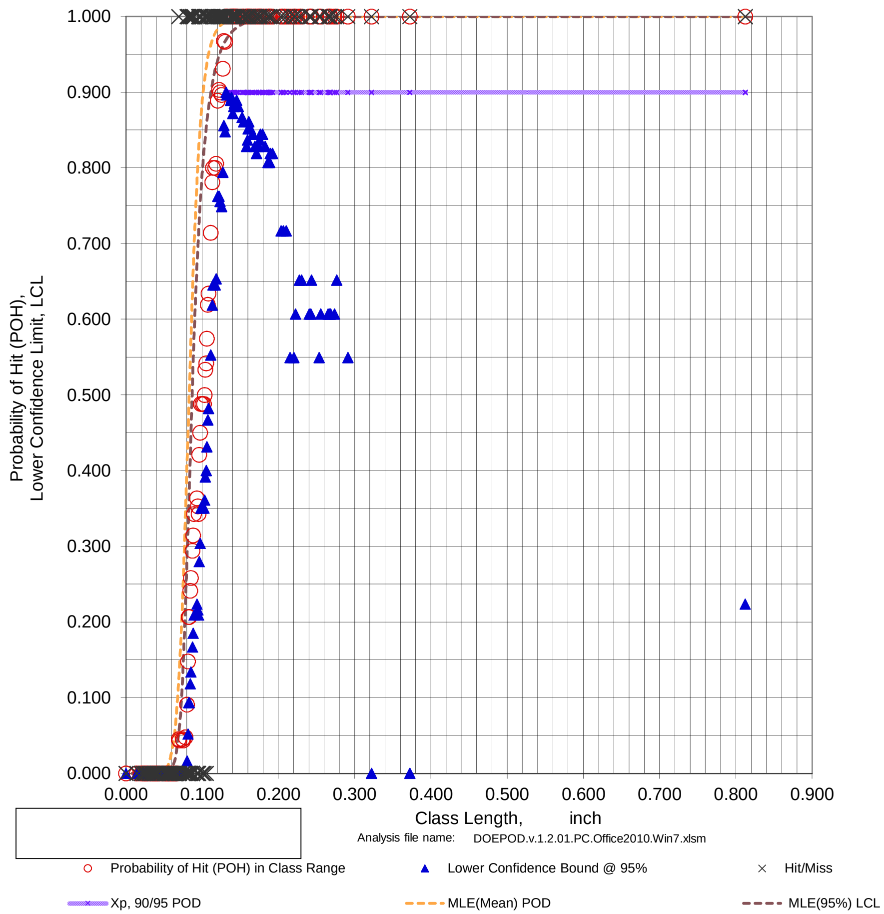
Large flaw validation failure. Need 16 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

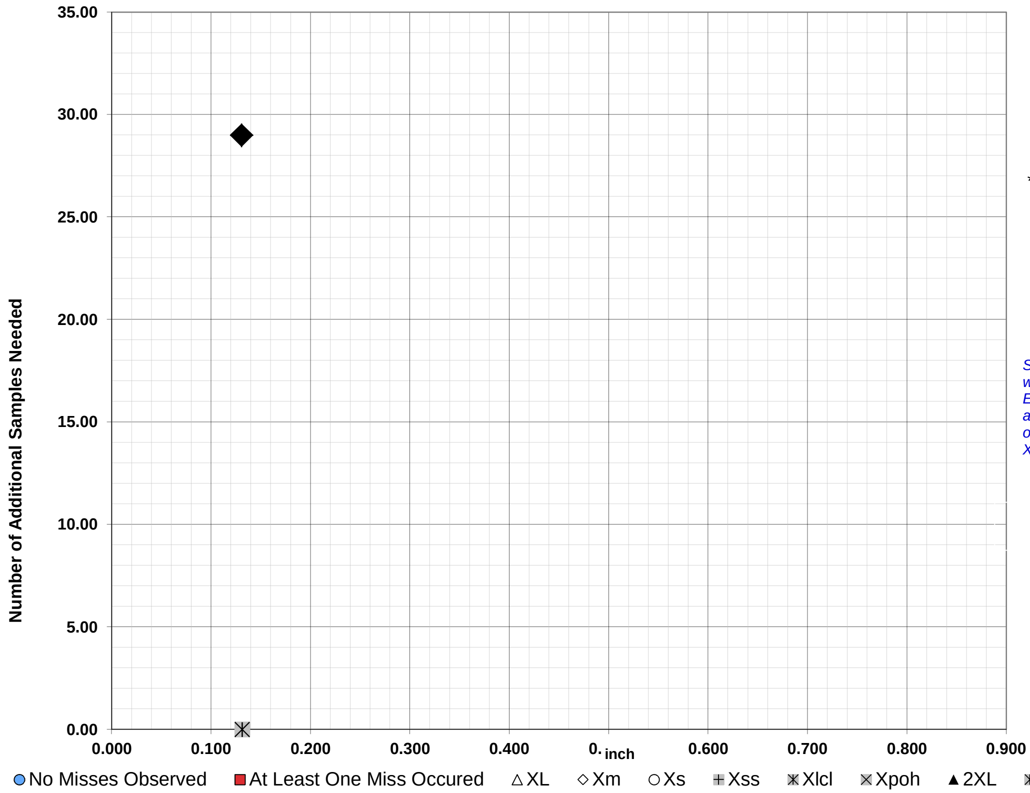


TABLE C

	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

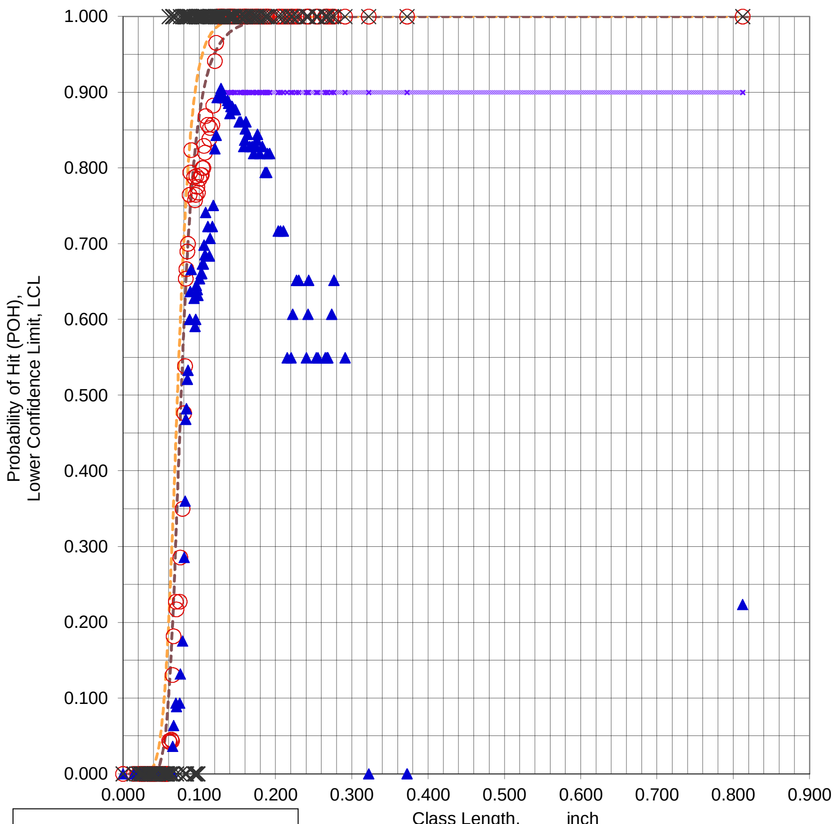
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = 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

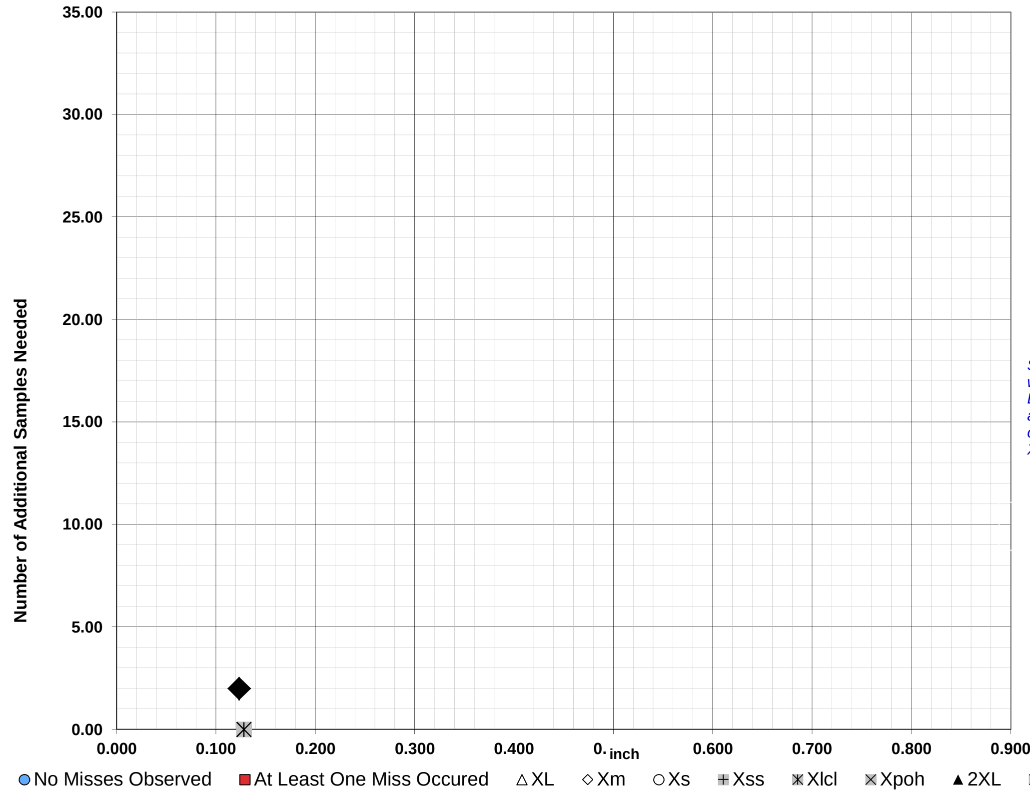


TABLE C

	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)

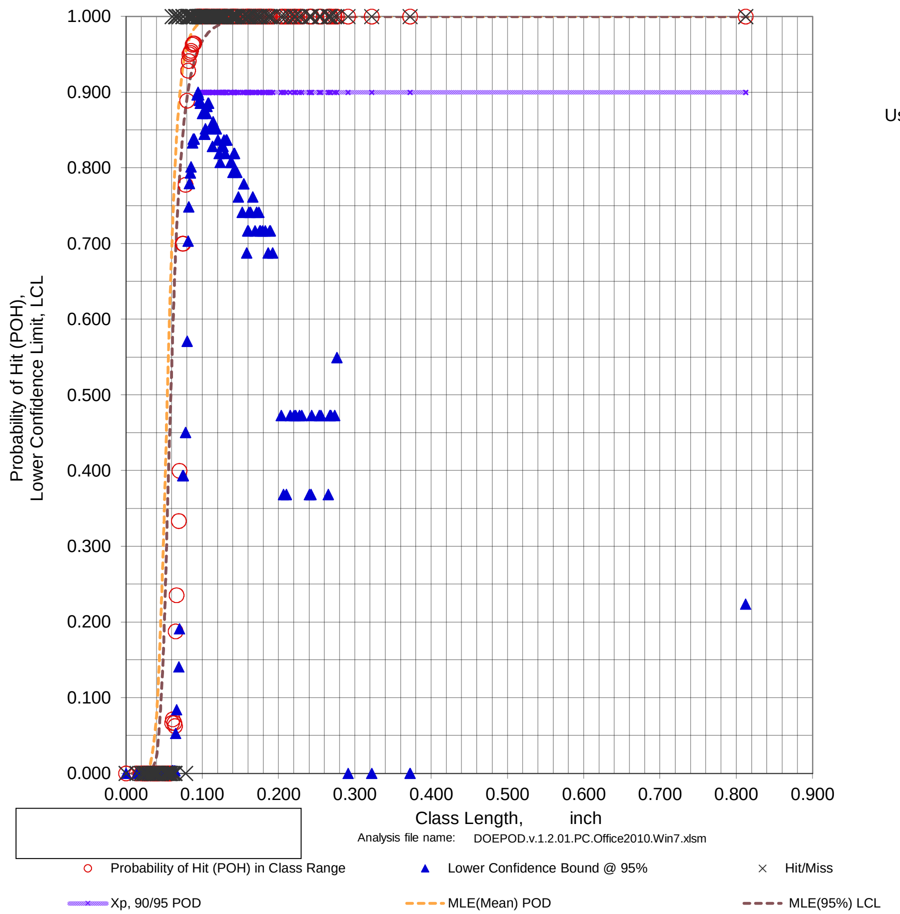
Large flaw validation failure. Need 15 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

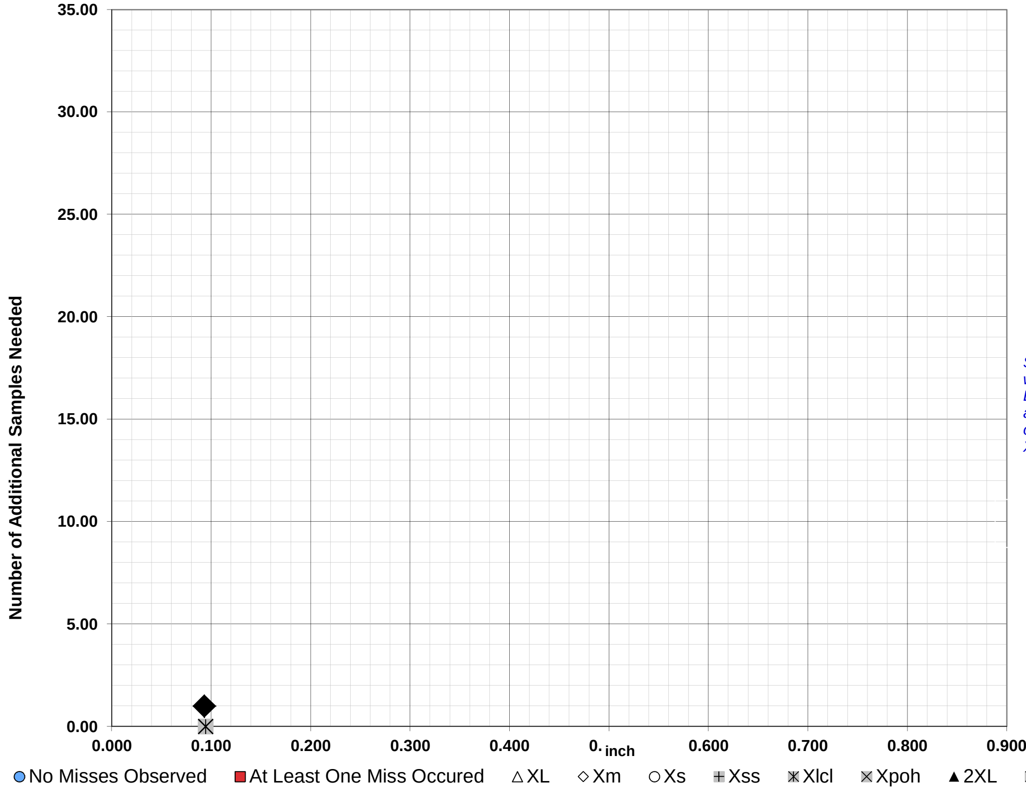


TABLE C

	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.

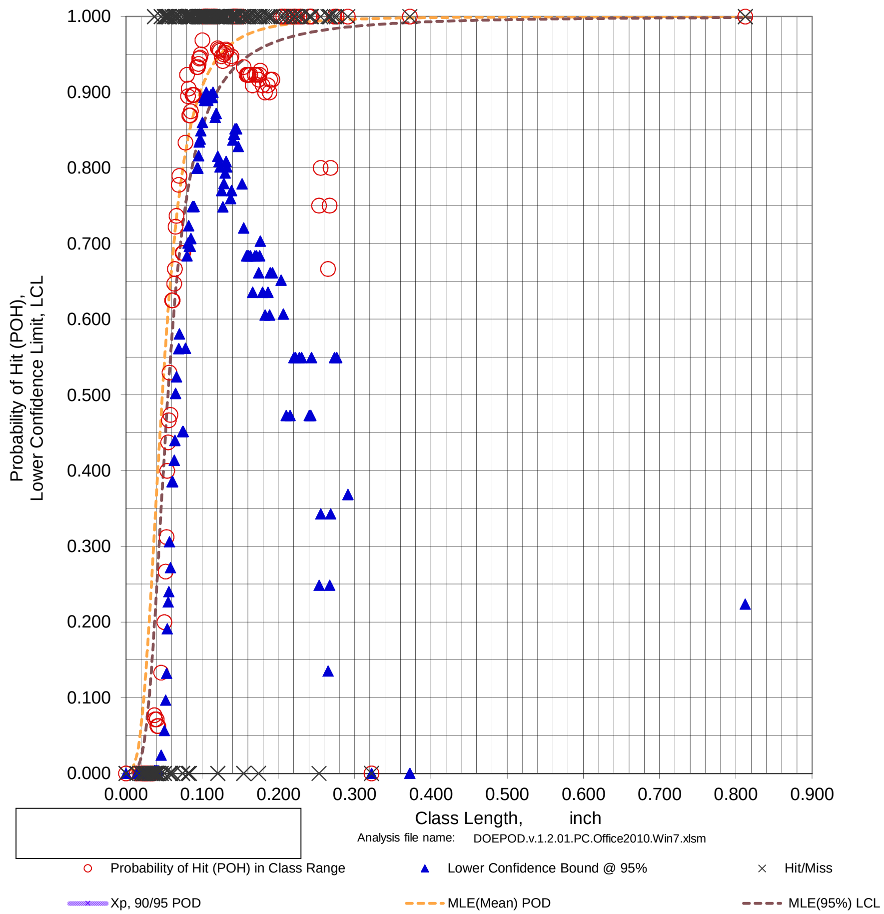
Xpod,Class Length	No. Need

* 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

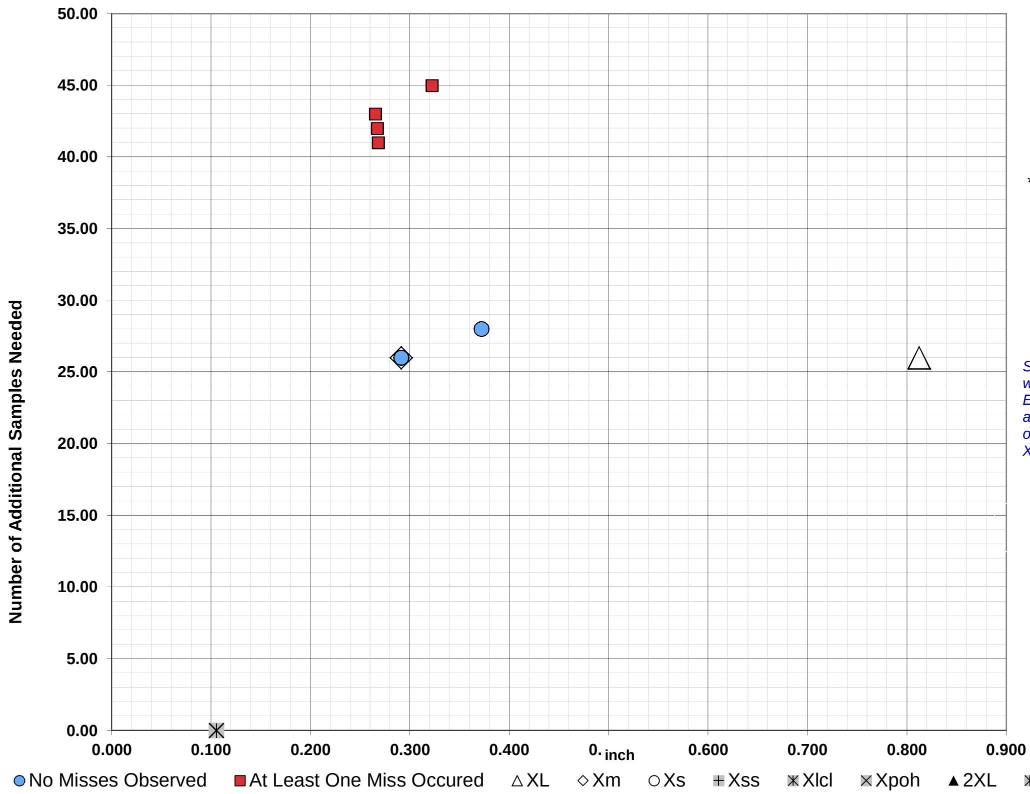


TABLE C

	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.

TABLE B*

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

Table A: Xpod,Class Length	No. Need	Table B: Xpod,Class Length	No. Need
0.3220	45	0.3720	28
0.2680	41	0.2910	26
0.2670	42	0.2910	26
0.2650	43	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

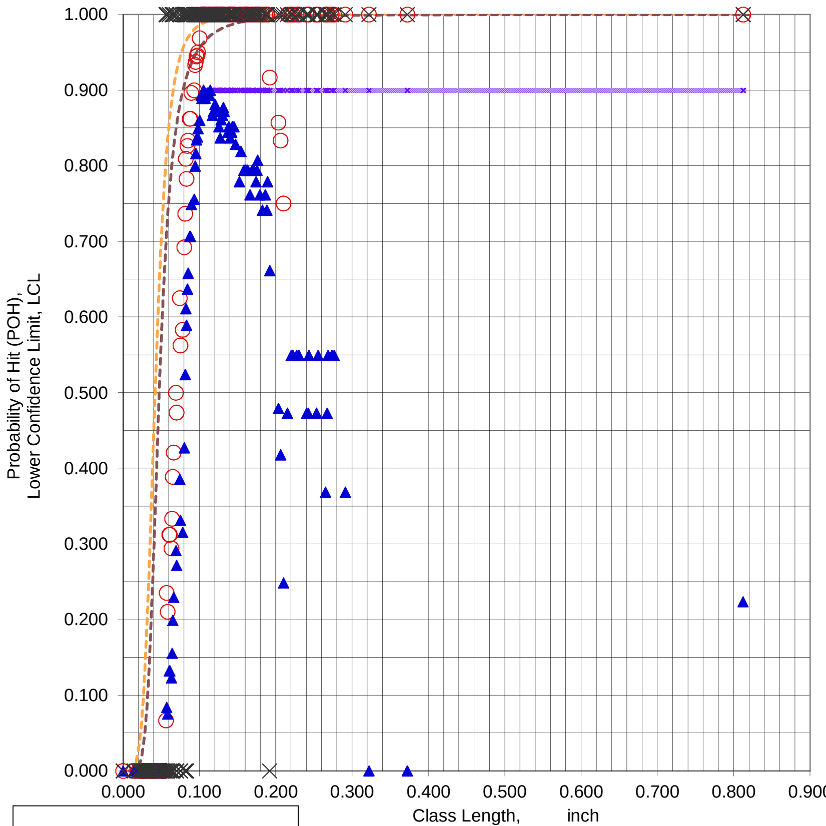
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

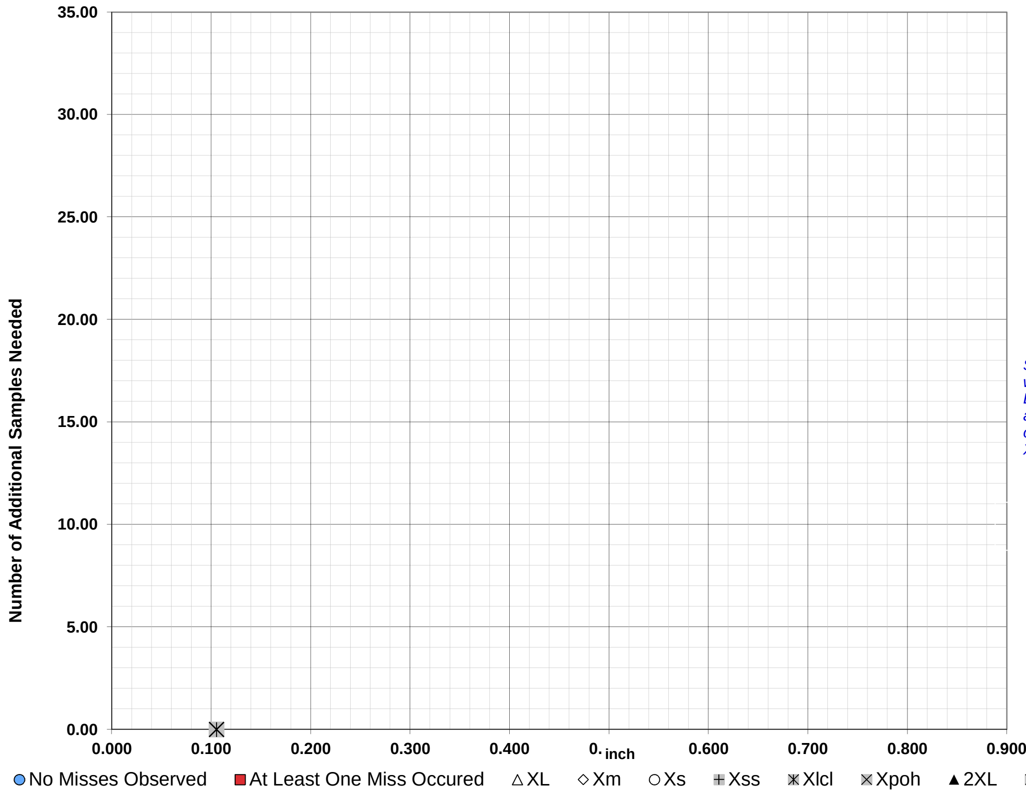


TABLE C

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

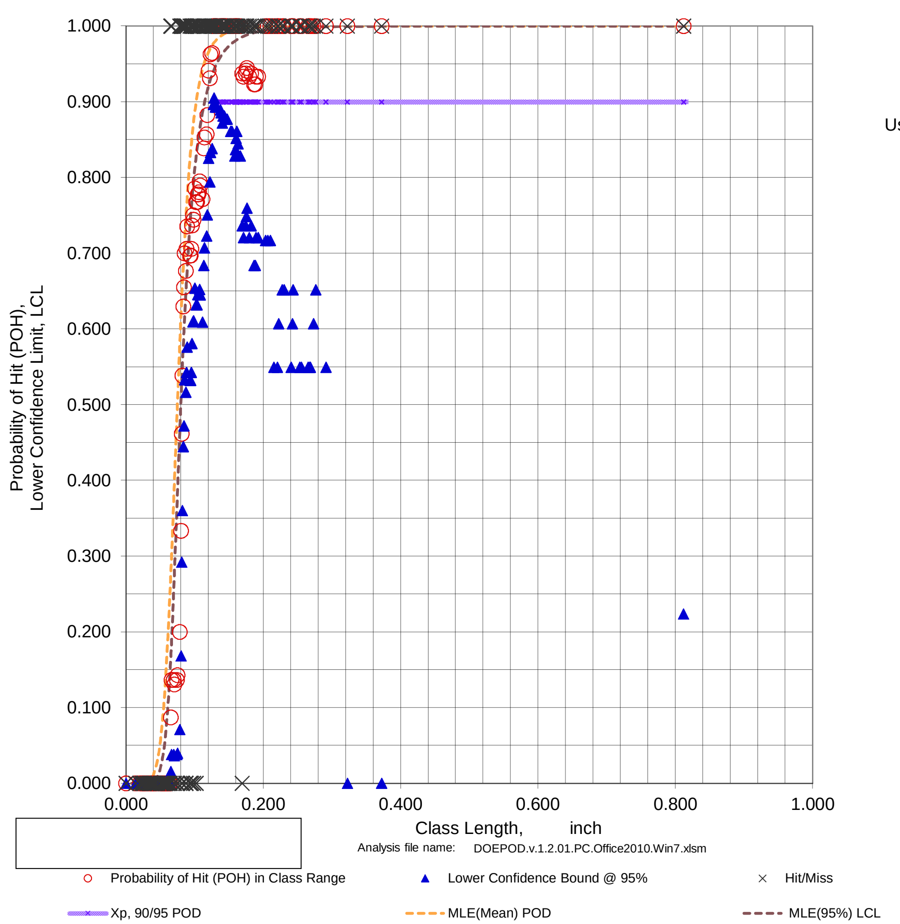
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

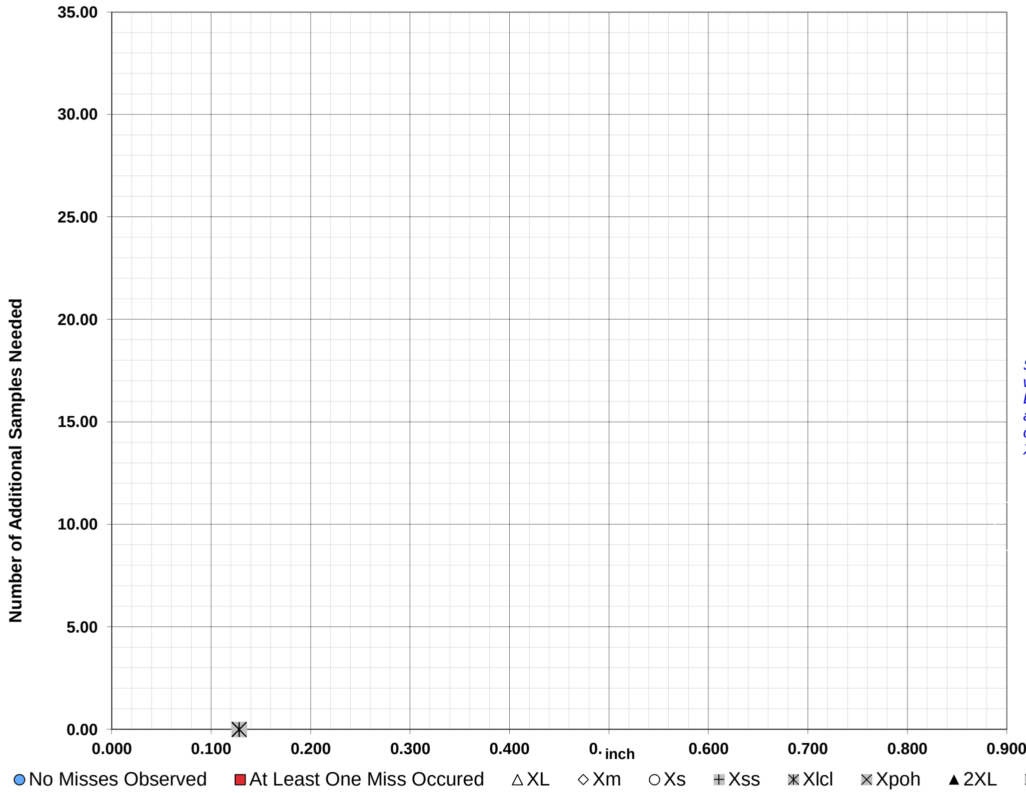


TABLE C

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

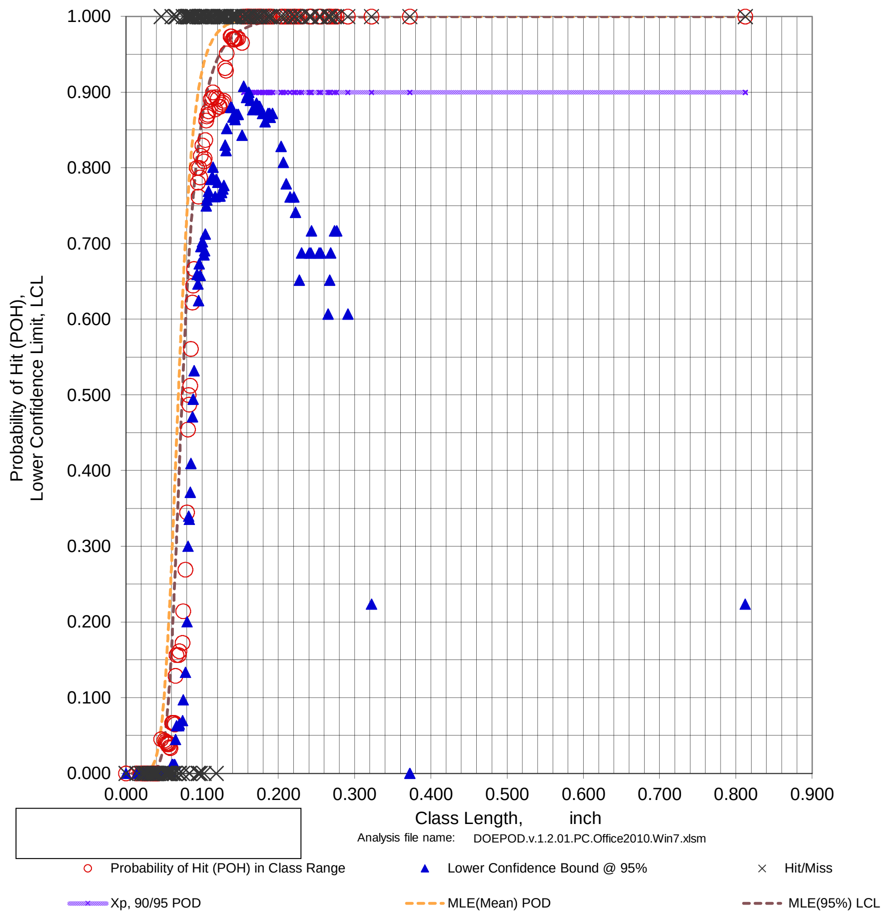
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

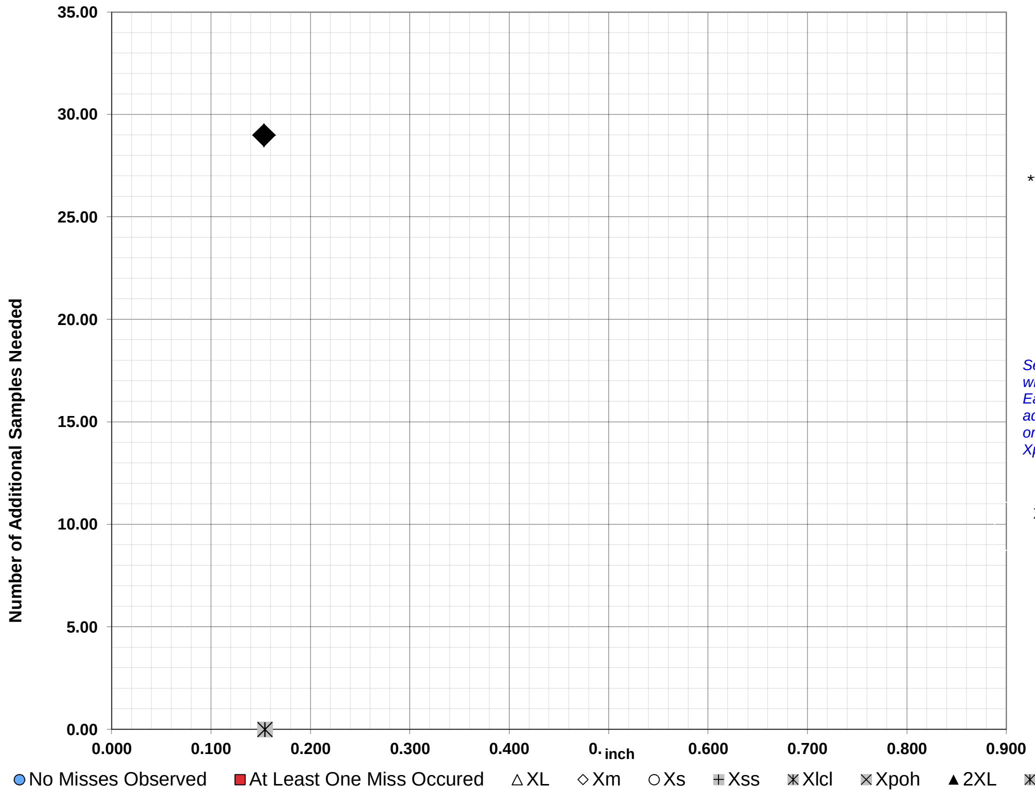


TABLE C

	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

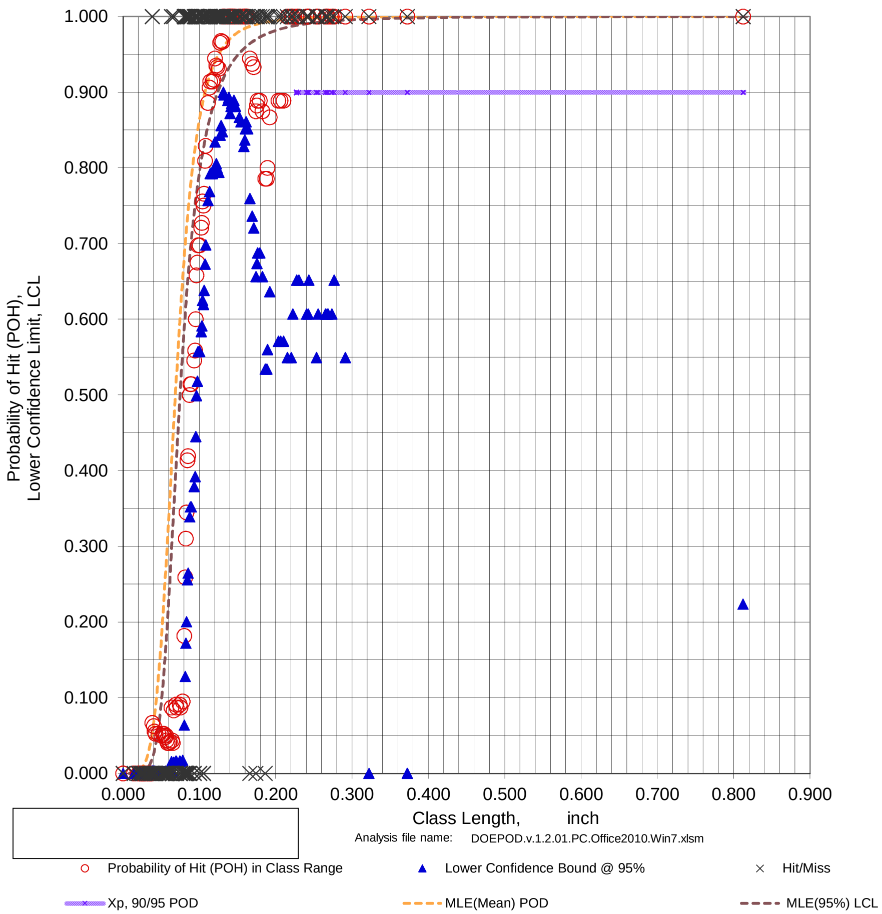
Classlength @ Best LCL = inch

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

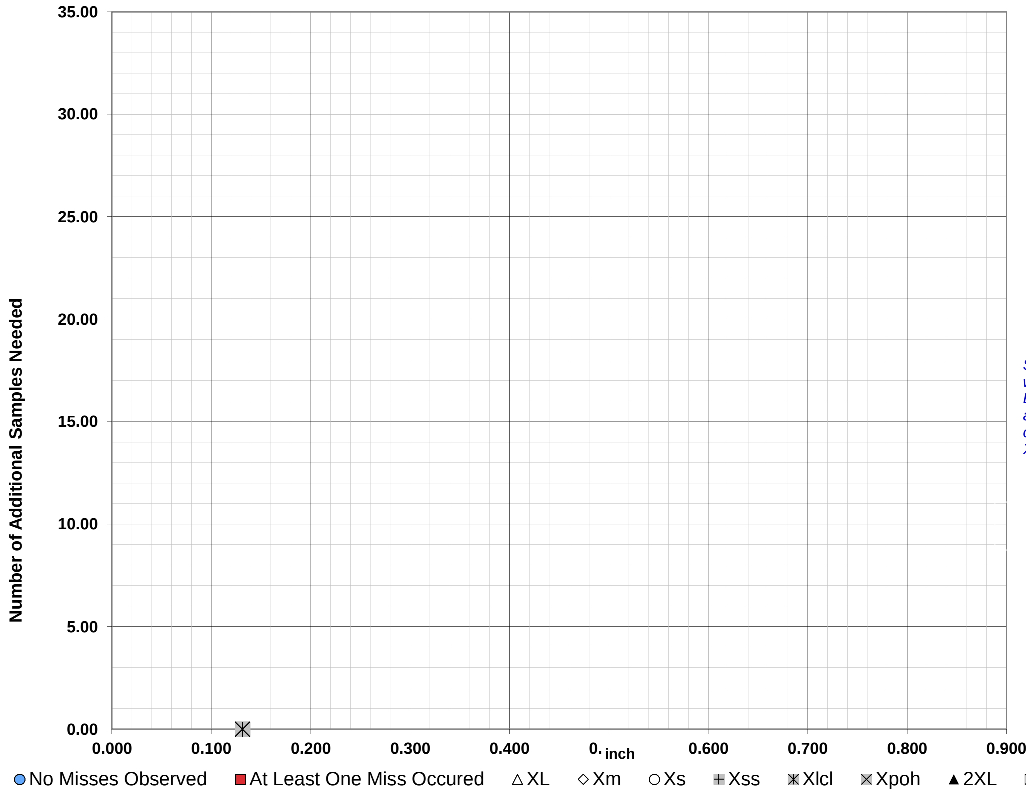


TABLE C

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

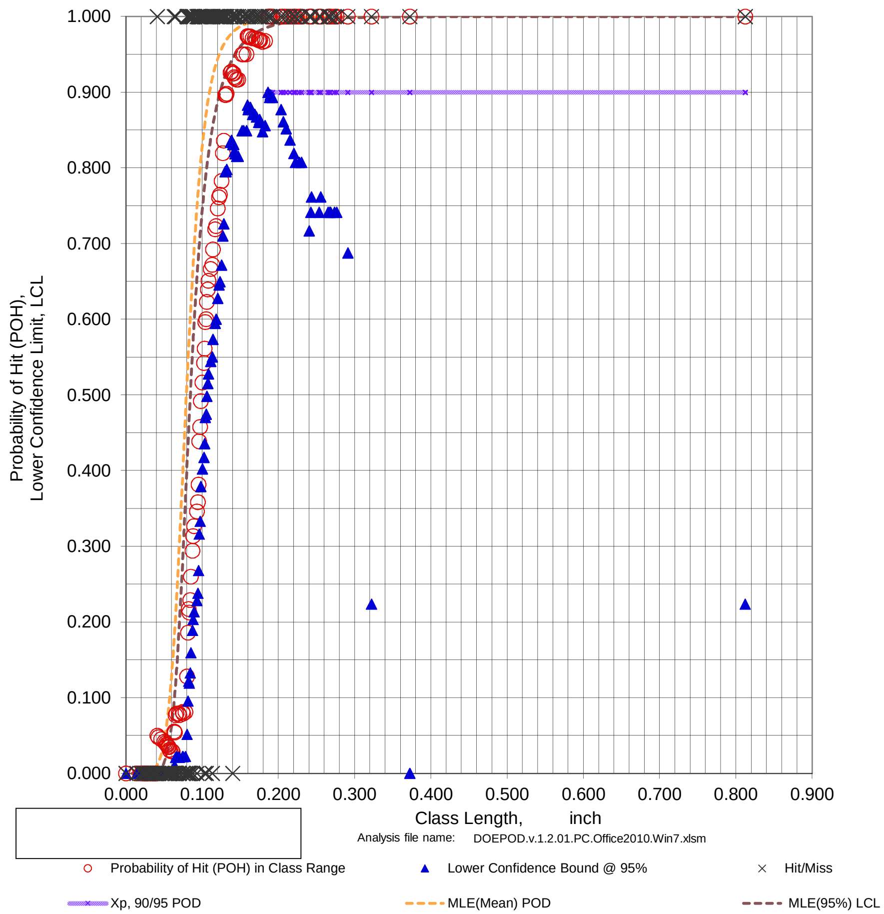
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

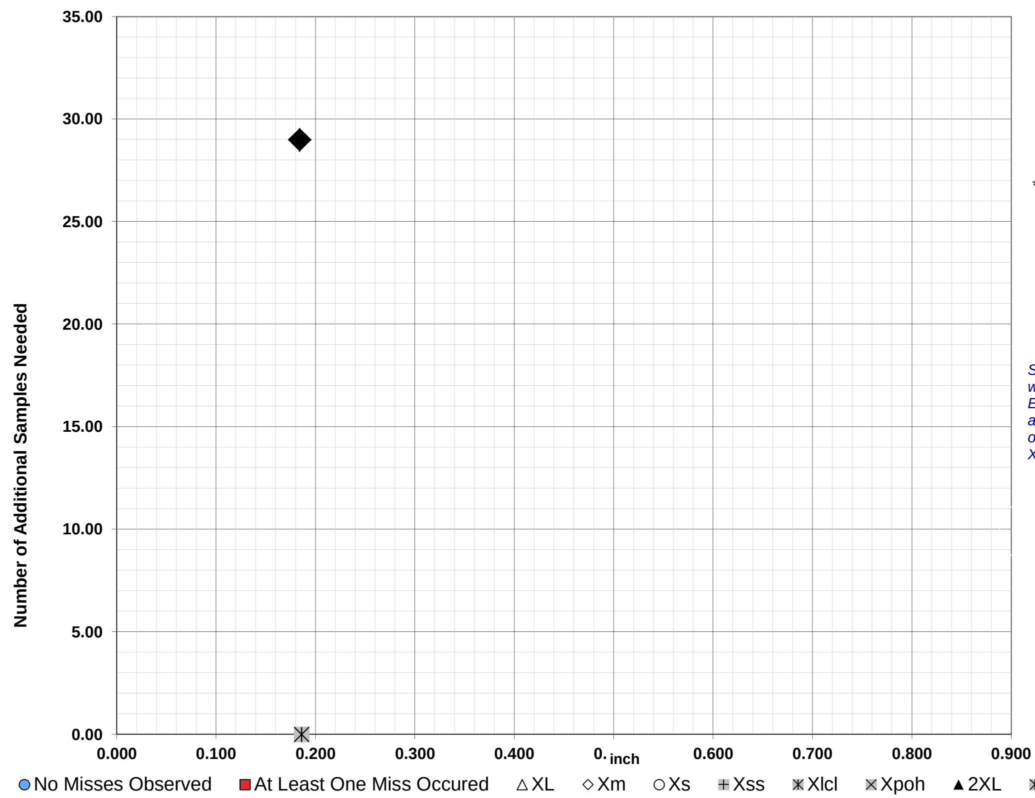


TABLE C

	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.

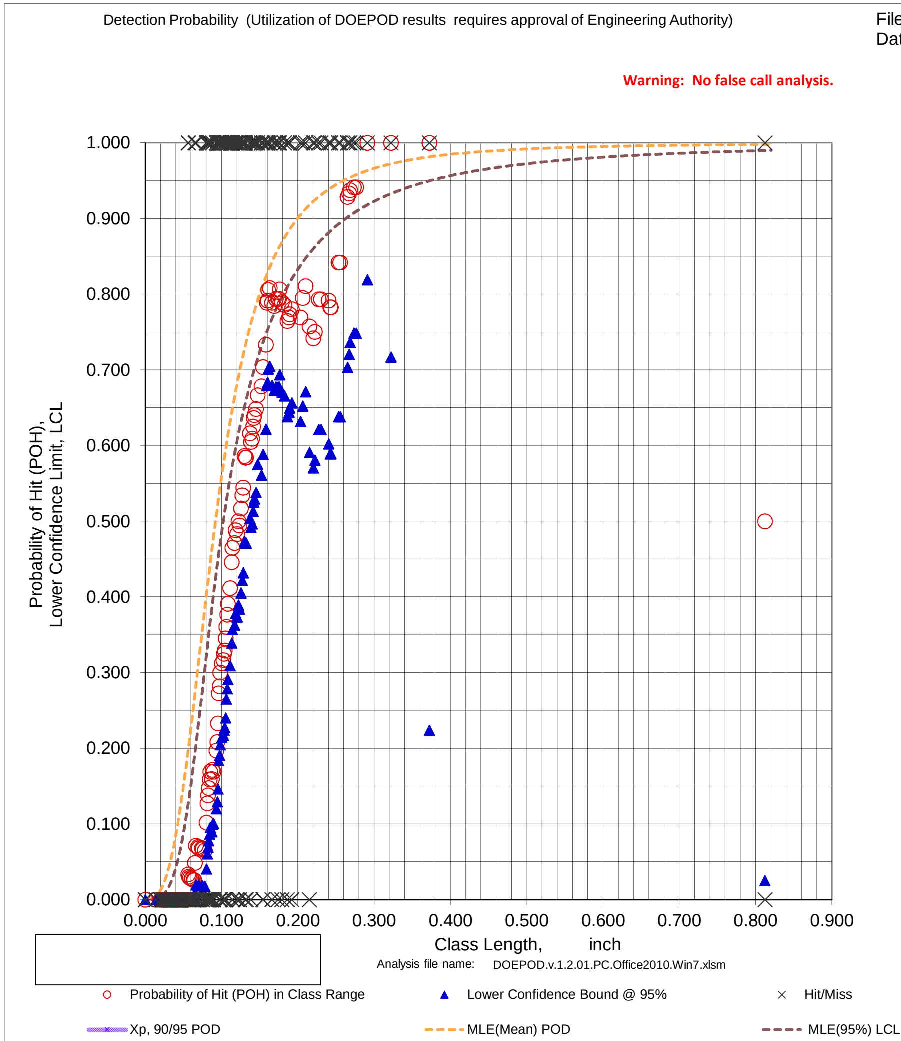
Xpod,Class Length	No. Need

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



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

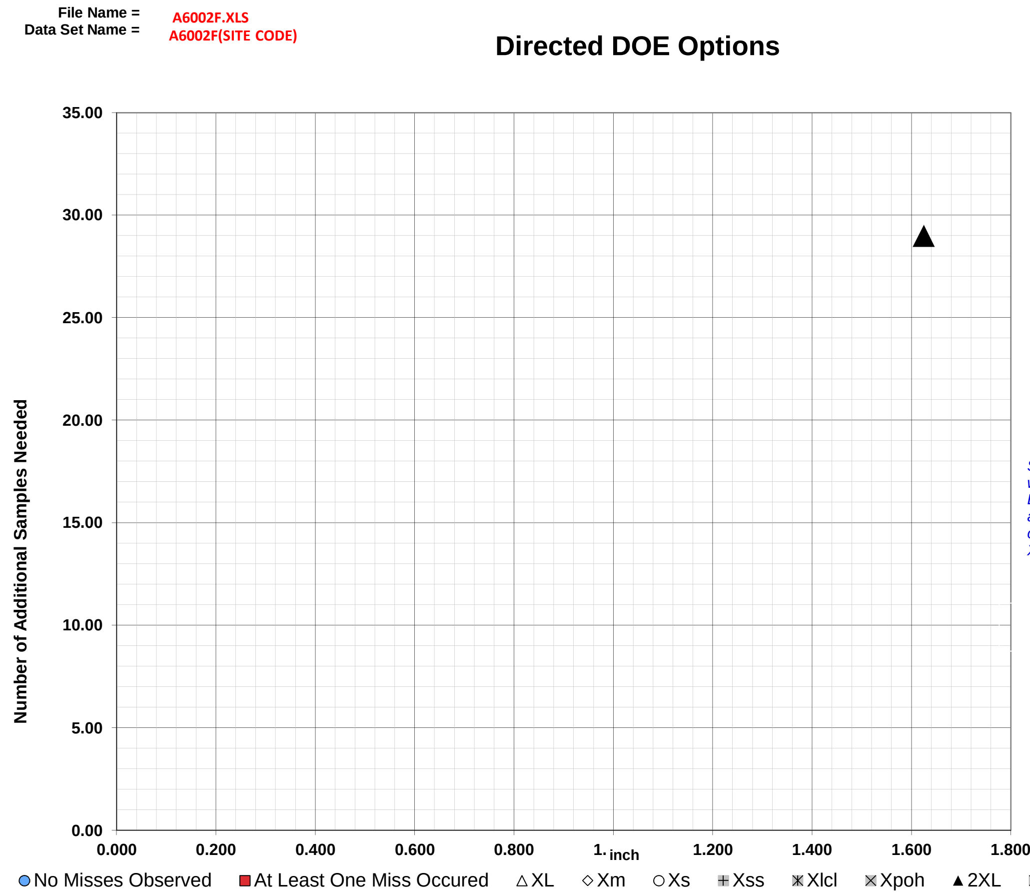


TABLE C

	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

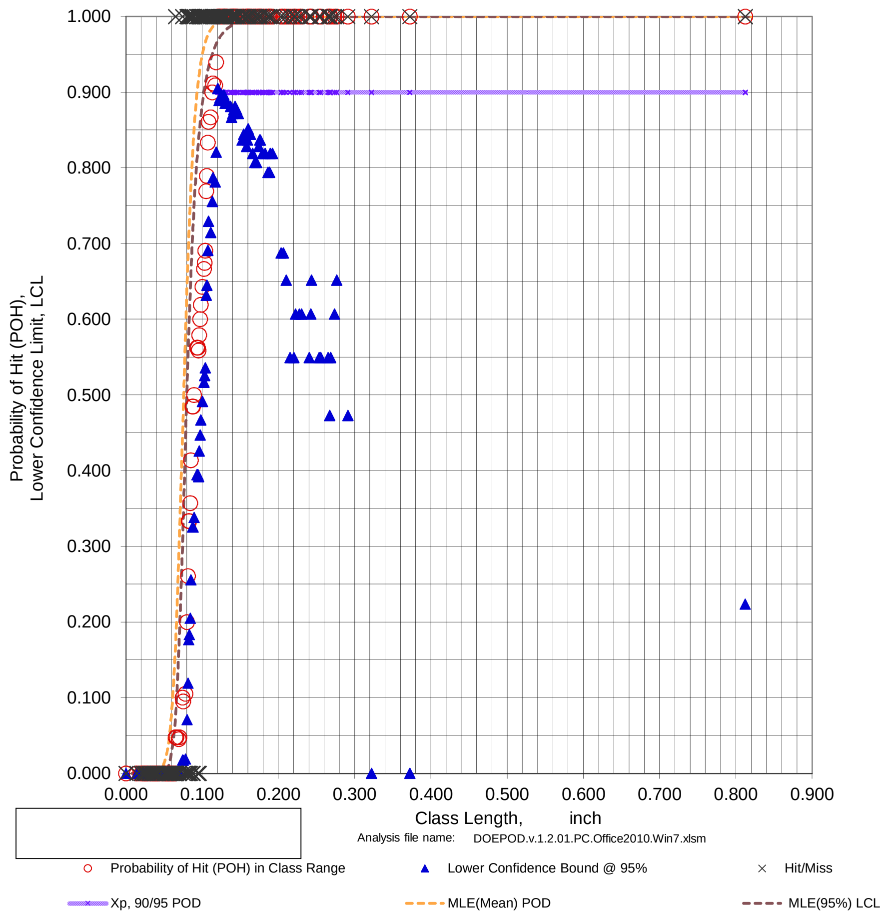
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

Large flaw validation failure. Need 16 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

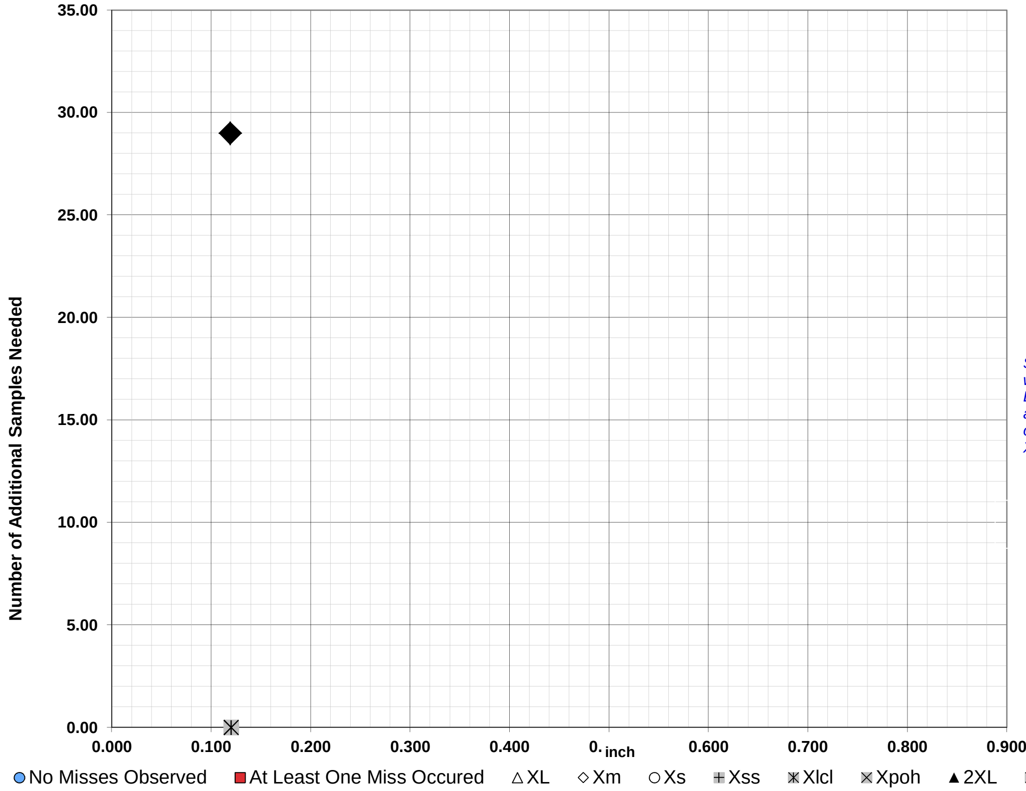


TABLE C

	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

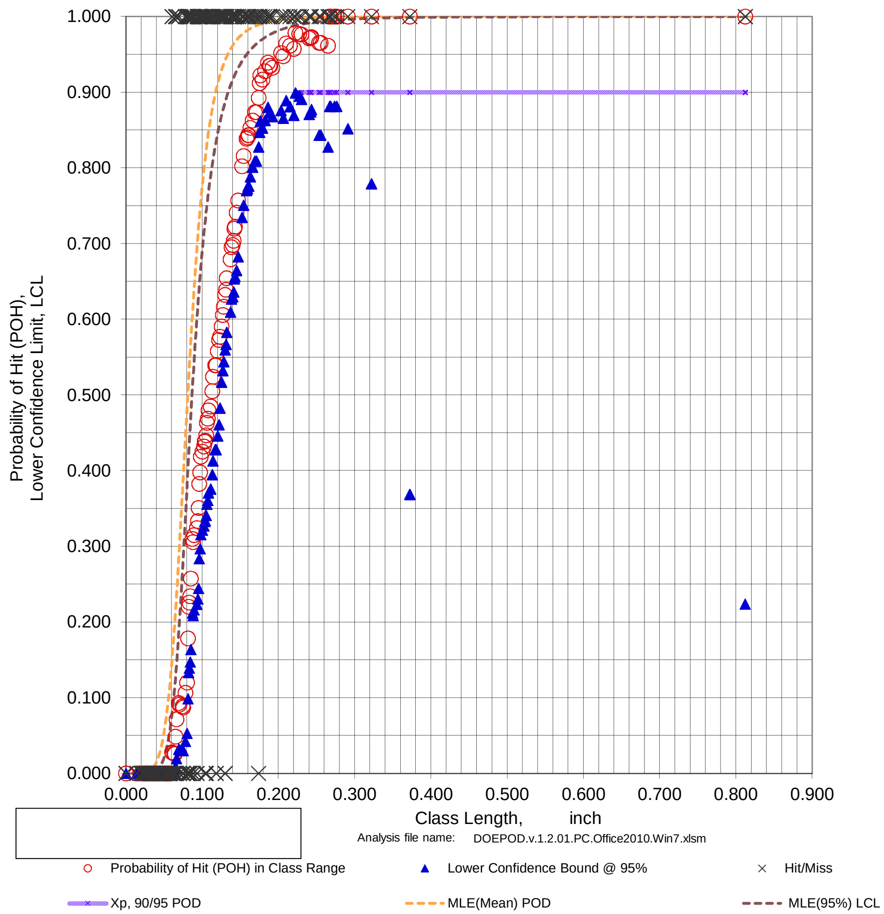
MLE Divergence Warning: Initial results listed.

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	



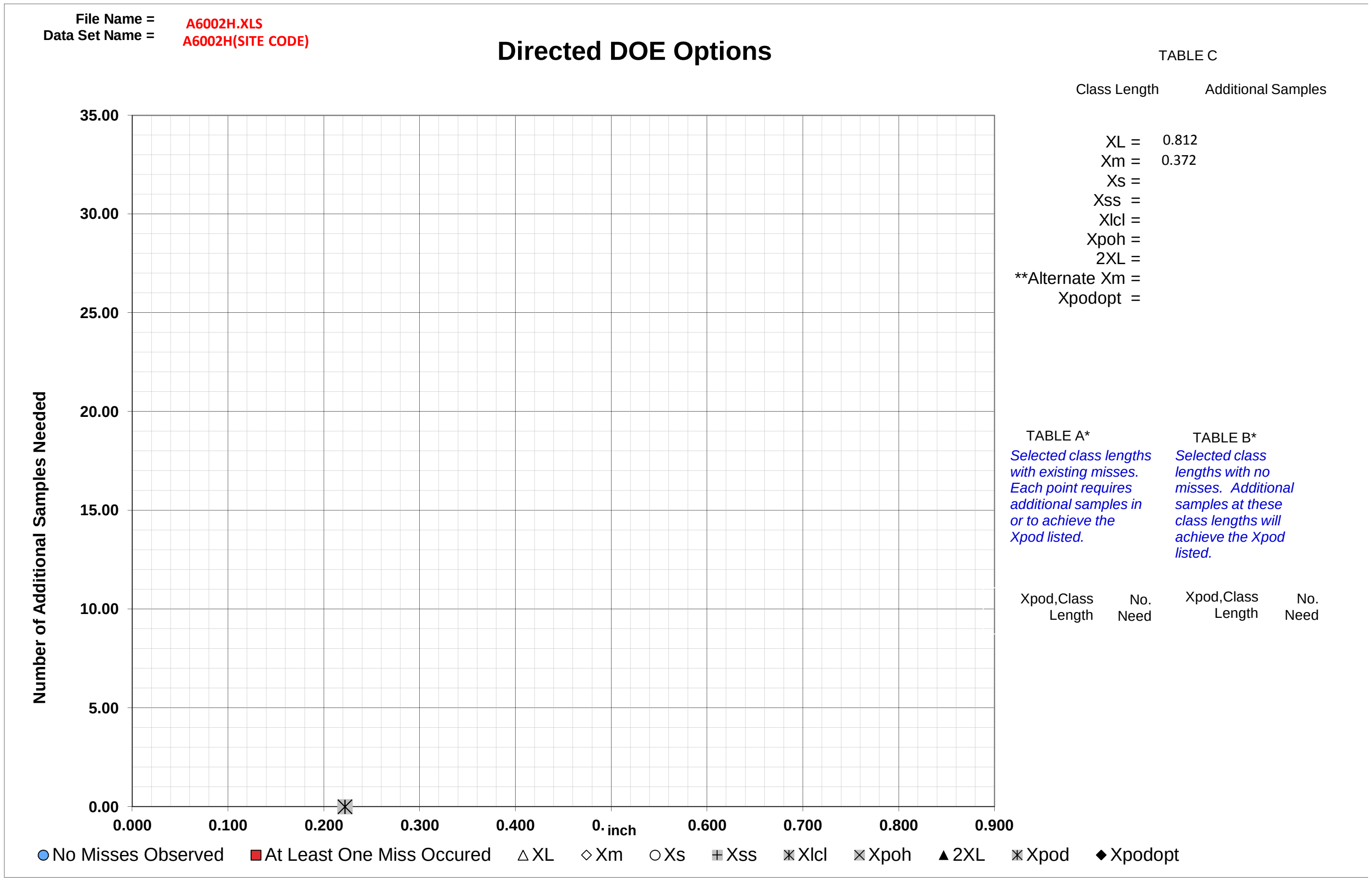
CASE 1* - 90/95 Xpod is reached. Xp used to satisfy XL and Xm requirements. Xp may VALIDATE between Xpod and XL when causes of highlighted Misses are understood and corrected.

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



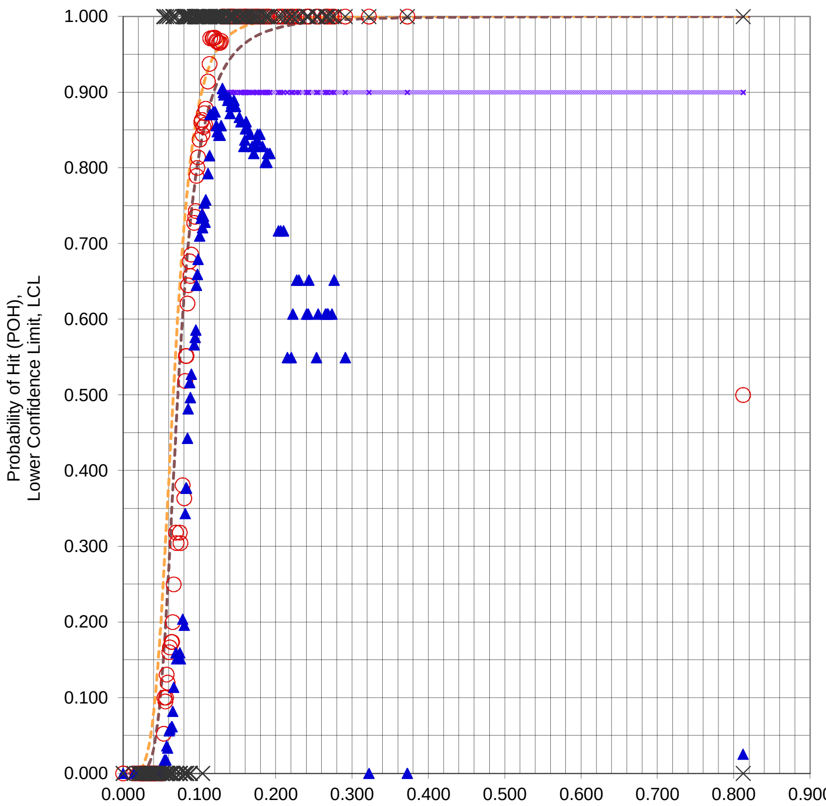
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.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



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 = **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

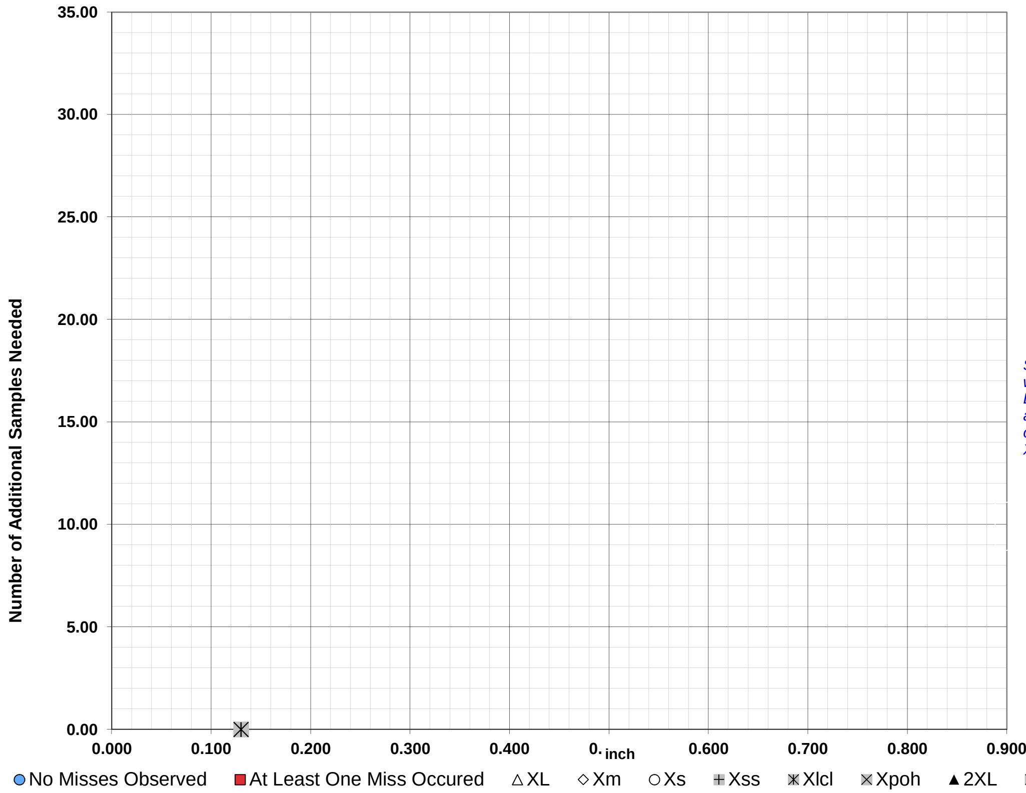


TABLE C

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*

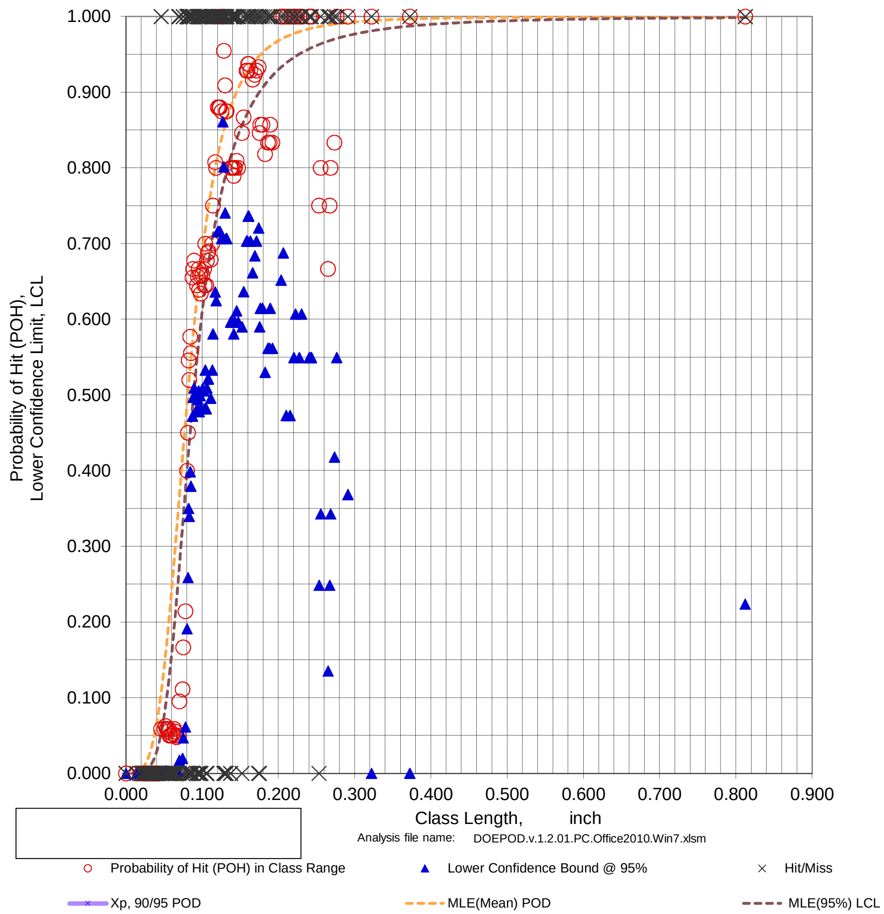
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

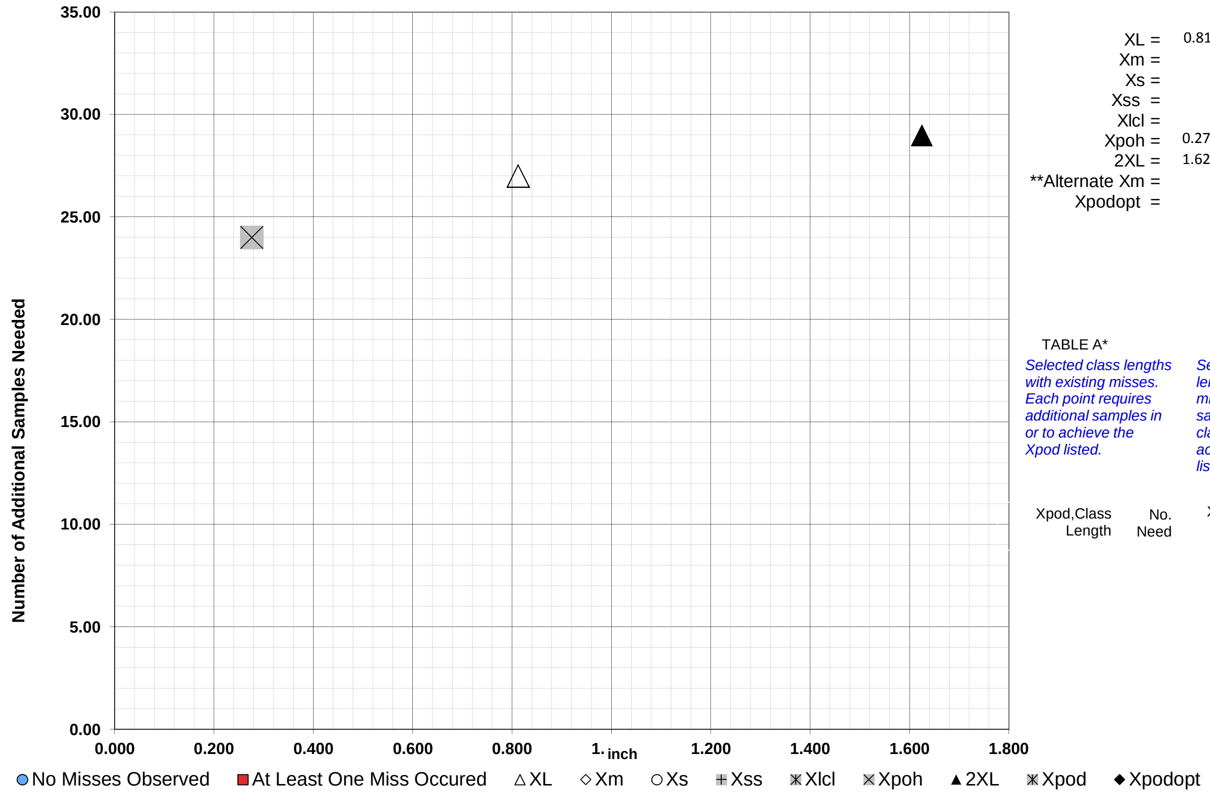


TABLE C

	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

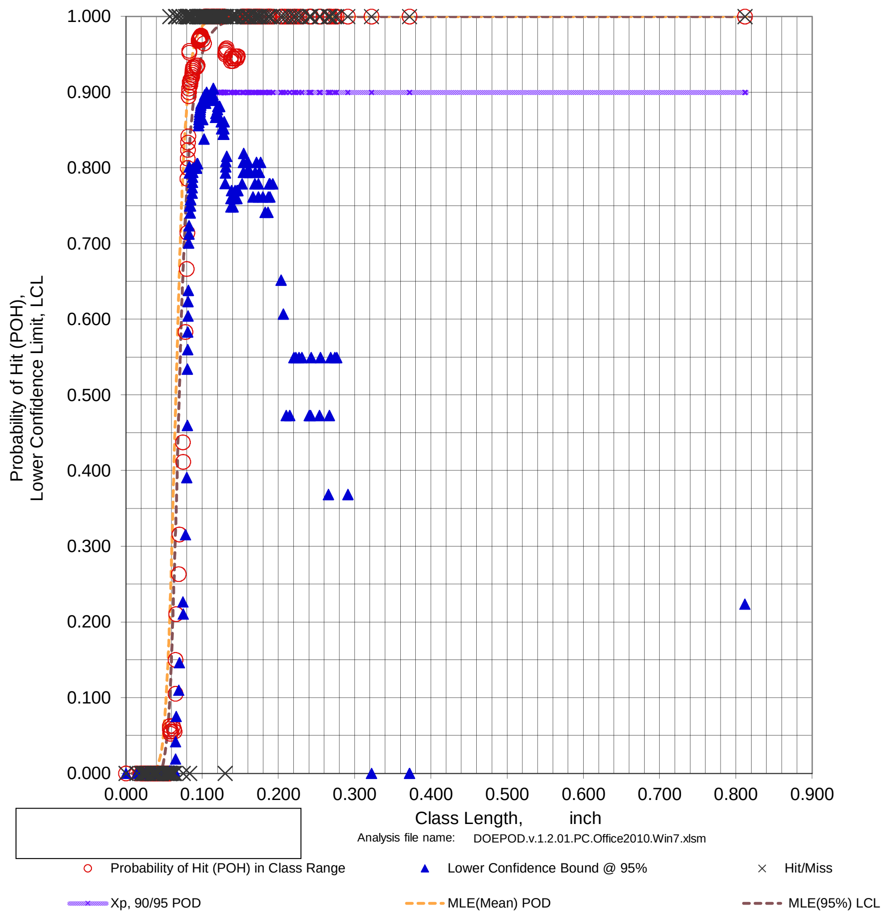
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

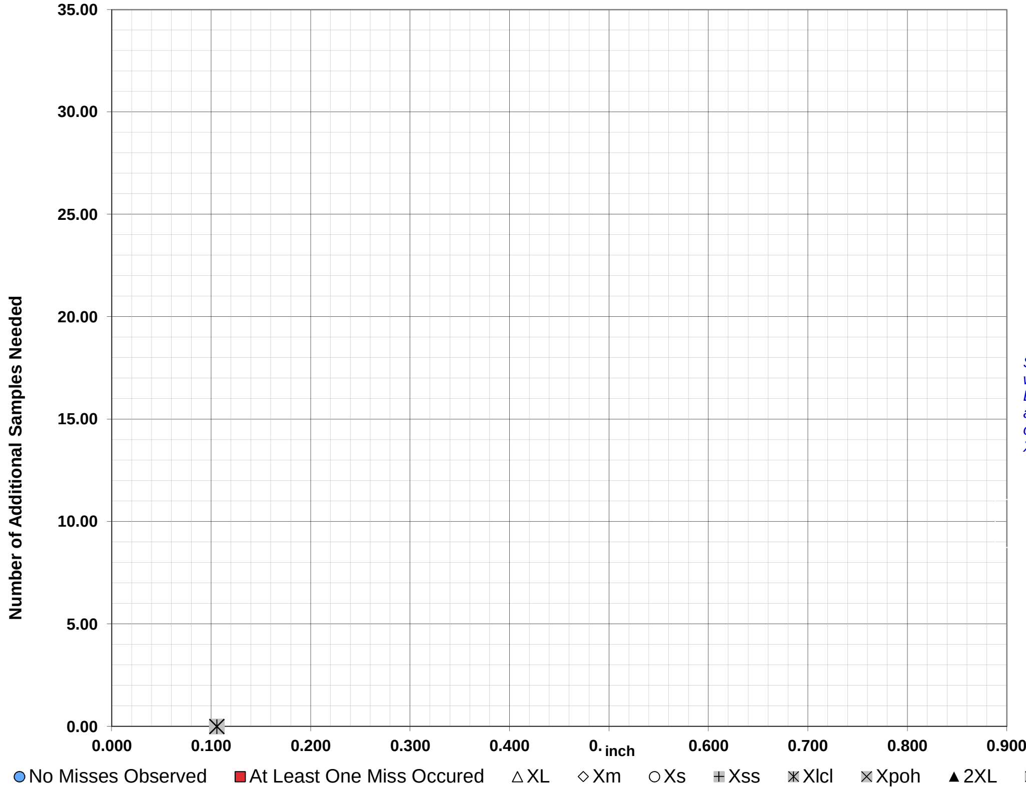


TABLE C

	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

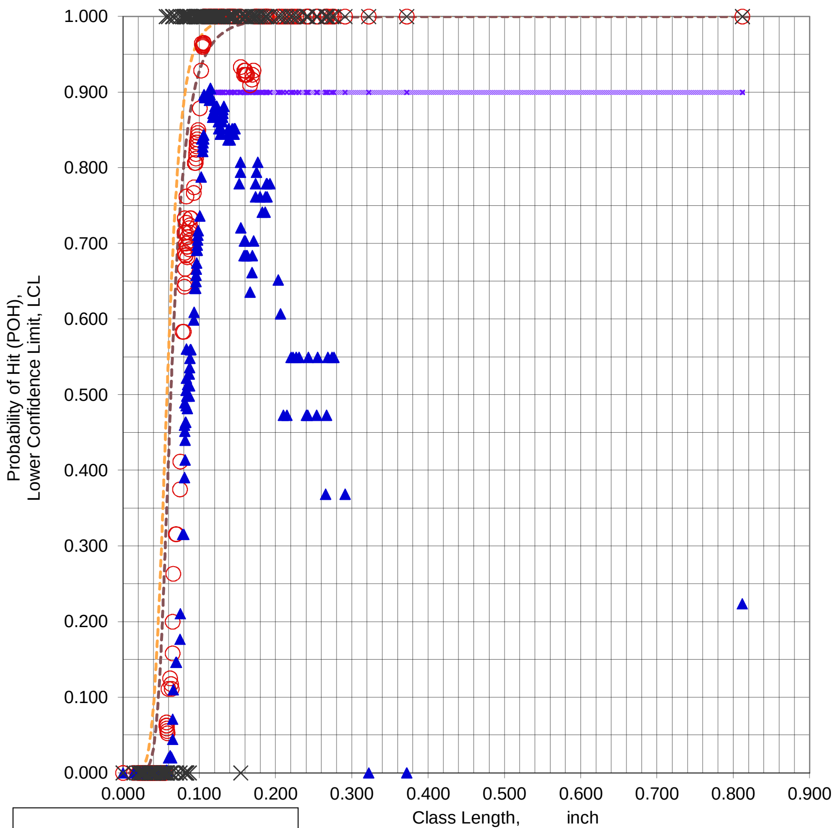
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

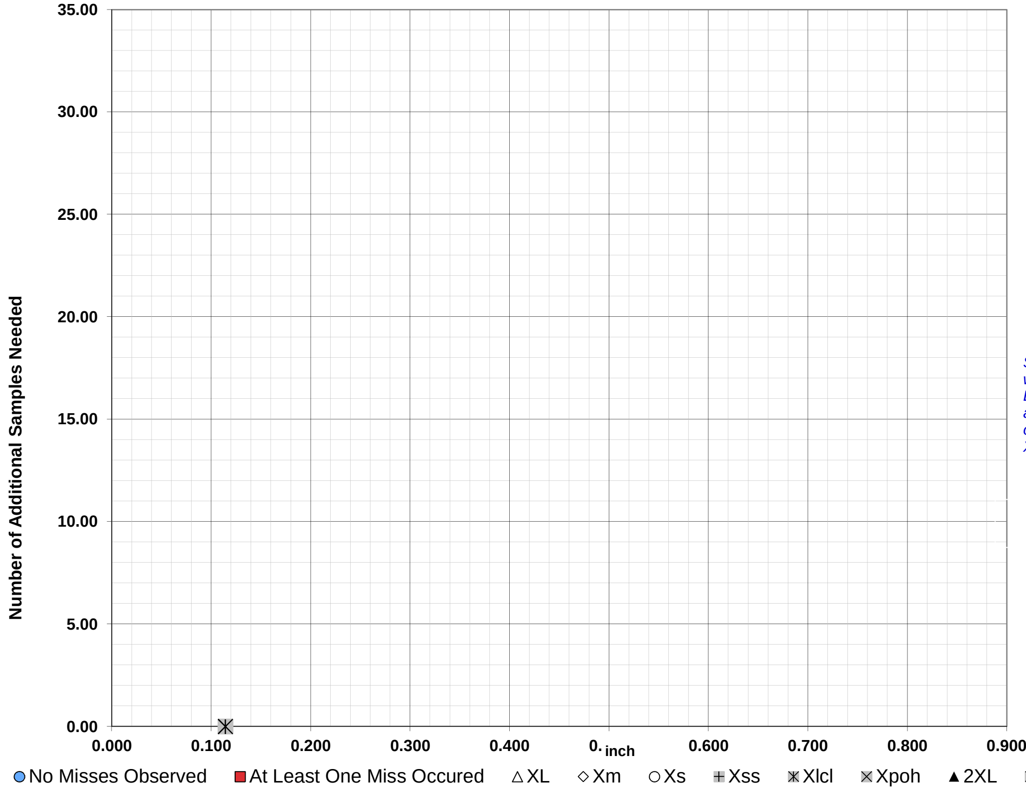


TABLE C

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

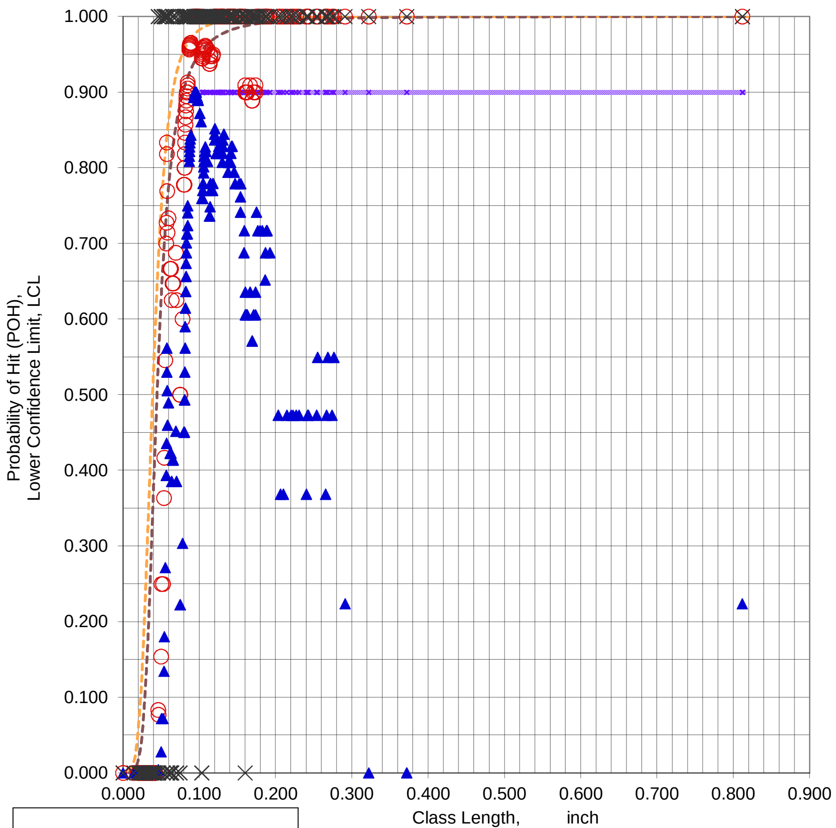
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

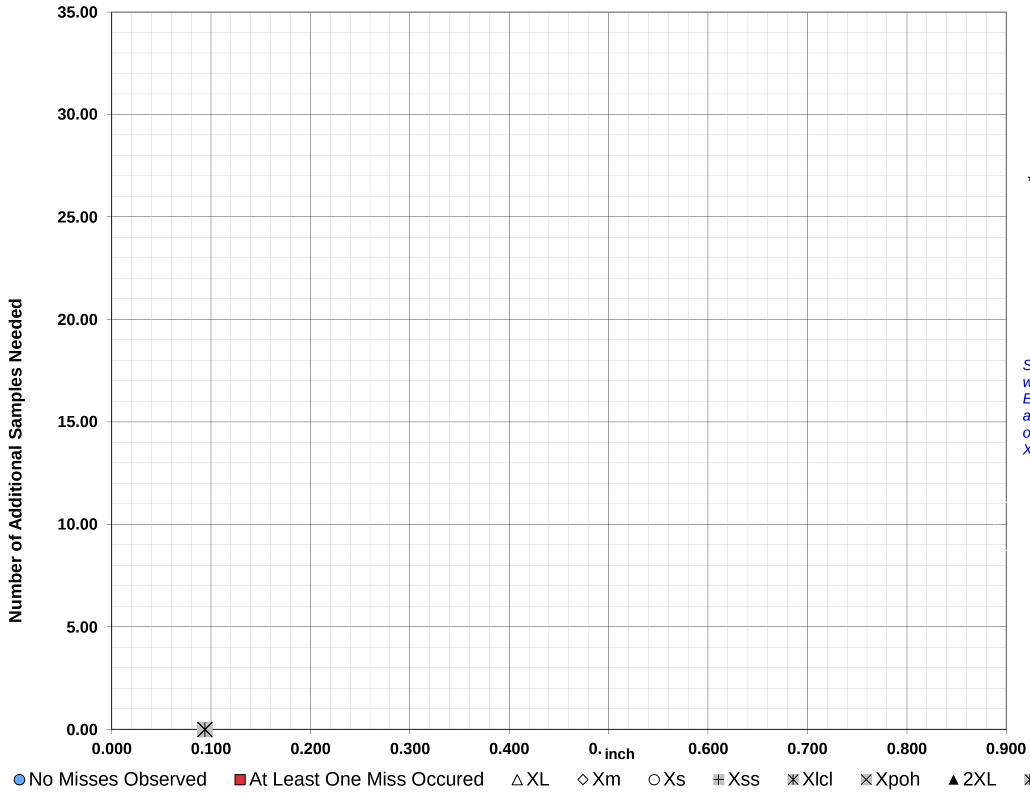


TABLE C

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

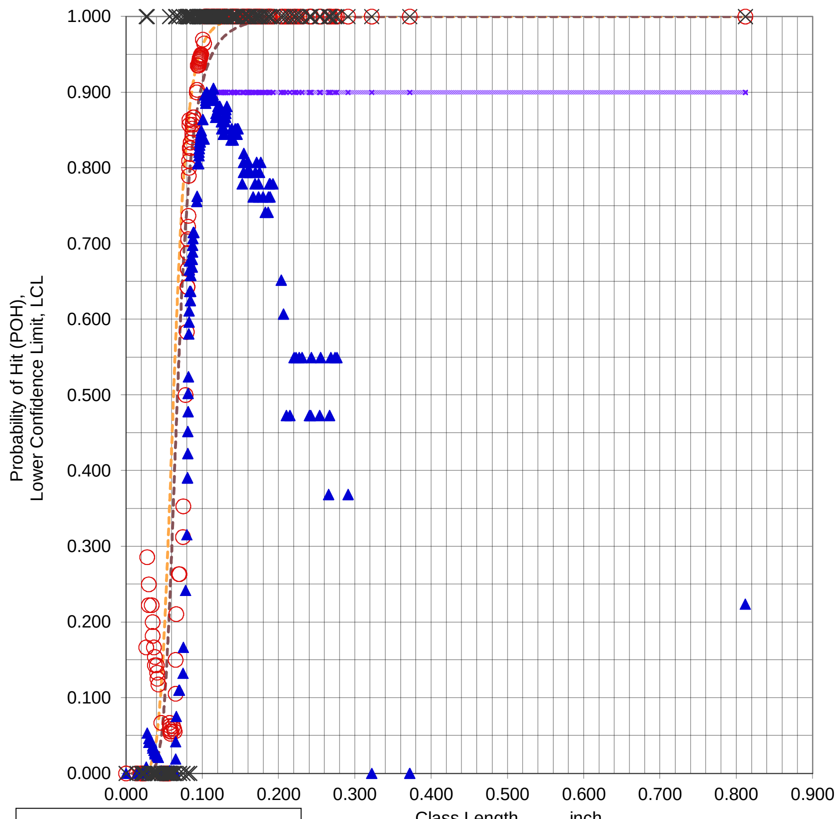
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

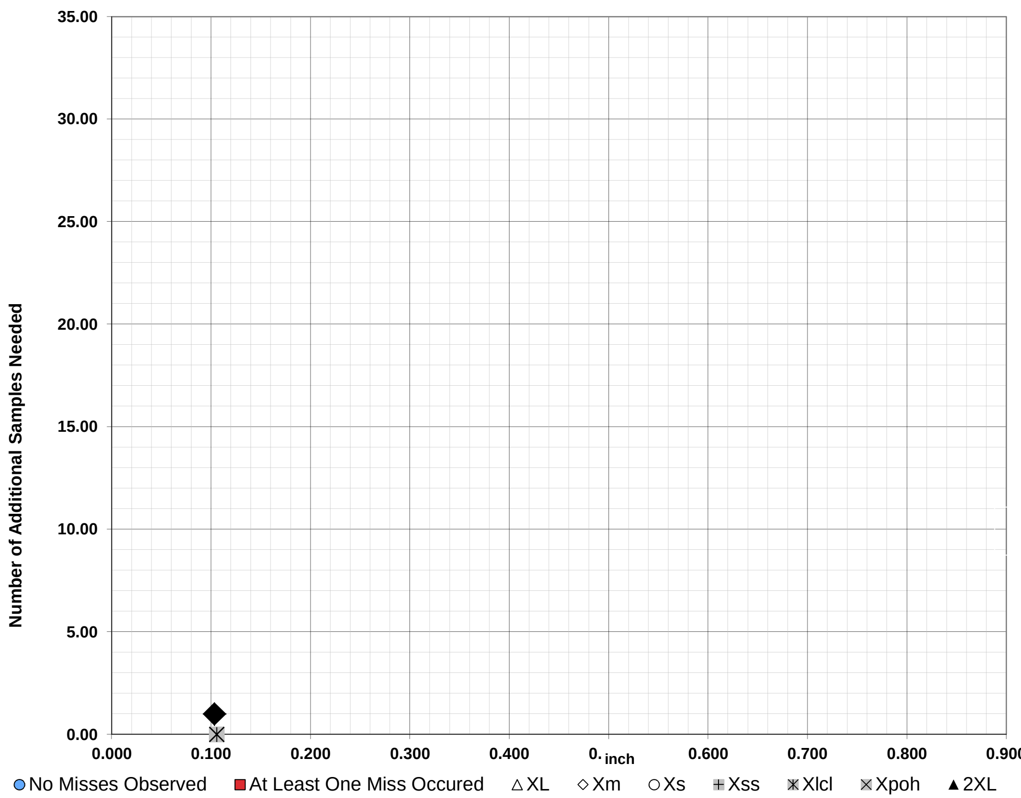


TABLE C

	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

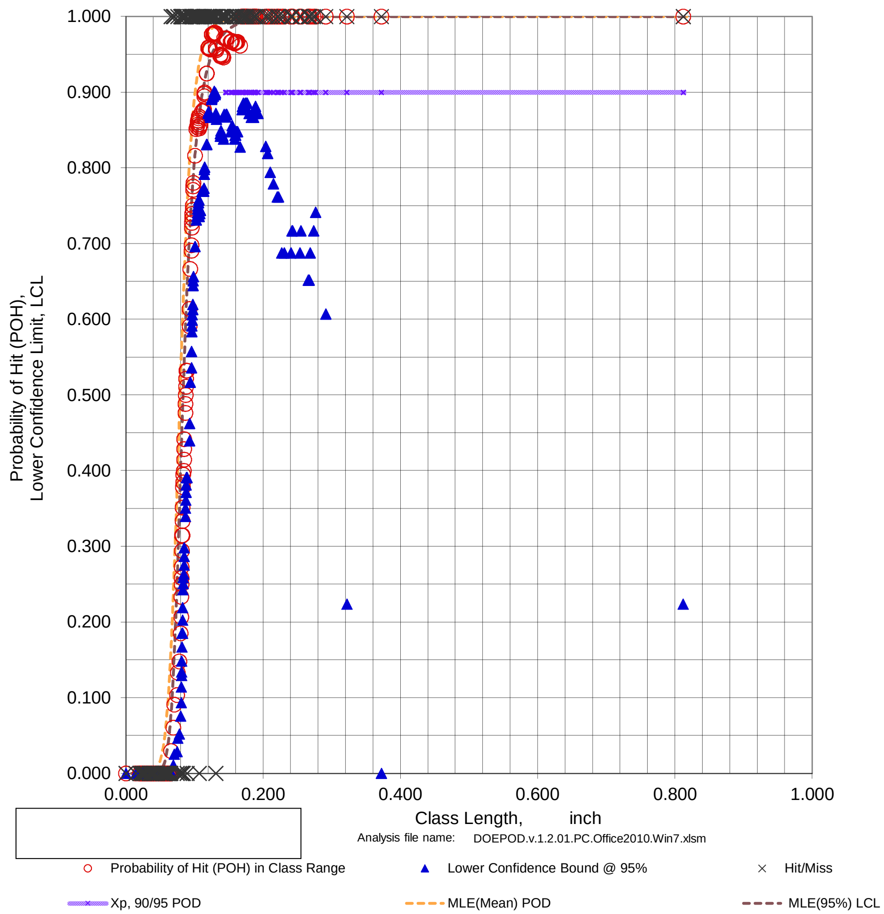
Classlength @ Best LCL = inch

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

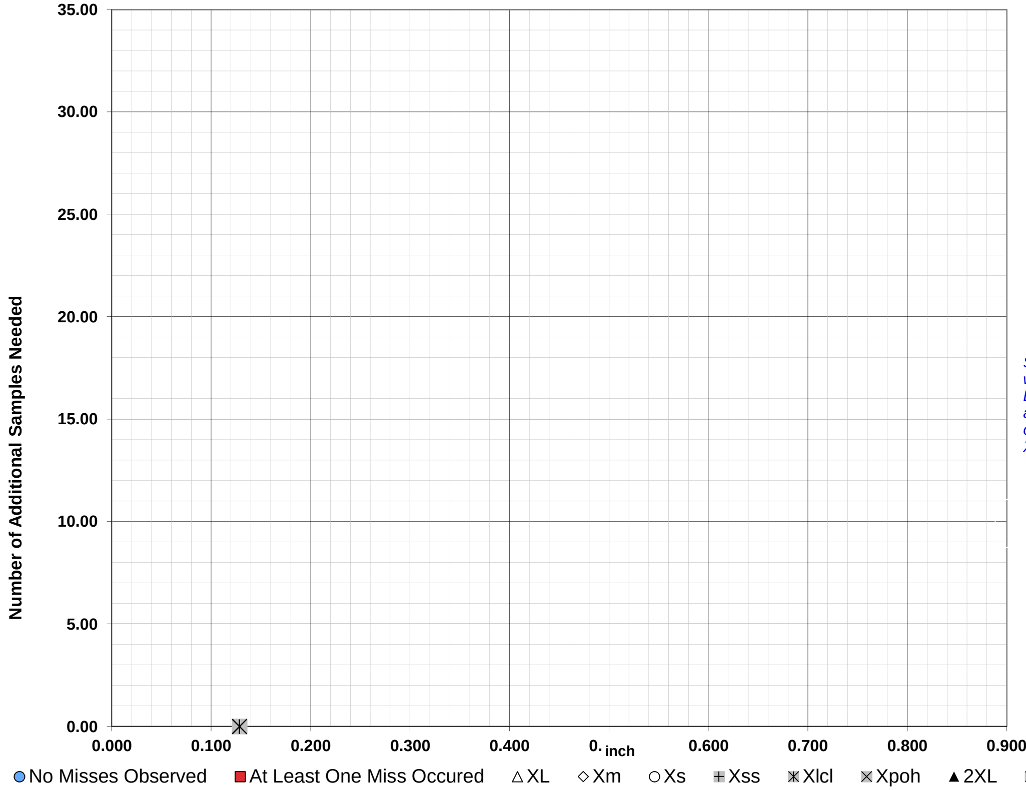


TABLE C

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

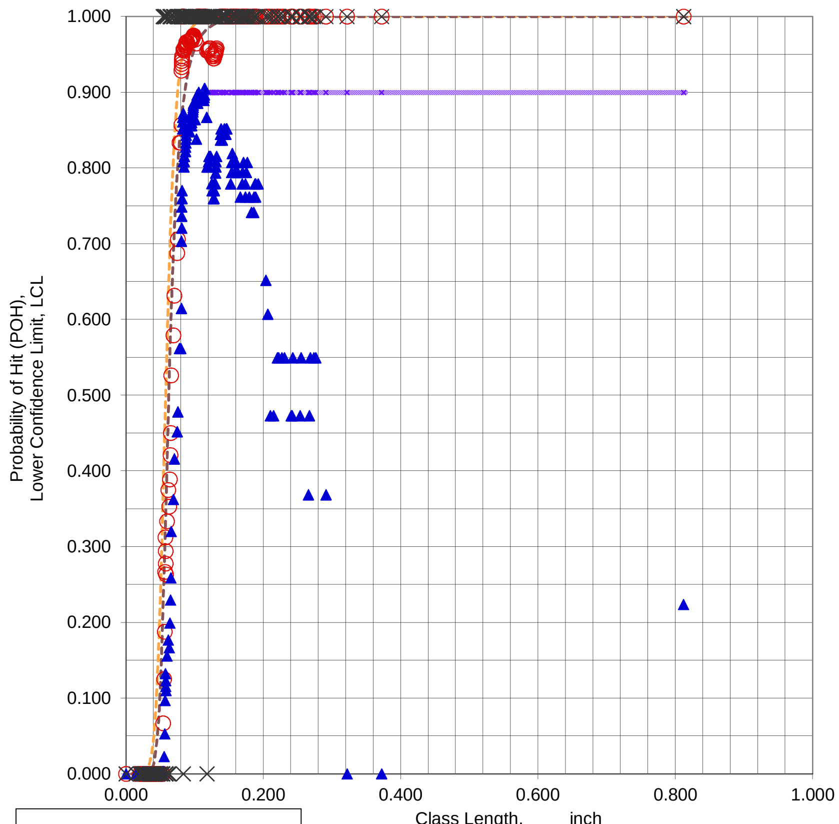
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

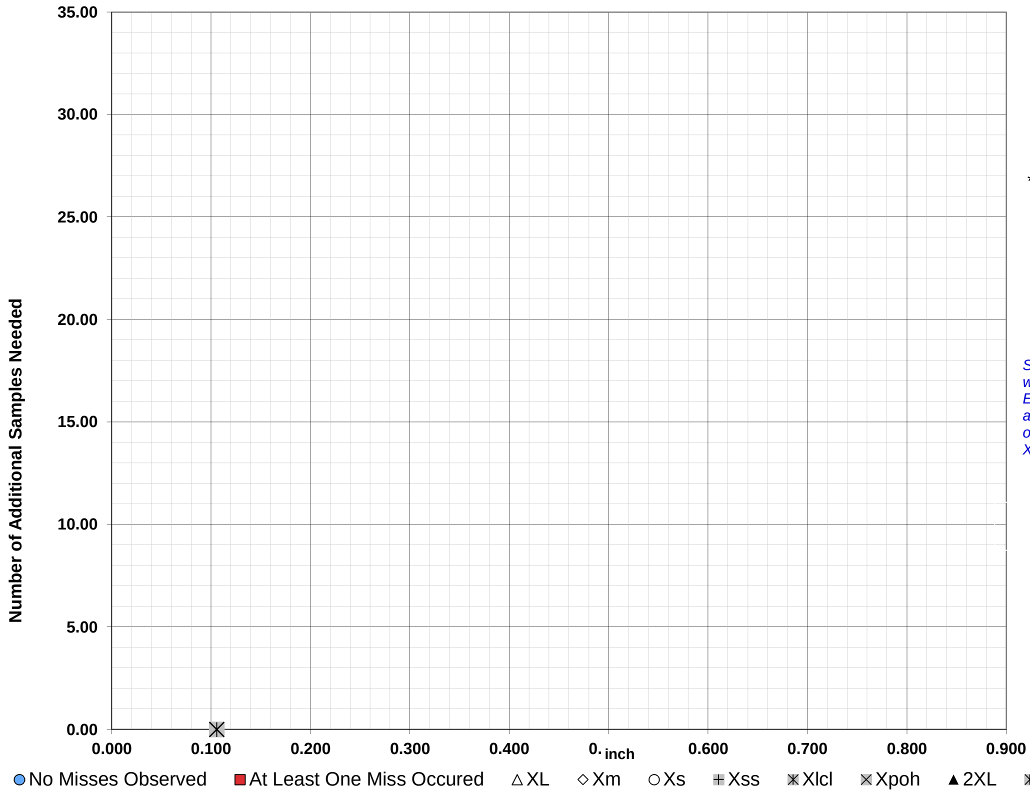


TABLE C

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

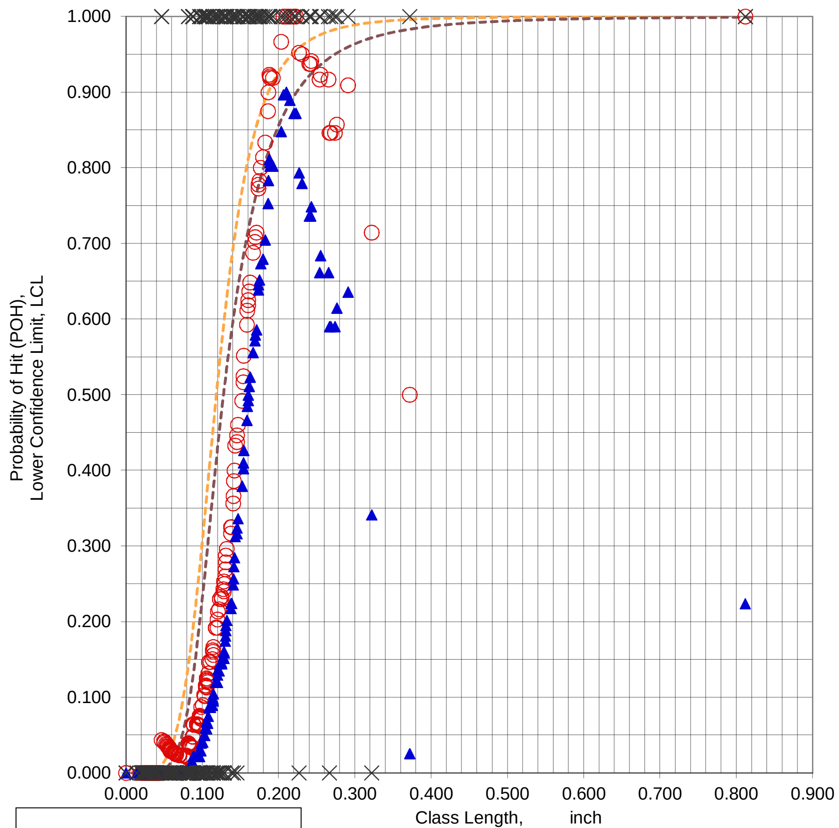
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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



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

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

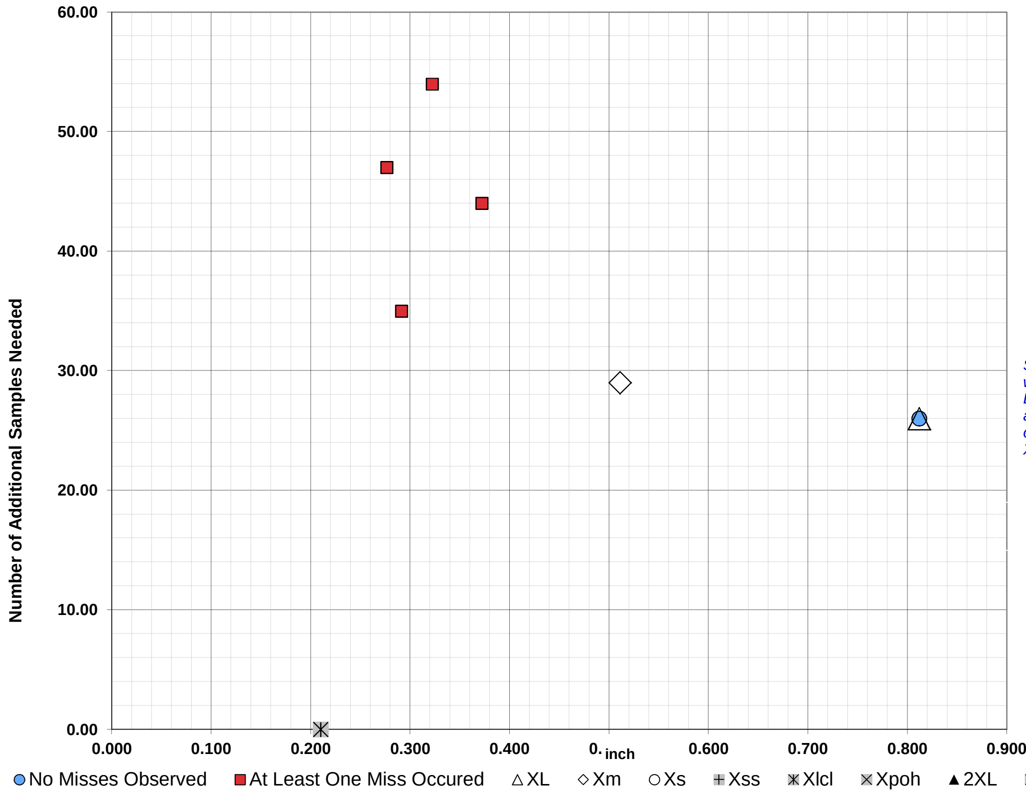


TABLE C

	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

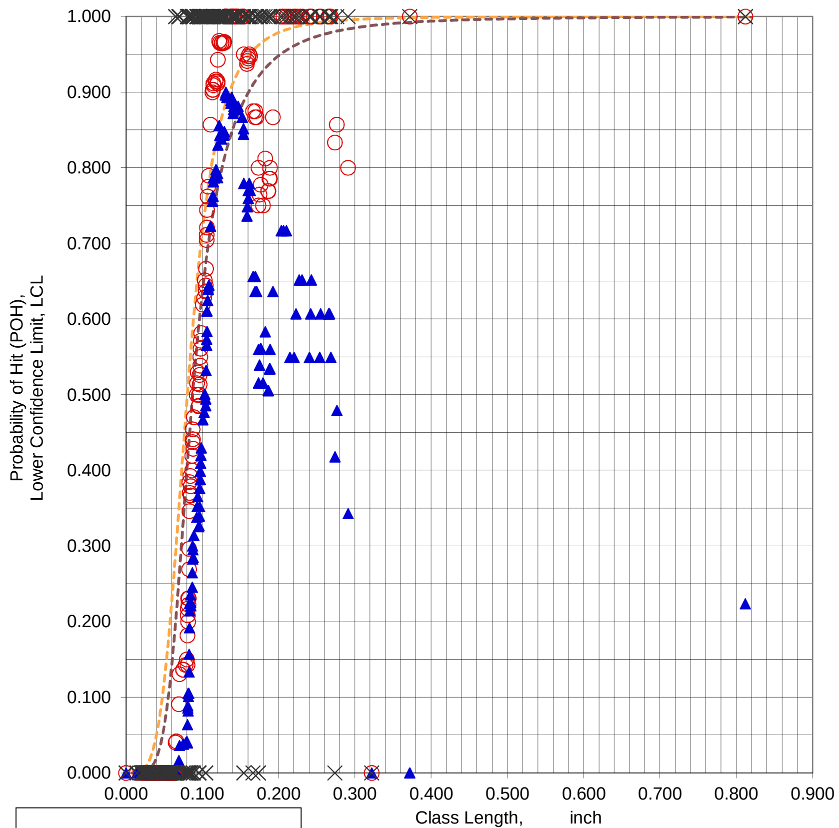
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

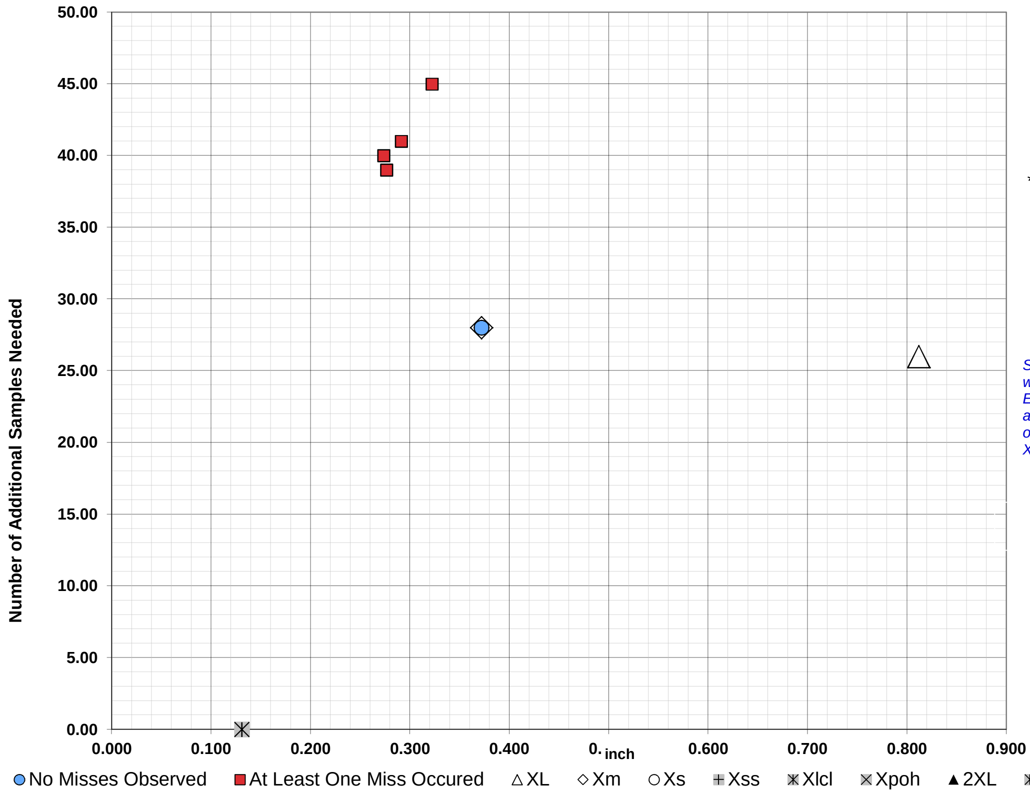


TABLE C

	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)

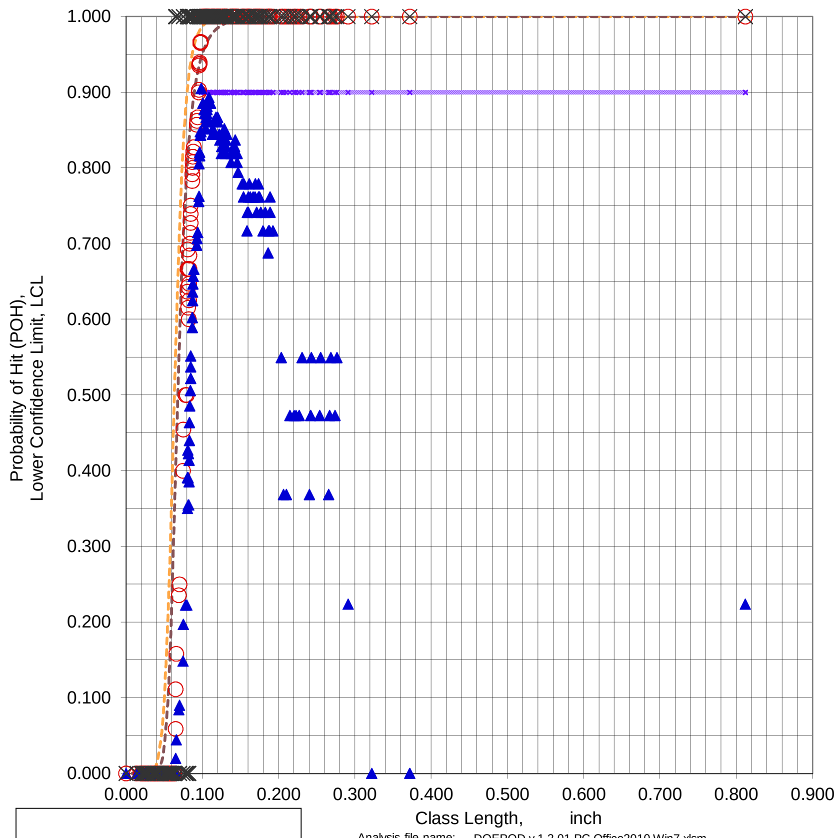
Large flaw validation failure. Need 15 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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



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

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

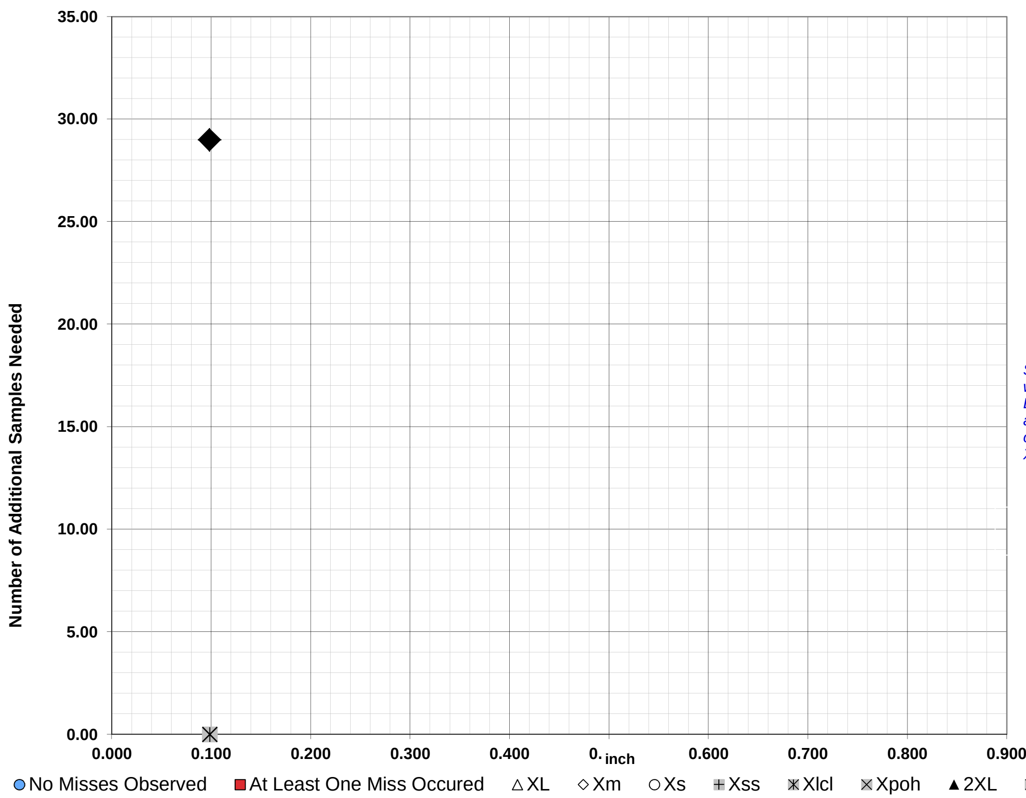


TABLE C

	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.

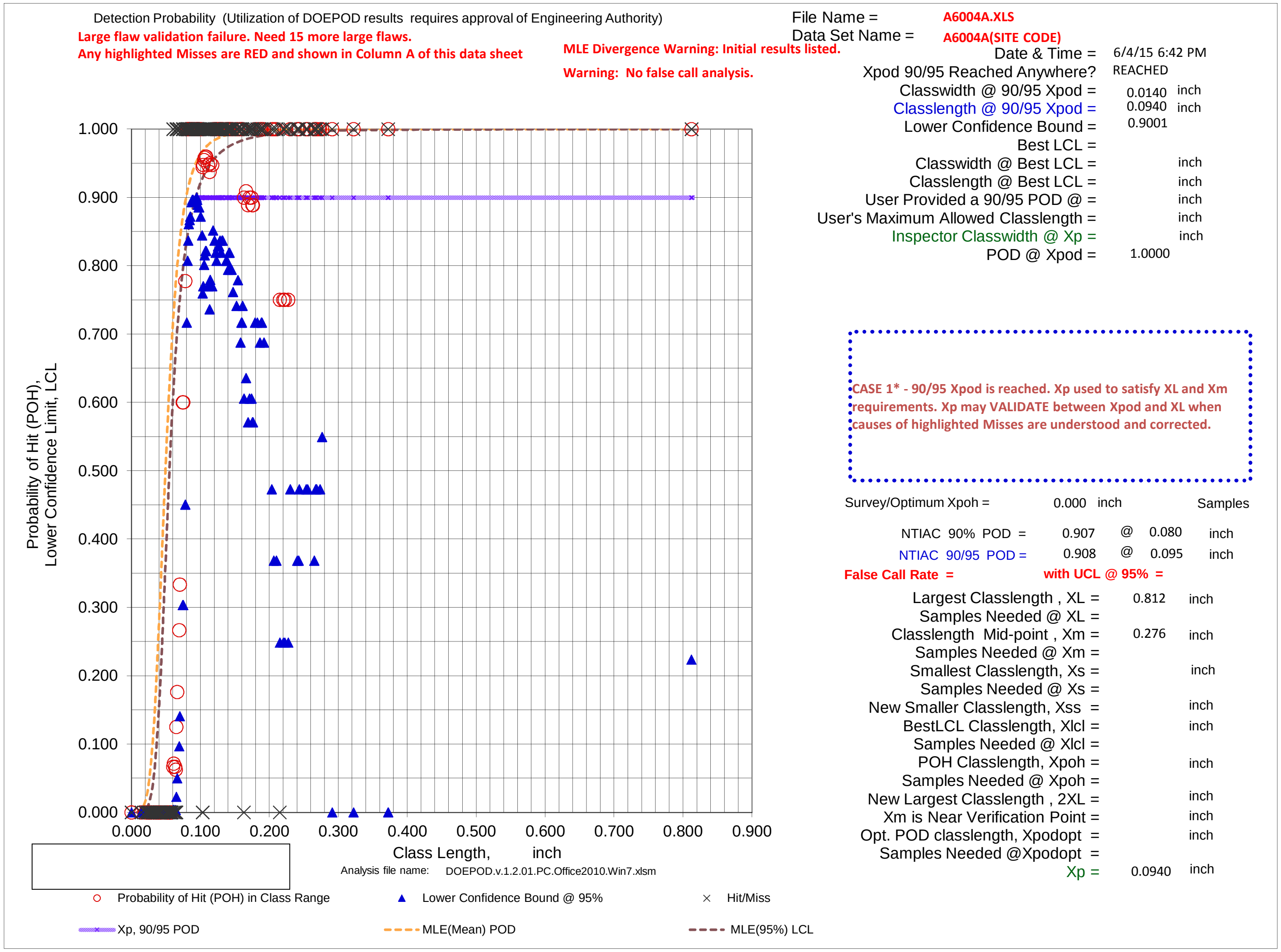
Xpod,Class Length	No. Need

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
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
0.900
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 = A6004A.XLS
Data Set Name = A6004A(SITE CODE)

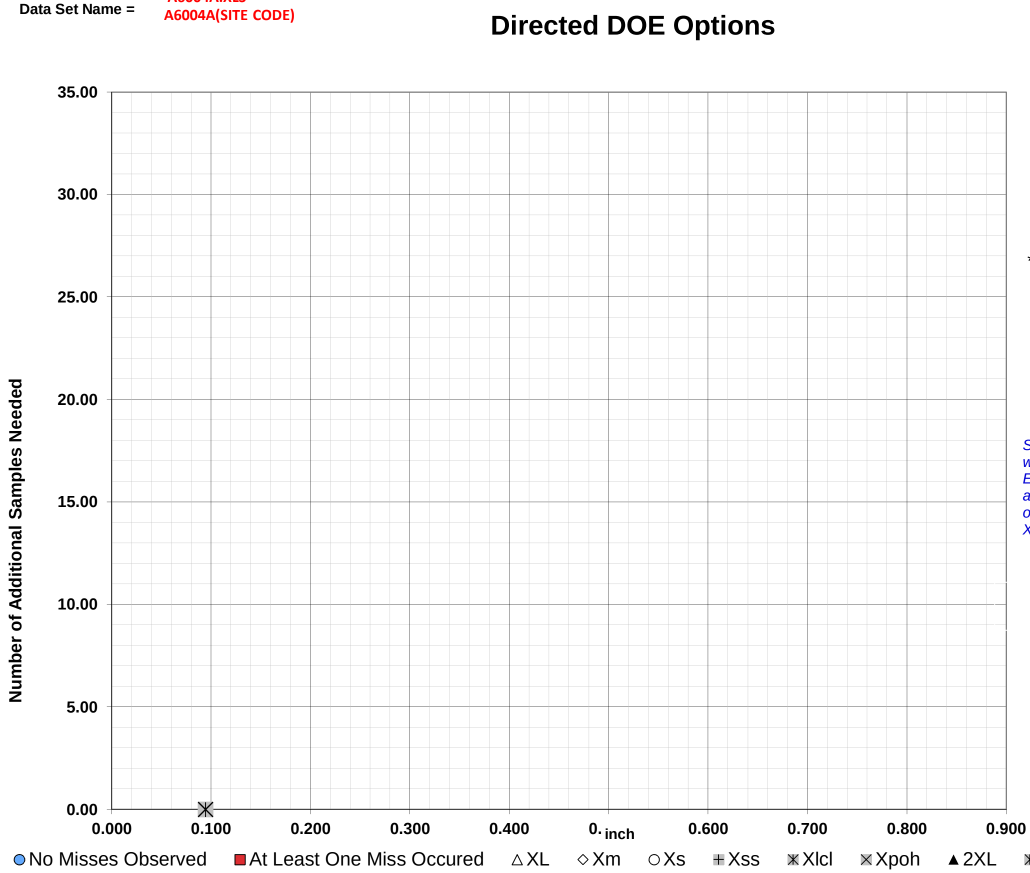


TABLE C

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

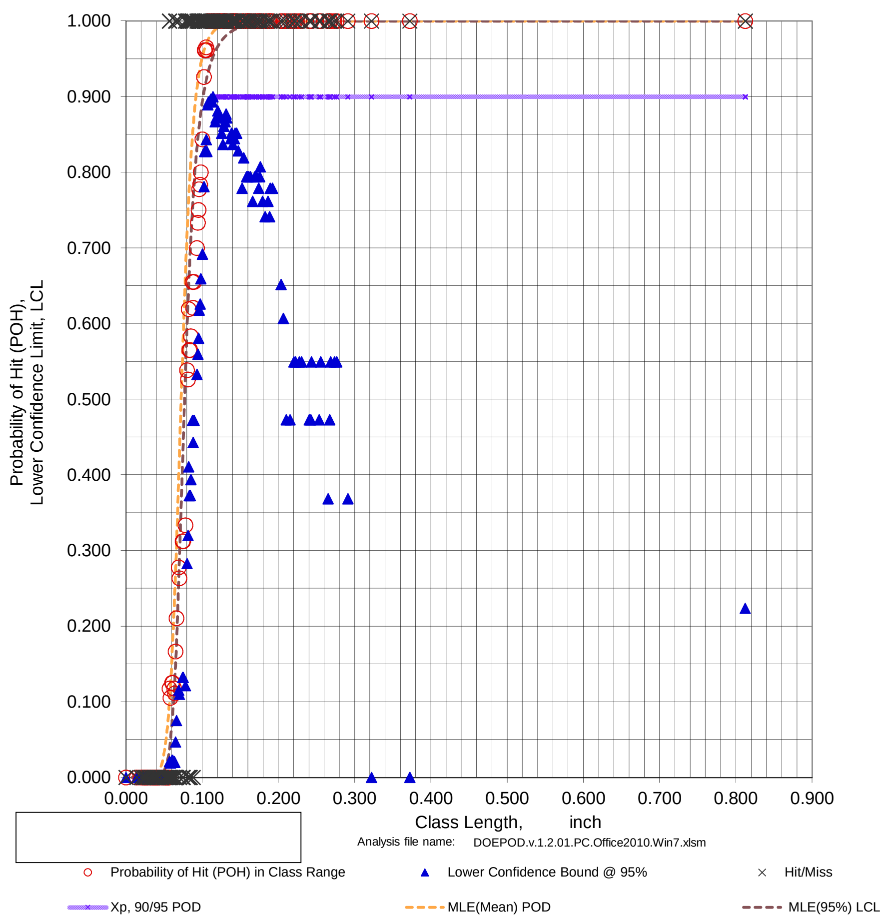
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

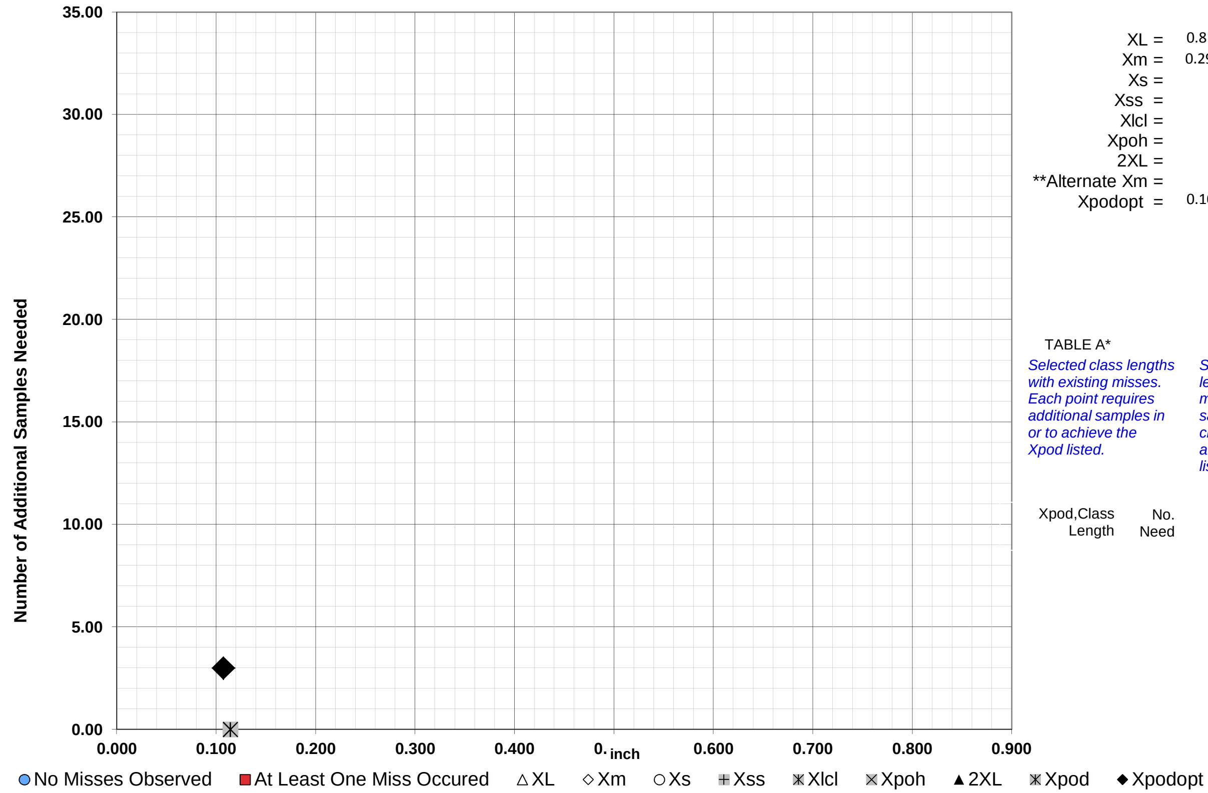


TABLE C

	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.

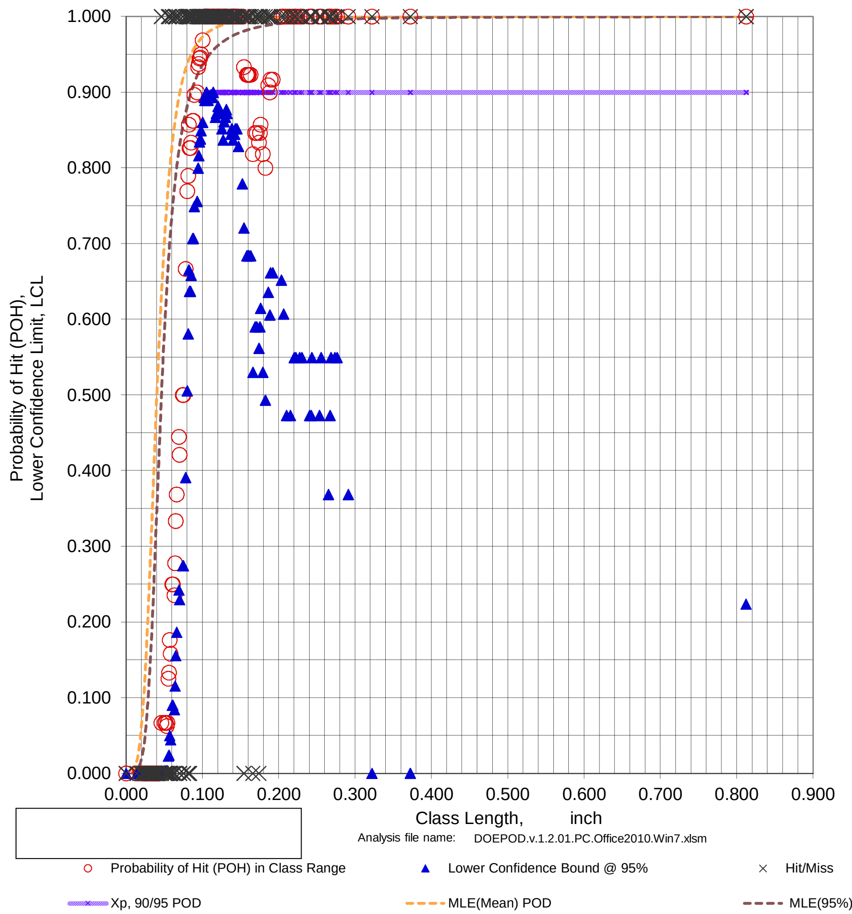
Any highlighted Misses are RED and shown in Column A of this data sheet

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

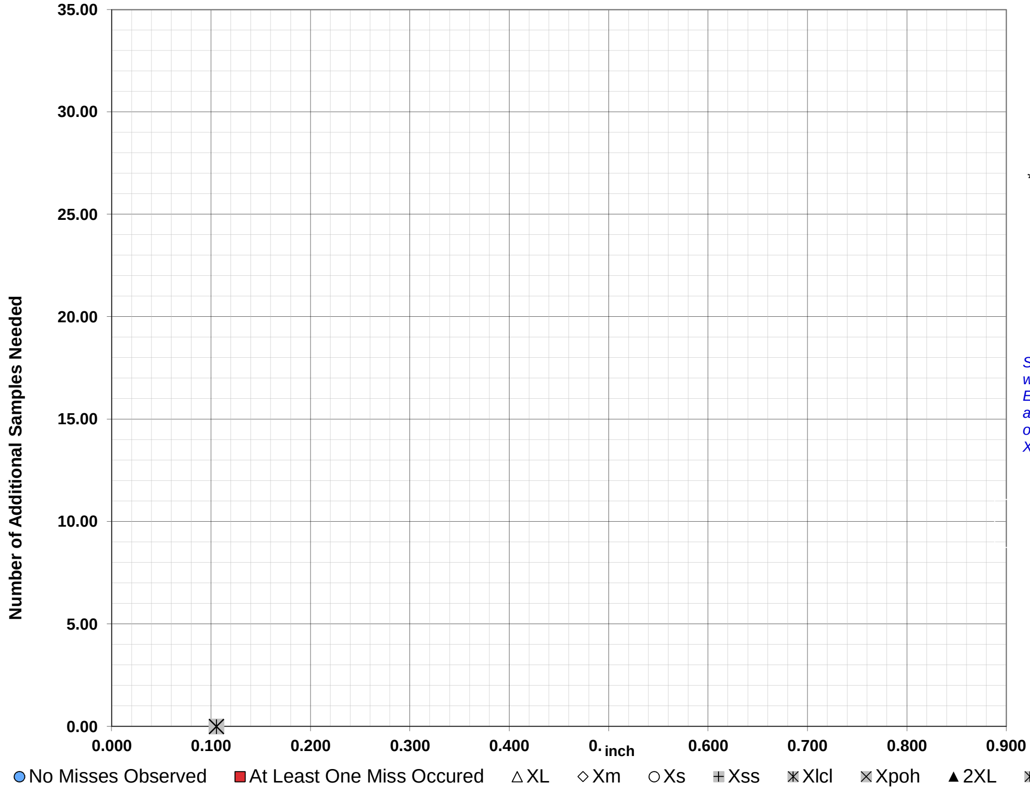


TABLE C

	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*

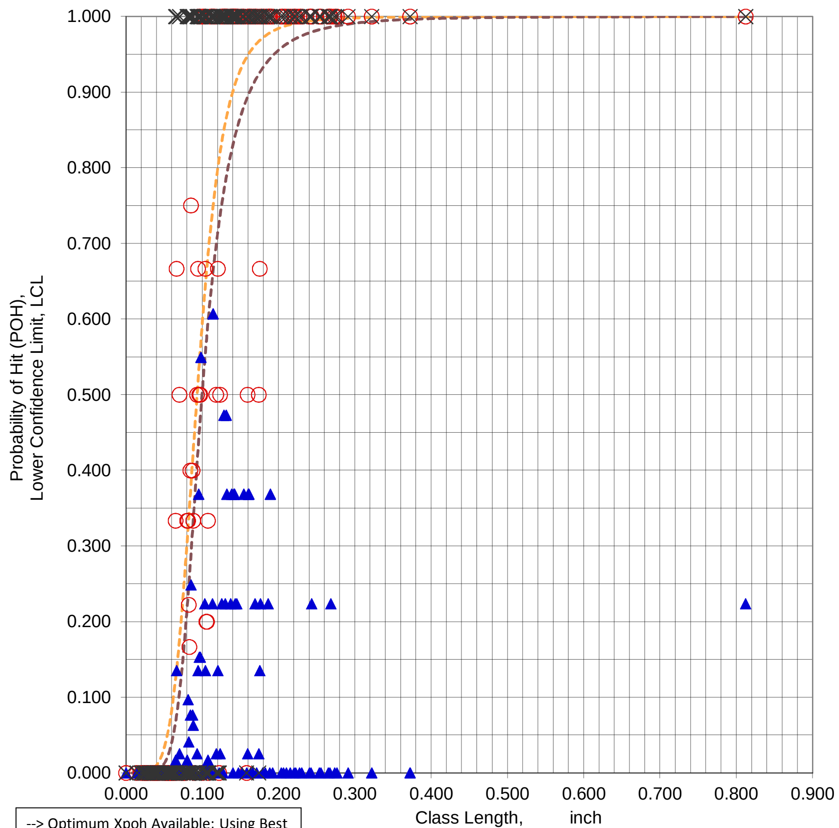
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



--> 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 = 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

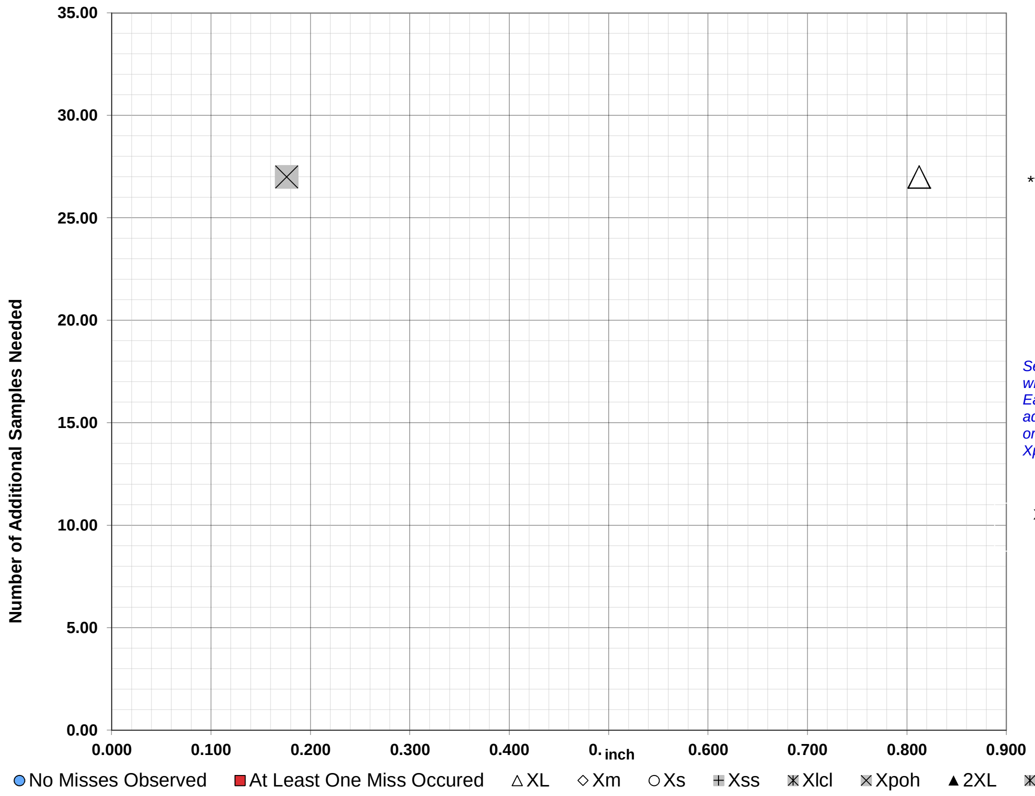


TABLE C

	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

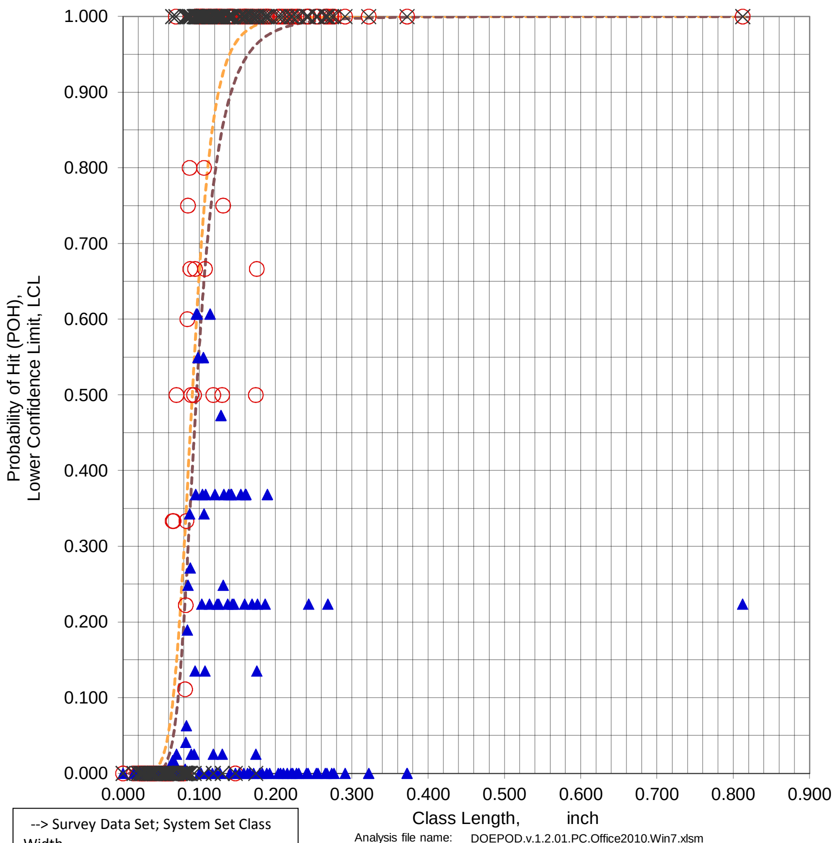
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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 =



--> Survey Data Set; System Set Class Width

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

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

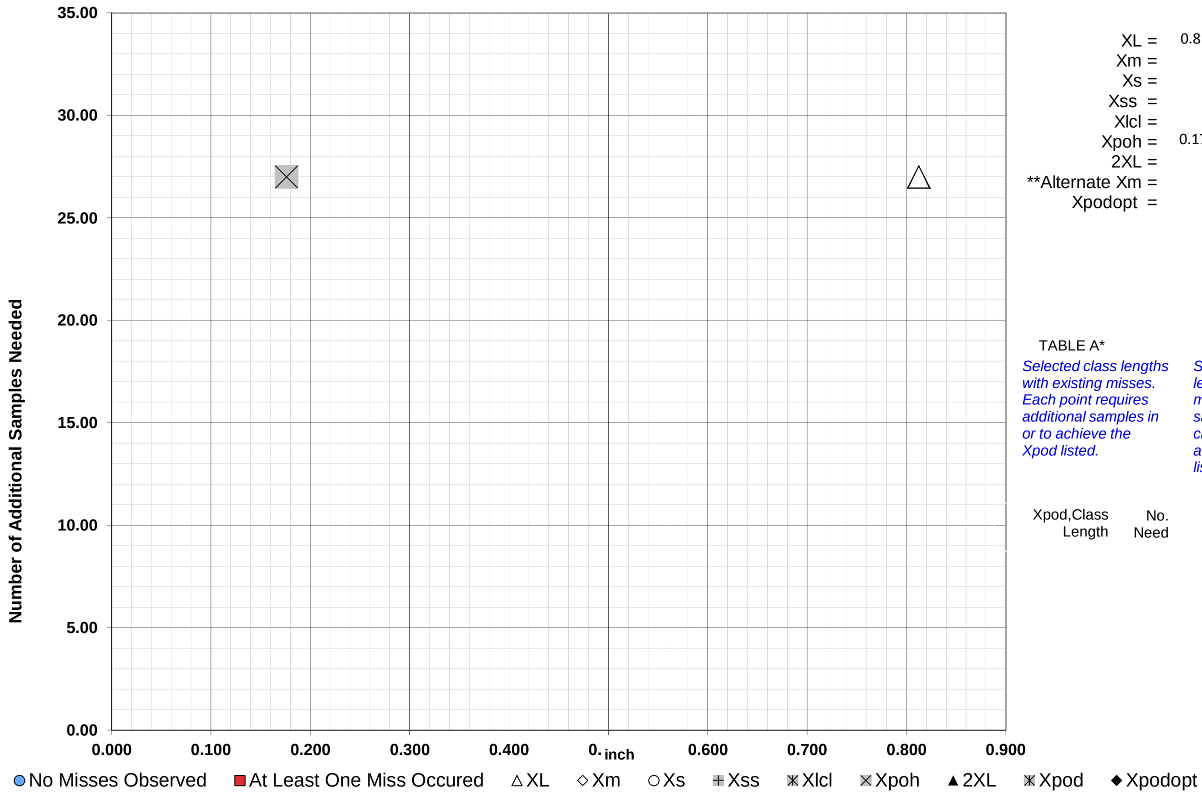


TABLE C

	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

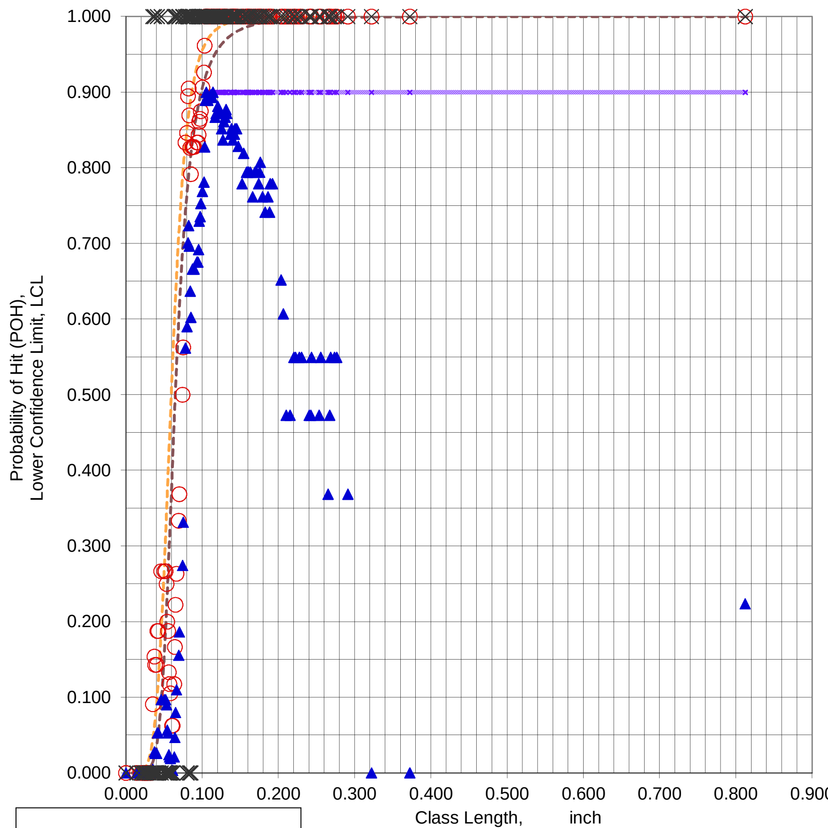
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = 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

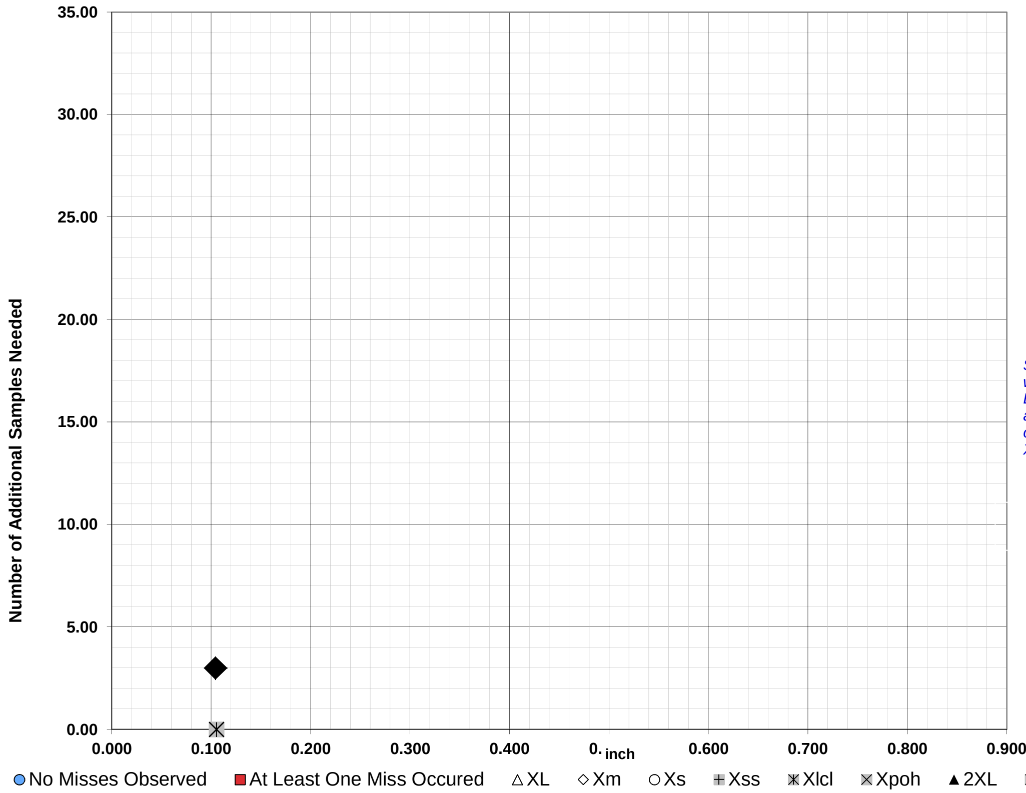


TABLE C

	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

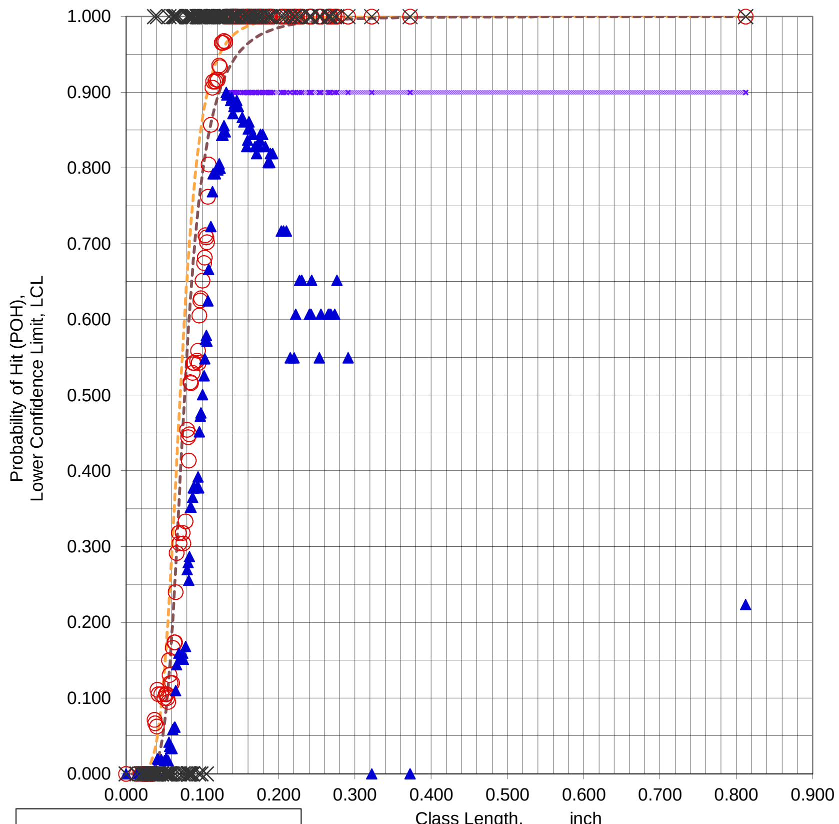
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

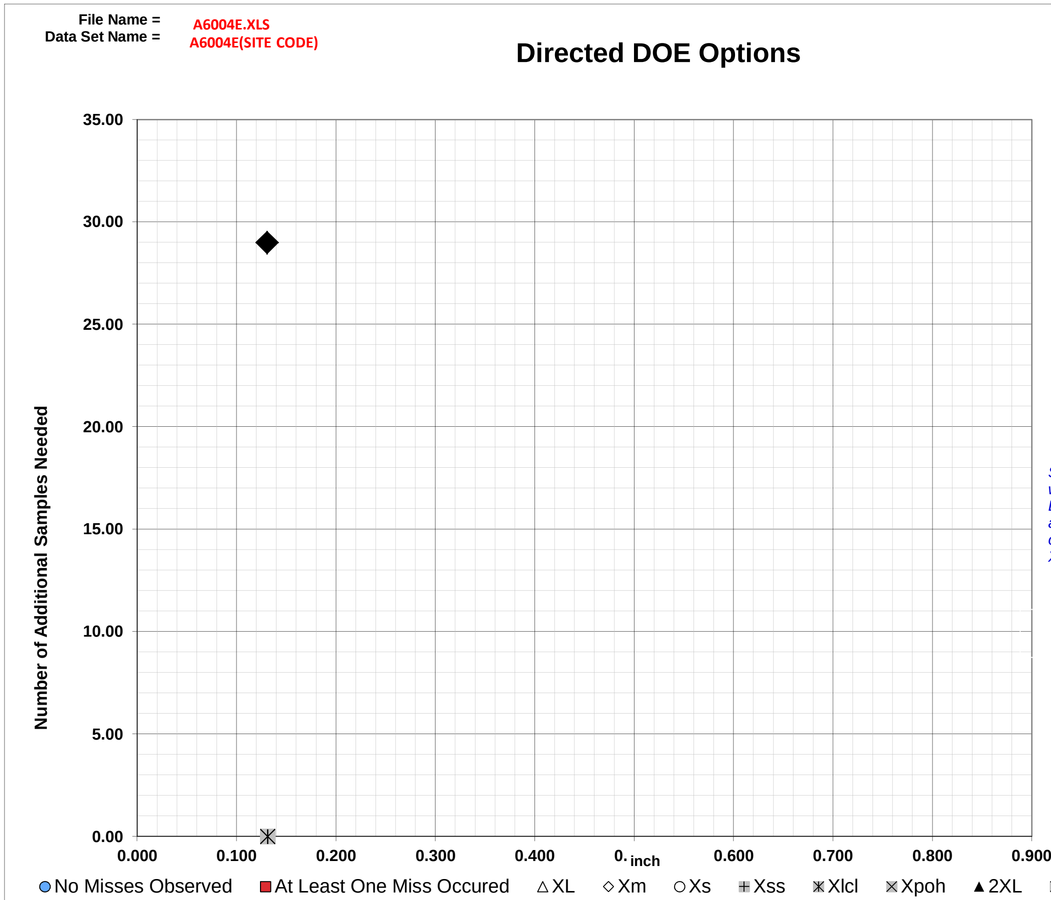


TABLE C

	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

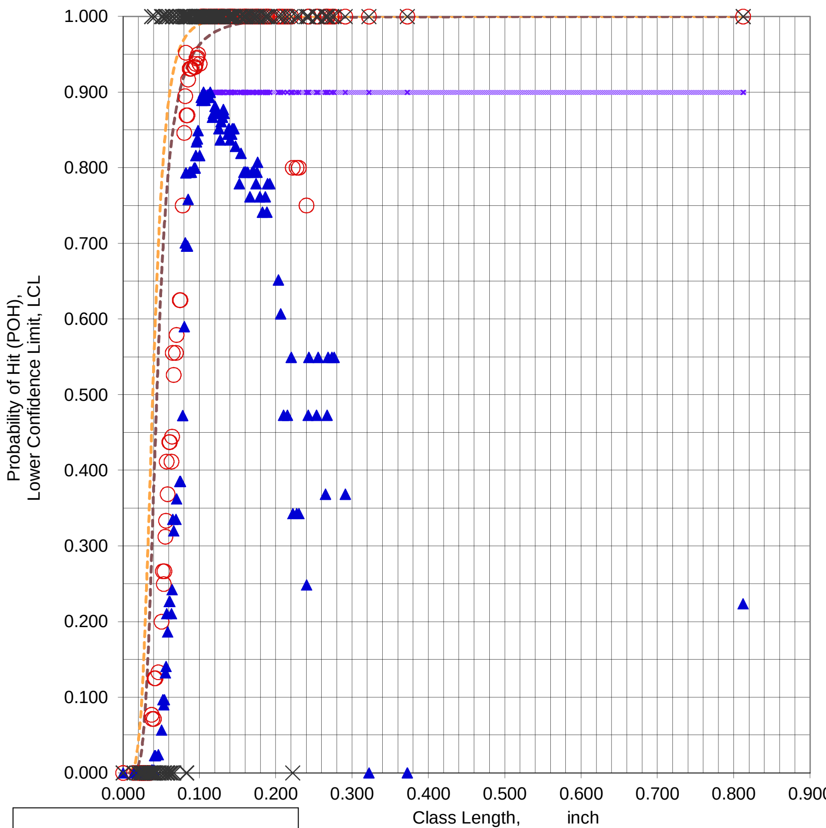
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

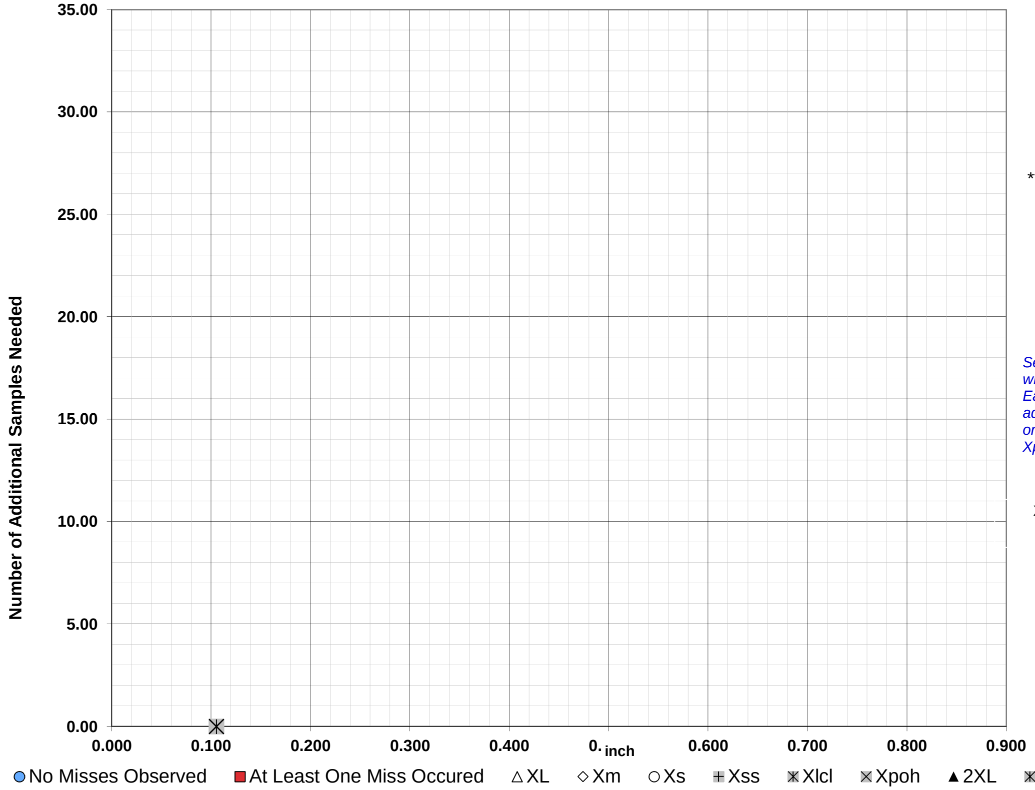


TABLE C

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)

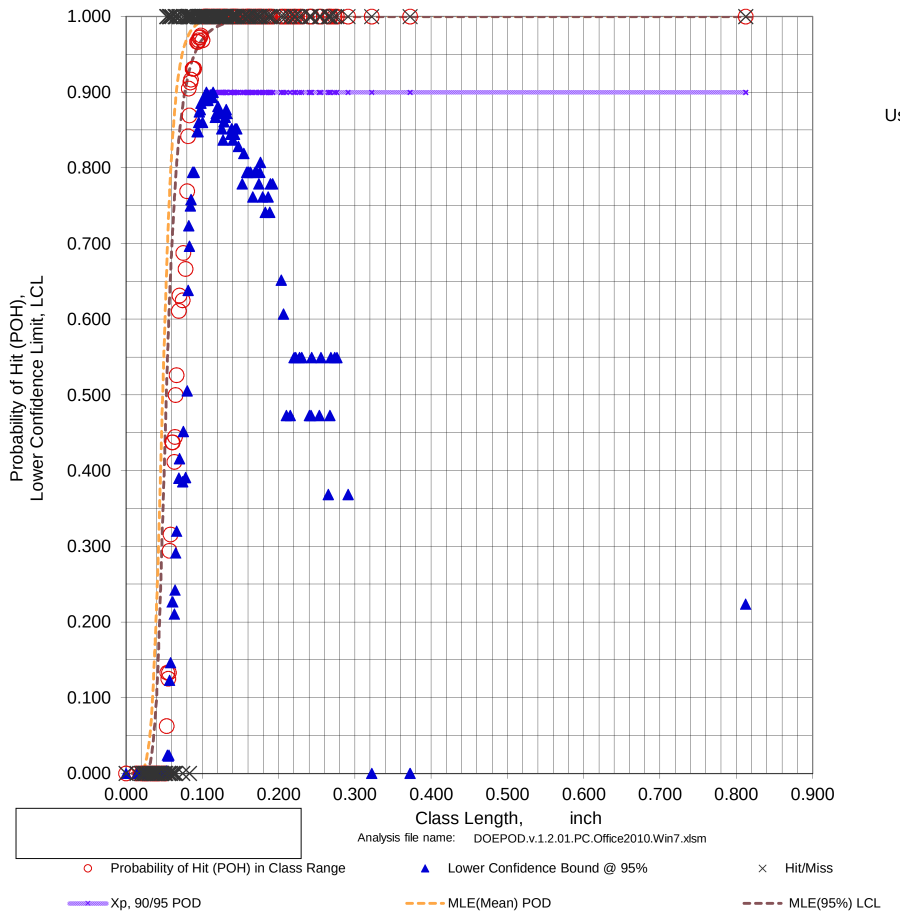
Large flaw validation failure. Need 15 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

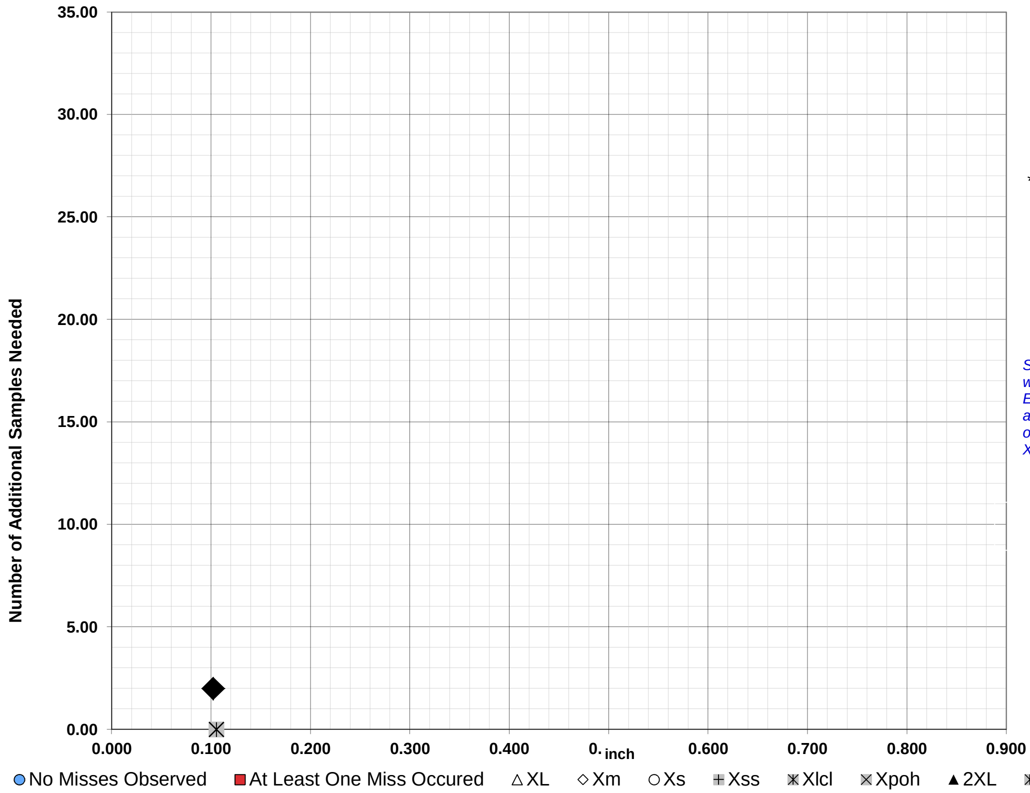


TABLE C

	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

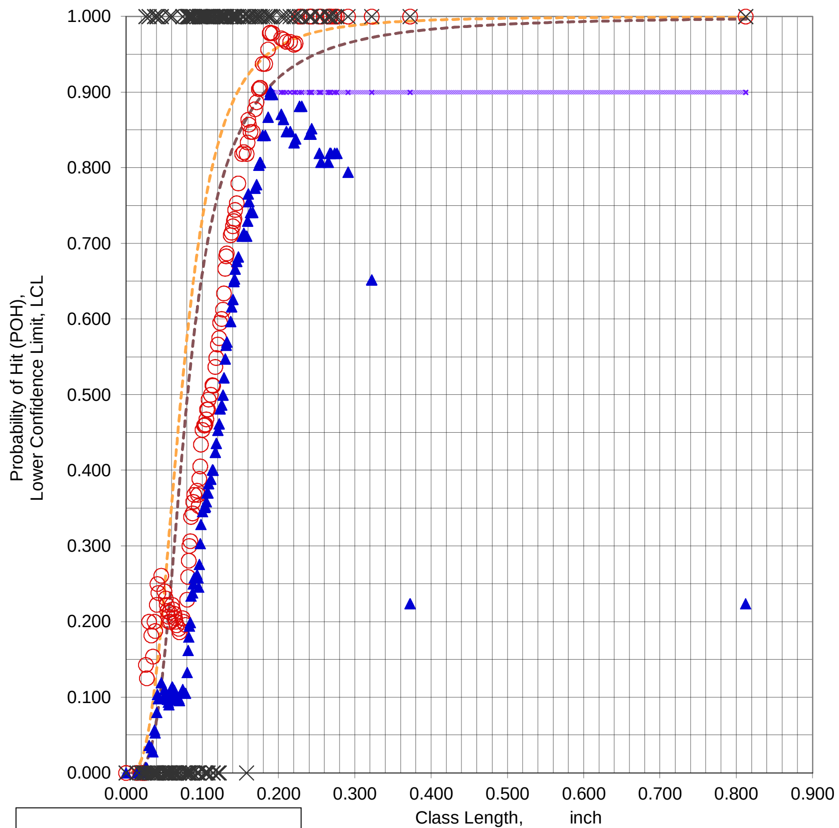
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

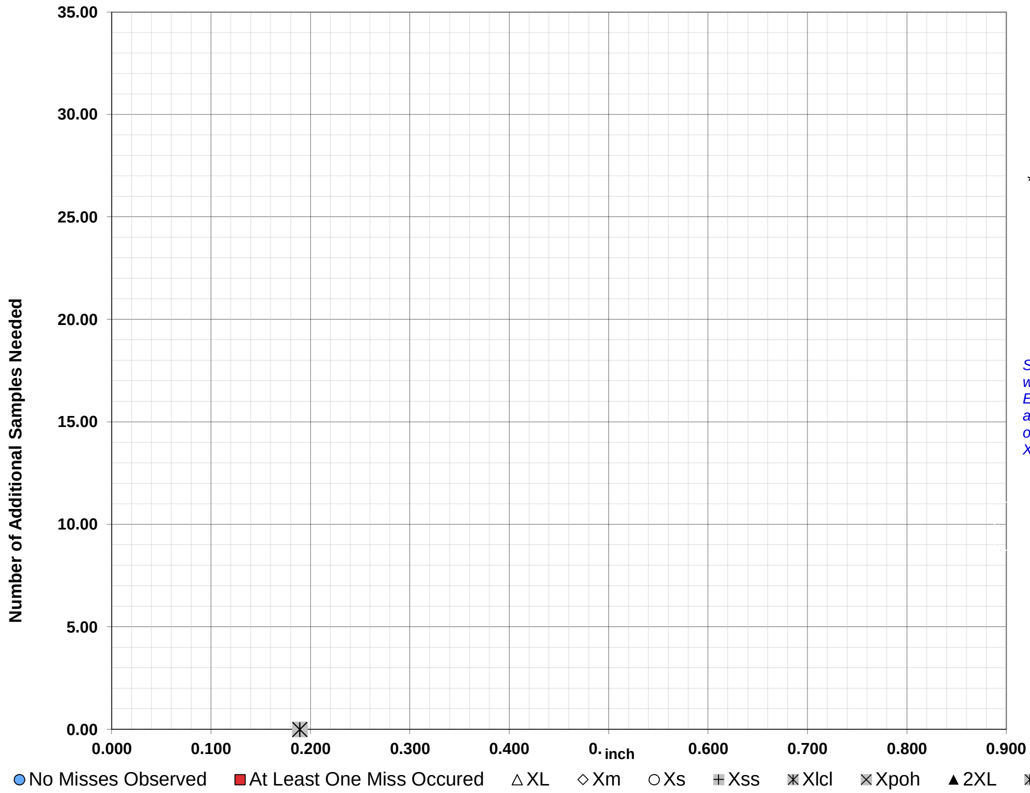


TABLE C

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

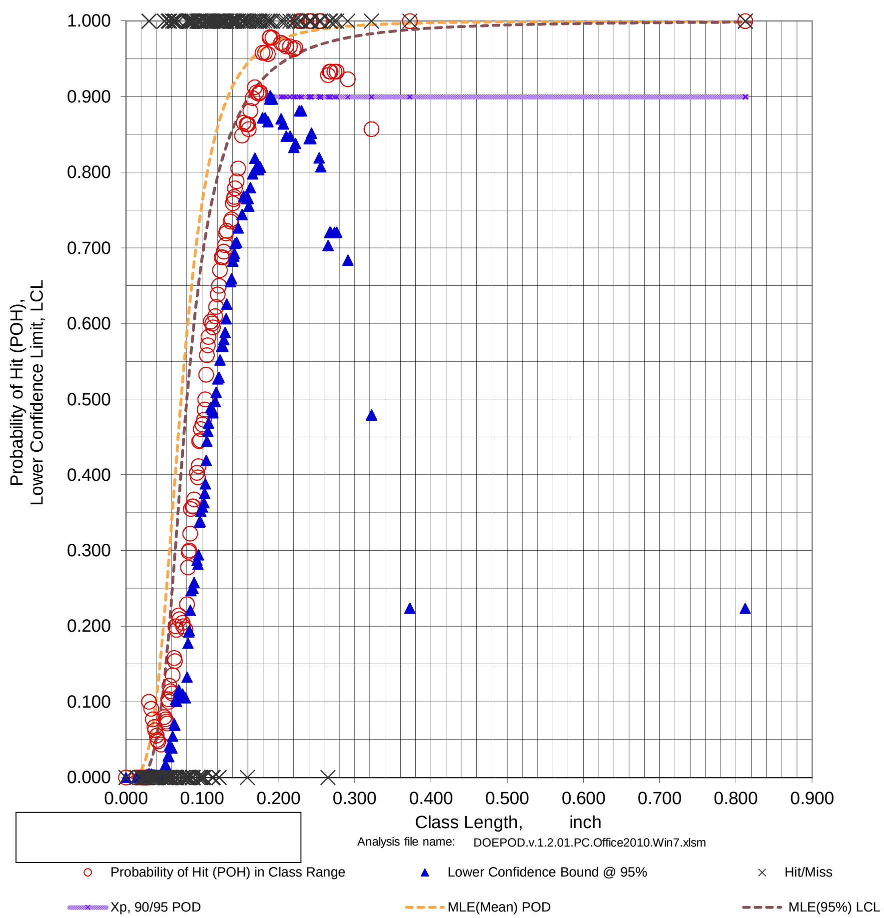
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

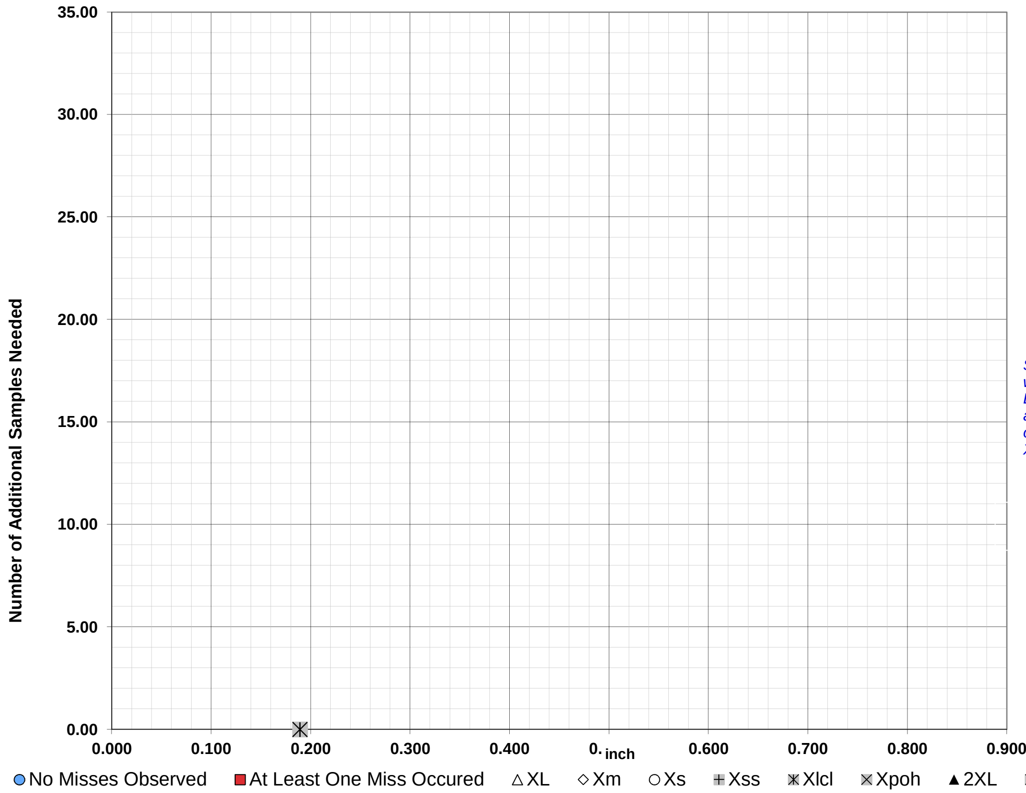


TABLE C

	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

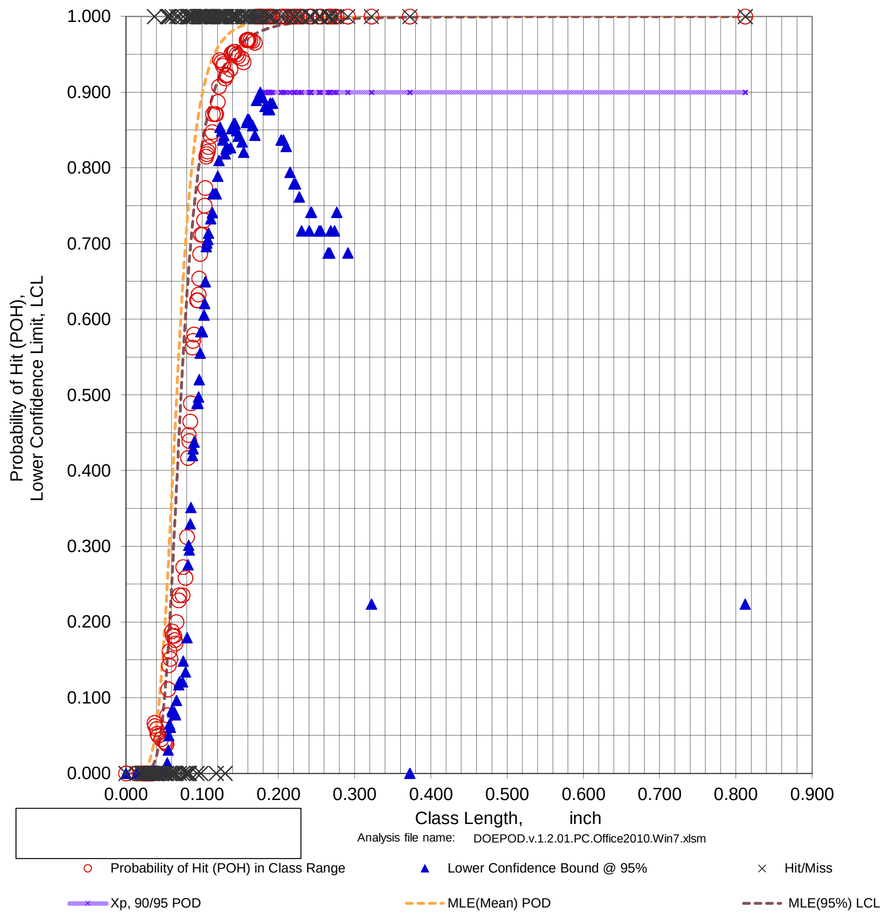
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

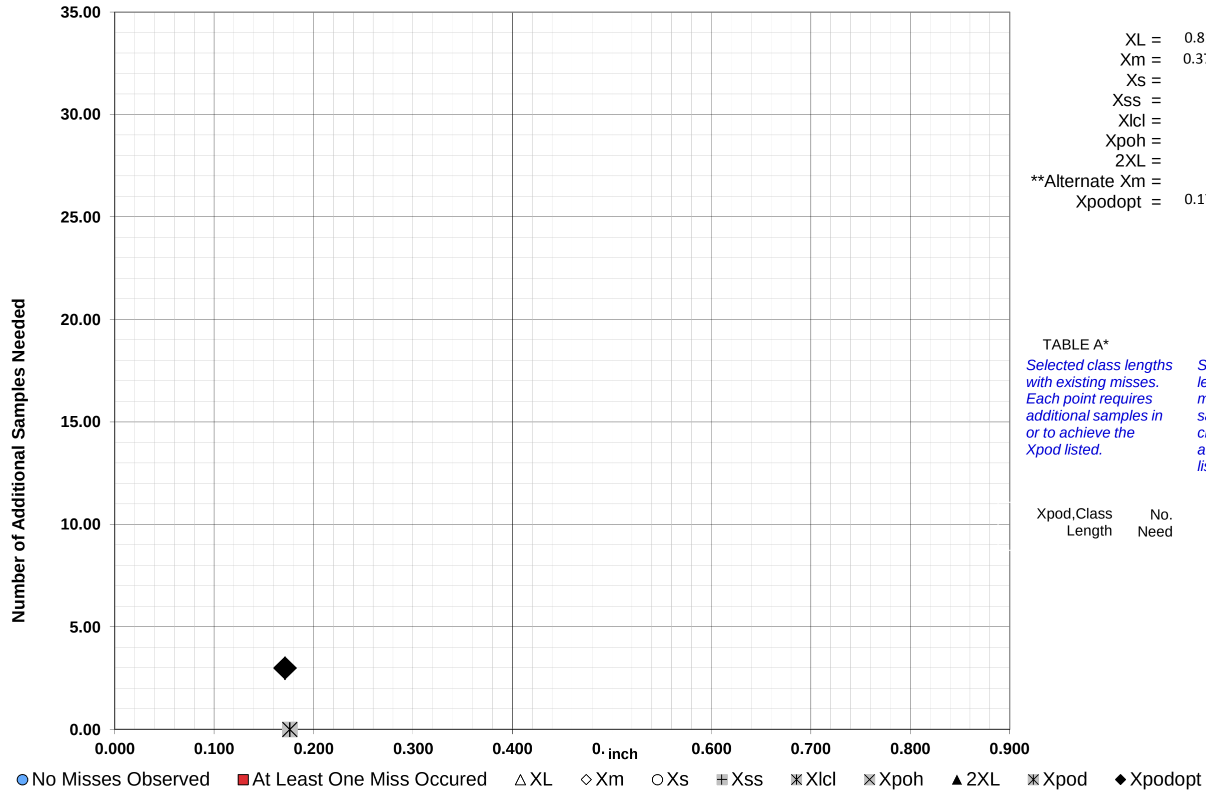


TABLE C

	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*

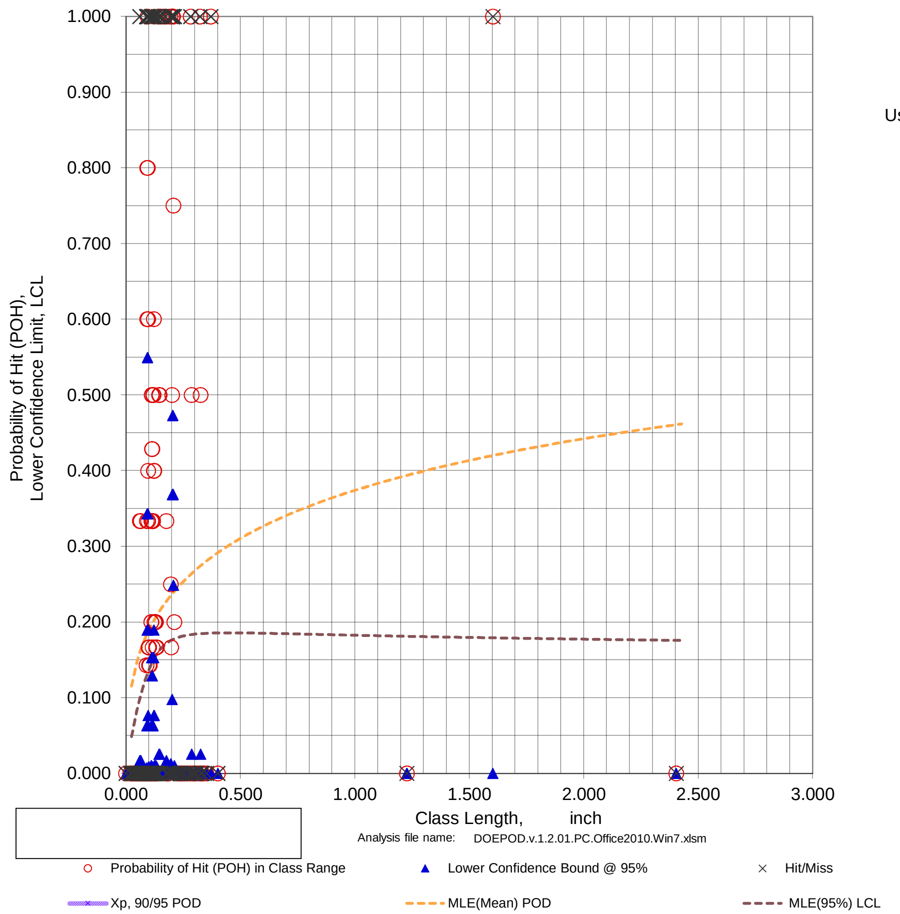
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

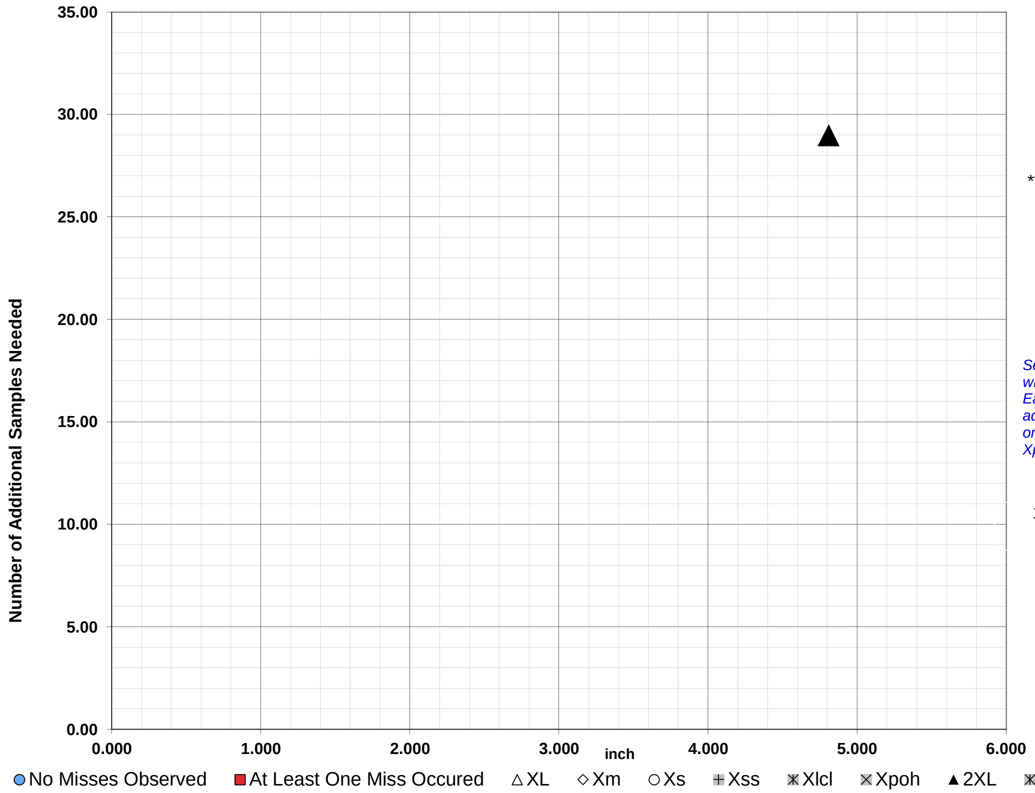


TABLE C

	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*

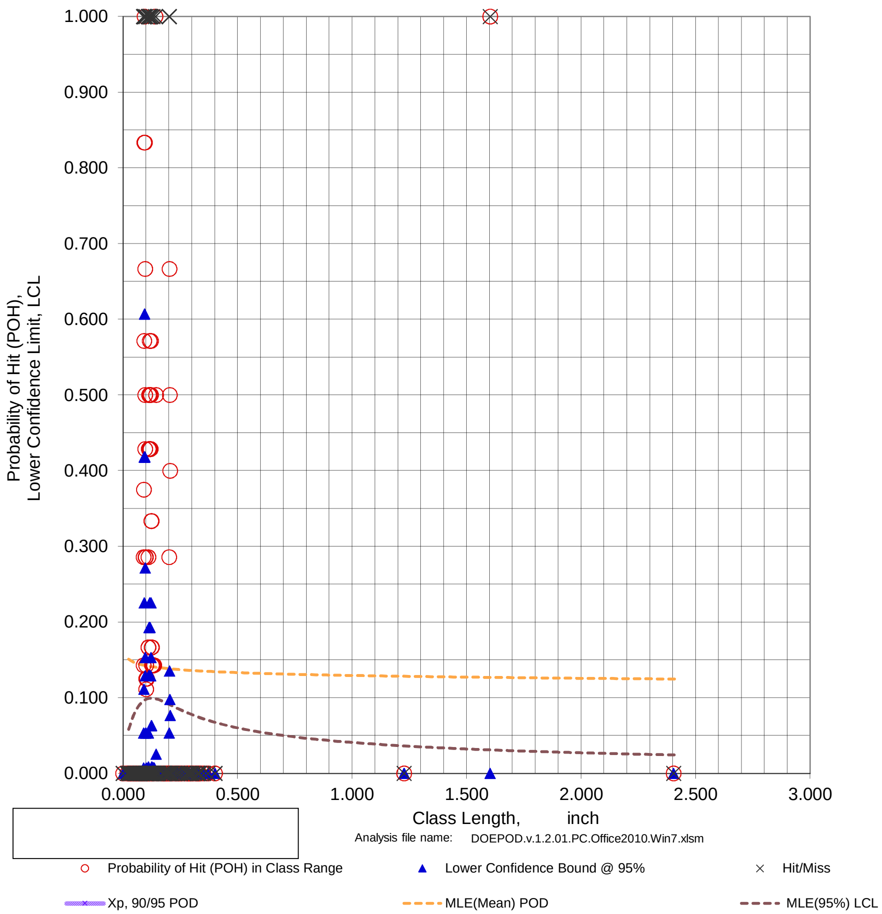
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

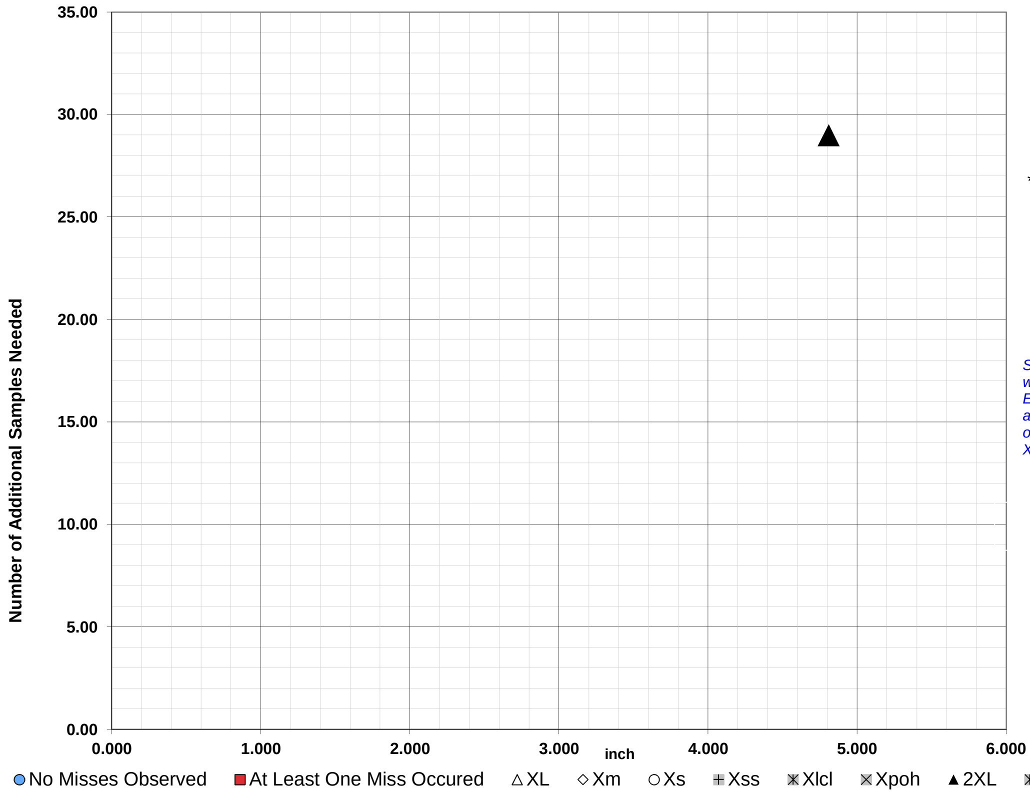


TABLE C

	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*

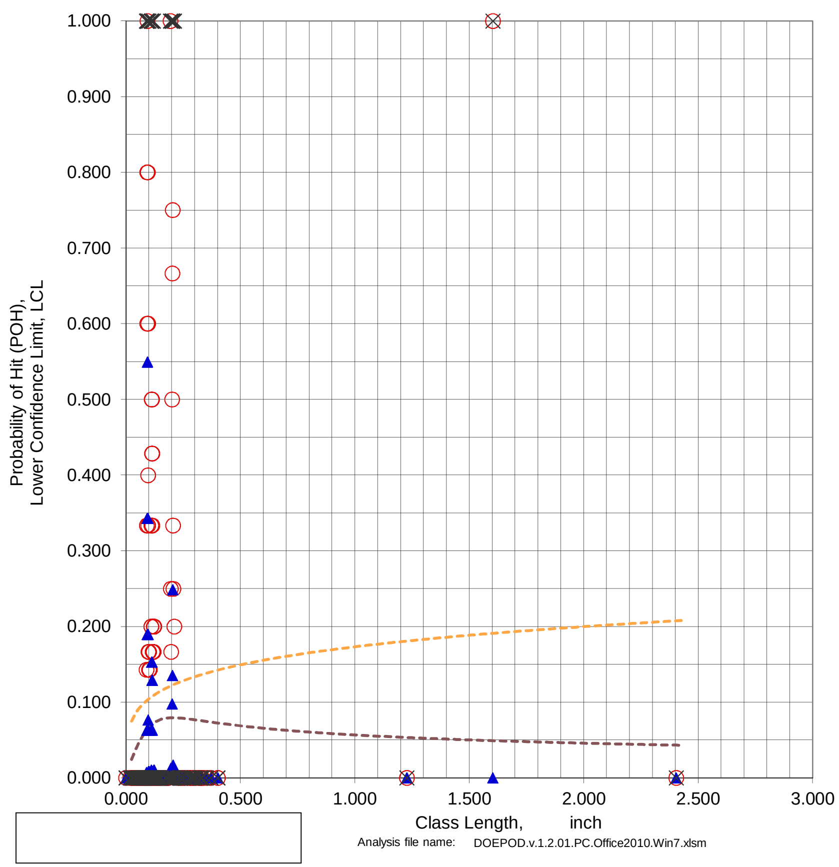
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

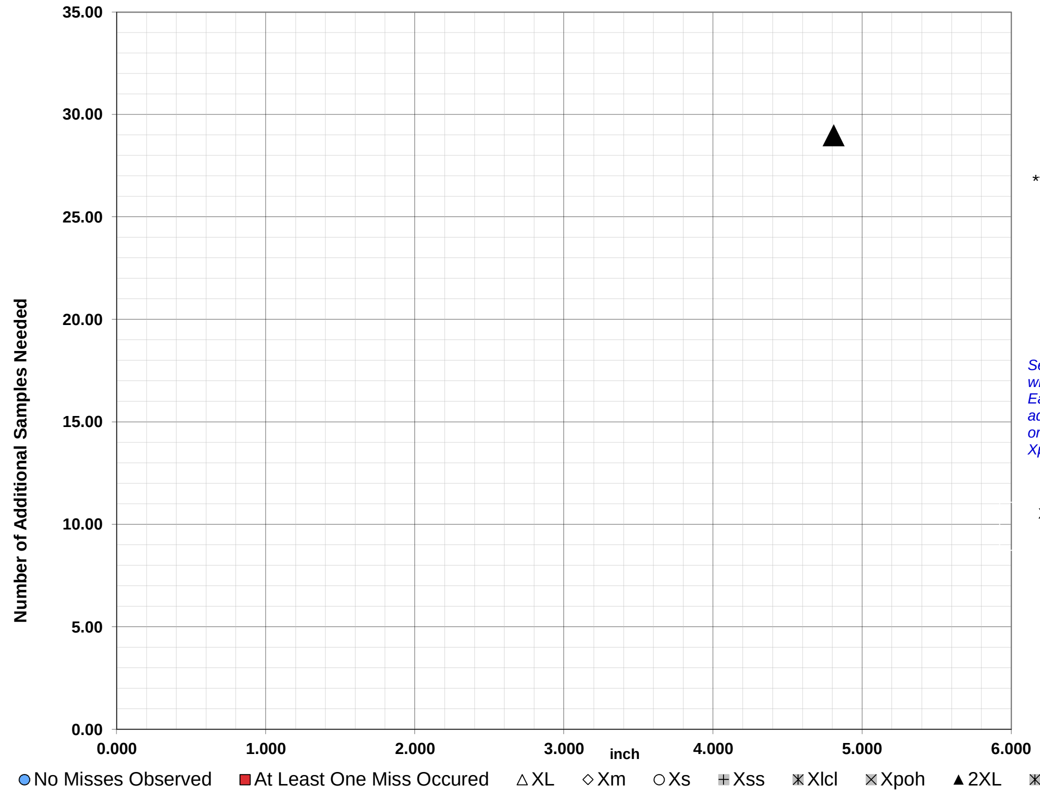


TABLE C

	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*

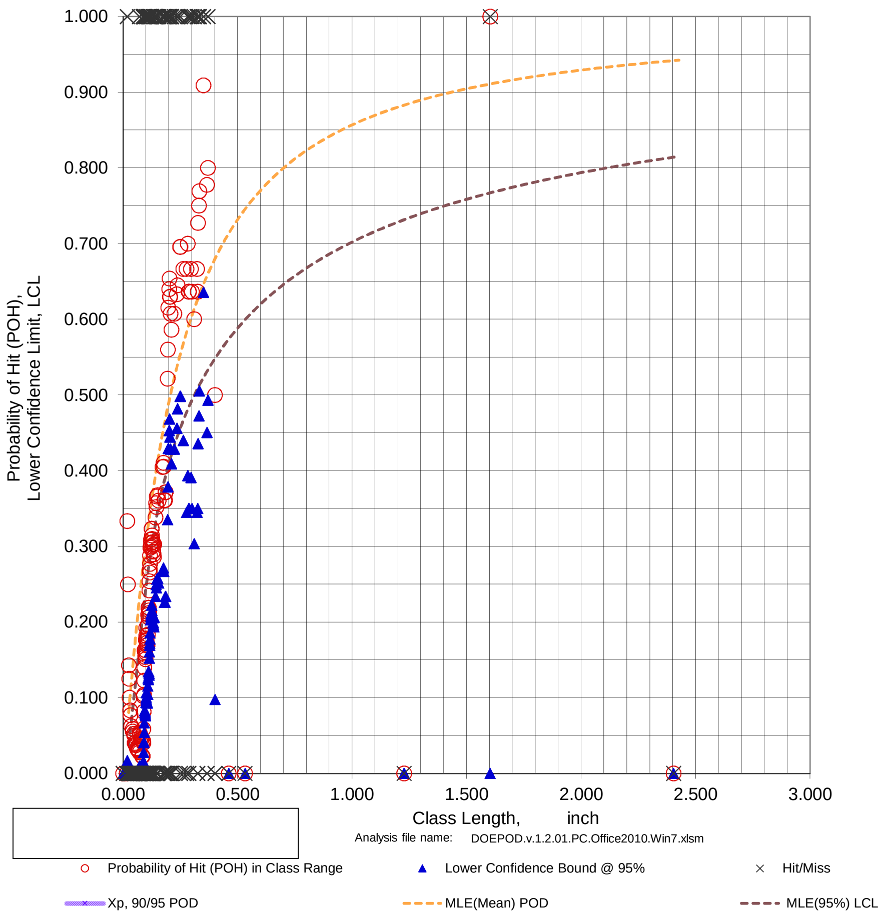
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

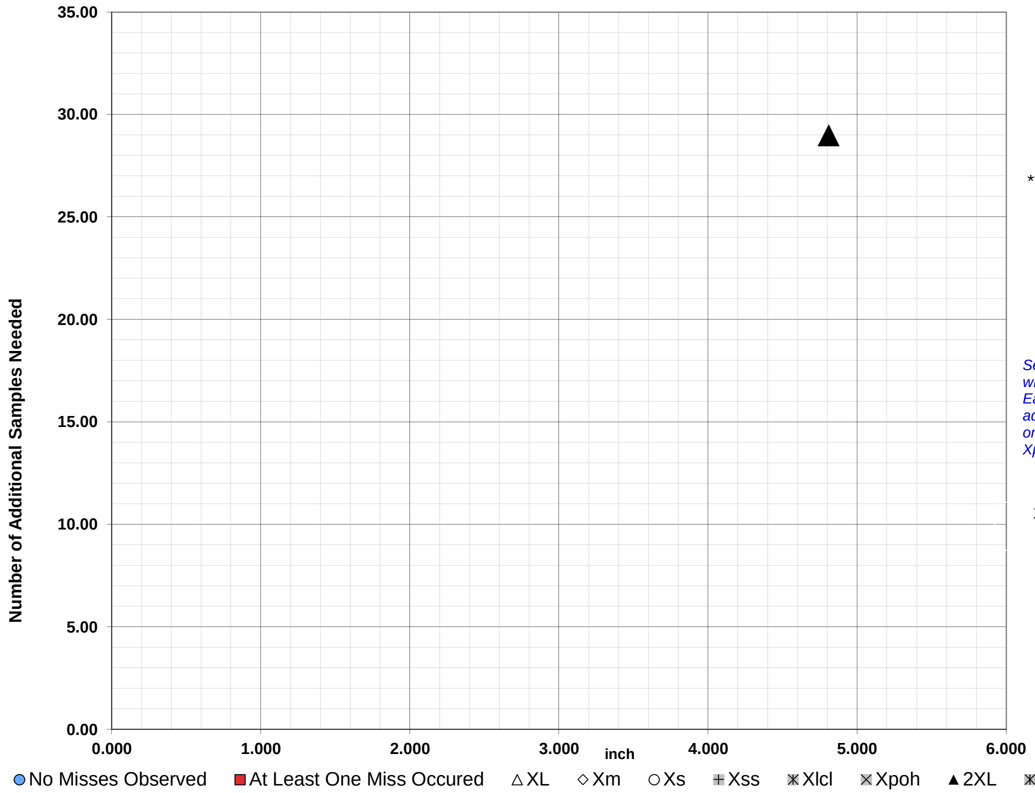


TABLE C

	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*

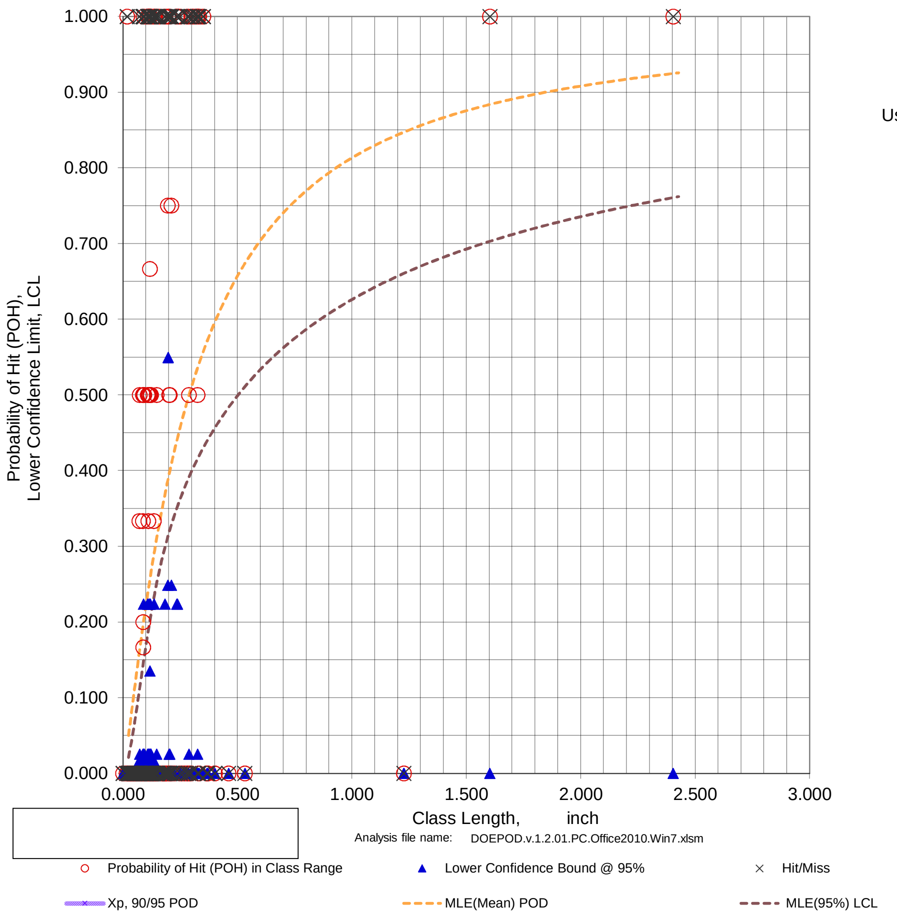
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

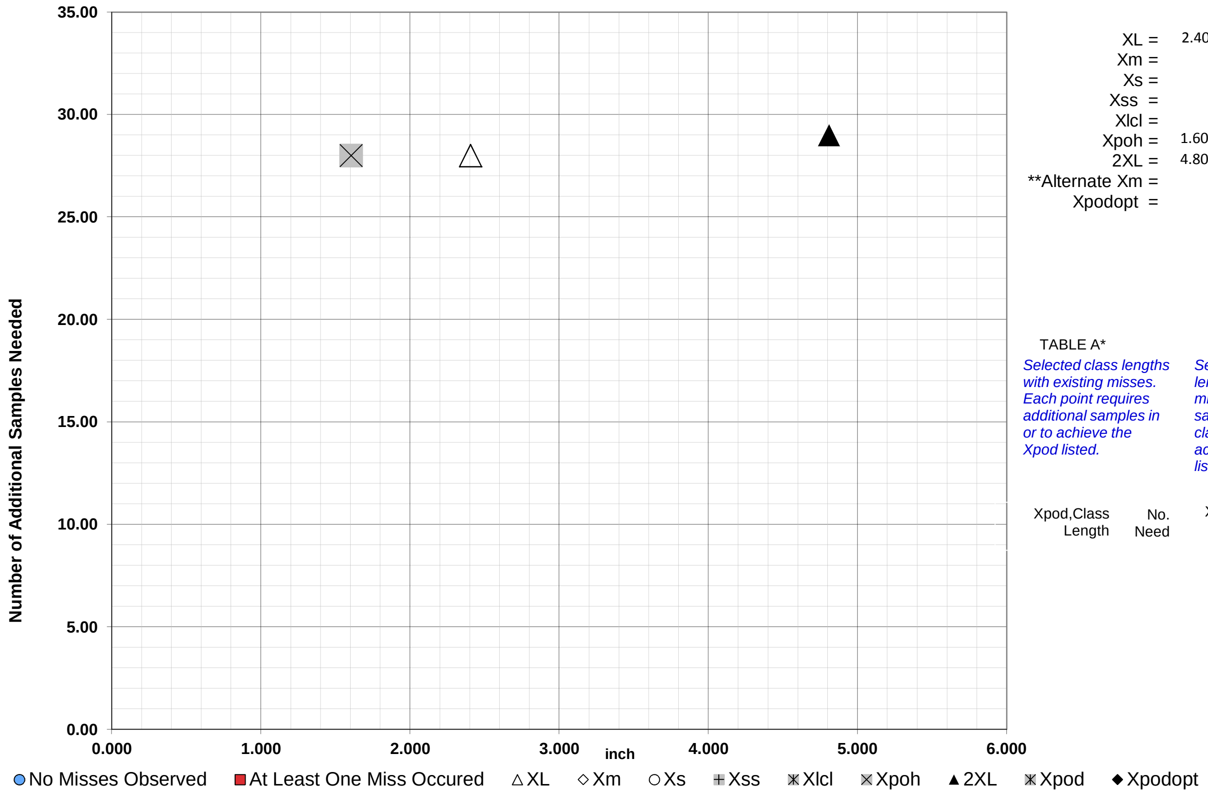


TABLE C

	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*

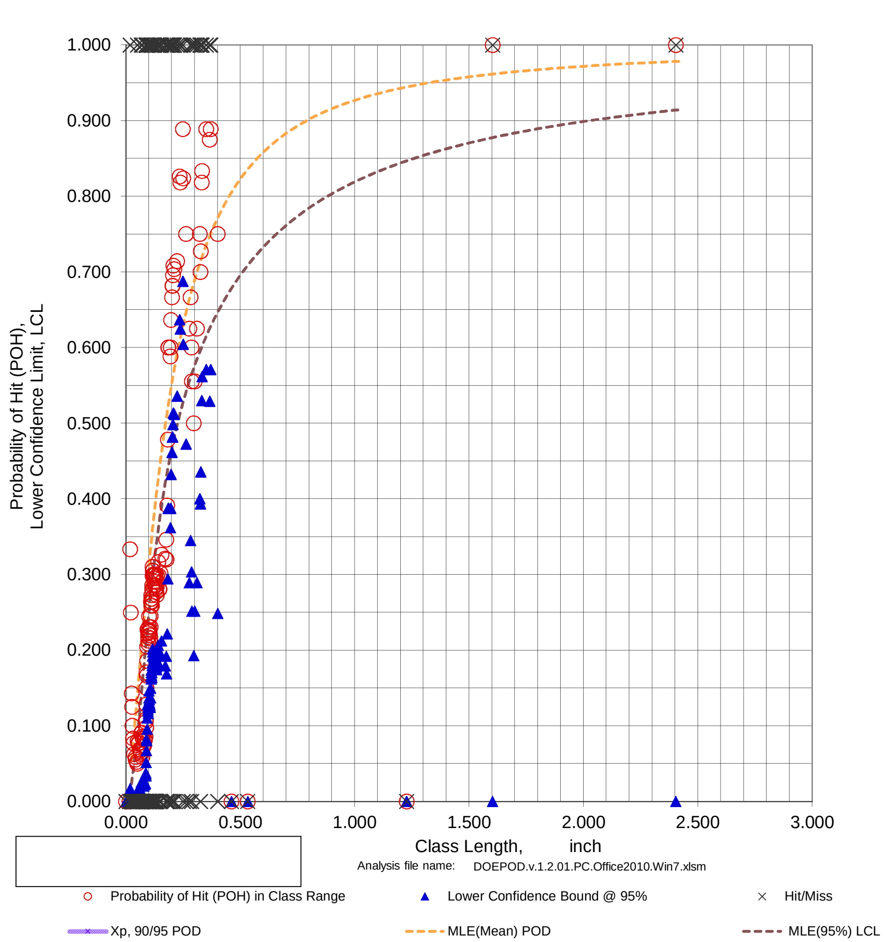
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

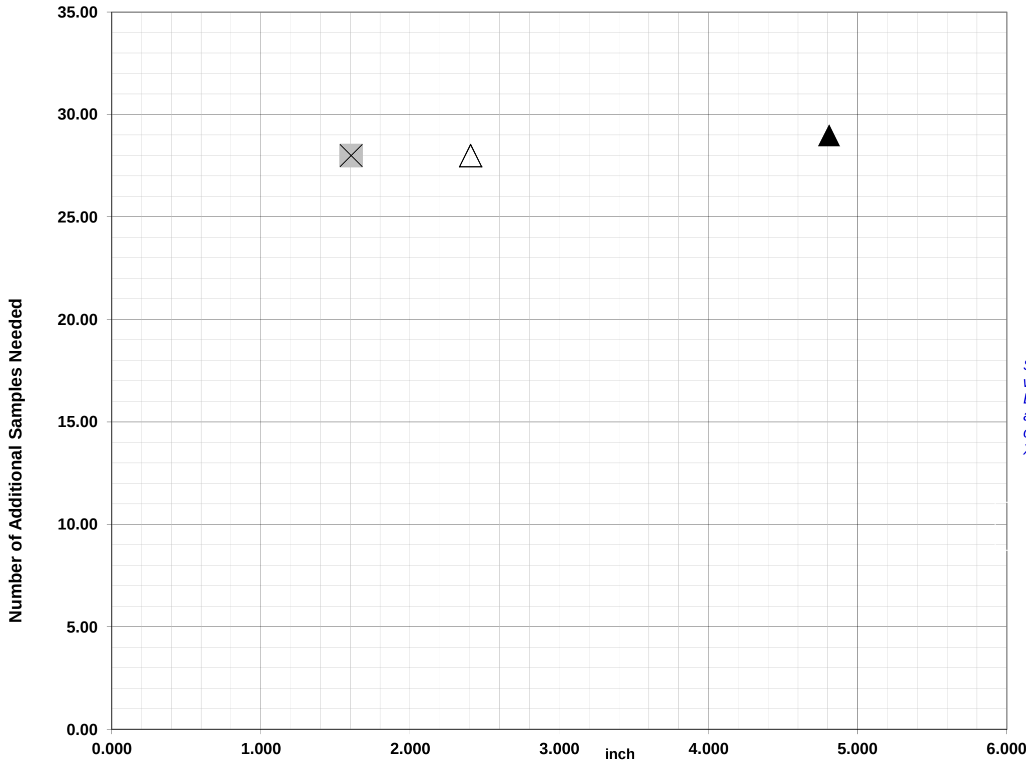
NTIAC 90/95 POD = @ inch

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



● No Misses Observed ■ At Least One Miss Occured △ XL ◇ Xm ○ Xs ⊞ Xss ⋇ Xlcl ⊠ Xpoh ▲ 2XL ⋇ Xpod ◆ Xpodopt

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

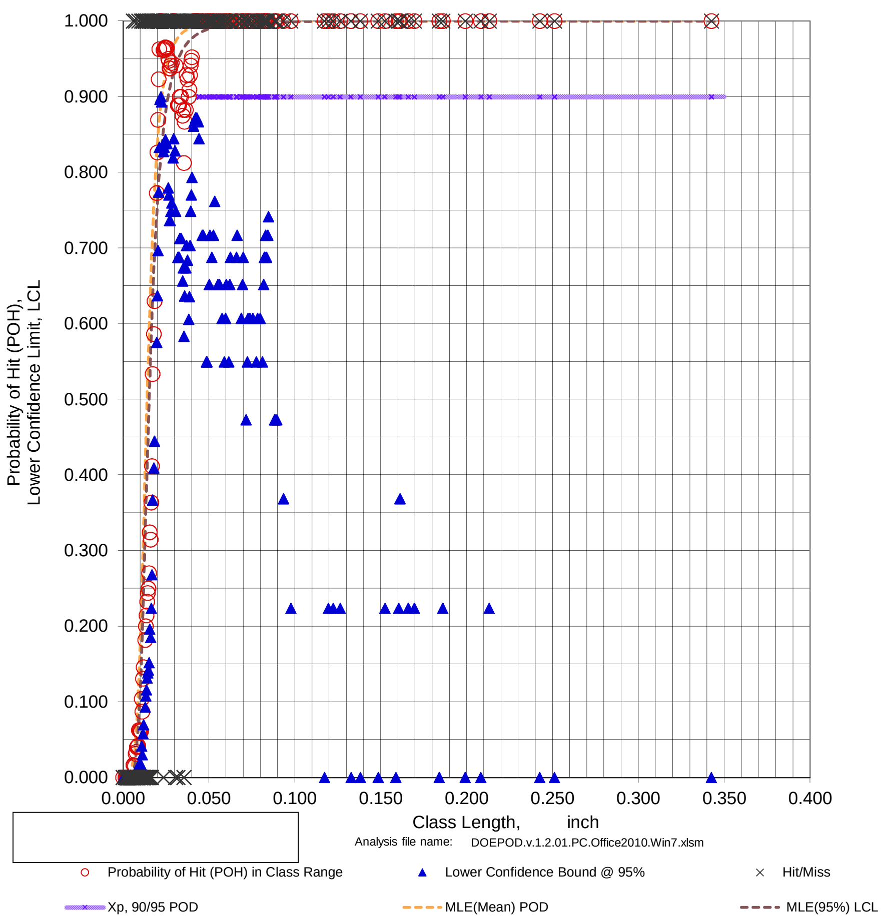
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

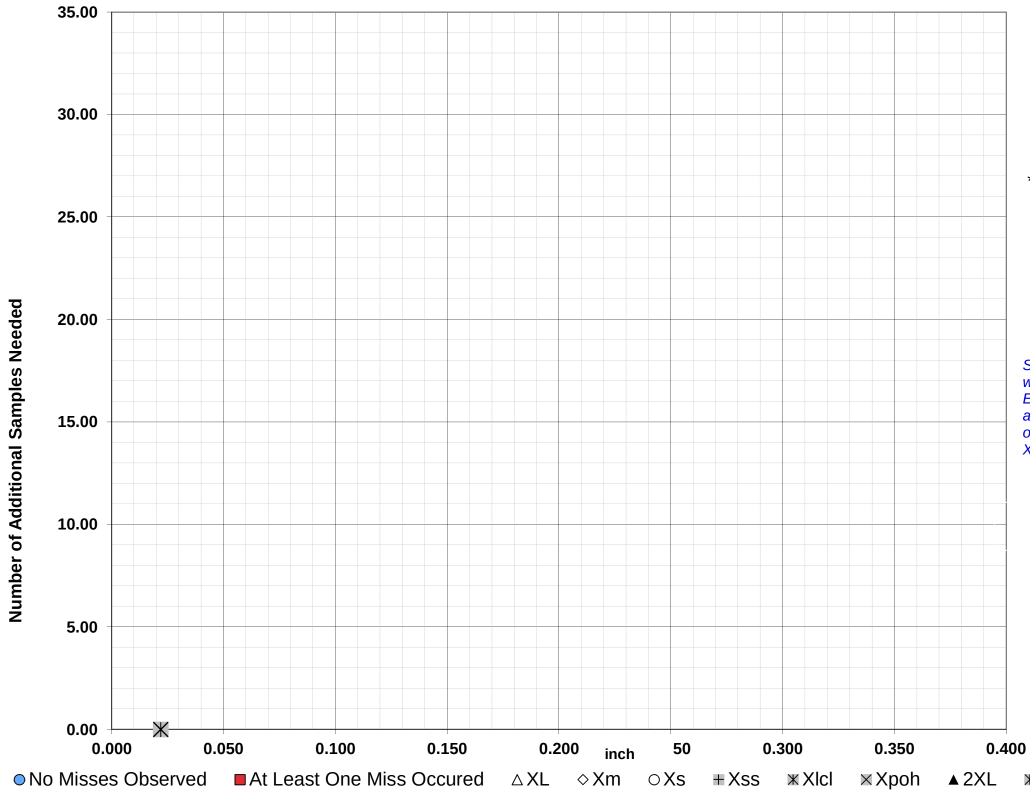


TABLE C

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

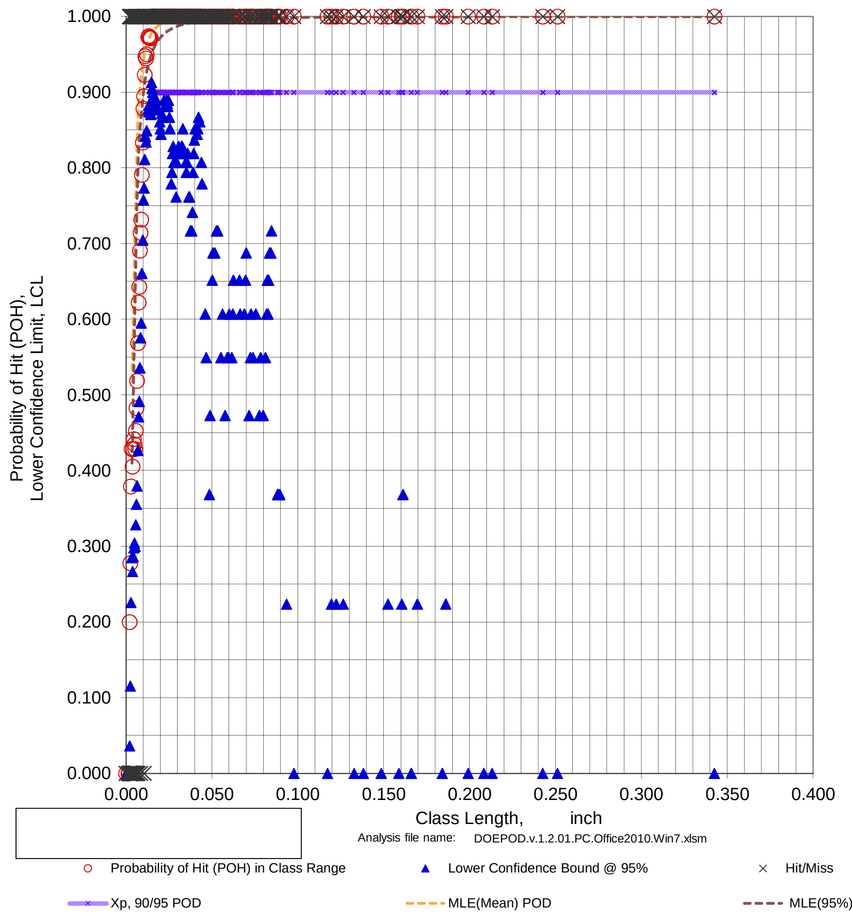
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

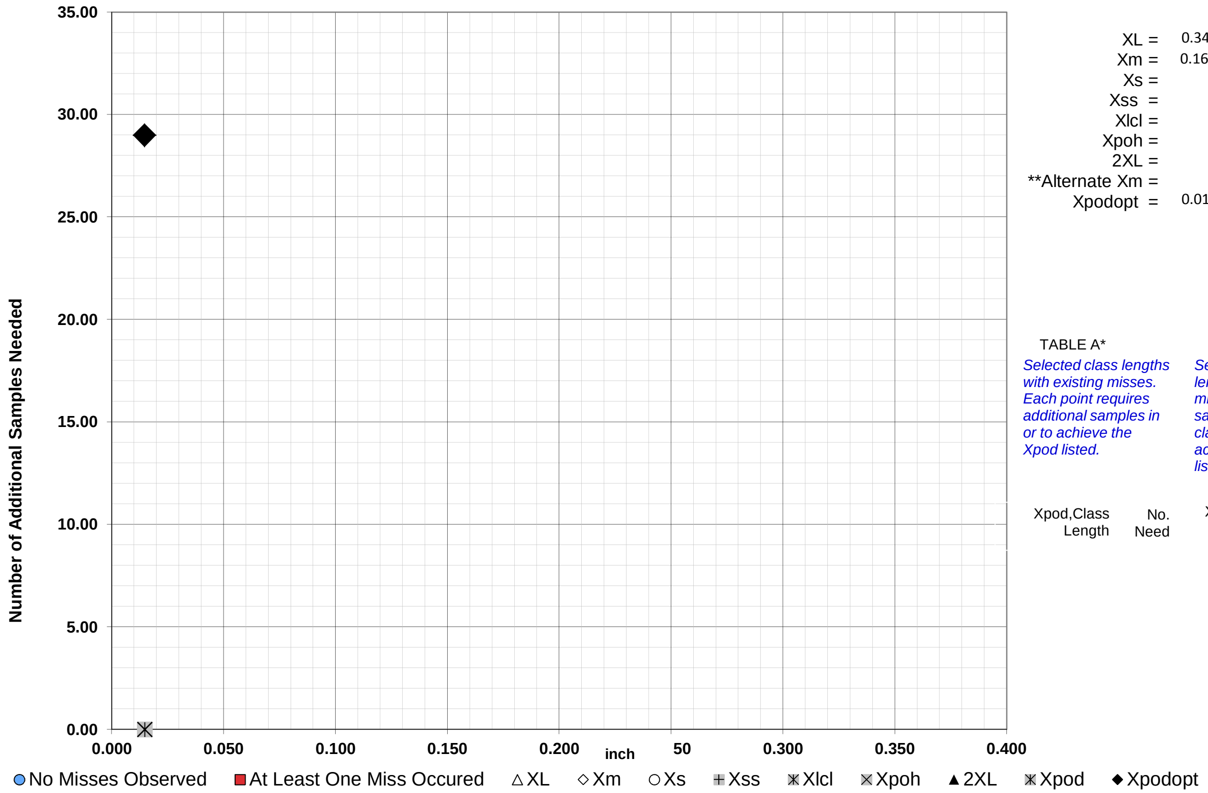


TABLE C

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

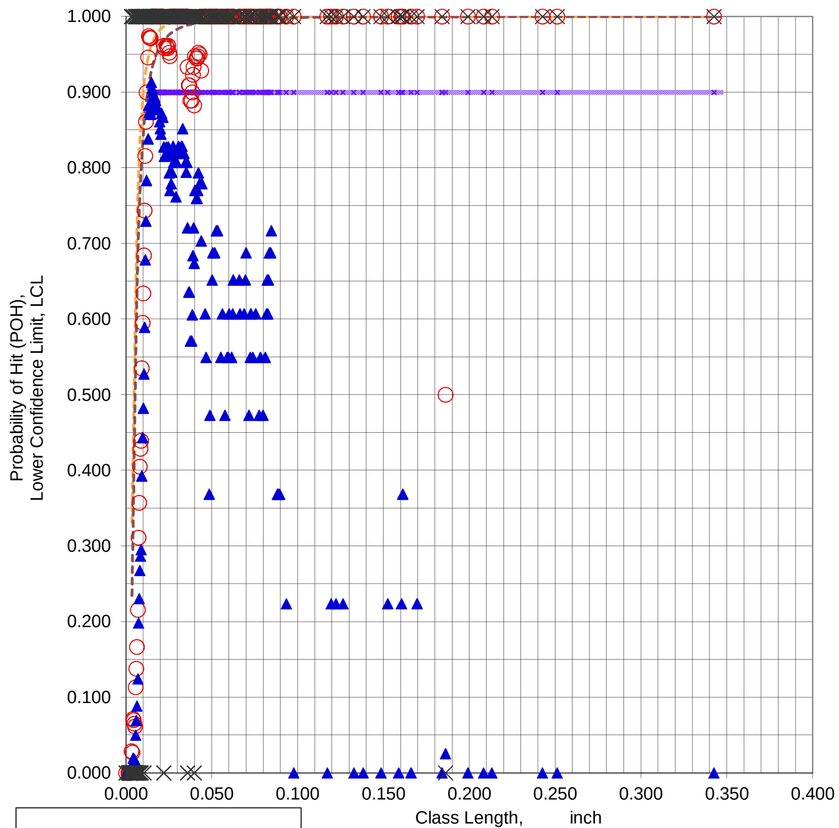
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

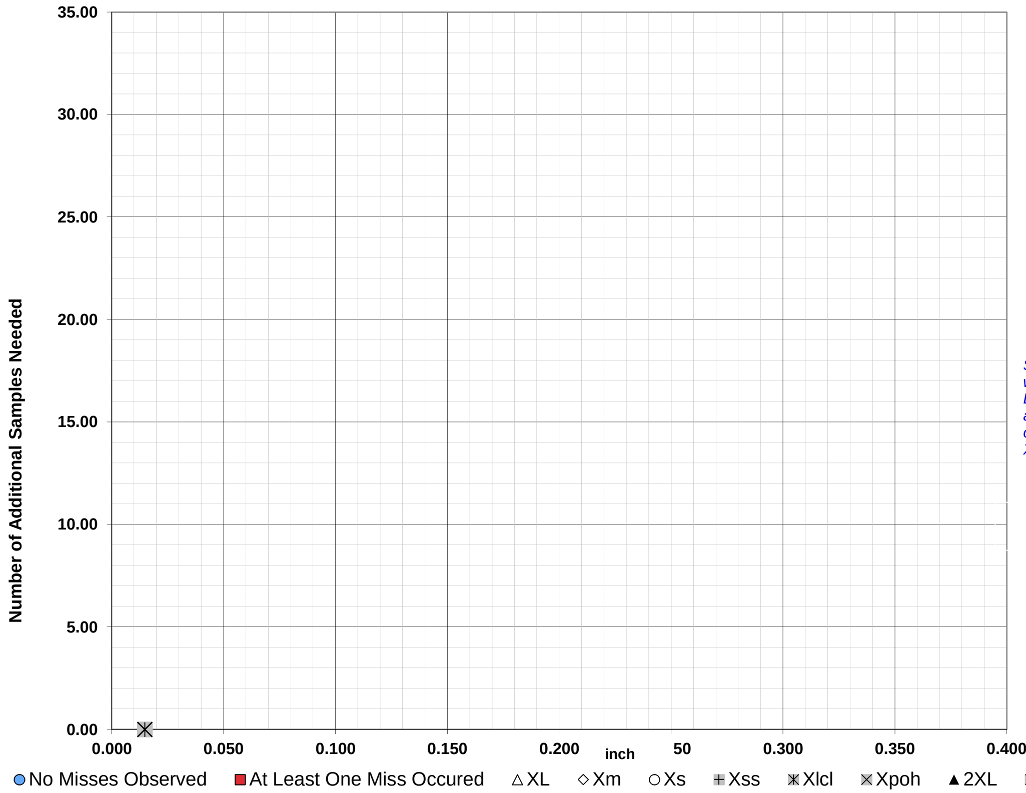


TABLE C

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

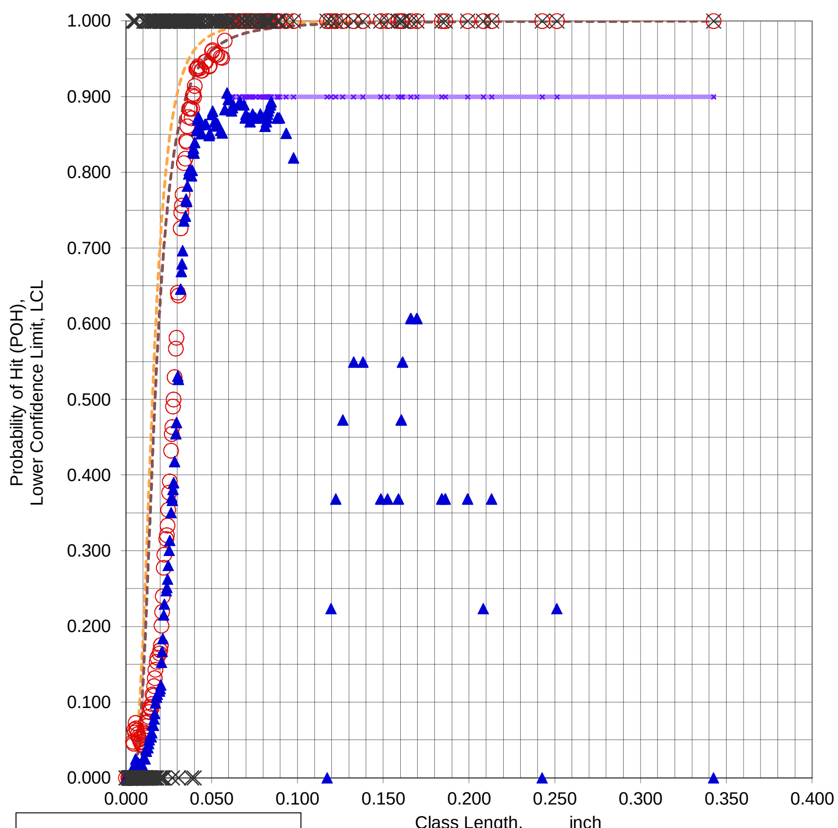
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

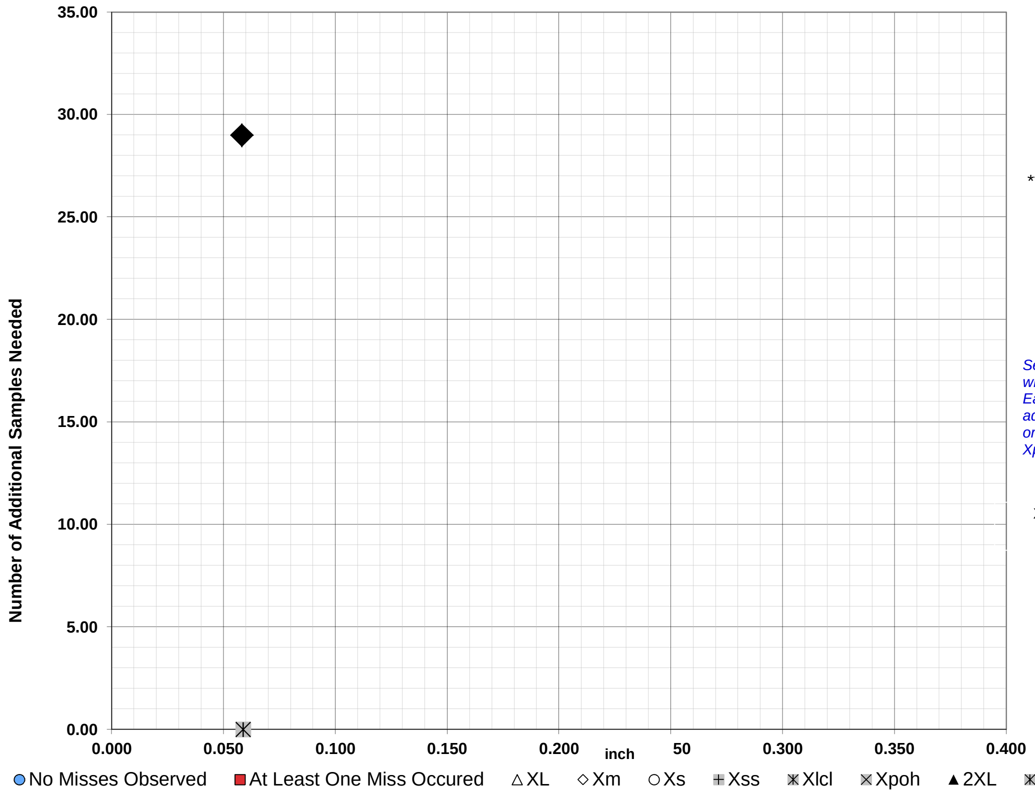


TABLE C

	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

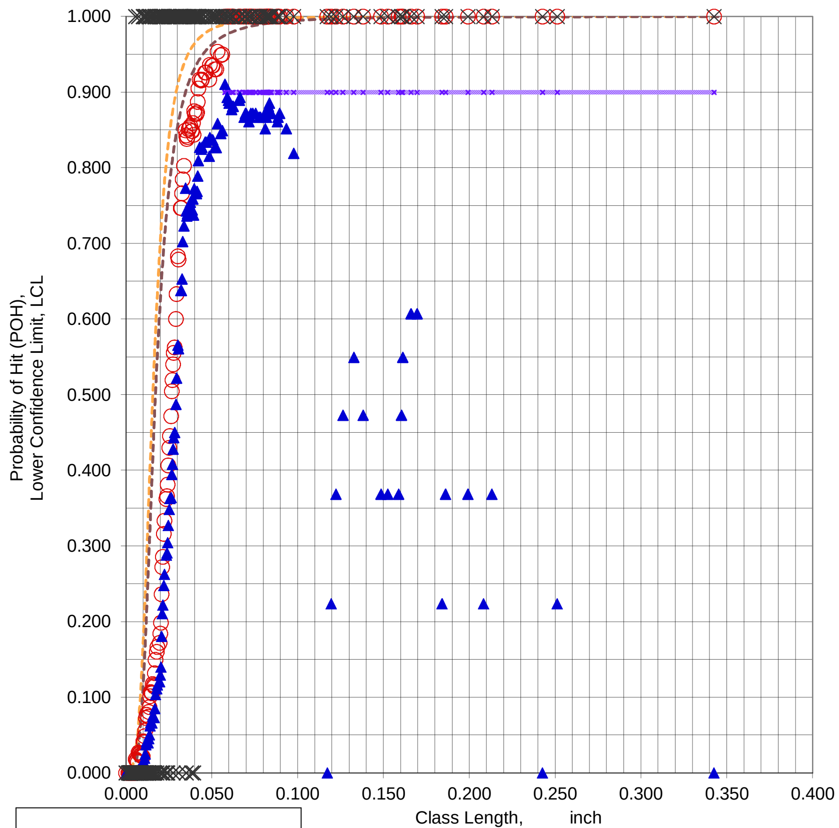
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 =	**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

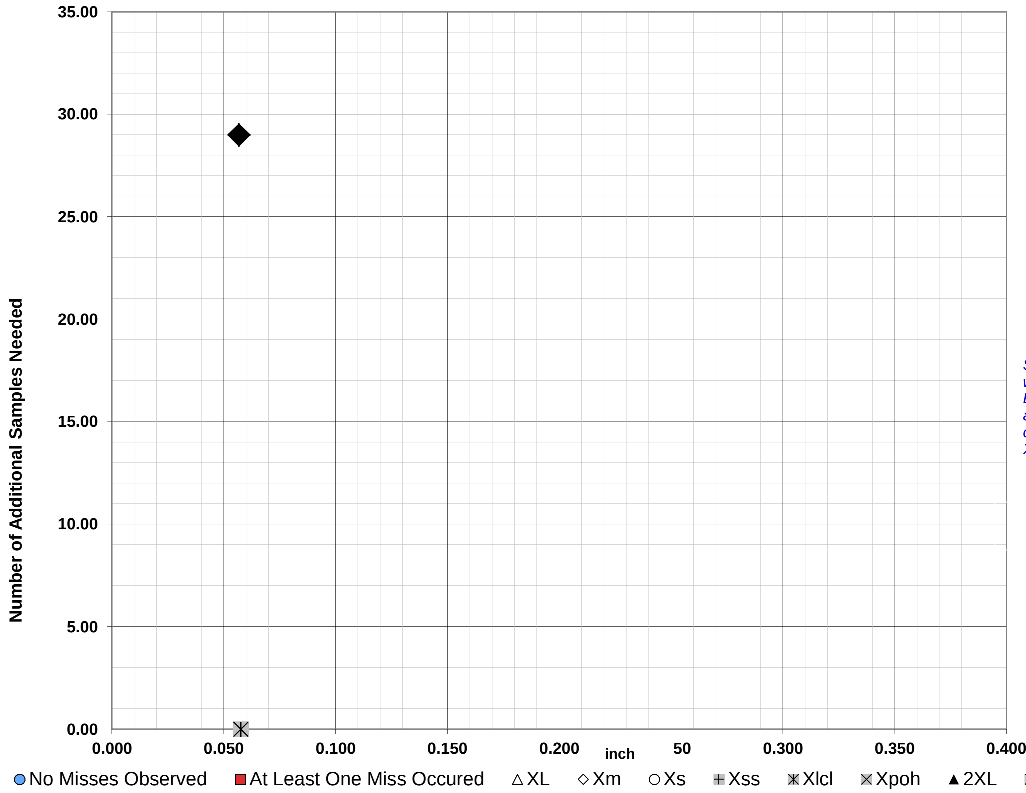


TABLE C

	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)

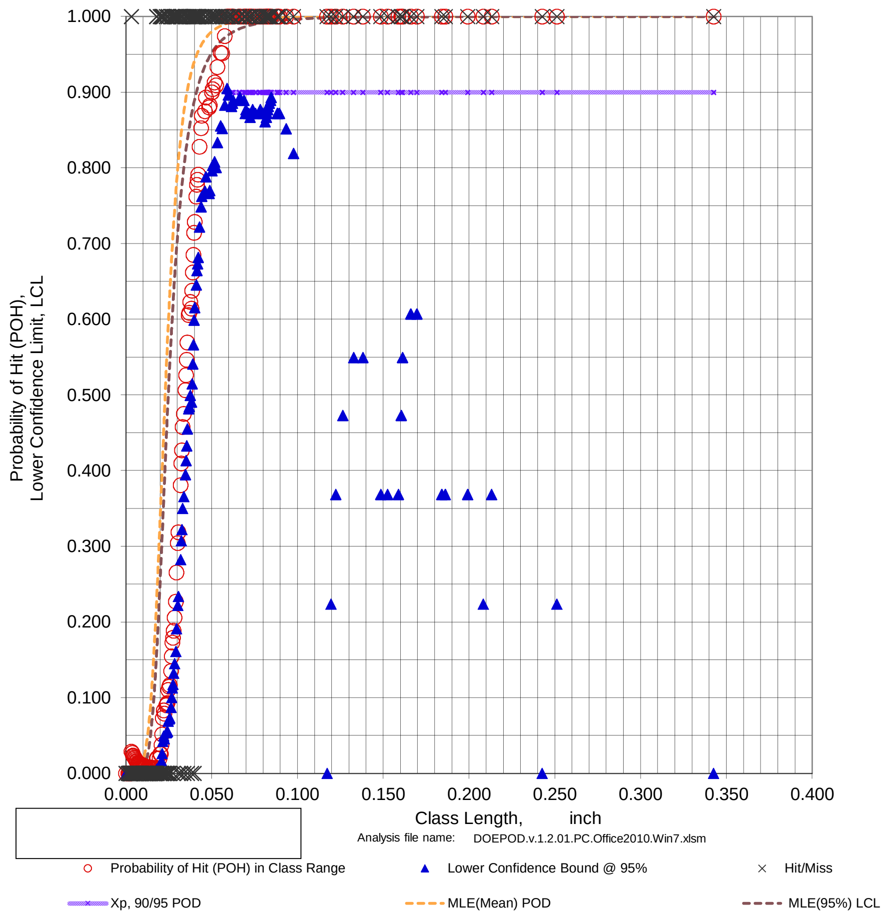
Large flaw validation failure. Need 9 more large flaws.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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

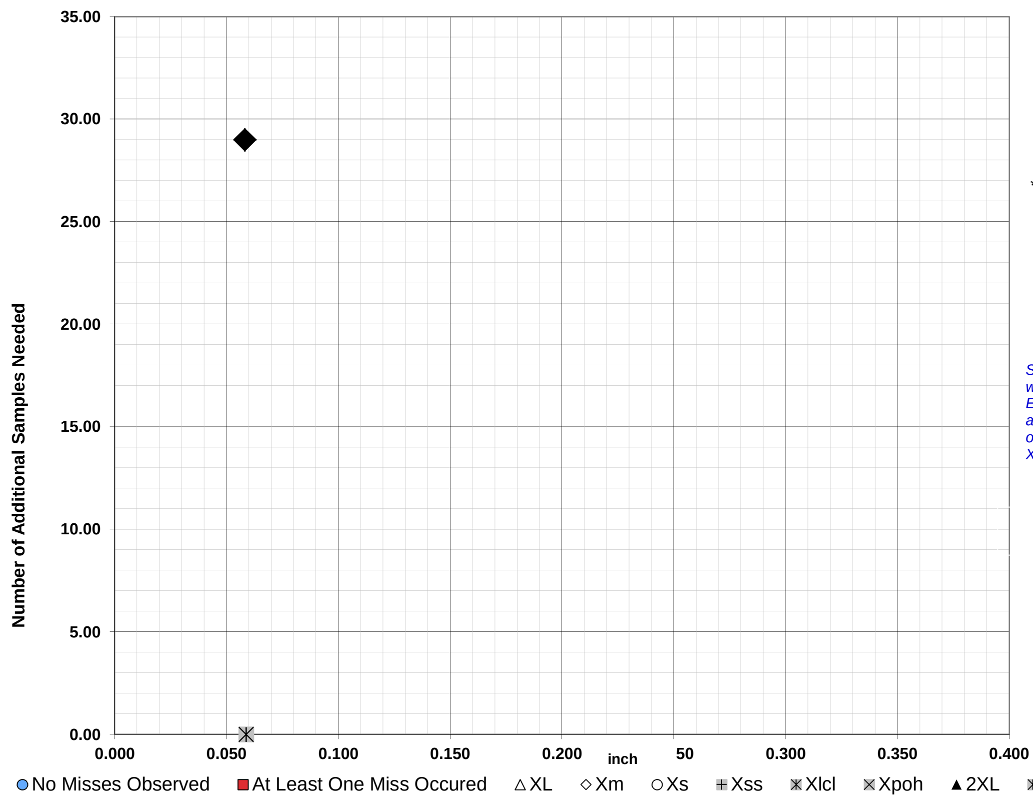


TABLE C

	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

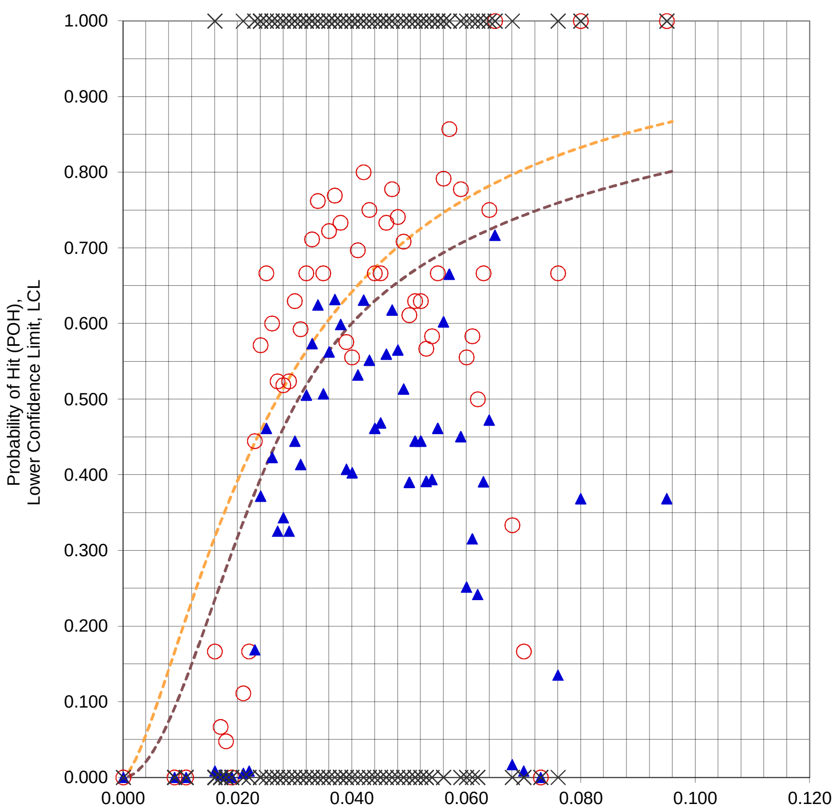
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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)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

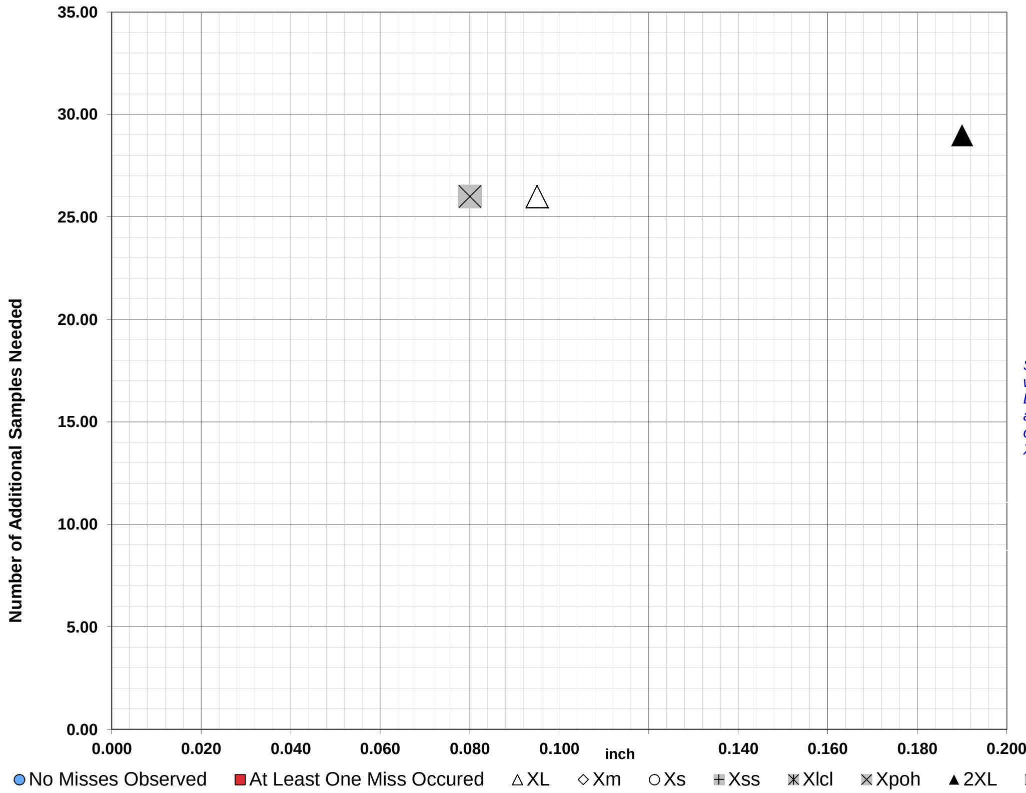


TABLE C

	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*

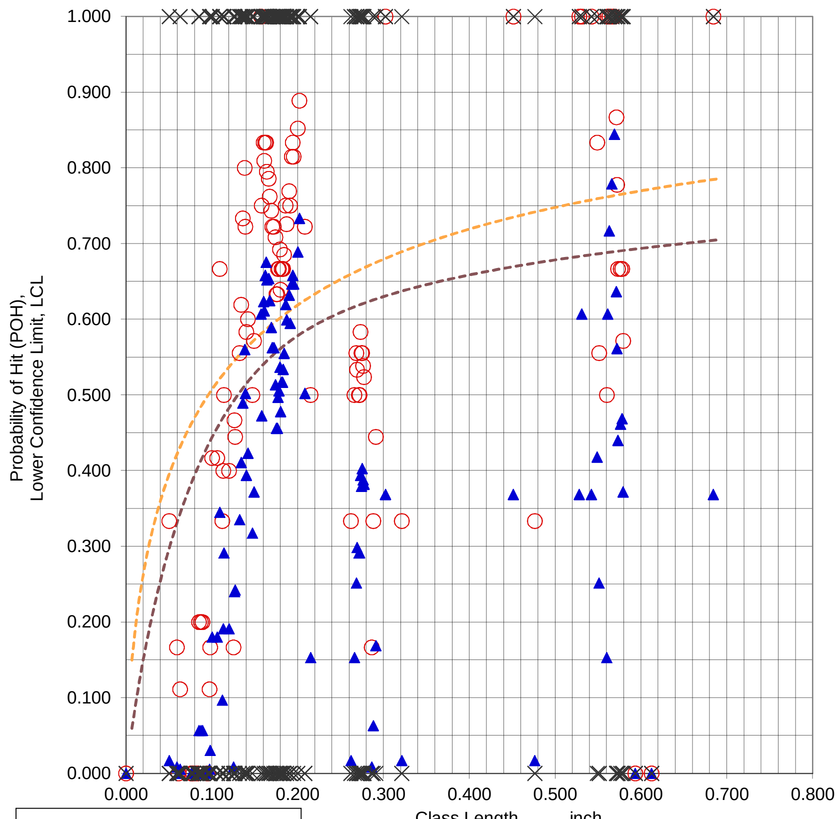
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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

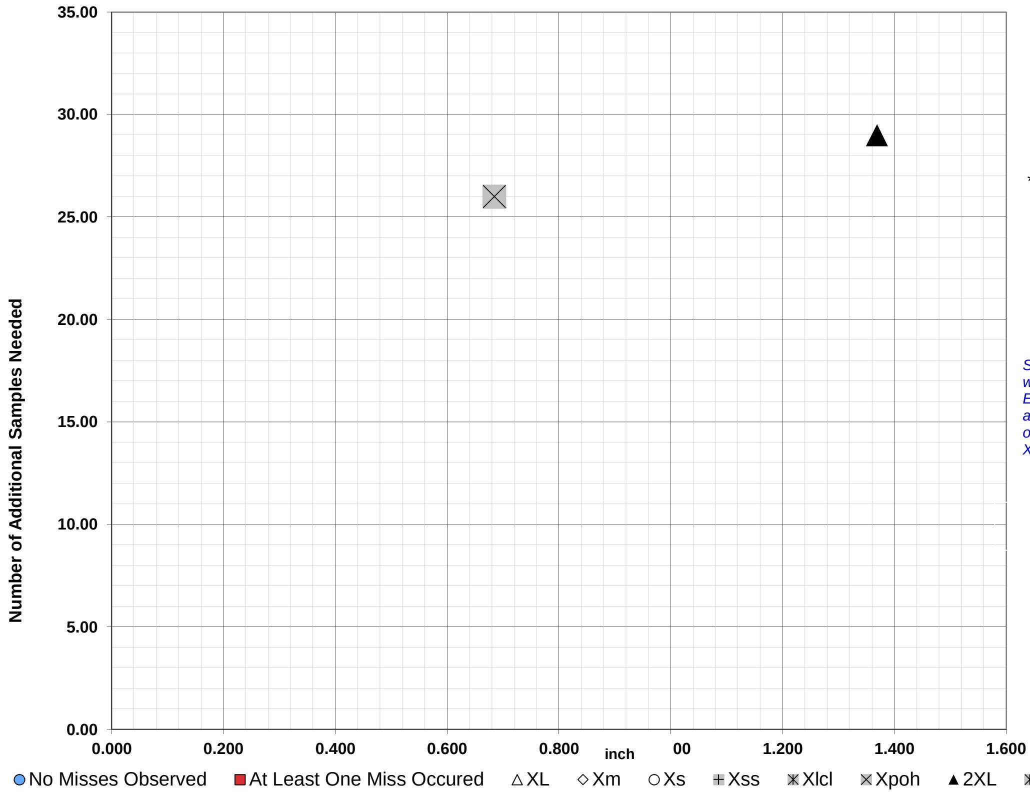


TABLE C

	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*

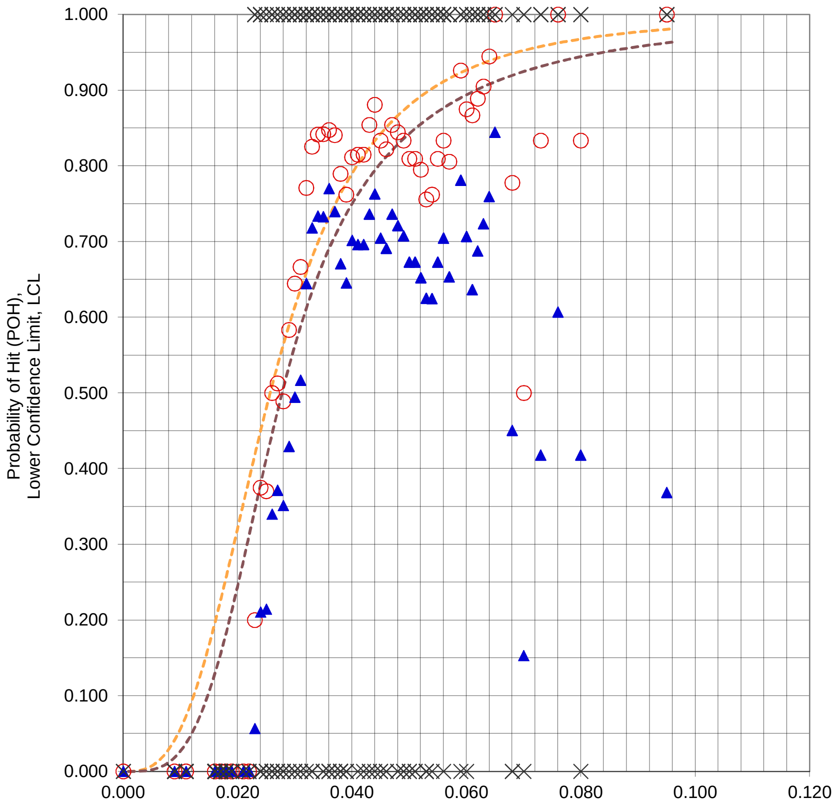
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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

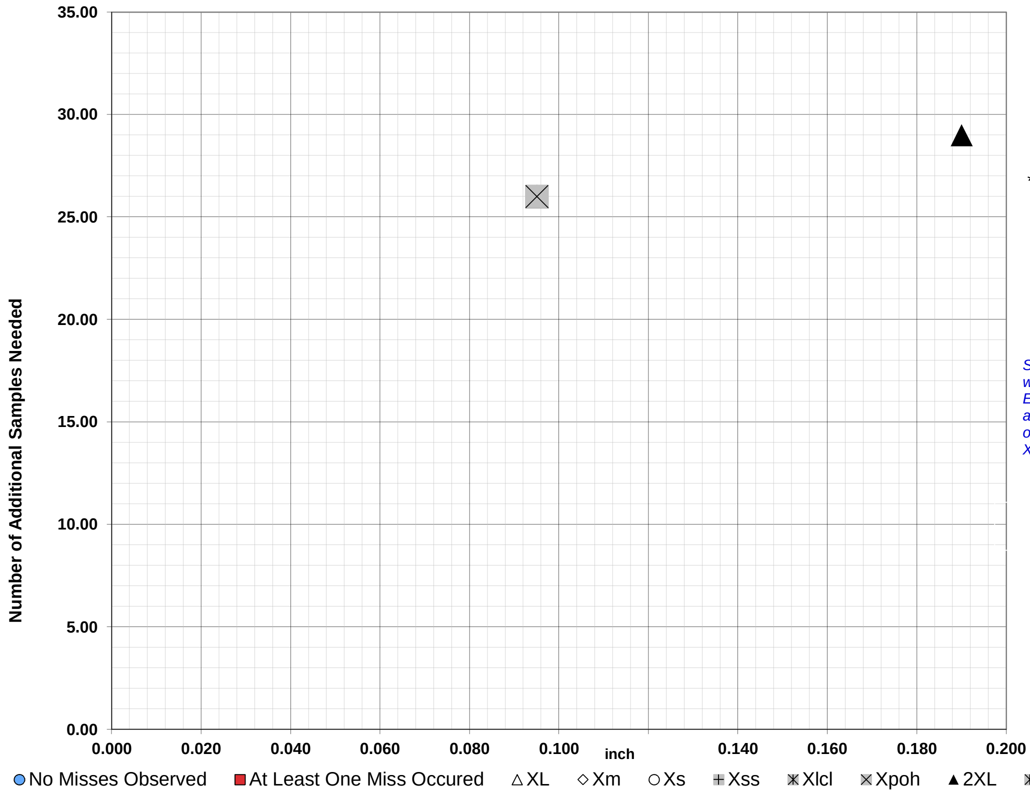


TABLE C

	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*

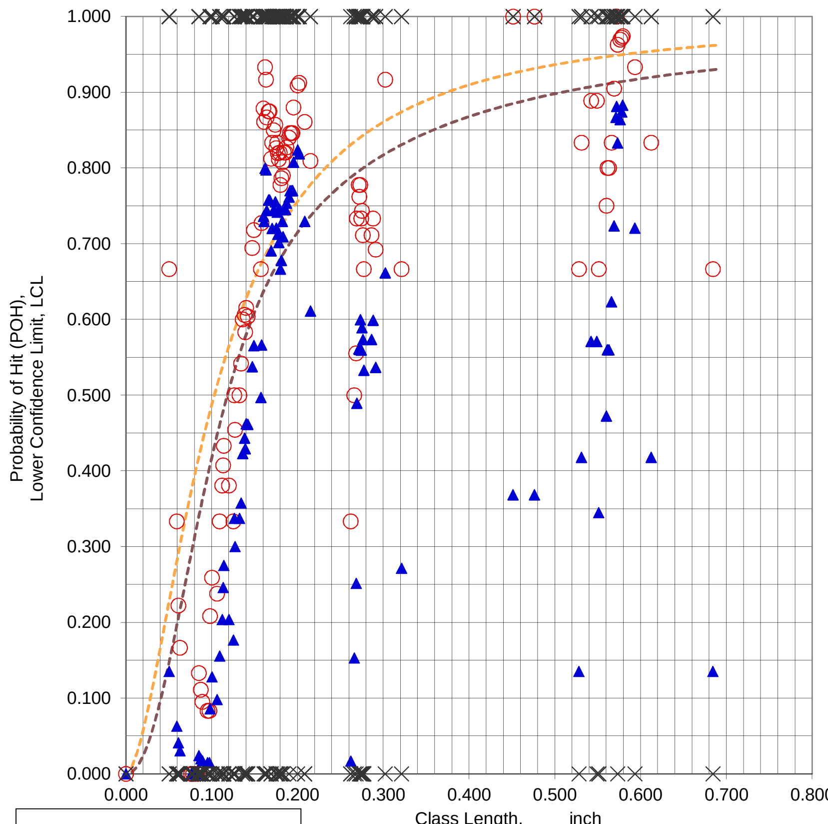
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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)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

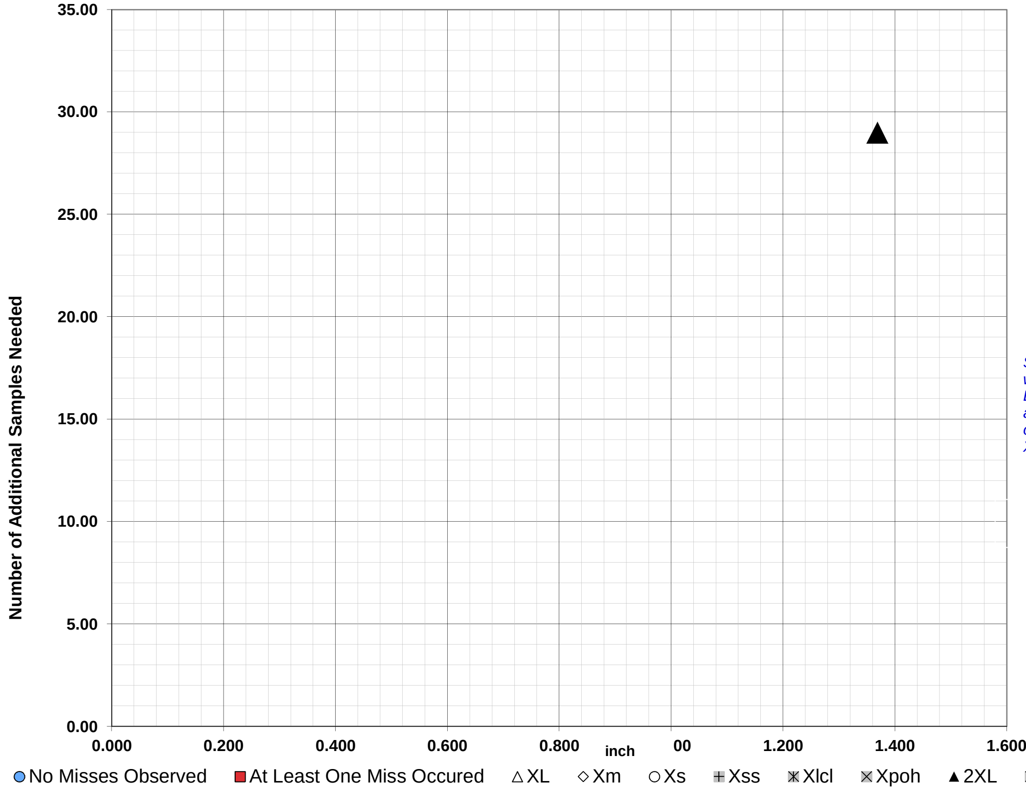


TABLE C

	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*

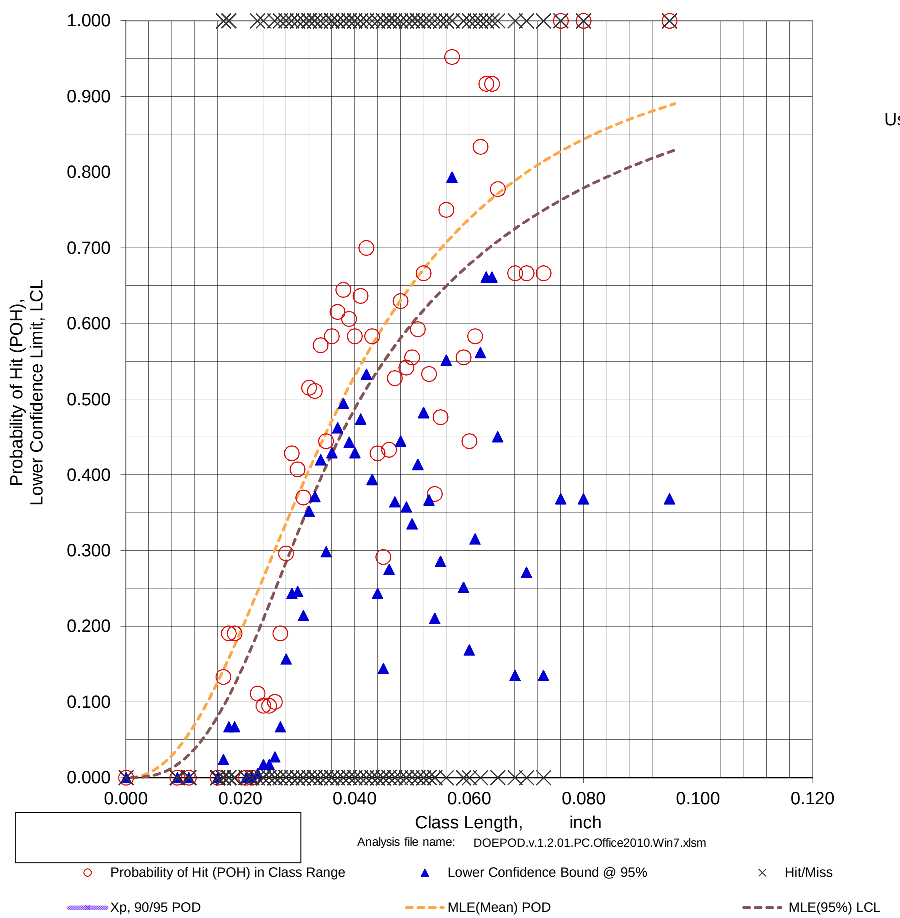
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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

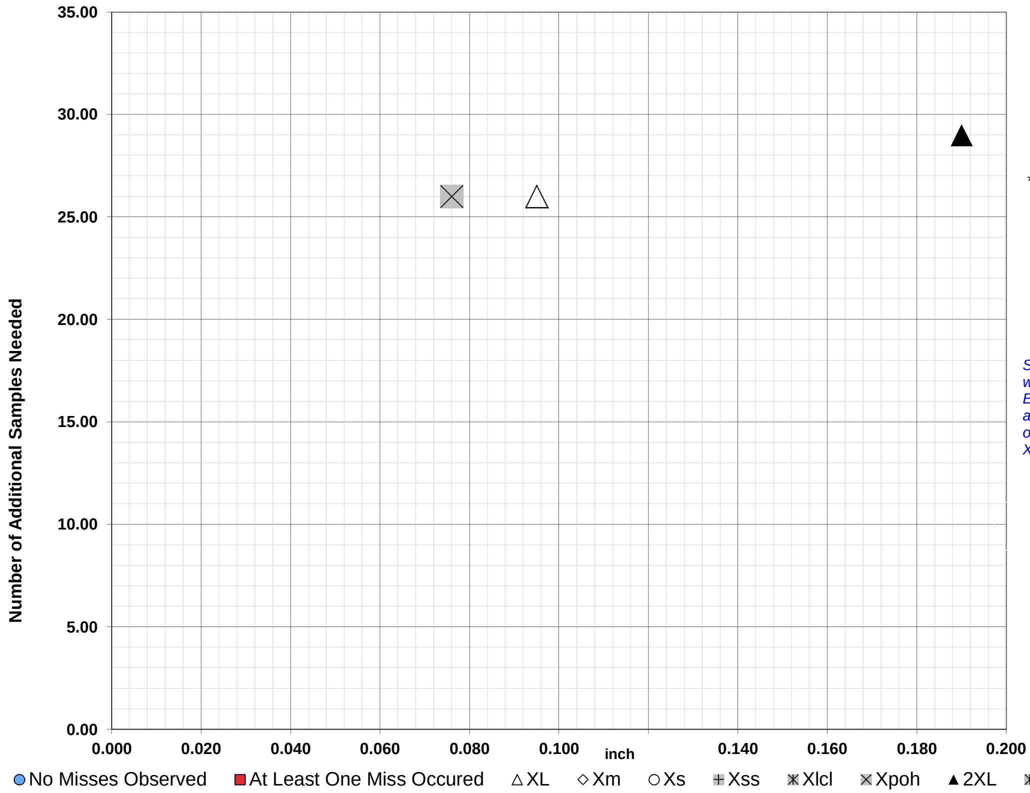


TABLE C

	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*

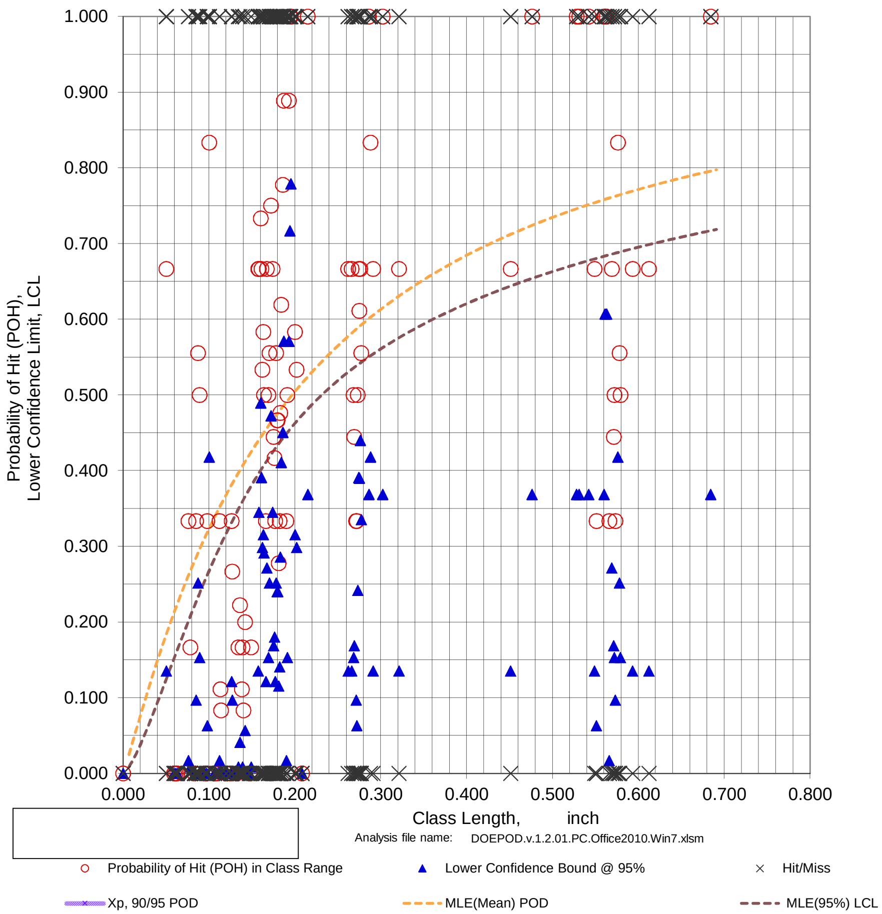
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



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

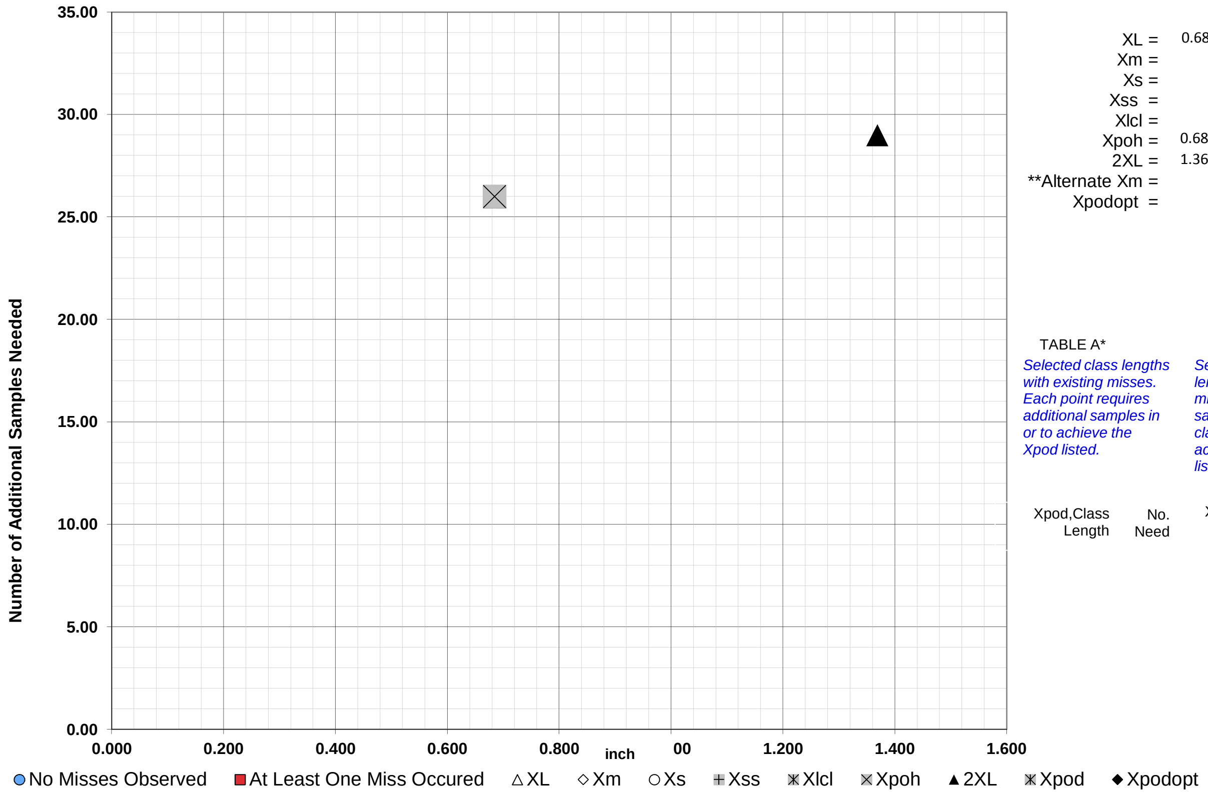


TABLE C

	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*

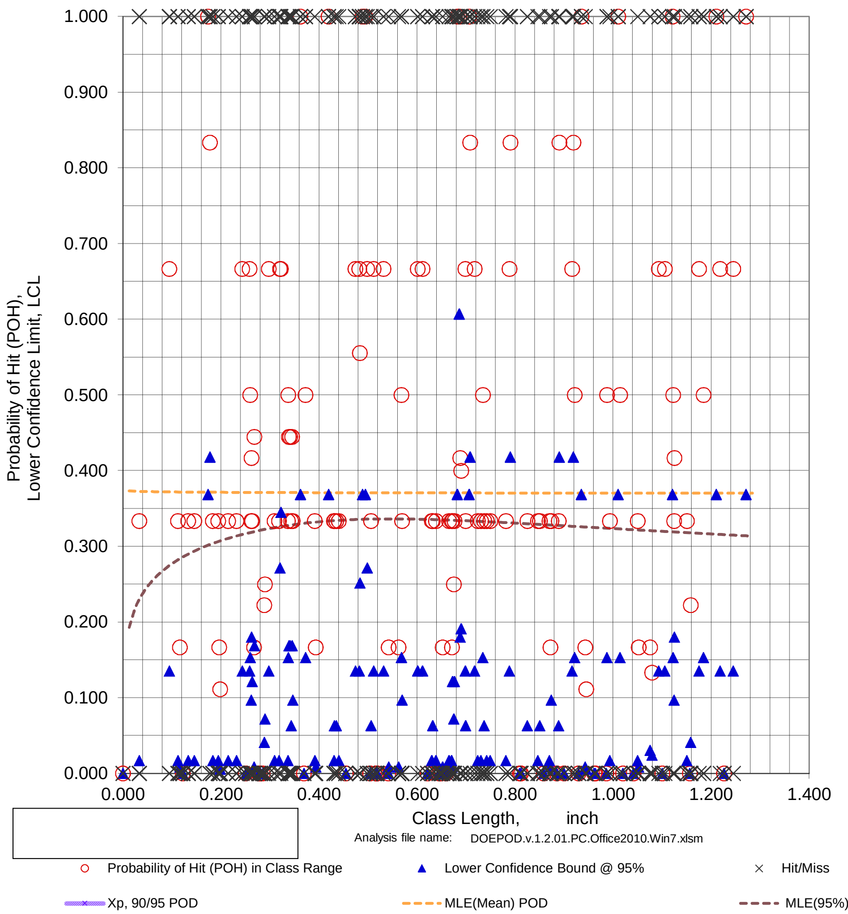
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

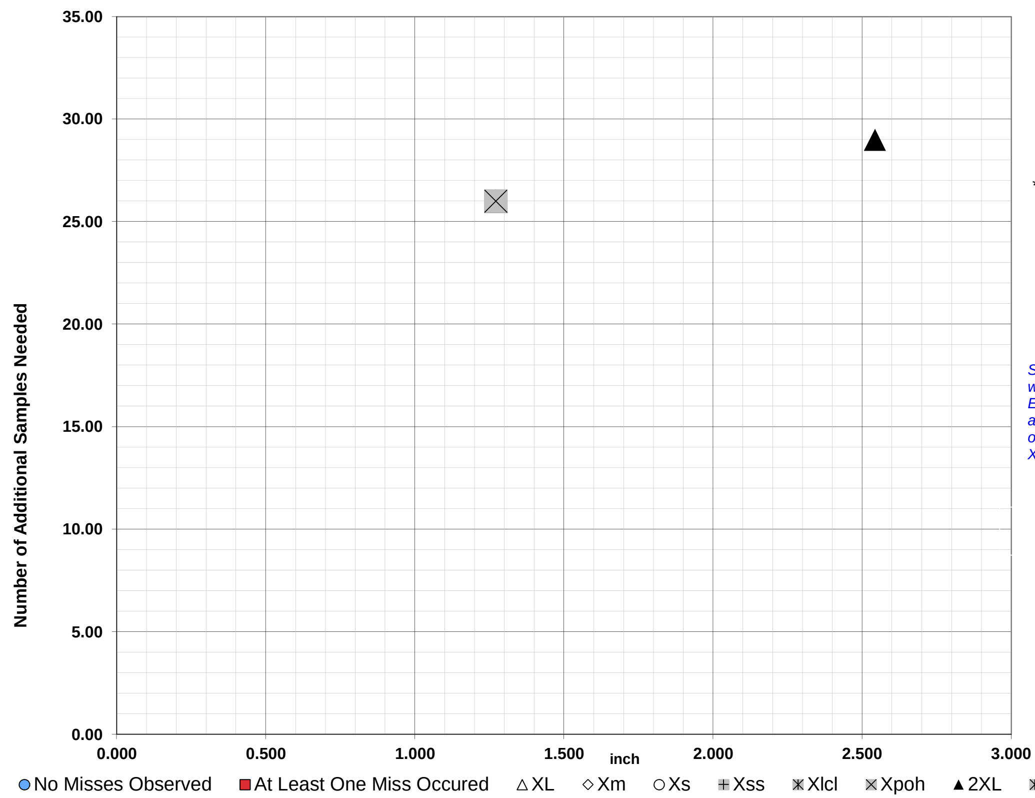


TABLE C

	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*

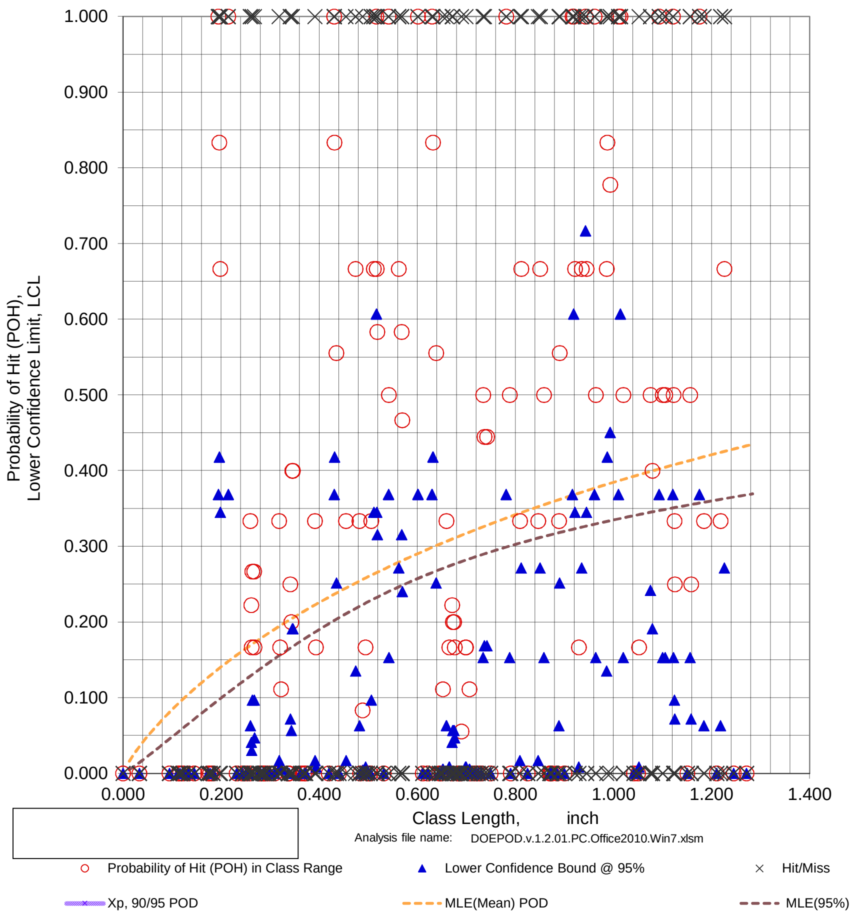
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

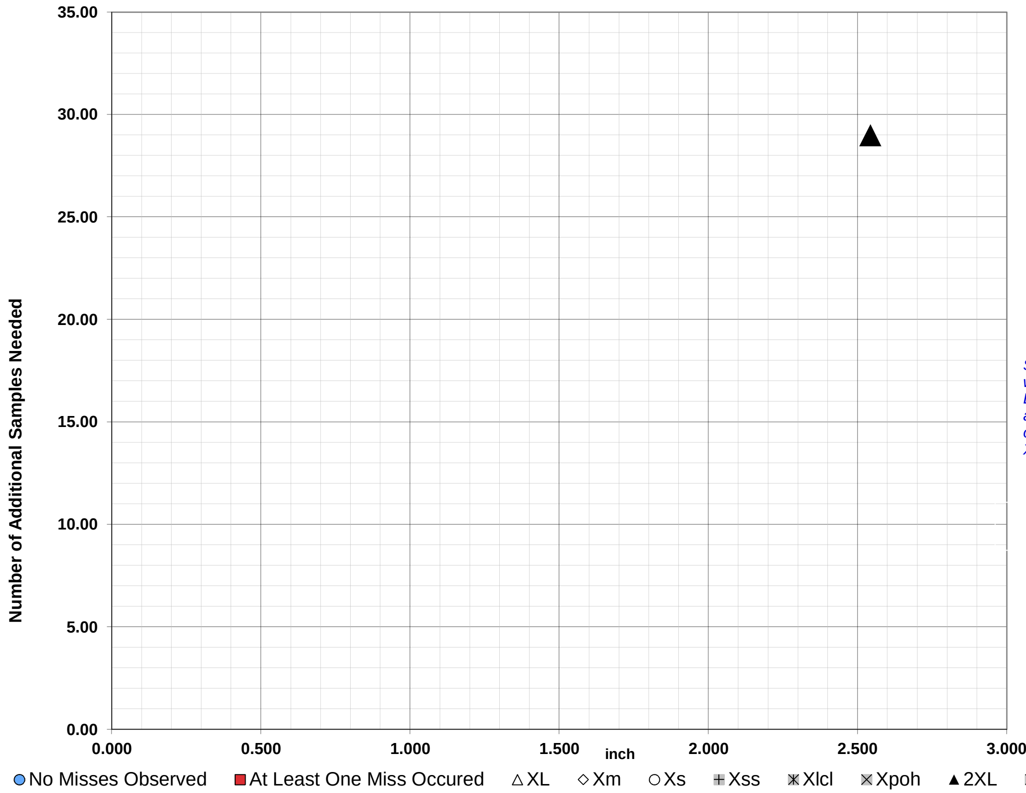


TABLE C

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.

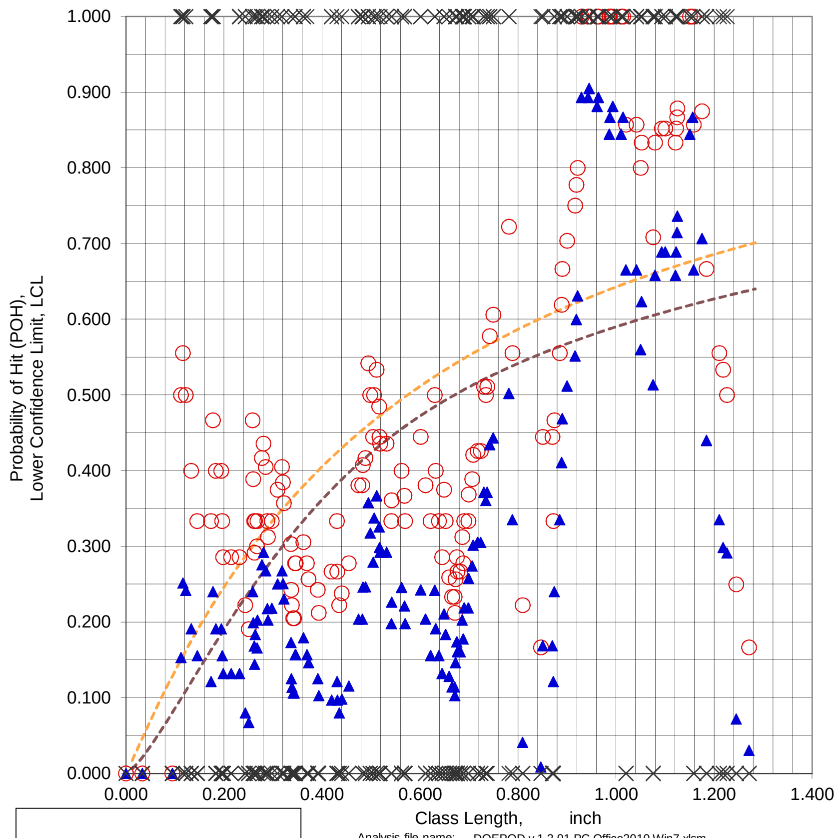
Xpod,Class Length	No. Need

* 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.



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 = **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

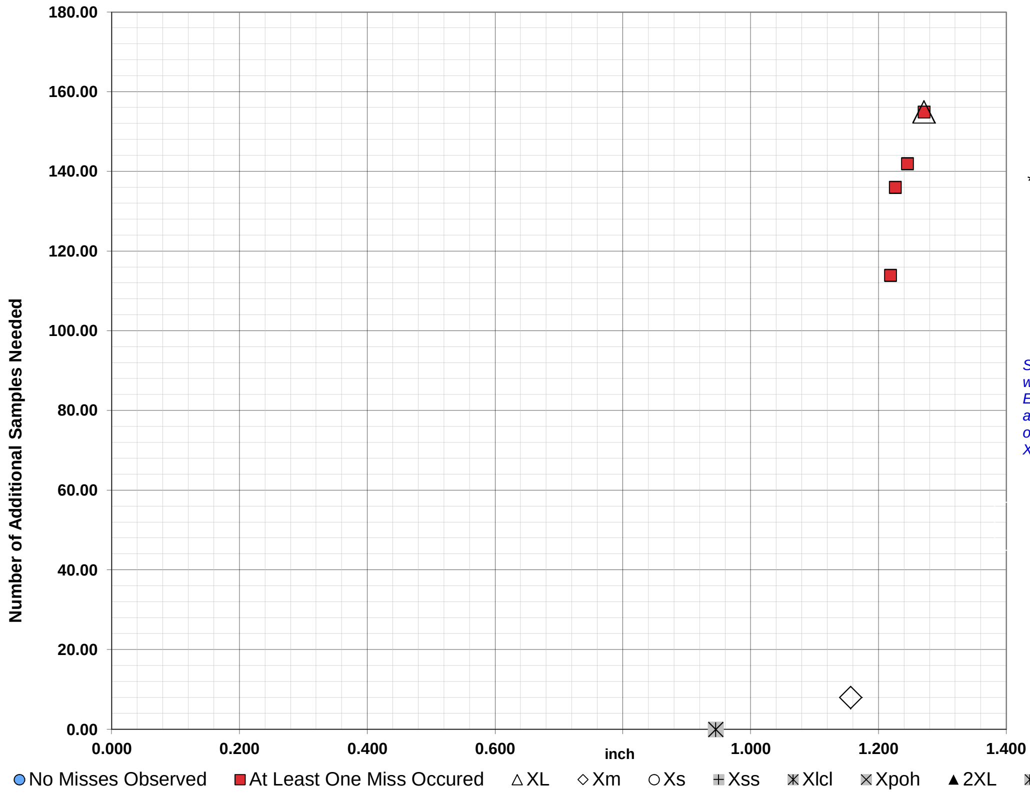


TABLE C

	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

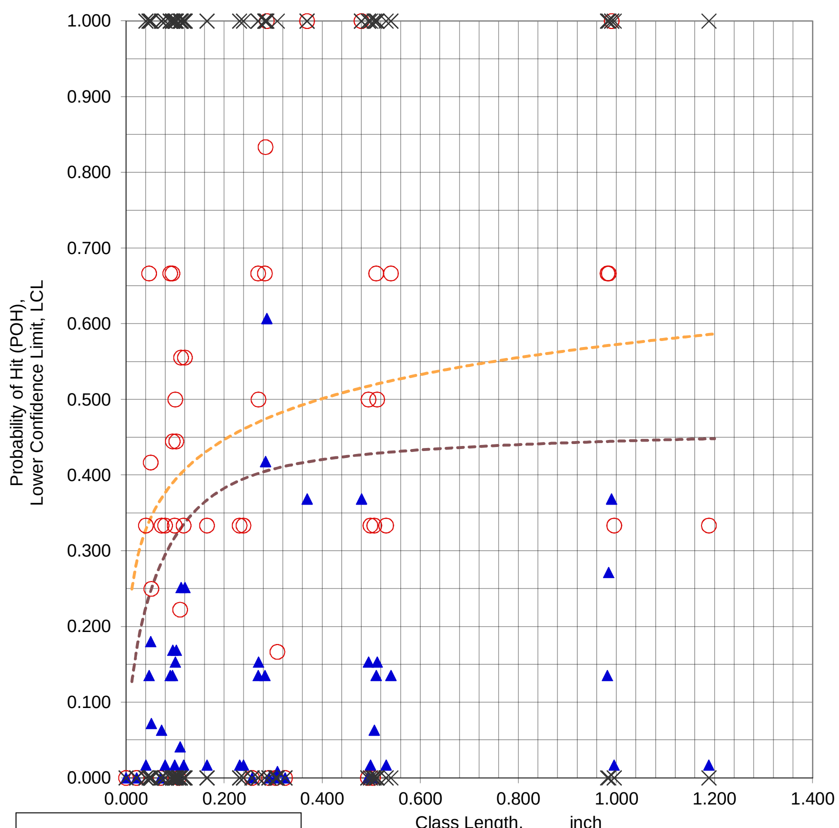
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

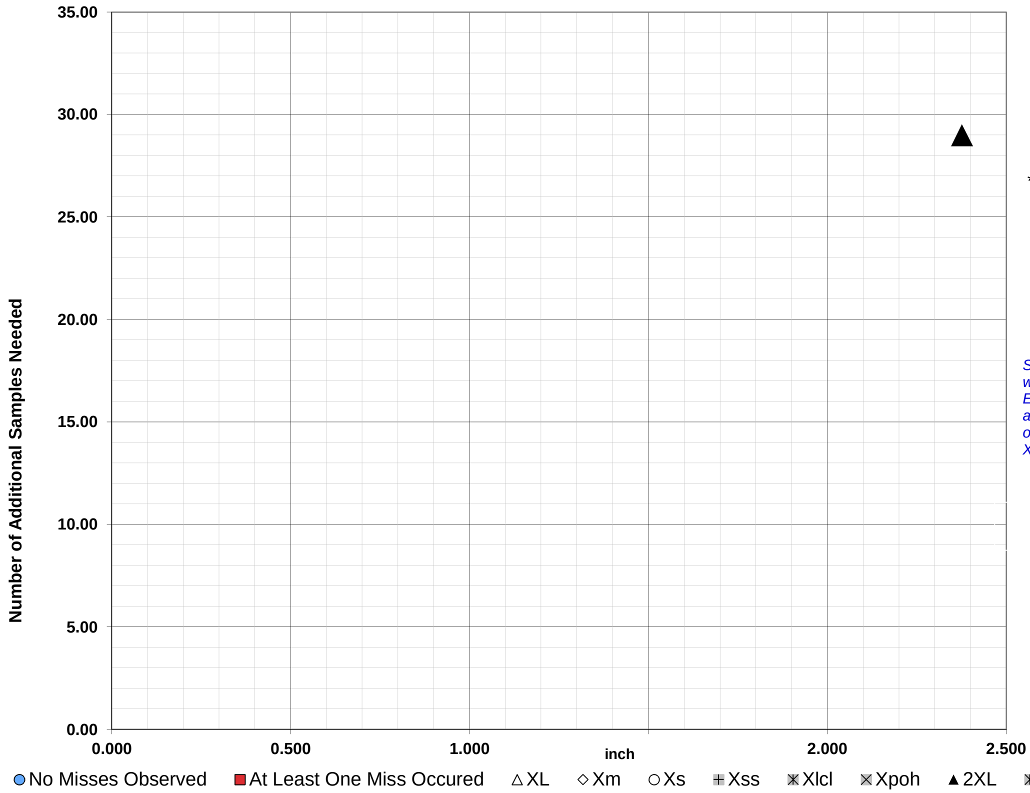


TABLE C

	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*

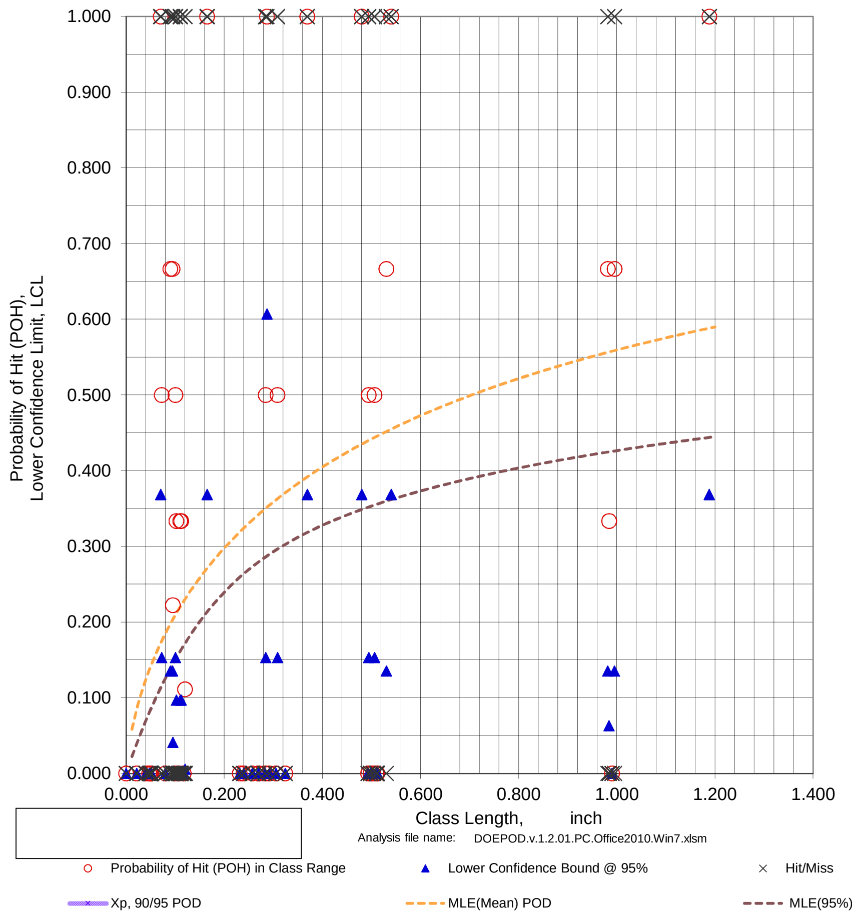
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

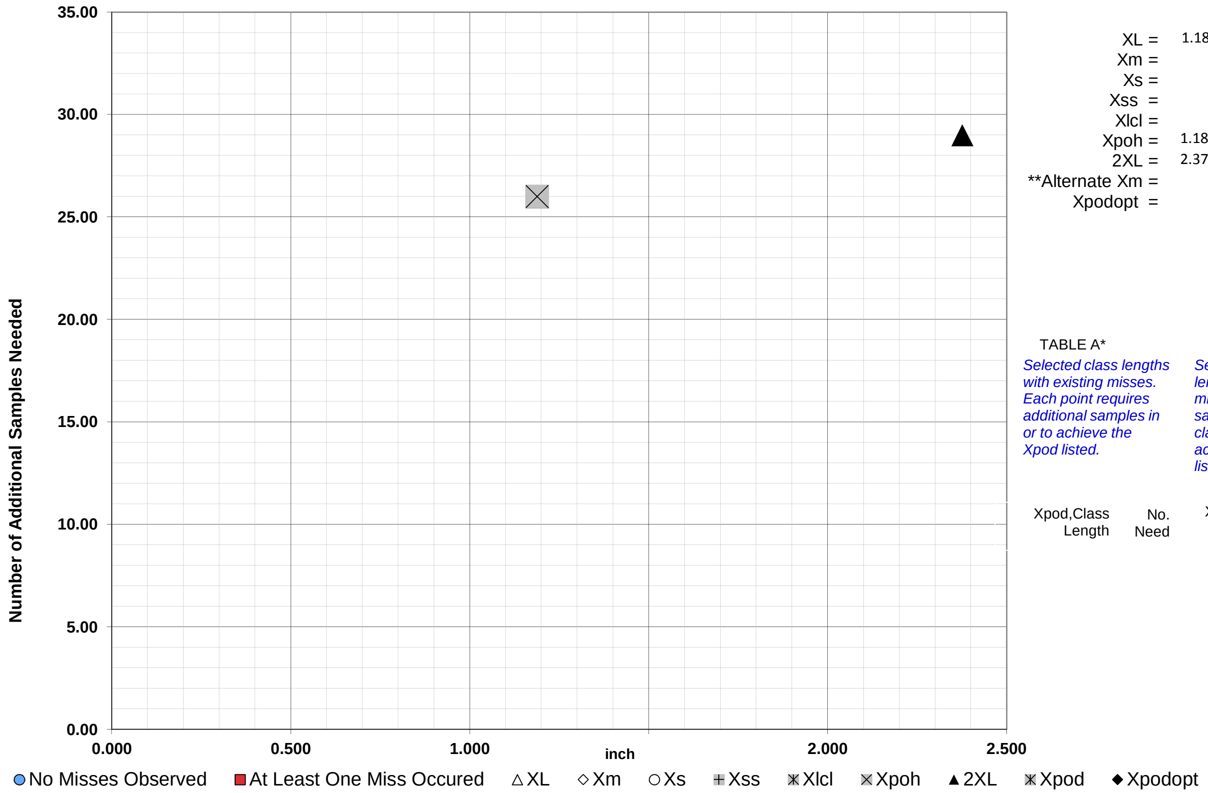


TABLE C

	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*

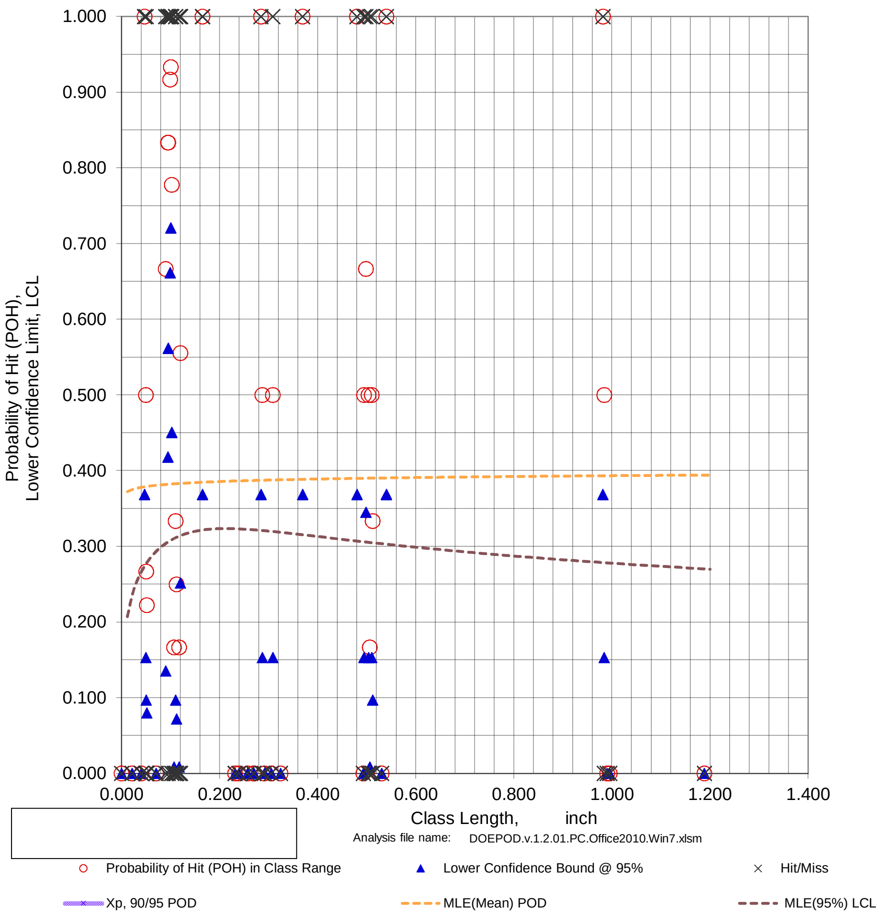
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

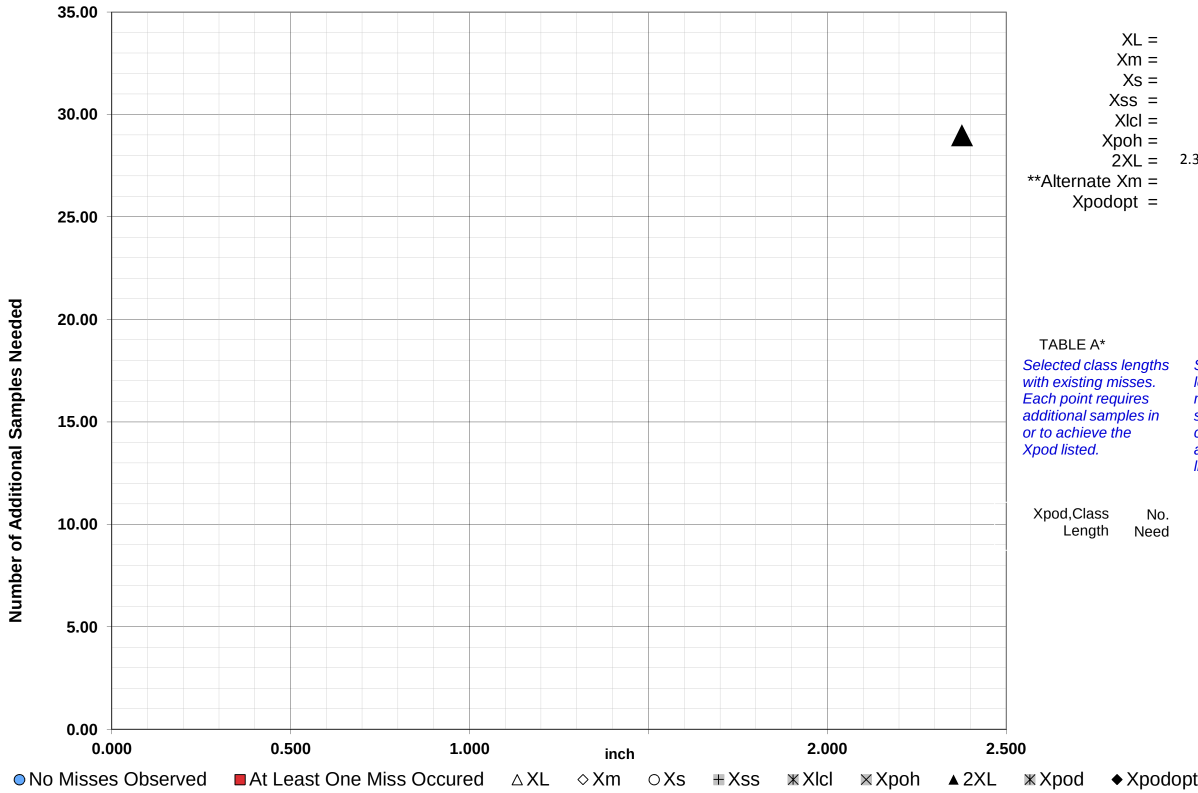


TABLE C

	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*

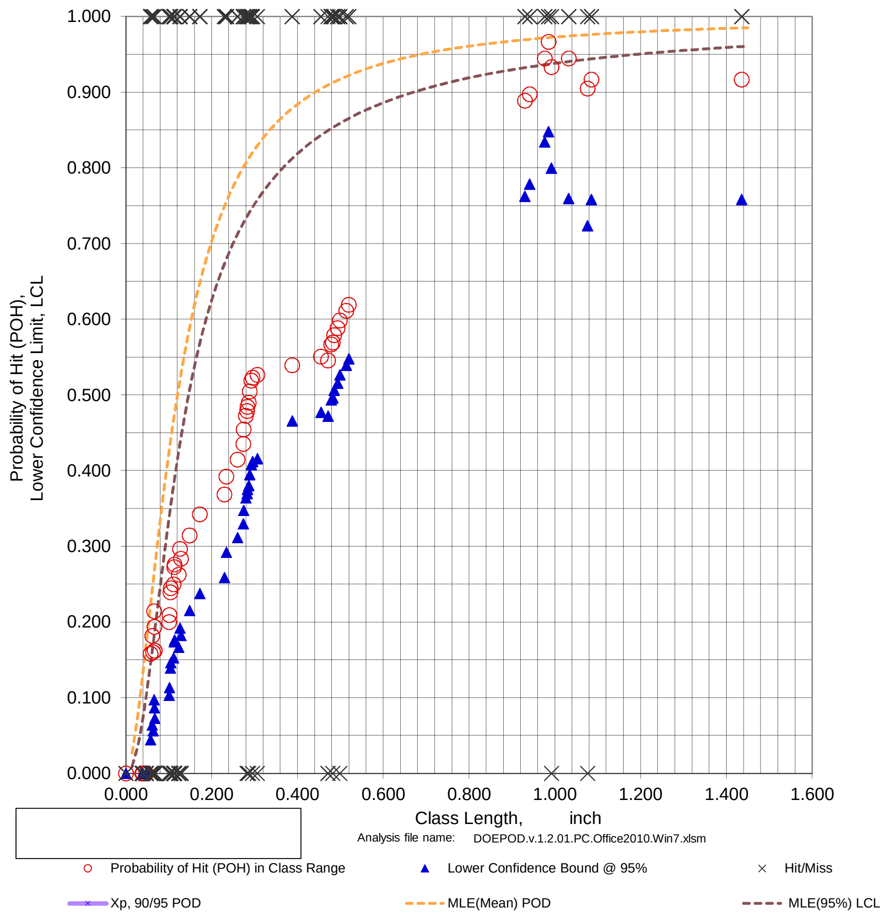
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

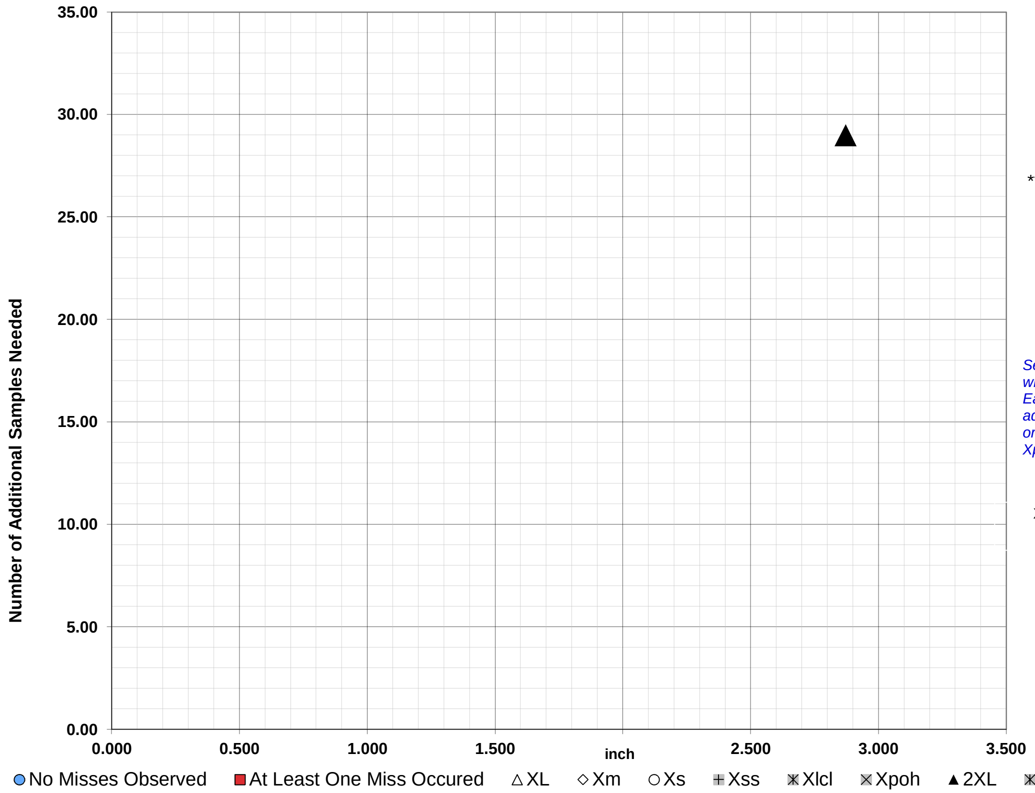


TABLE C

	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*

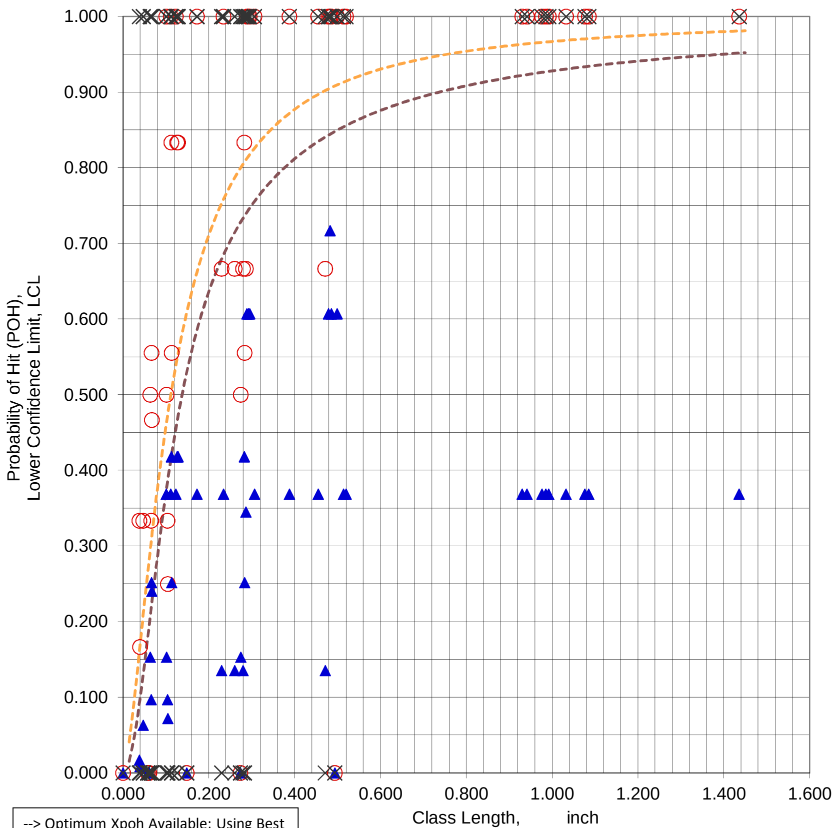
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



--> 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 = 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.)

Directed DOE Options

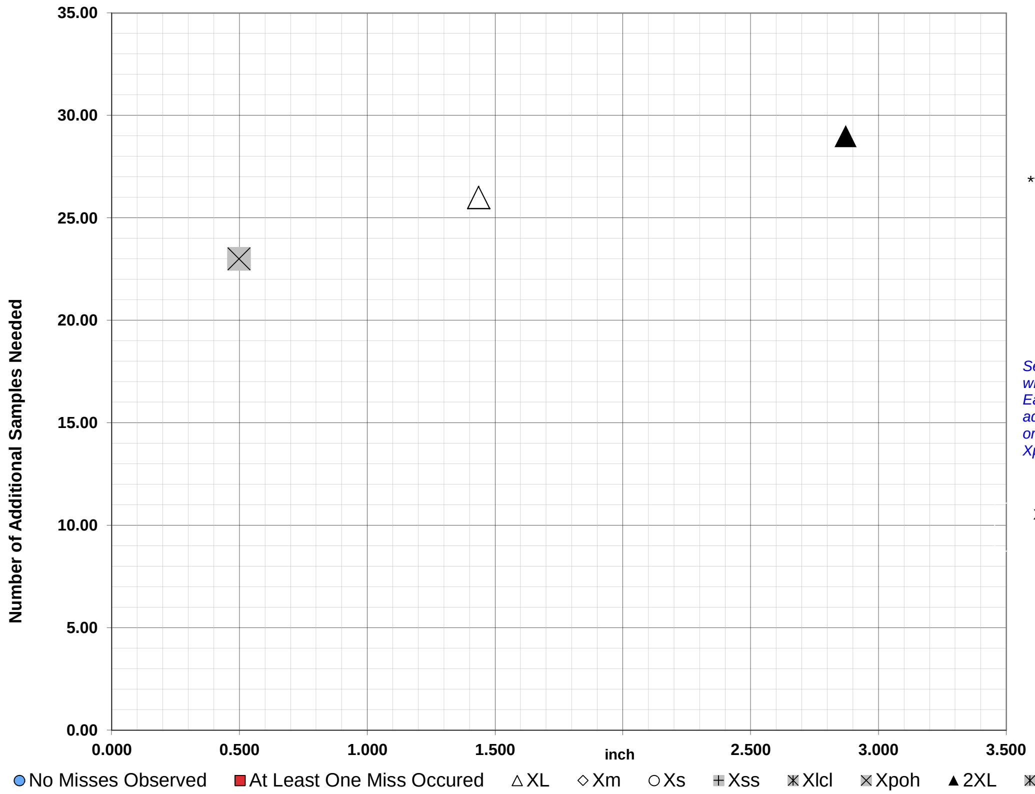


TABLE C

	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

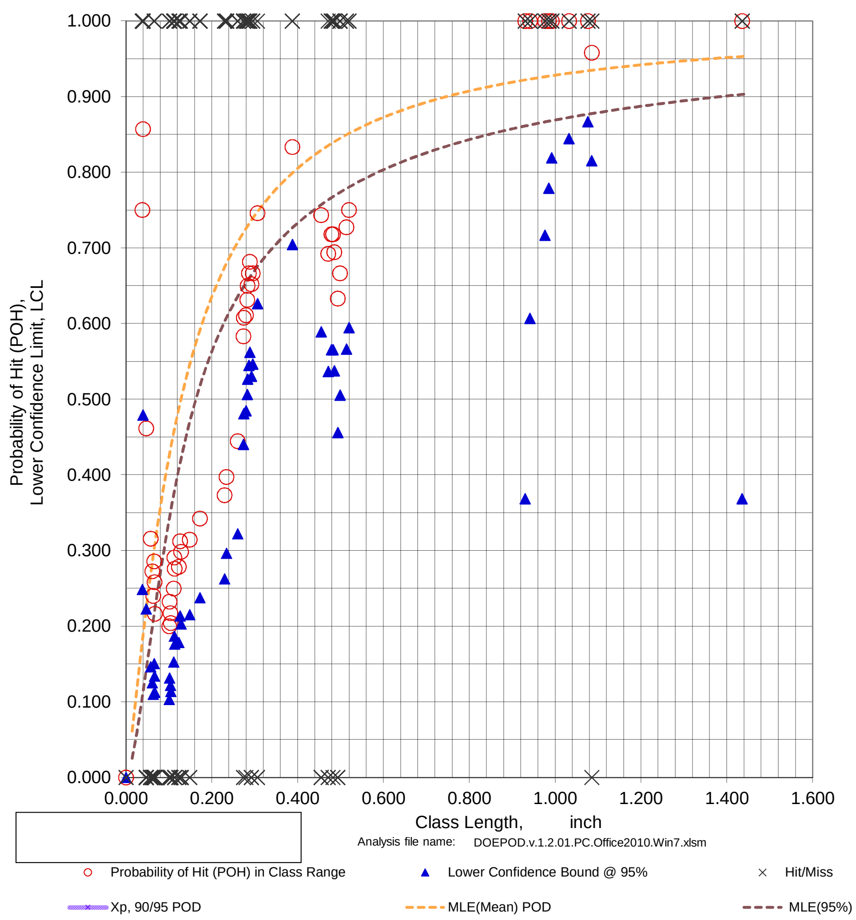
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

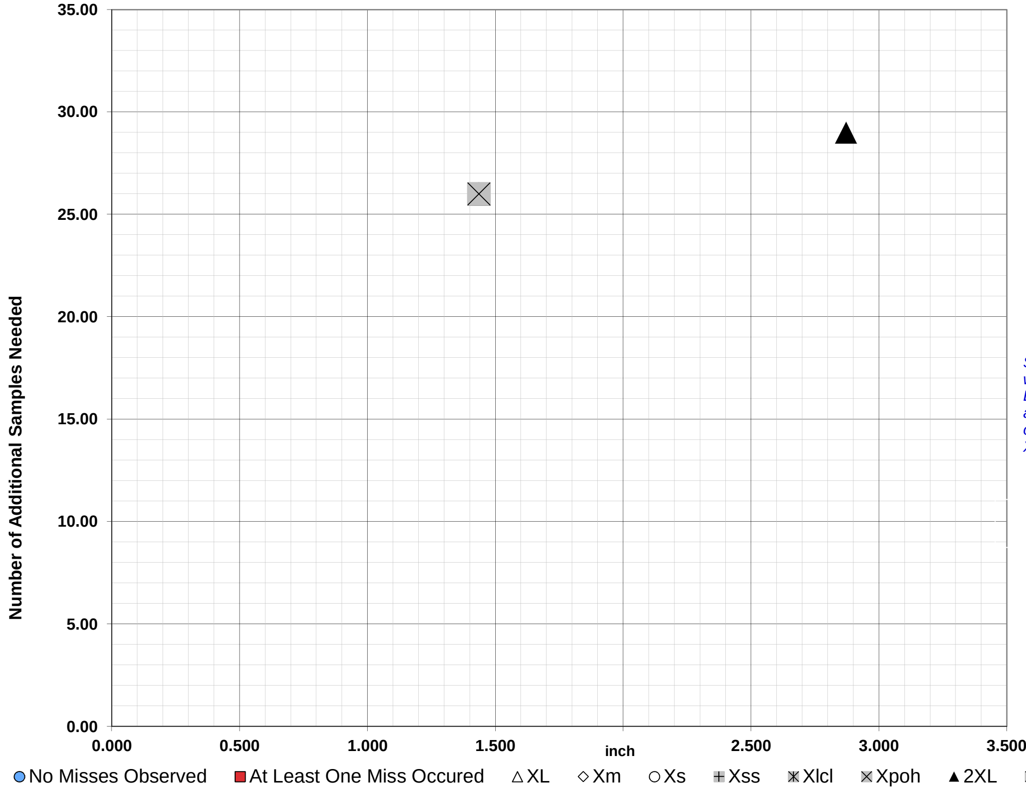


TABLE C

	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

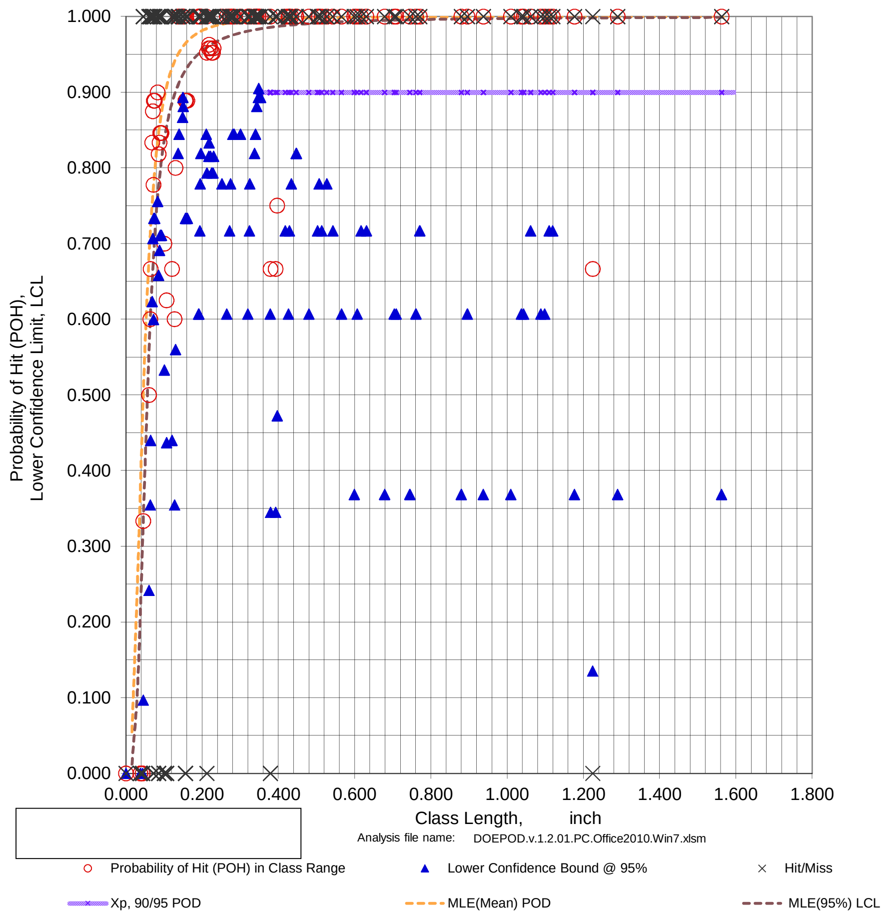
Classlength @ Best LCL = inch

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

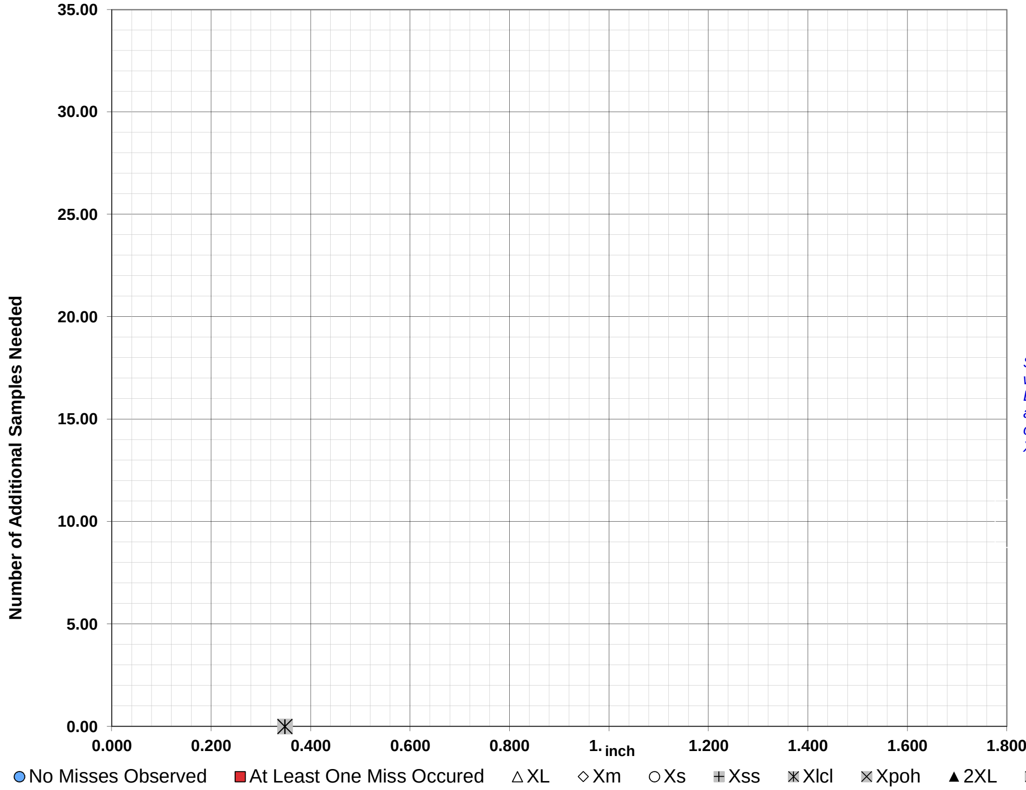


TABLE C

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

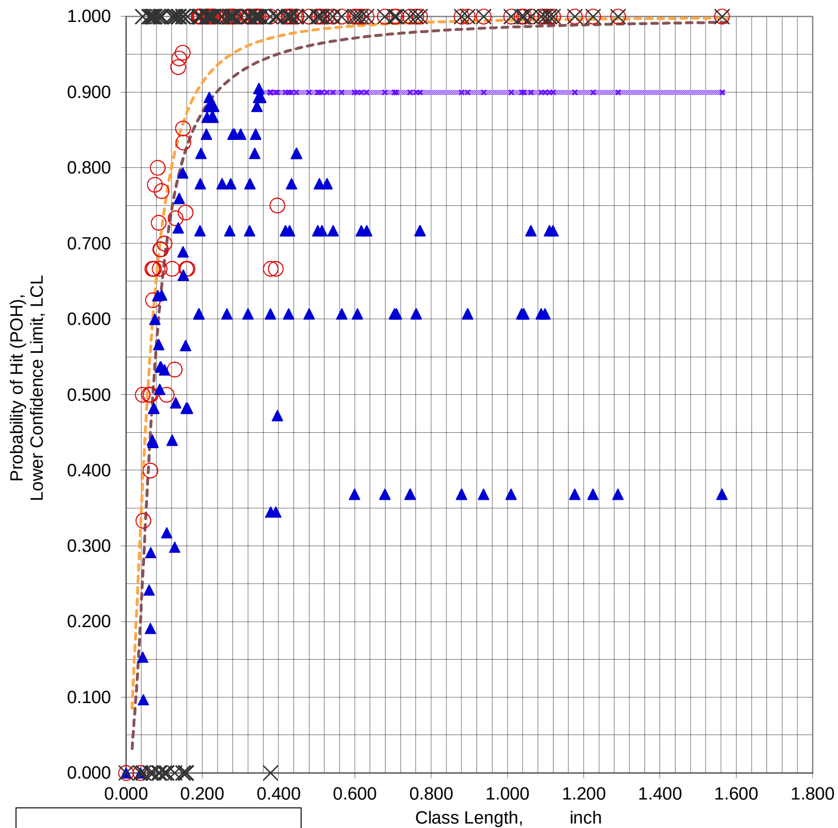
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

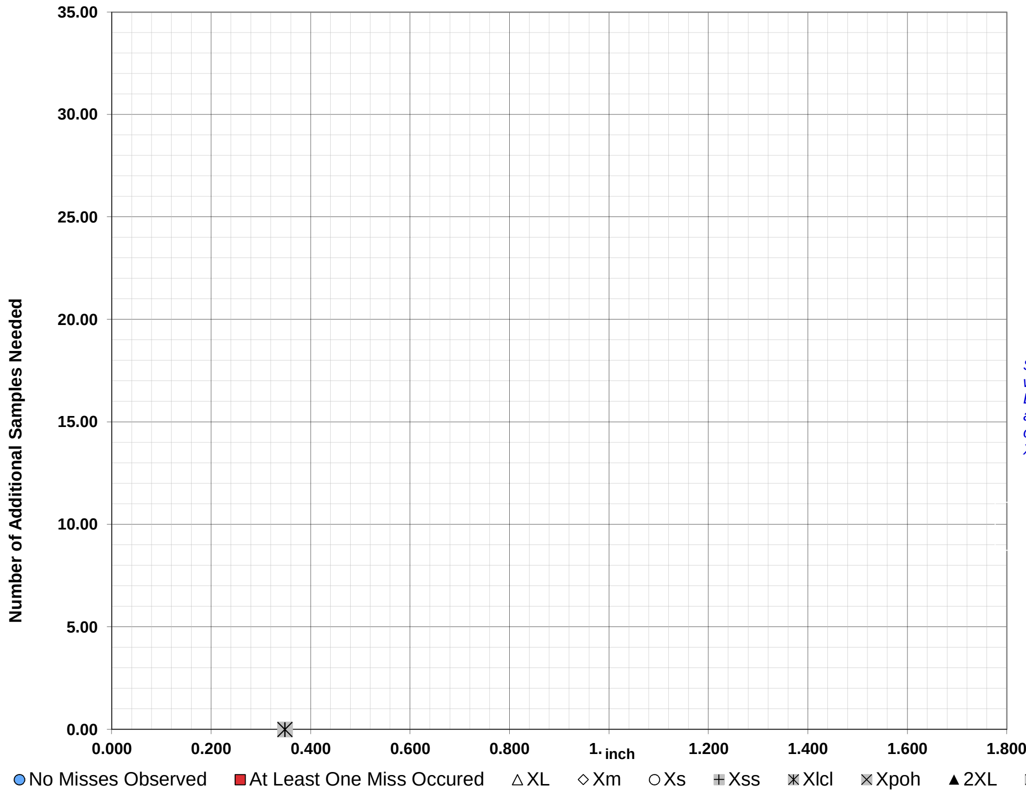


TABLE C

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

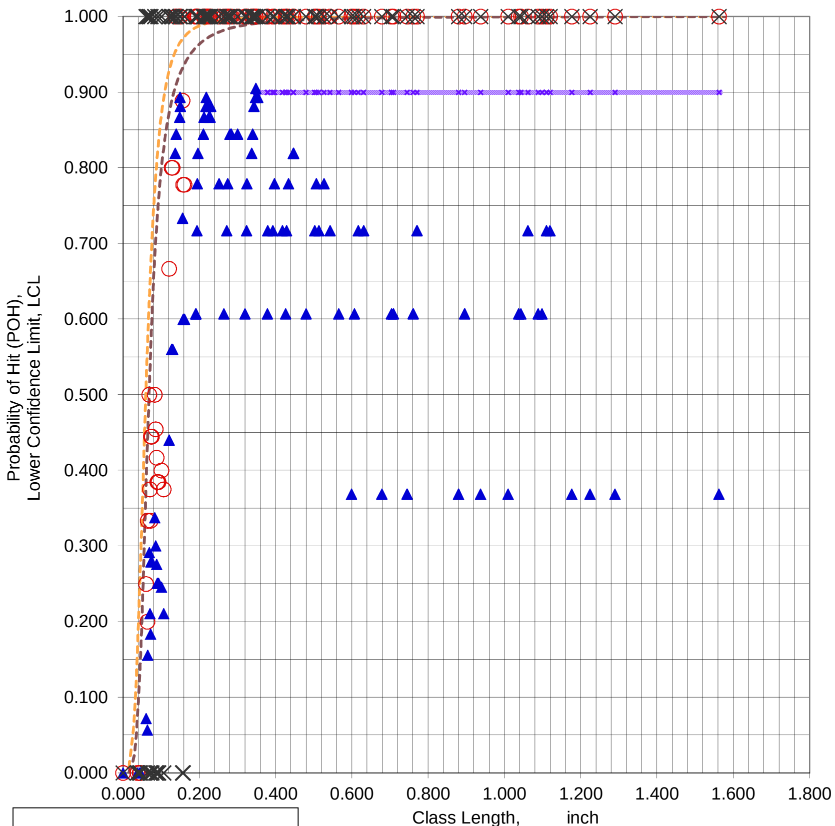
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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



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

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

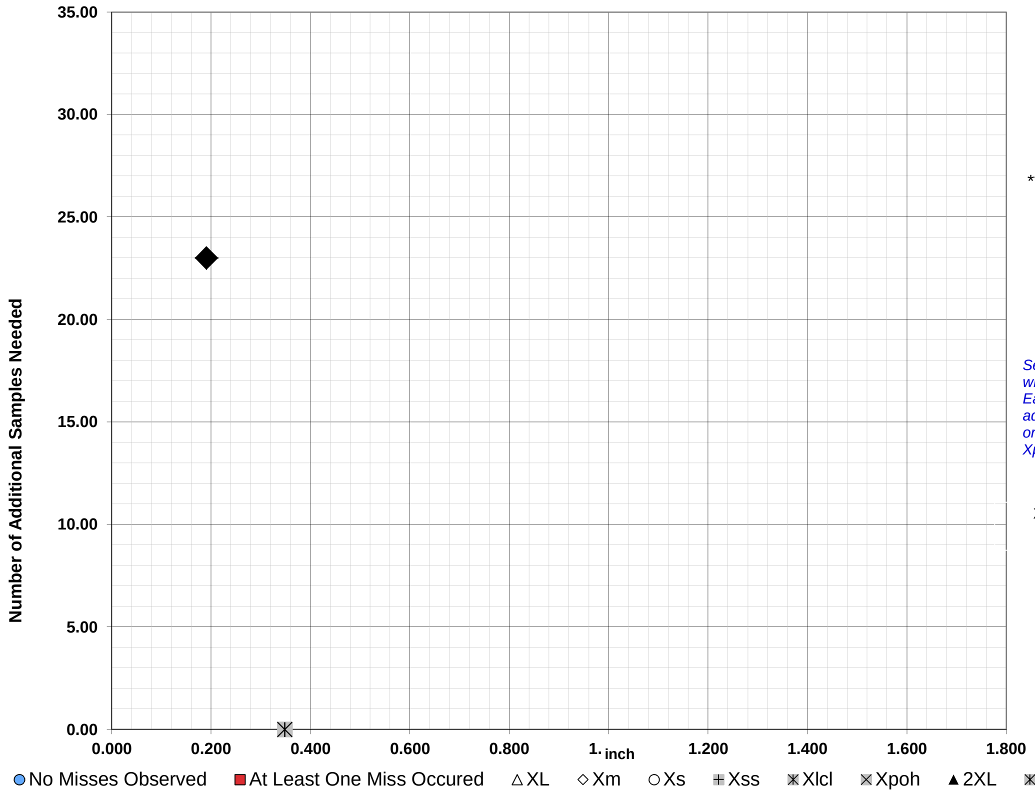


TABLE C

	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

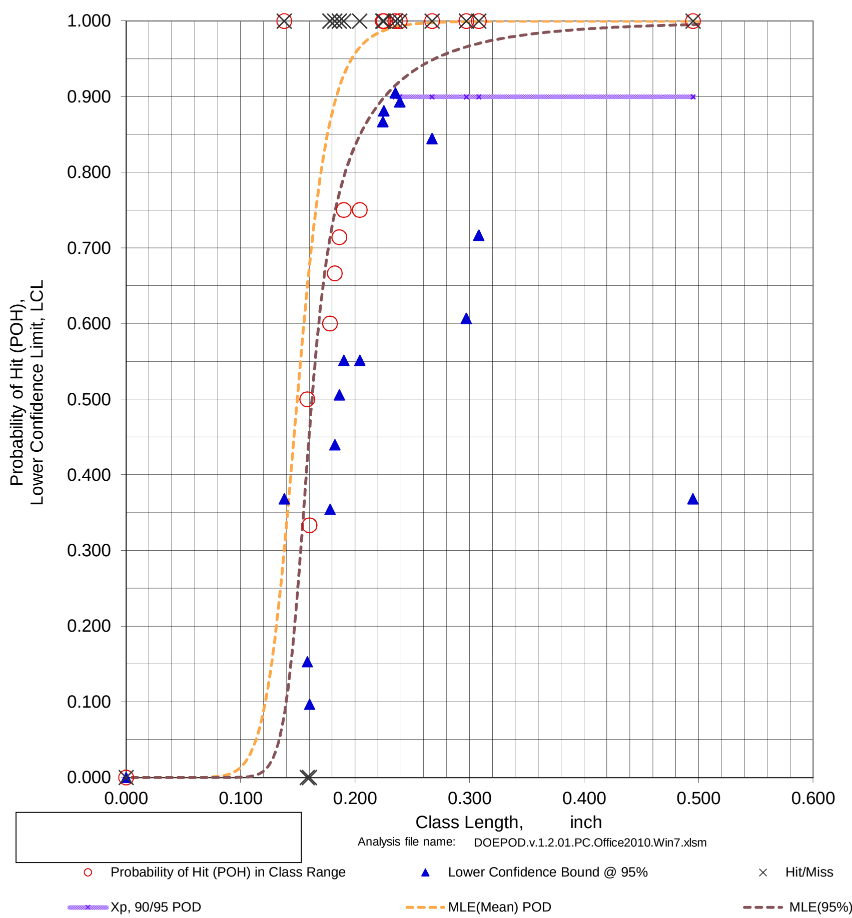
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

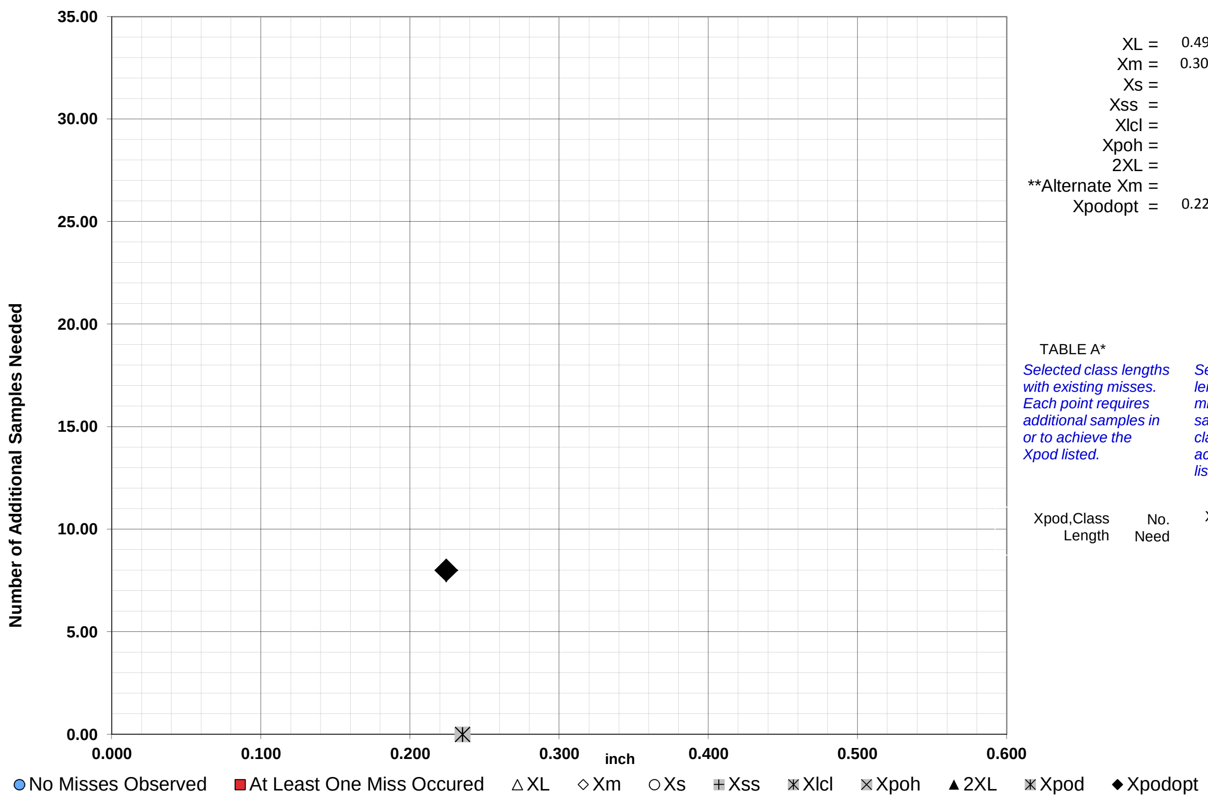


TABLE C

	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)

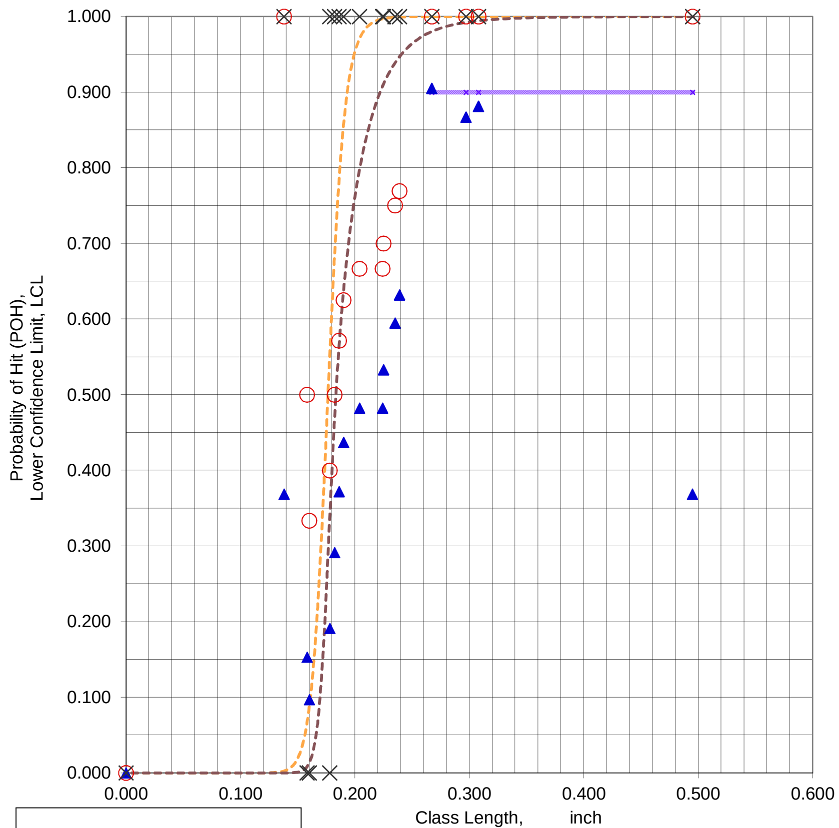
Large flaw validation failure. Extend flaw size range to 0.801.

MLE Divergence Warning: Initial results listed.

Note: Xpodopt is within one class width of Xpod.

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



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

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

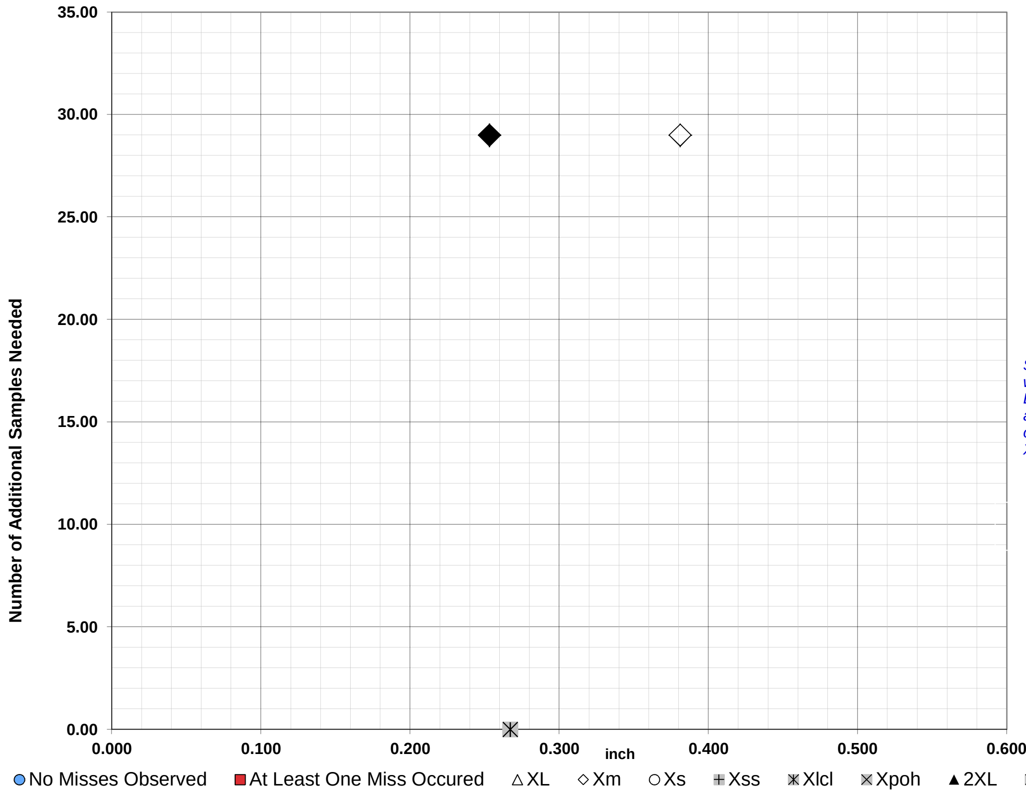


TABLE C

	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

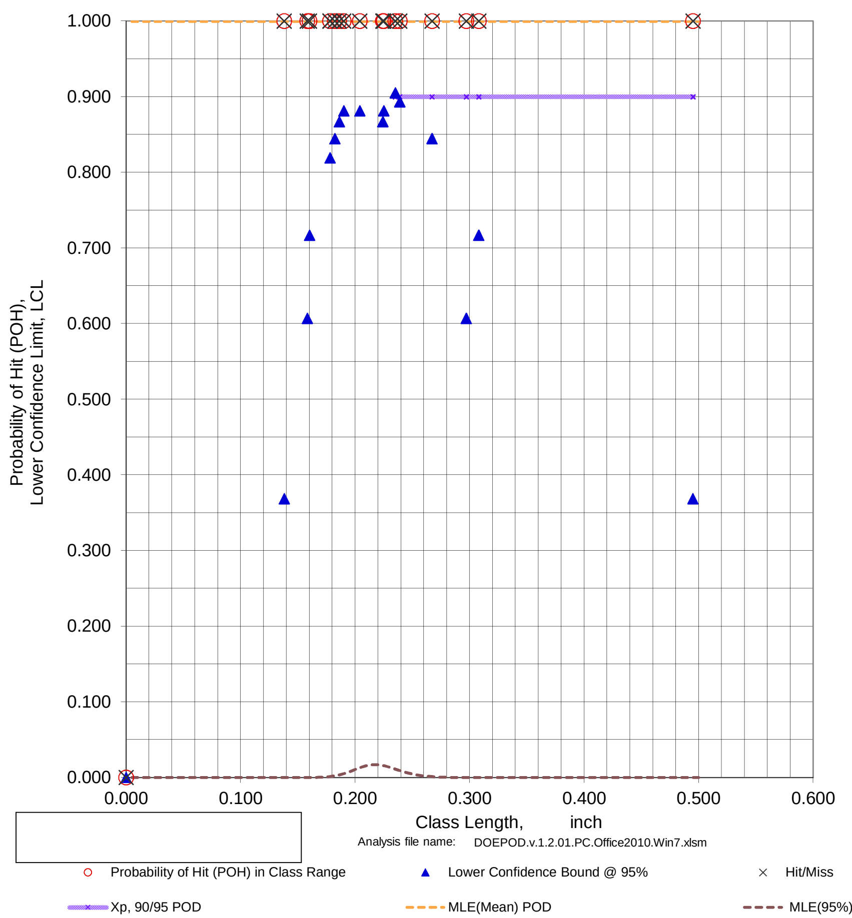
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

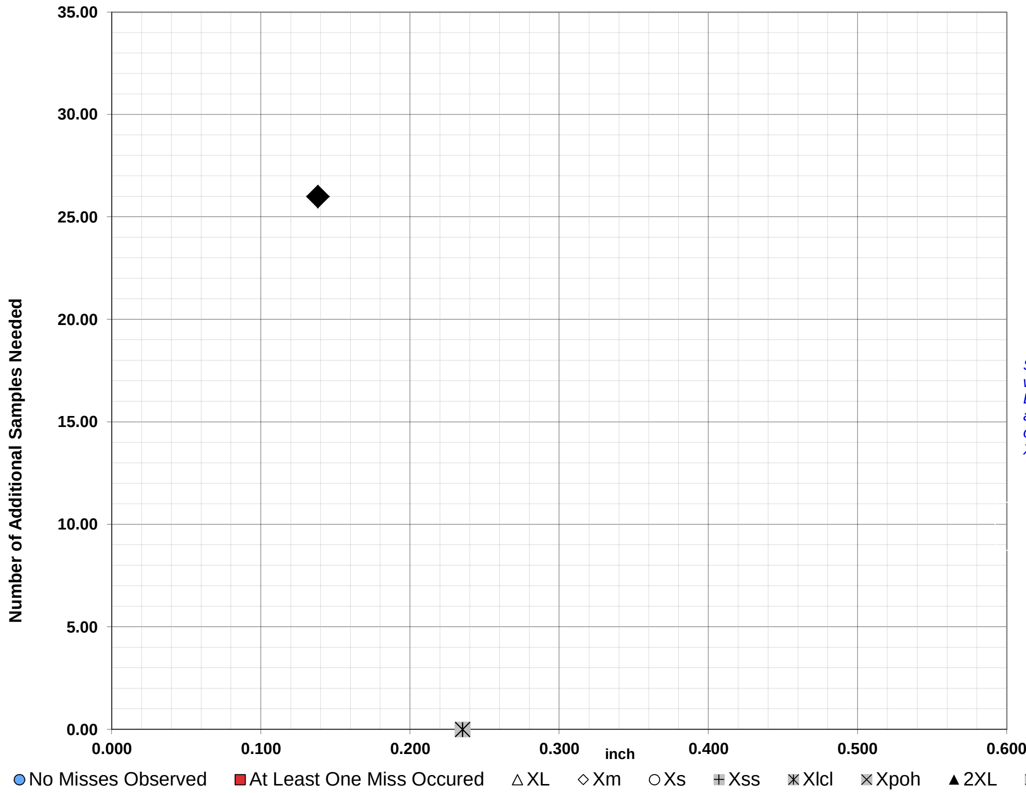


TABLE C

	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.

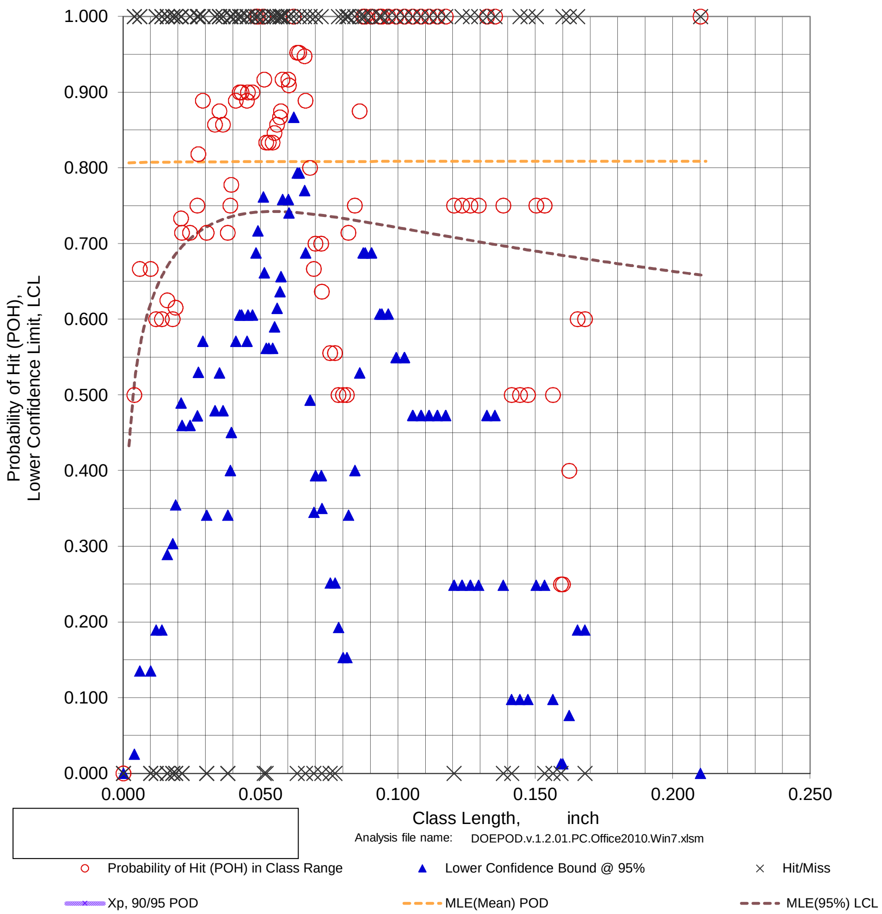
Xpod,Class Length	No. Need

* 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)

File Name = B1001AD.XLS
Data Set Name = B1001AD(CRK #)

Warning: No false call analysis.



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

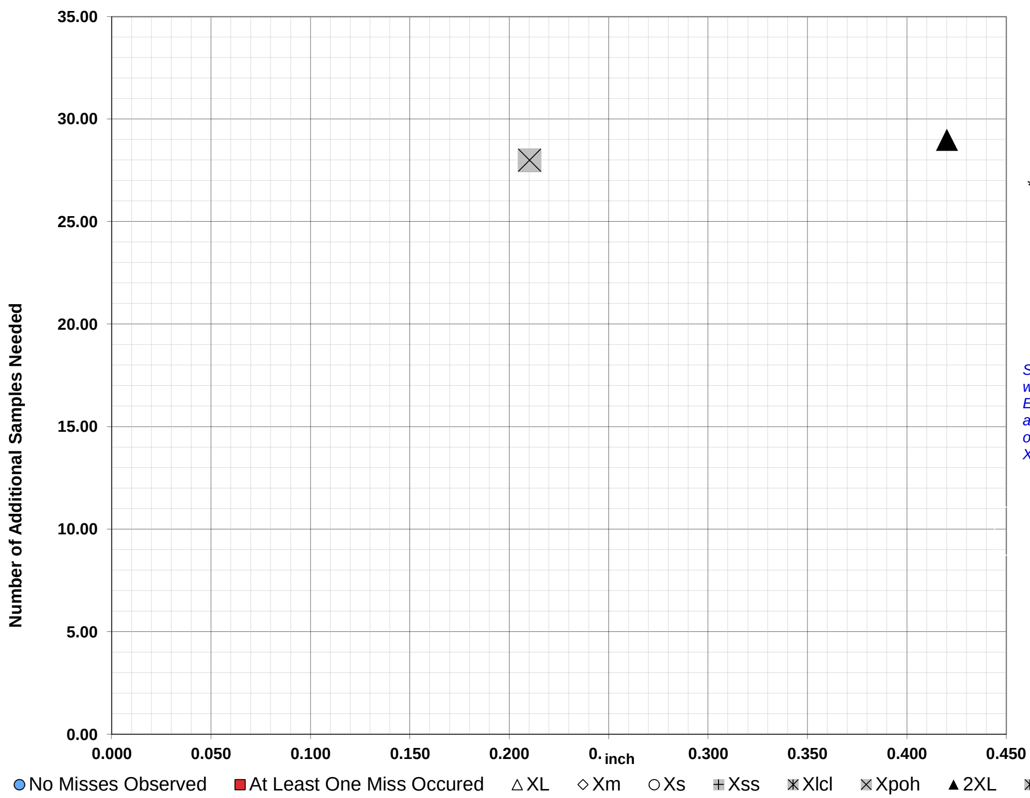


TABLE C

	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*

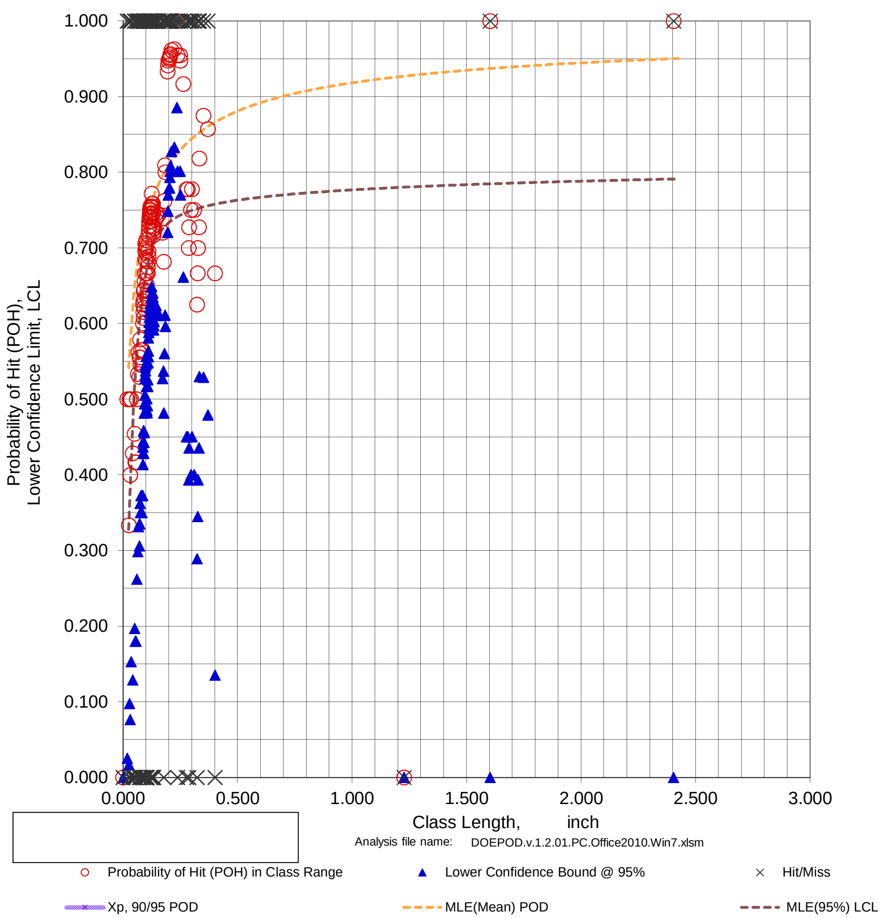
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

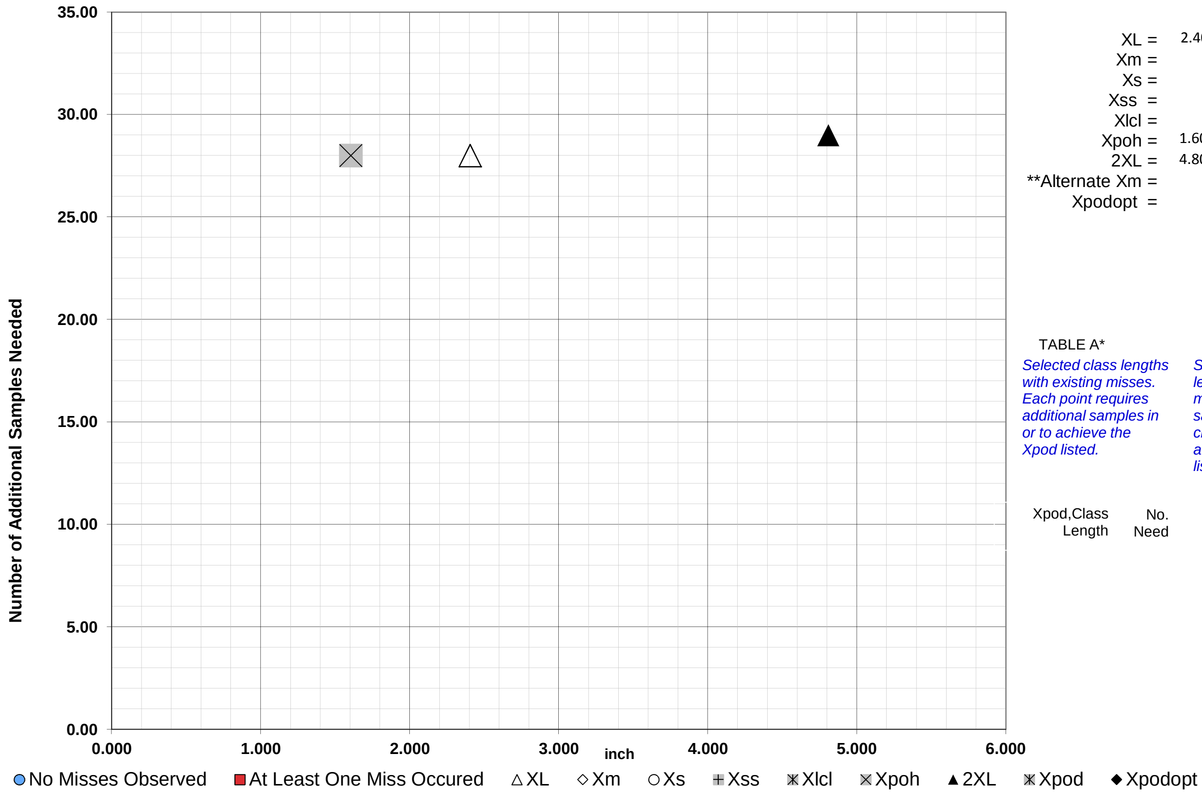


TABLE C

	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*

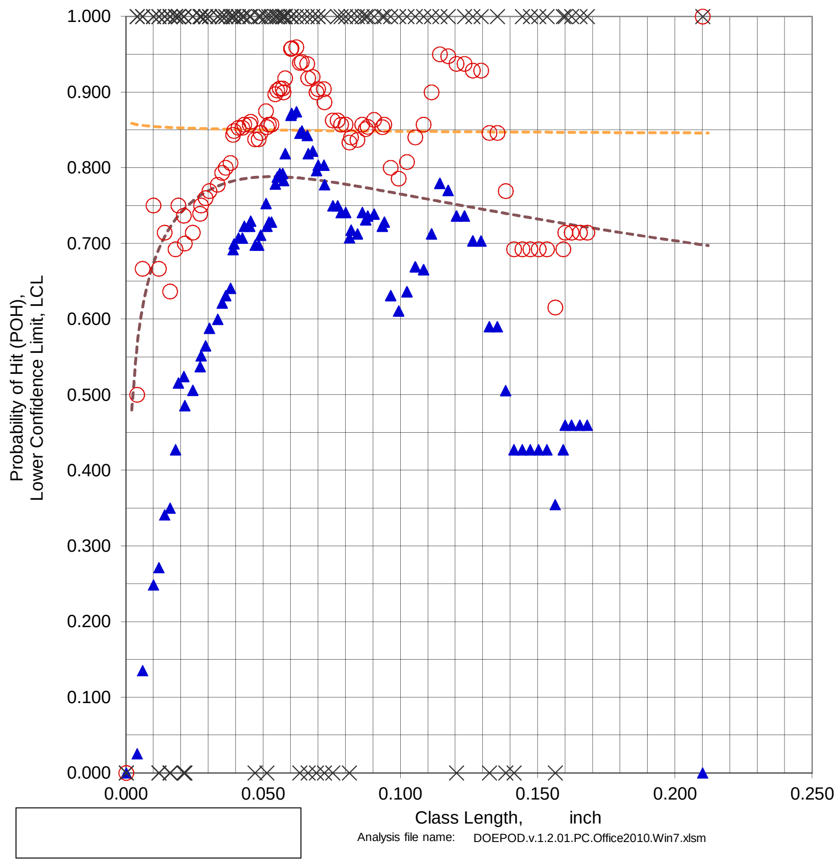
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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.

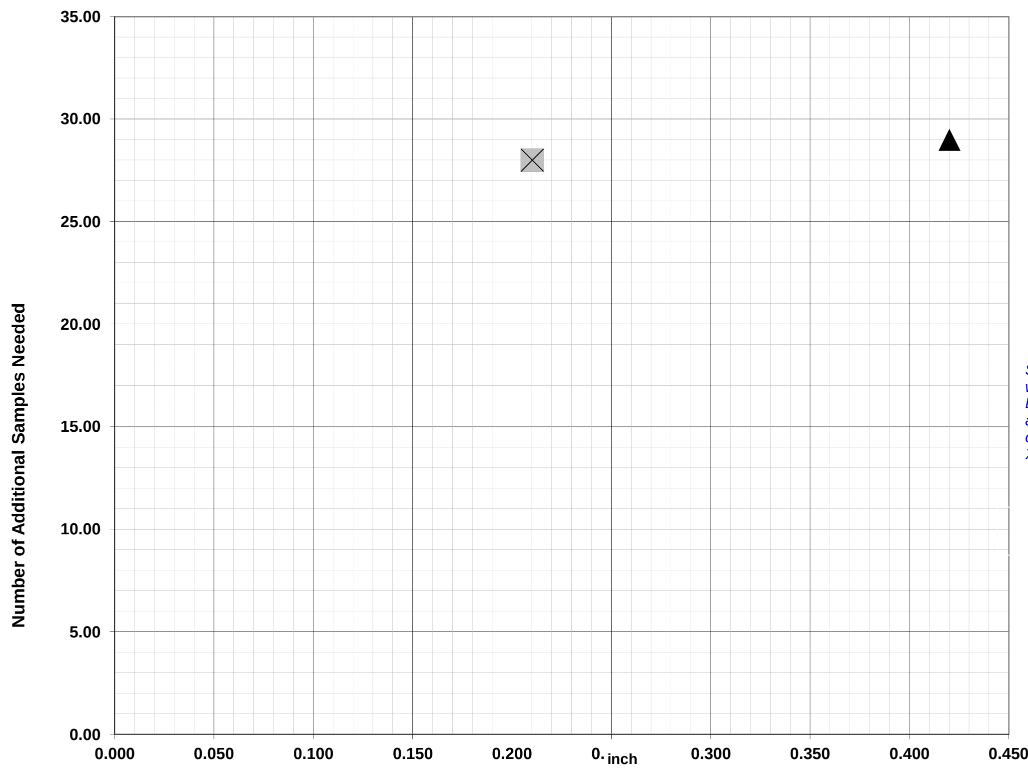
Survey/Optimum Xpoh = 0.1593 -0.002 inch 28 Samples

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



● No Misses Observed ■ At Least One Miss Occured △ XL ◇ Xm ○ Xs ⊞ Xss ⋇ Xlcl ⊠ Xpoh ▲ 2XL ⋇ Xpod ◆ Xpodopt

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*

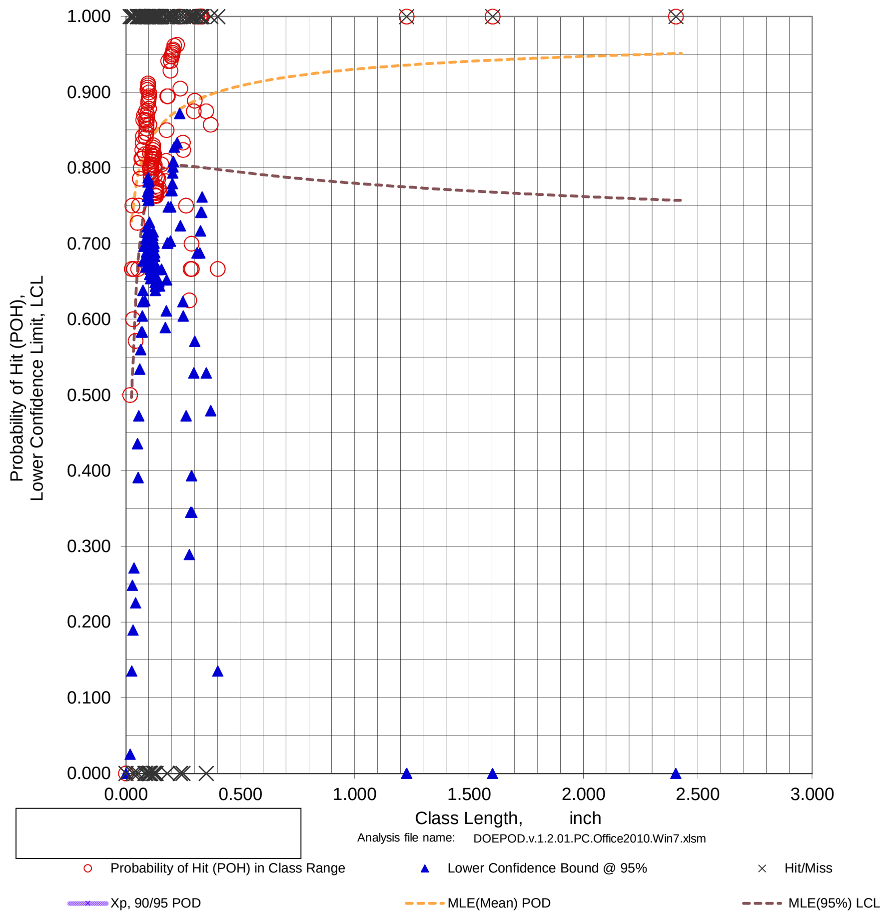
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

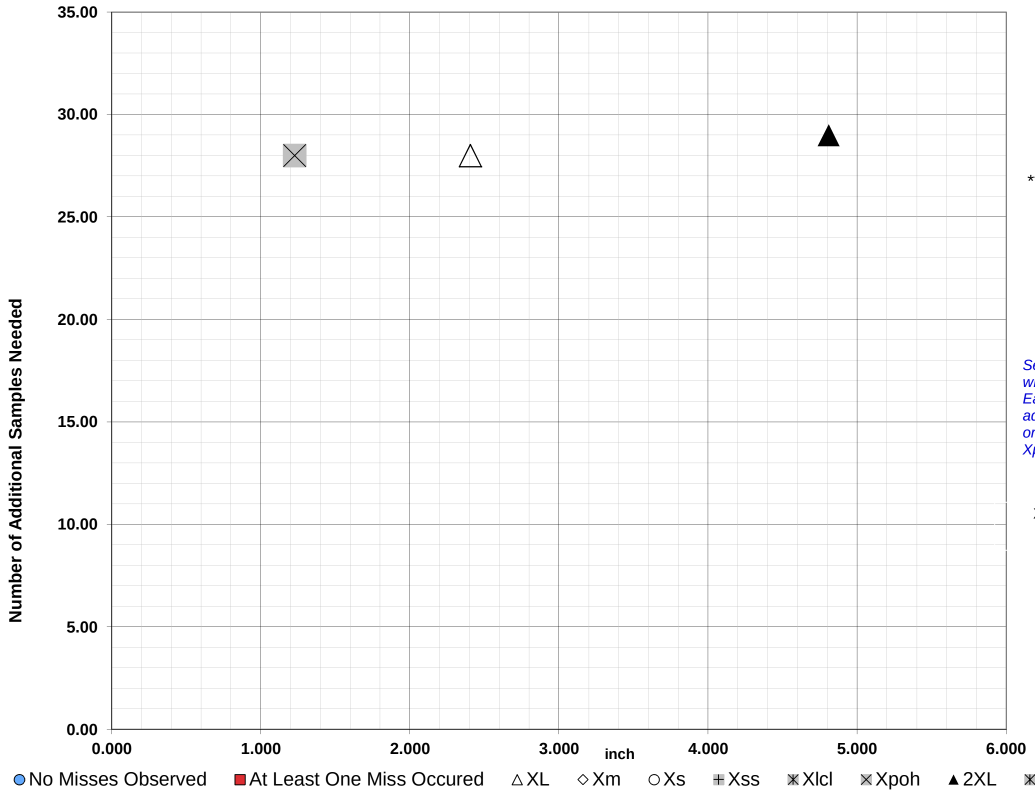


TABLE C

	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.

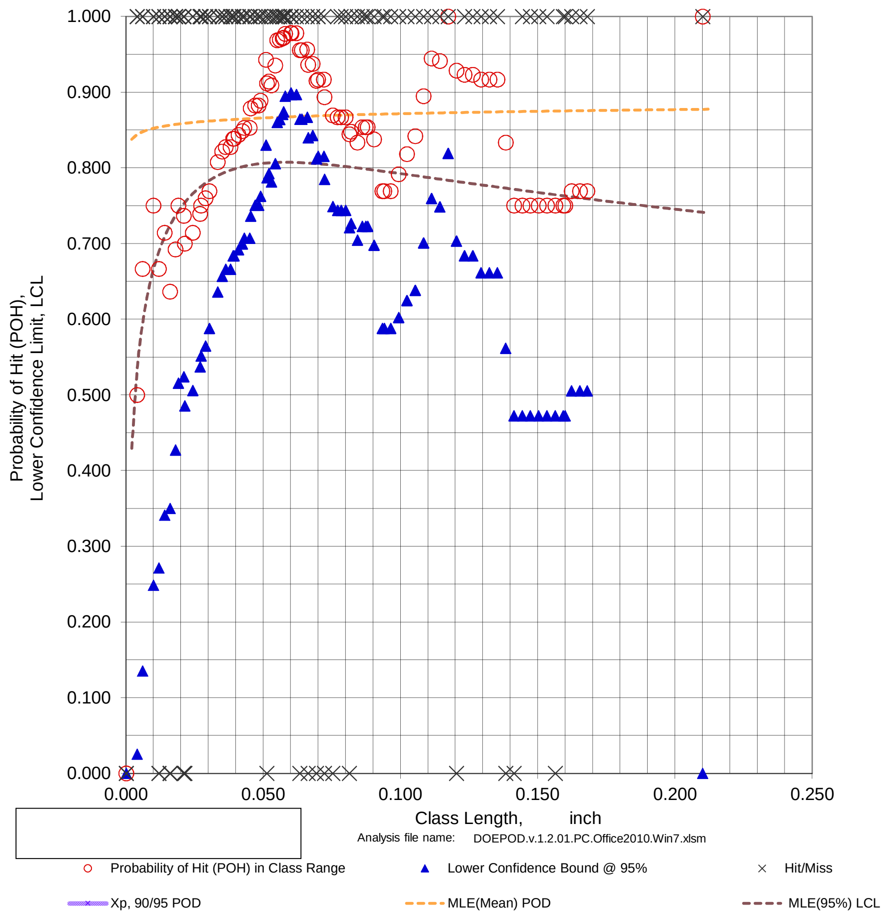
Xpod,Class Length	No. Need

* 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 =

Samples Needed @Xpodopt =

Xp = inch

File Name = B1001CD.XLS
Data Set Name = B1001CD(CRK #)

Directed DOE Options

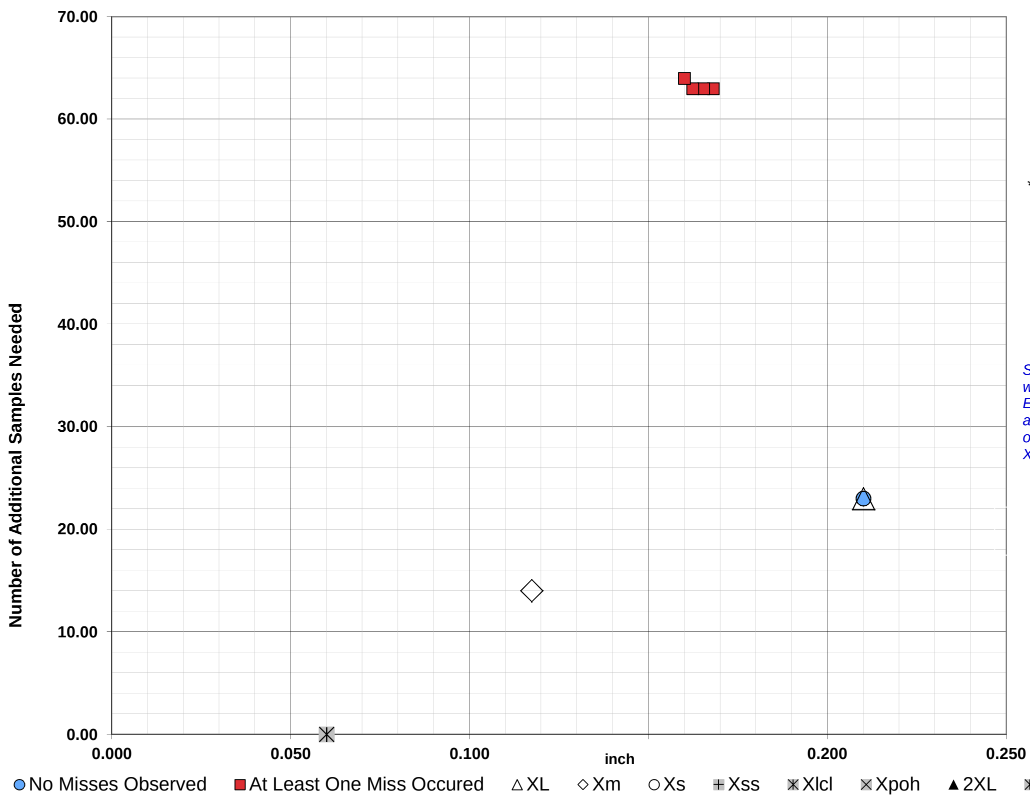


TABLE C

	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.

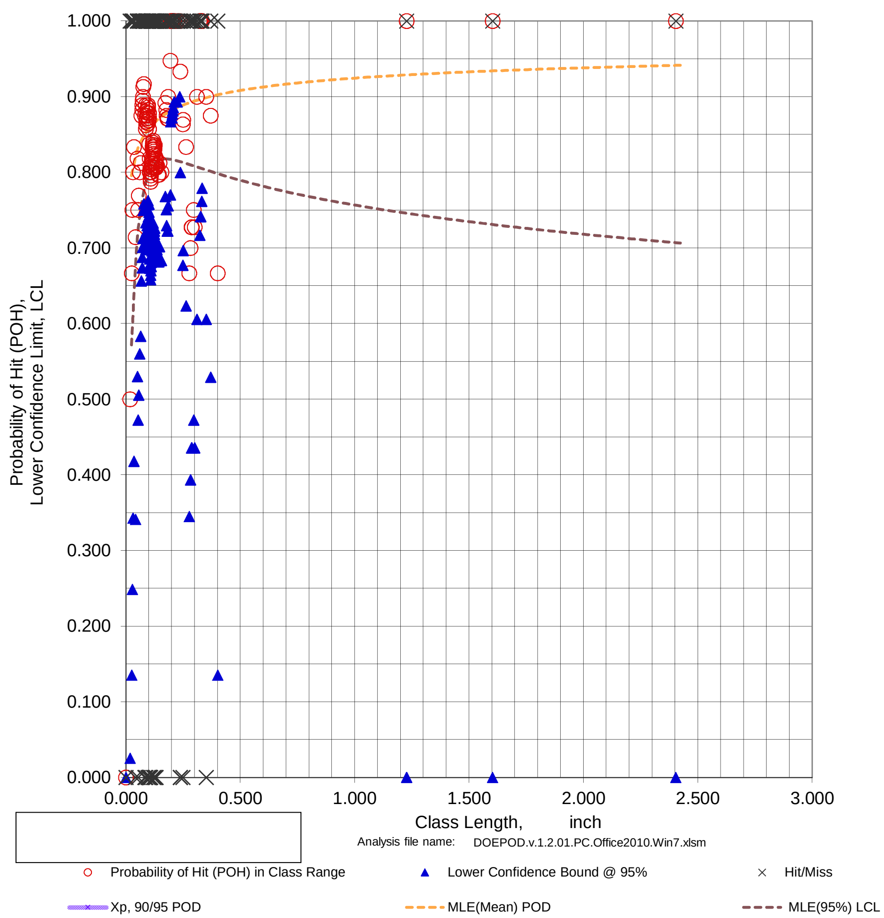
Xpod,Class Length	No. Need
0.2100	23

* 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

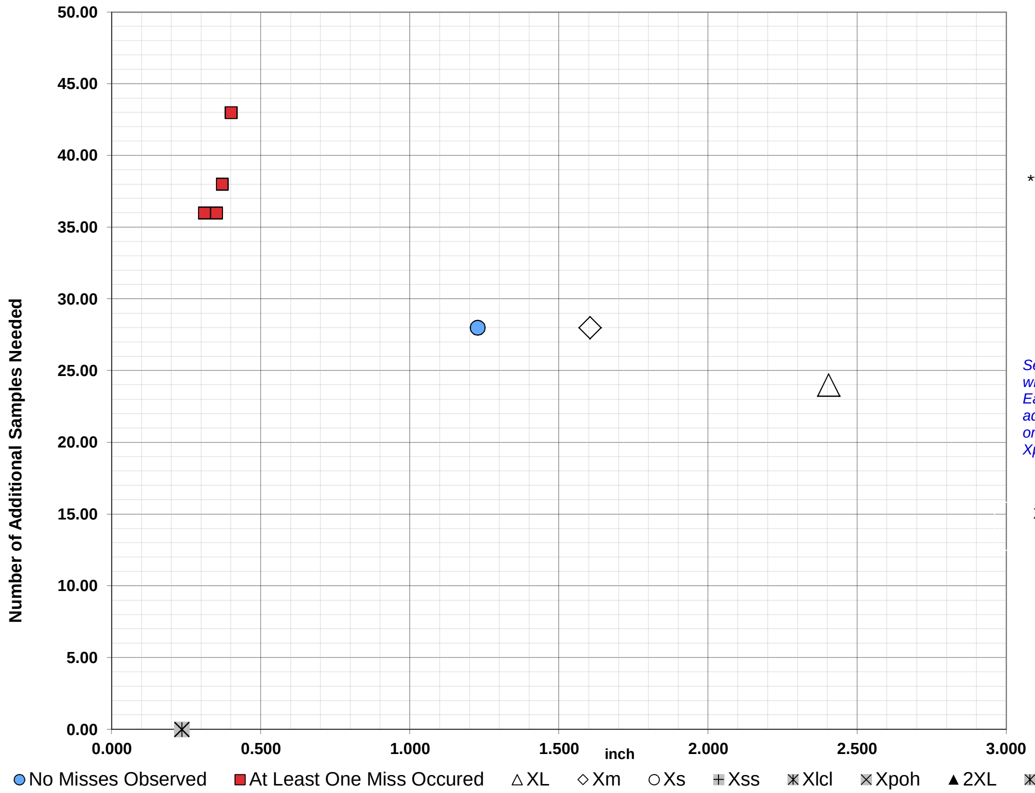


TABLE C

	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*

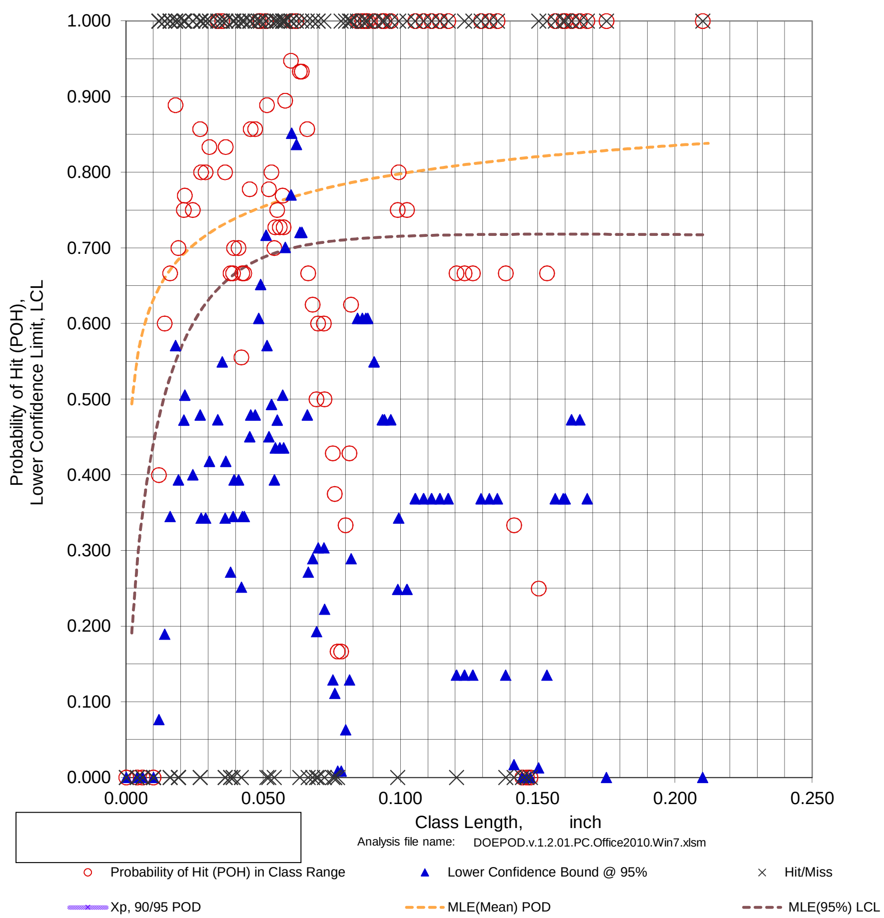
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

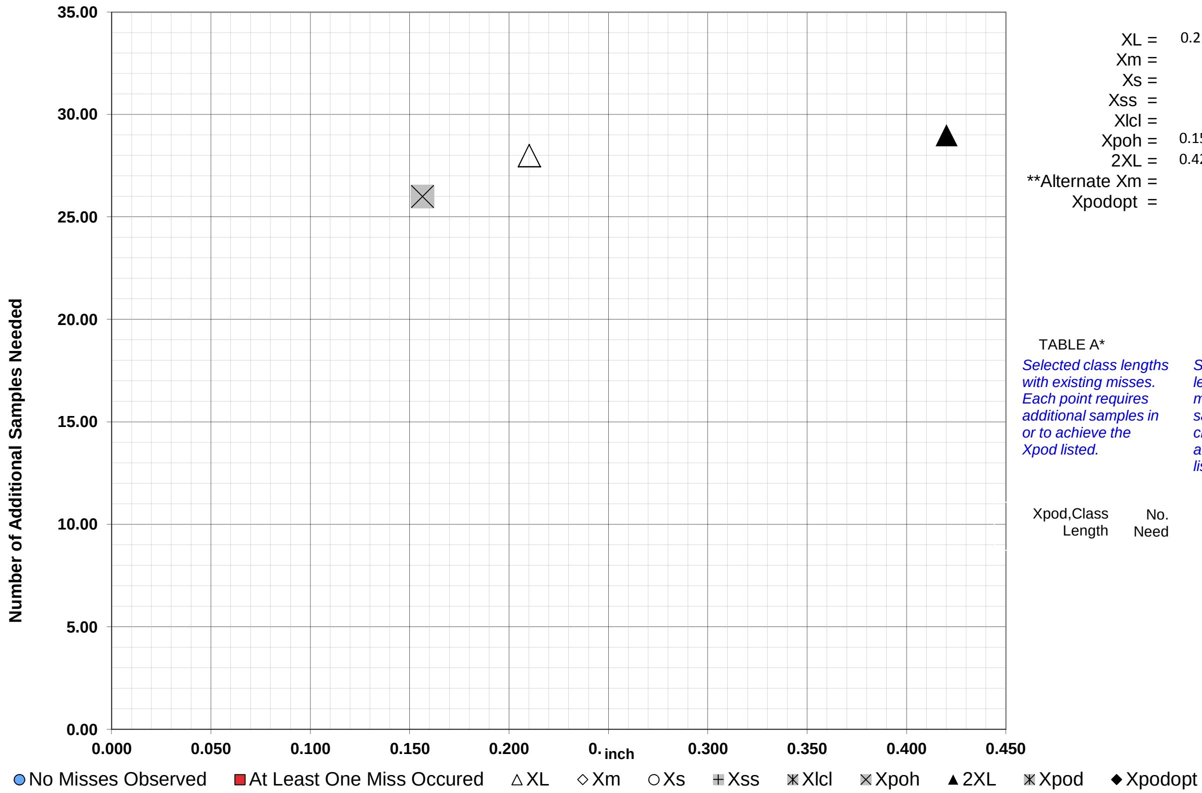


TABLE C

	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.

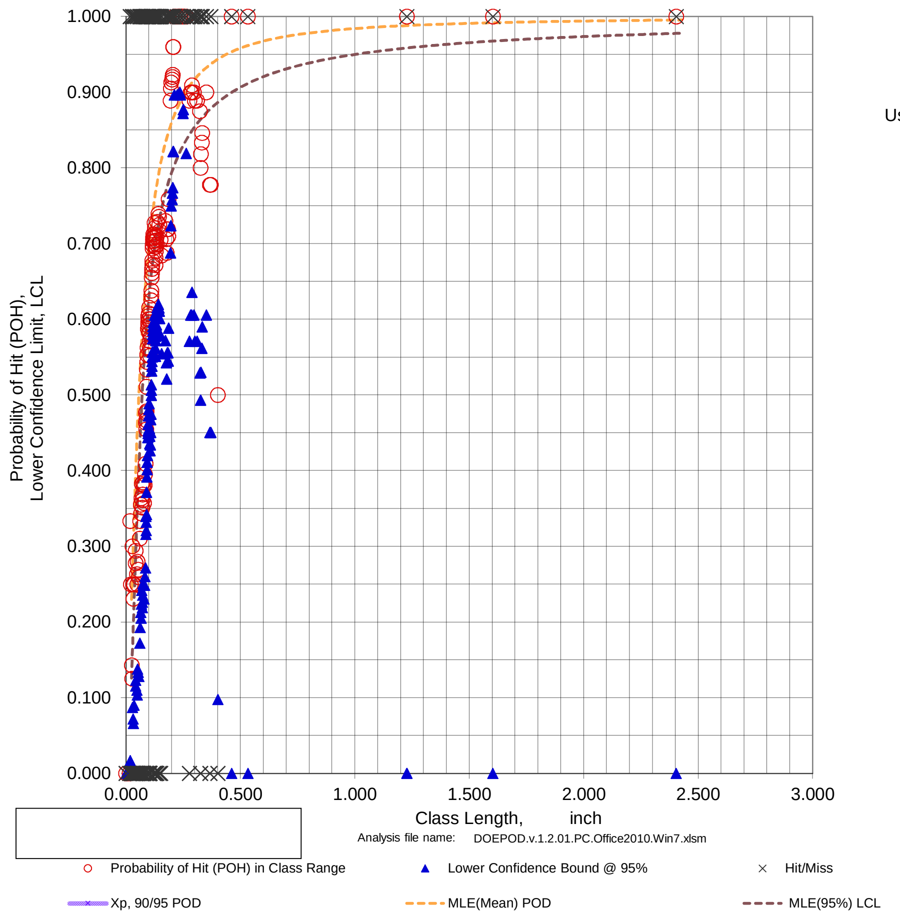
Xpod,Class Length	No. Need

* 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

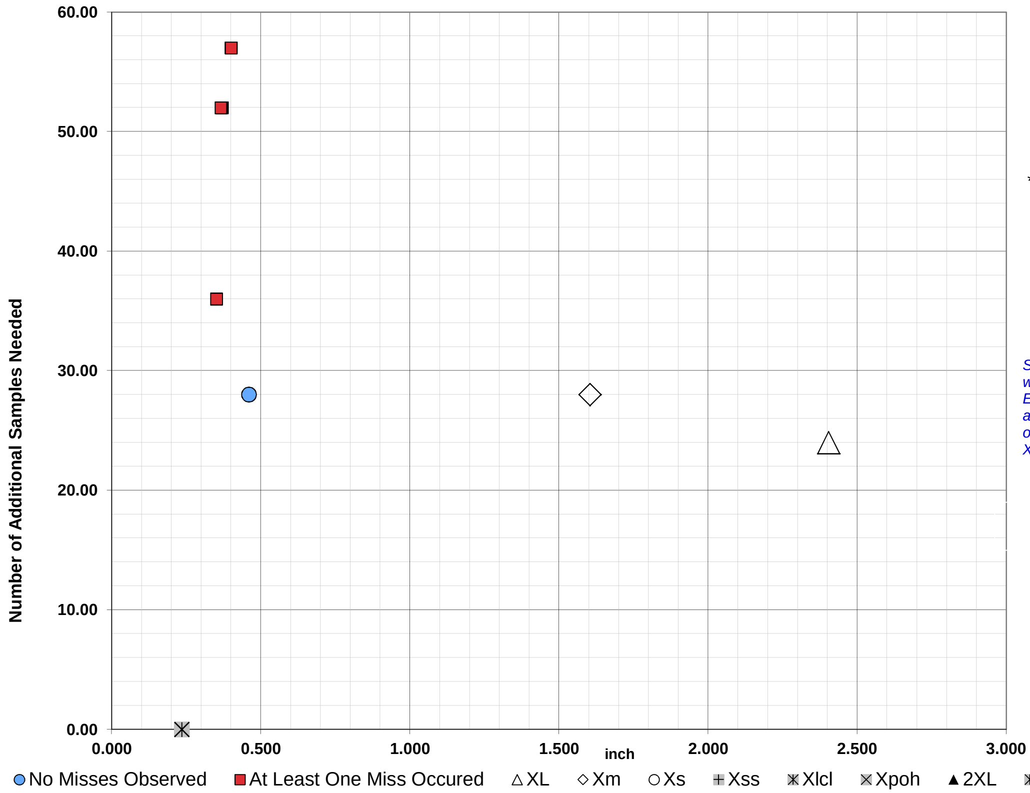


TABLE C

	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.

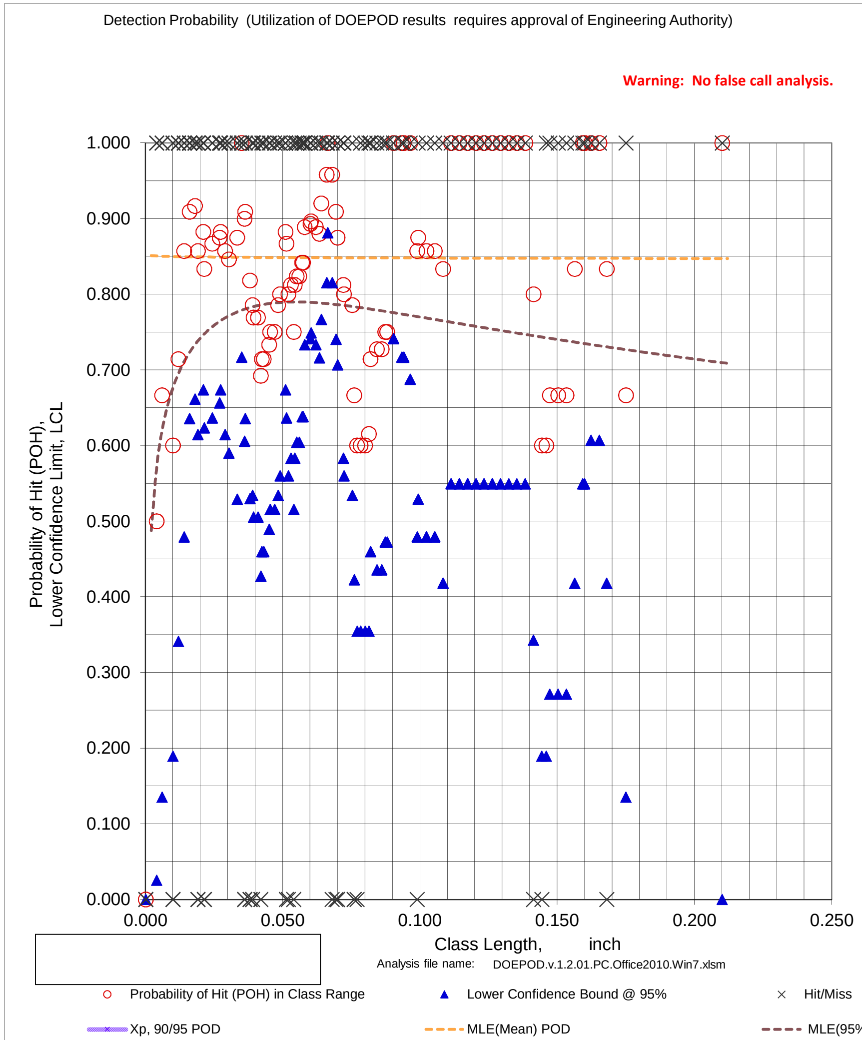
Xpod,Class Length	No. Need
0.4000	57
0.3700	52
0.3650	52
0.3500	36

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



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

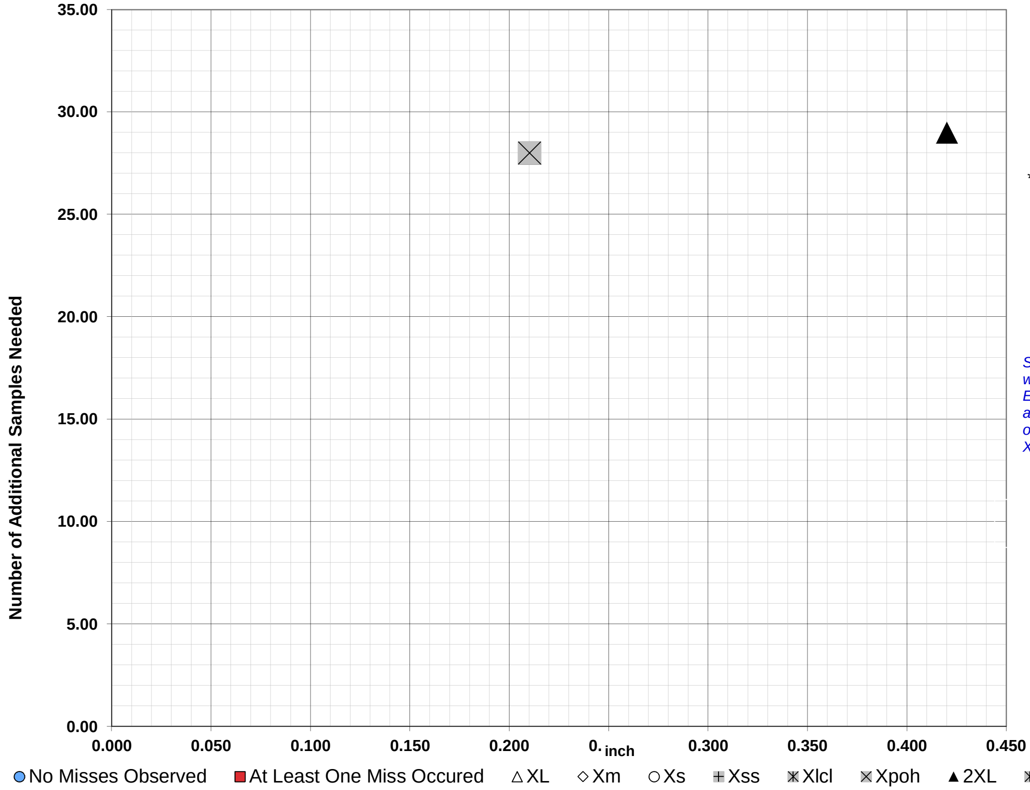


TABLE C

	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

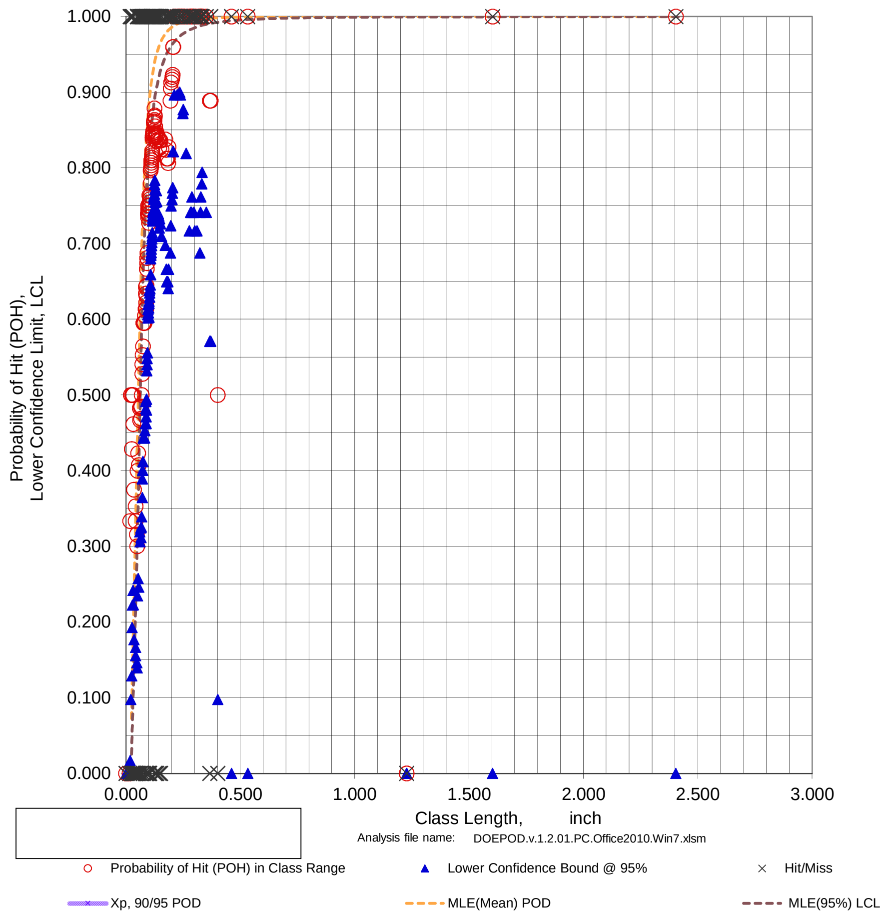
Classlength @ Best LCL = inch

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

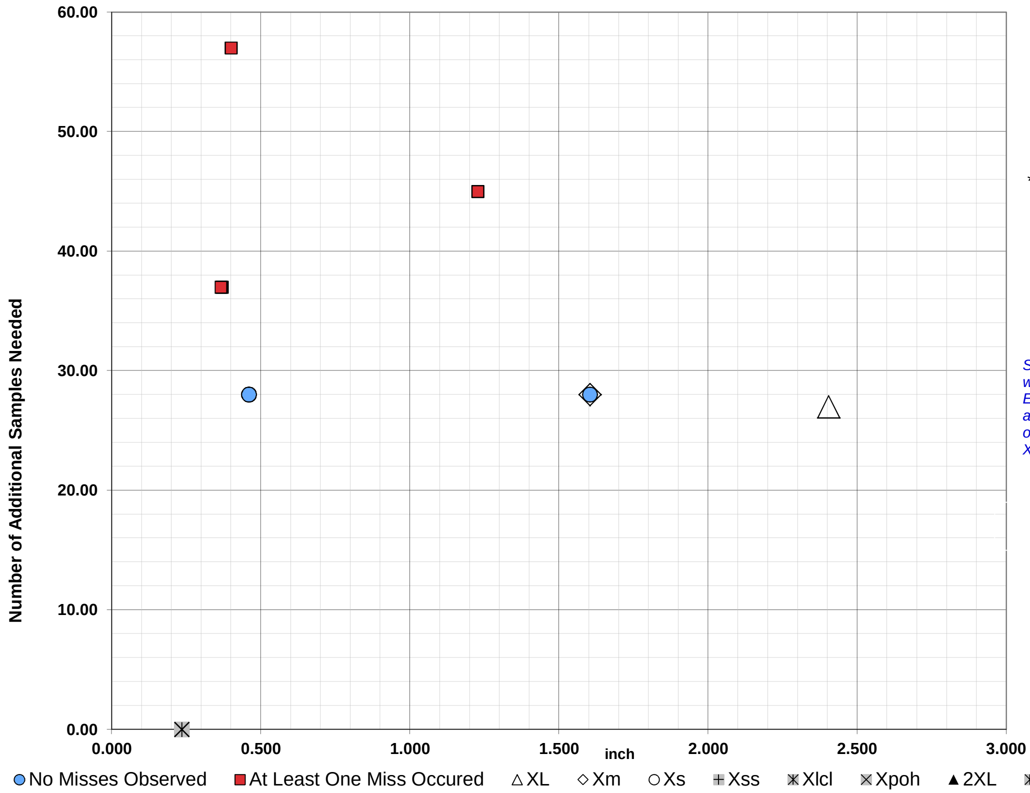


TABLE C

	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.

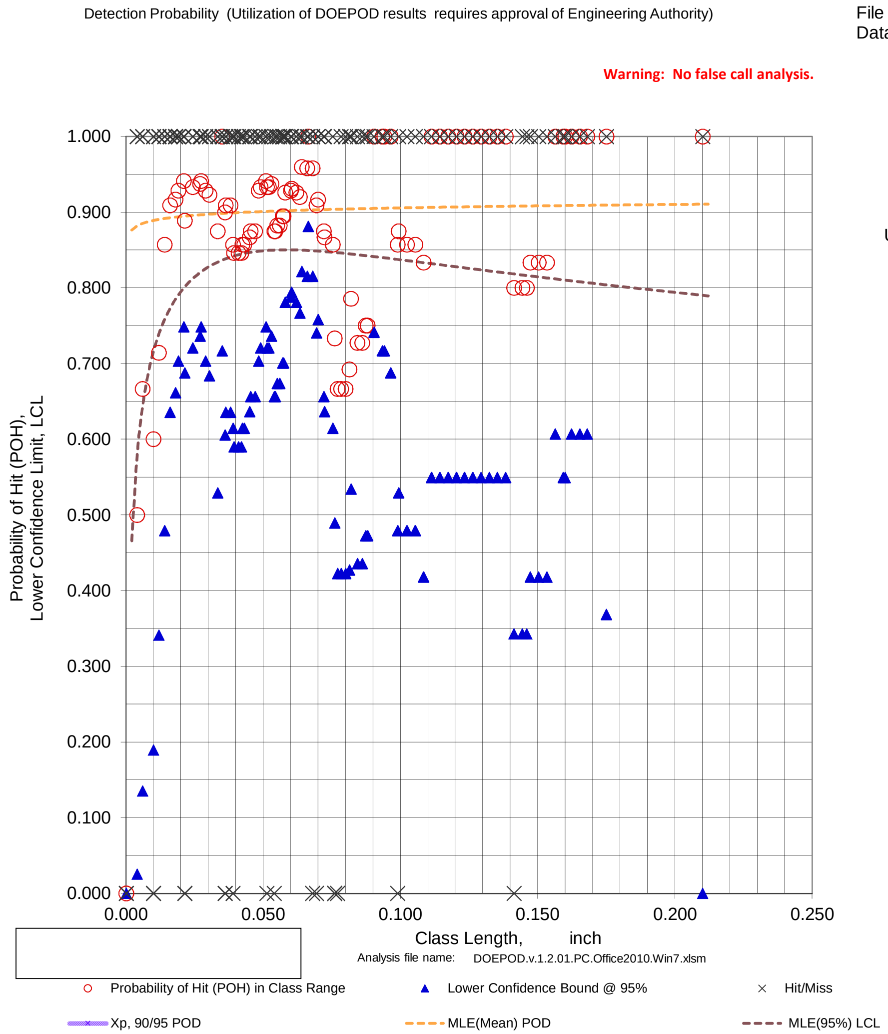
Xpod,Class Length	No. Need
1.2270	45
0.4000	57
0.3700	37
0.3650	37

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



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

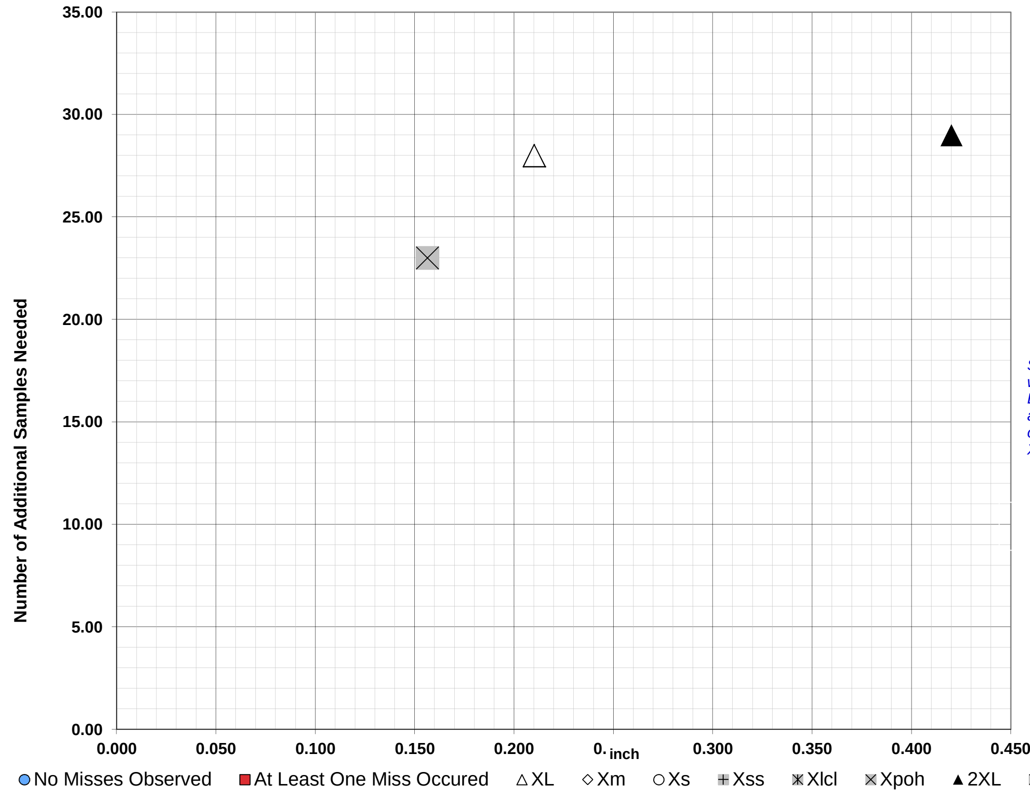


TABLE C

	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

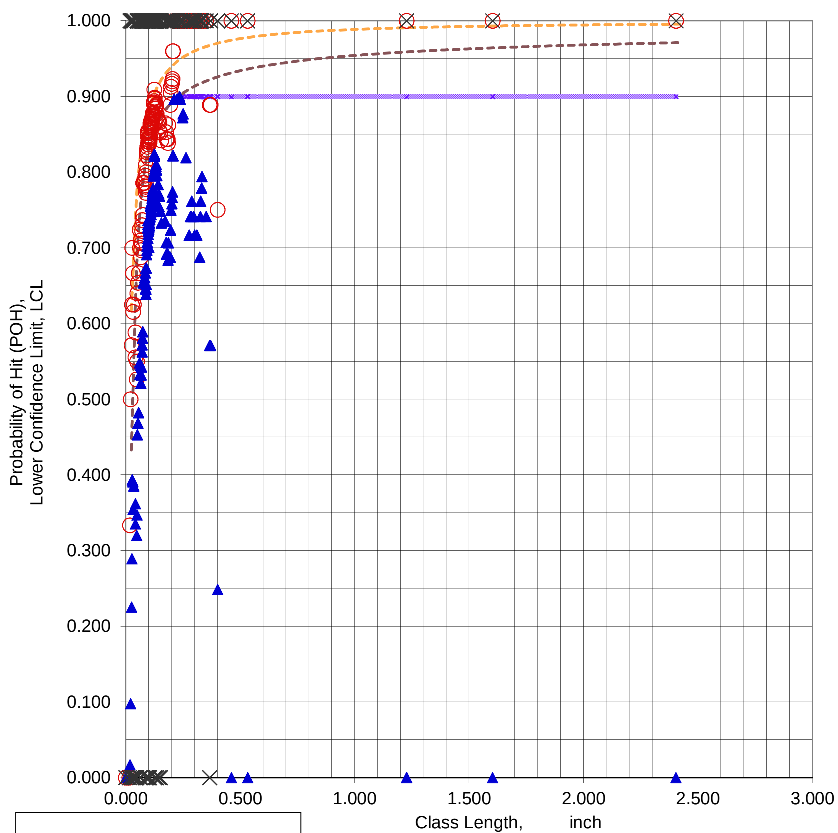
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 =	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

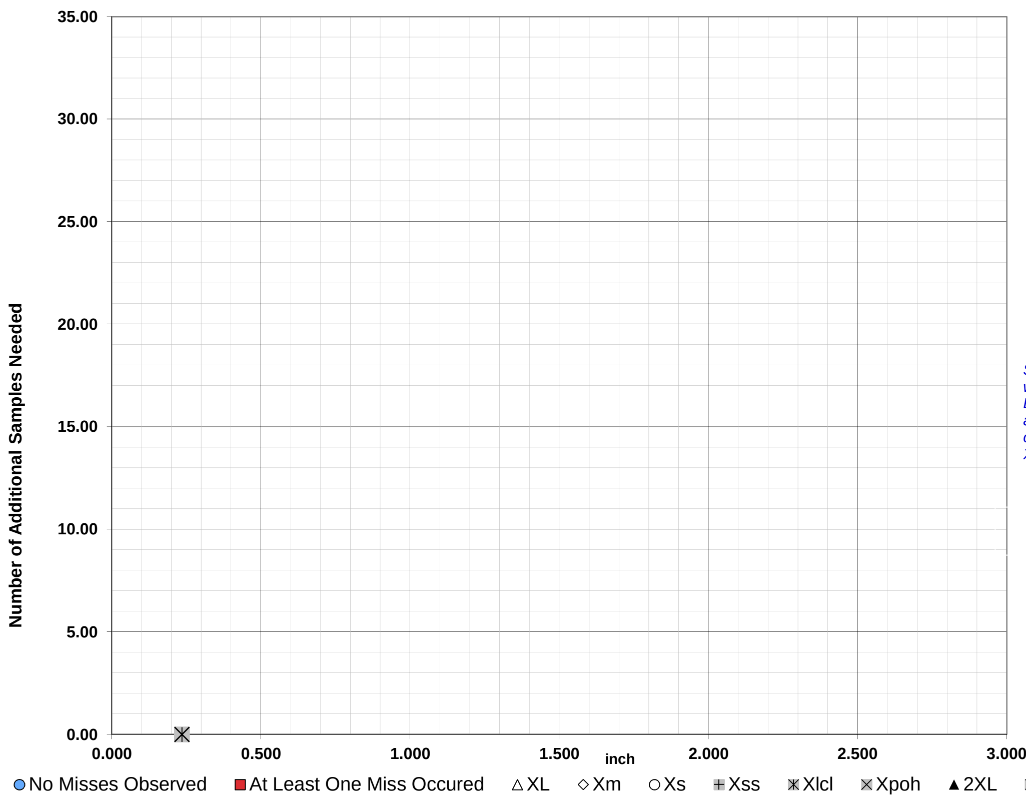


TABLE C

	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*

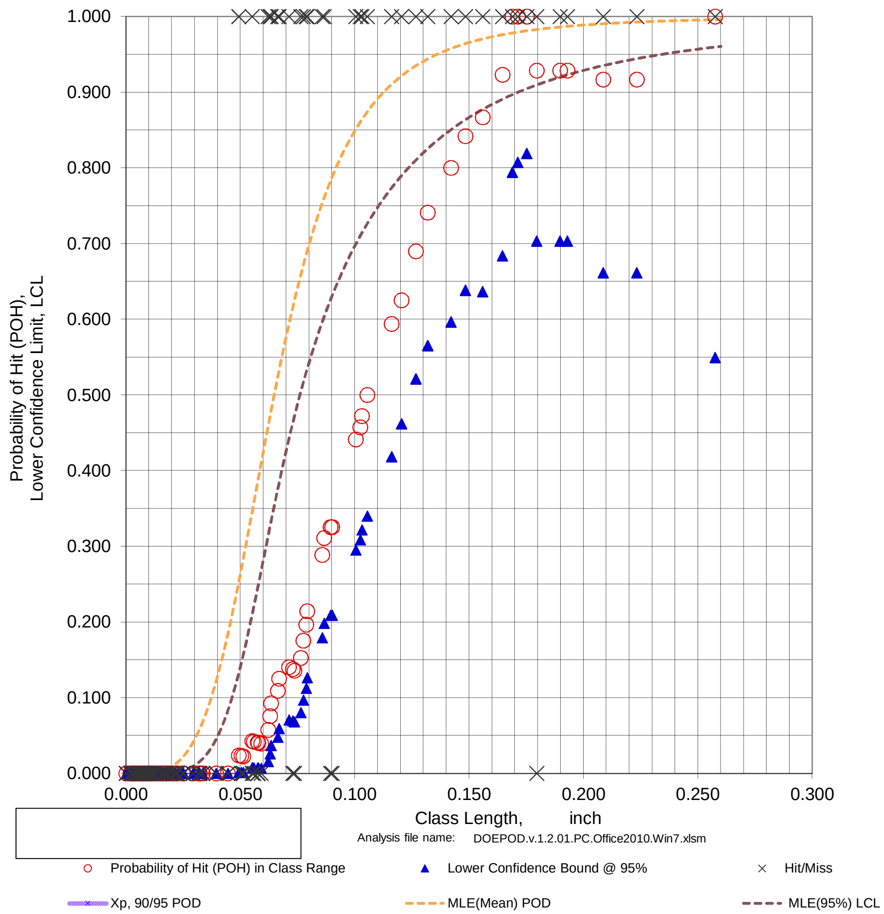
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

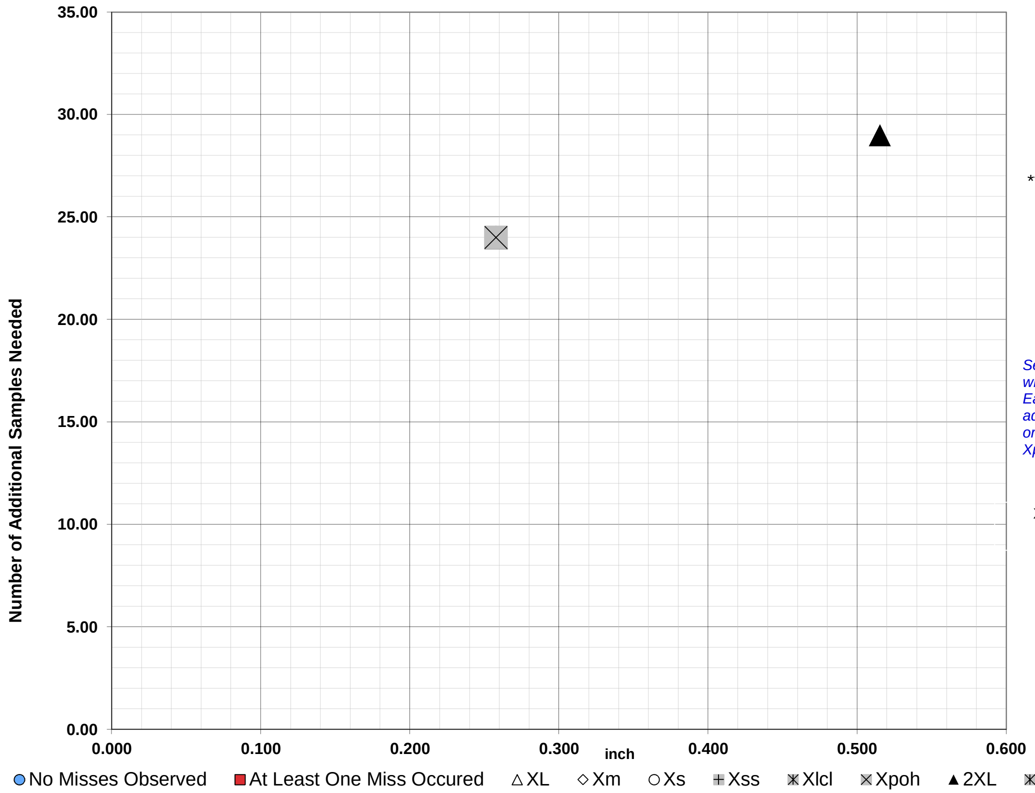


TABLE C

	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

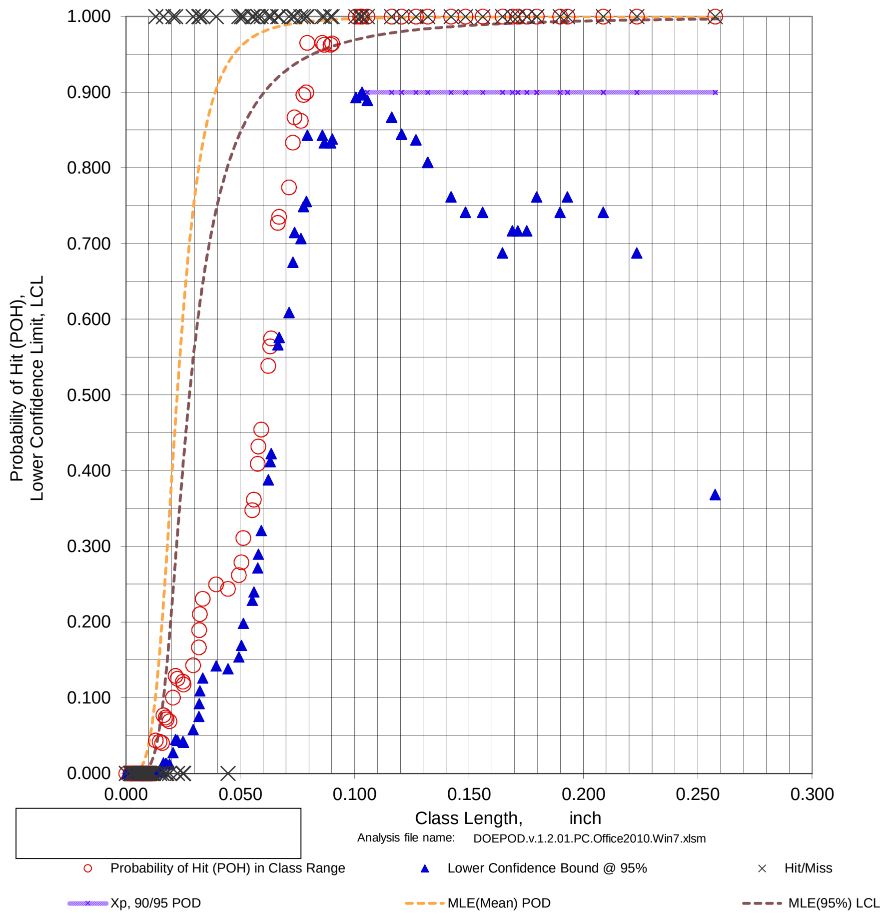
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

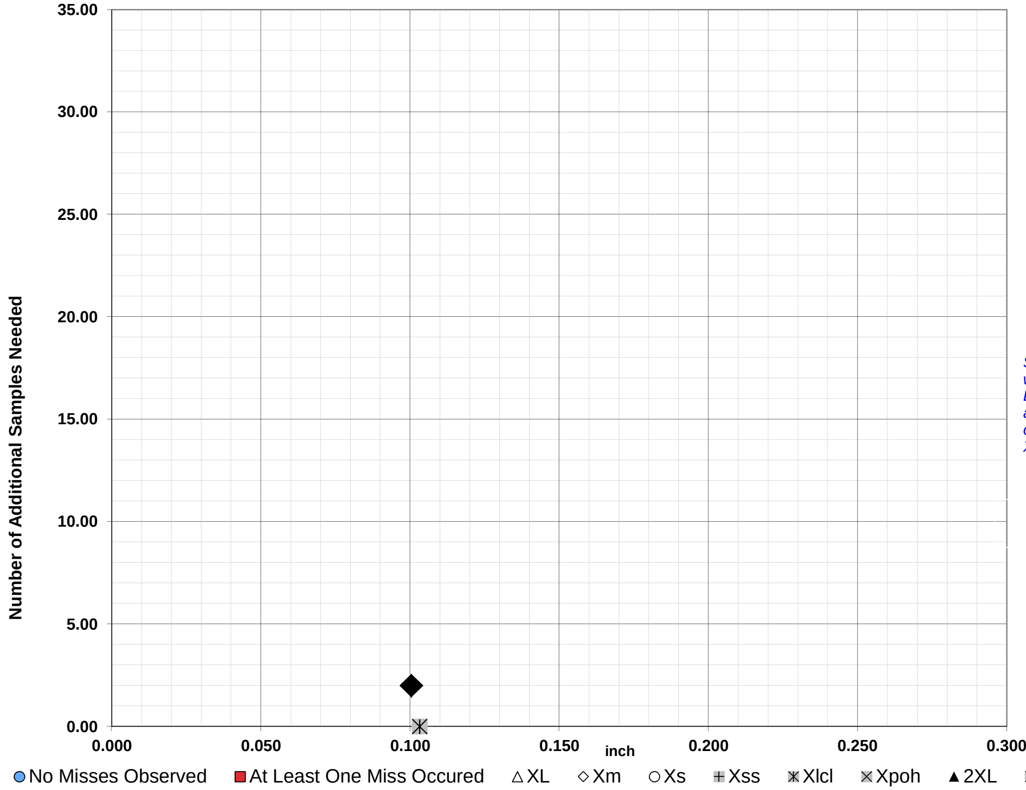


TABLE C

	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

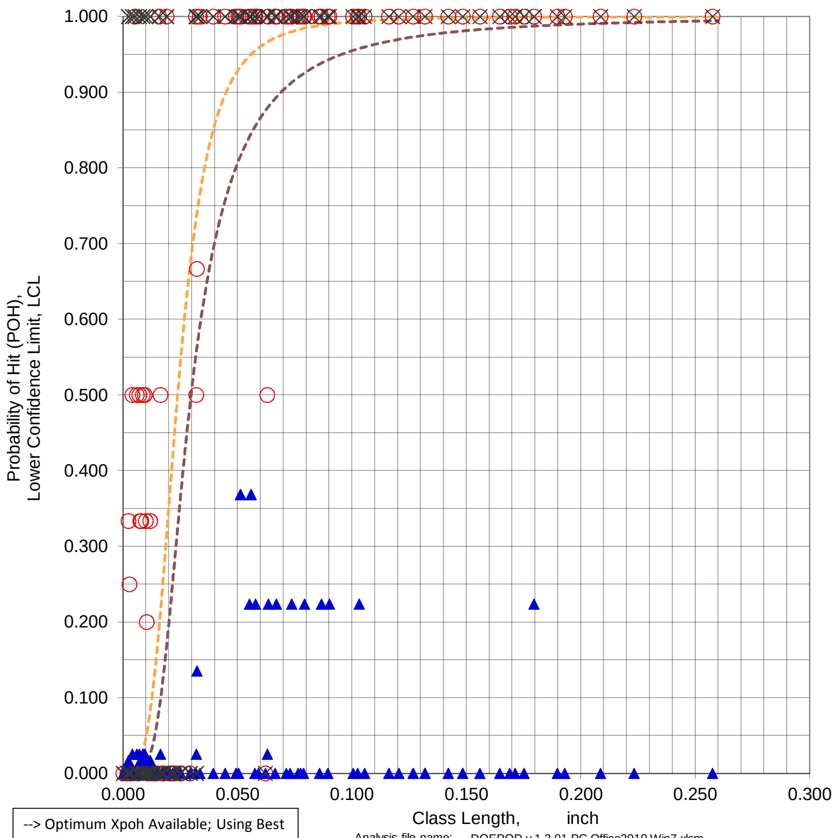
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = B2003.XLS
Data Set Name = B2003(HOLE #)
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 =



--> 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

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 #)

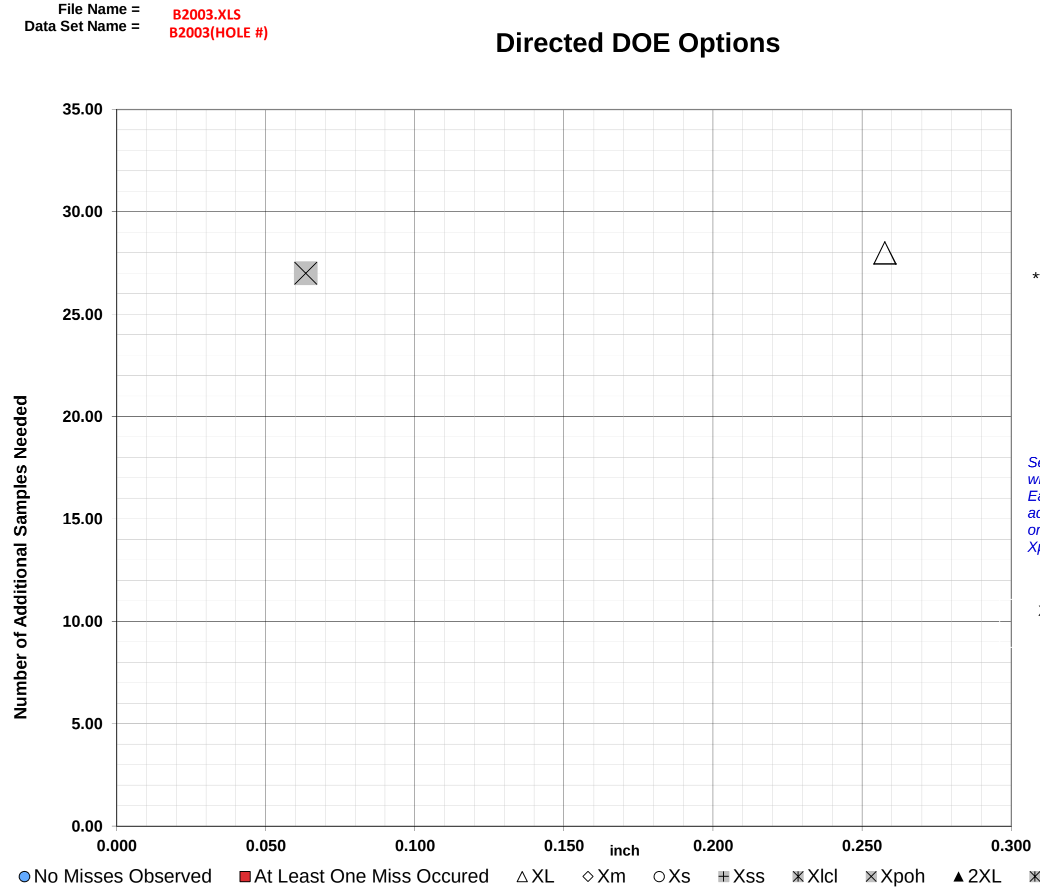


TABLE C

	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

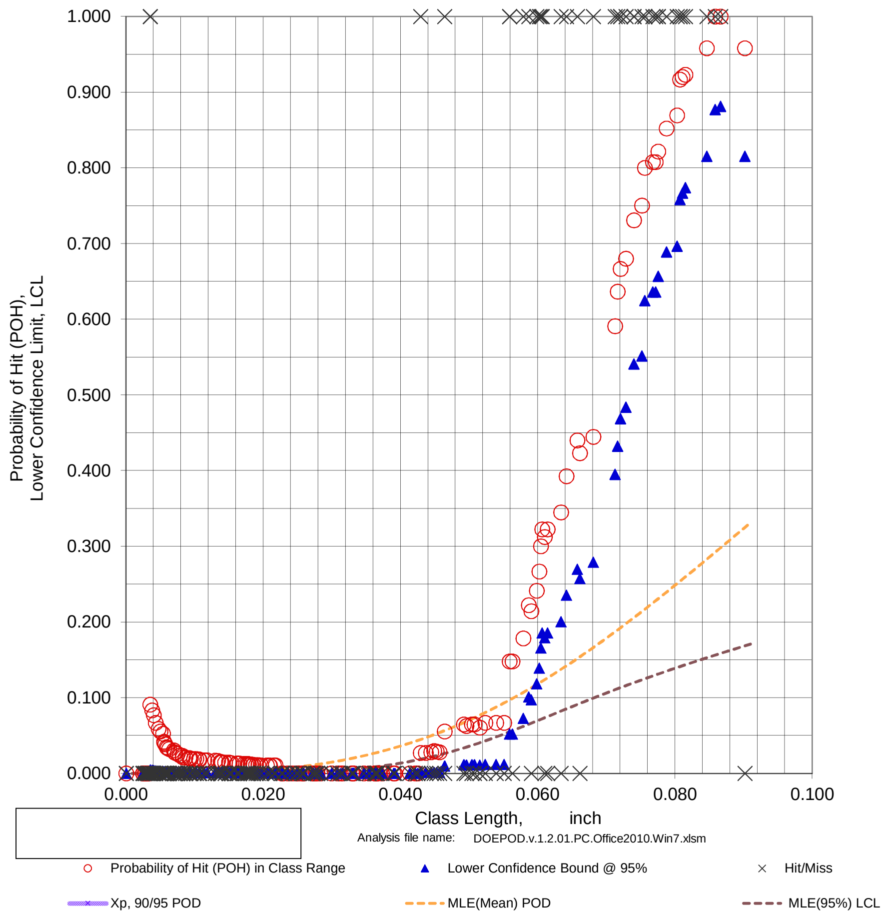
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = **B30011.XLS**
Data Set Name = **B30011(HOLE #)**
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

File Name = B30011.XLS
Data Set Name = B30011(HOLE #)

Directed DOE Options

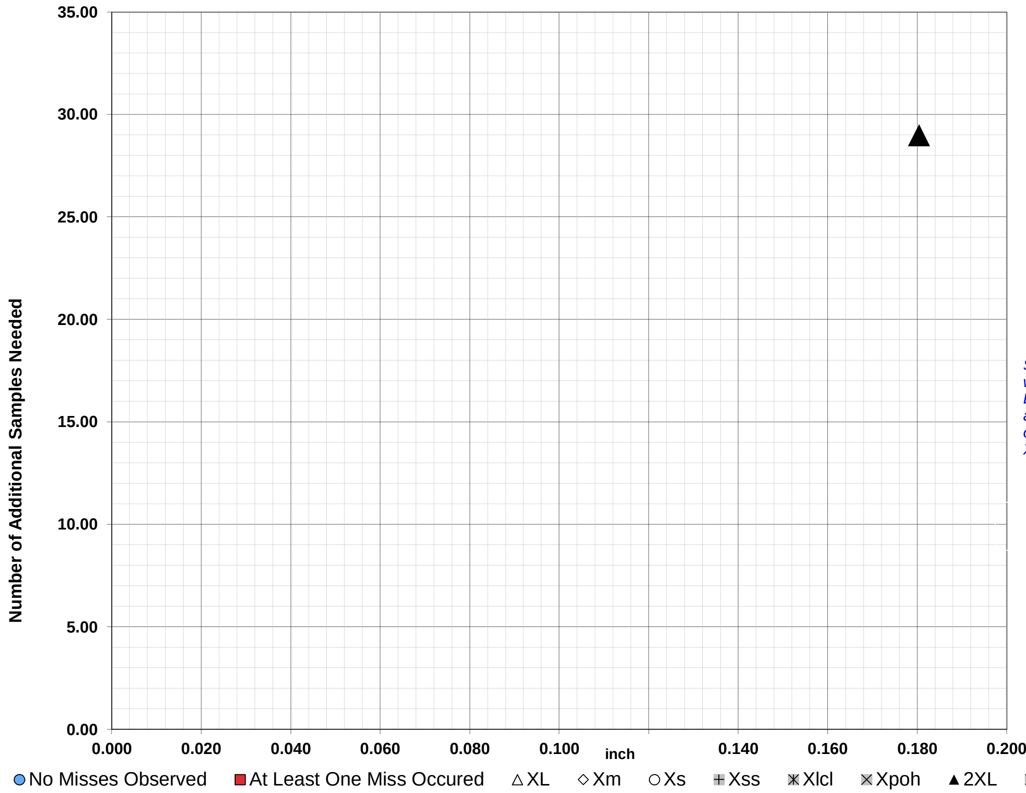


TABLE C

	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*

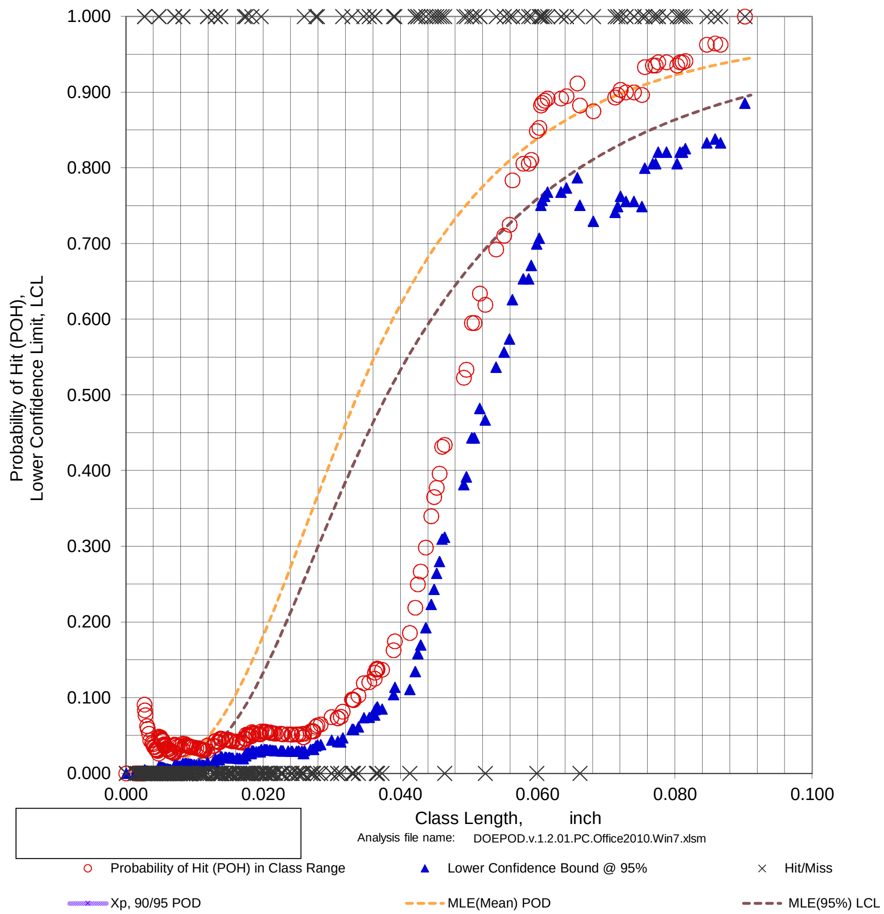
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

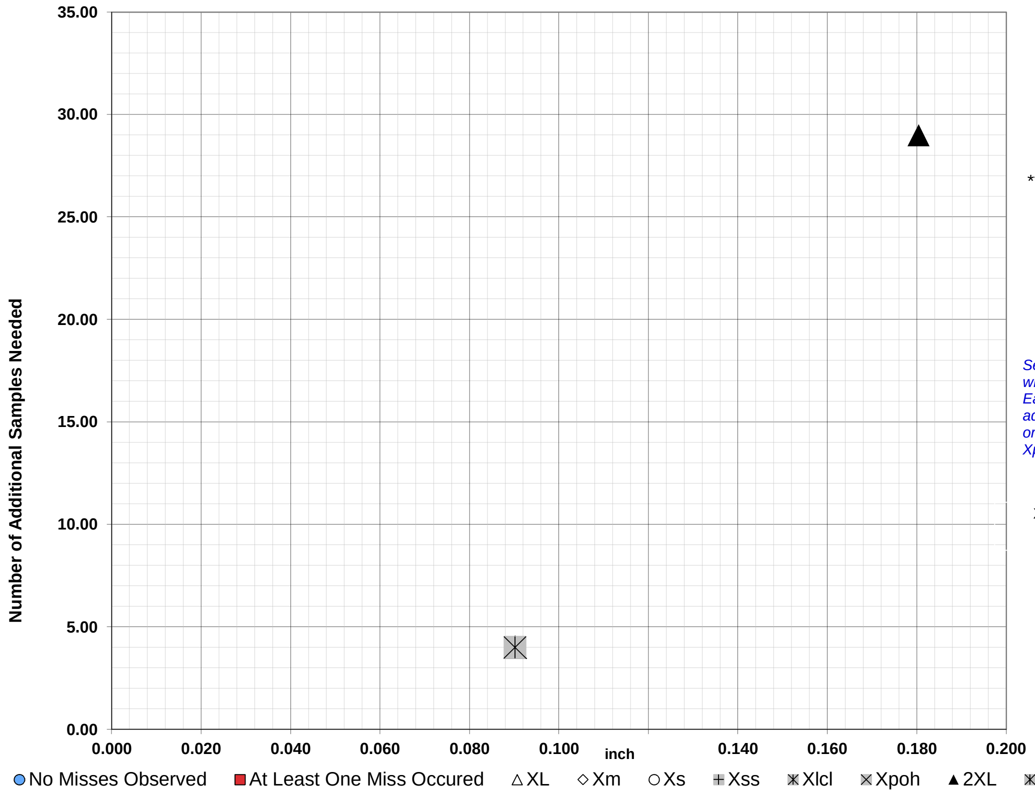


TABLE C

	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*

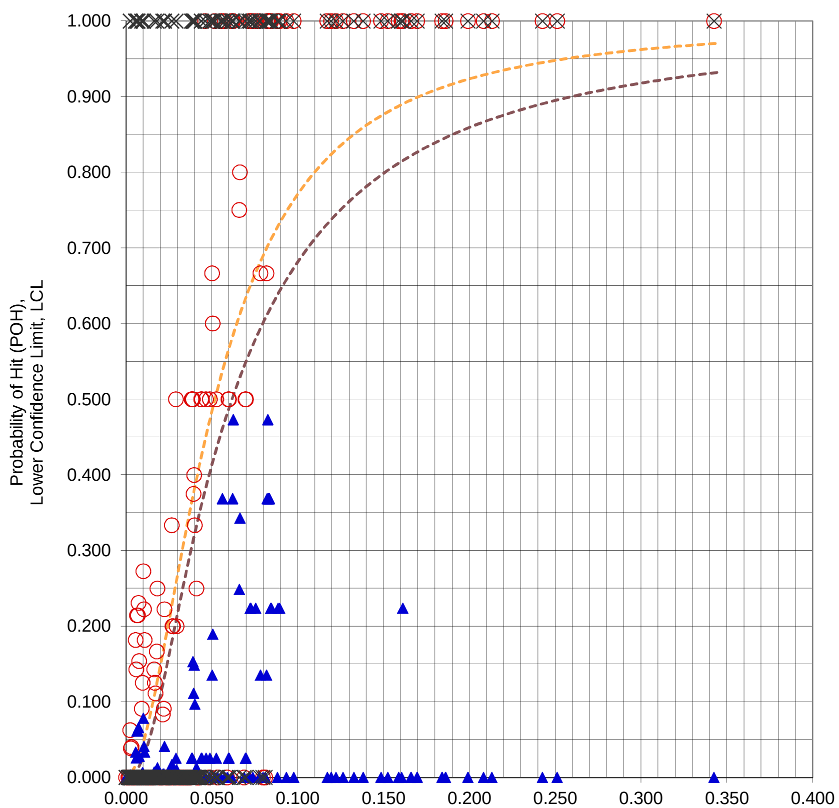
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



--> 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 = 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

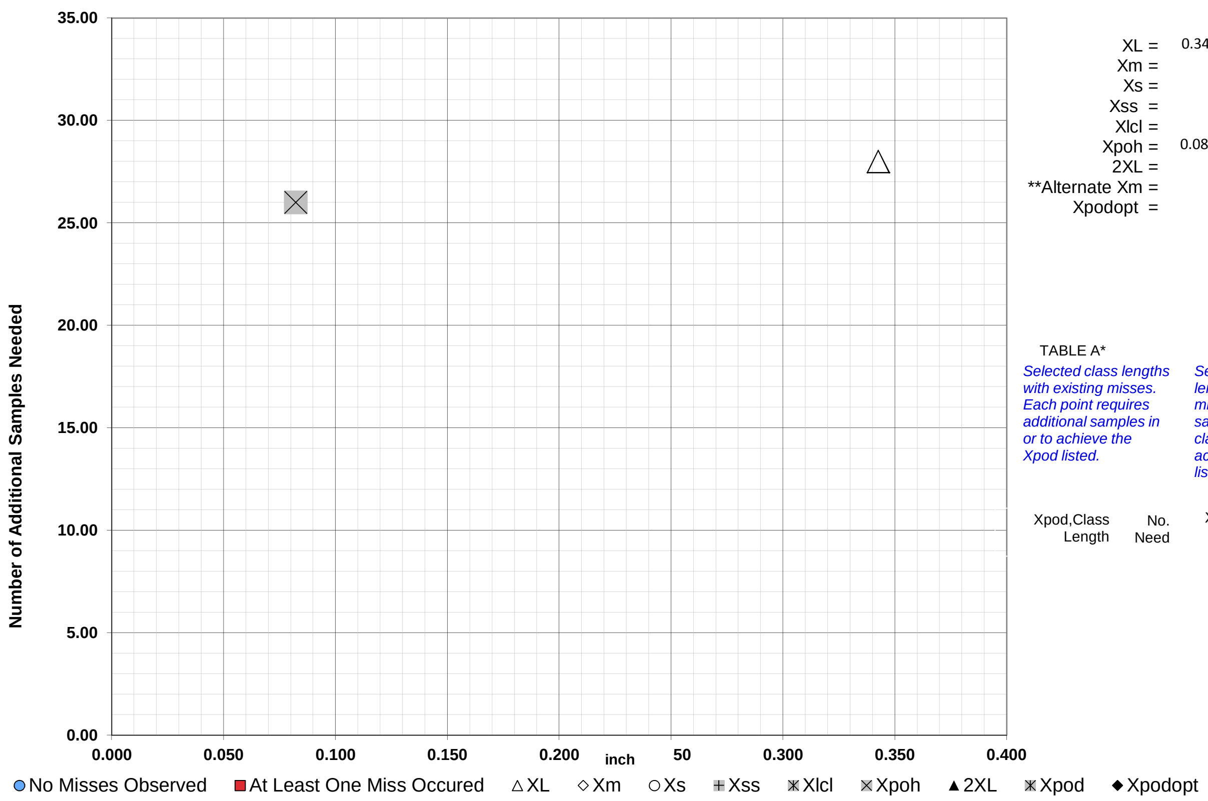


TABLE C

	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*

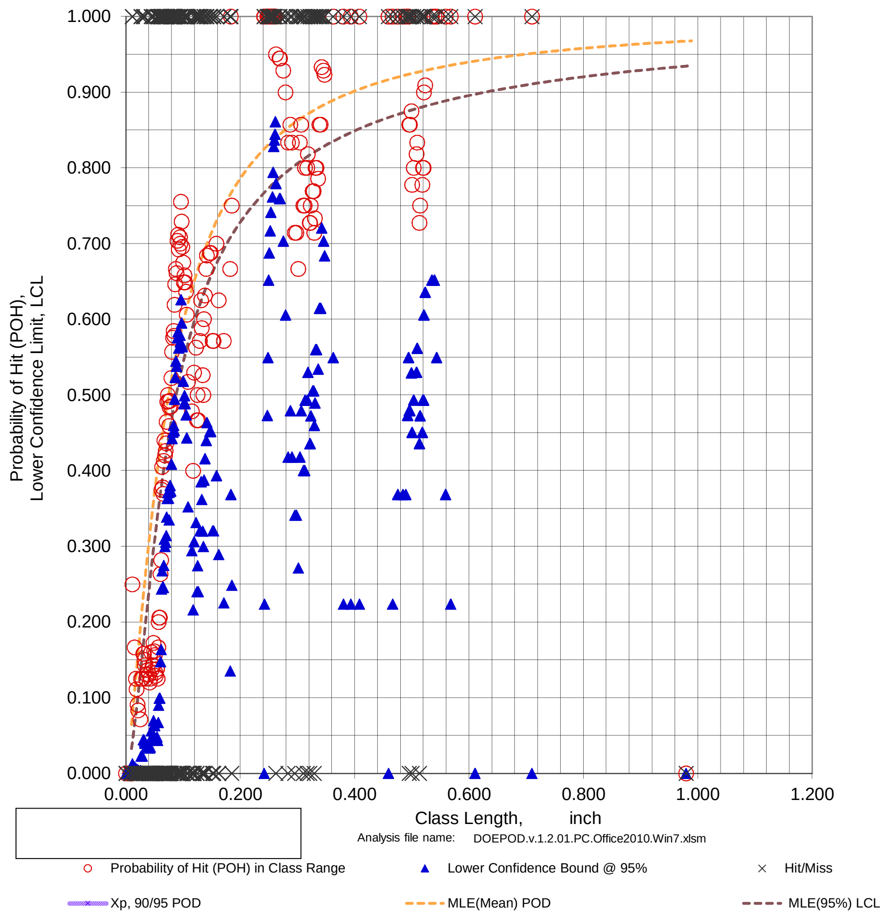
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

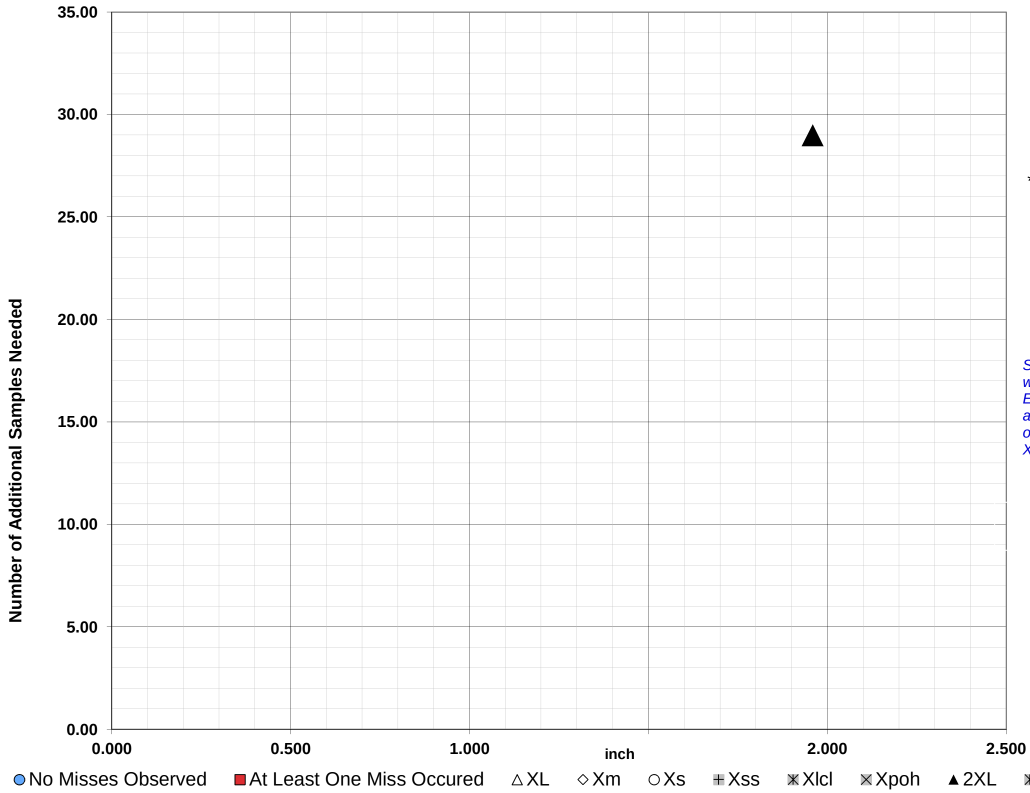


TABLE C

	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*

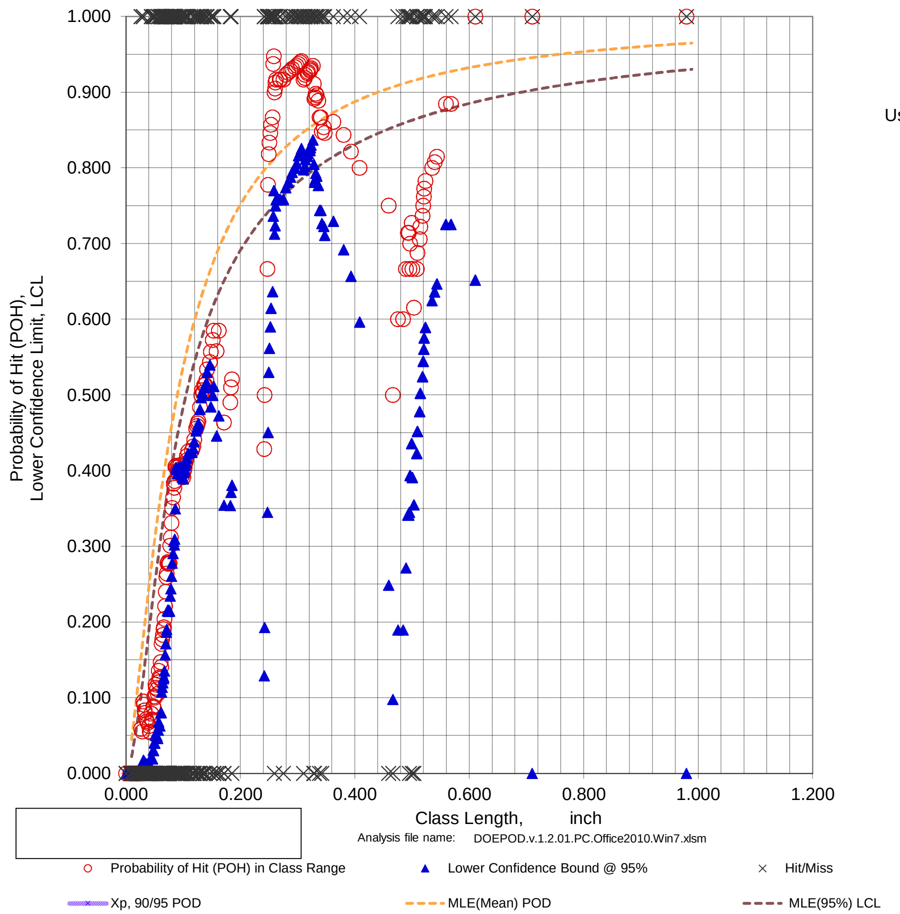
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

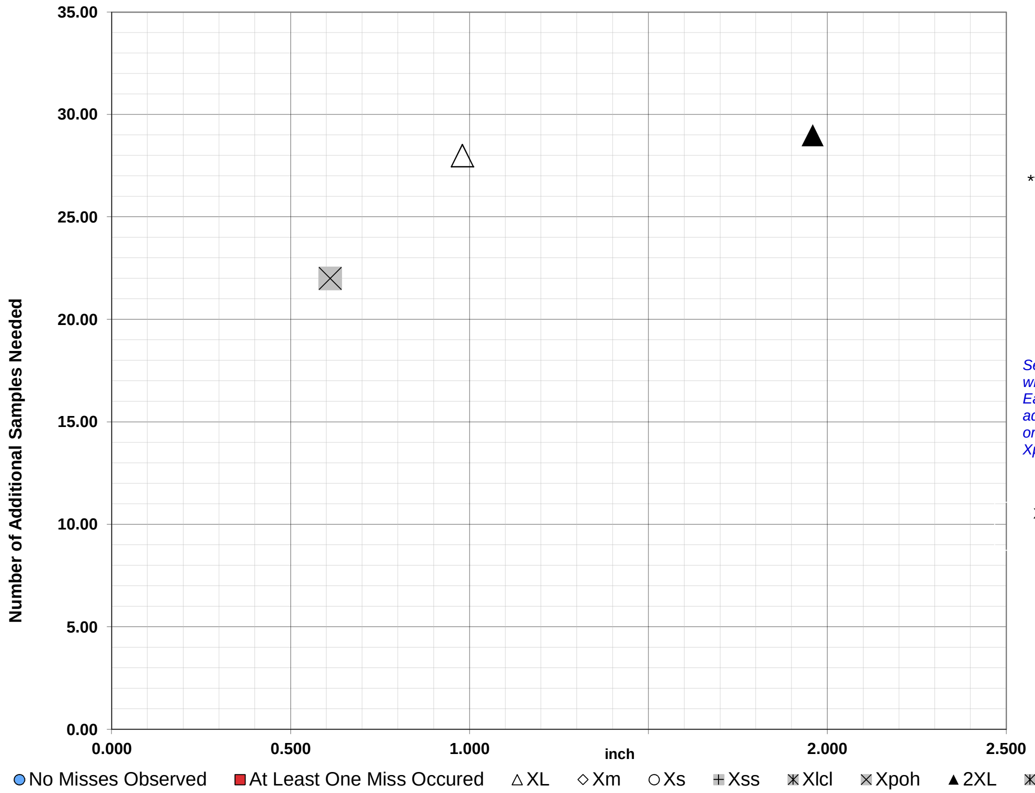


TABLE C

	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

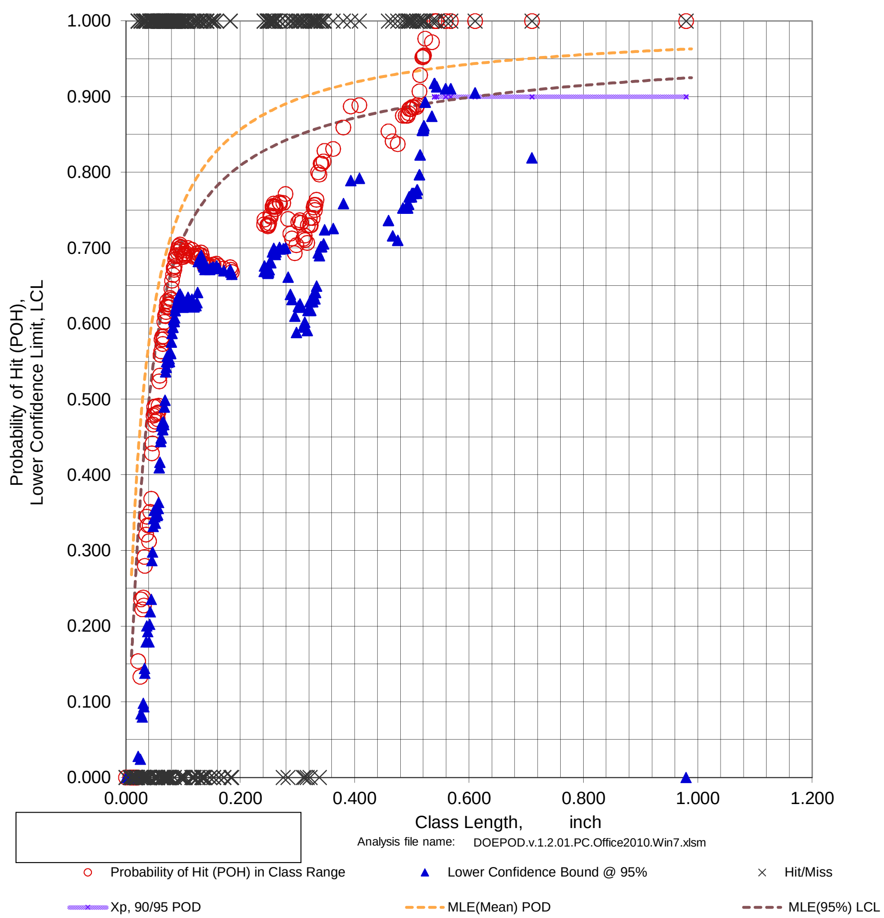
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

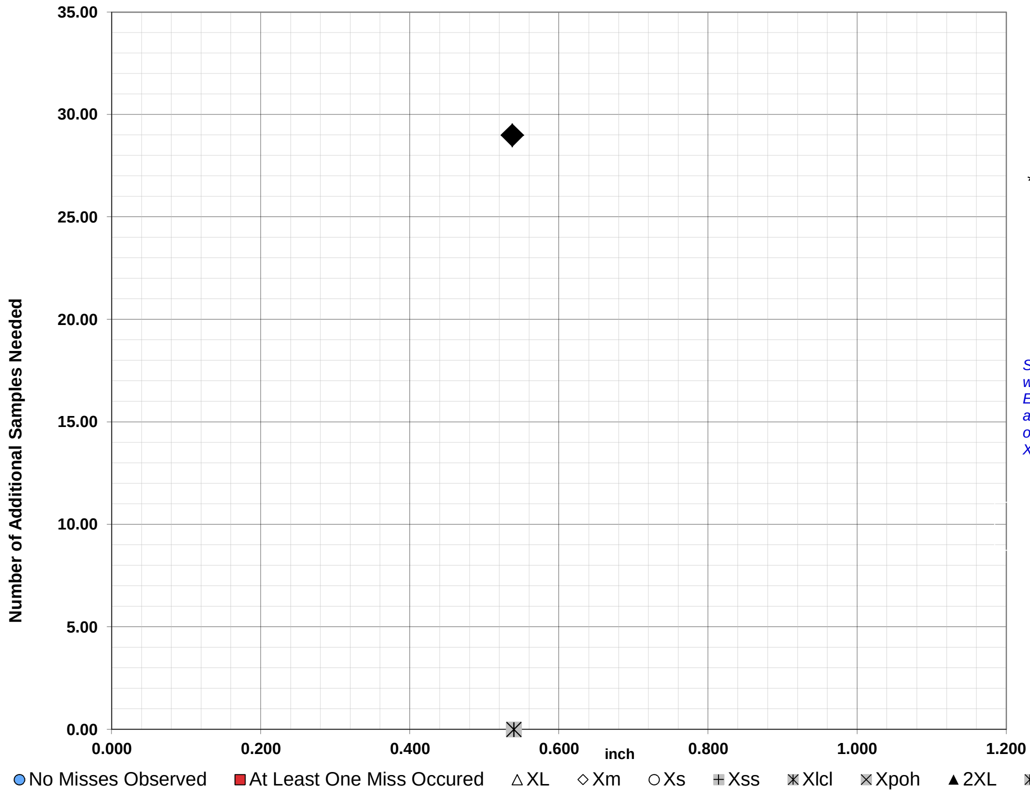


TABLE C

	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

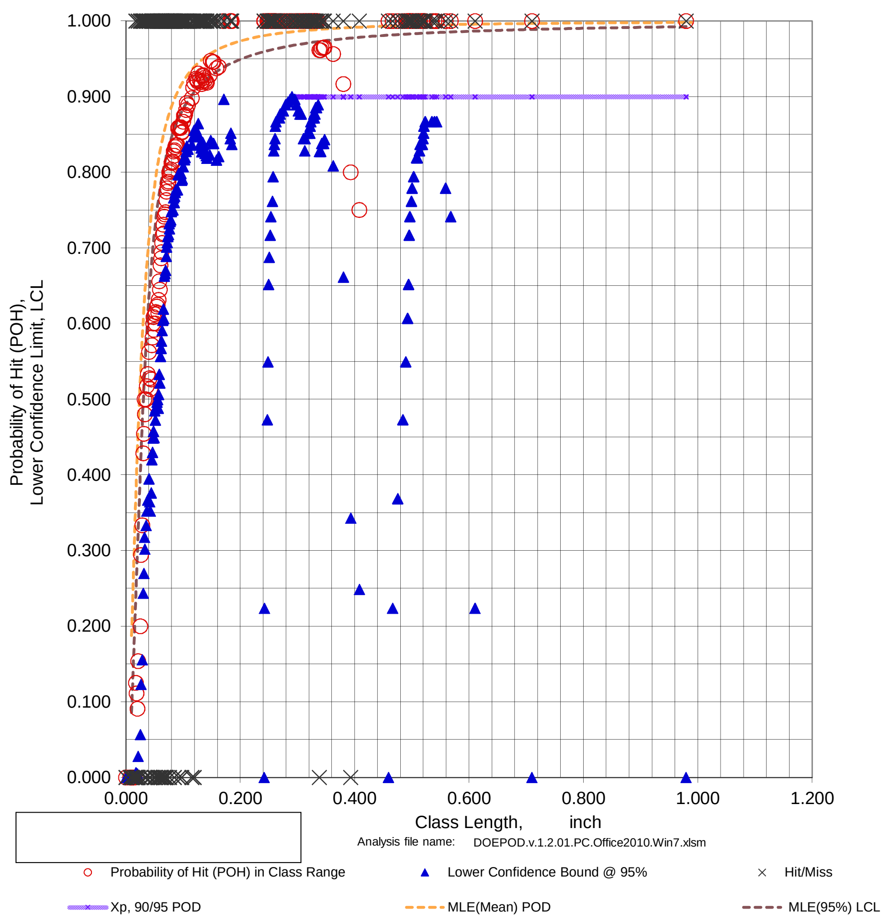
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

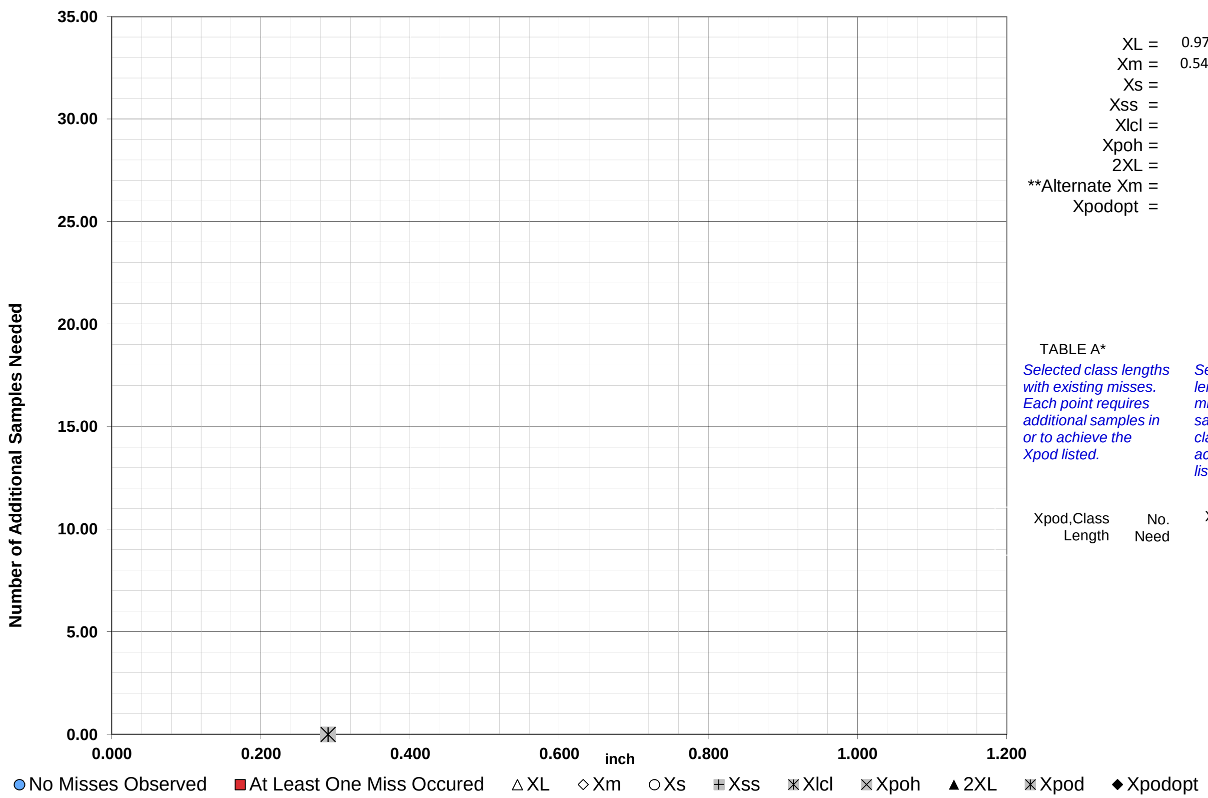


TABLE C

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

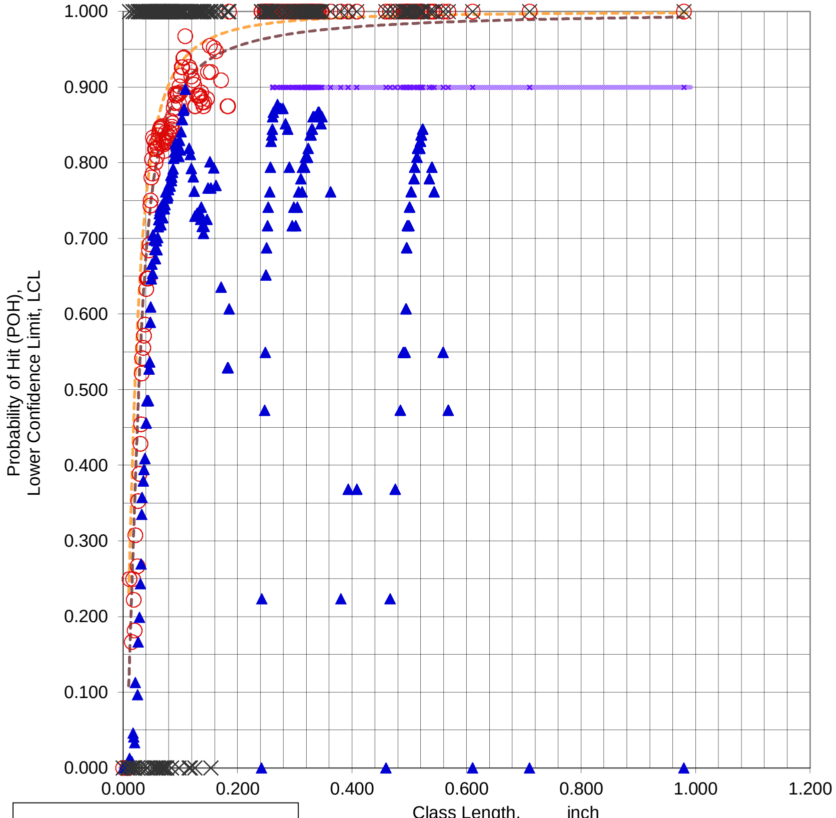
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 =	**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

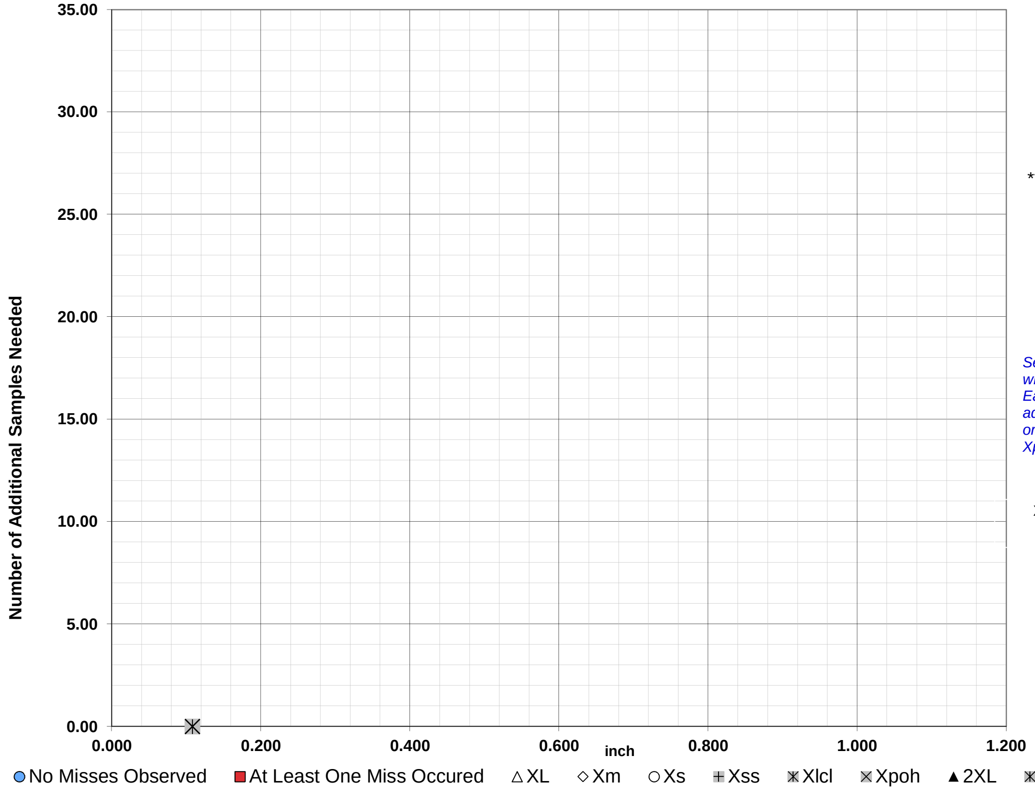


TABLE C

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

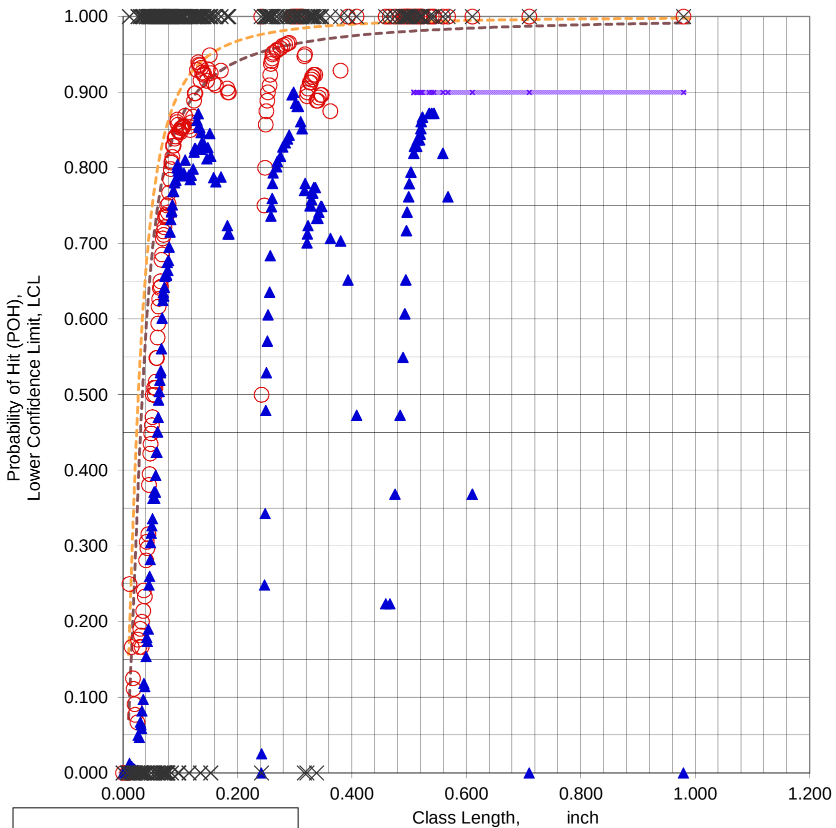
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

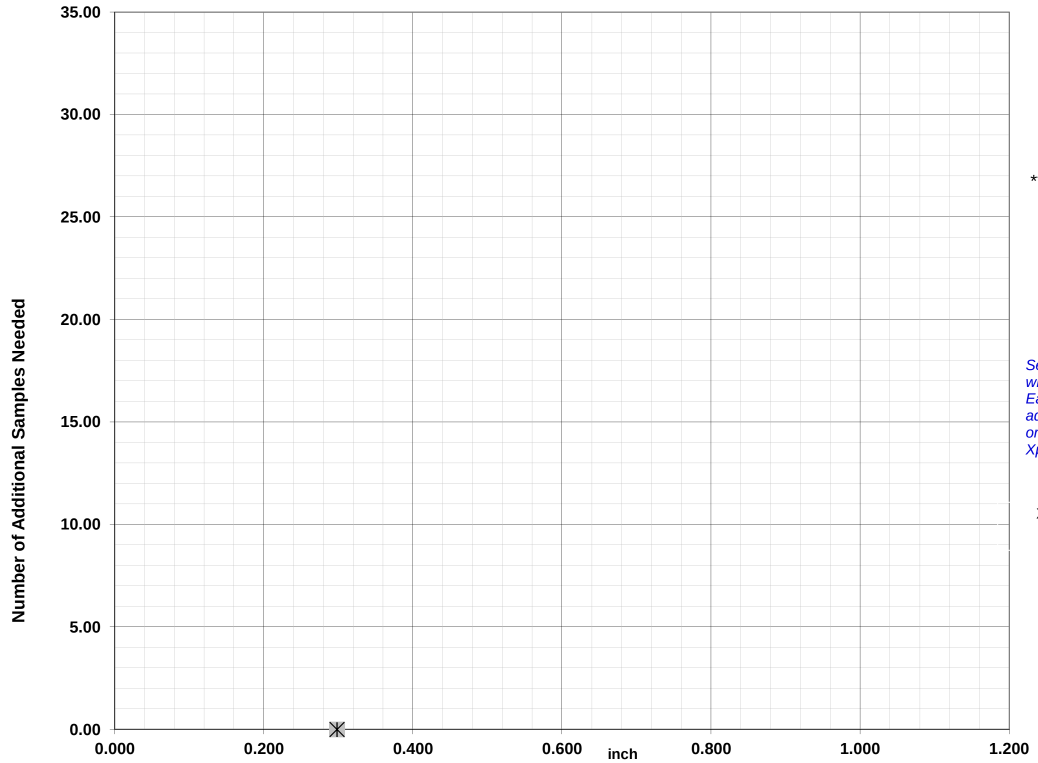
Opt. POD classlength, Xpodopt = inch

Samples Needed @Xpodopt =

Xp = 0.5080 inch

File Name = C1002CL.XLS
Data Set Name = C1002CL(CRACK #)

Directed DOE Options



No Misses Observed · At Least One Miss Occured · XL · Xm · Xs · Xss · Xlcl · Xpoh · 2XL · Xpod · Xpodopt

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

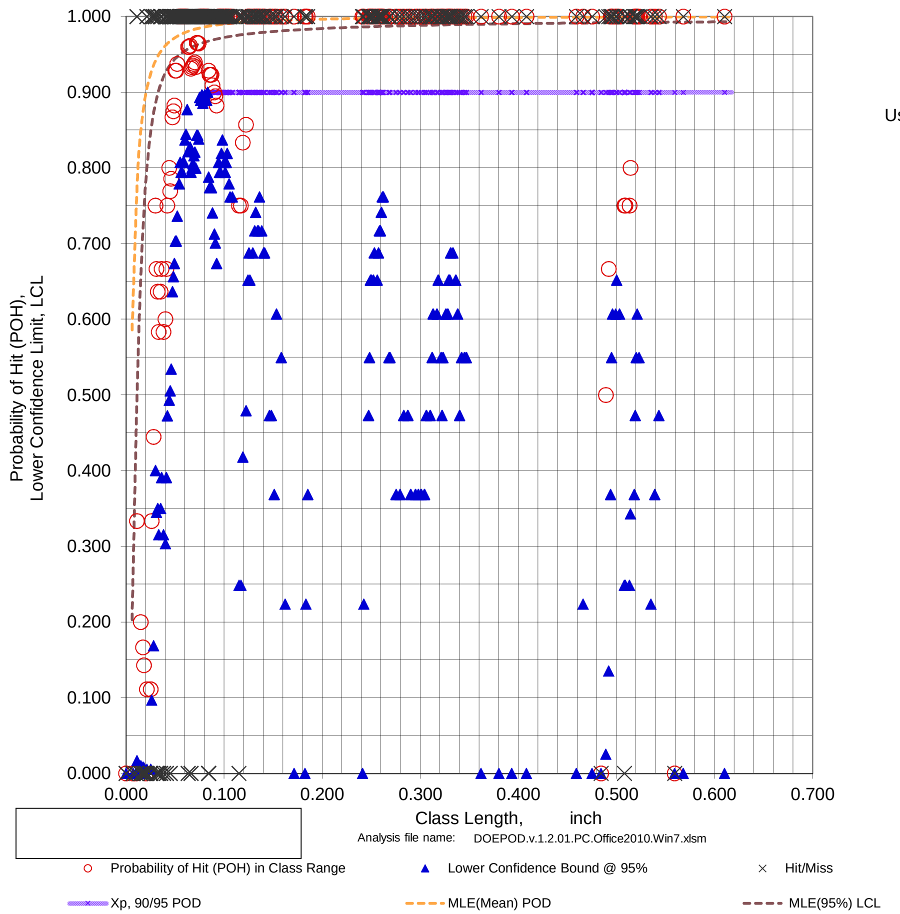
MLE Divergence Warning: Initial results listed.

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

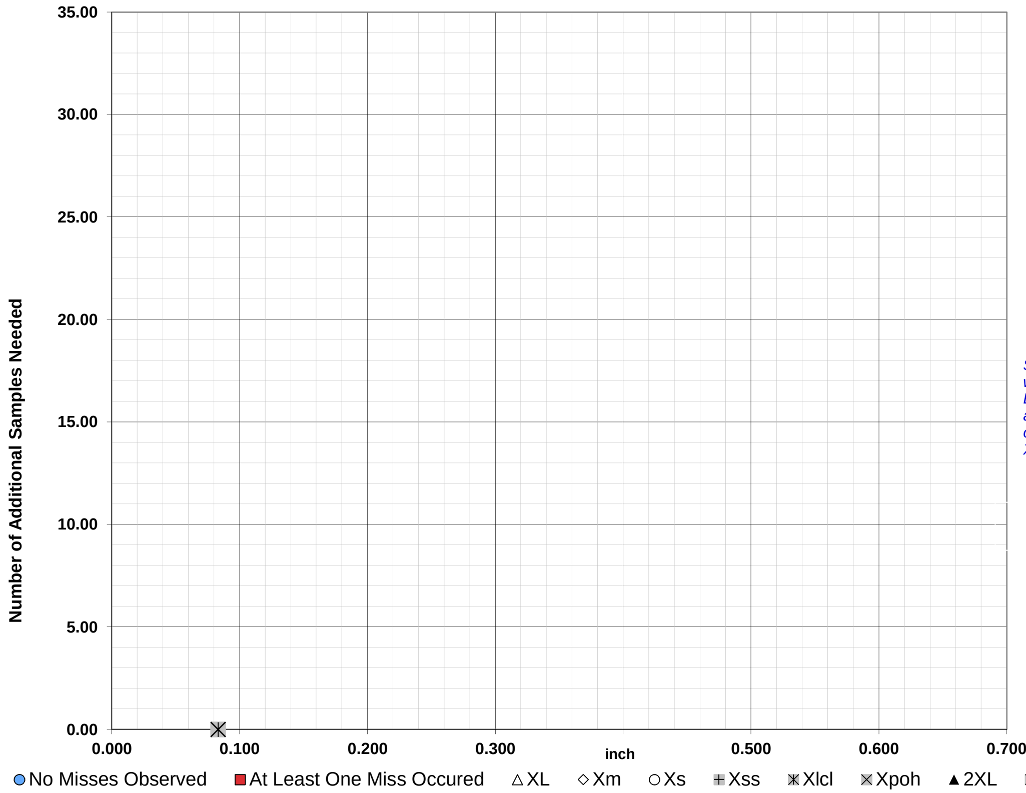


TABLE C

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

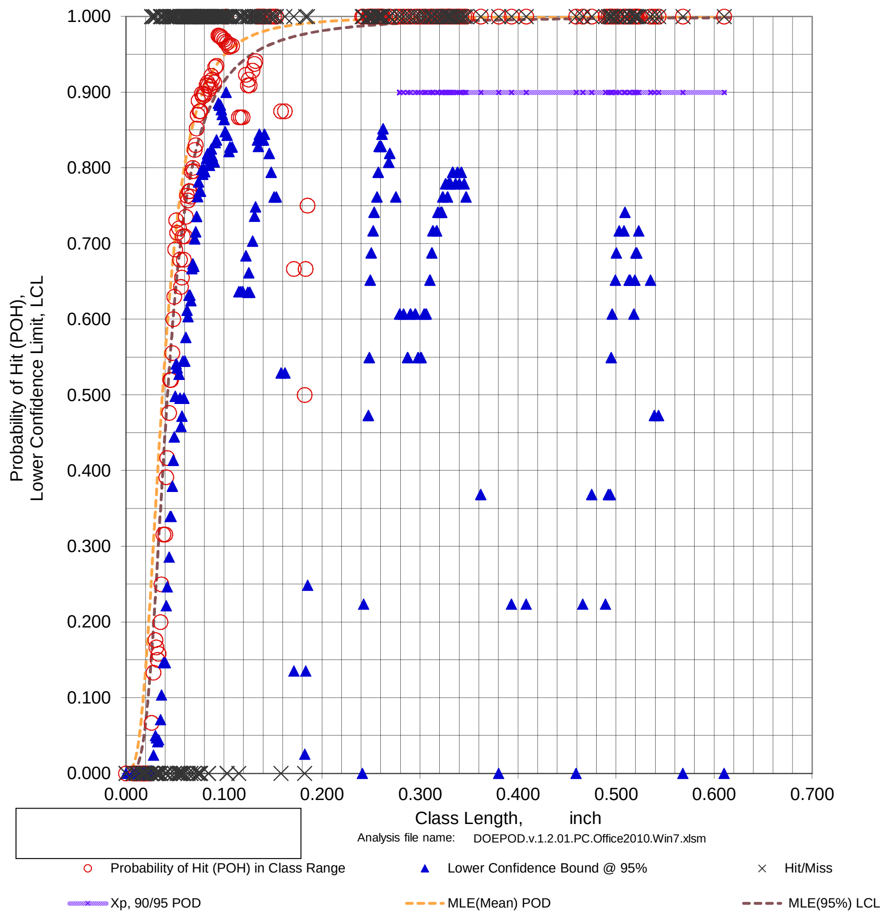
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

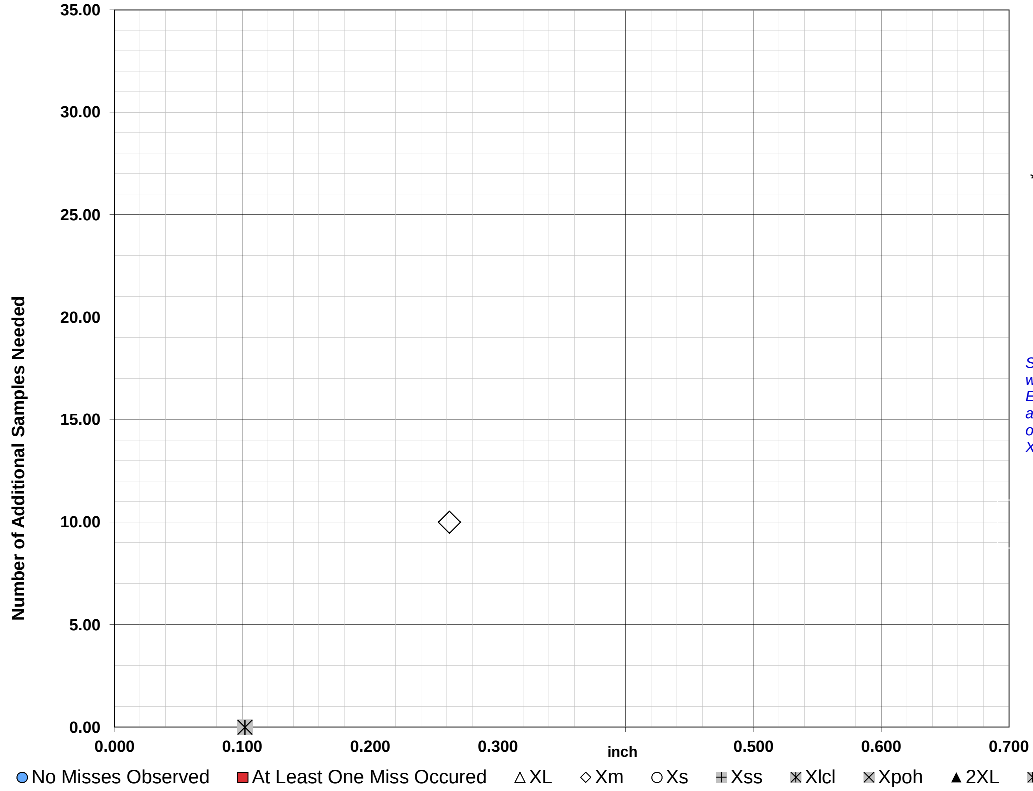


TABLE C

	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

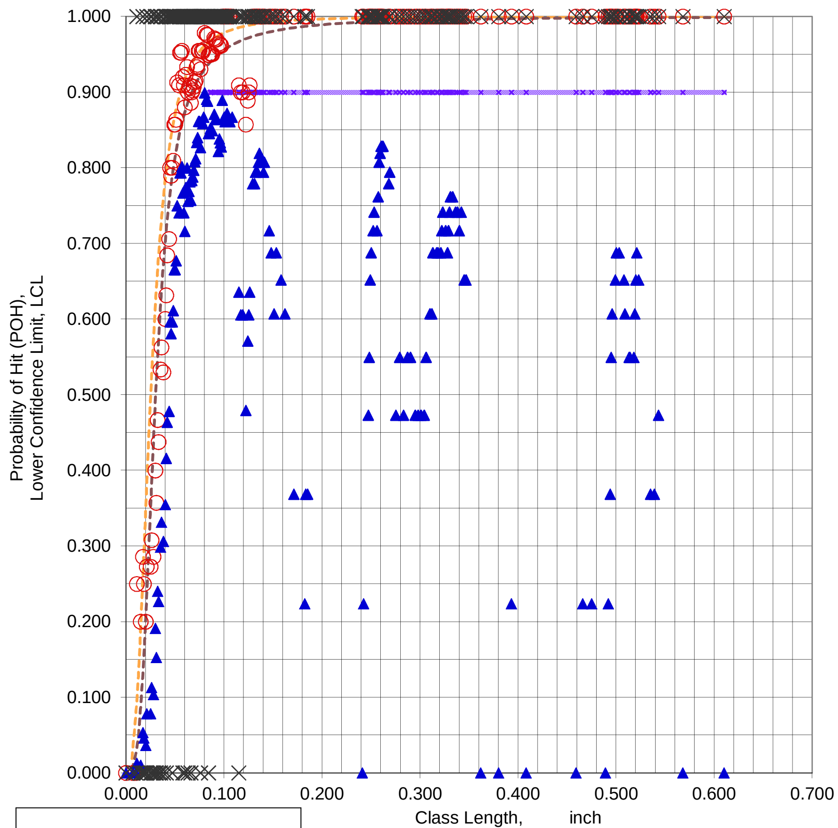
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 =	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

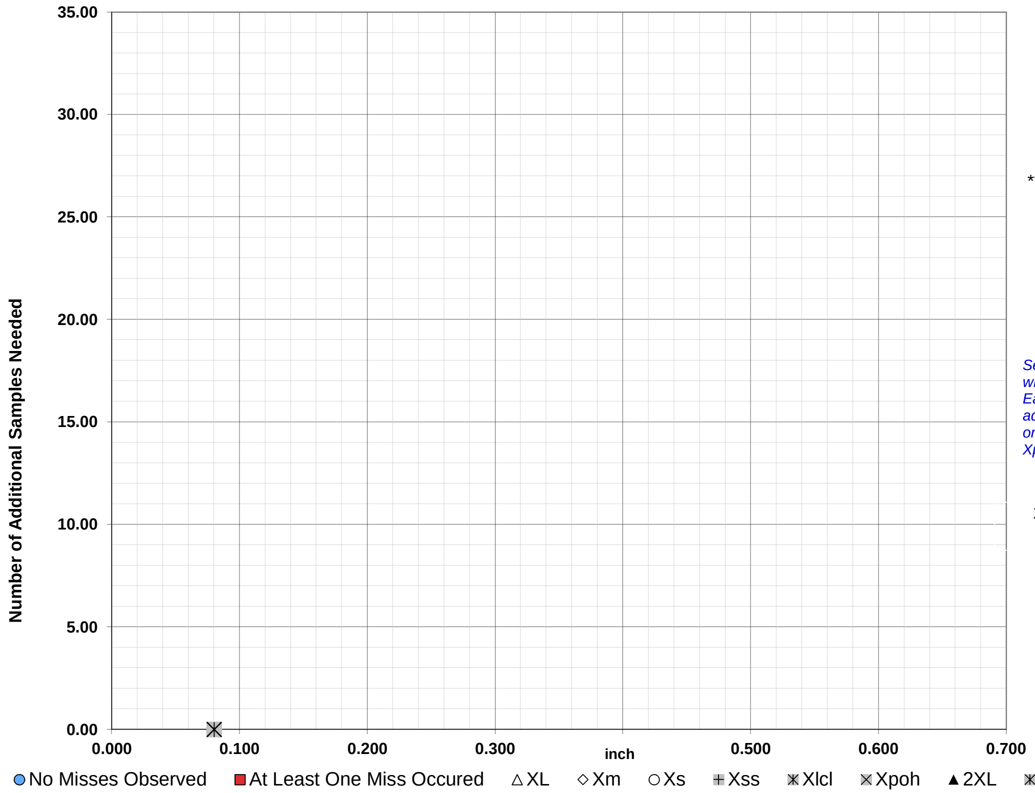


TABLE C

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*

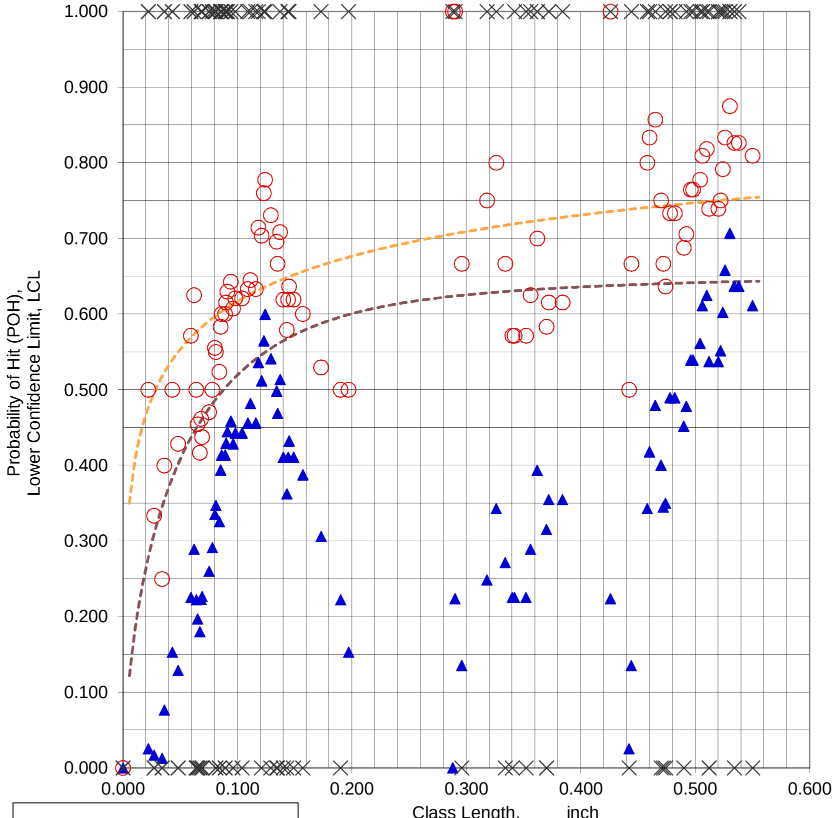
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

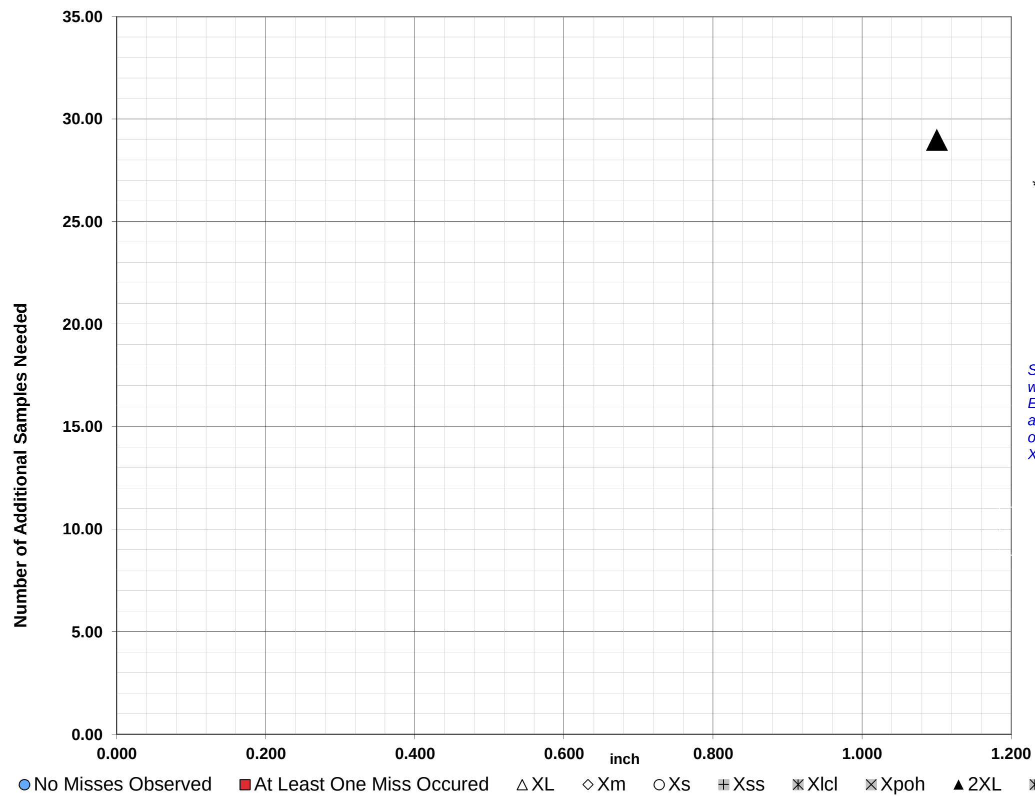


TABLE C

	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.

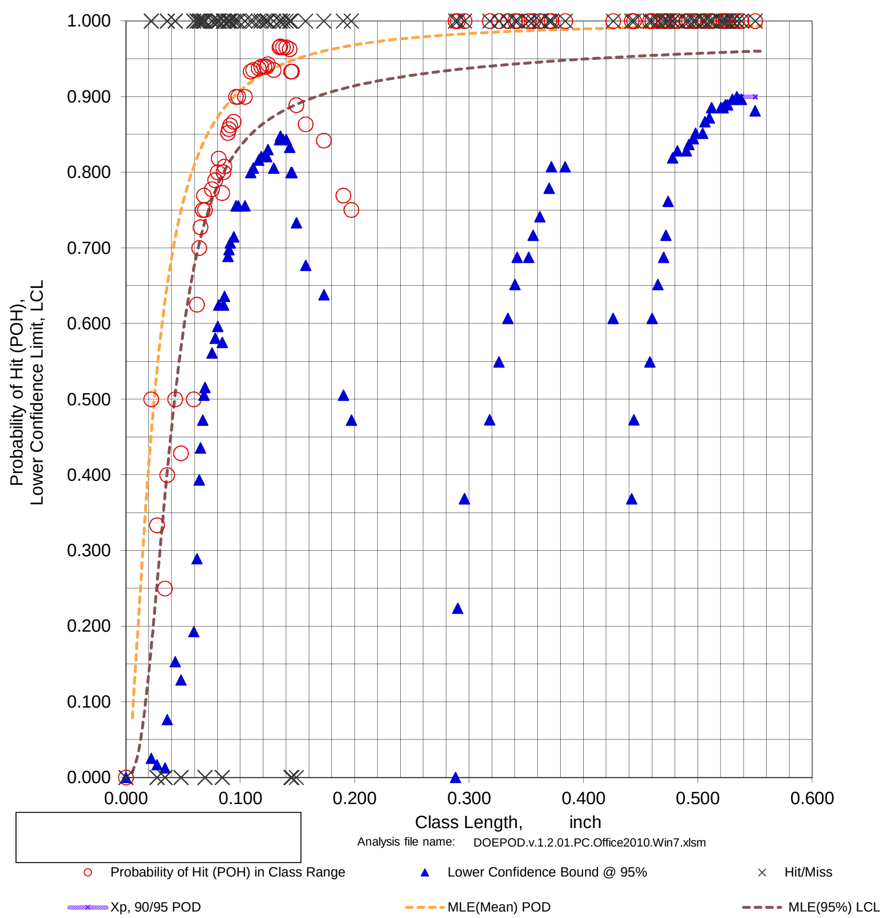
Xpod,Class Length	No. Need

* 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

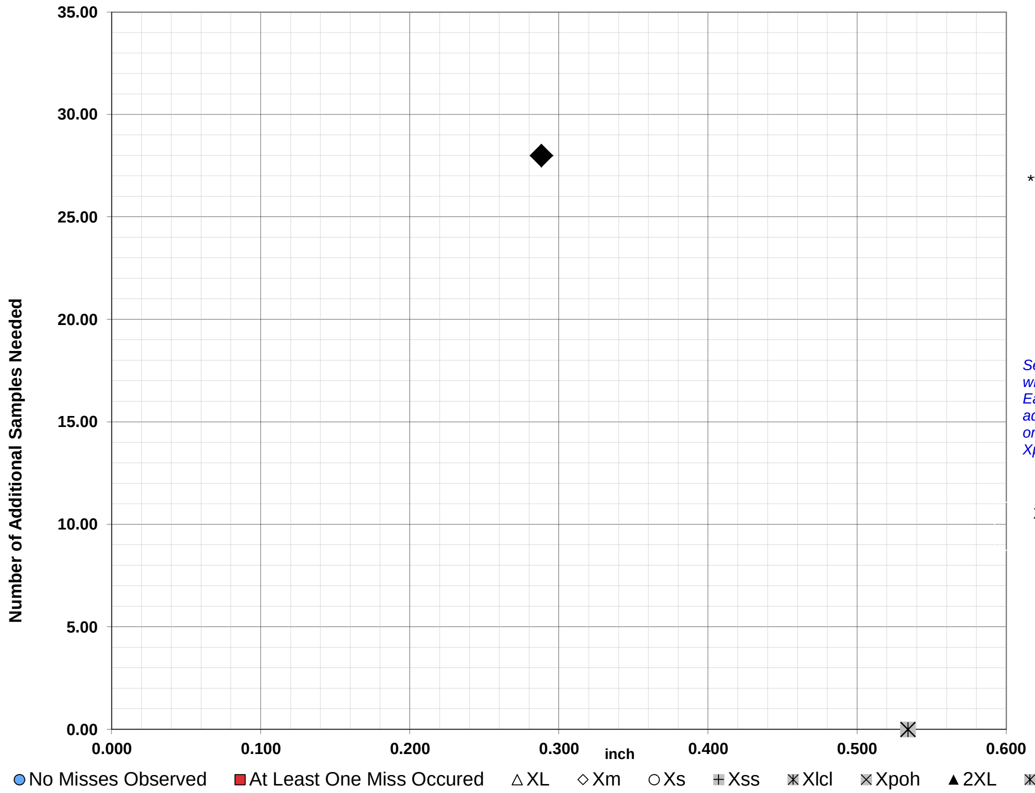


TABLE C

	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.

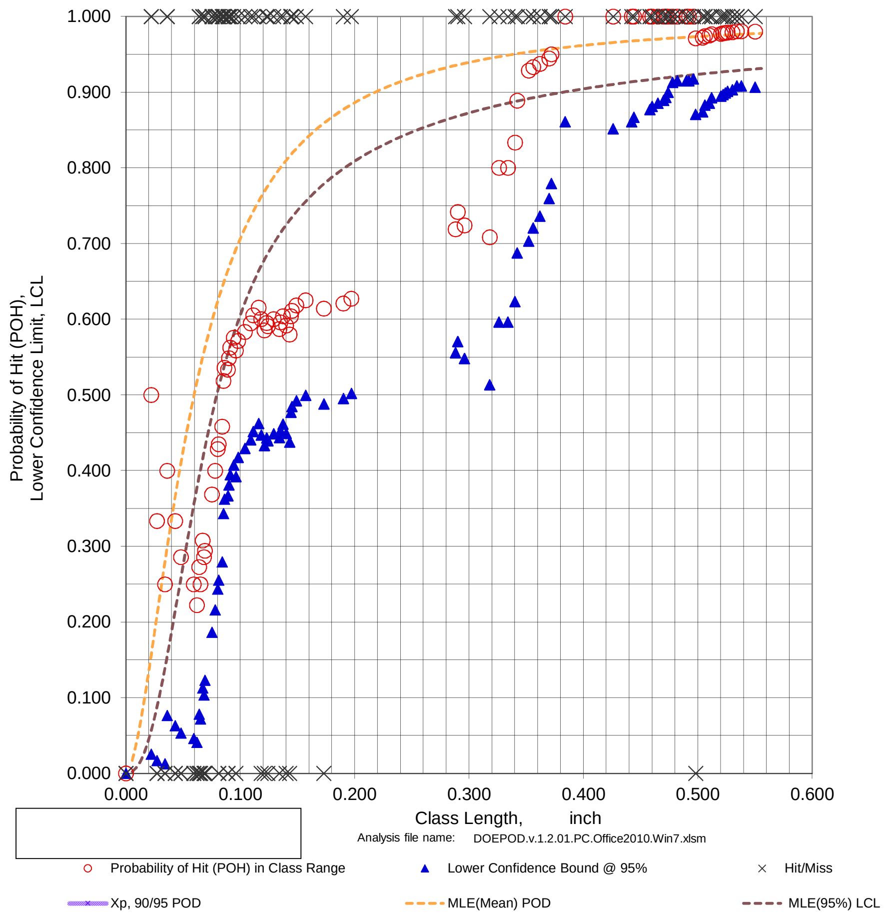
Xpod,Class Length	No. Need

* 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

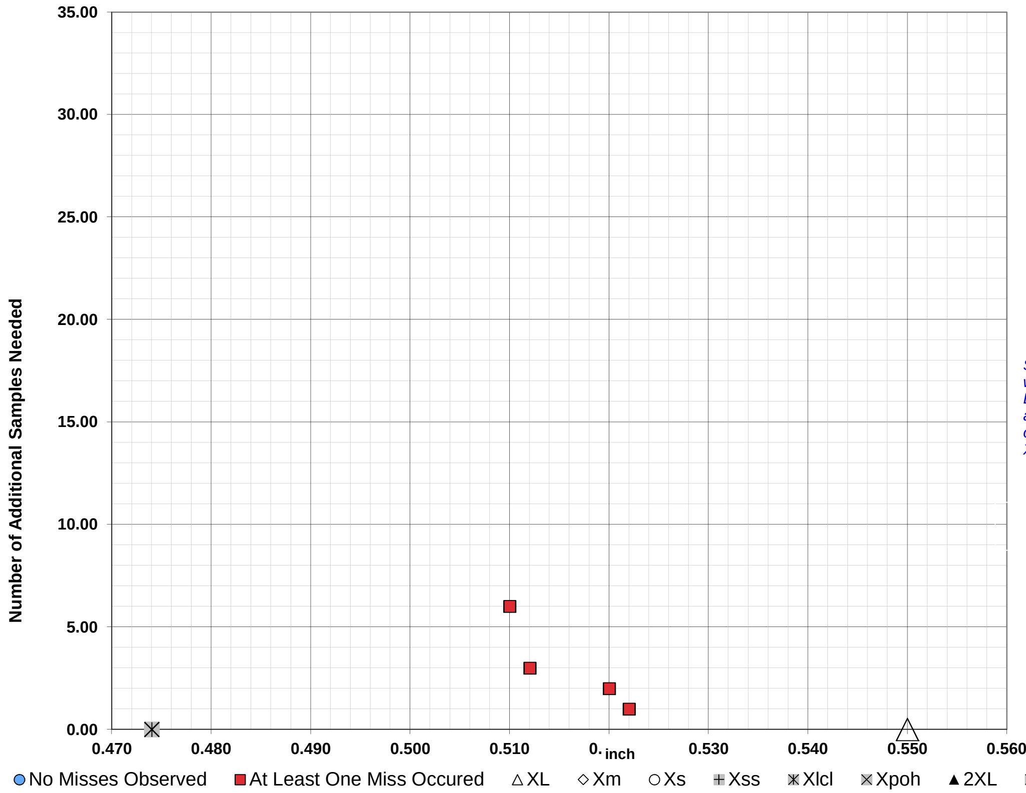


TABLE C

	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*

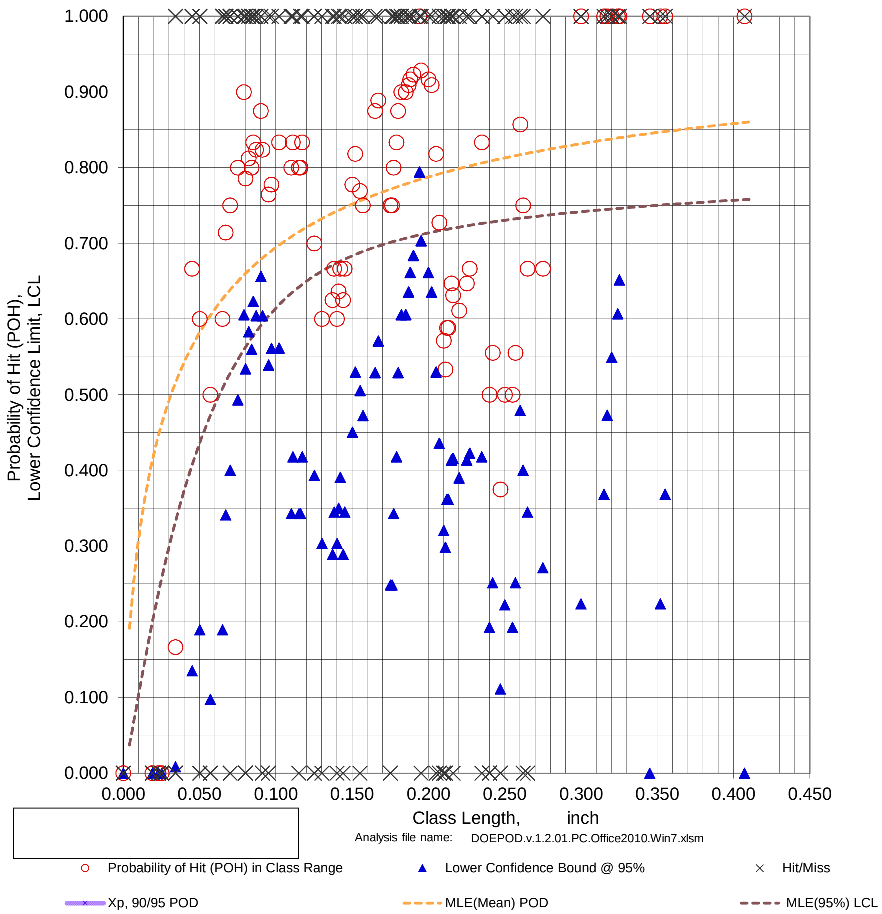
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

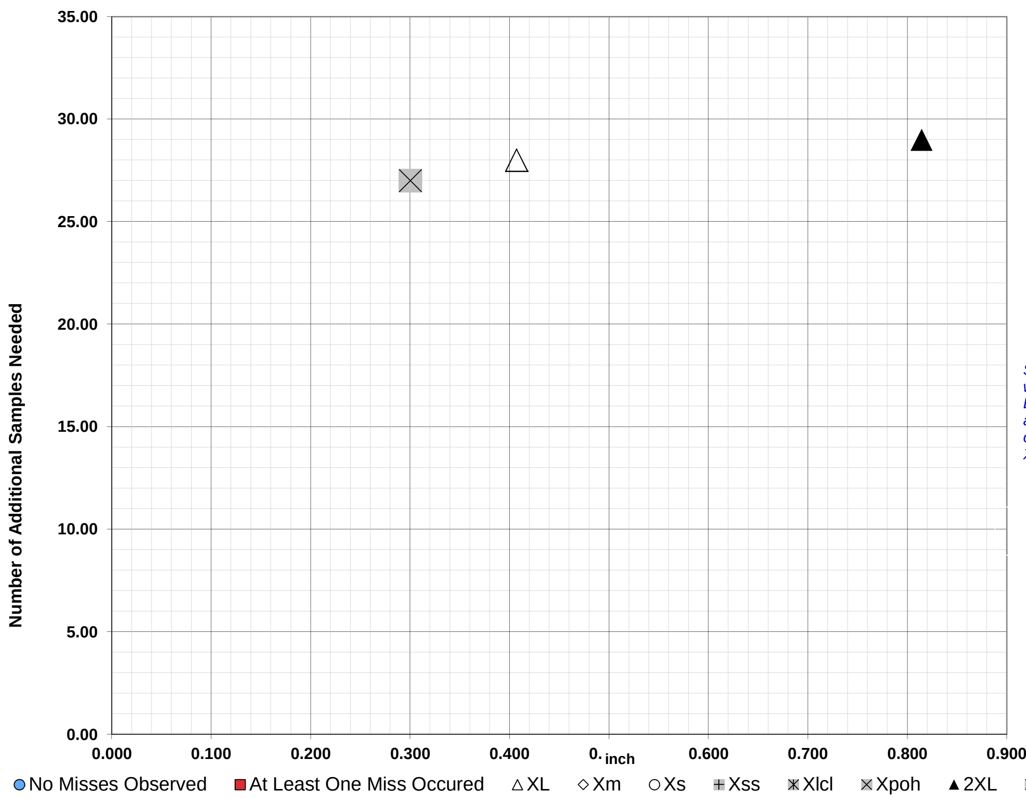


TABLE C

	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

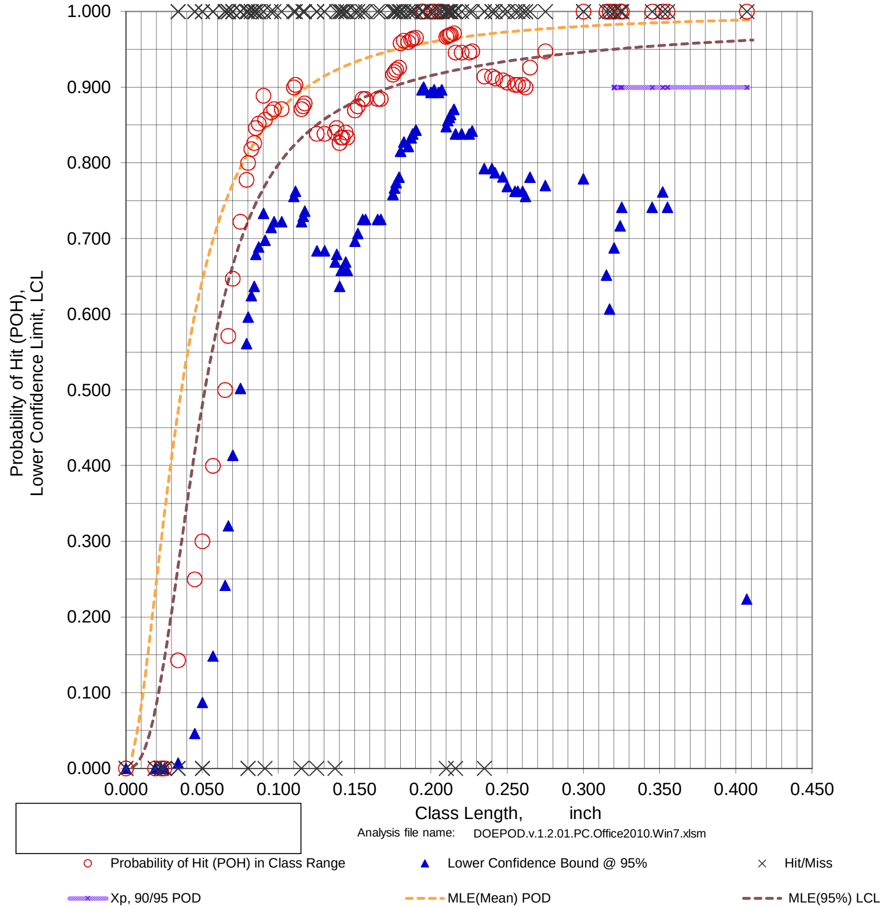
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

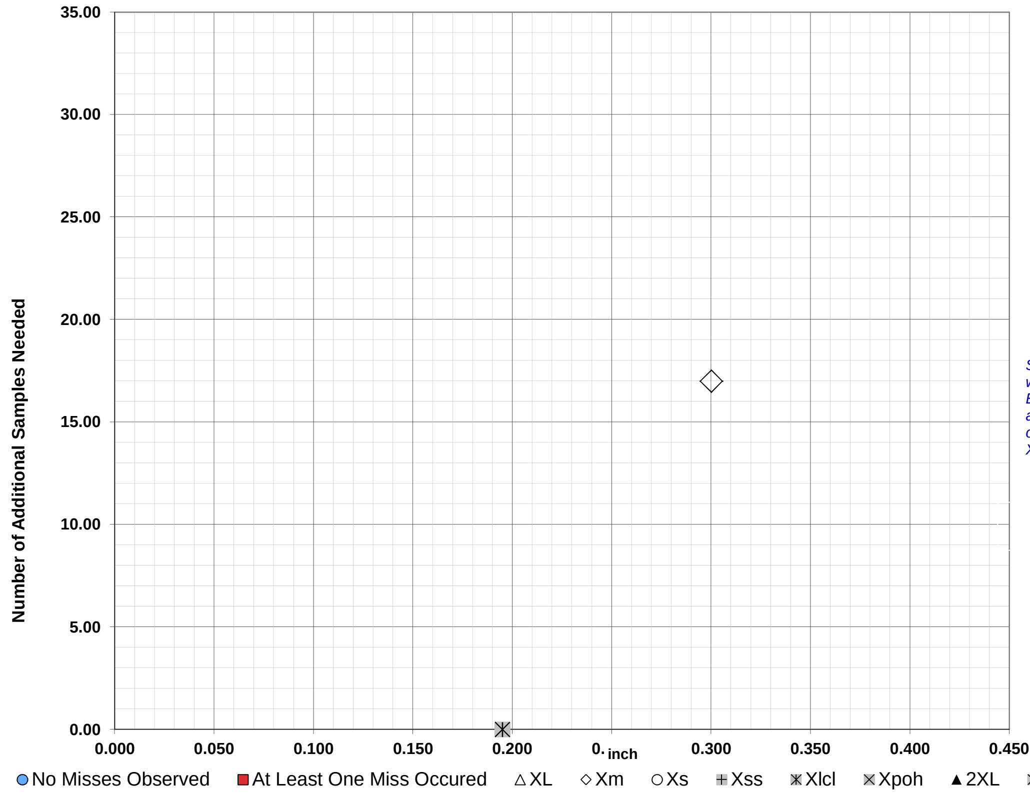


TABLE C

	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

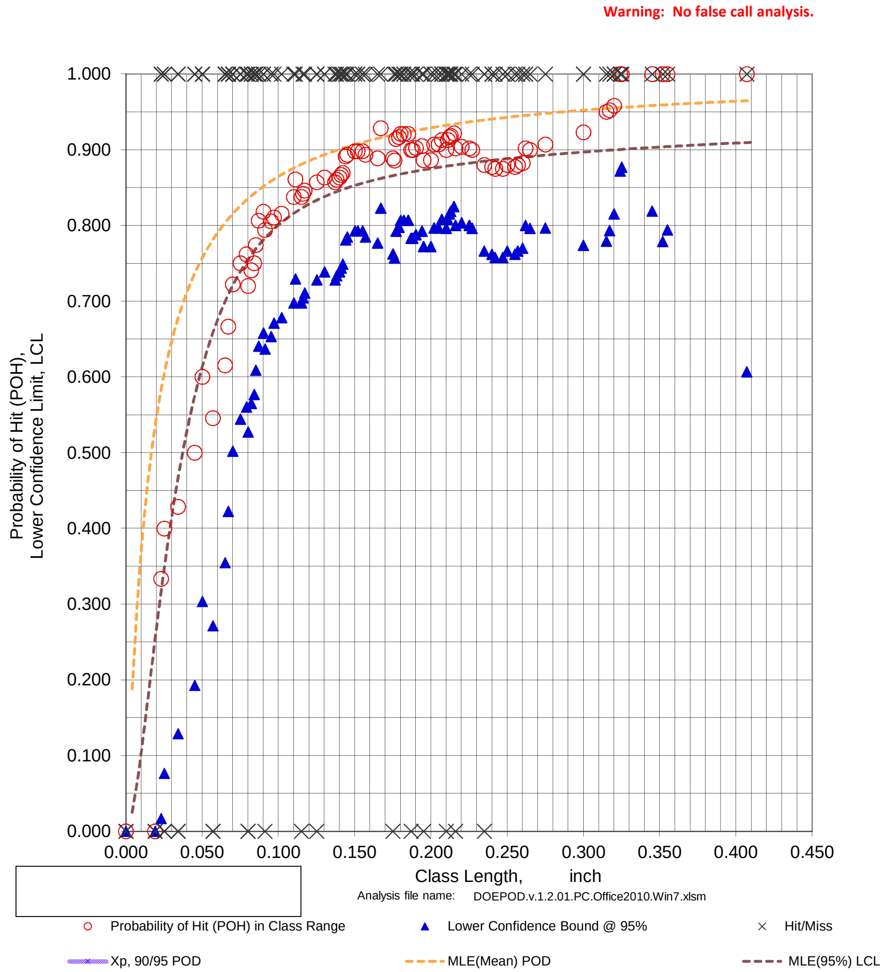
TABLE B*

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)



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

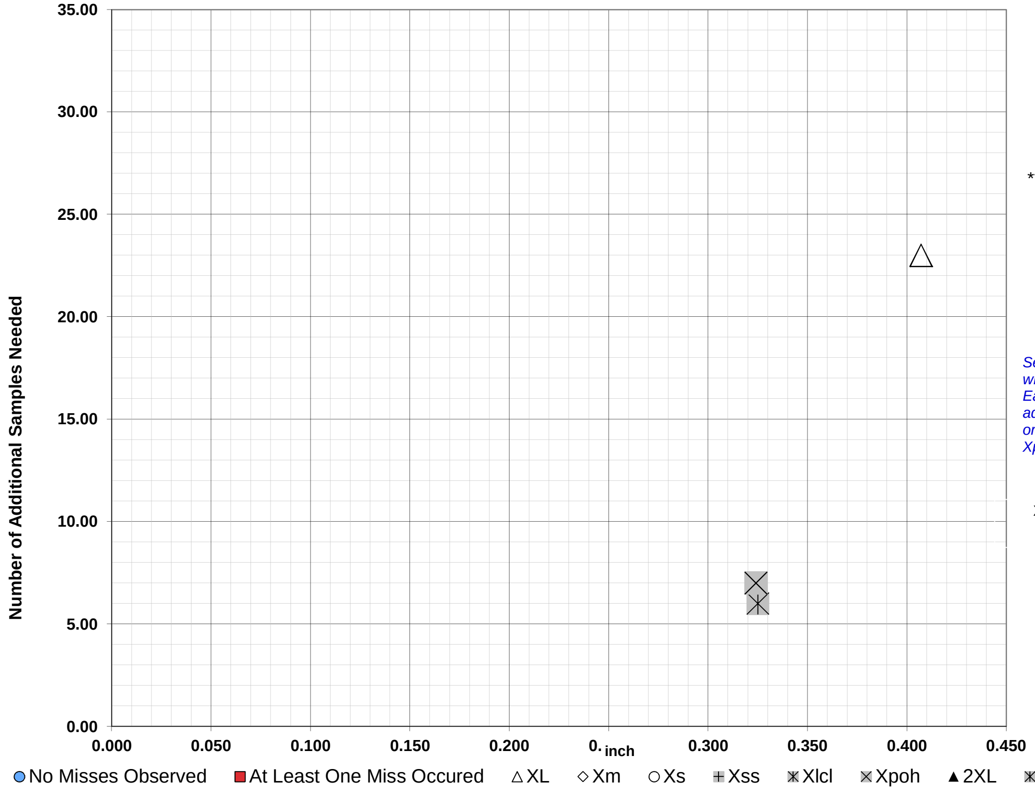


TABLE C

	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*

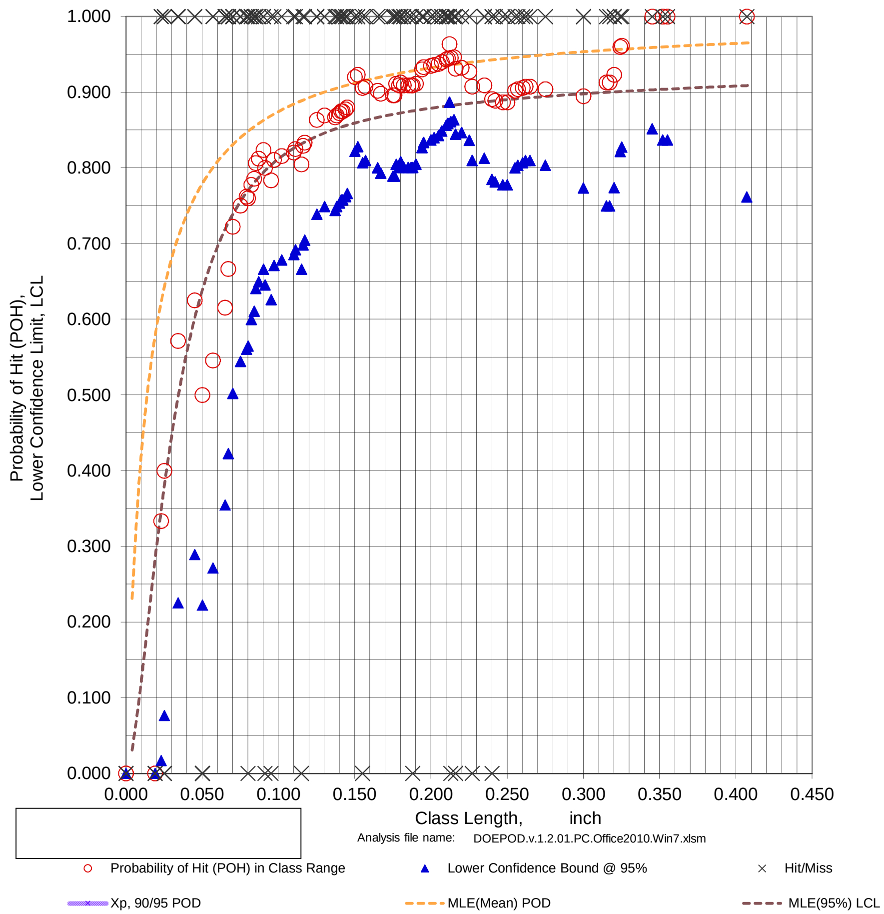
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



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

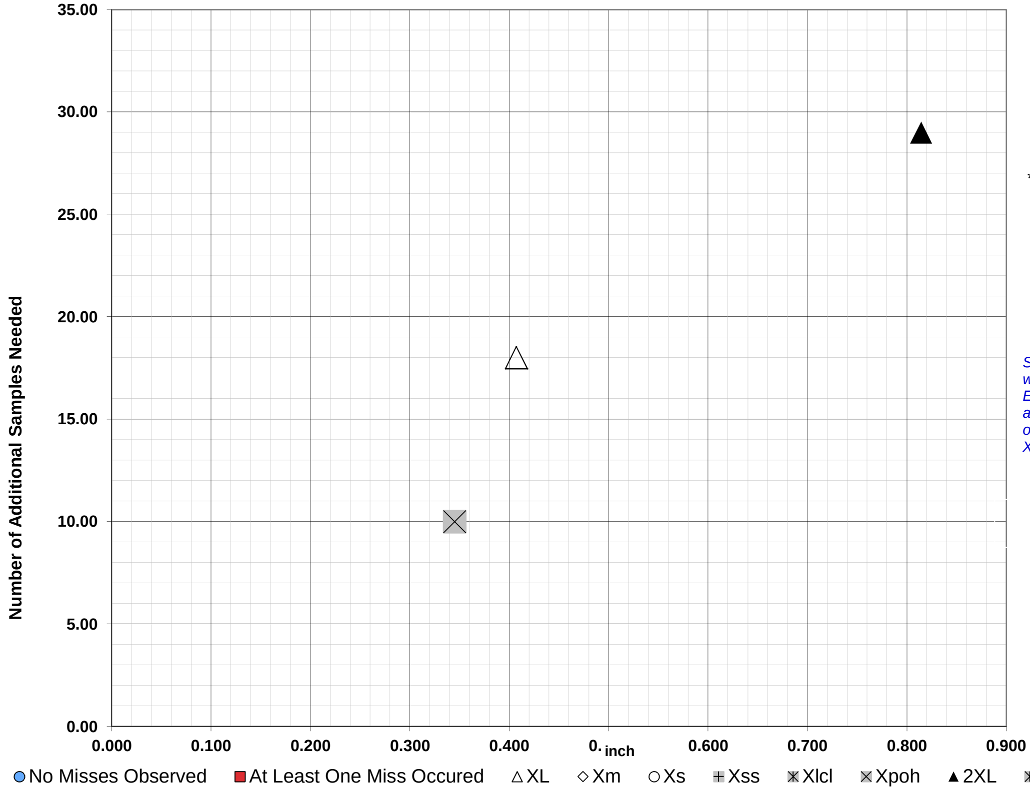


TABLE C

	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

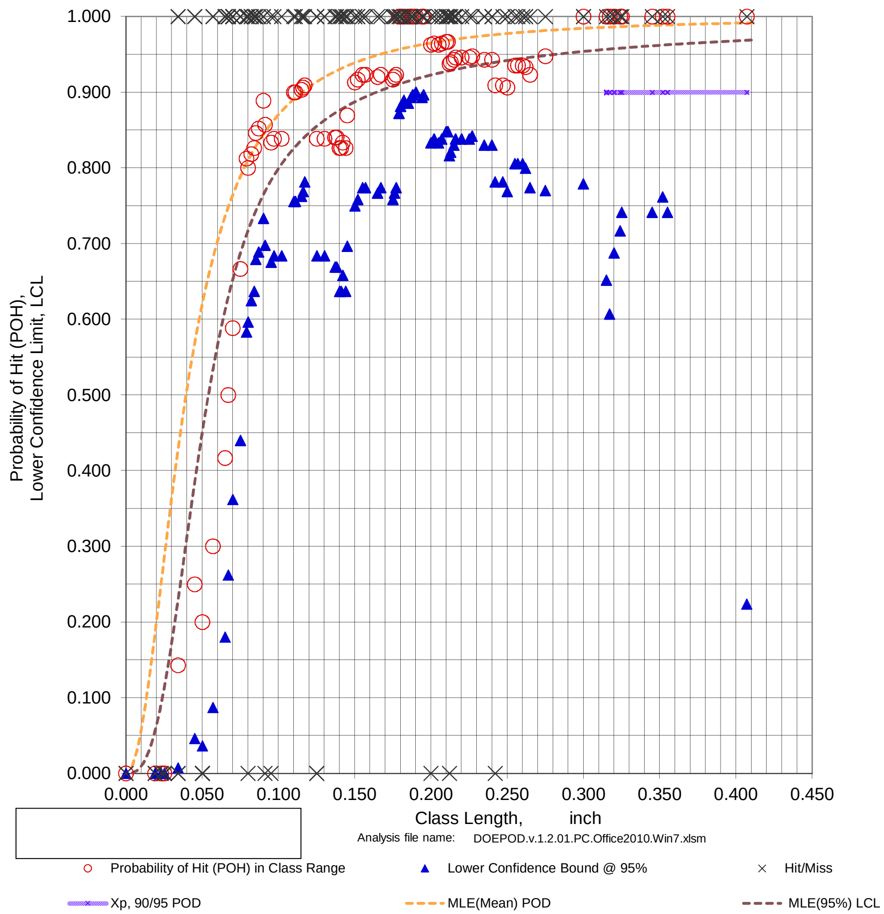
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

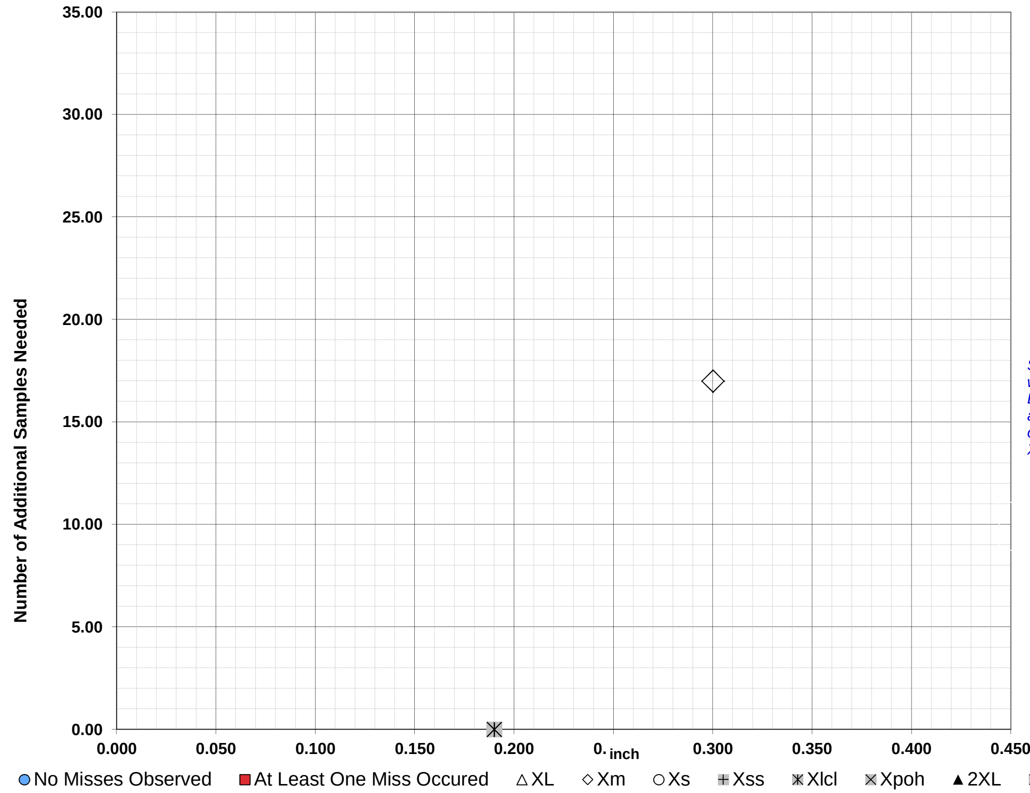


TABLE C

	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

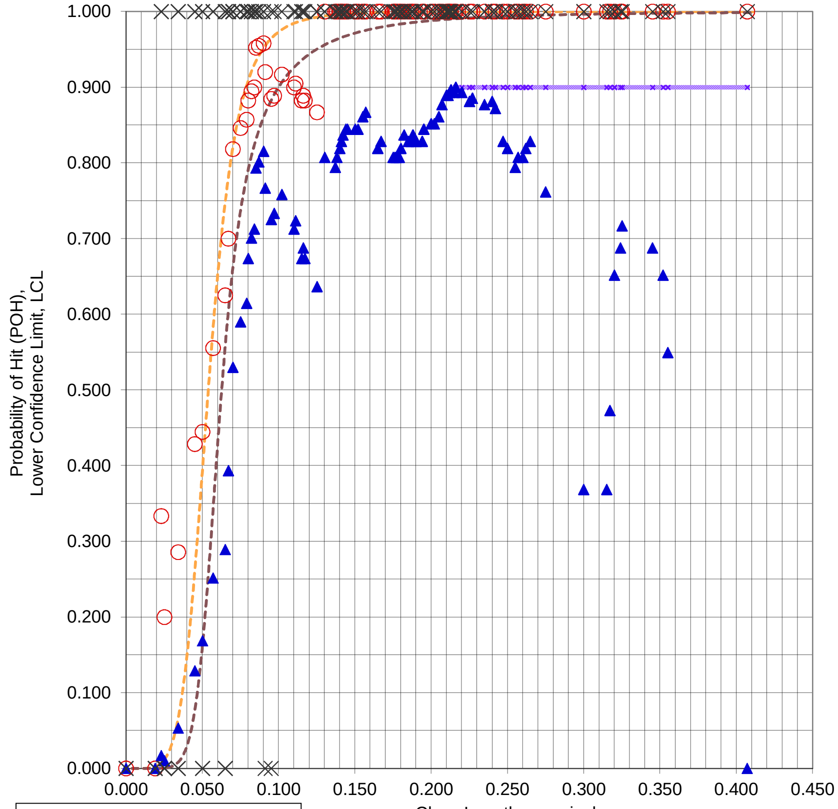
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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



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

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

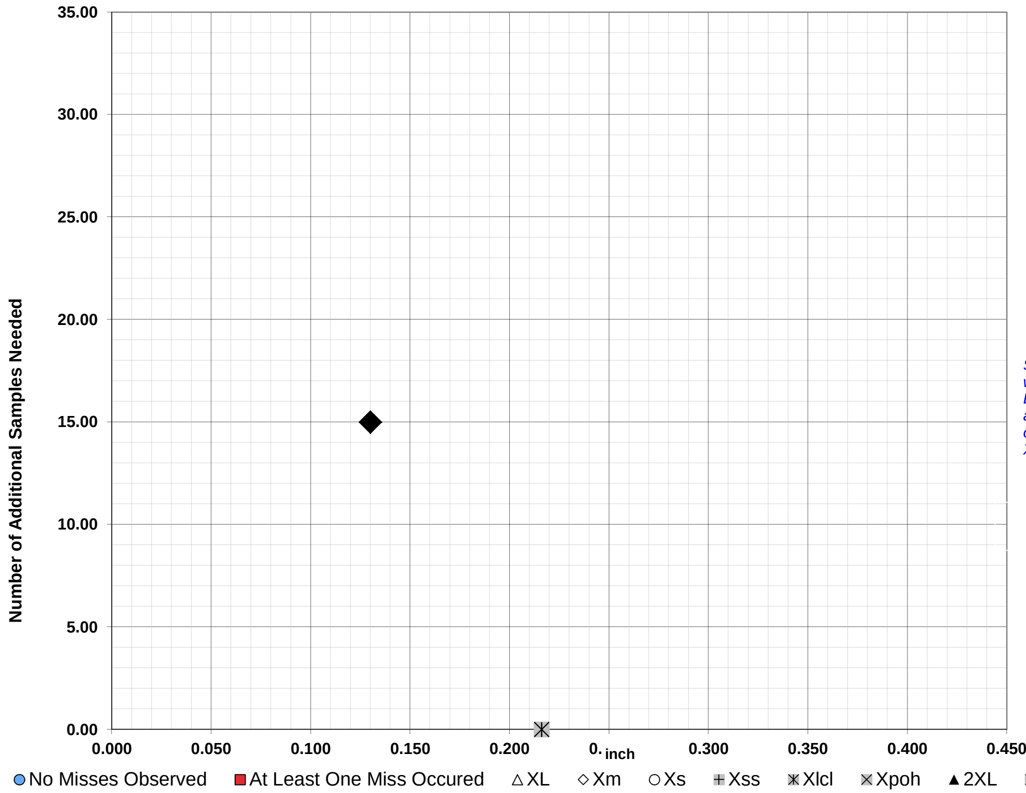


TABLE C

	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*

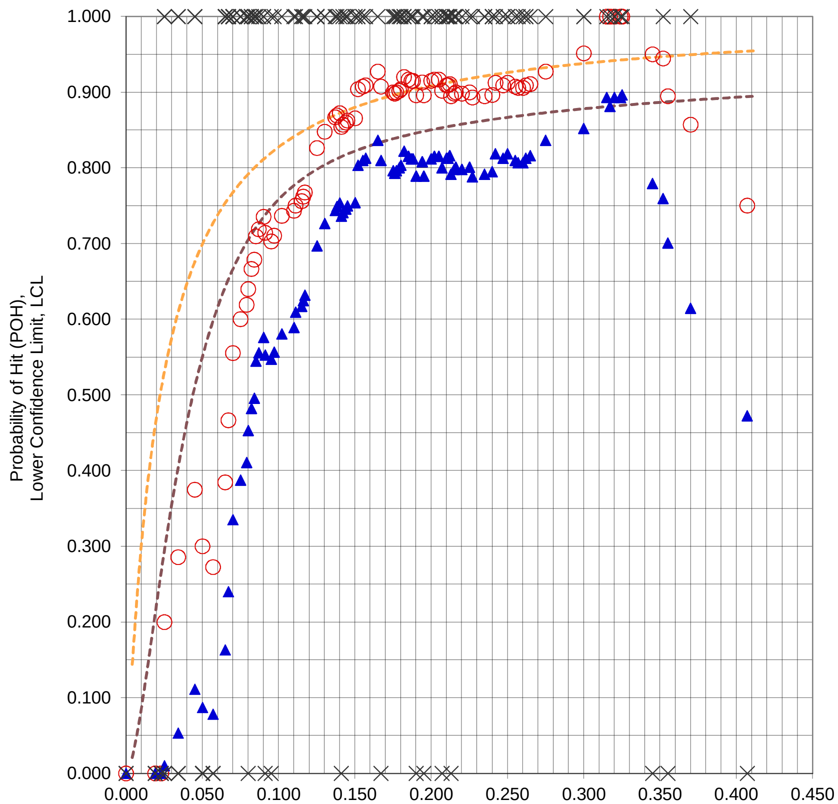
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

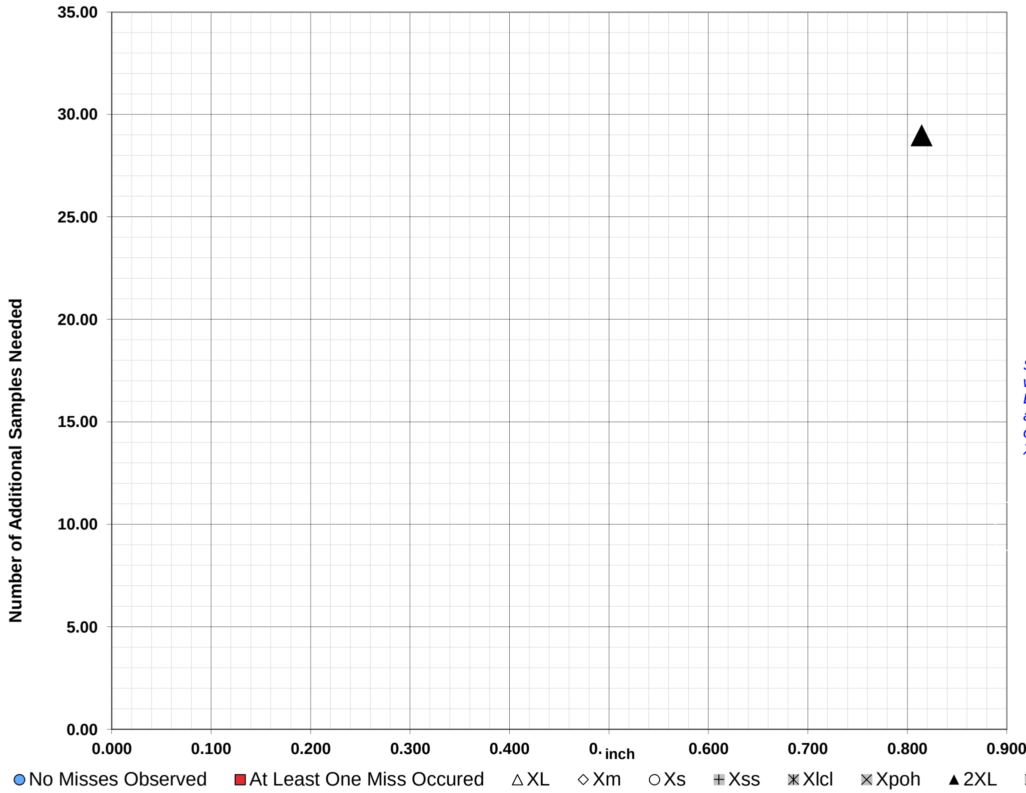


TABLE C

	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.

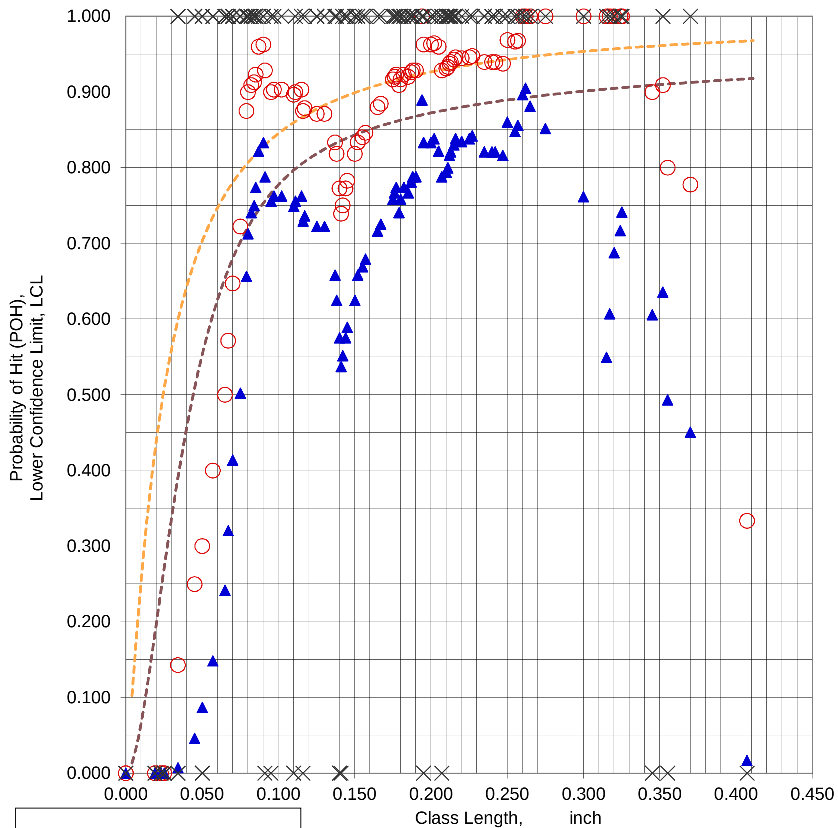
Xpod,Class Length	No. Need

* 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.



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 =	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

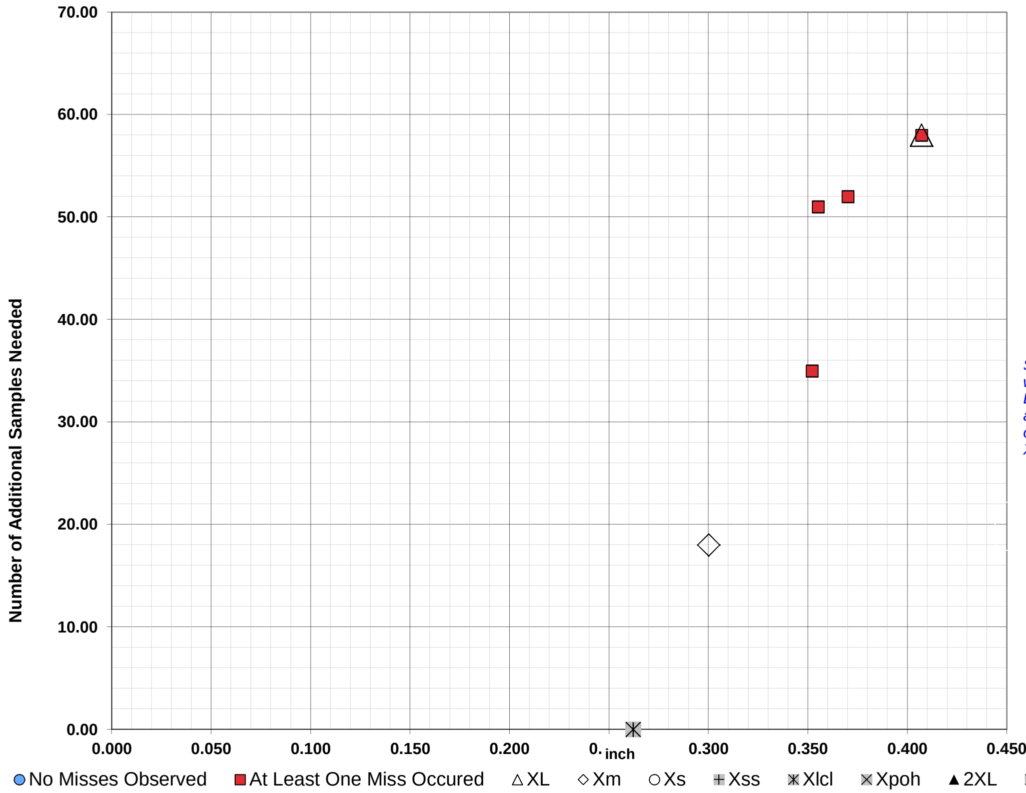


TABLE C

	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.

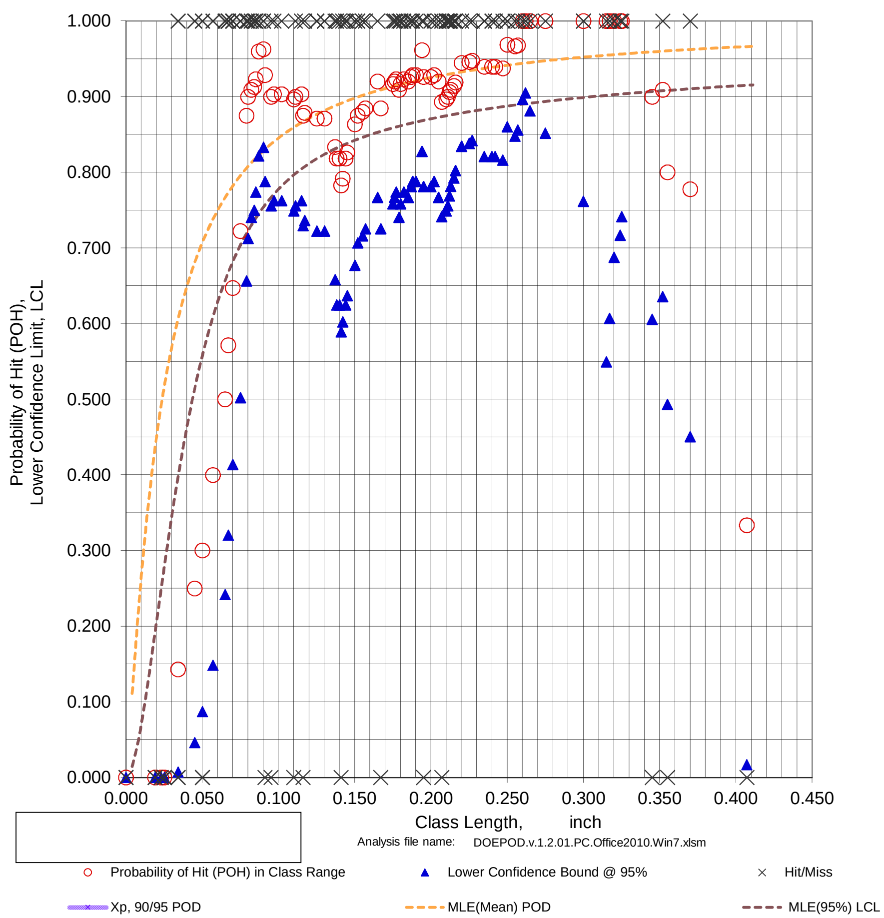
Xpod,Class Length	No. Need

* 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

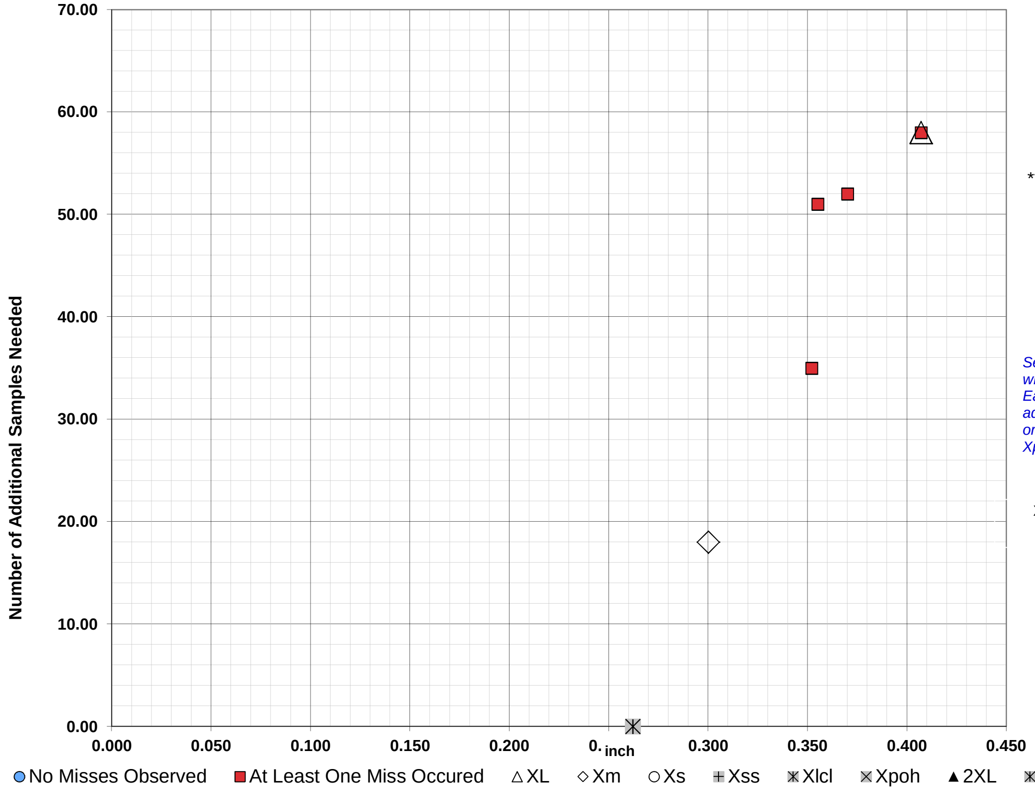


TABLE C

	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.

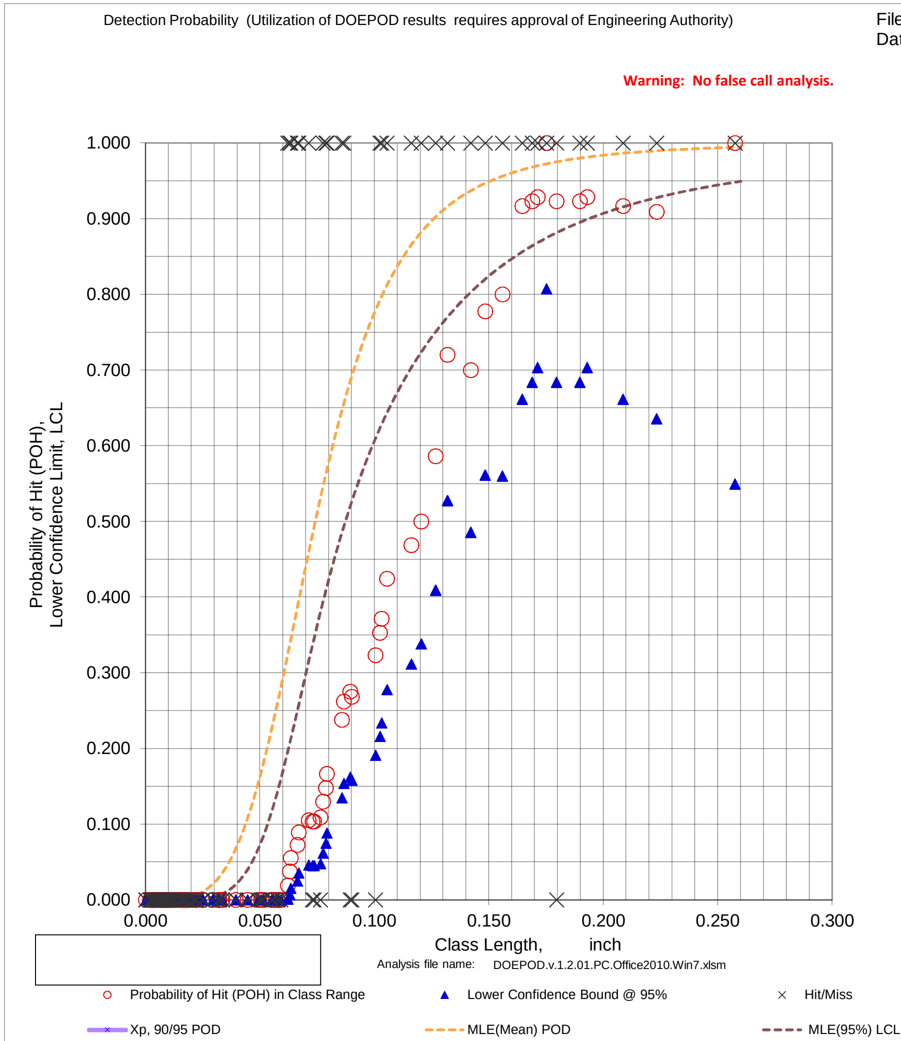
Xpod,Class Length	No. Need
0.4070	58
0.3700	52
0.3550	51
0.3520	35

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



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

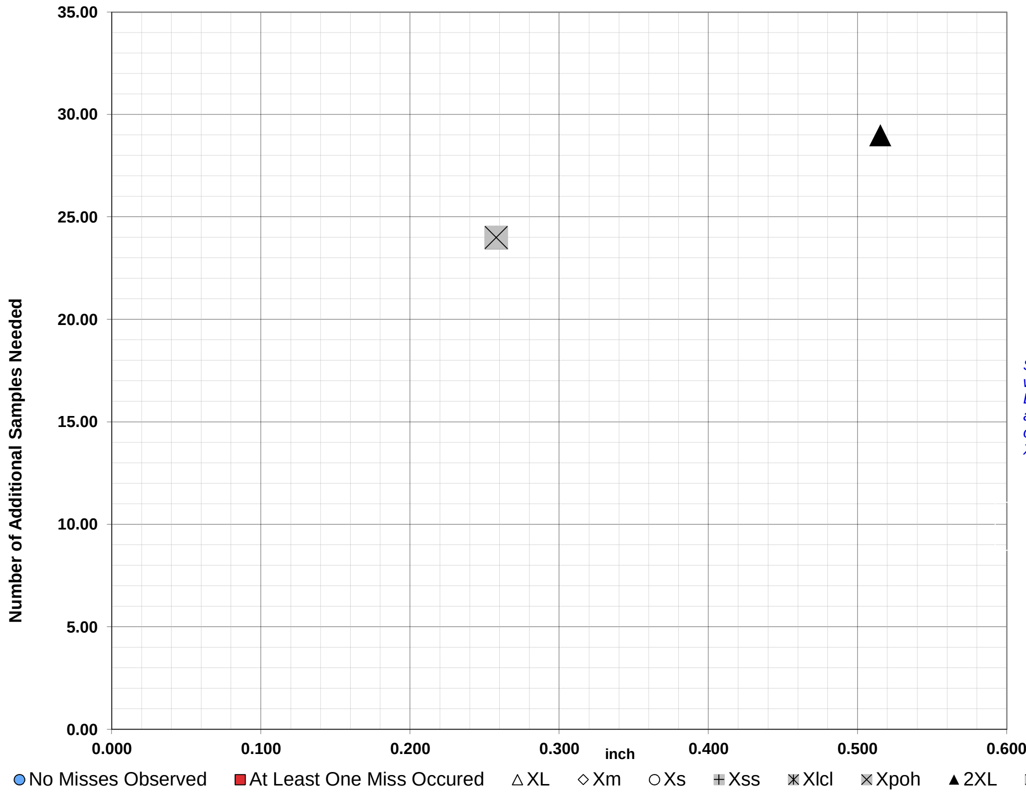


TABLE C

	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*

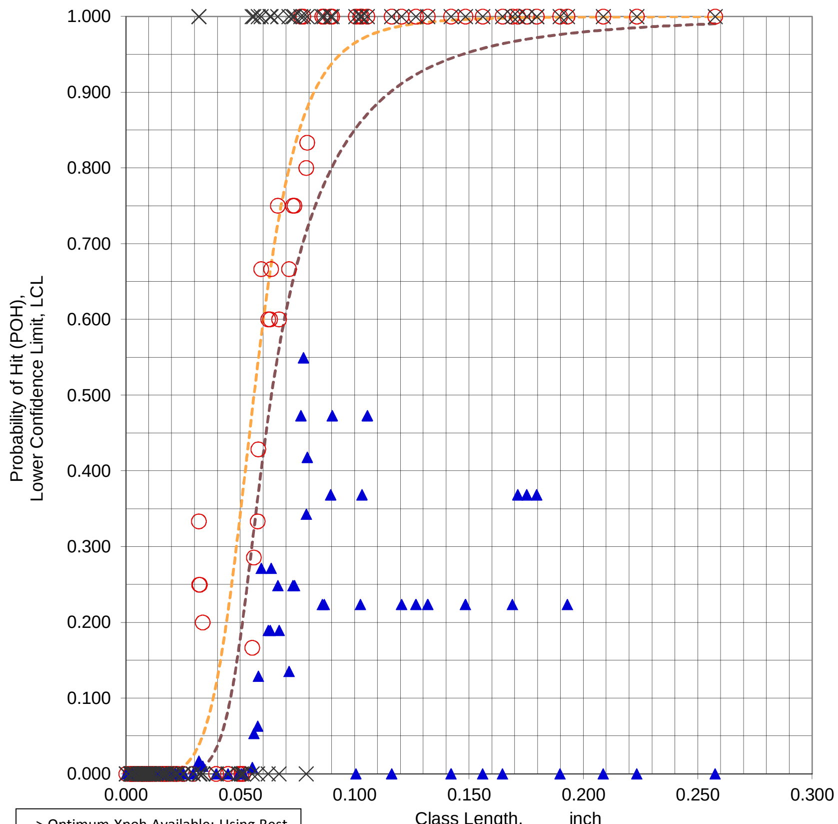
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

--> Optimum Xpoh Available; Using Best LCL

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 = 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

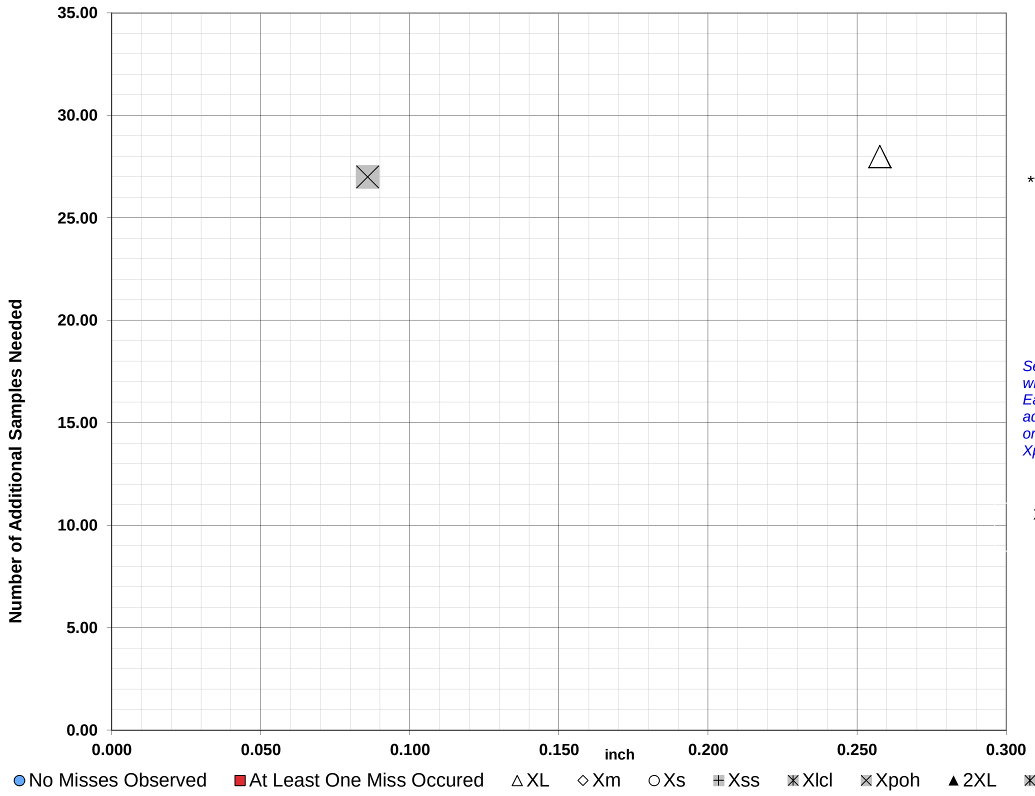


TABLE C

	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*

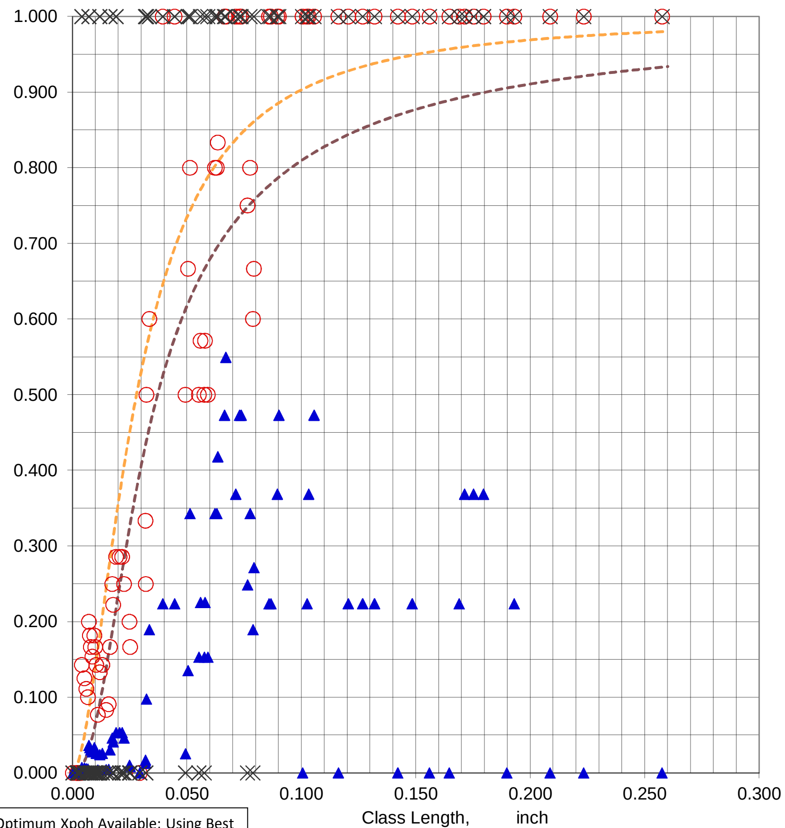
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



--> 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 = 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

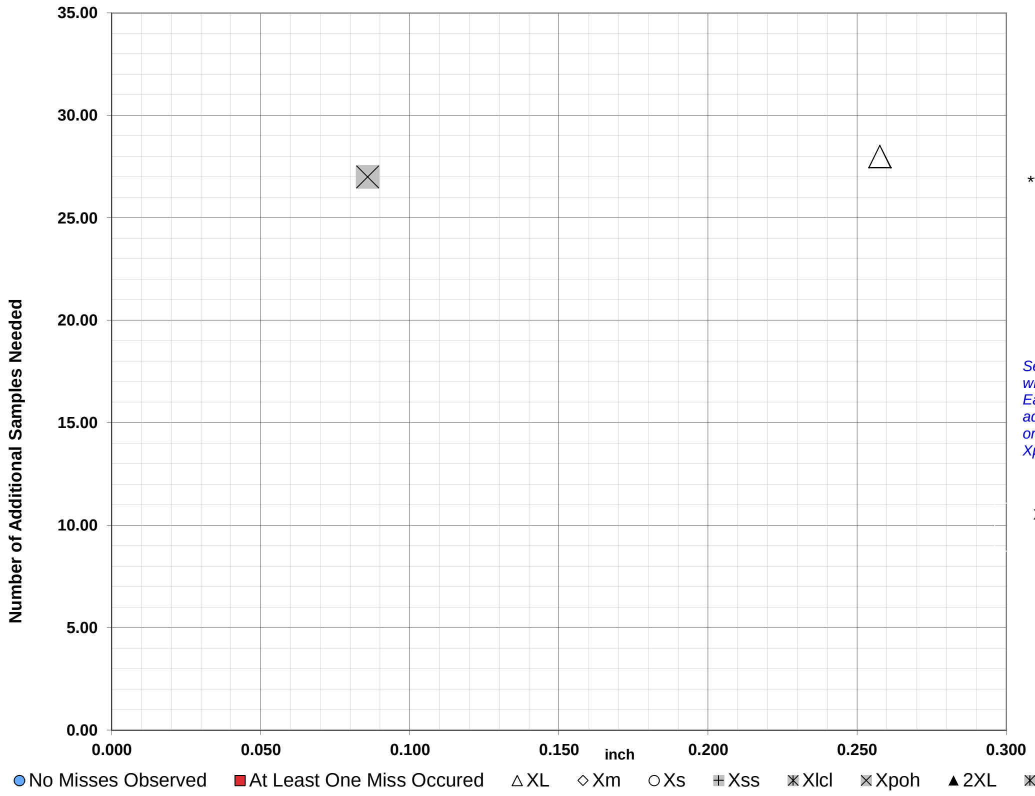


TABLE C

	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*

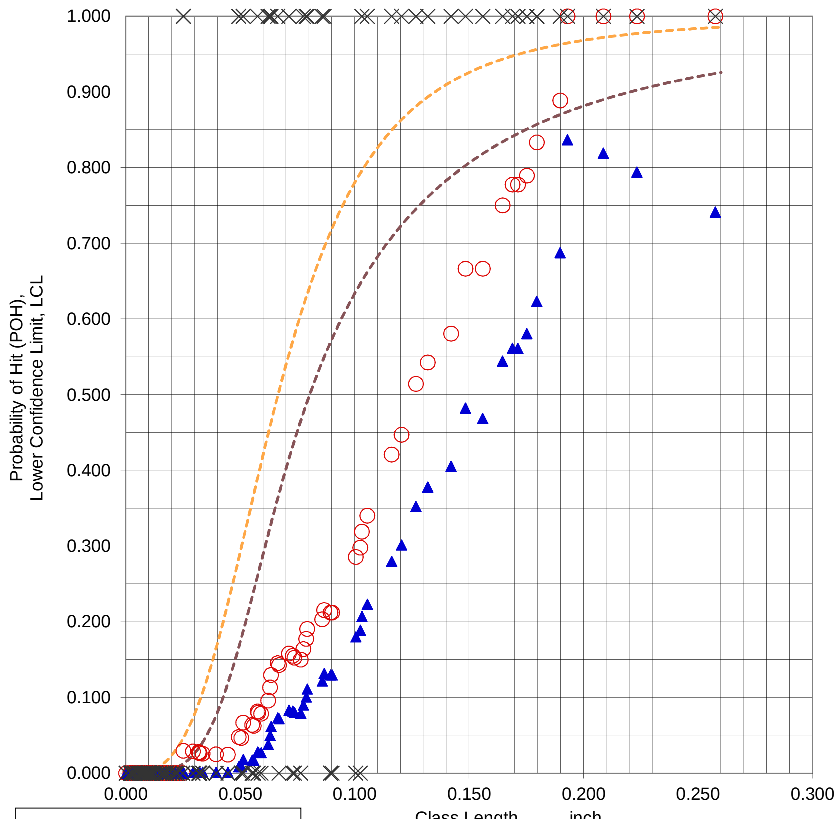
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

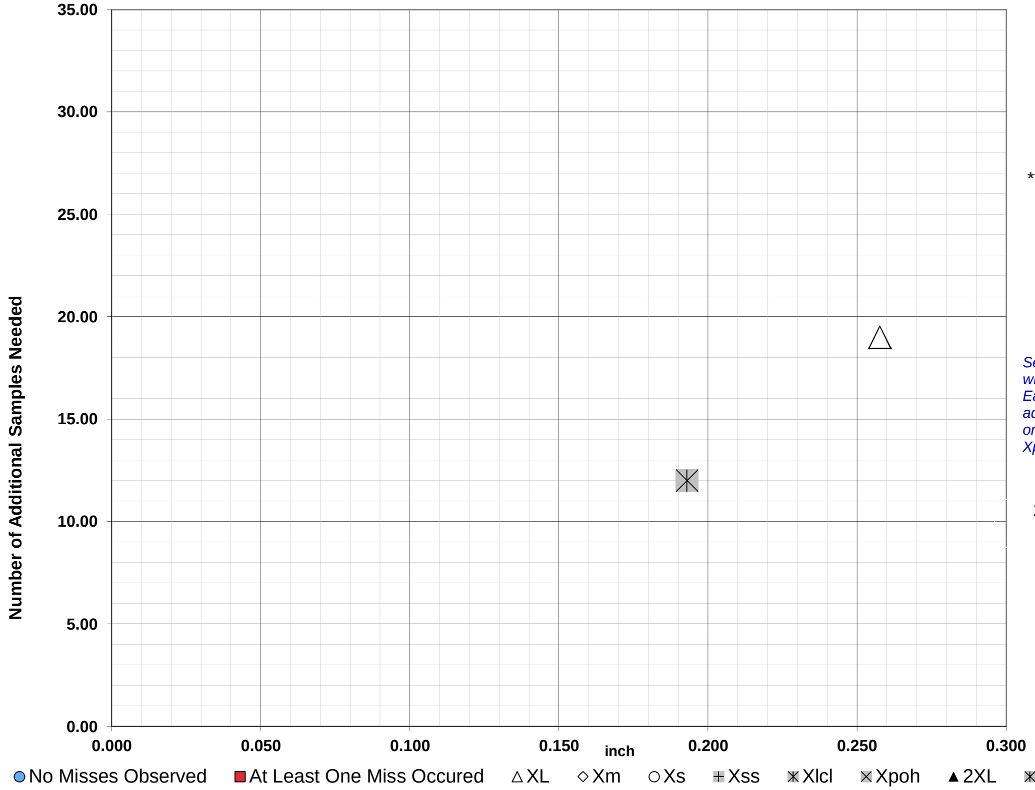


TABLE C

	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*

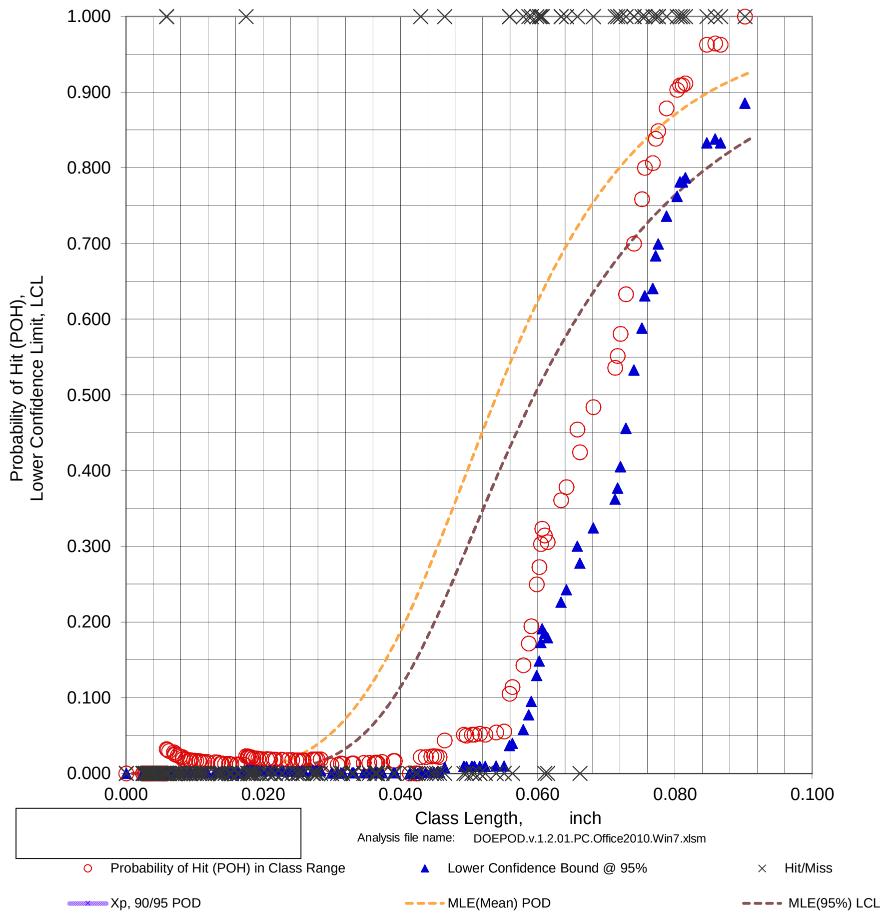
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

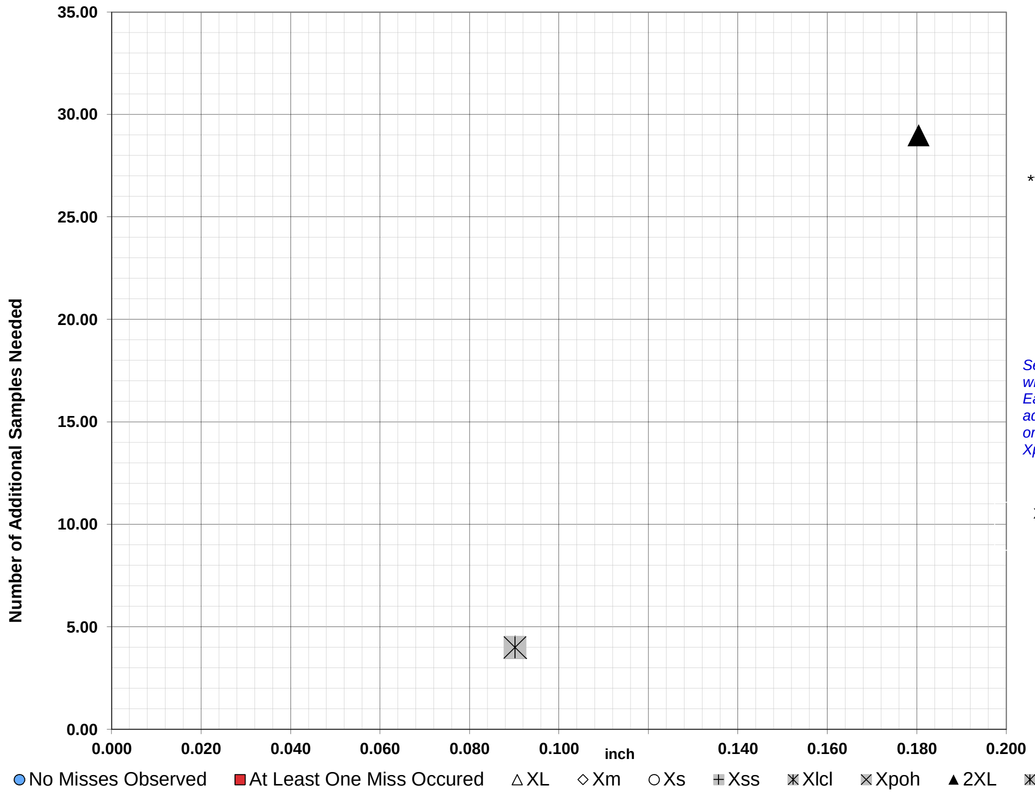


TABLE C

	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*

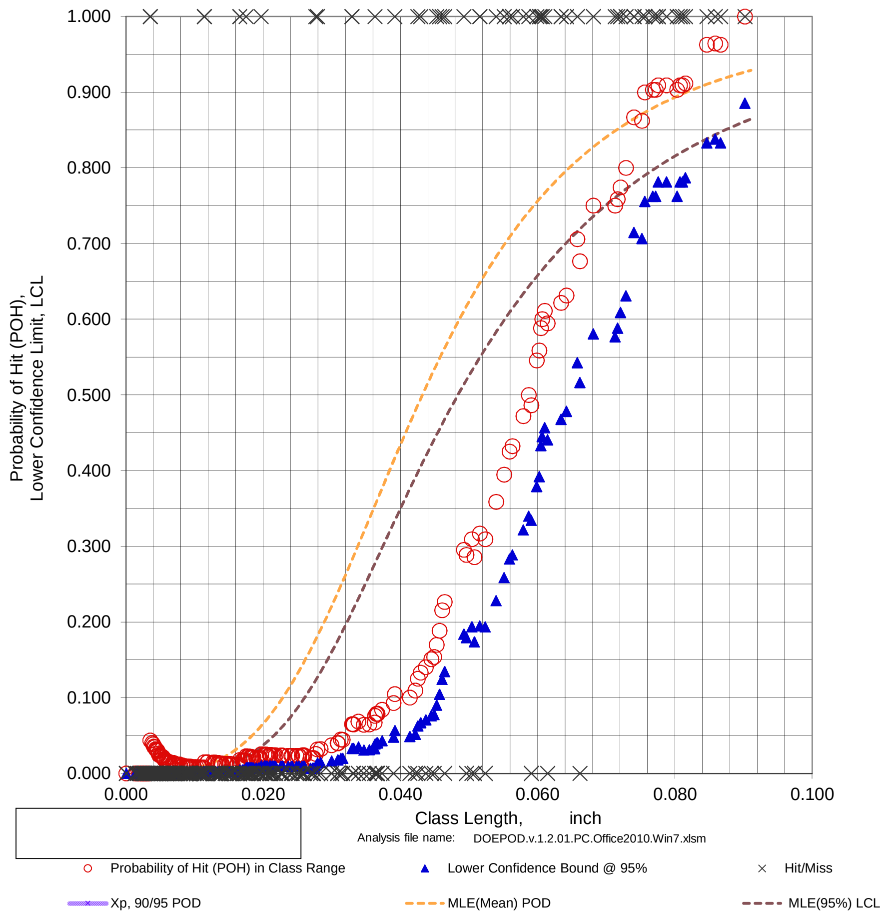
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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

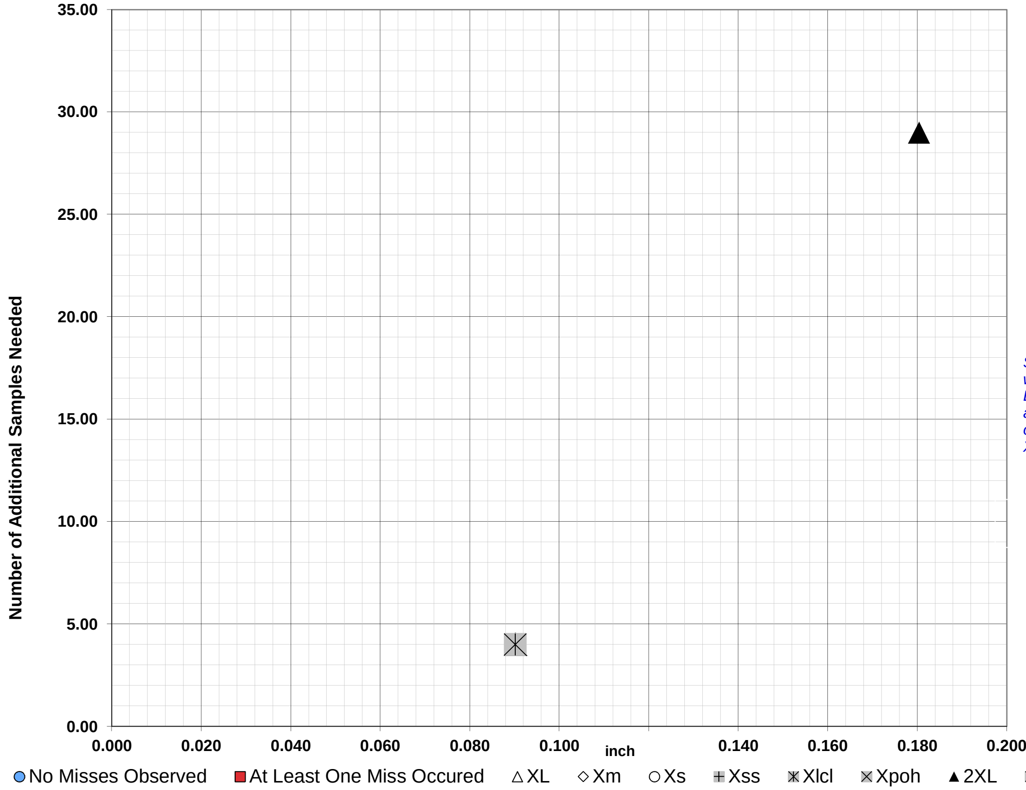


TABLE C

	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*

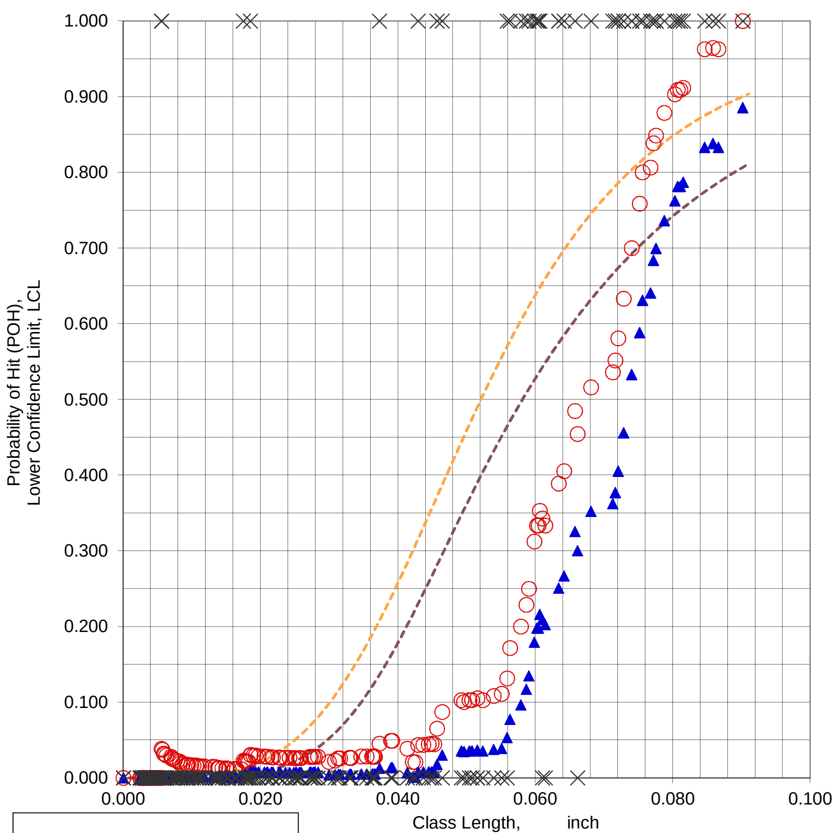
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = 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

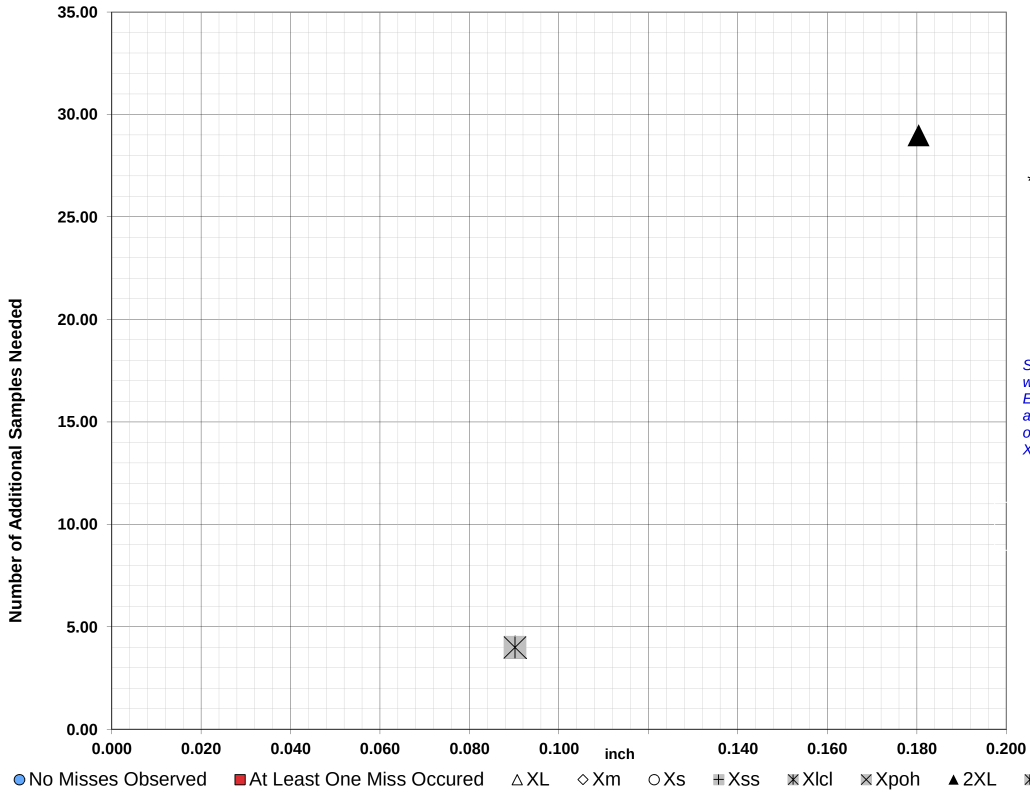


TABLE C

	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*

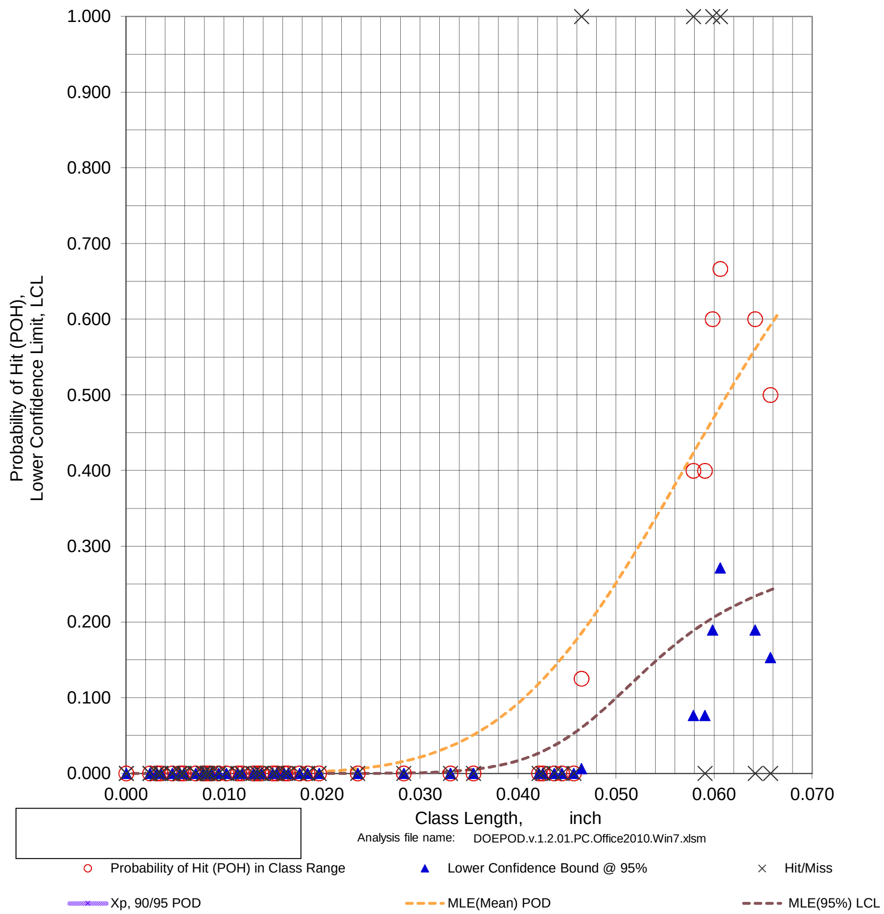
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

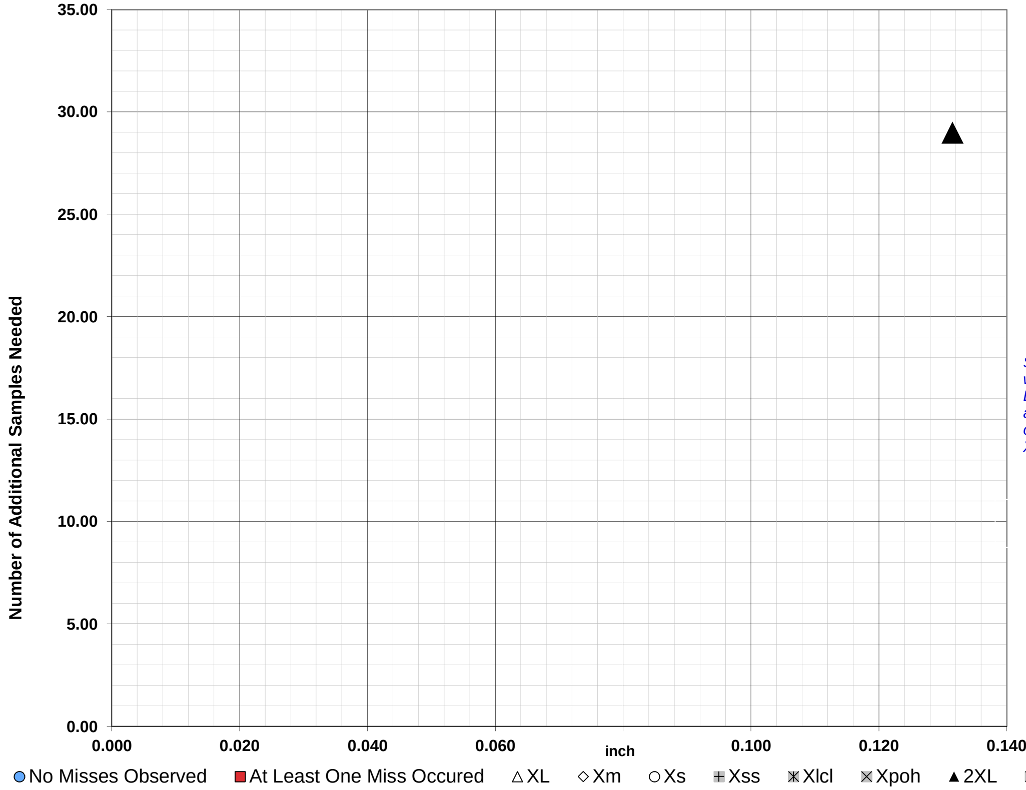


TABLE C

	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*

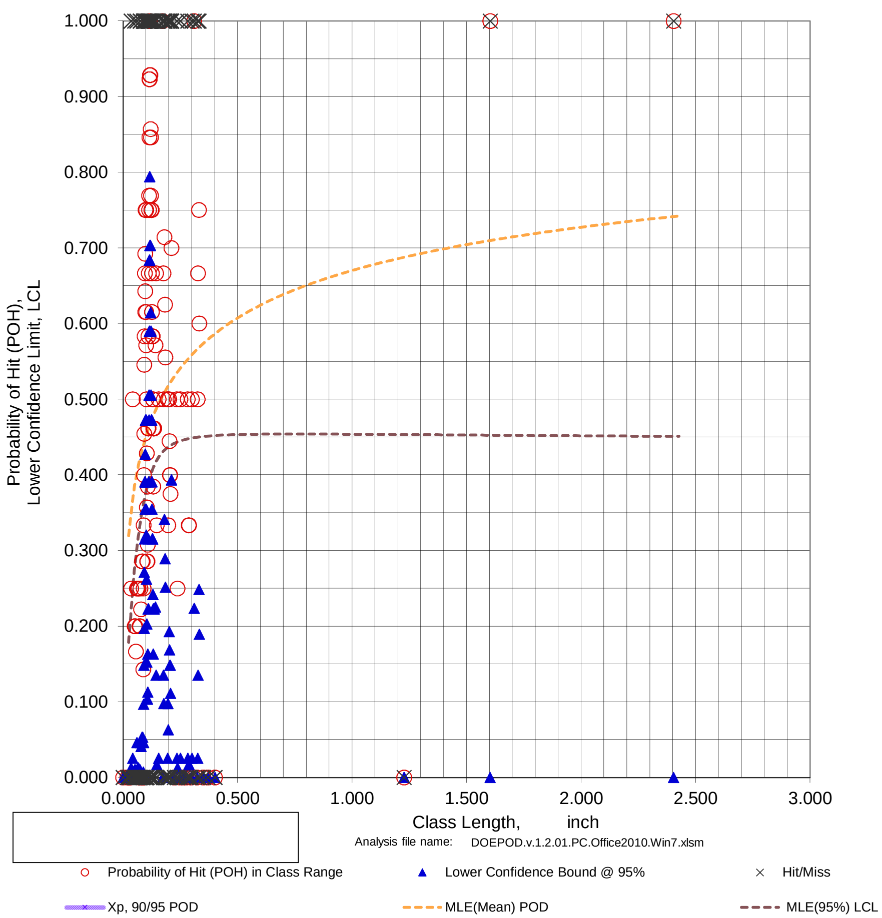
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

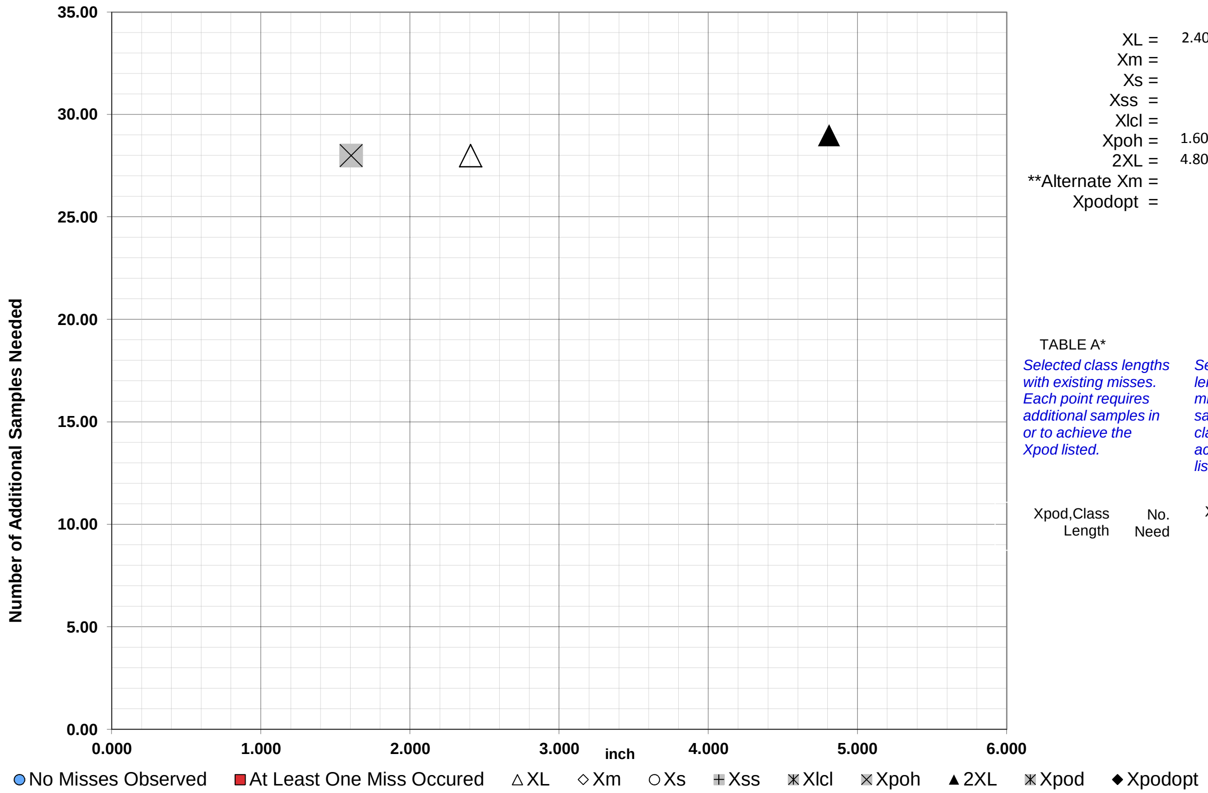


TABLE C

	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*

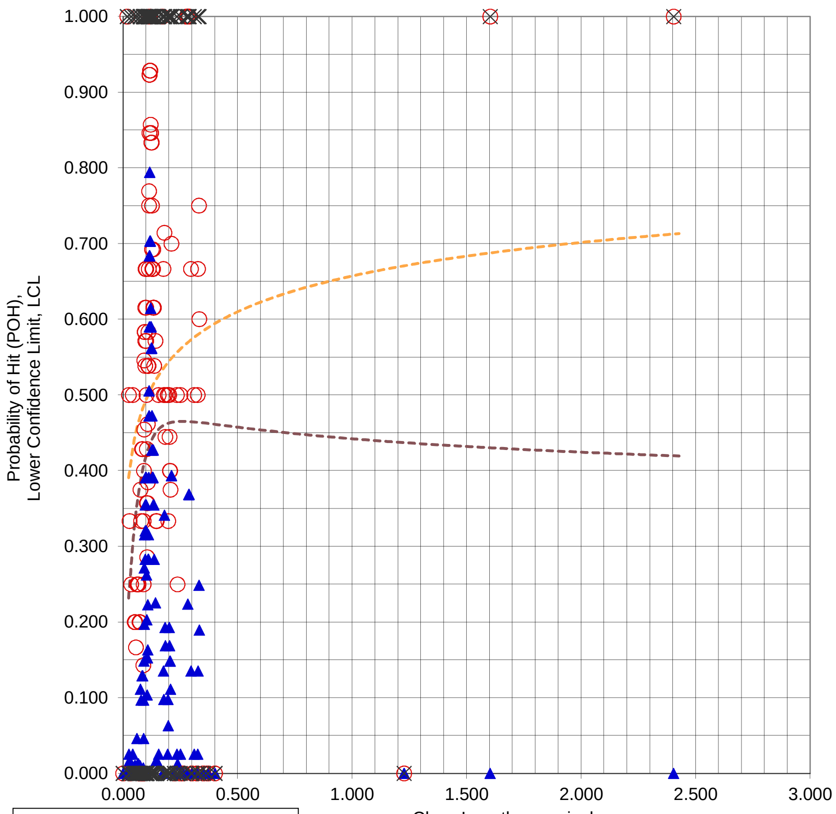
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

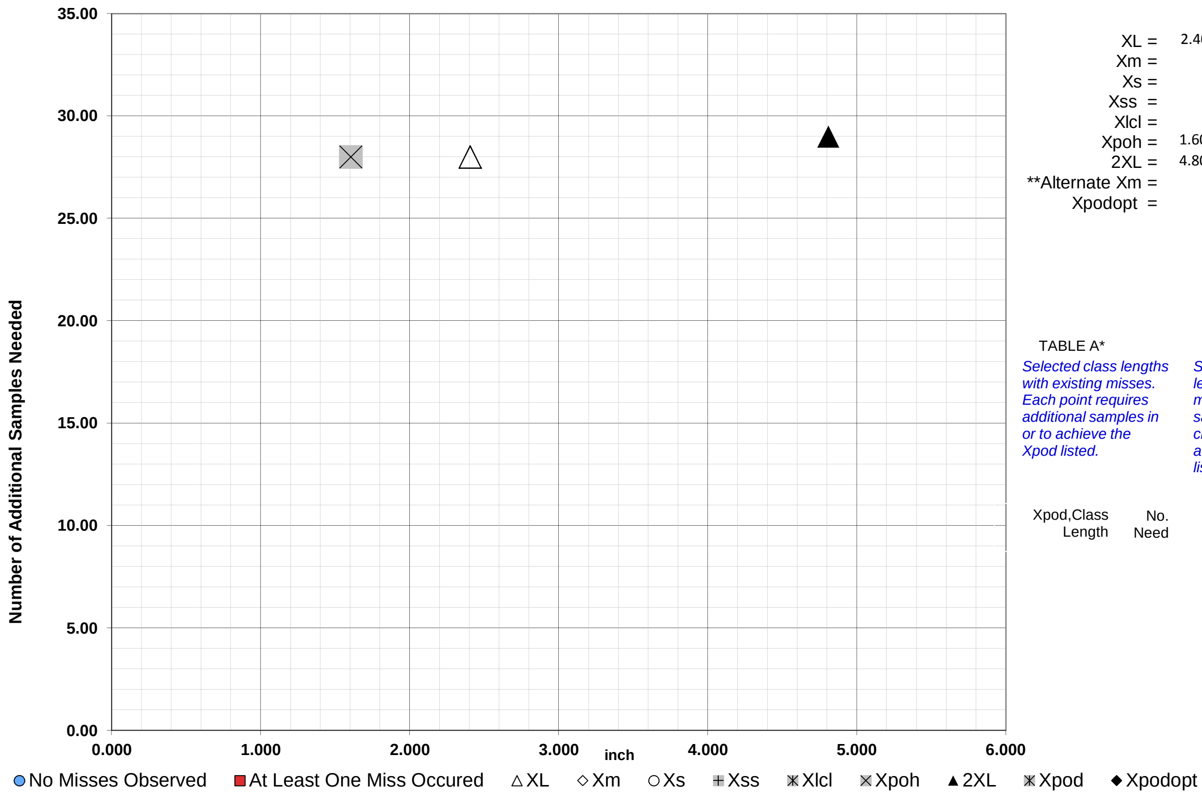


TABLE C

	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*

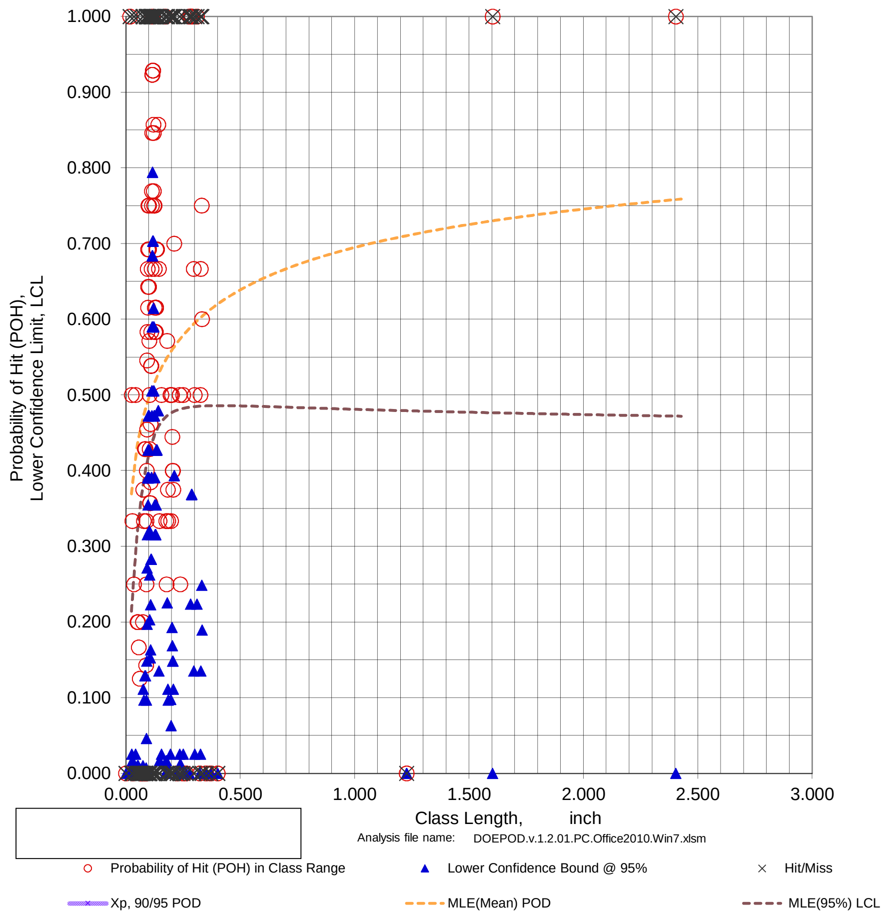
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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 =
Samples Needed @Xpodopt =
Xp = inch

File Name = C6001CL.XLS
Data Set Name = C6001CL(CRK #)

Directed DOE Options

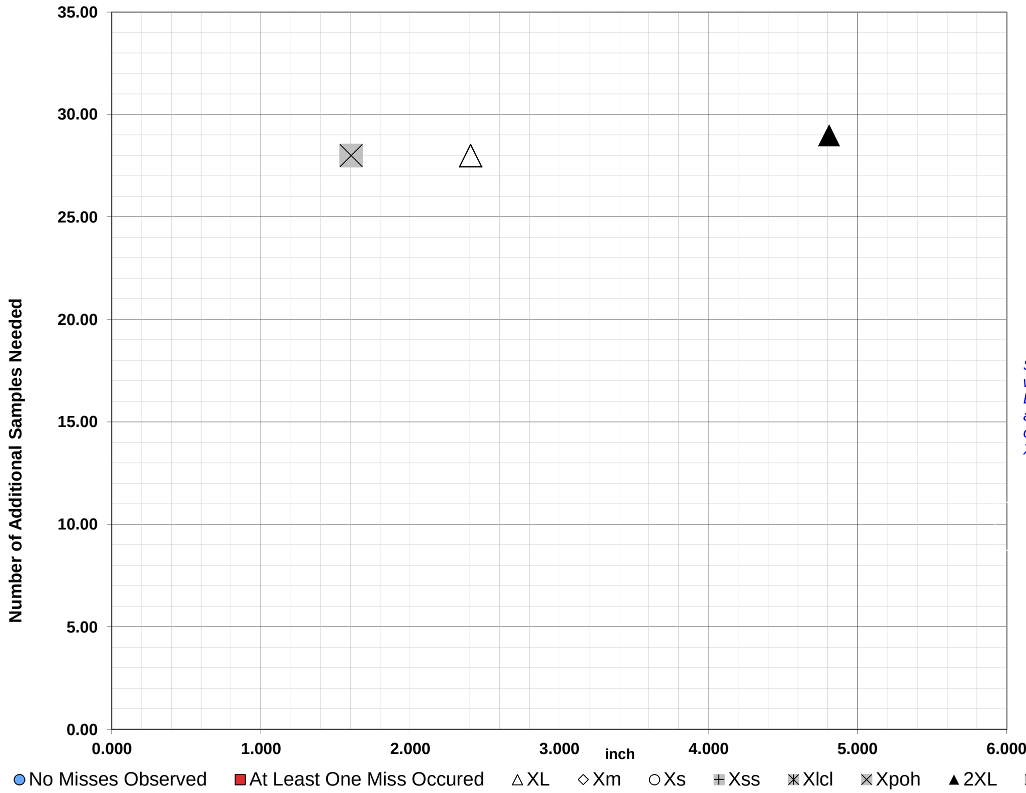


TABLE C

	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.

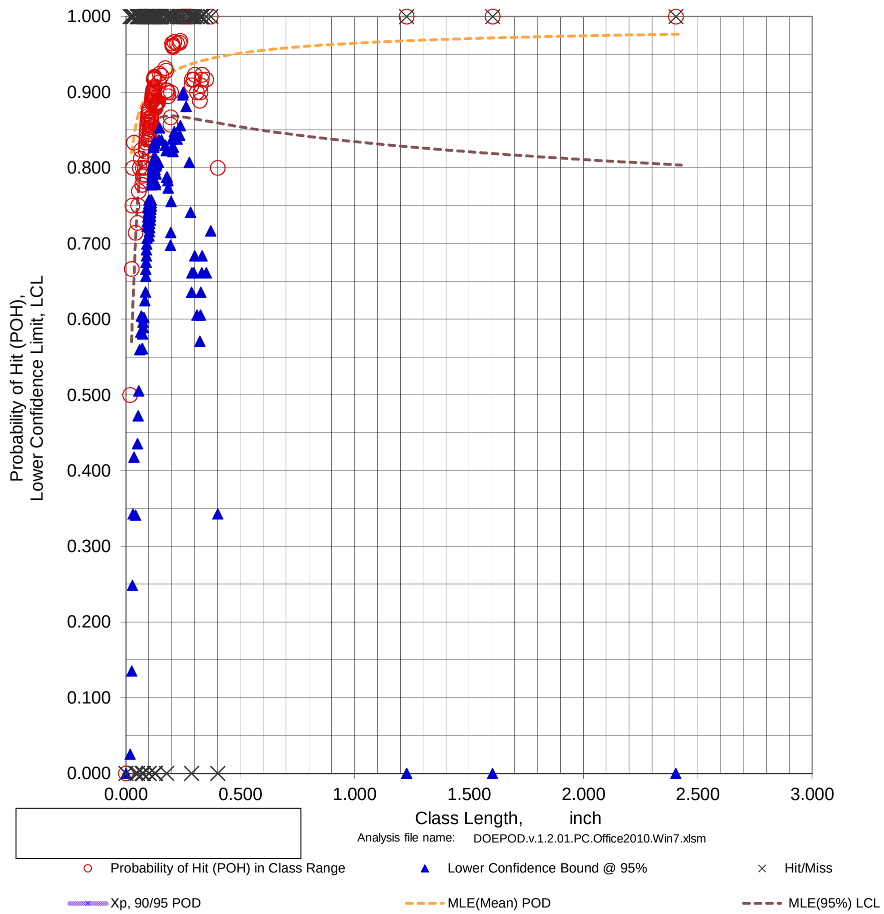
Xpod,Class Length	No. Need

* 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

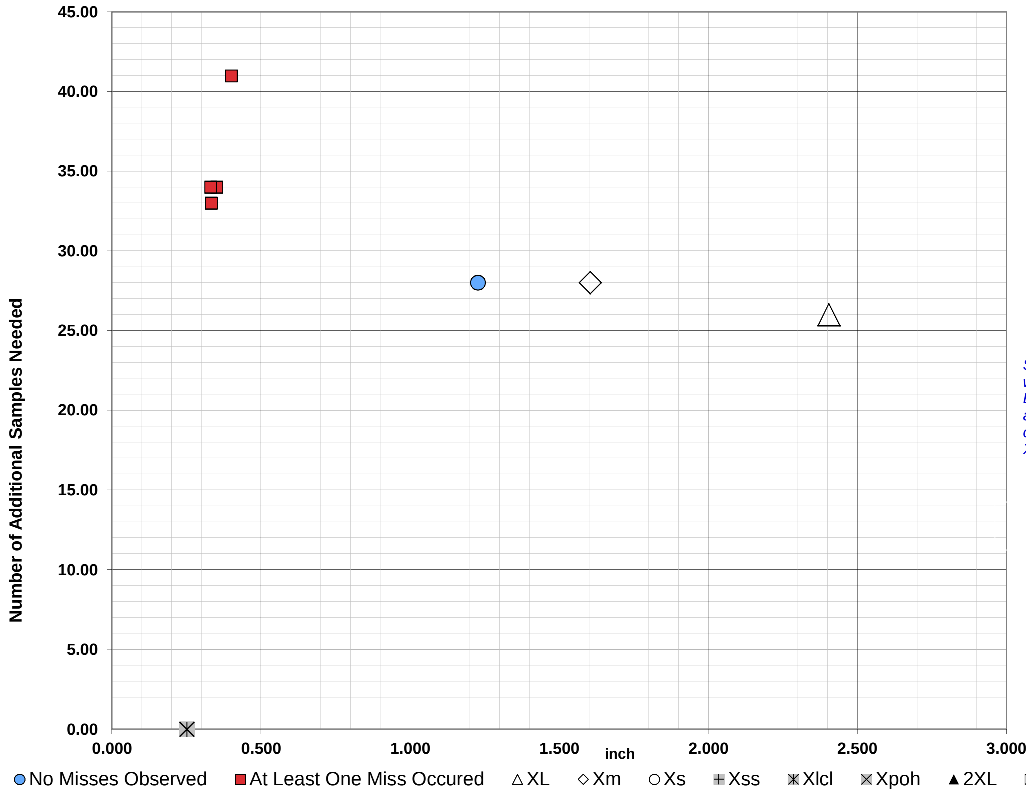


TABLE C

	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

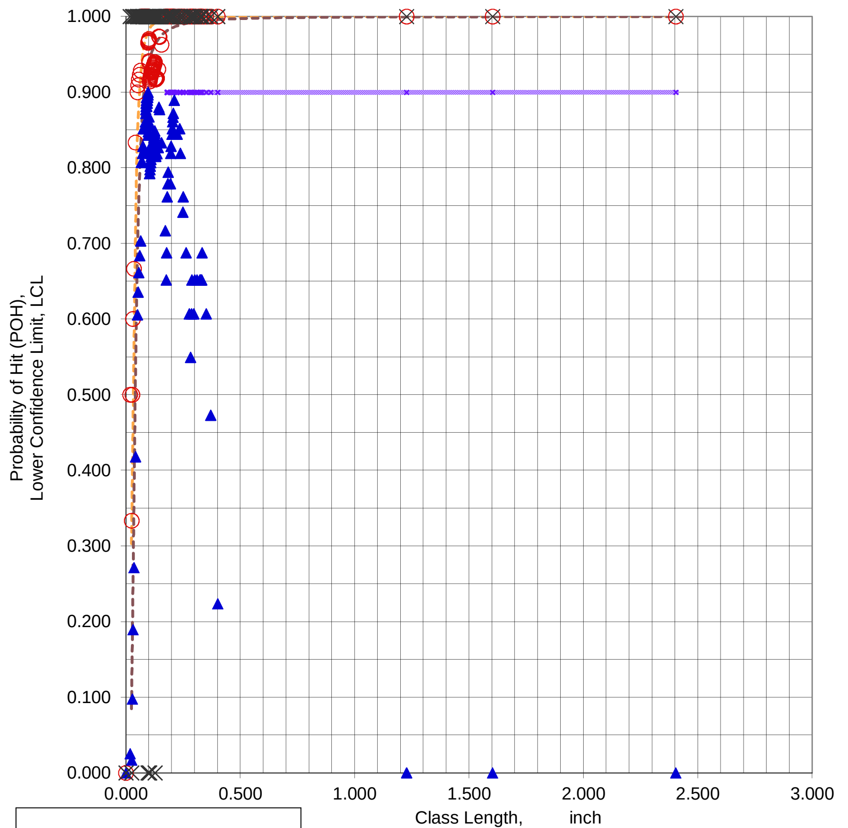
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

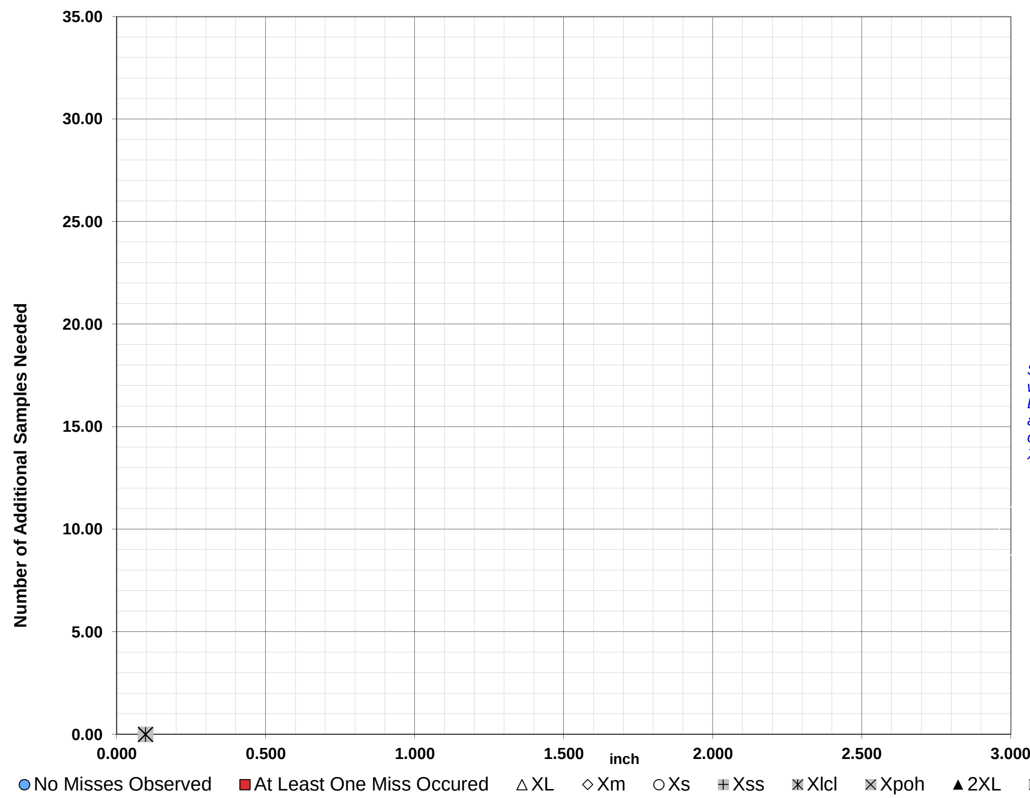


TABLE C

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.

MLE Divergence Warning: Initial results listed.

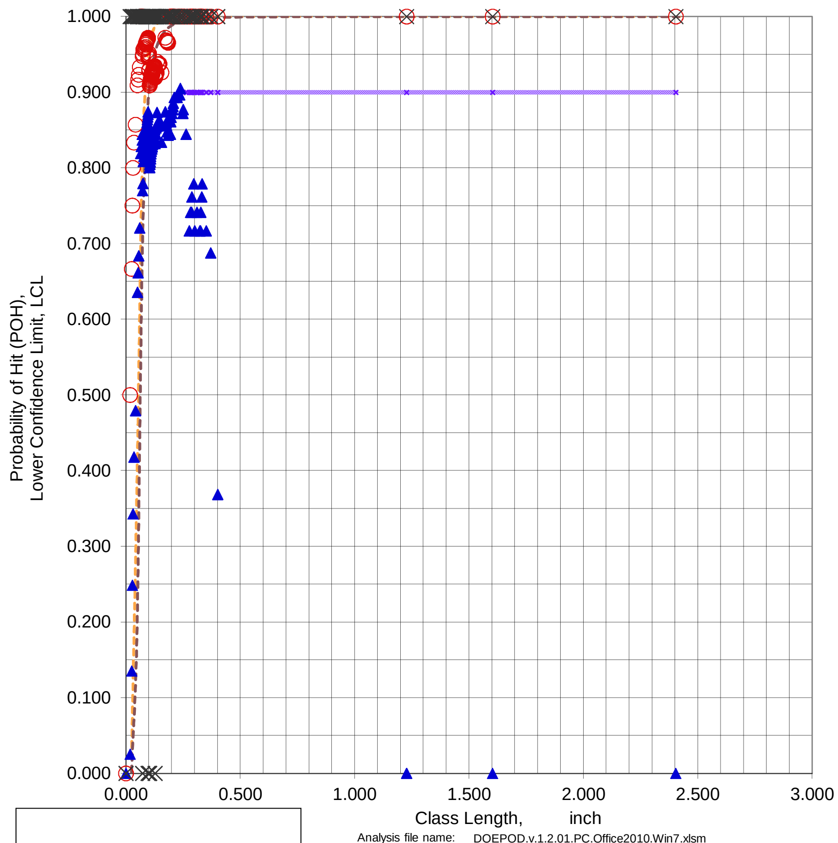
Note: Xpodopt is within one class width of Xpod.

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	



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

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

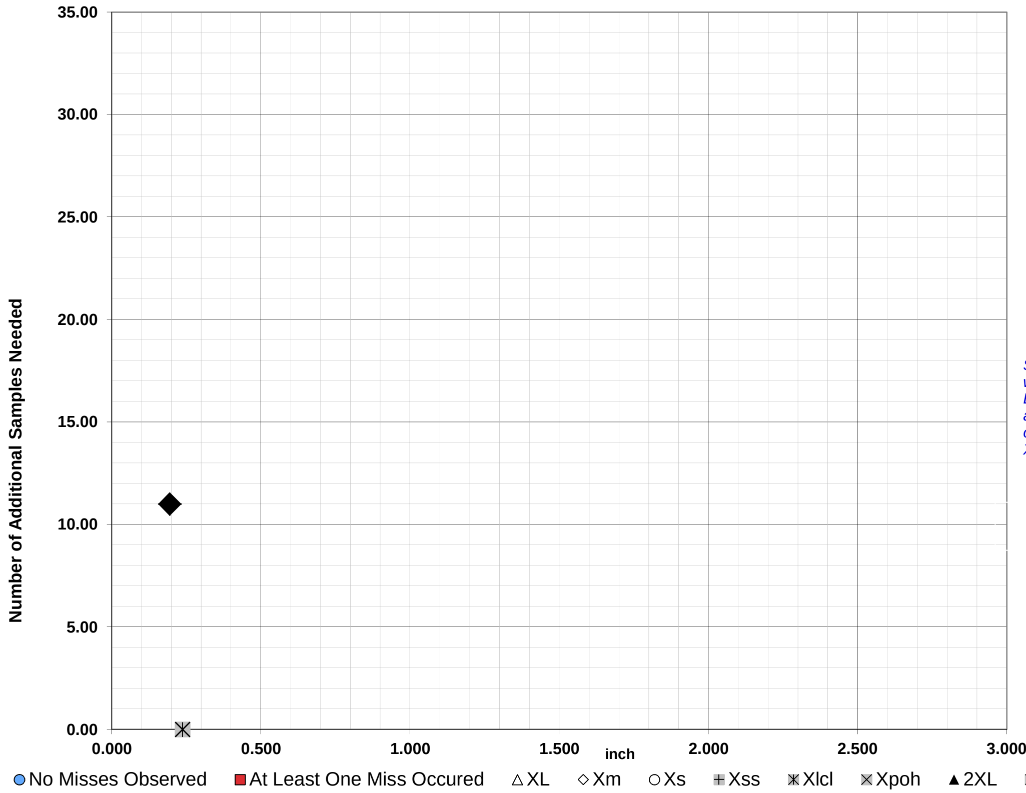


TABLE C

	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.

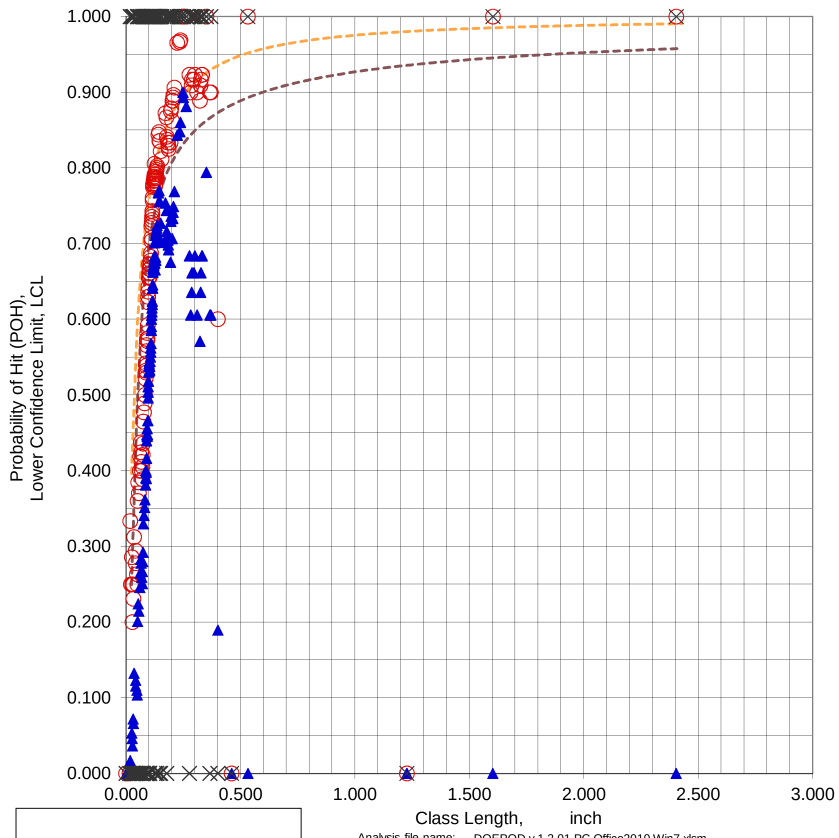
Xpod,Class Length	No. Need

* 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.



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 = **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

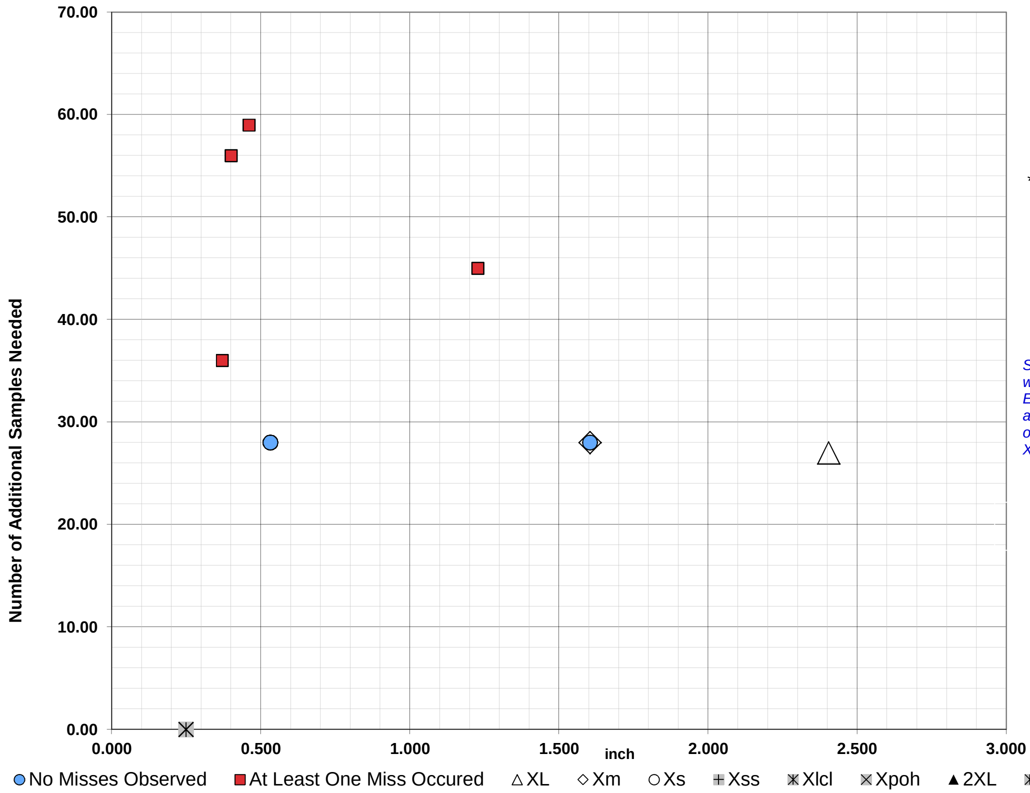


TABLE C

	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.

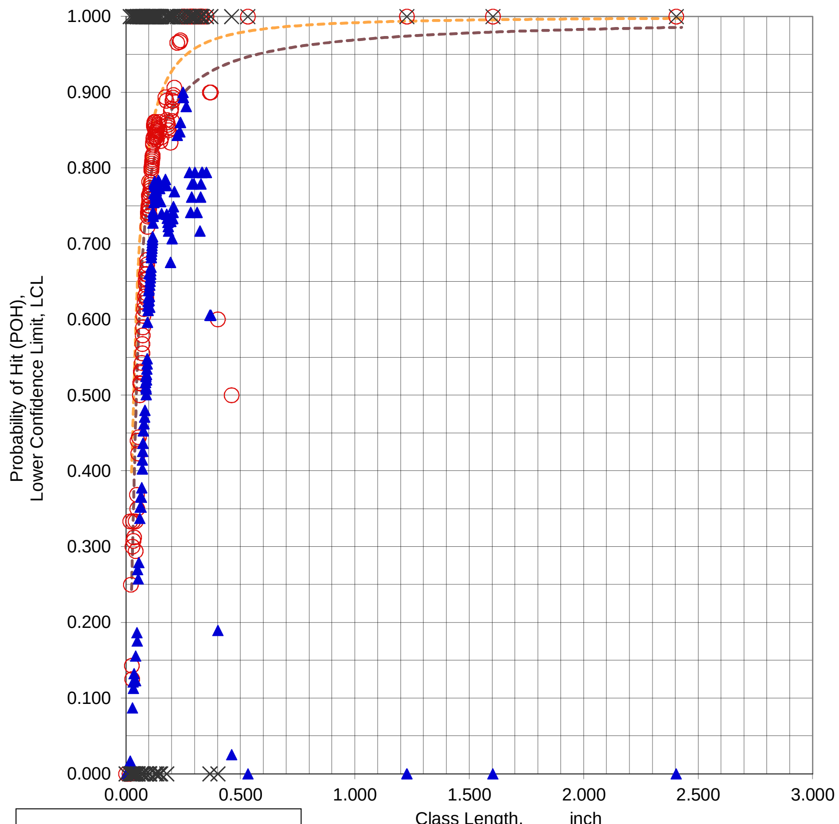
Xpod,Class Length	No. Need
1.6030	28
0.5320	28
0.5320	28
0.5320	28

* 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.



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 =	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

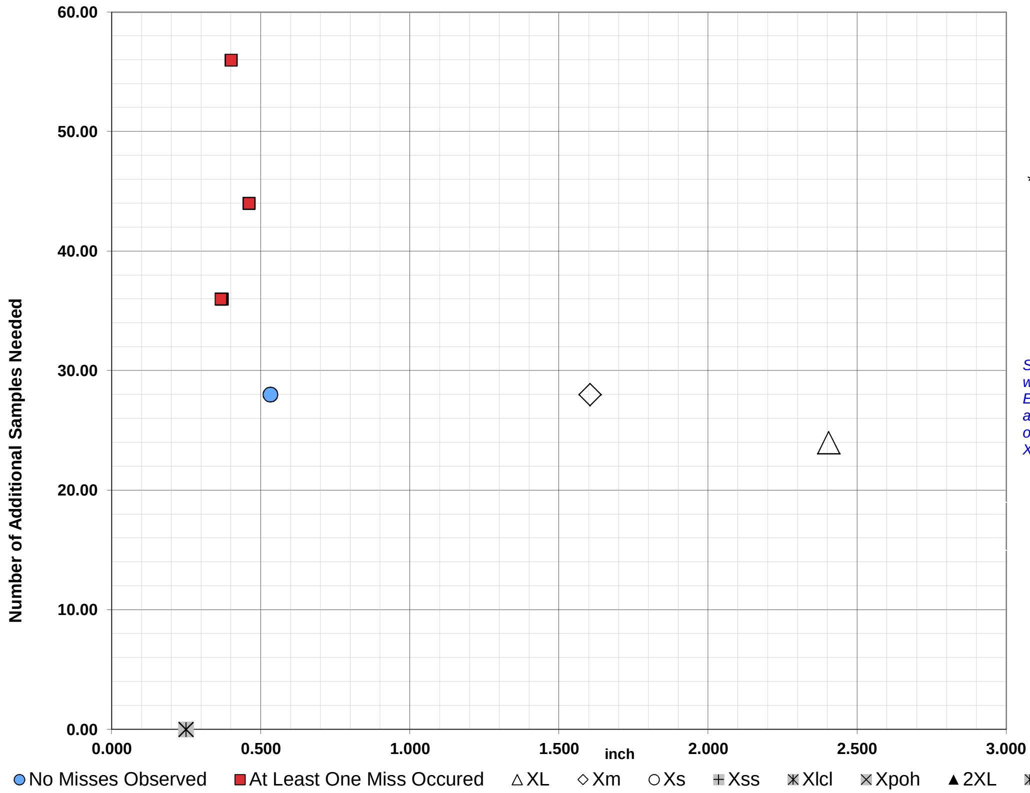


TABLE C

	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

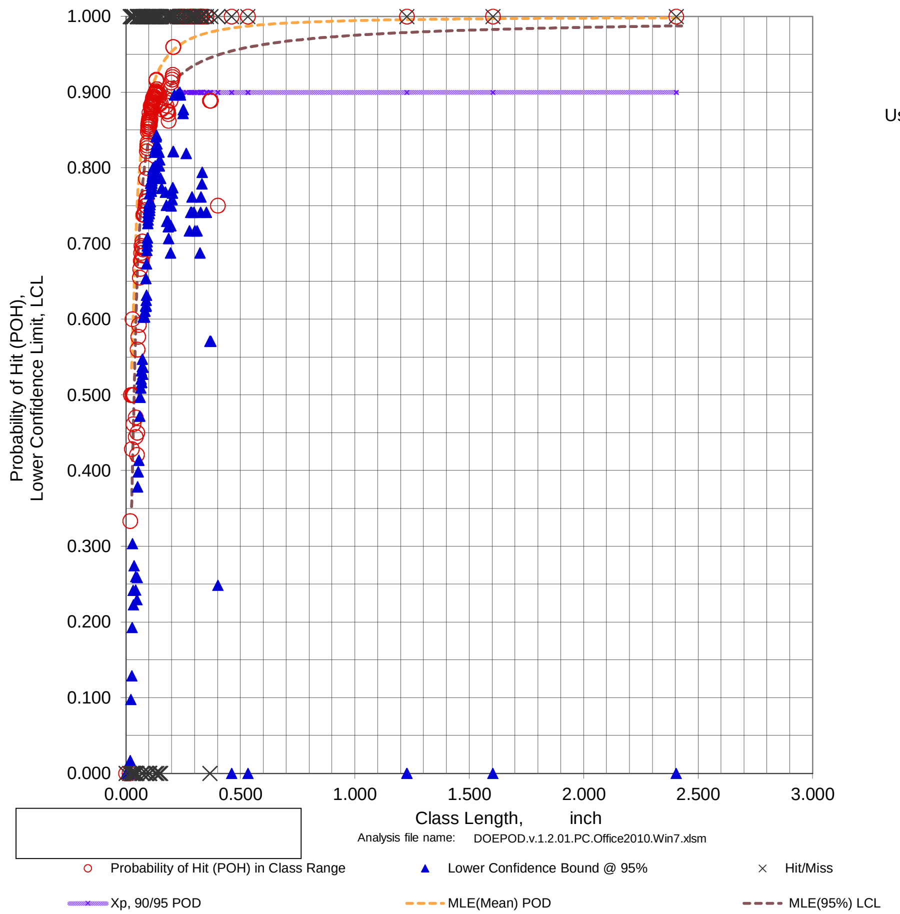
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

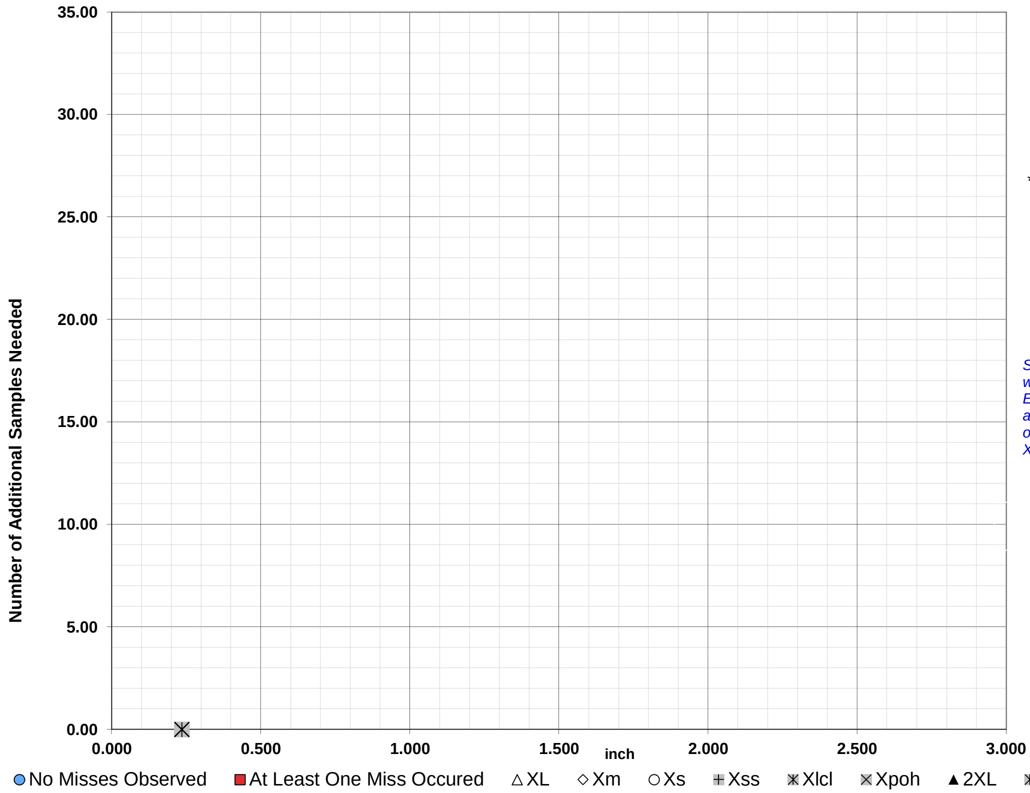


TABLE C

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.

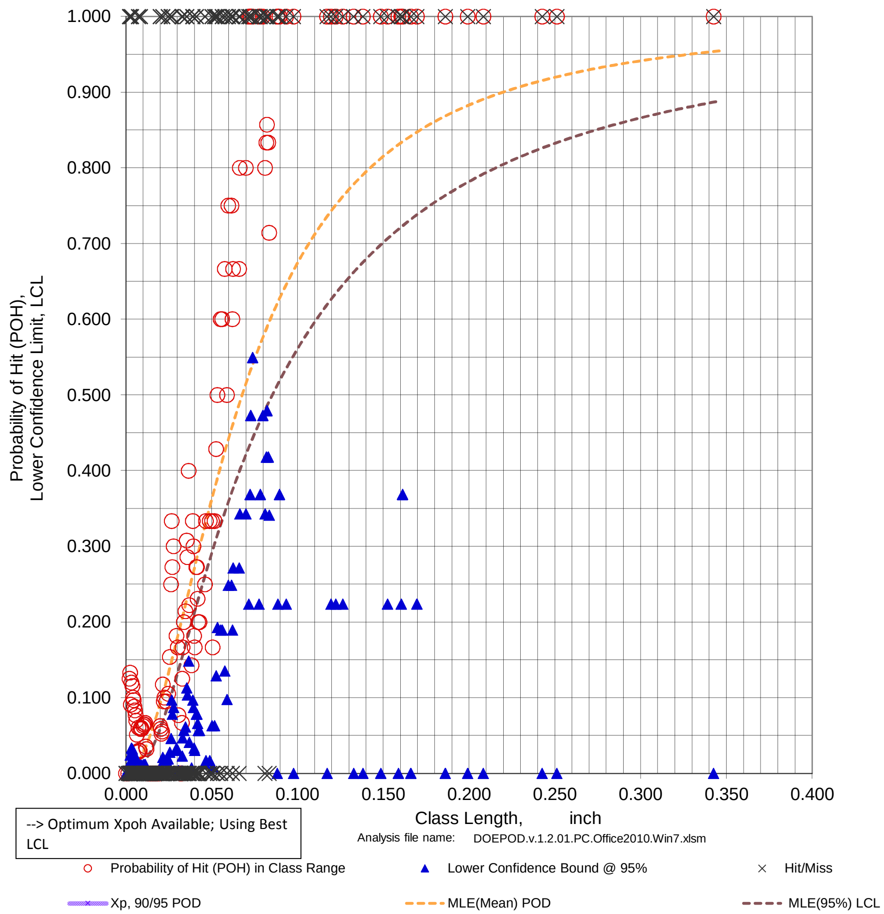
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



File Name = C7001L.XLS
Data Set Name = C7001L(Lpi-a)
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

File Name = C7001L.XLS
Data Set Name = C7001L(Lpi-a)

Directed DOE Options

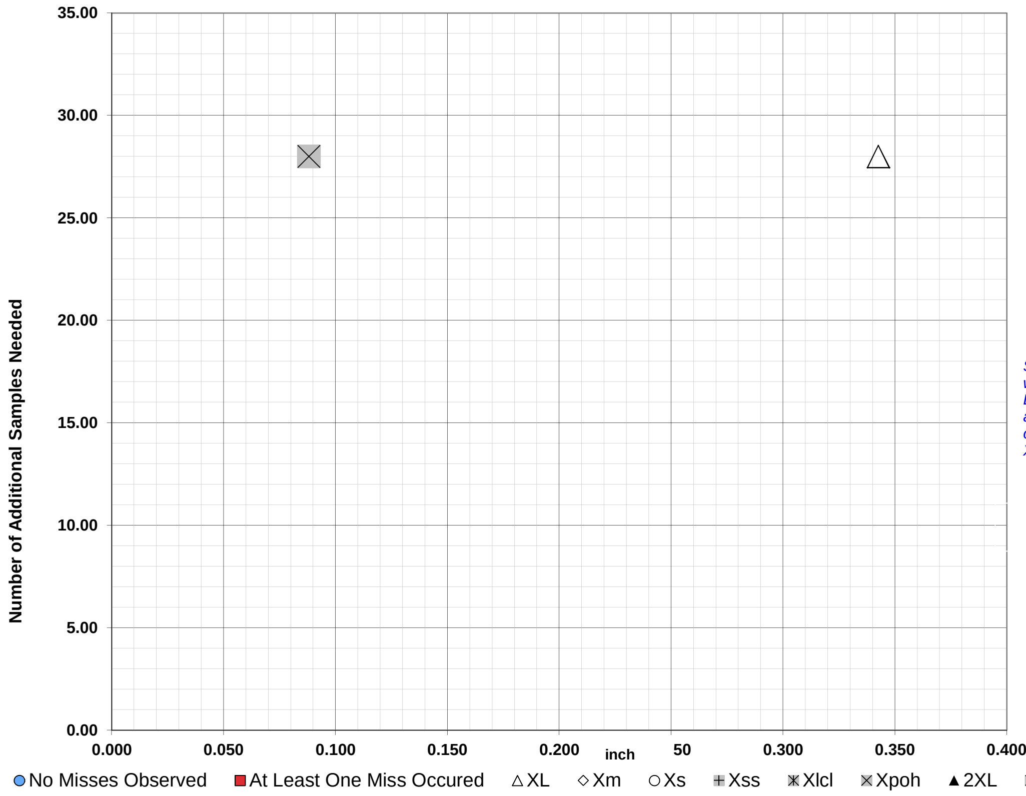


TABLE C

	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.

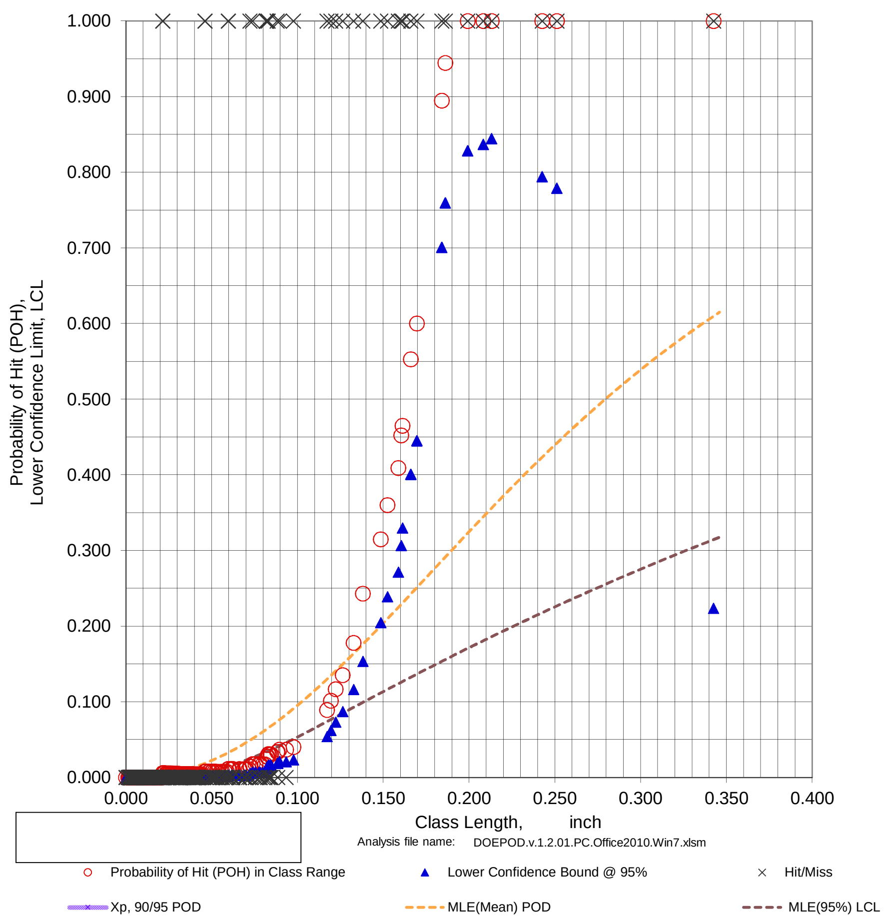
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

File Name = C7002L.XLS
Data Set Name = C7002L(Lpi-a)
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

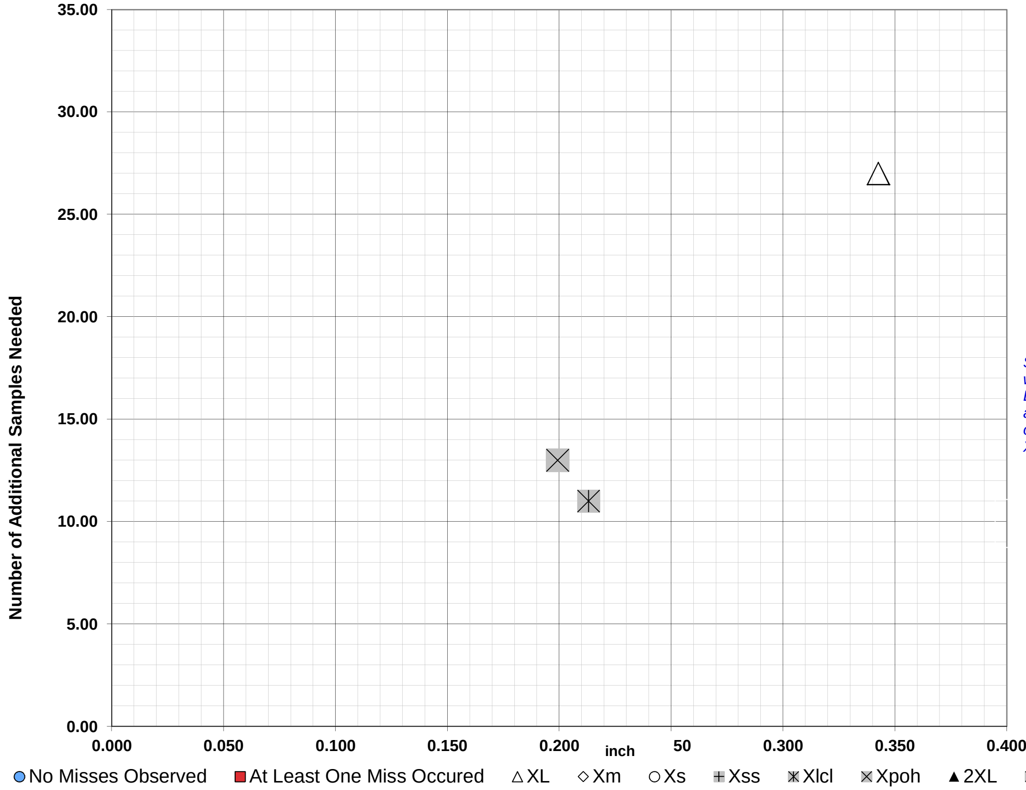


TABLE C

	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.

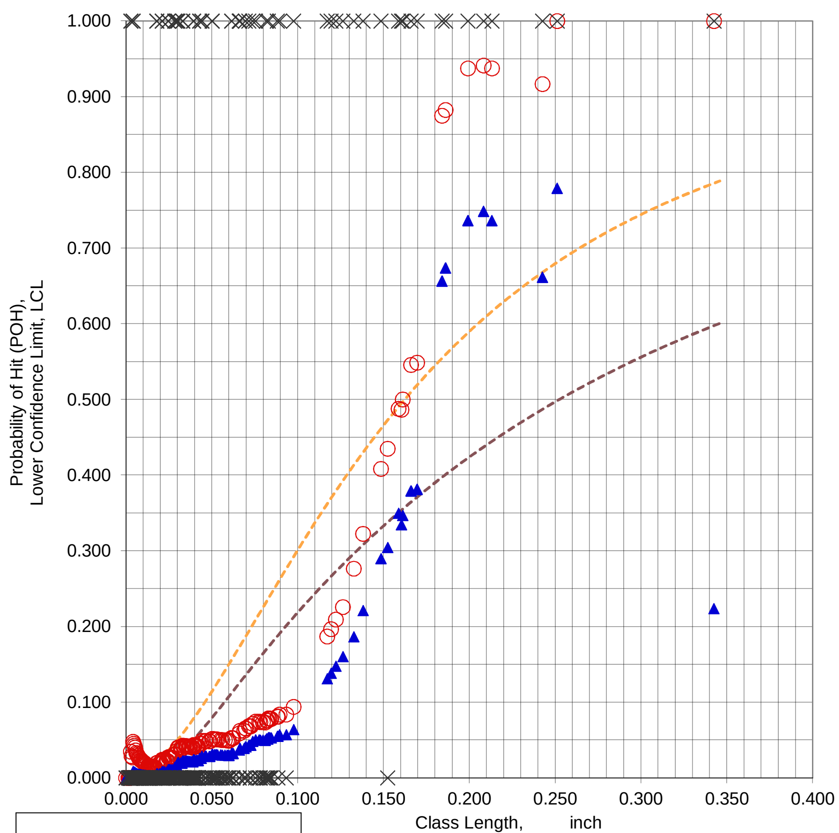
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



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 = C7003L.XLS
Data Set Name = C7003L(Lpi-d)
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

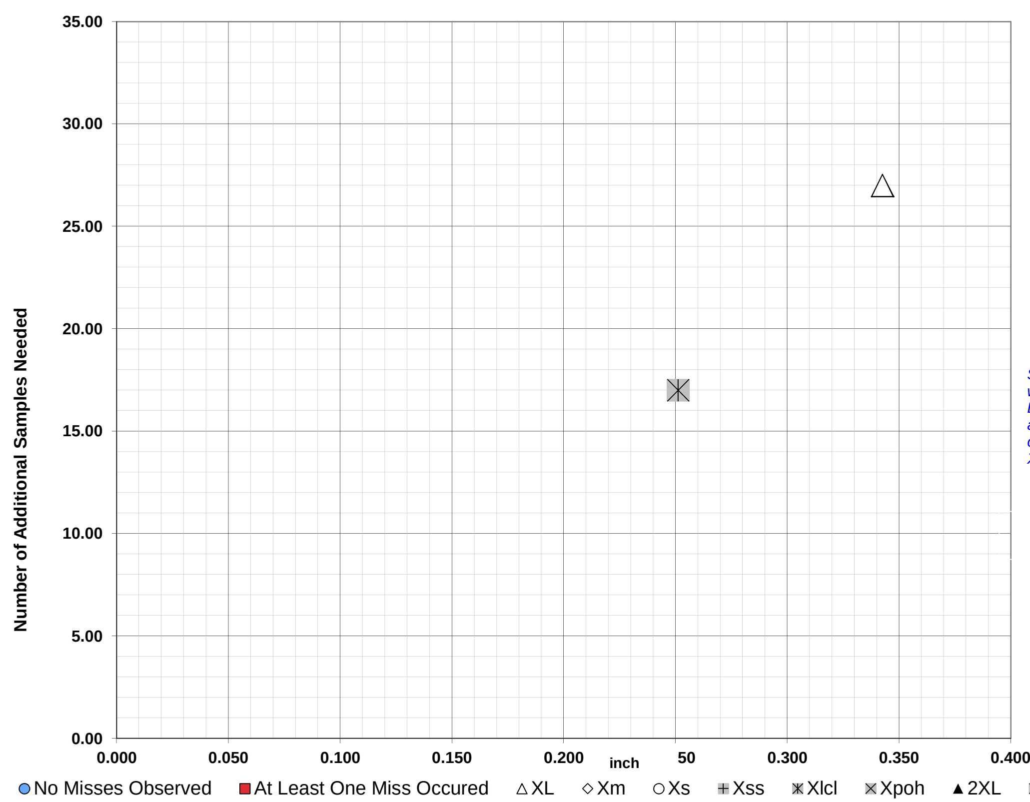


TABLE C

	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*

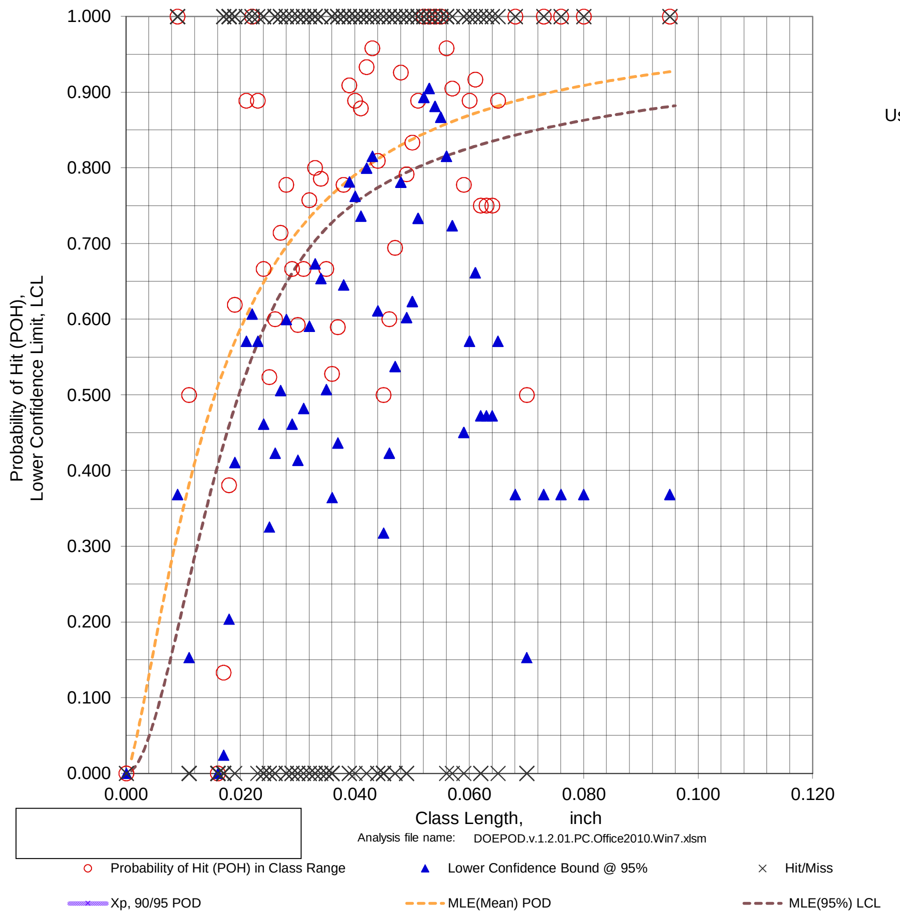
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

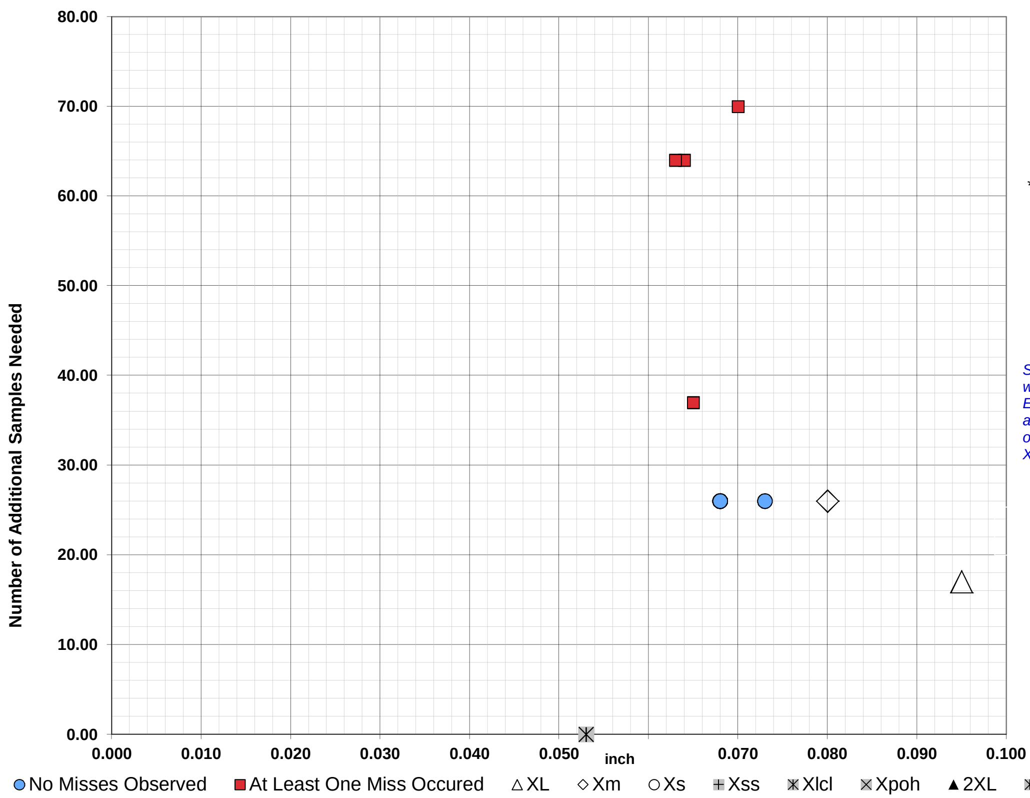


TABLE C

	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.

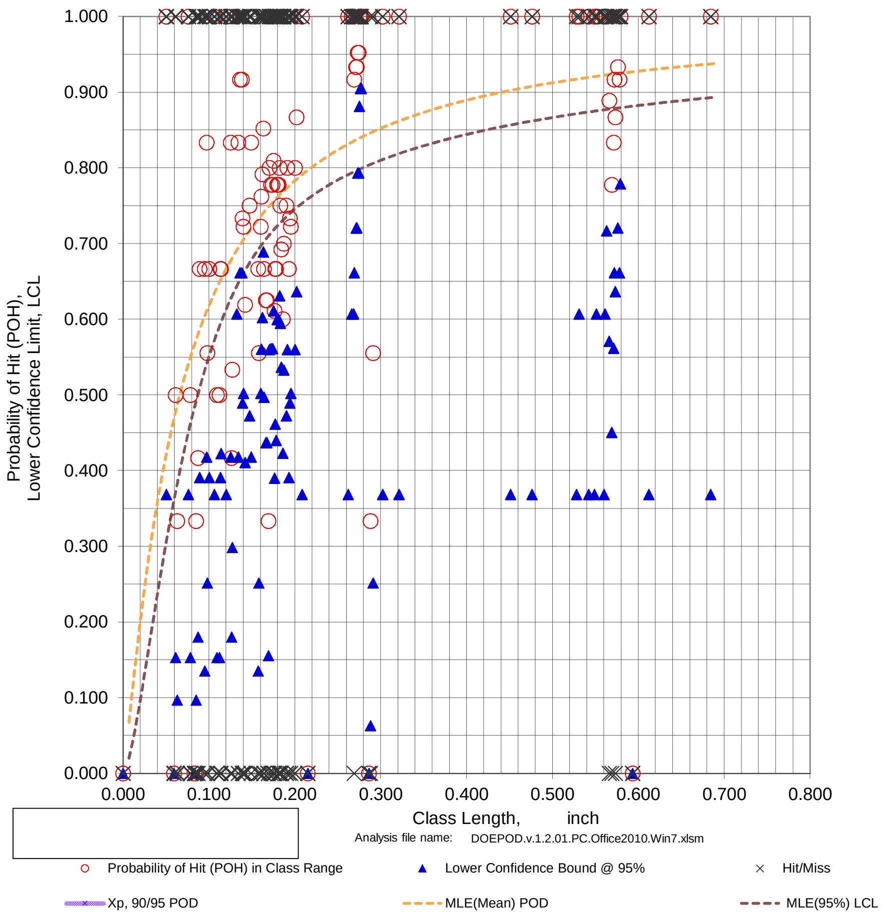
Xpod,Class Length	No. Need
0.0730	26
0.0680	26
0.0680	26
0.0680	26

* 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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

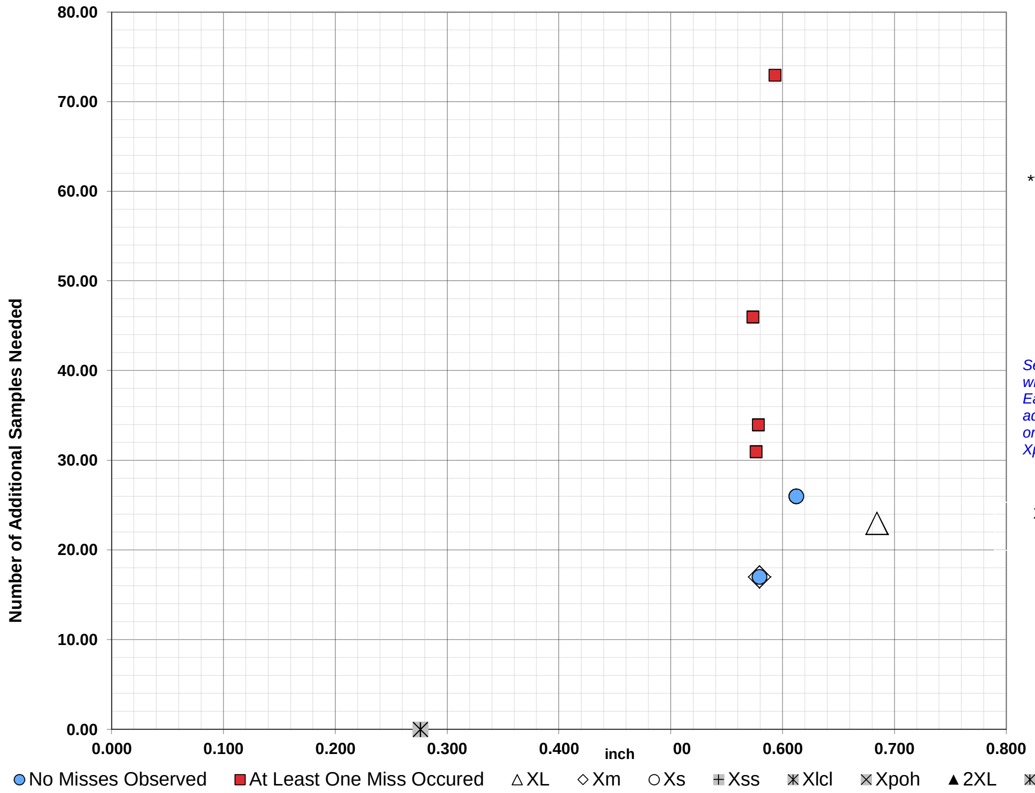


TABLE C

	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*

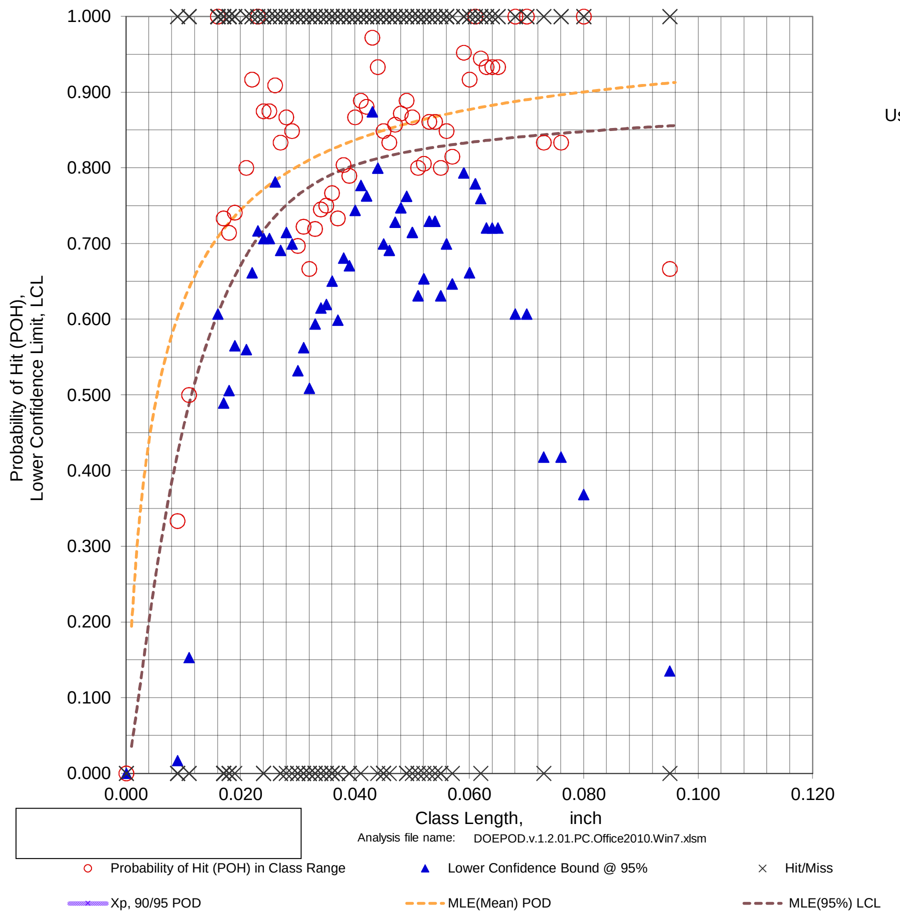
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

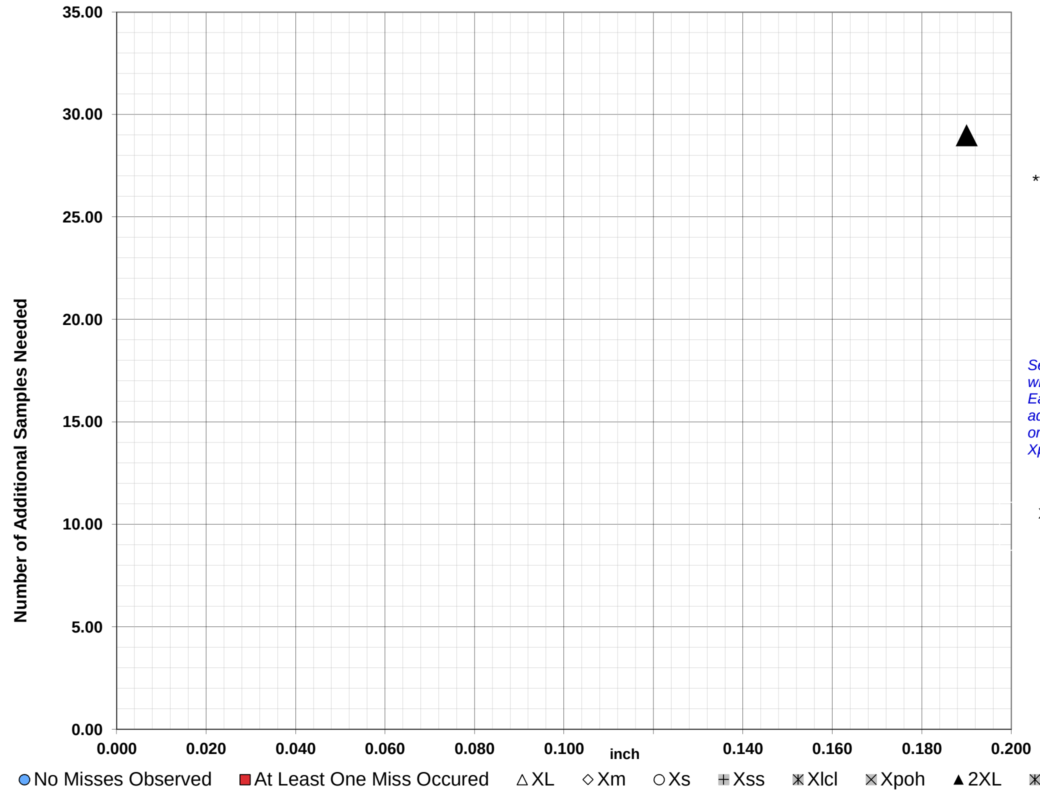


TABLE C

	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.

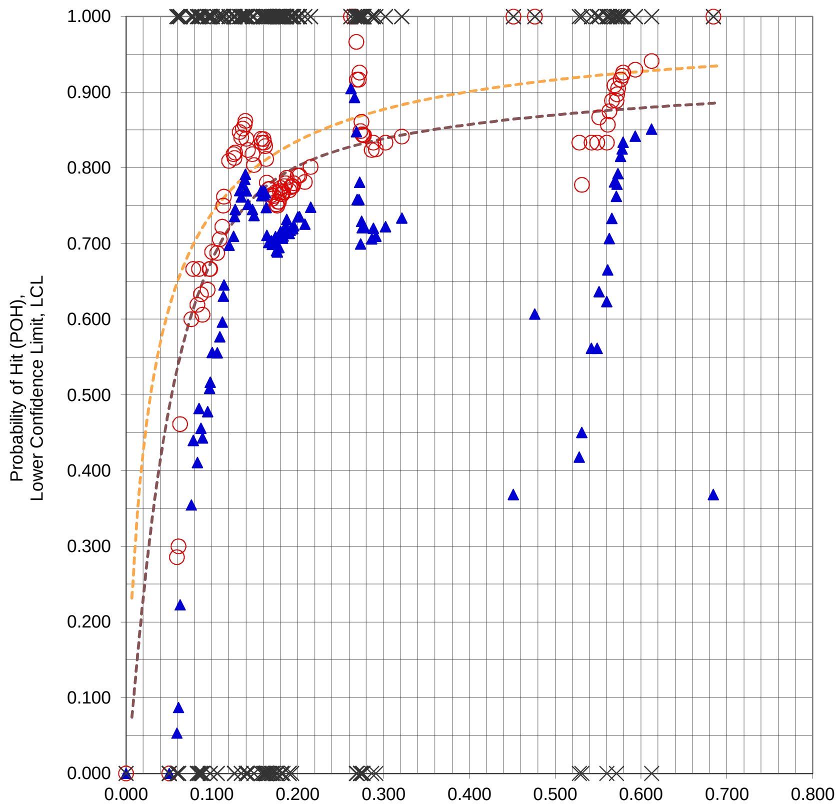
Xpod,Class Length	No. Need

* 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.



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 = **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

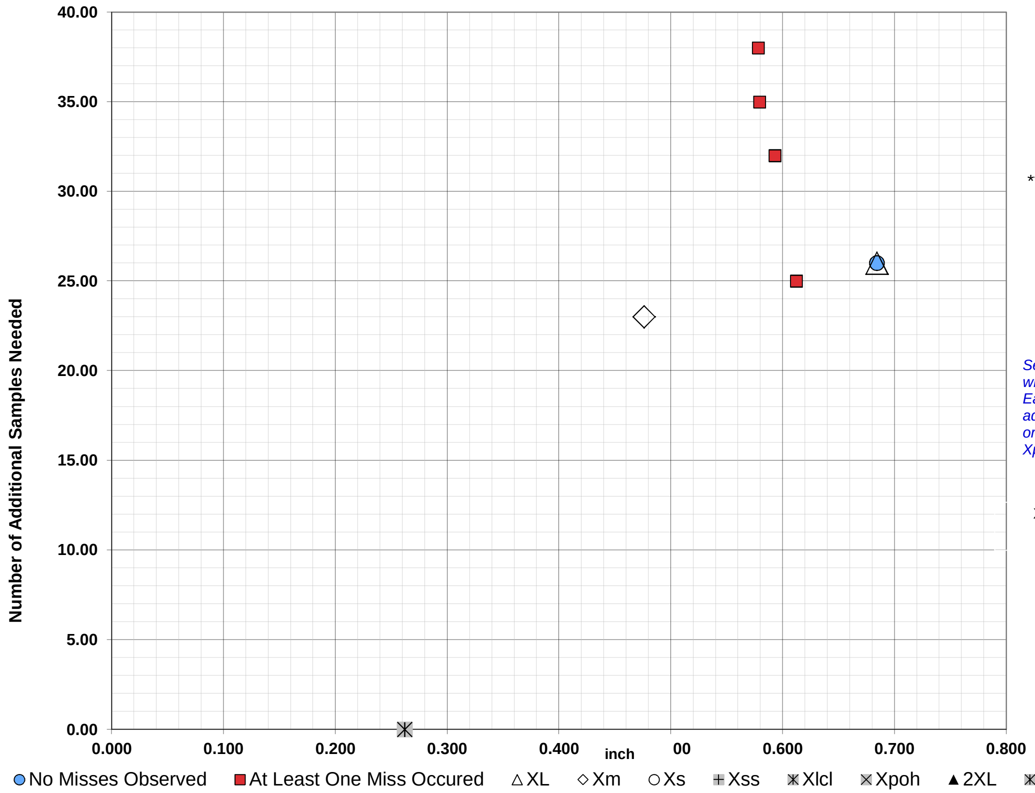


TABLE C

	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

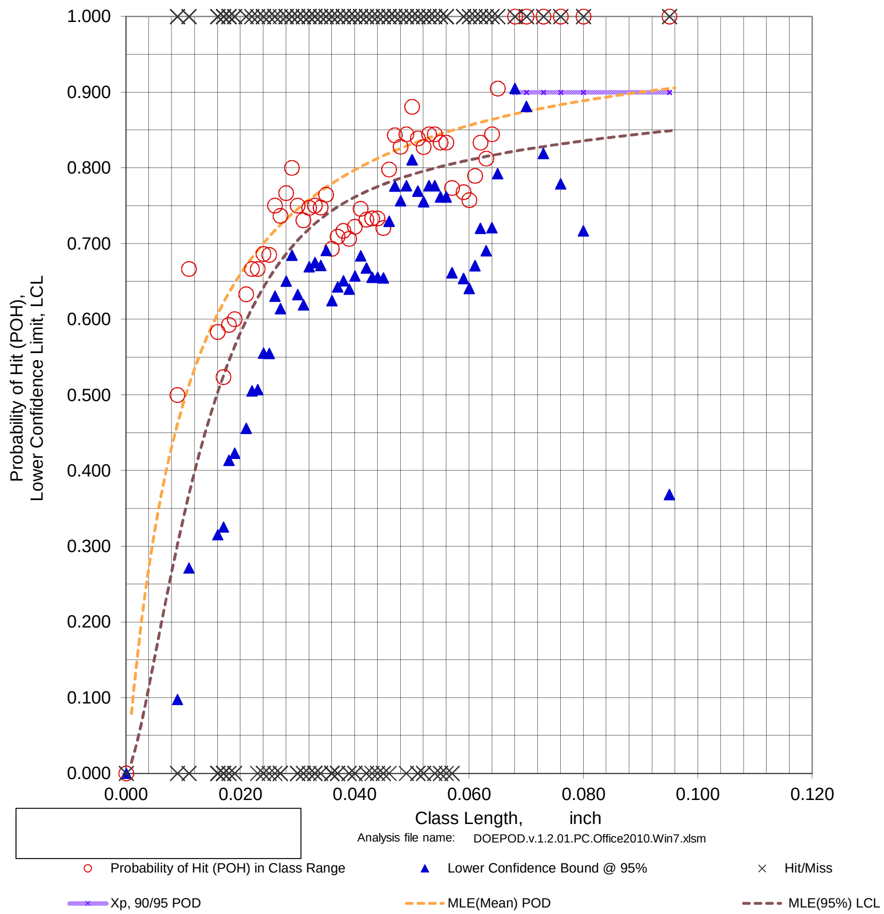
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

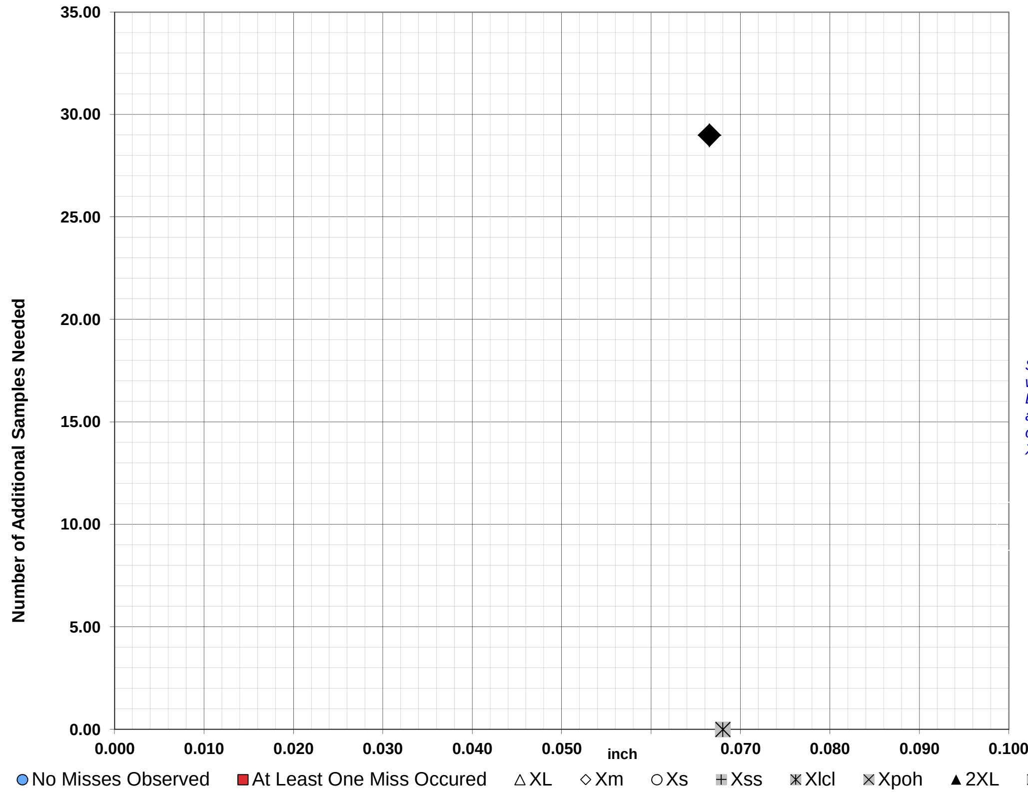


TABLE C

	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.

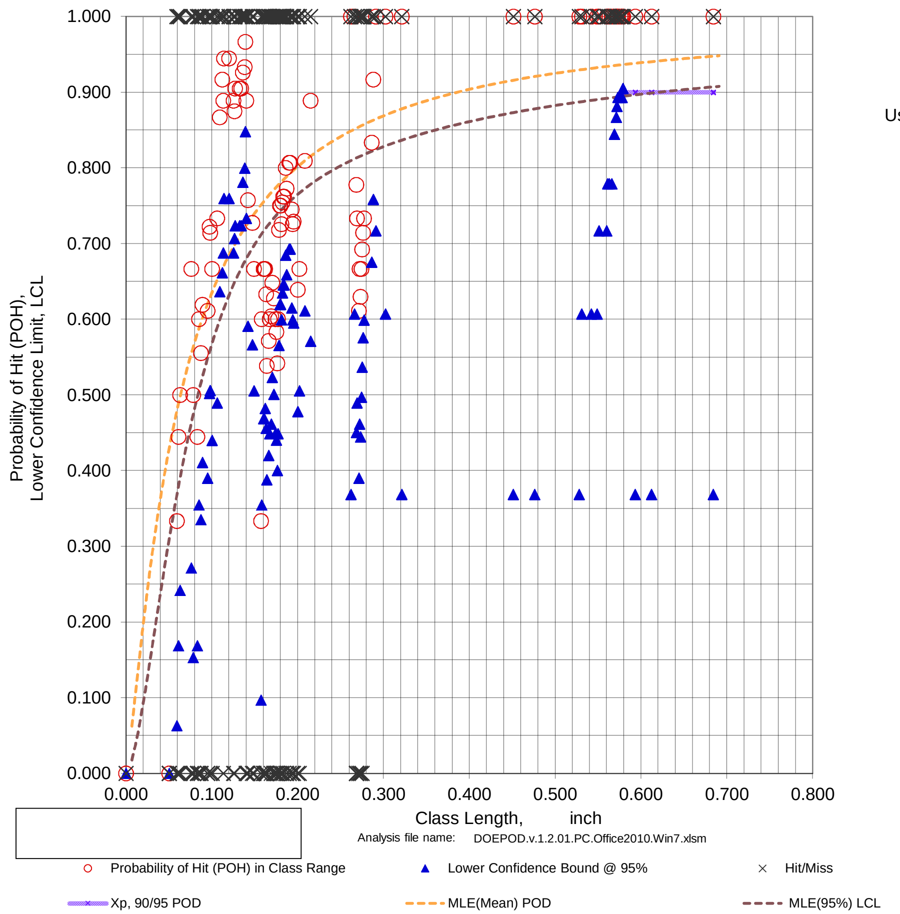
Xpod,Class Length	No. Need

* 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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

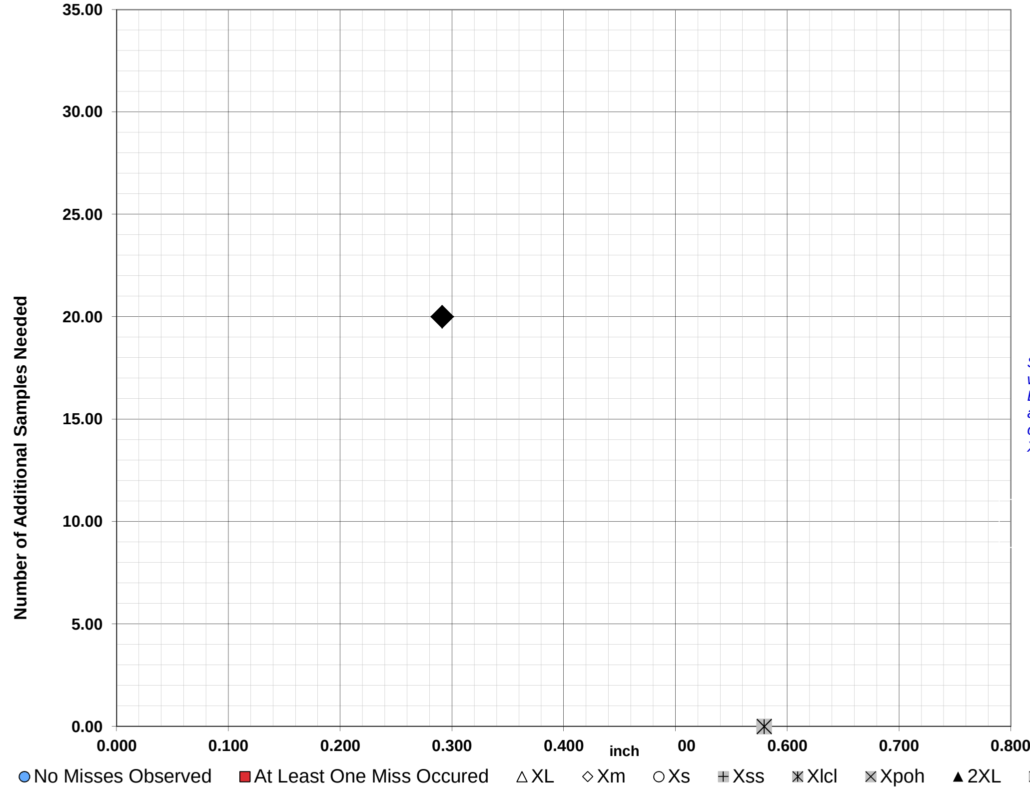


TABLE C

	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.

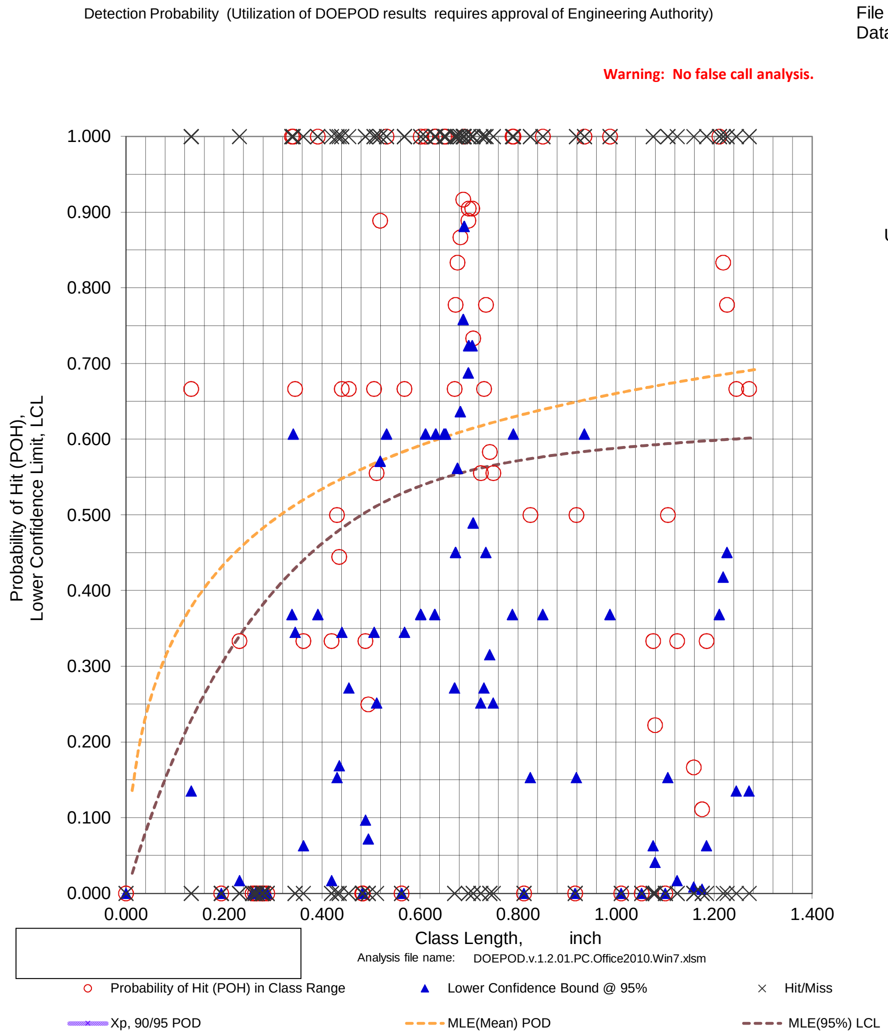
Xpod,Class Length	No. Need

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



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

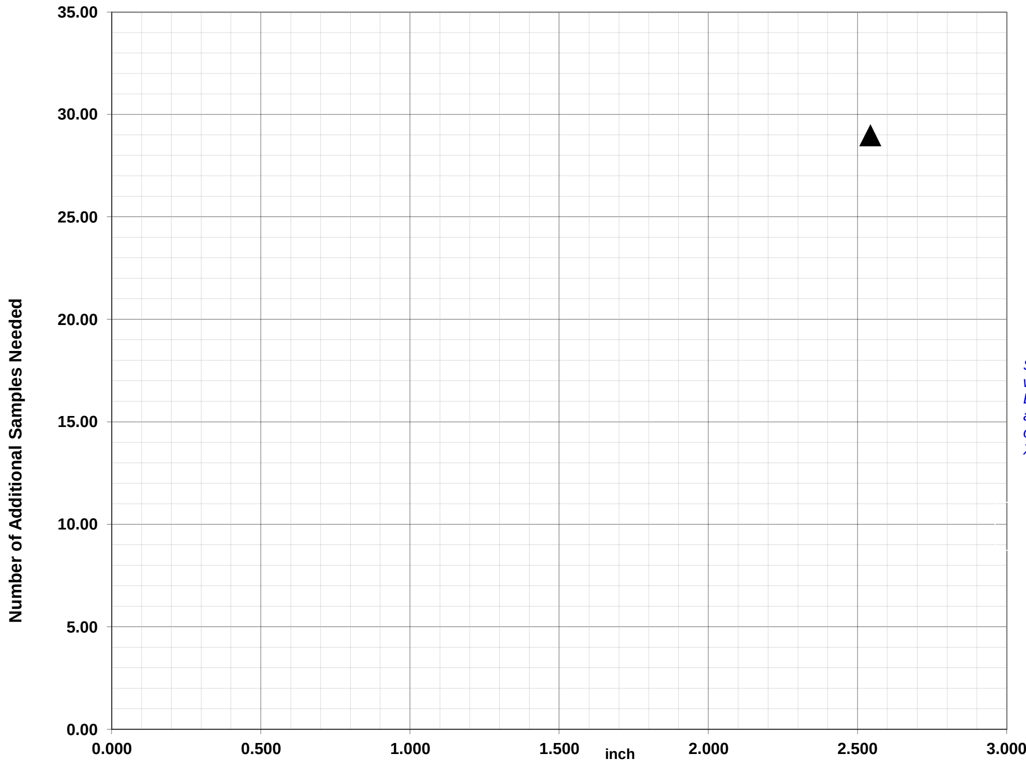


TABLE C

	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*

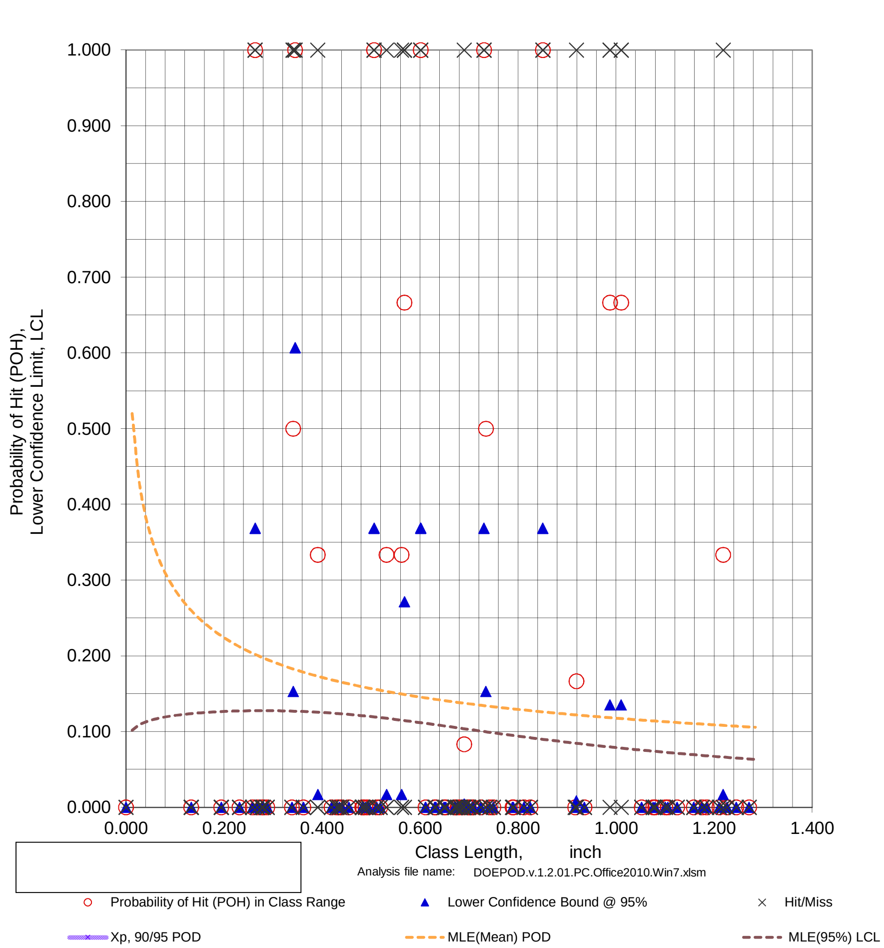
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

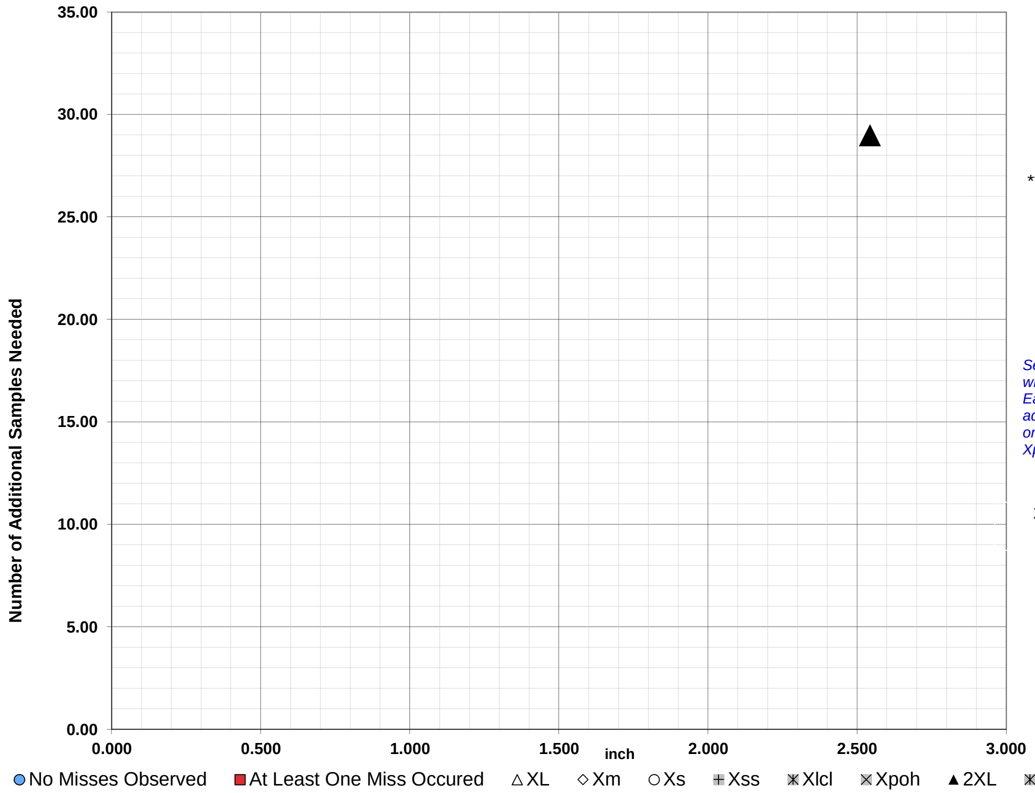


TABLE C

	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*

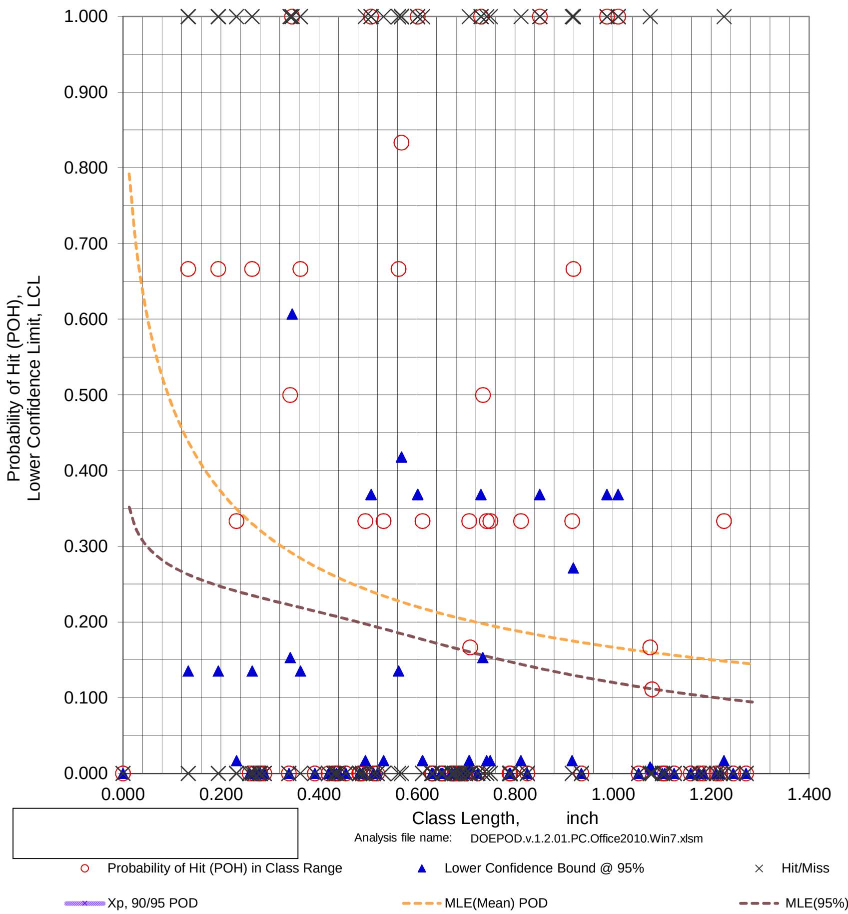
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

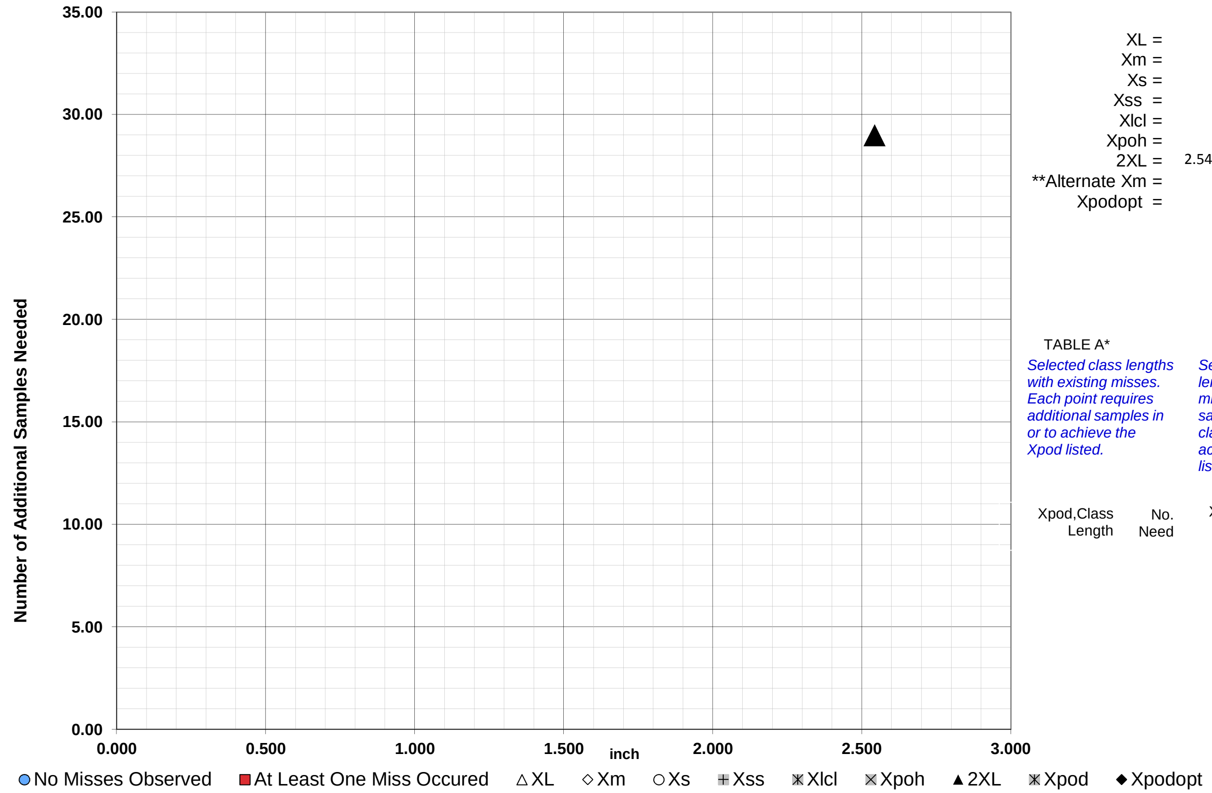


TABLE C

	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*

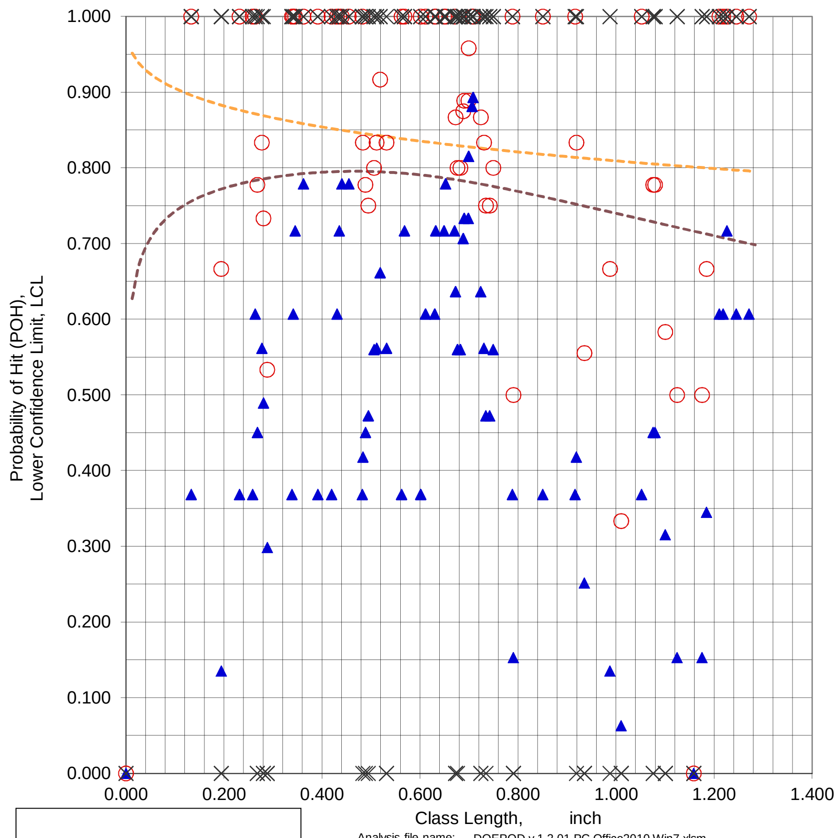
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = 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

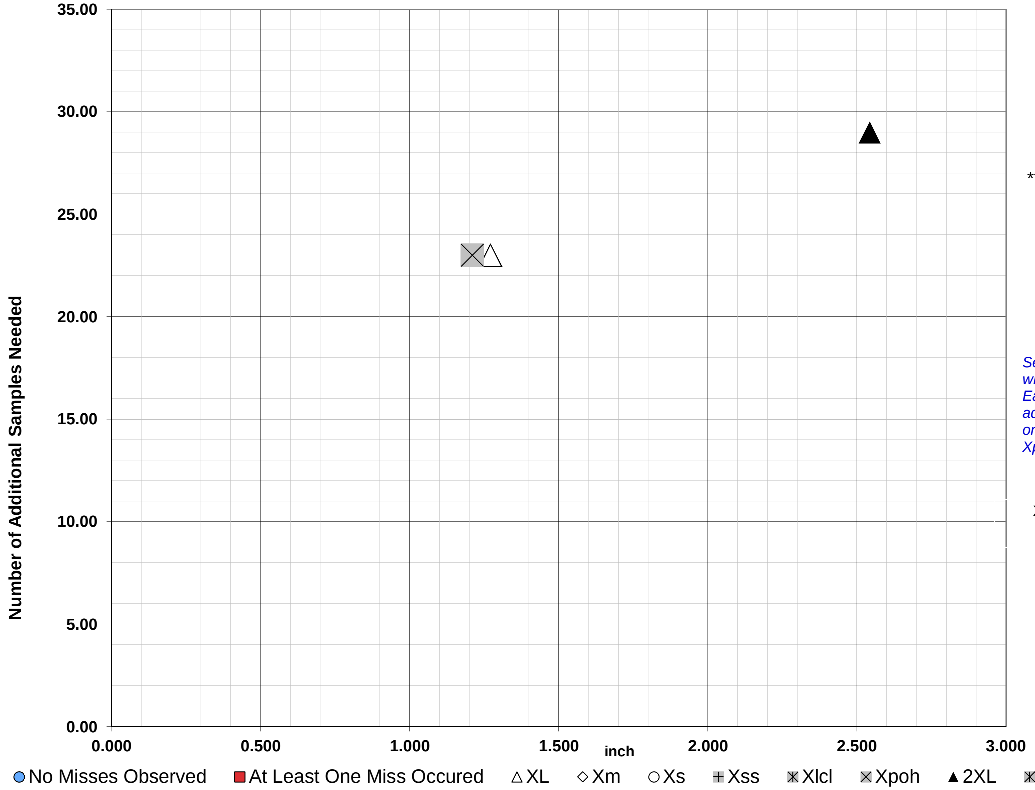


TABLE C

	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.

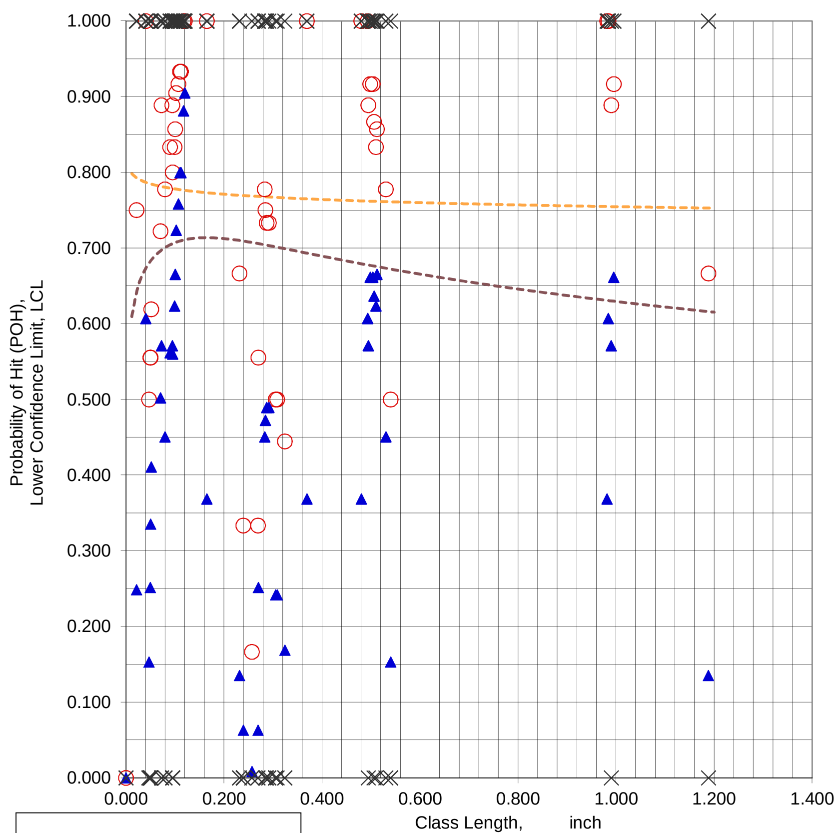
Xpod,Class Length	No. Need

* 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.



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 =	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

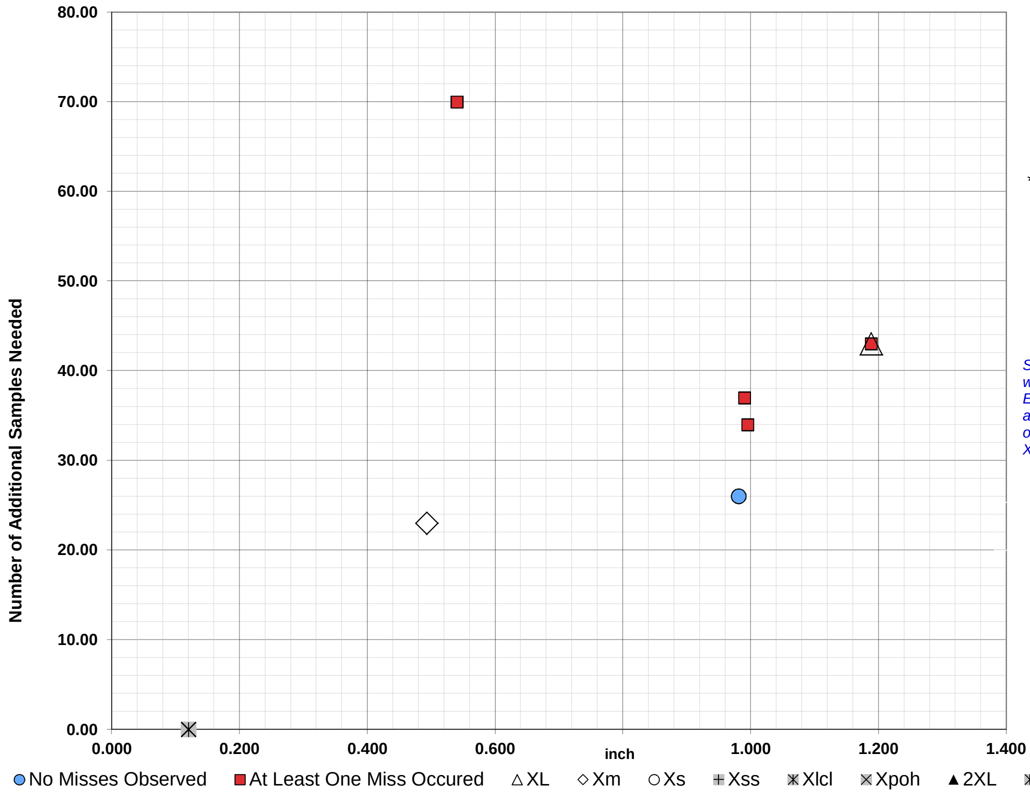


TABLE C

	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*

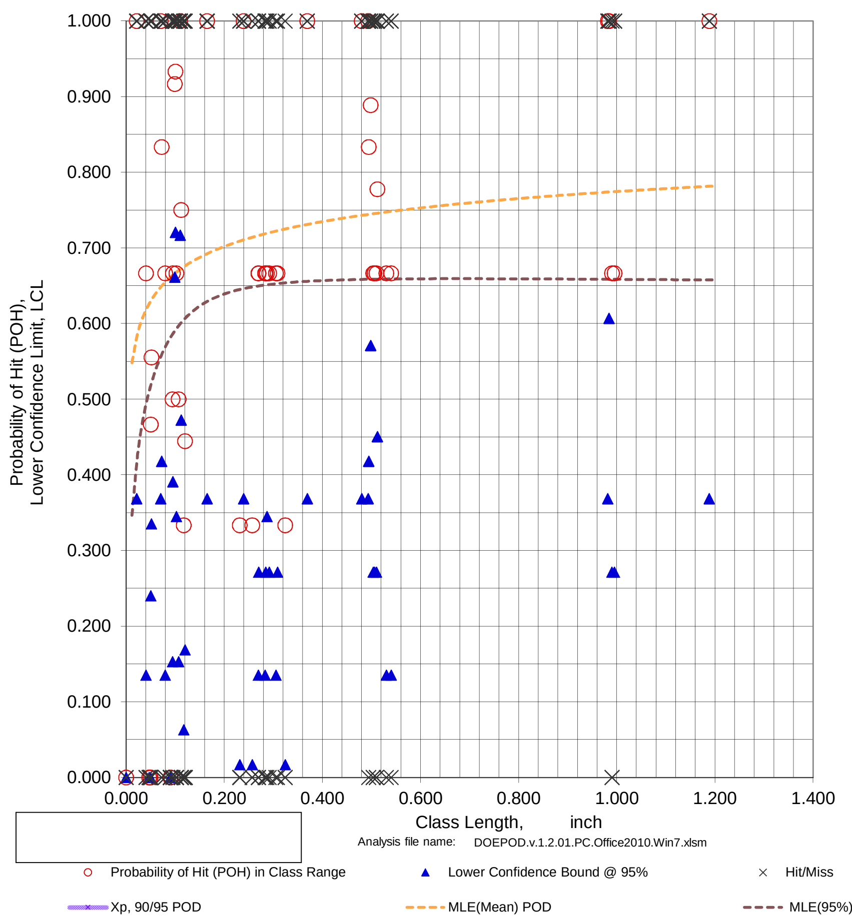
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

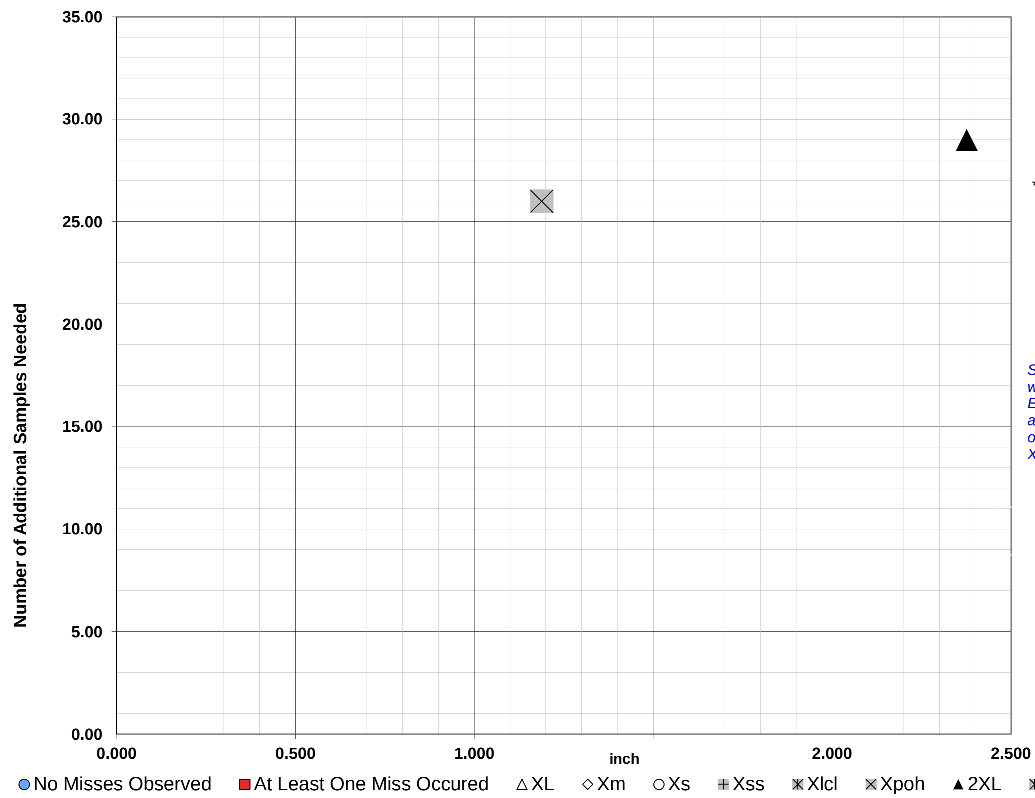


TABLE C

	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

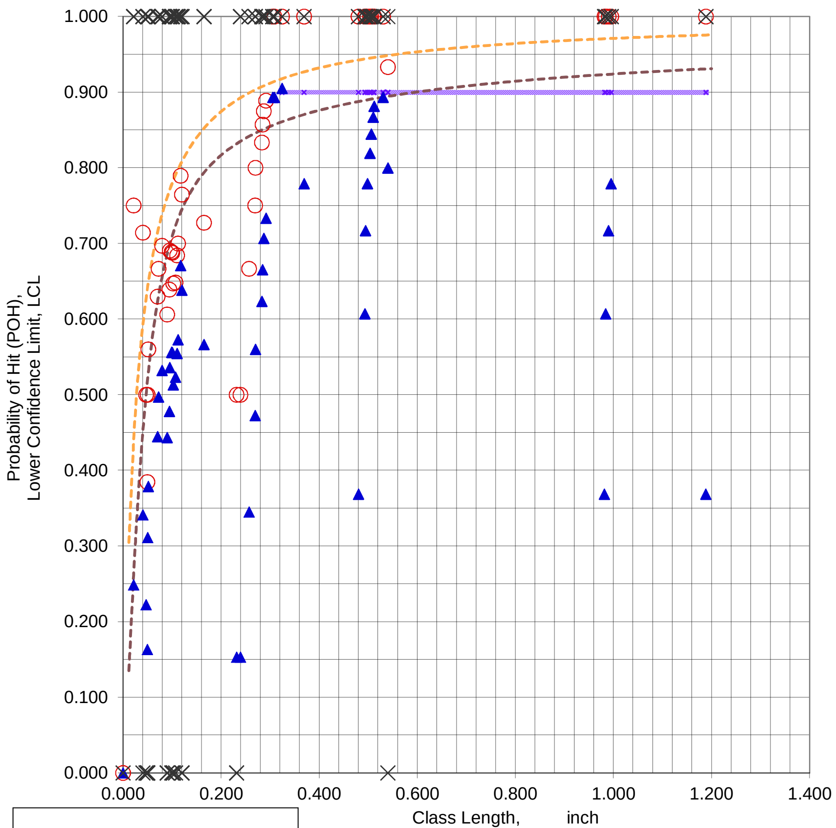
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

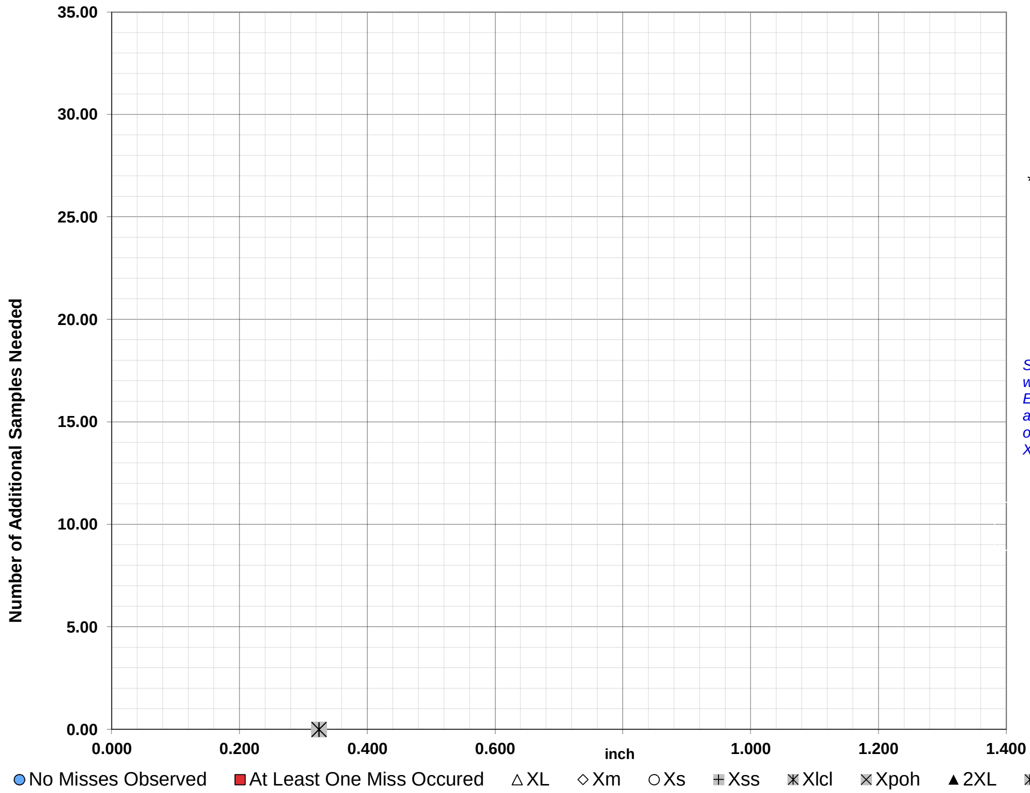


TABLE C

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

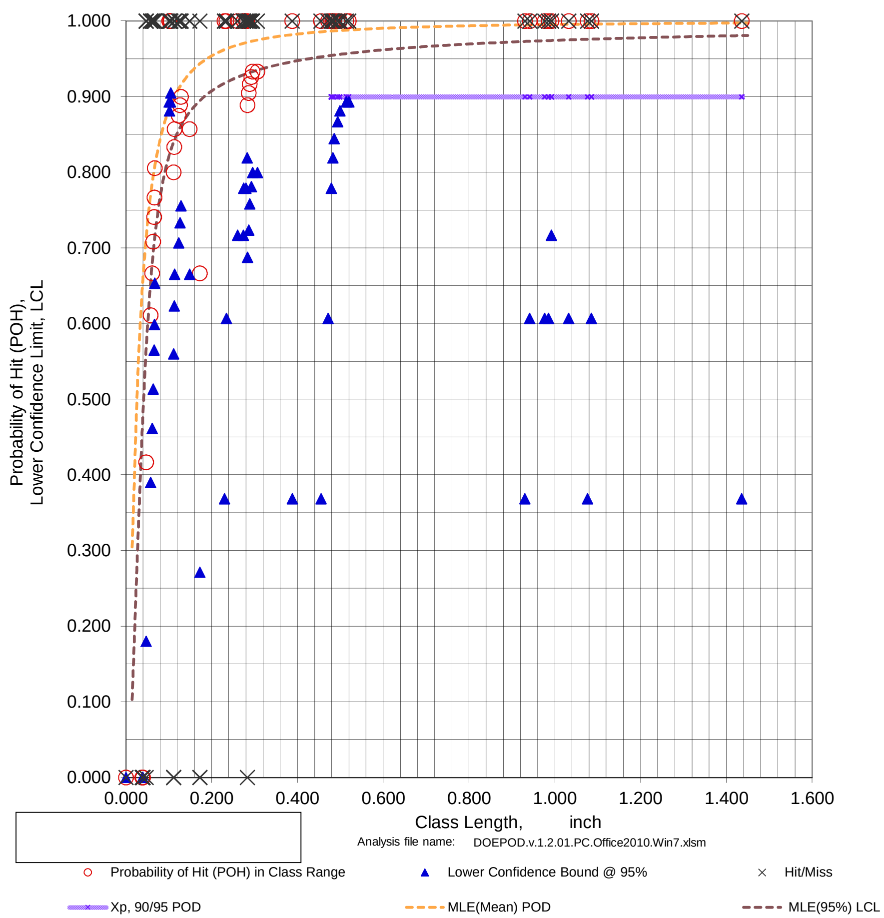
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

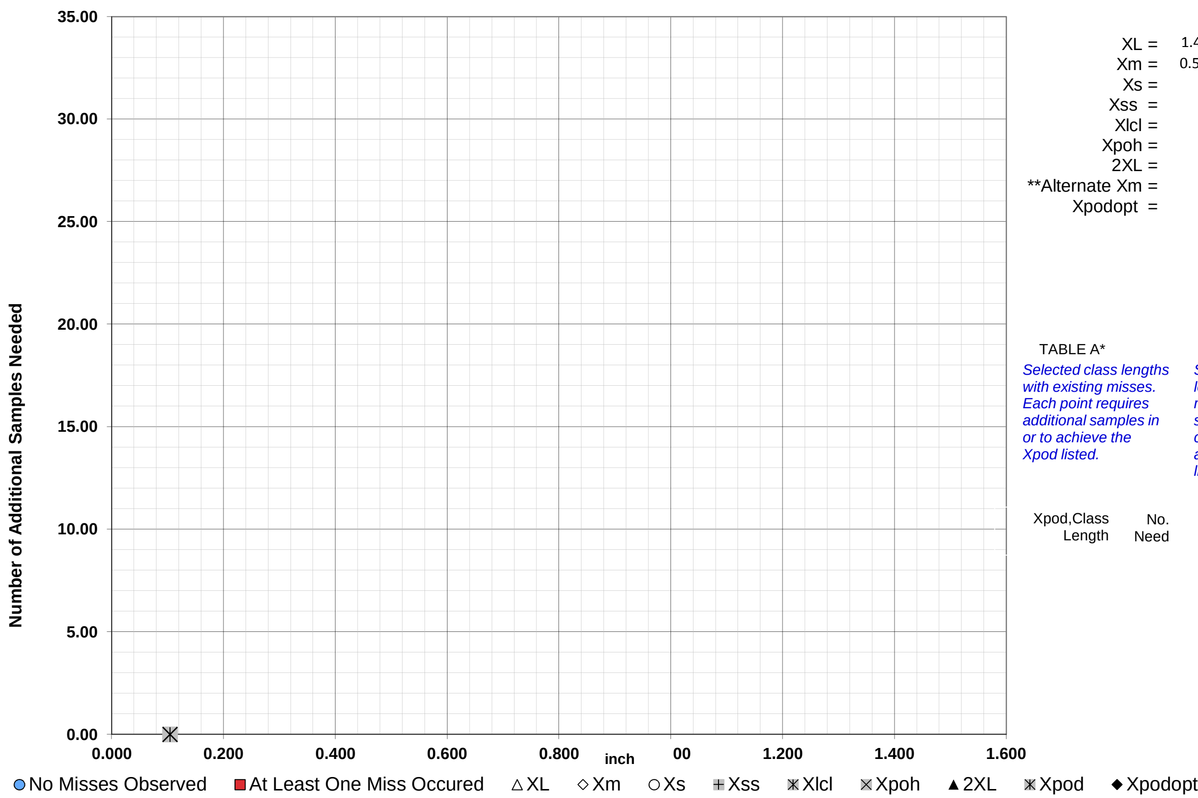


TABLE C

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

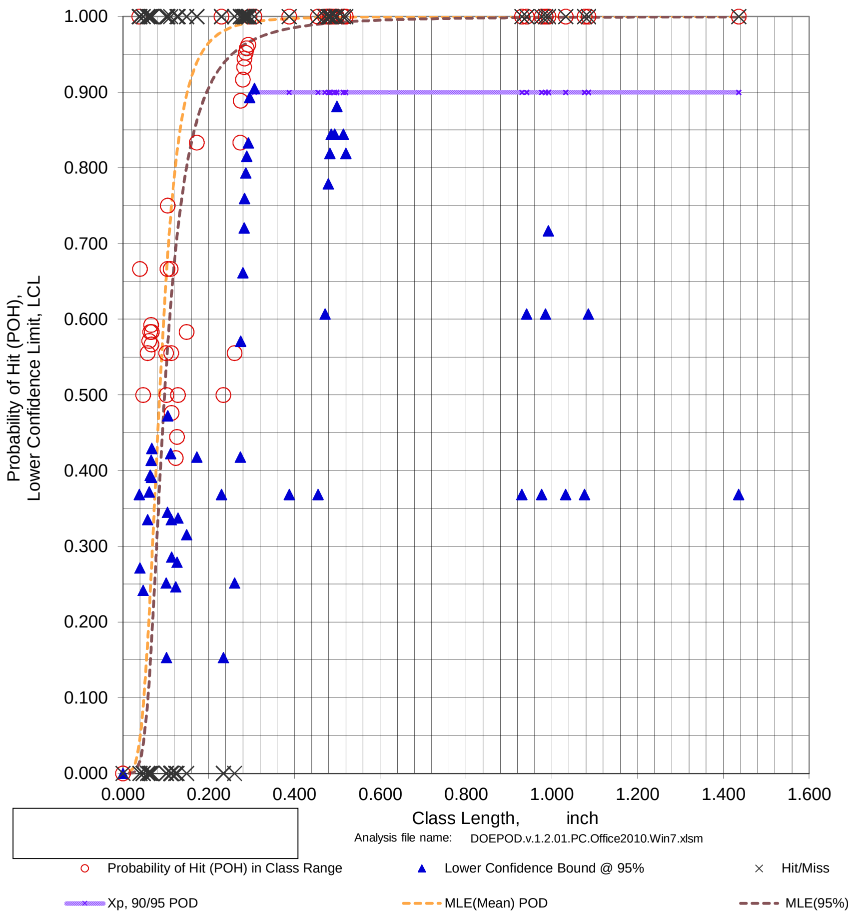
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

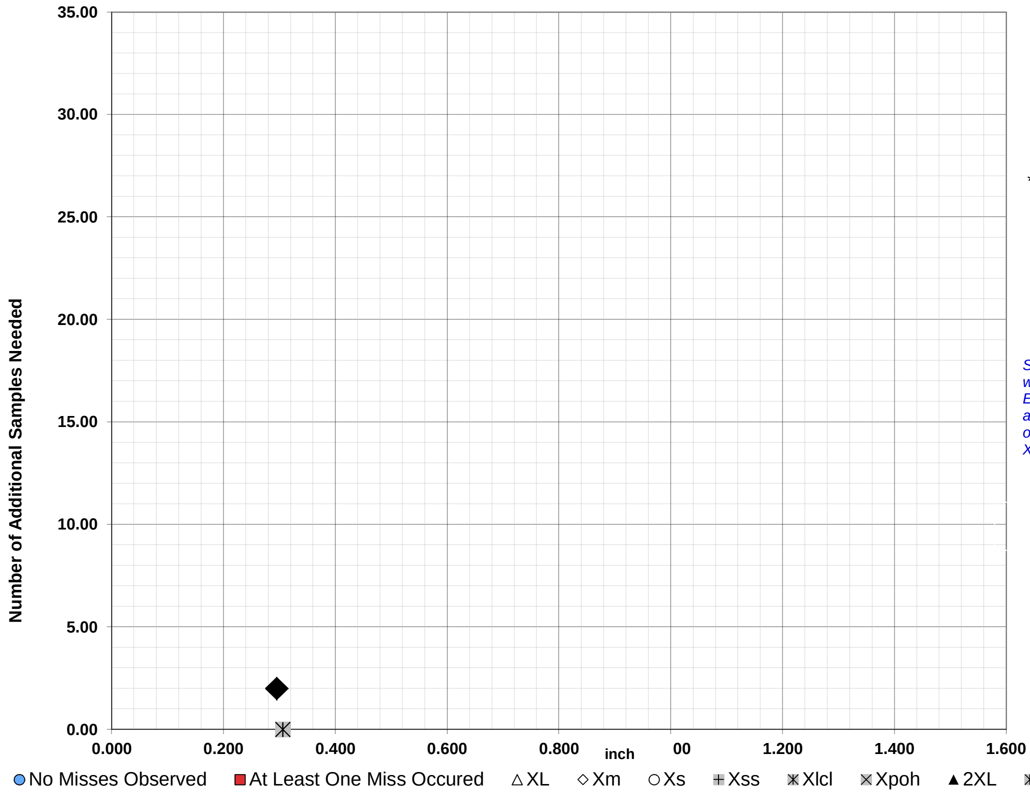


TABLE C

	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

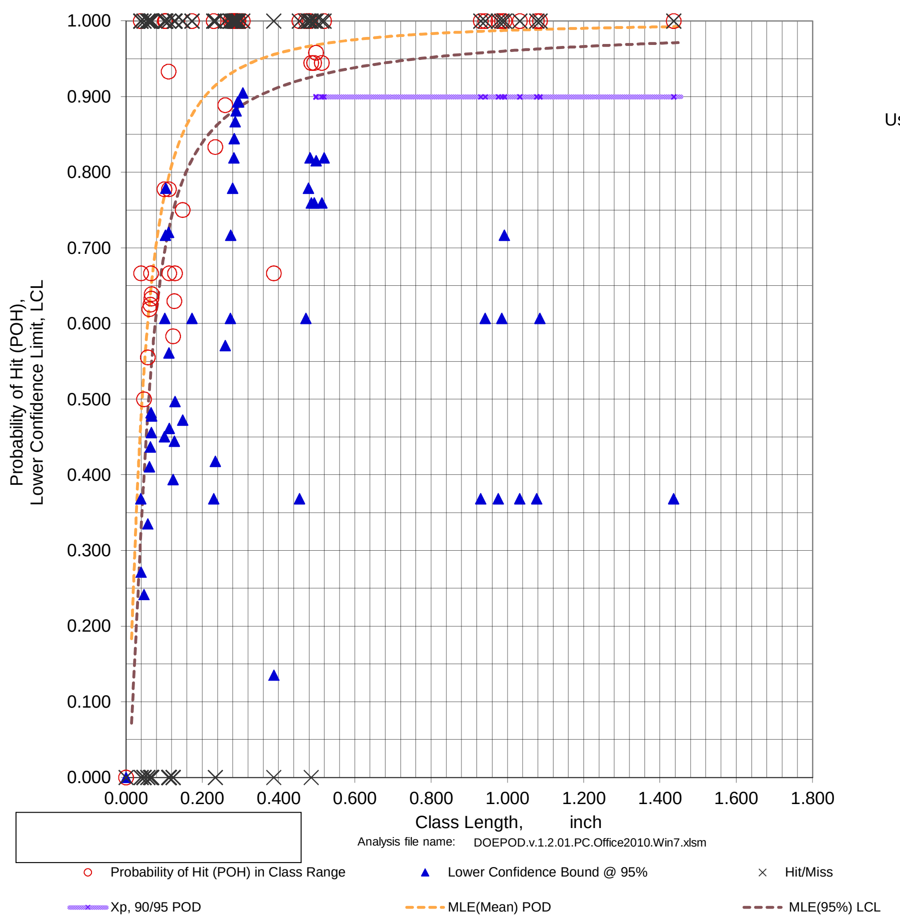
TABLE B*

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

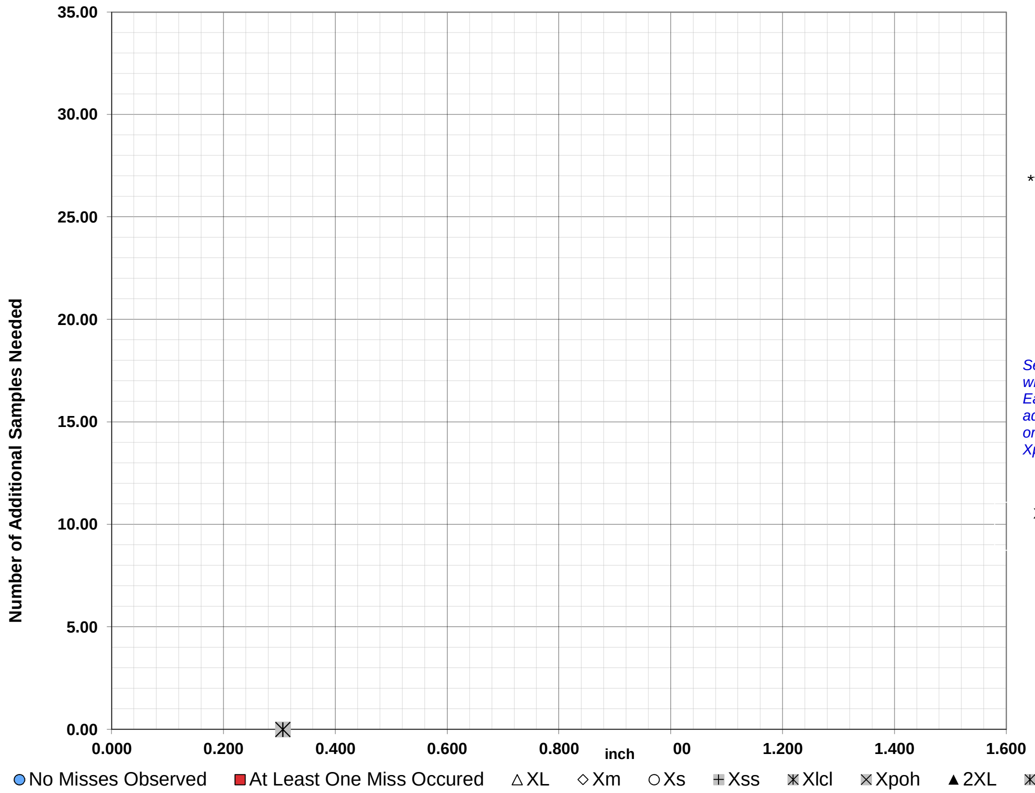


TABLE C

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.

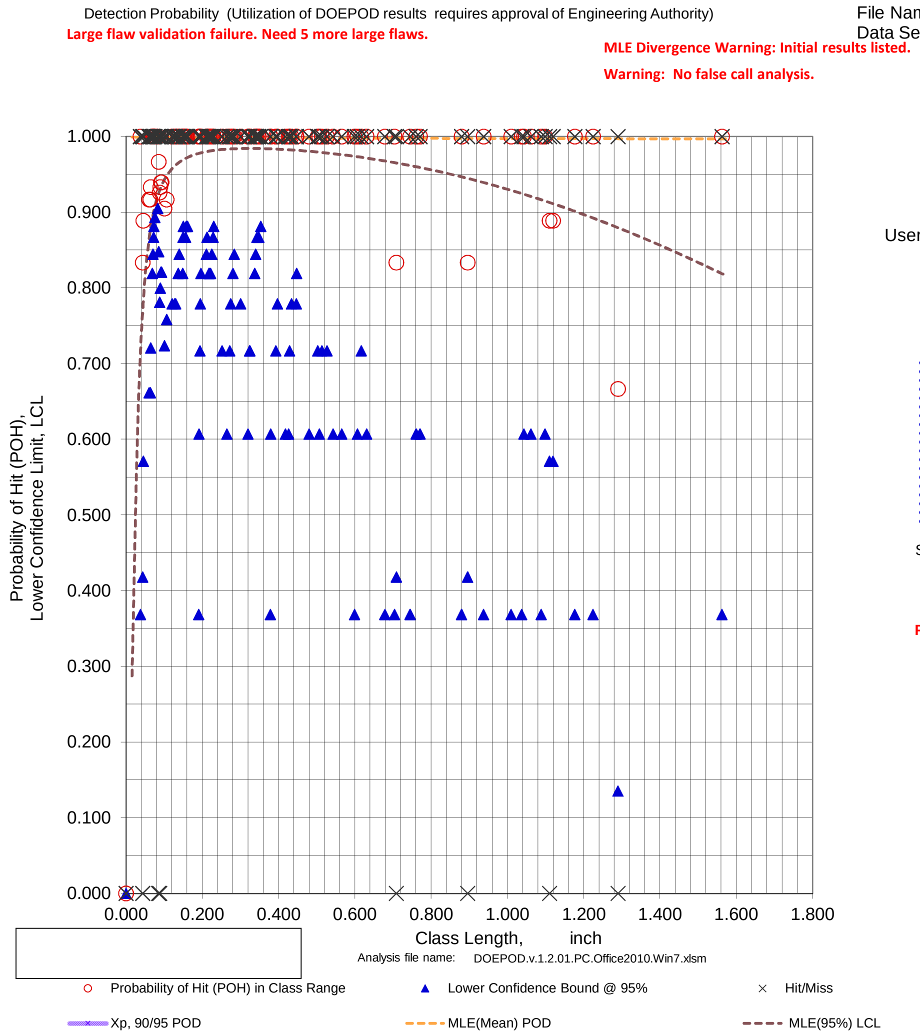
Xpod,Class Length	No. Need

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



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

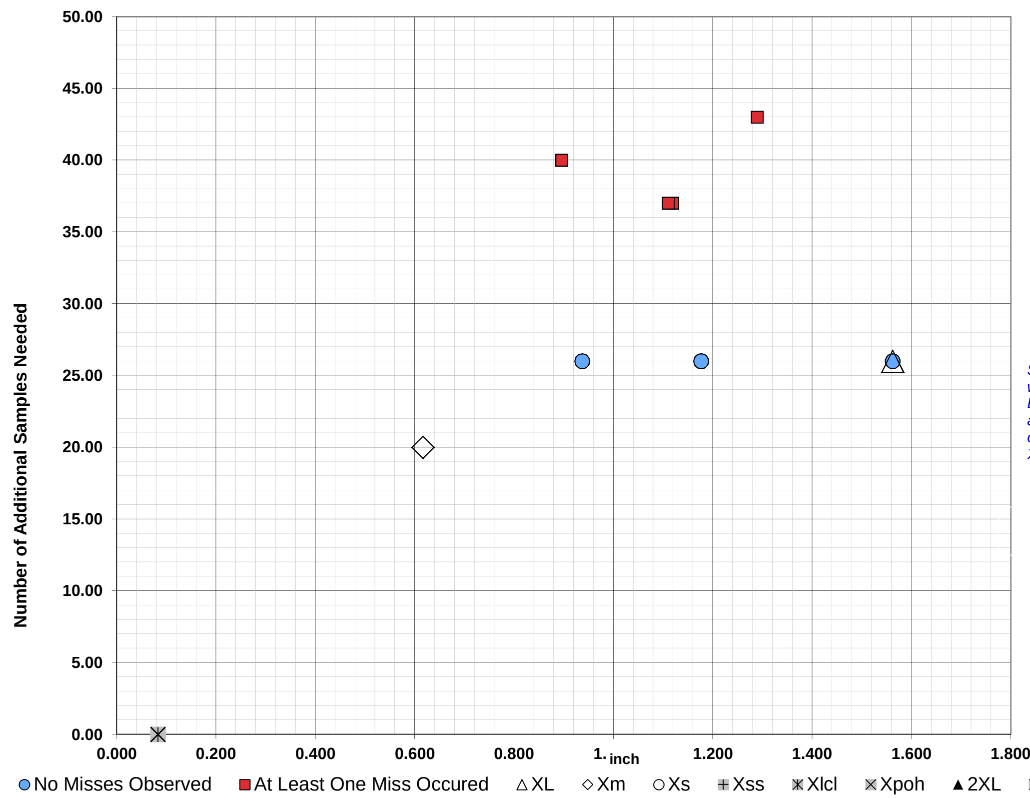


TABLE C

	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

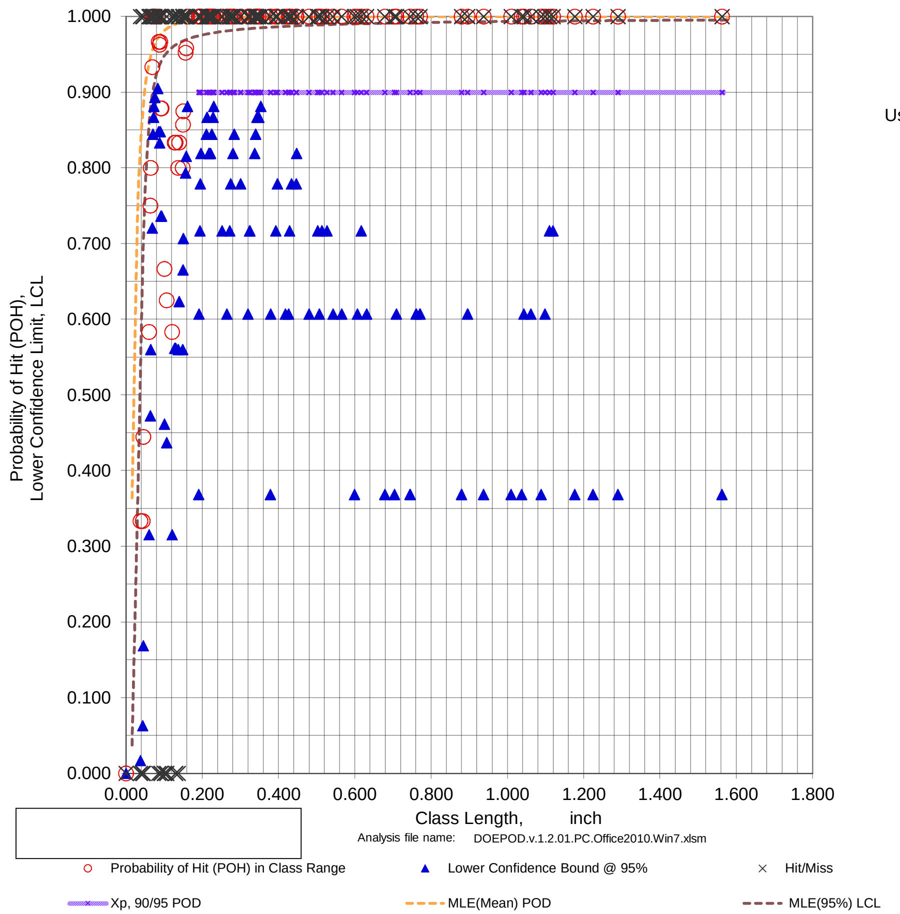
Classlength @ Best LCL = inch

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

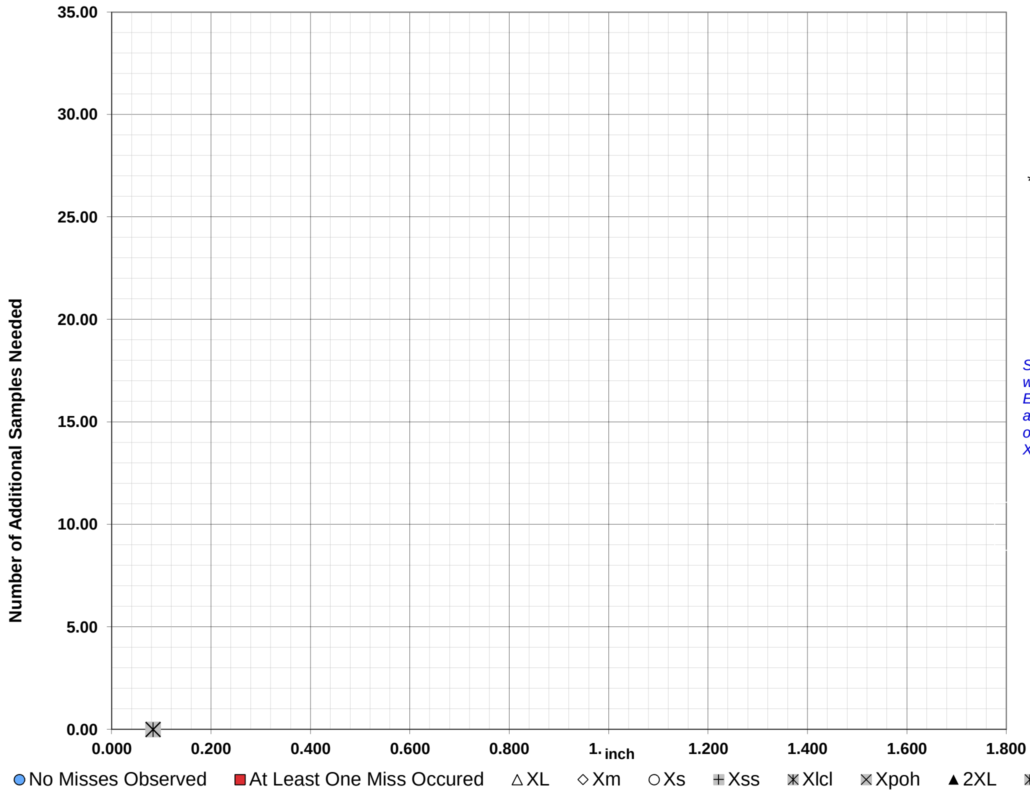


TABLE C

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

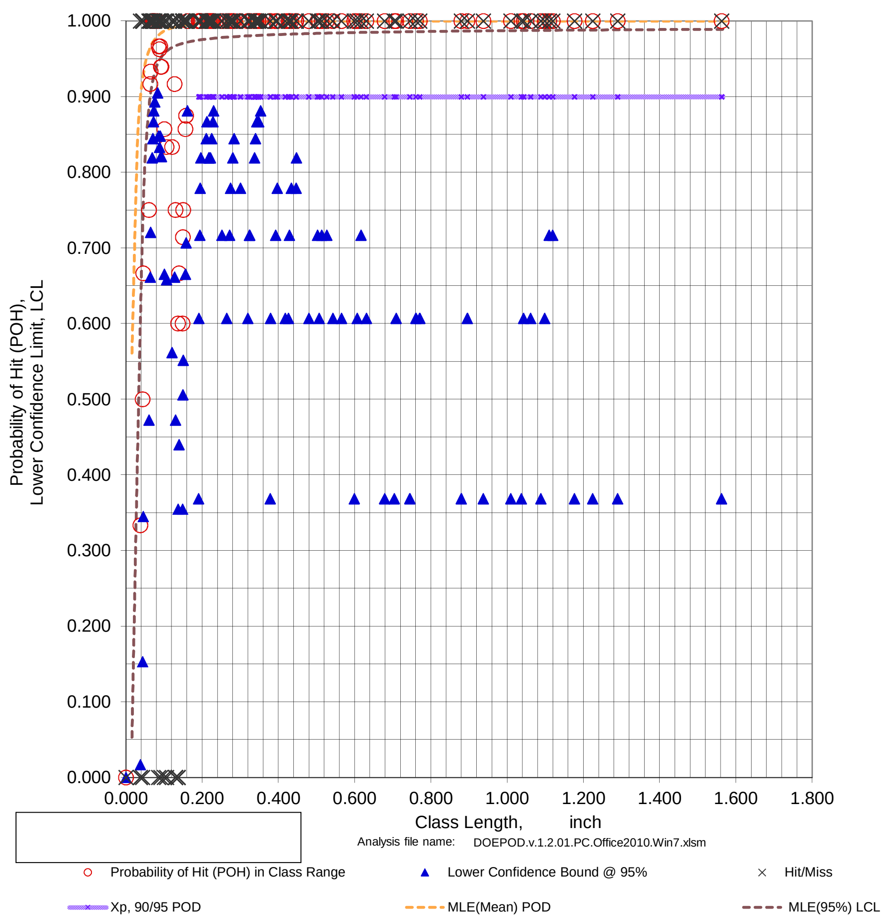
Classlength @ Best LCL = inch

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

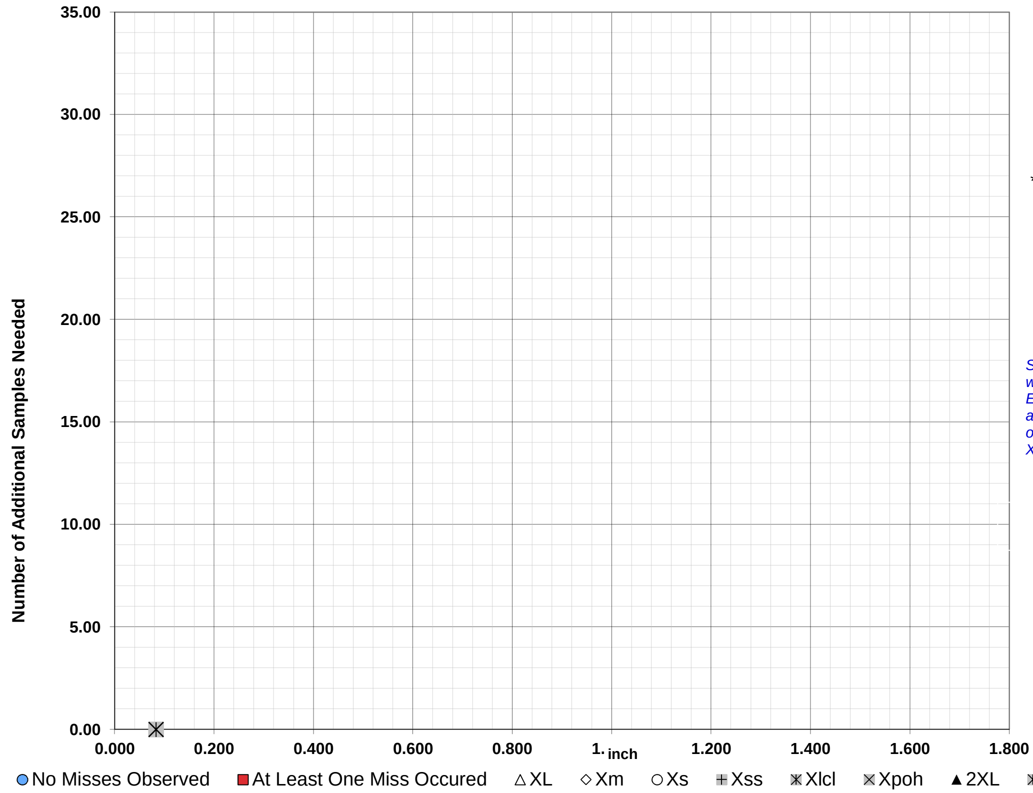


TABLE C

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

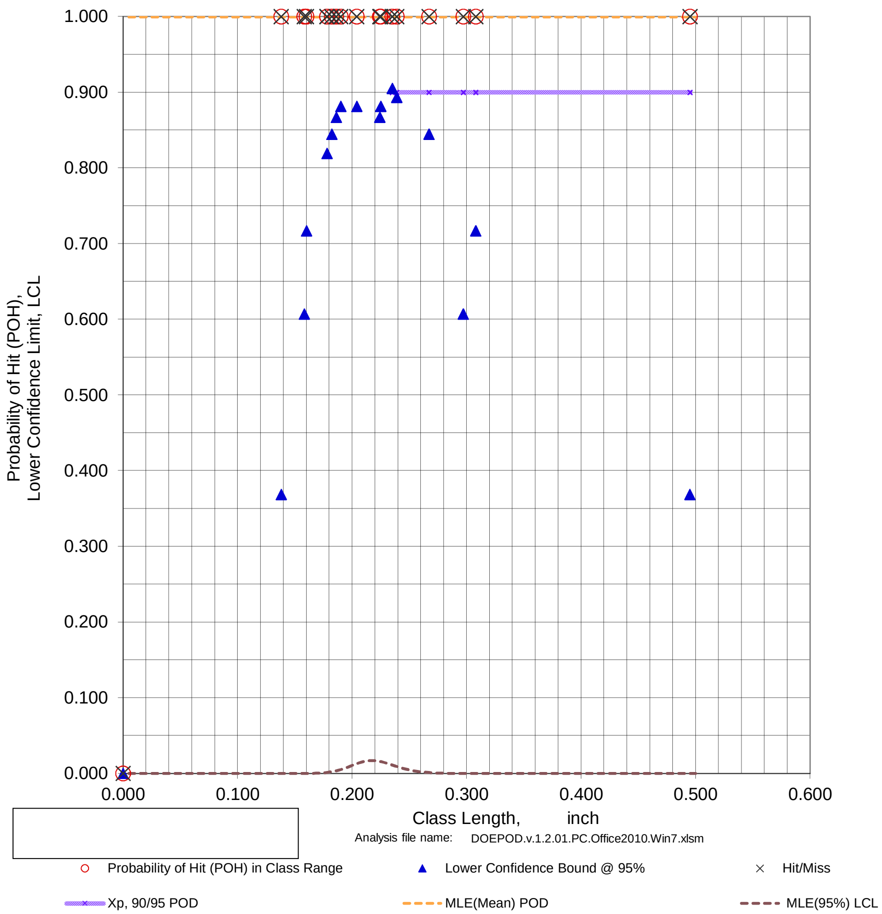
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

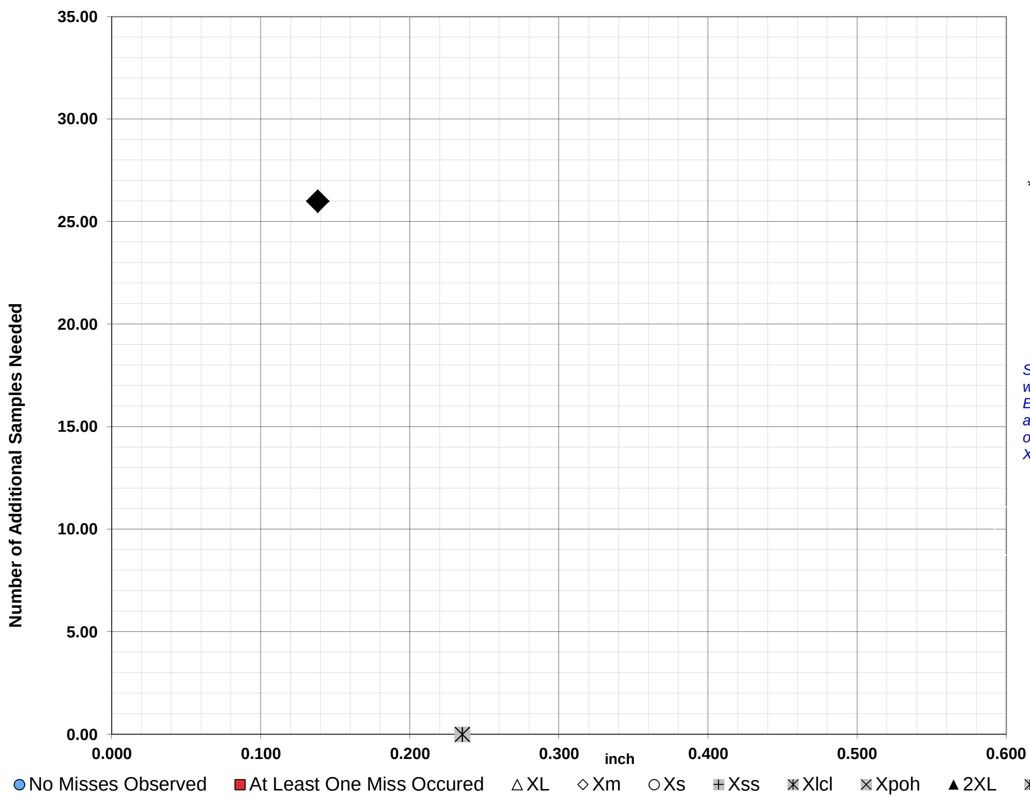


TABLE C

	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

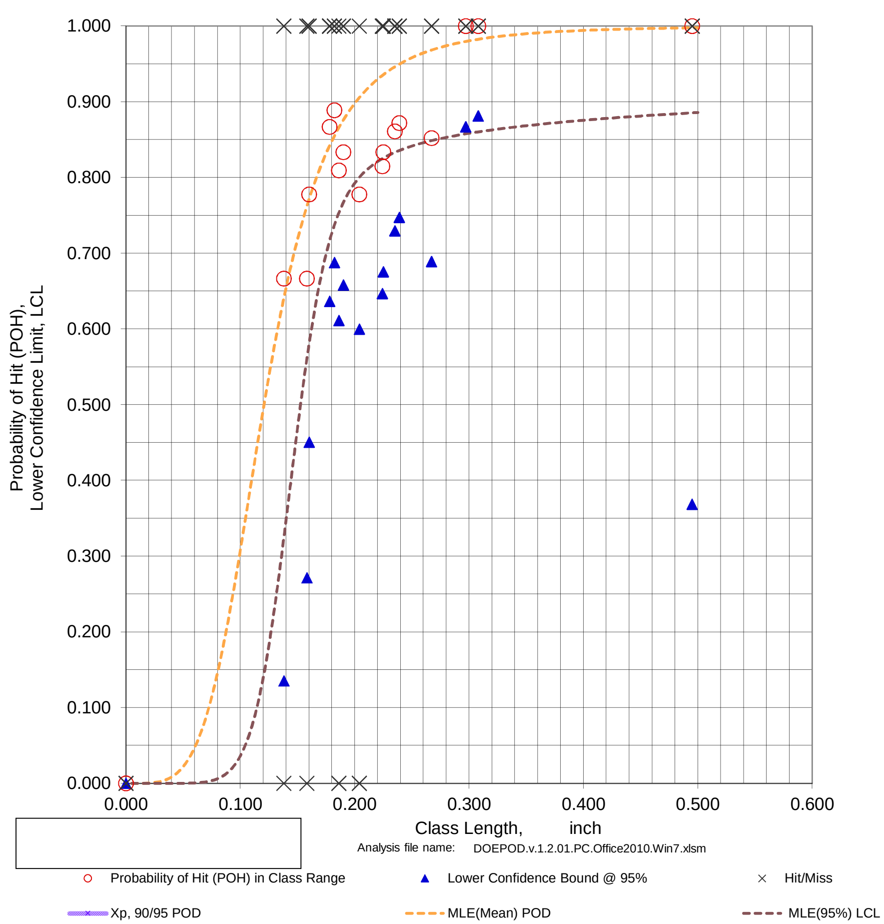
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

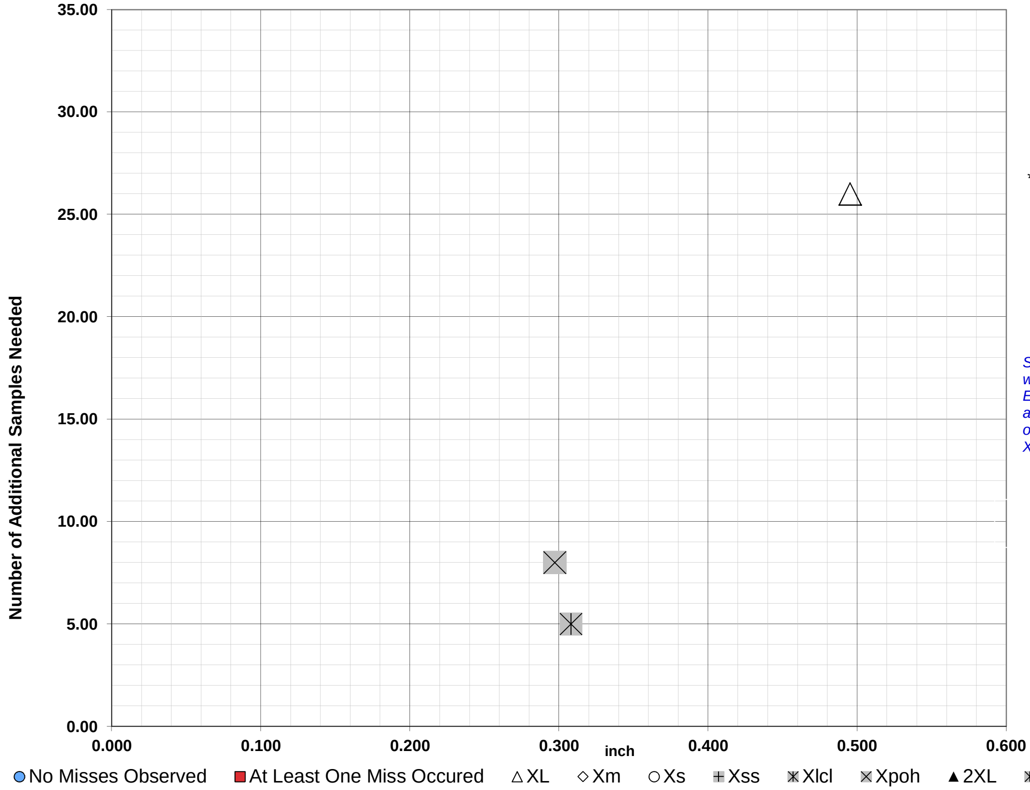


TABLE C

	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*

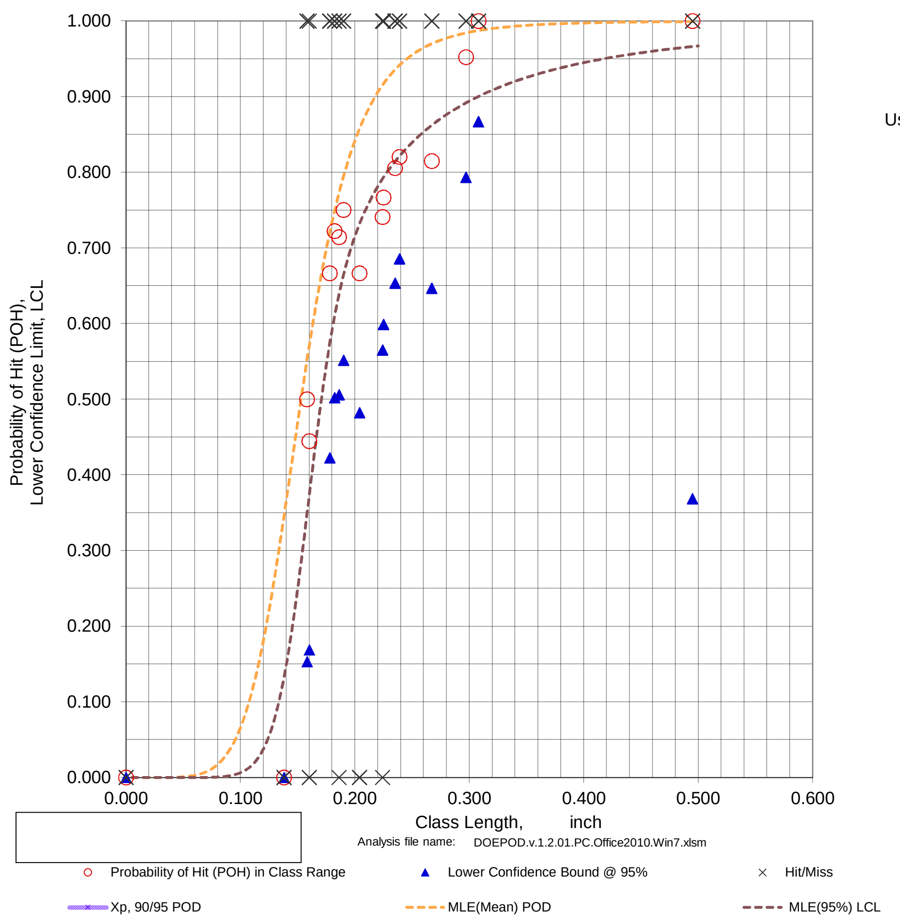
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

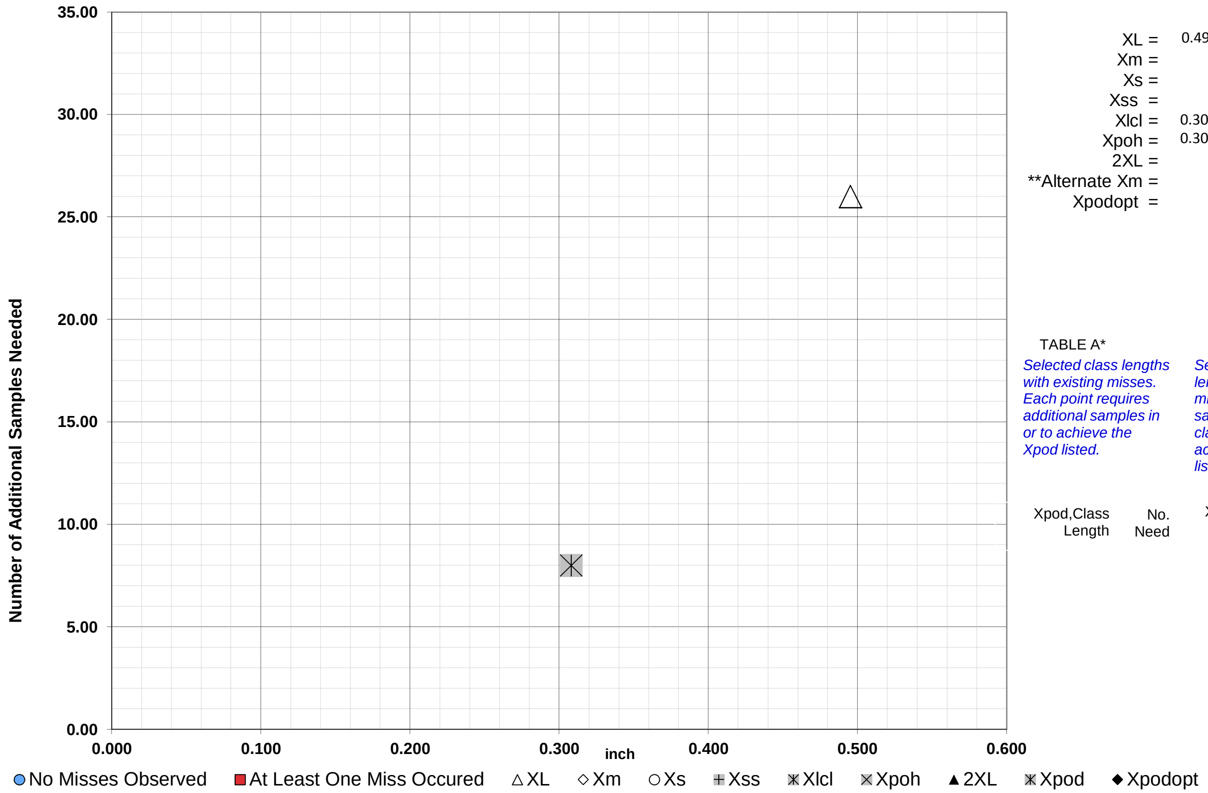


TABLE C

	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.

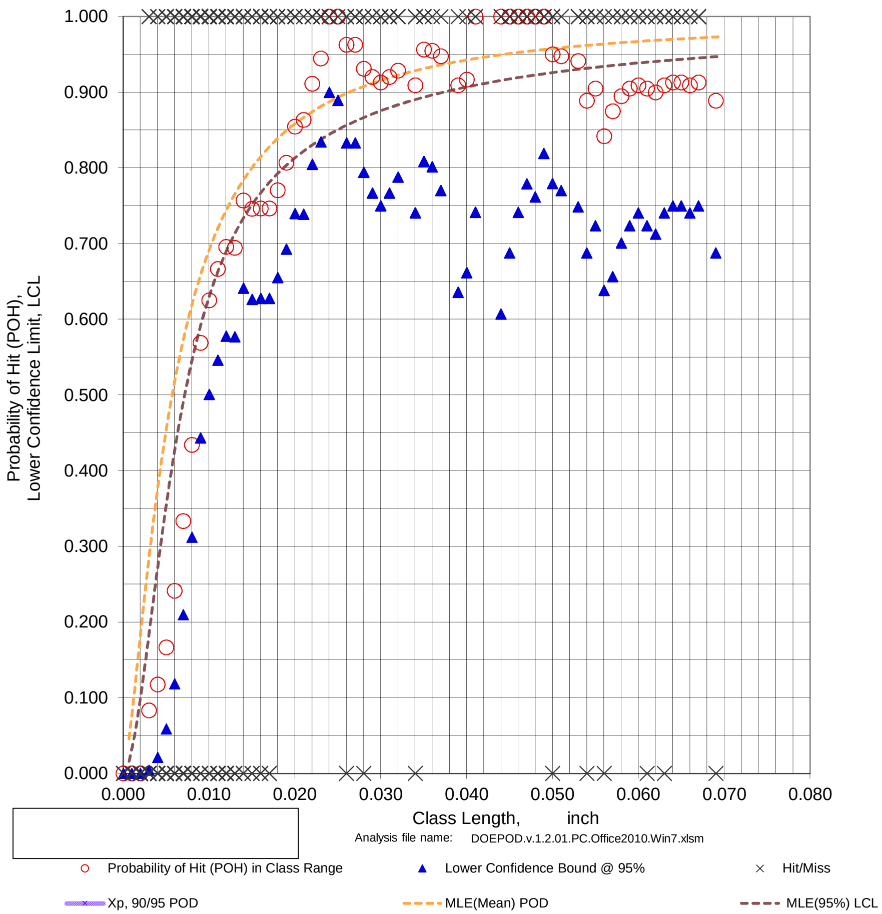
Xpod,Class Length	No. Need

* 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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

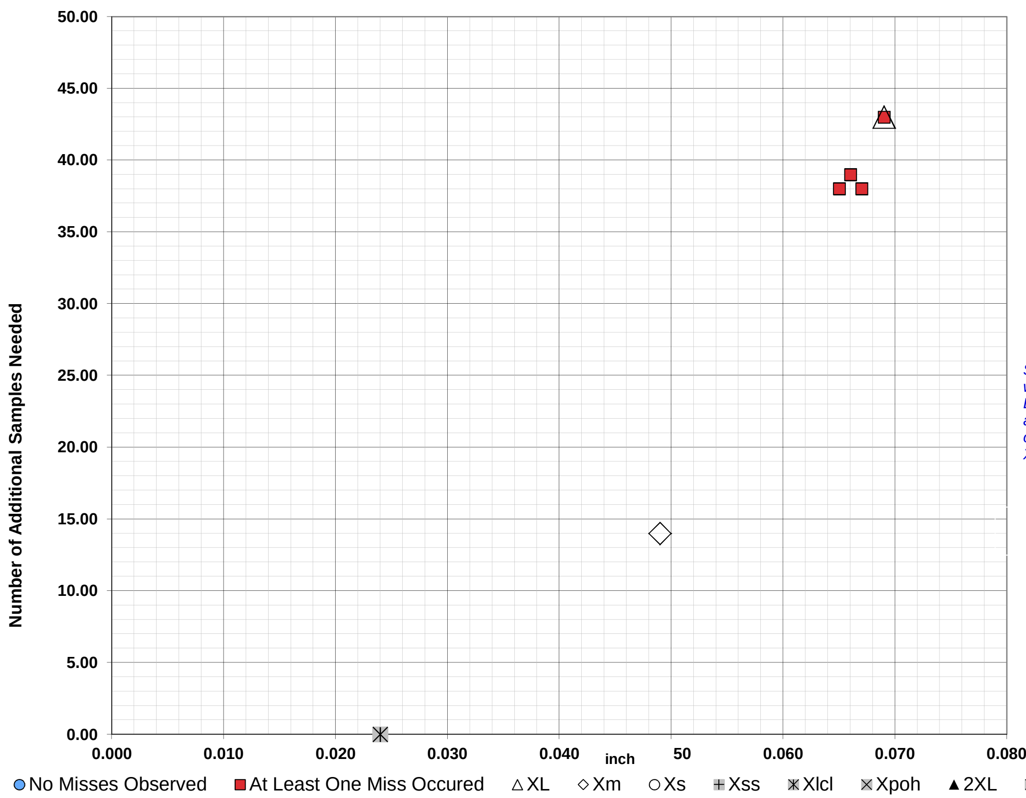


TABLE C

	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

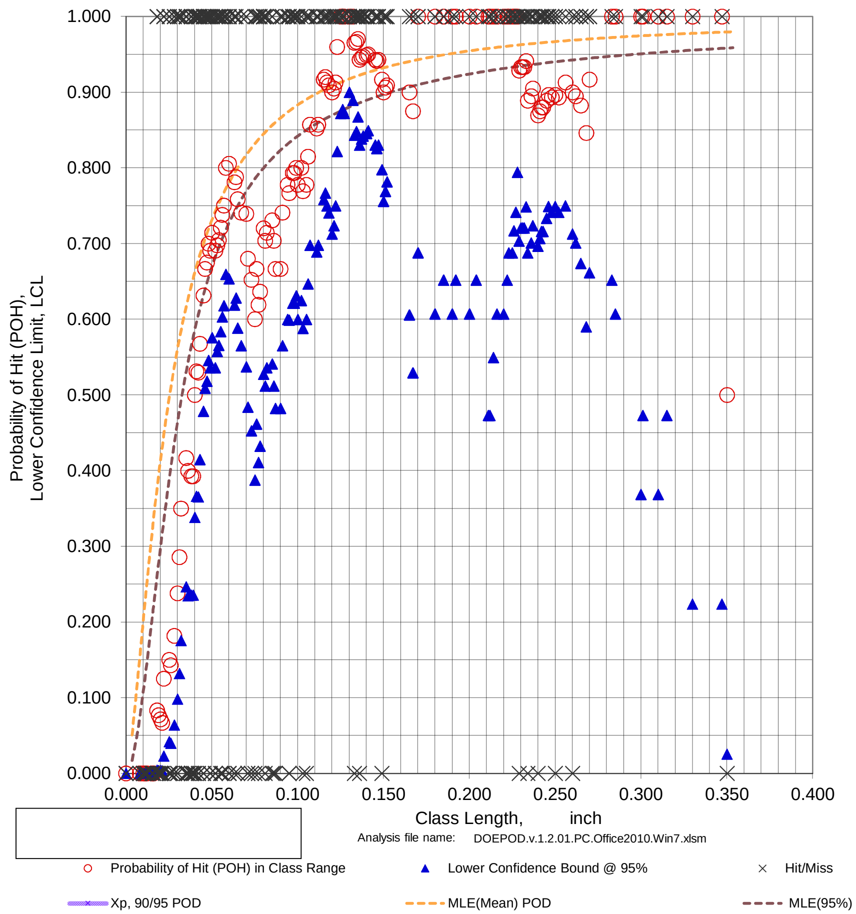
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.

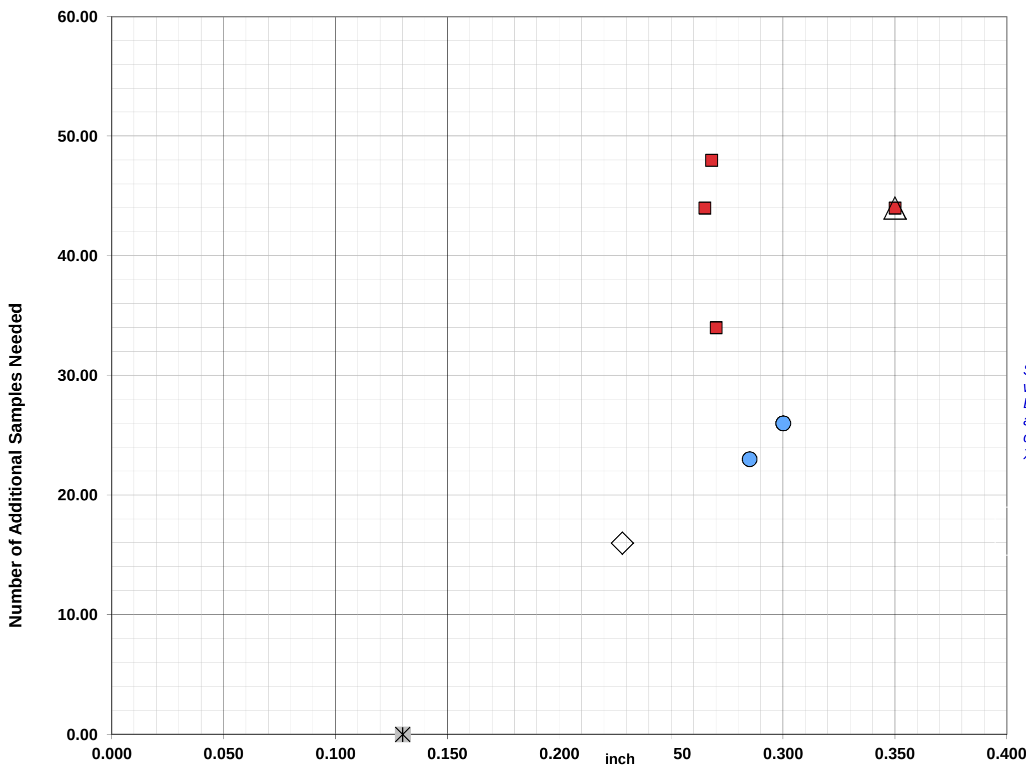
Survey/Optimum Xpoh = 0.000 inch Samples

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



● No Misses Observed ■ At Least One Miss Occured △ XL ◇ Xm ○ Xs Xss Xlcl Xpoh ▲ 2XL Xpod ◆ Xpodopt

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

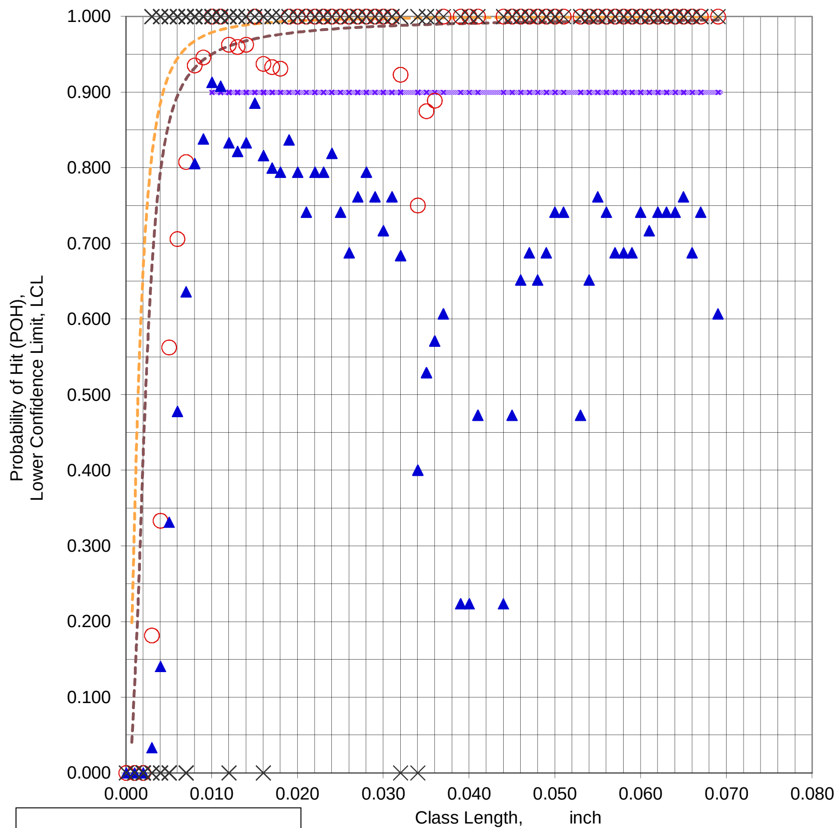
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

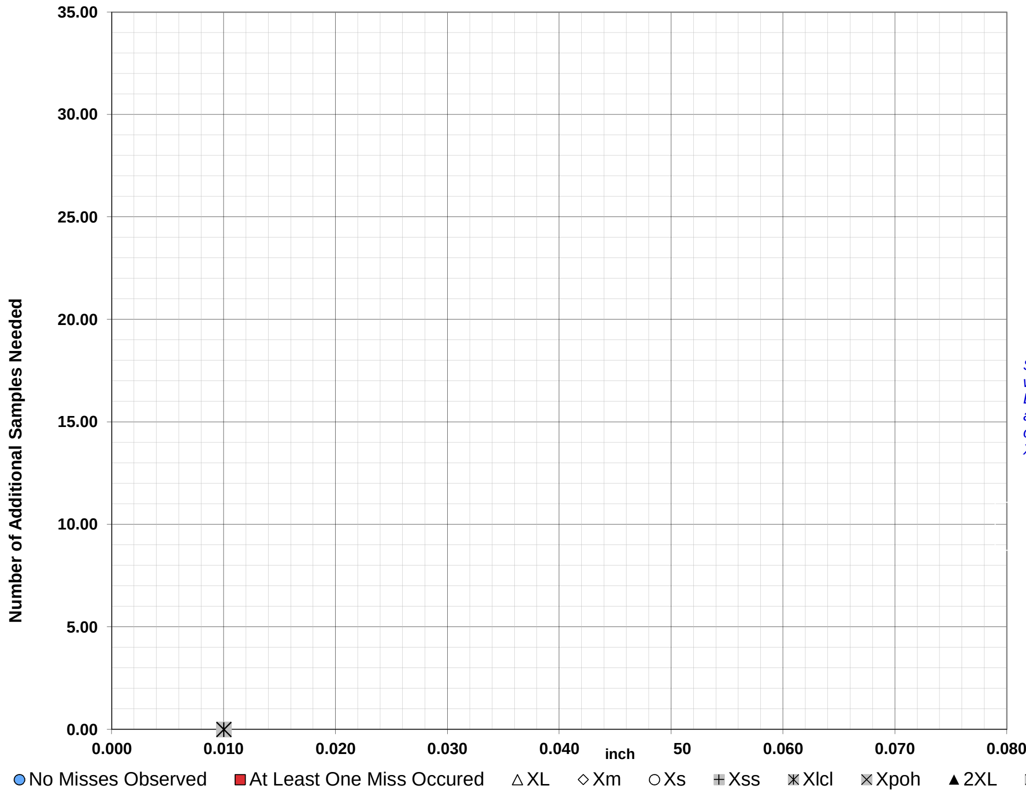


TABLE C

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

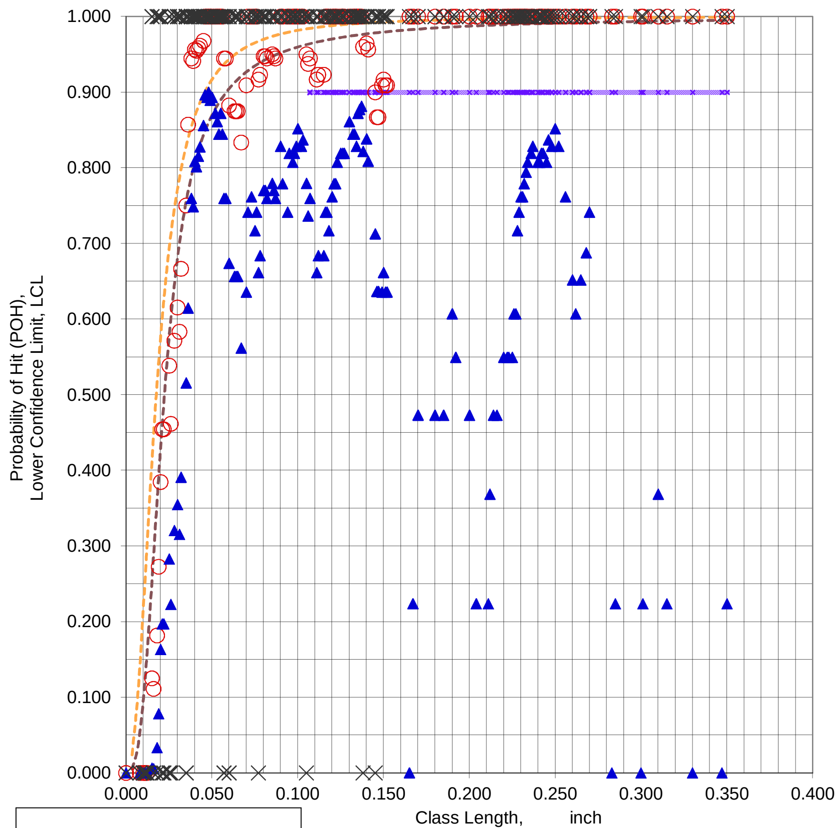
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

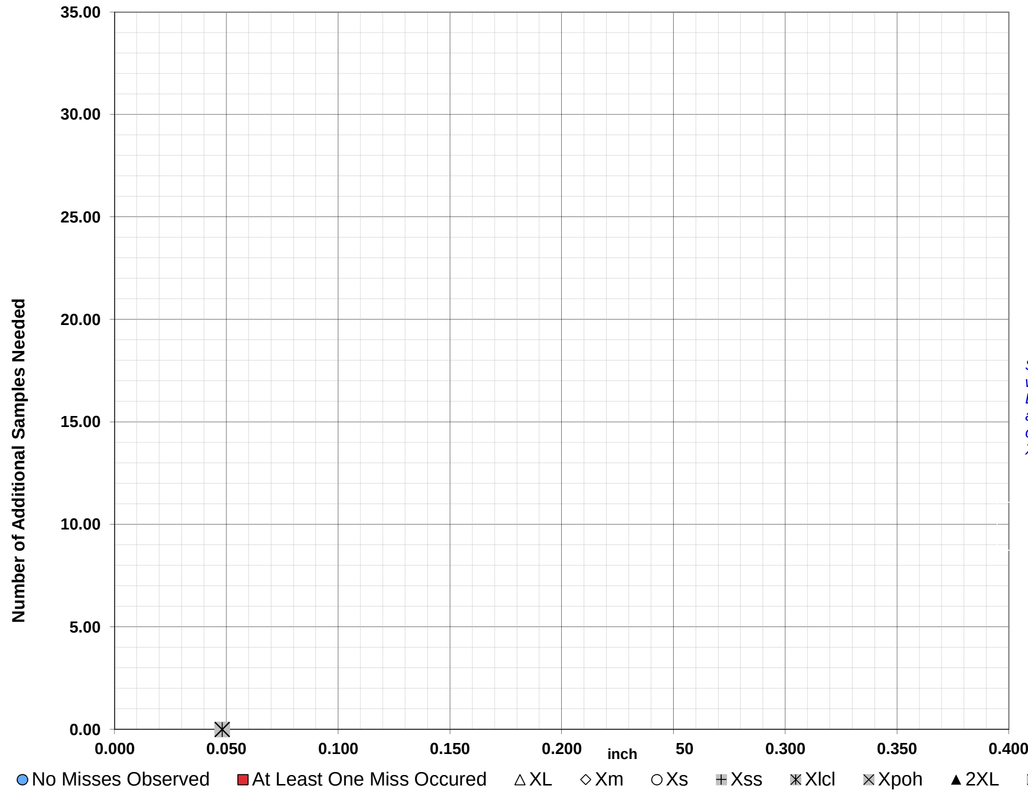


TABLE C

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*

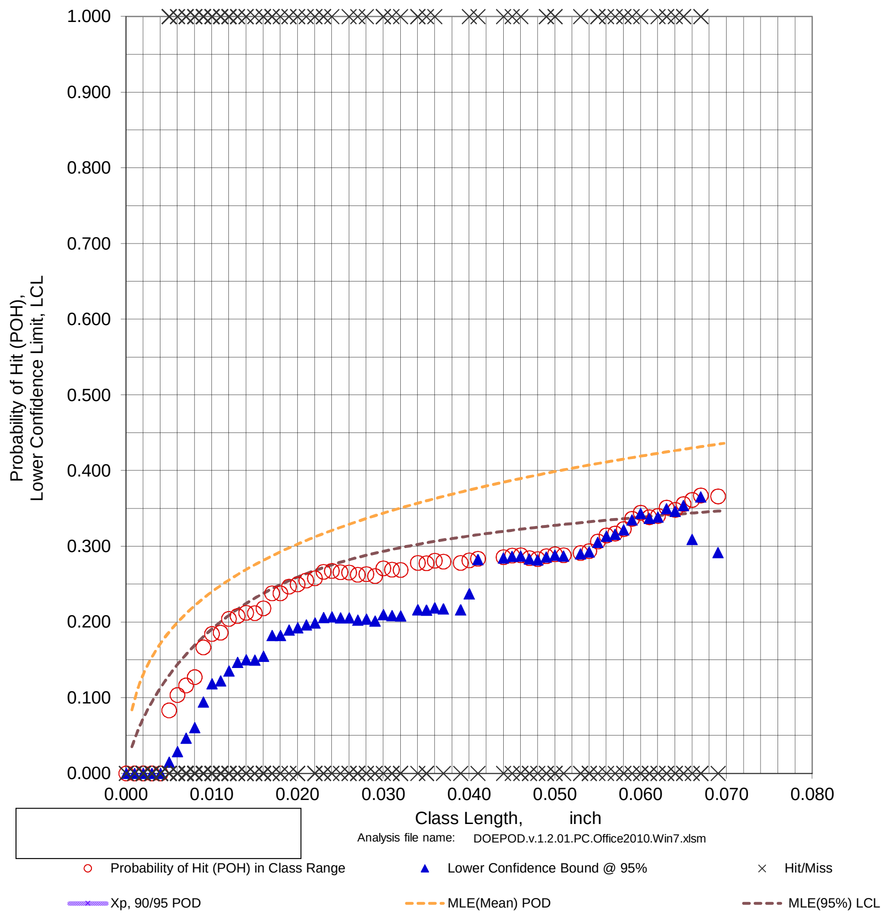
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

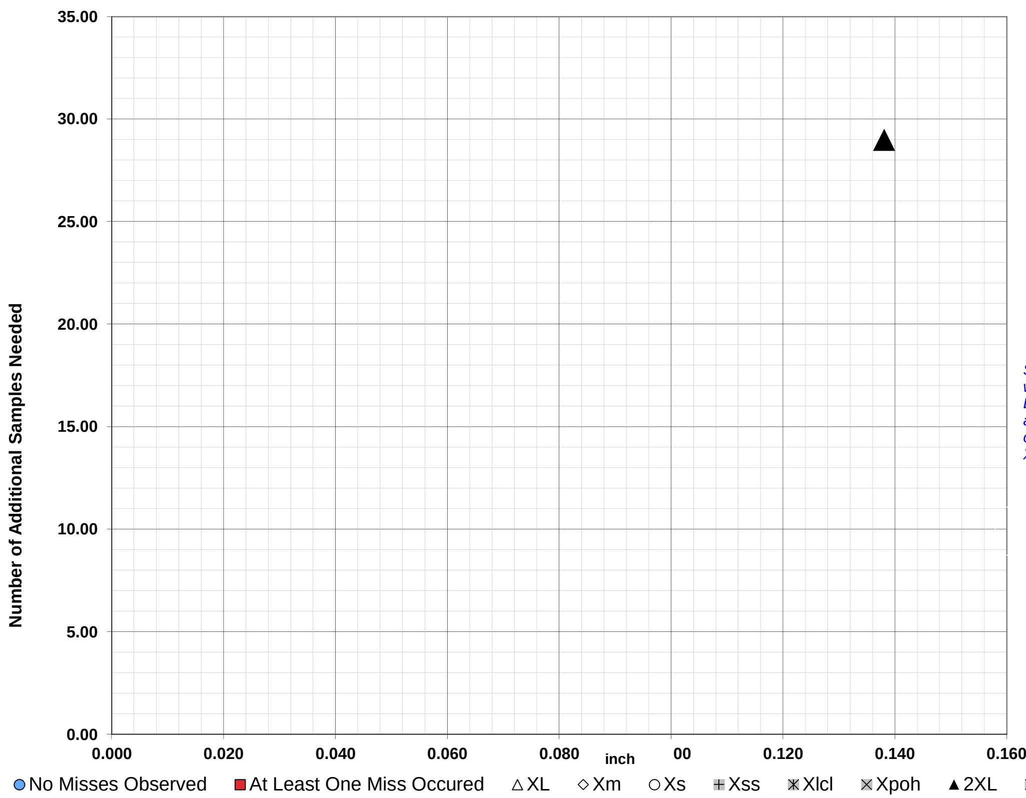


TABLE C

	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*

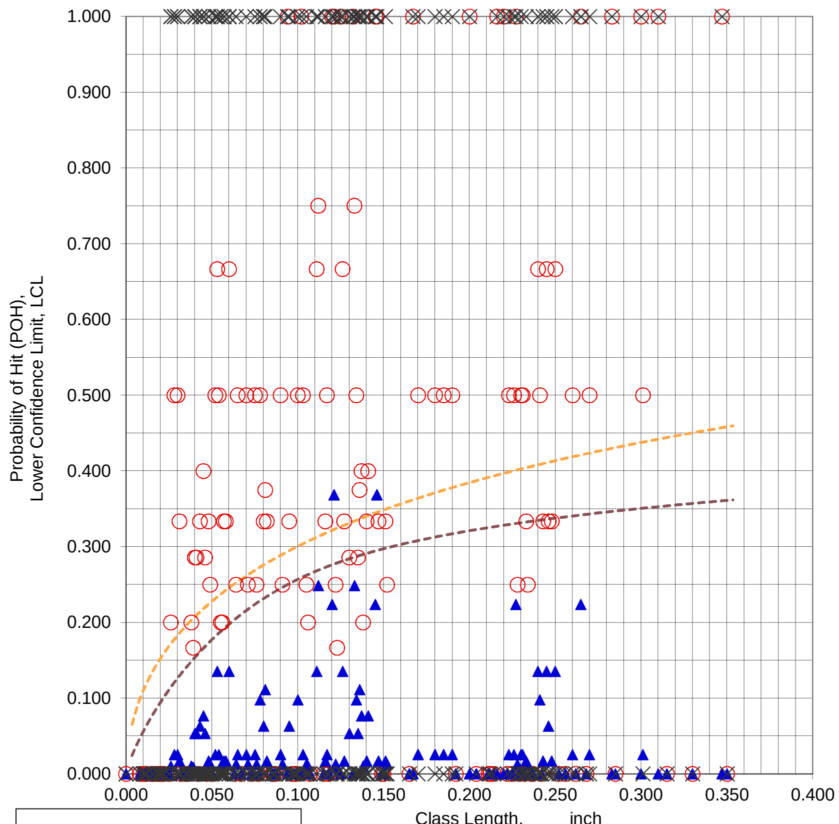
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

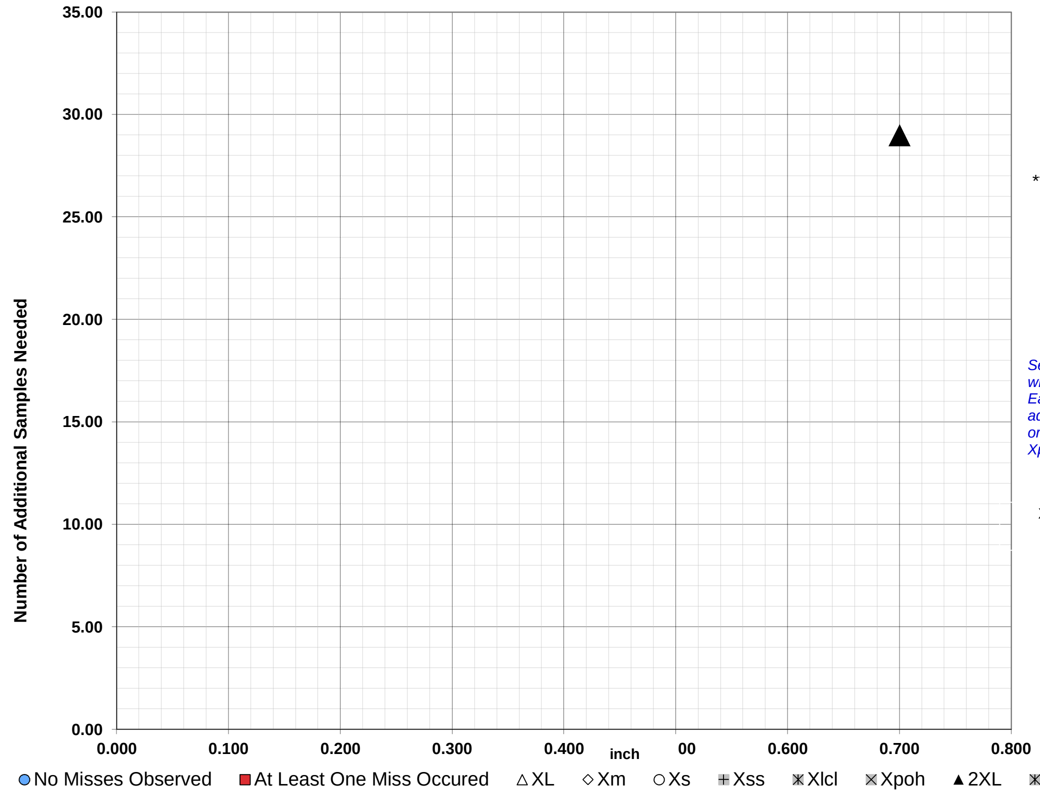


TABLE C

	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

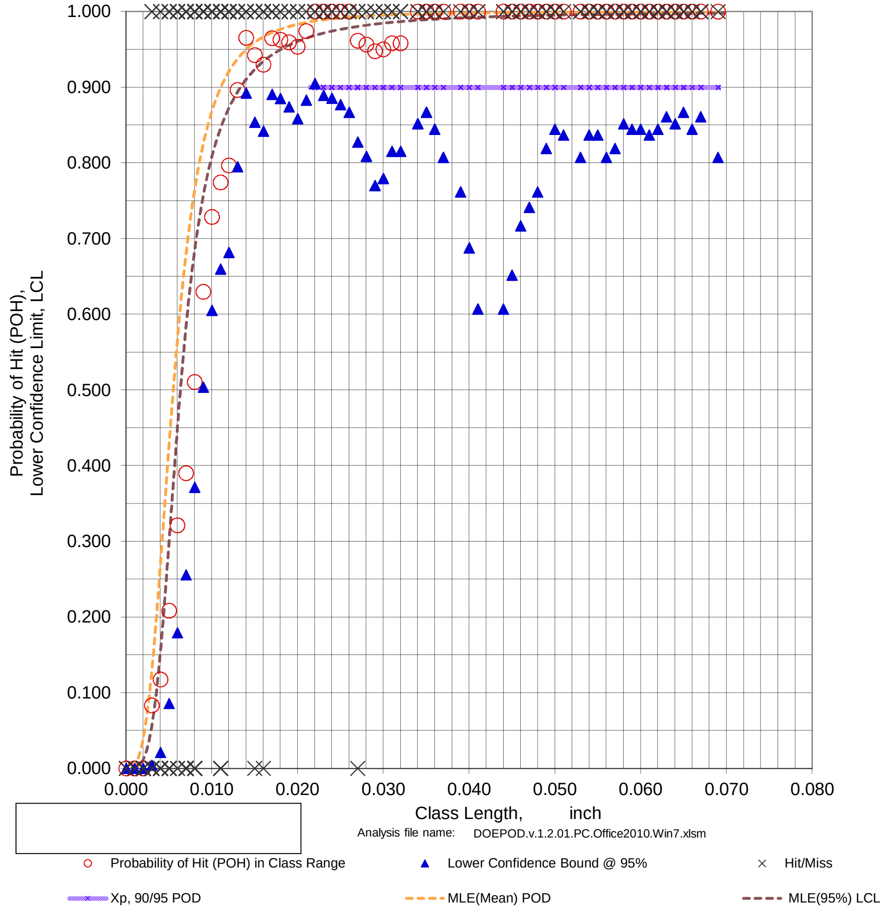
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

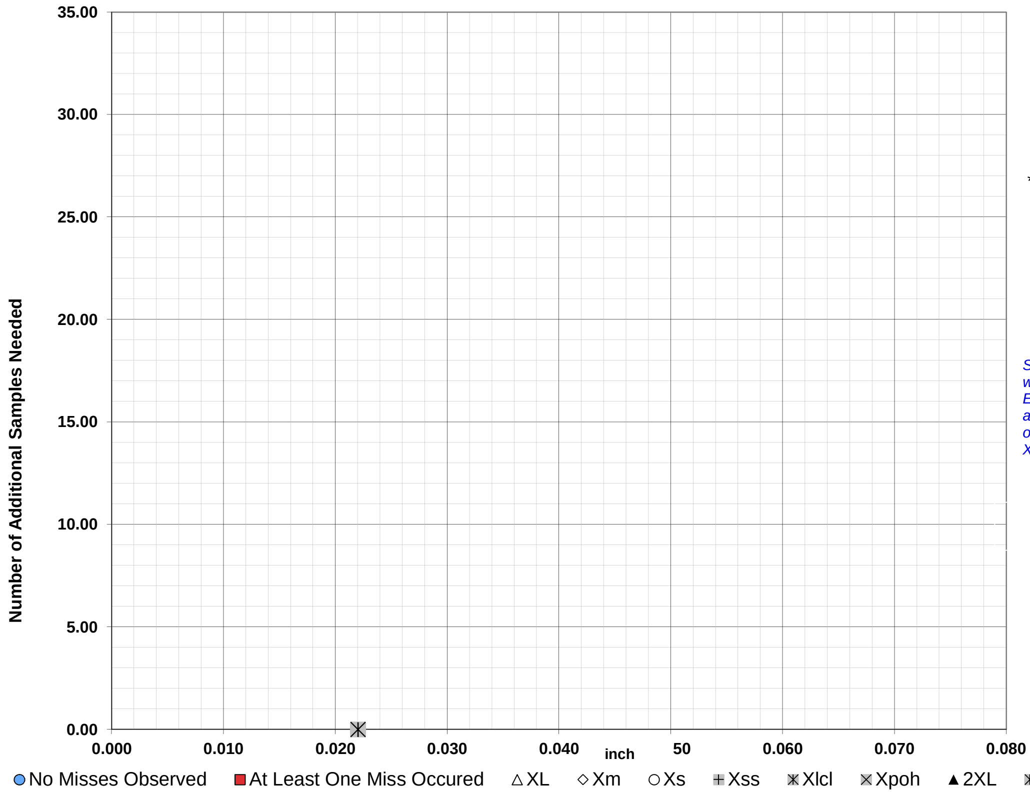


TABLE C

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

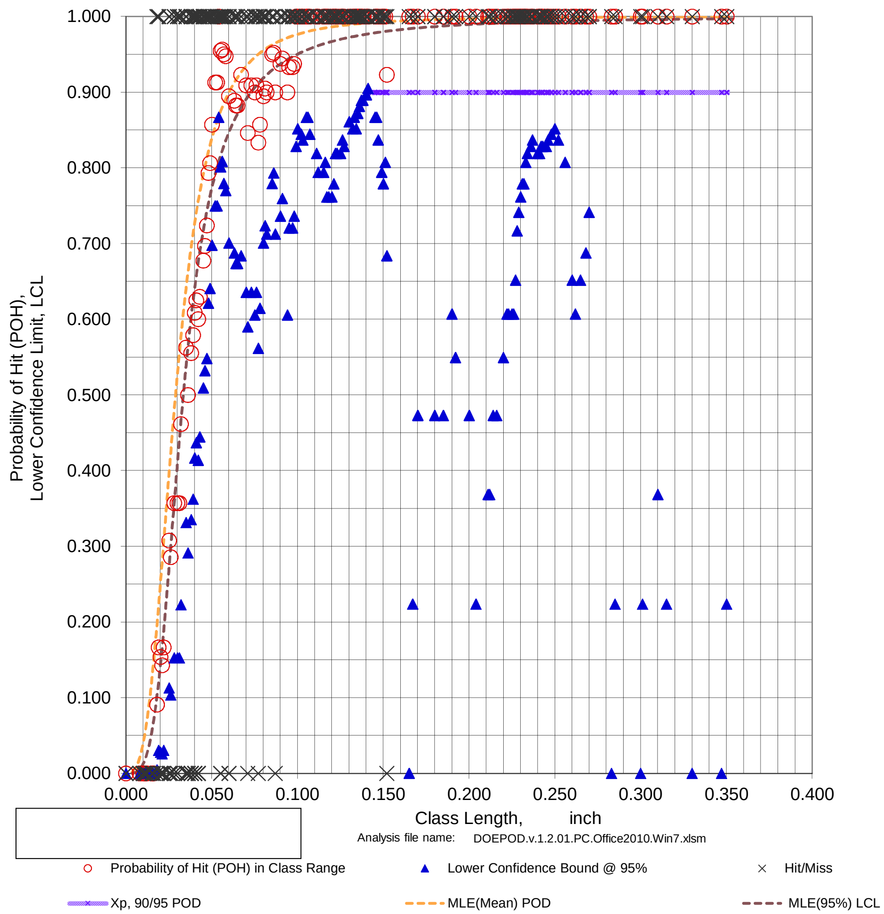
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

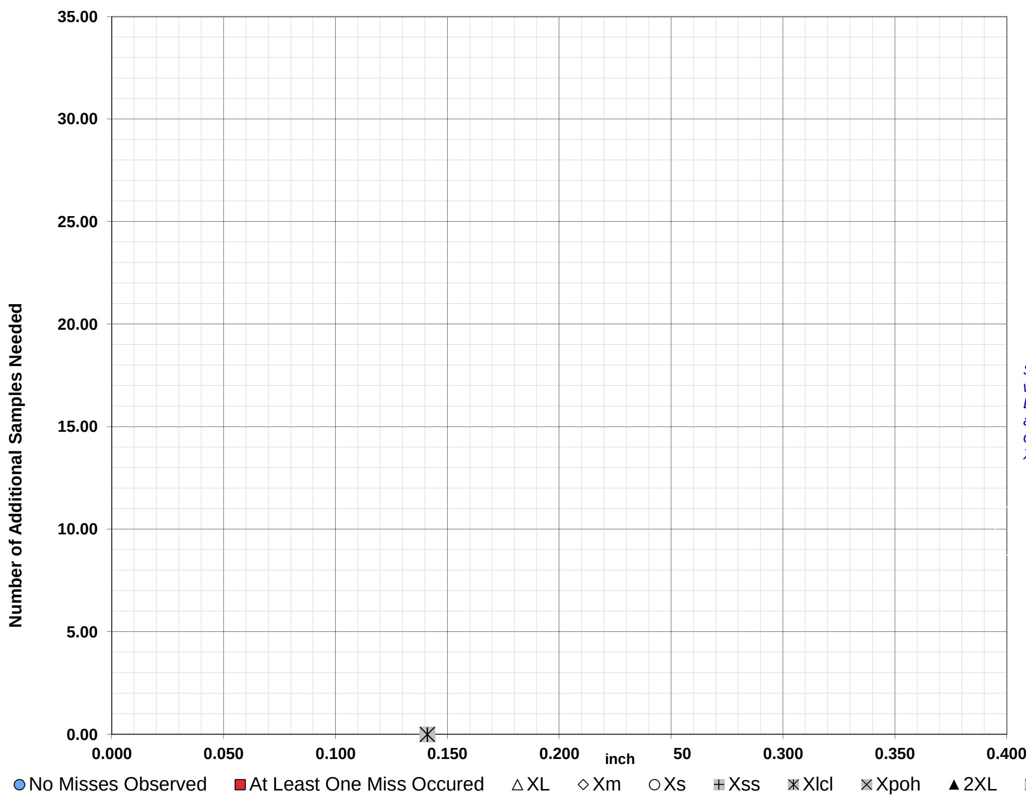


TABLE C

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*

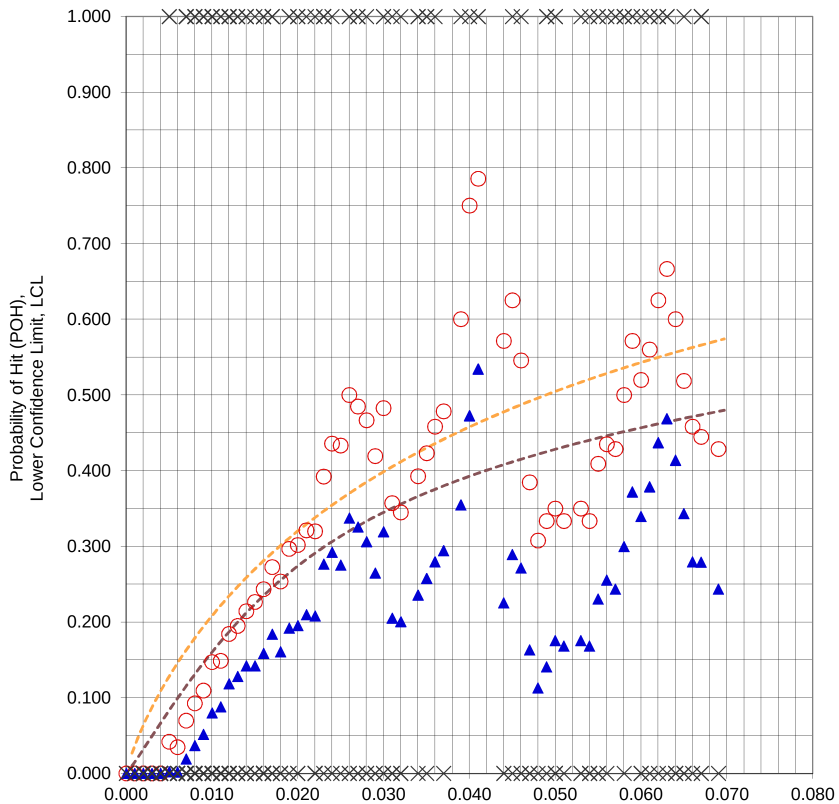
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

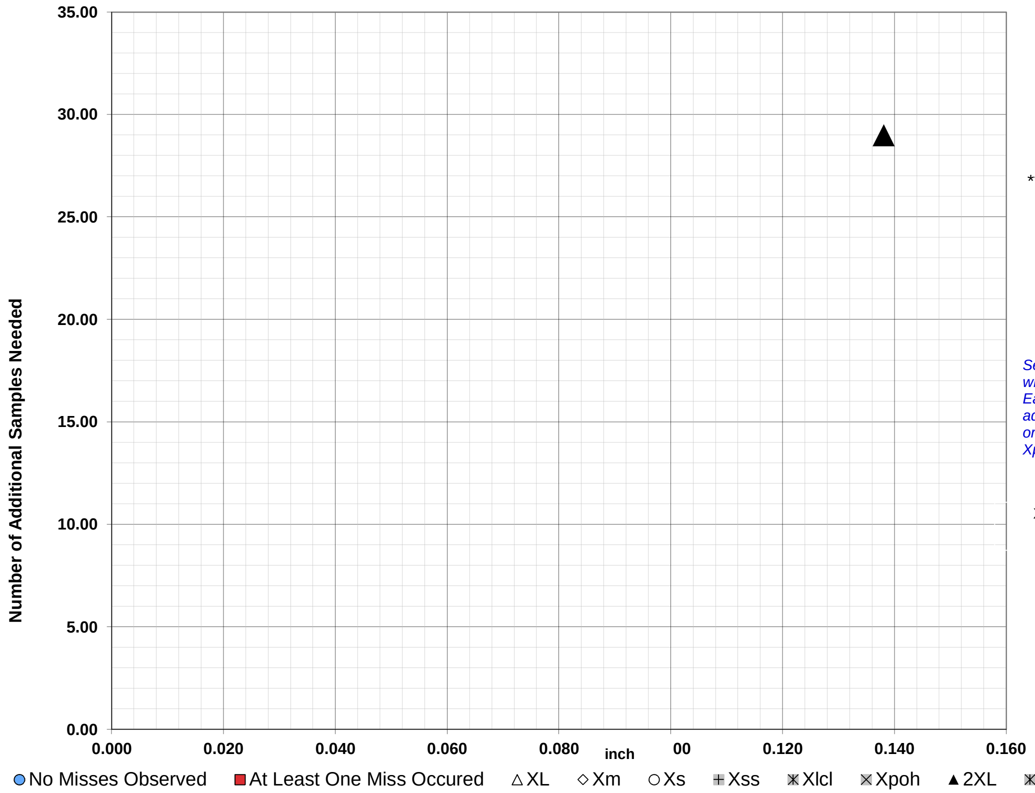


TABLE C

	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*

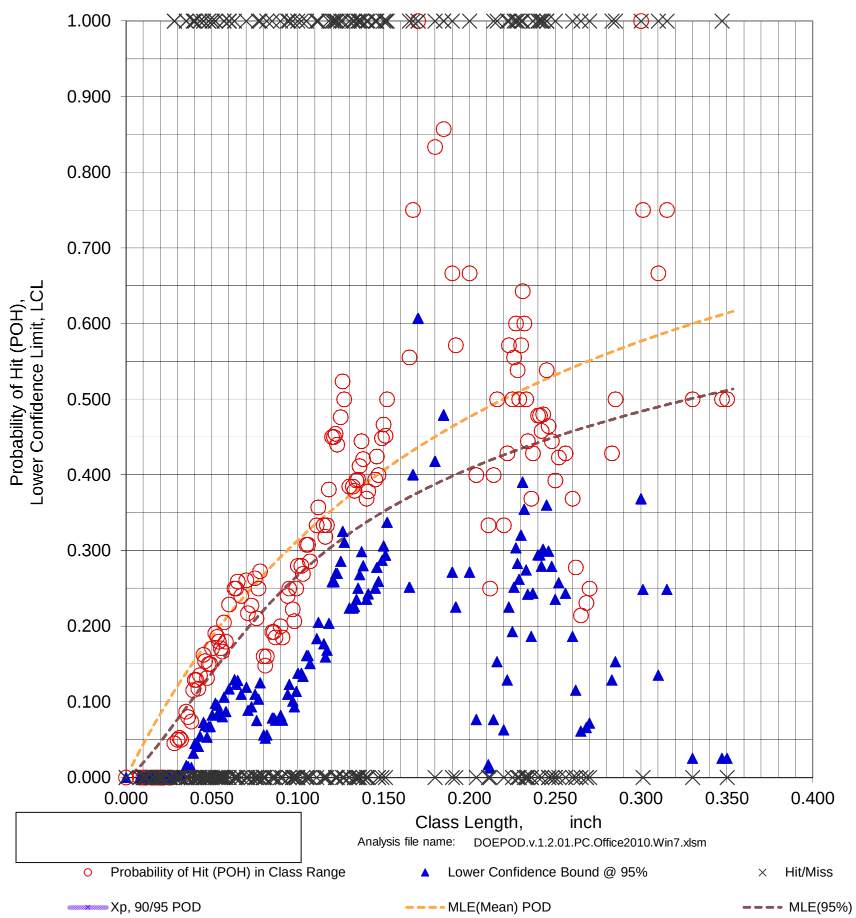
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

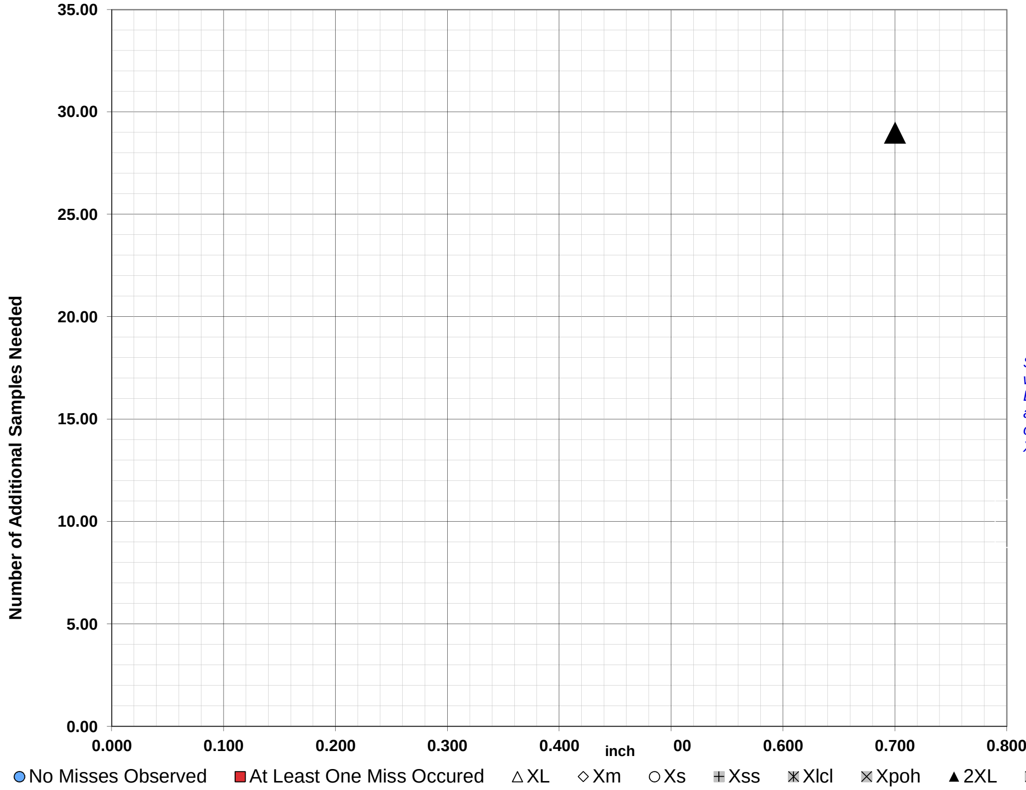


TABLE C

	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

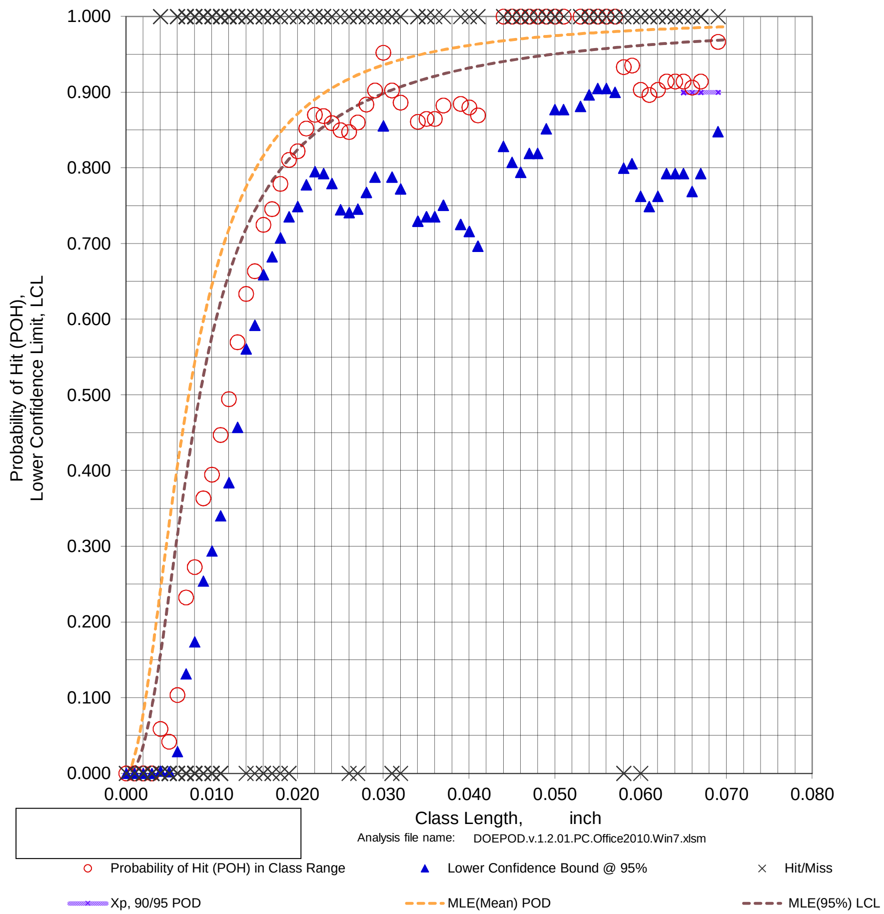
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

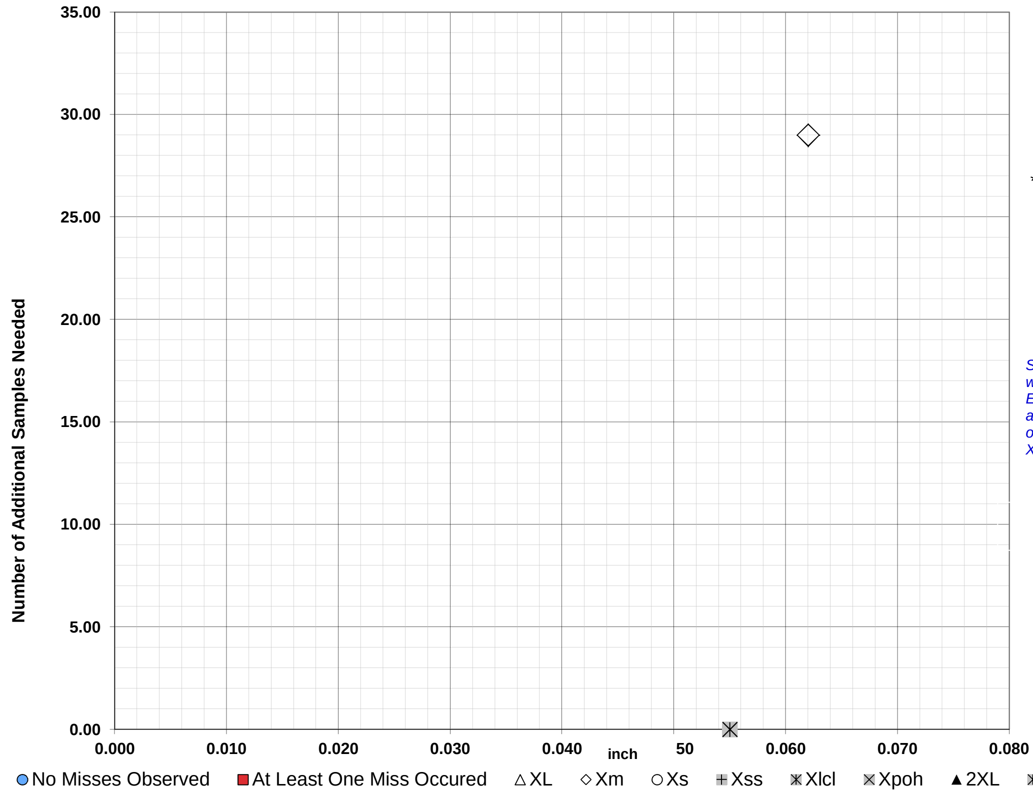


TABLE C

	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.

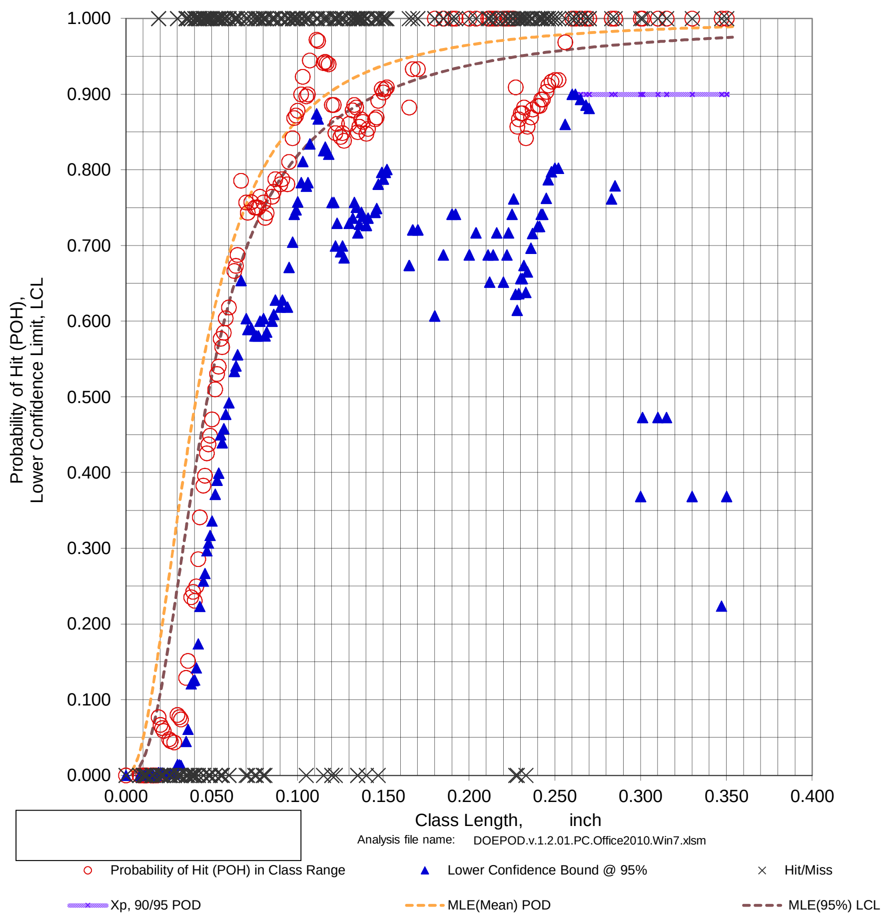
Xpod,Class Length	No. Need

* 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 #)

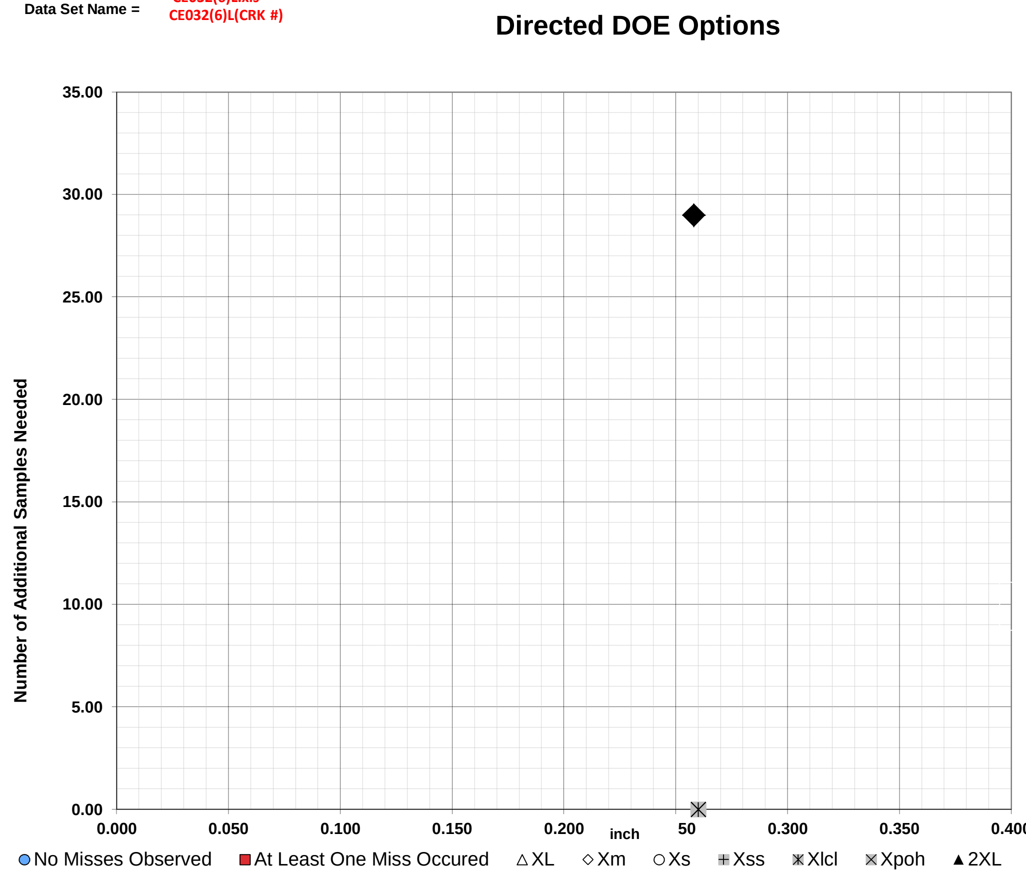


TABLE C

	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*

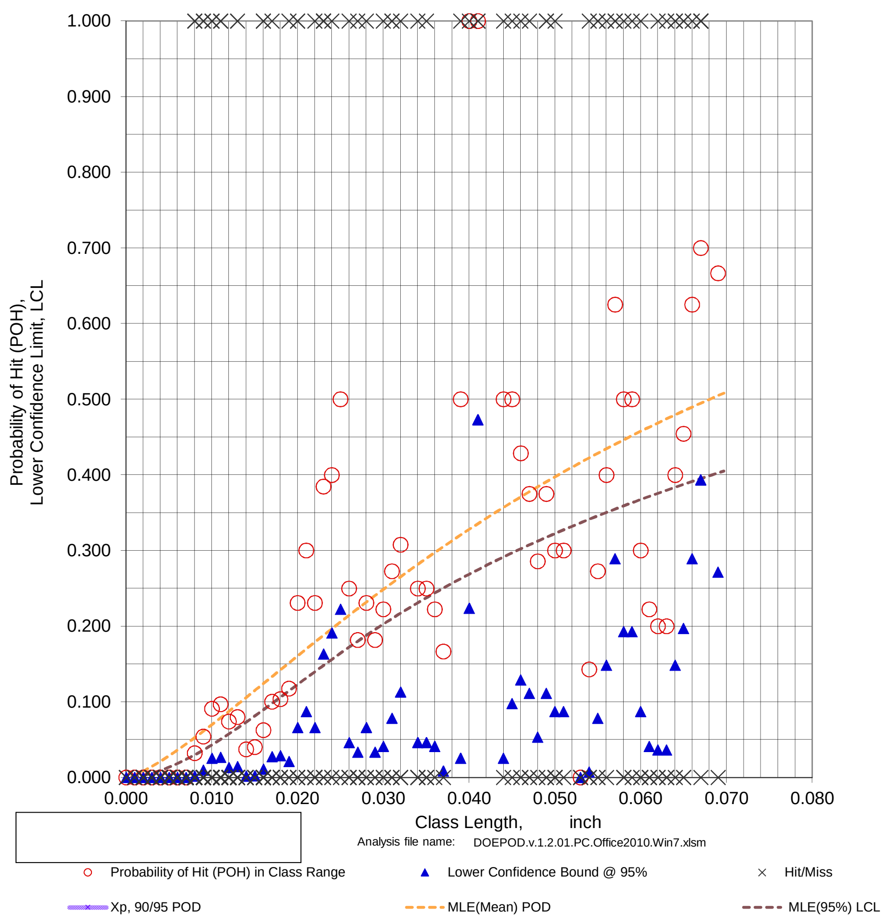
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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

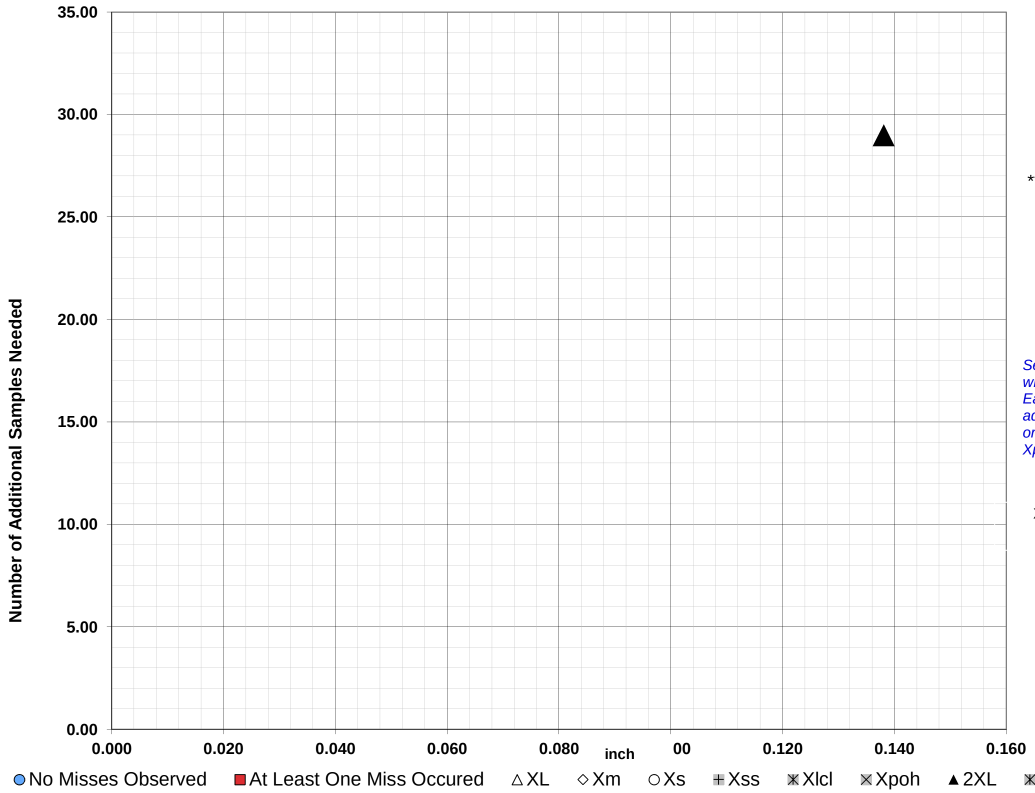


TABLE C

	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.

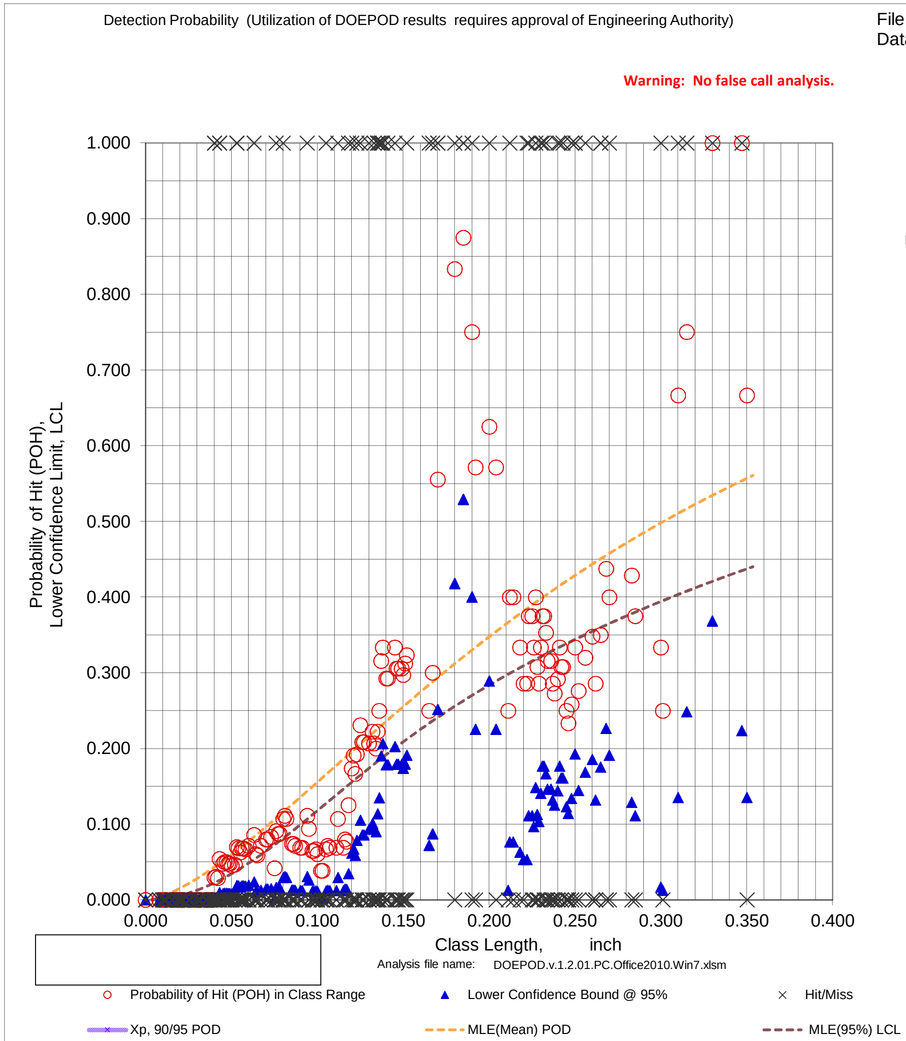
Xpod,Class Length	No. Need

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



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

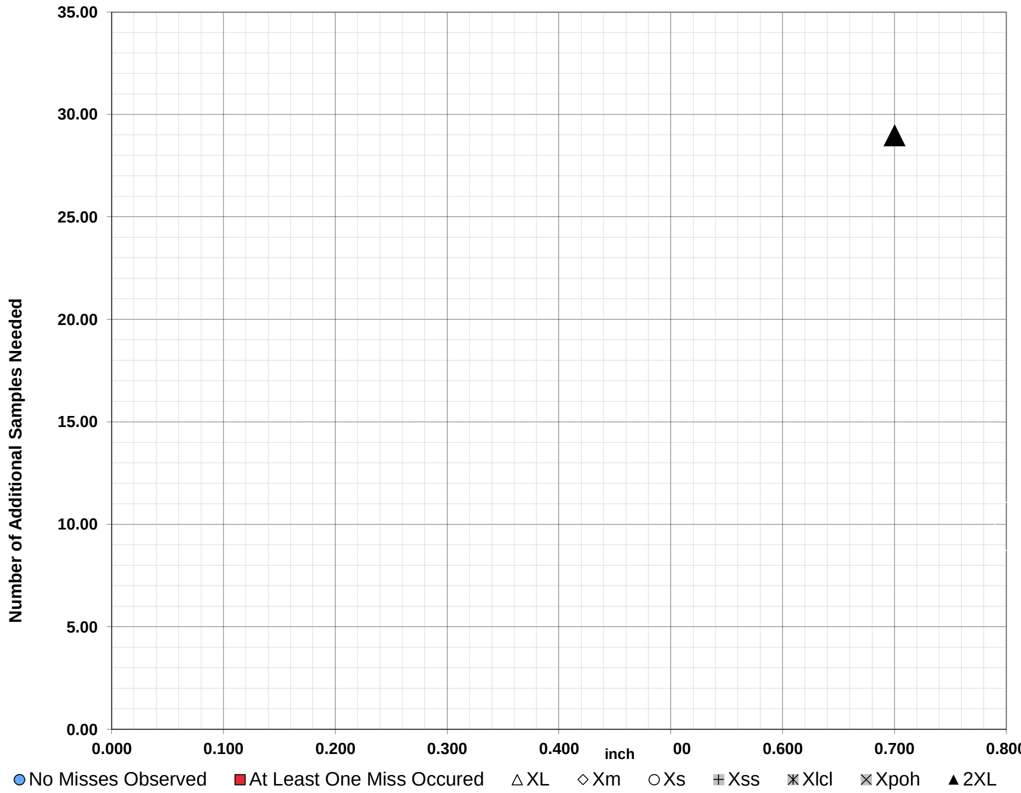


TABLE C

	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

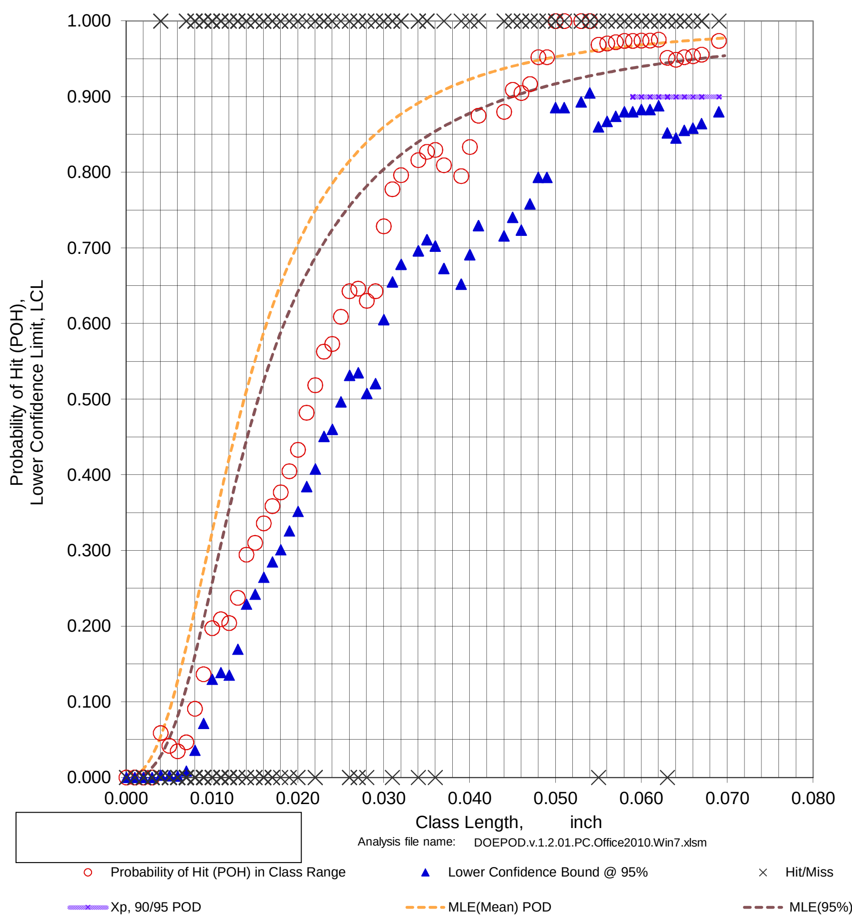
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

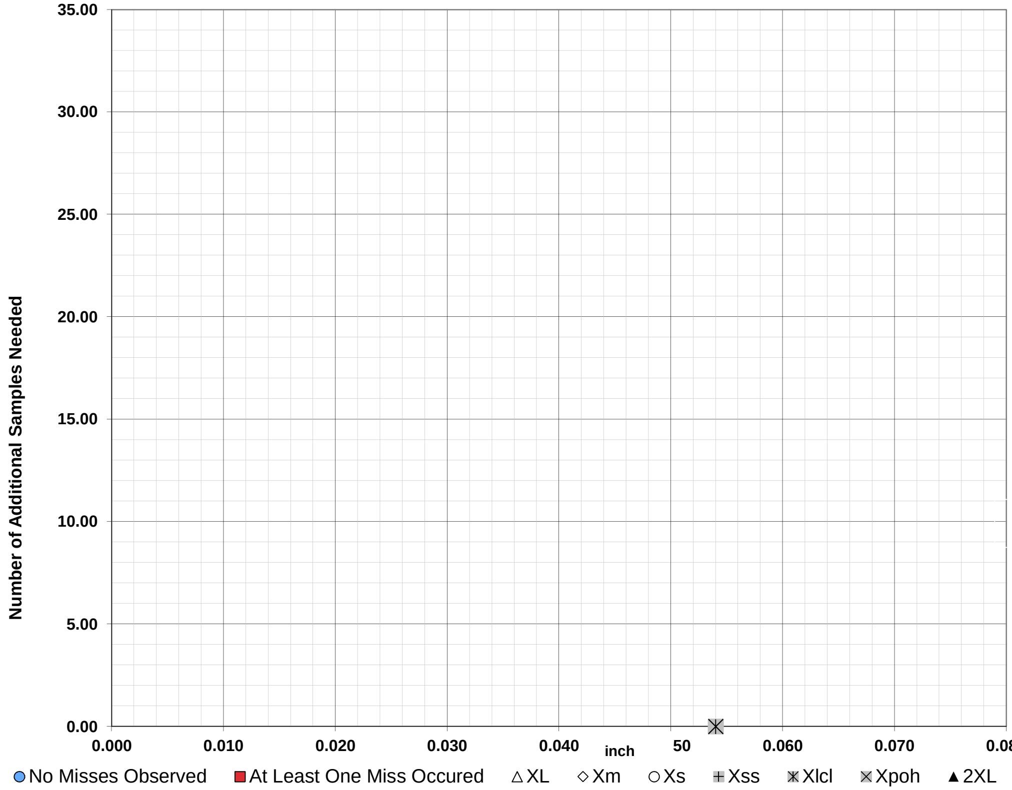


TABLE C

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

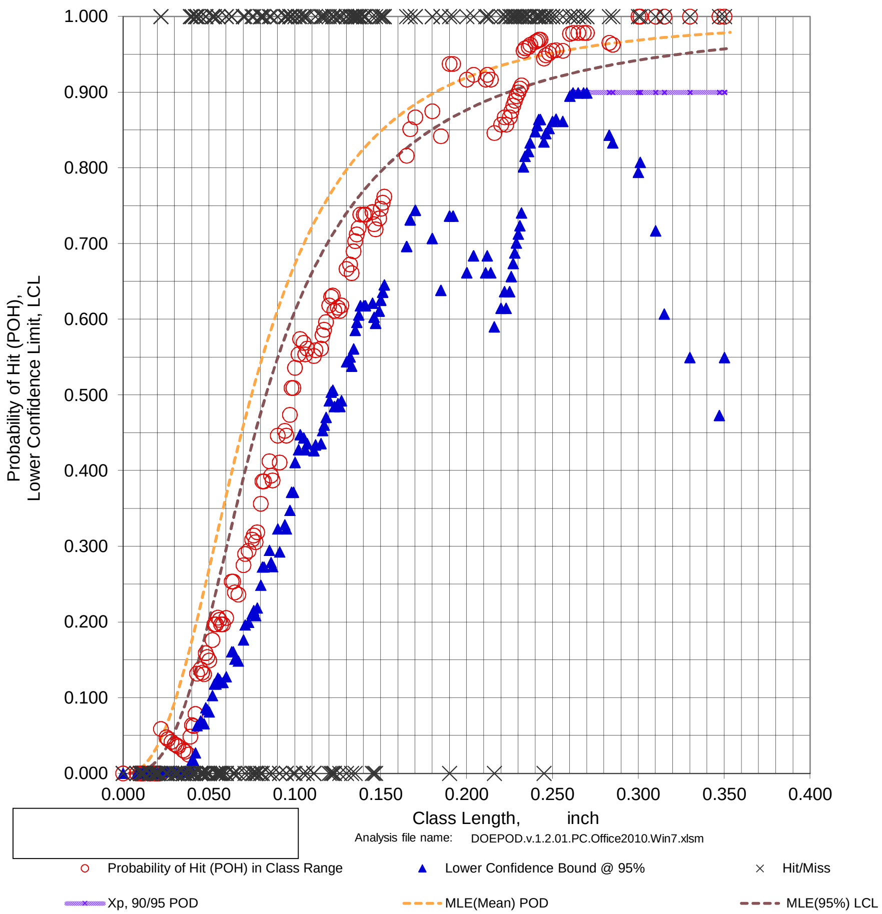
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

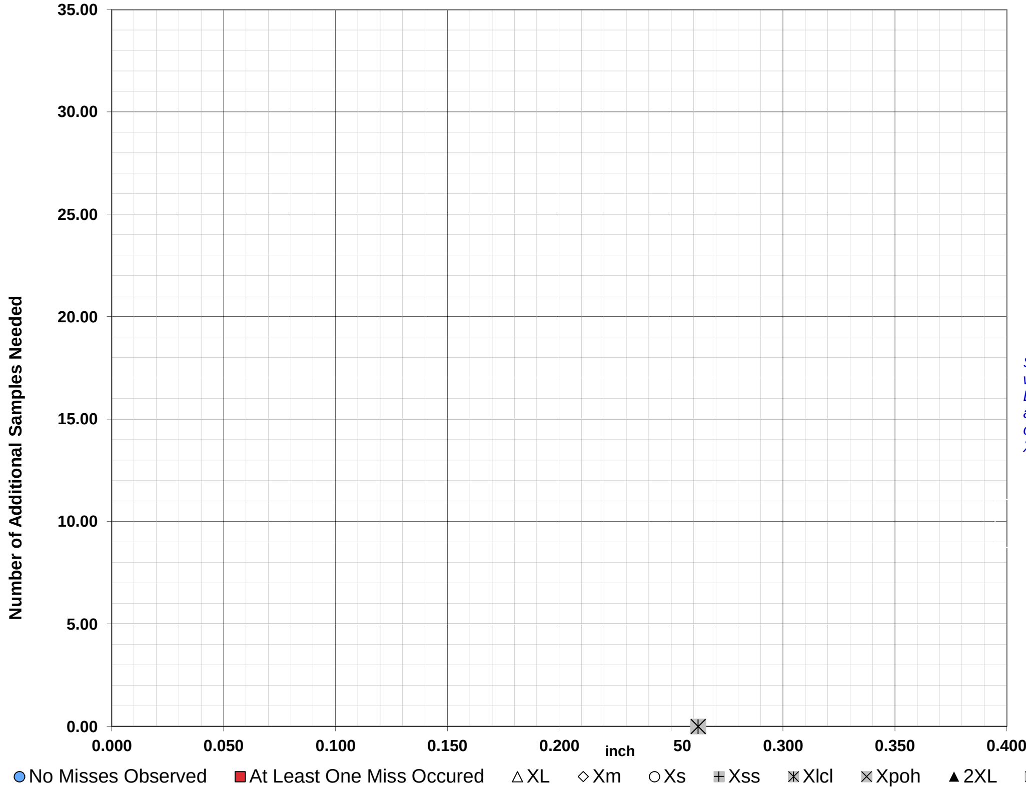


TABLE C

	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*

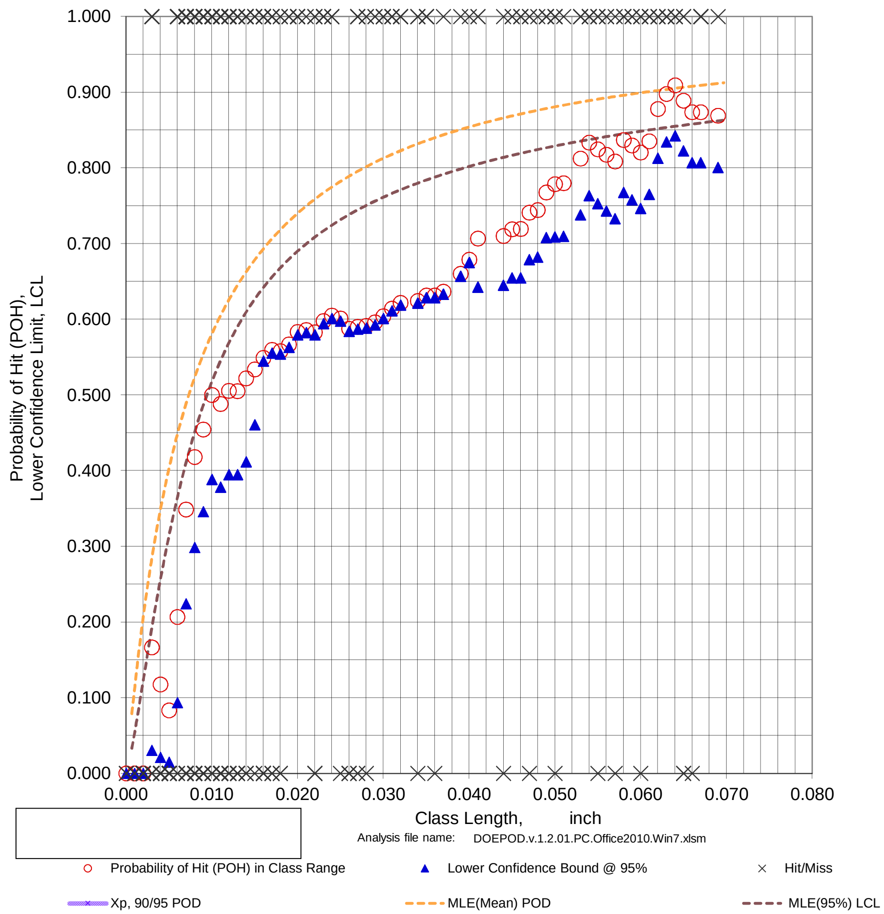
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

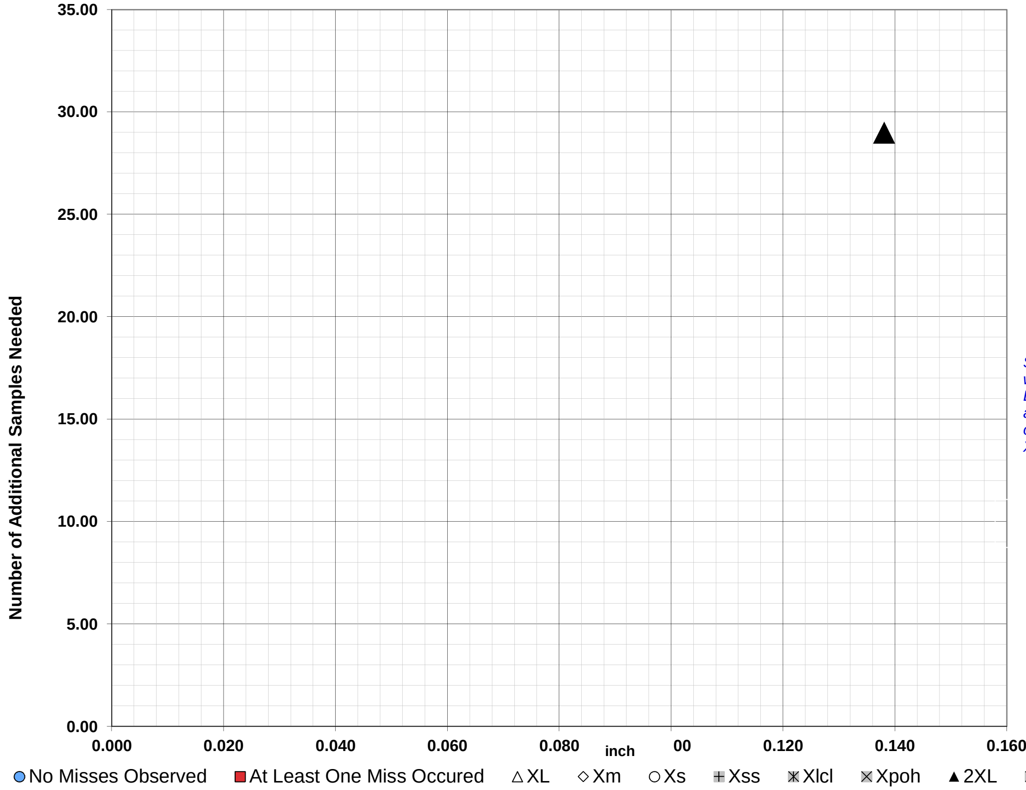


TABLE C

	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*

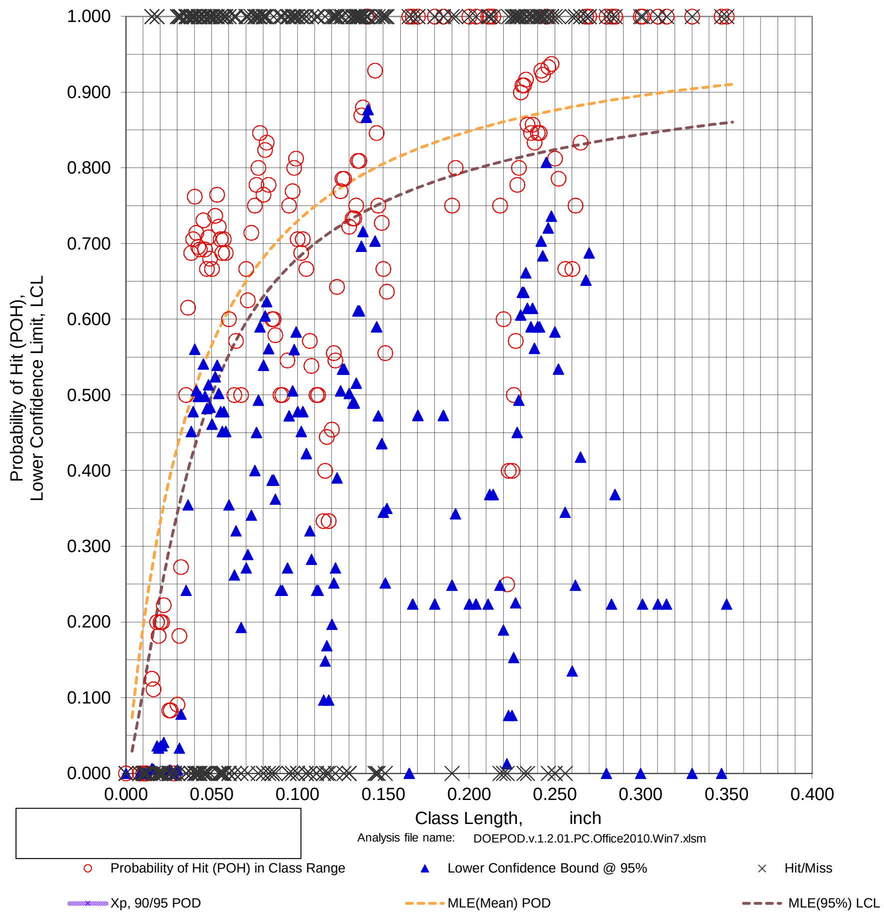
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

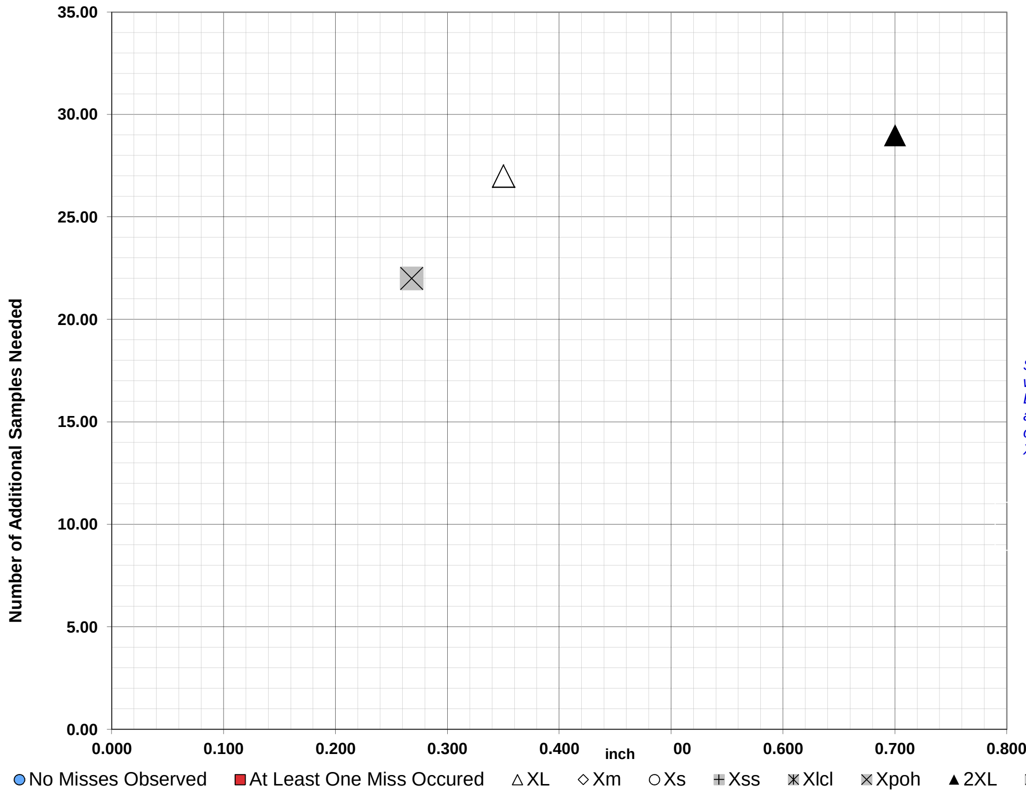


TABLE C

	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

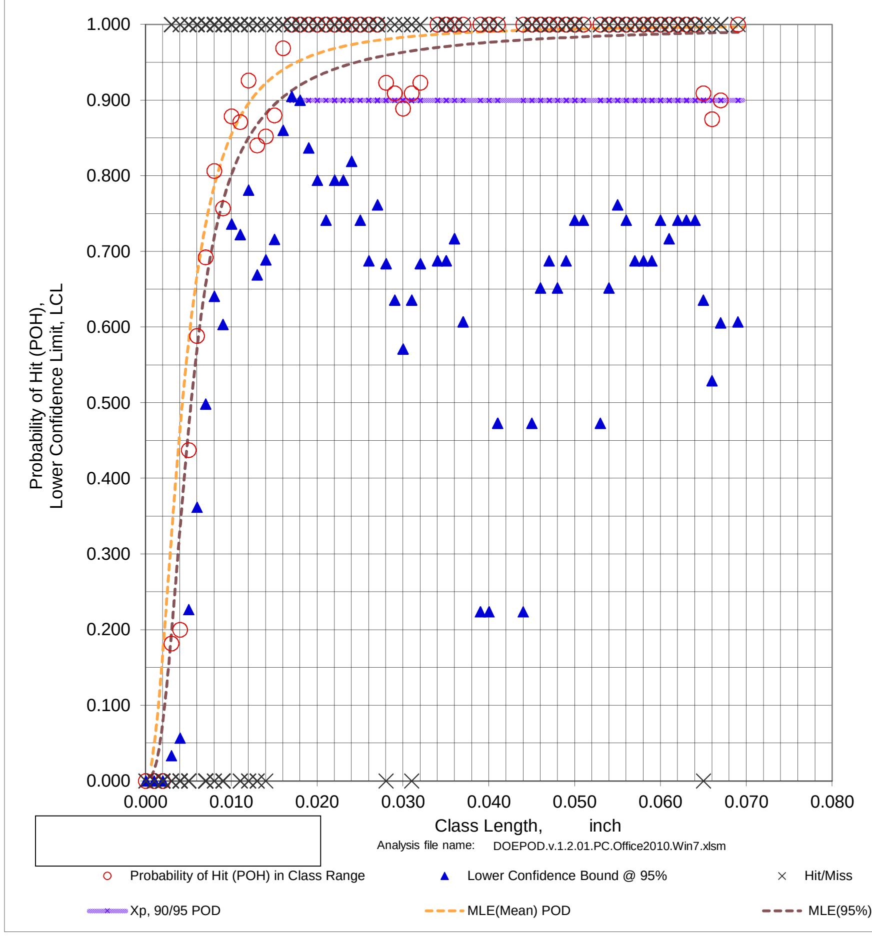
TABLE B*

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

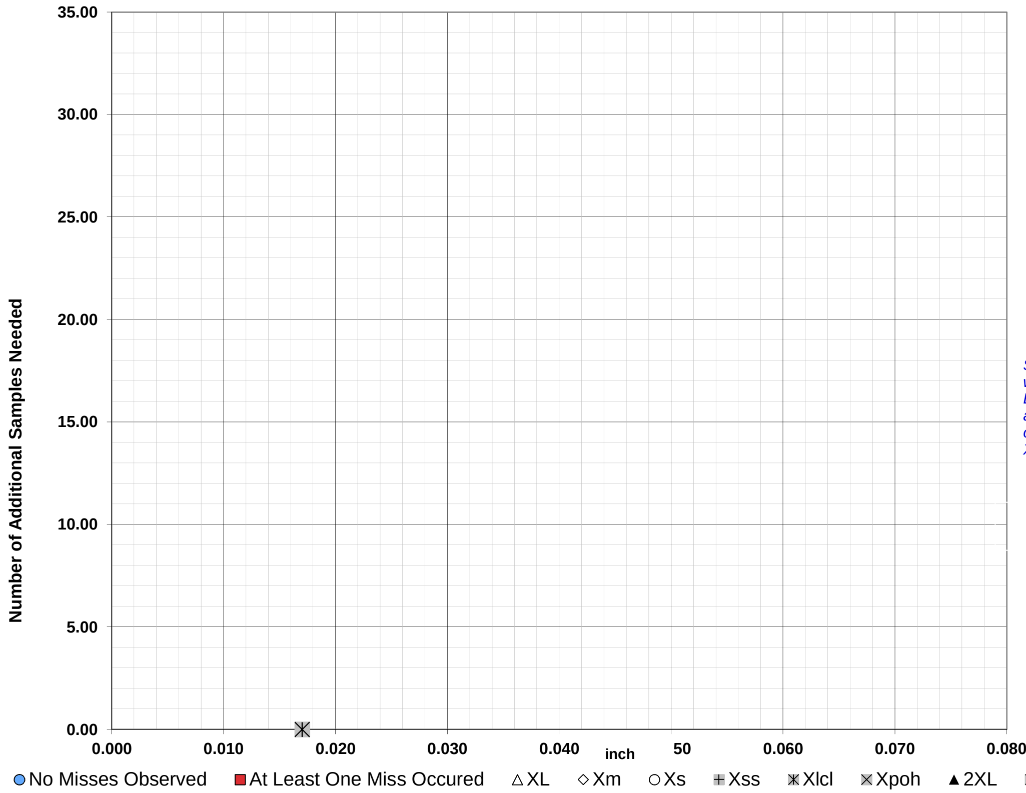


TABLE C

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

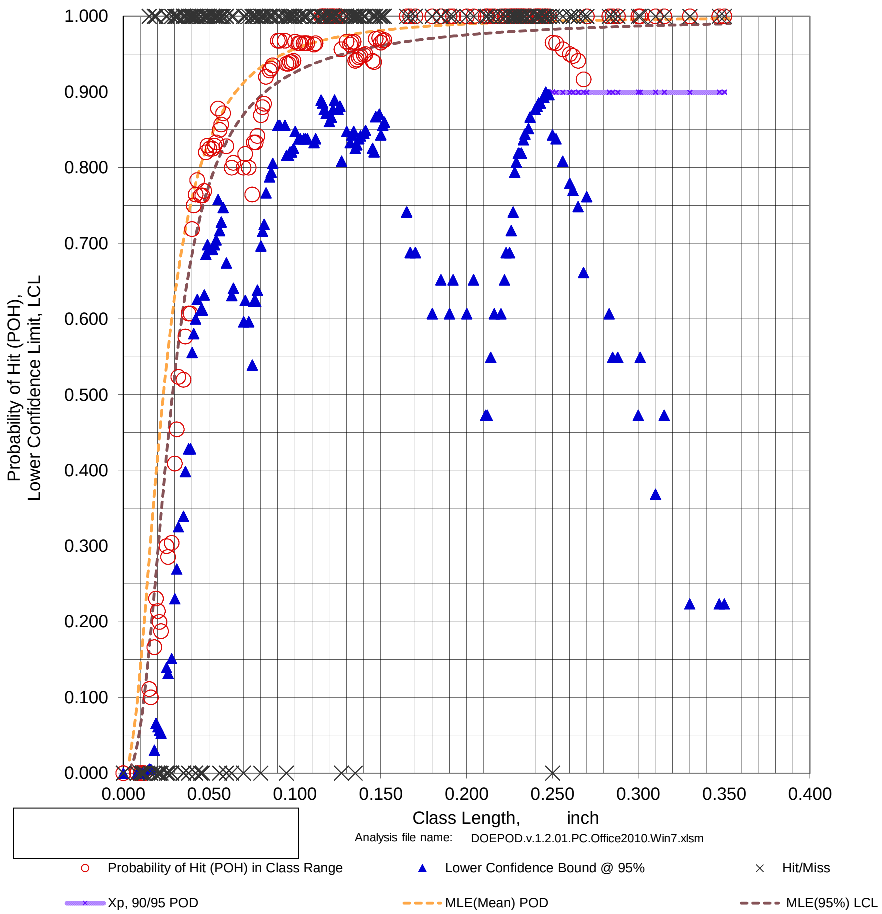
TABLE B*

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

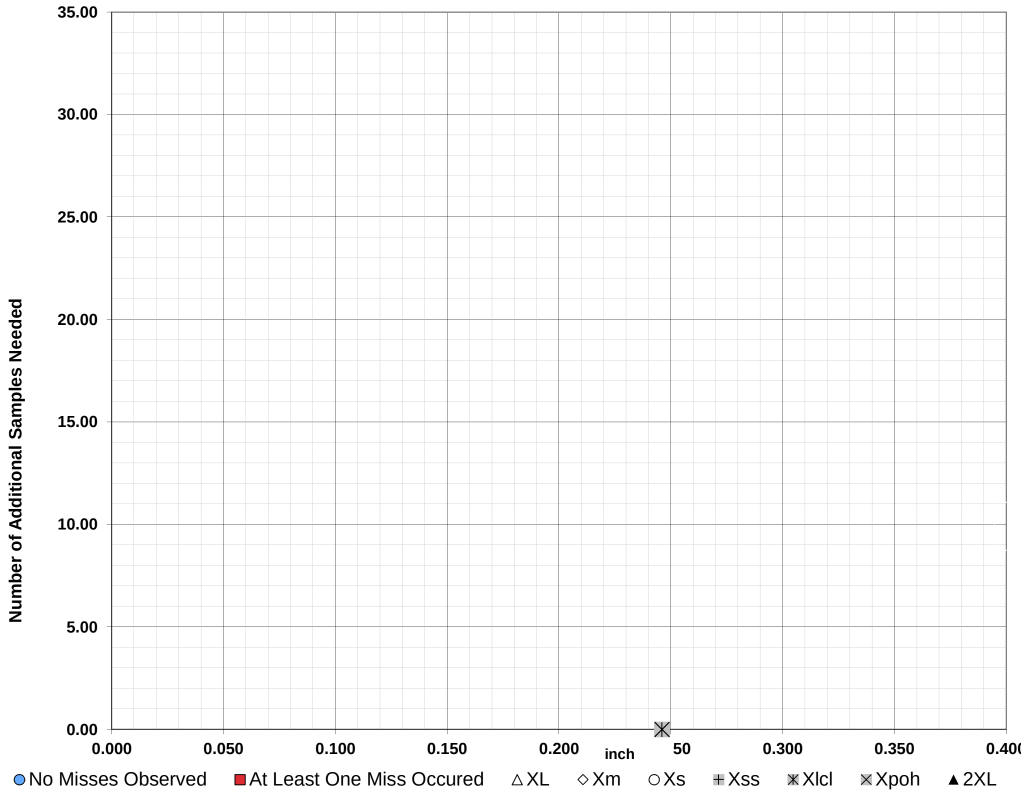


TABLE C

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.

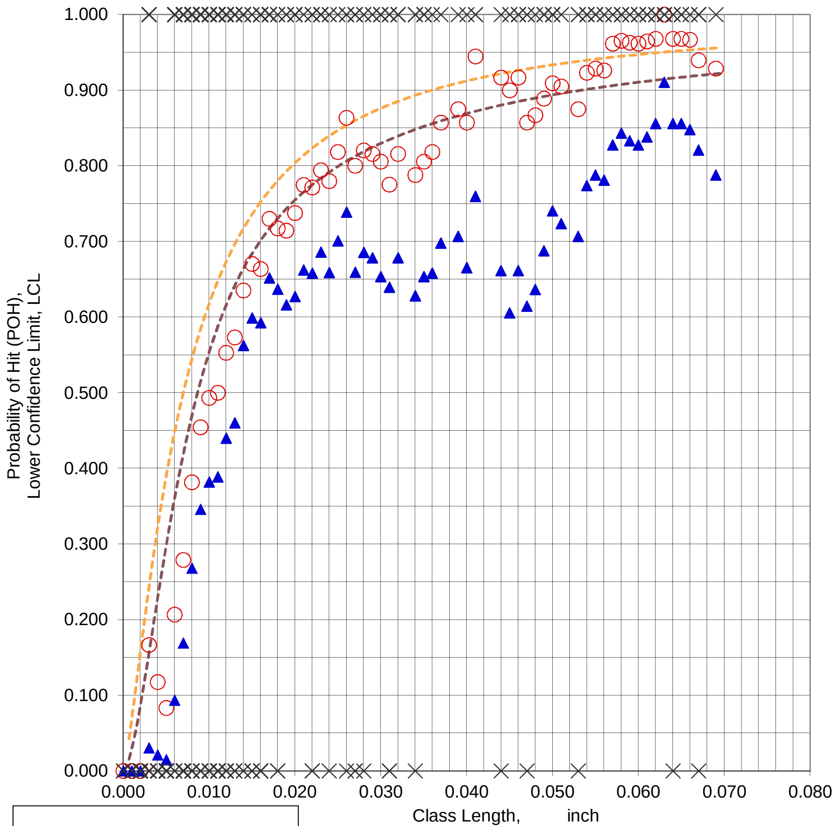
Xpod,Class Length	No. Need

* 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.



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 = **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

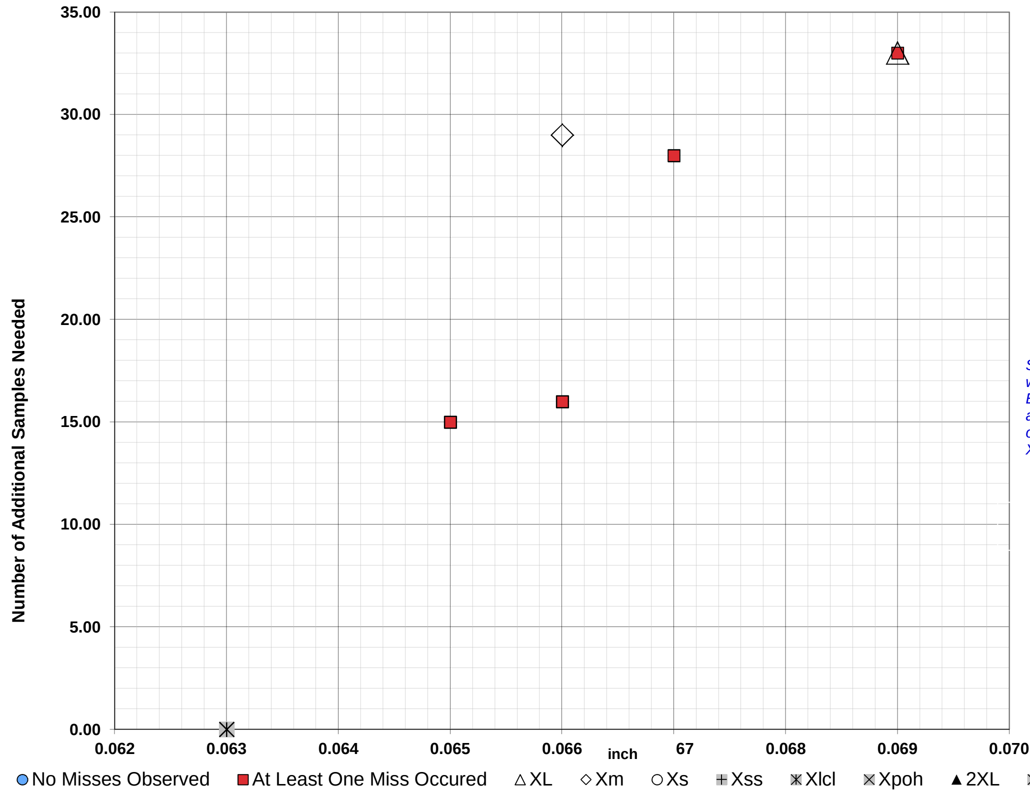


TABLE C

	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*

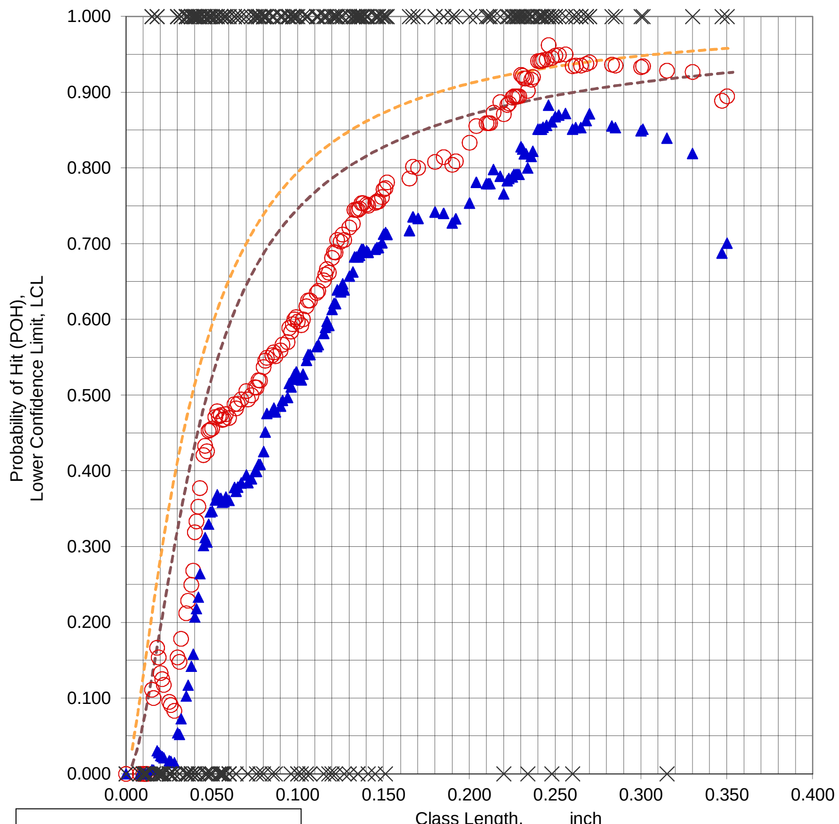
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

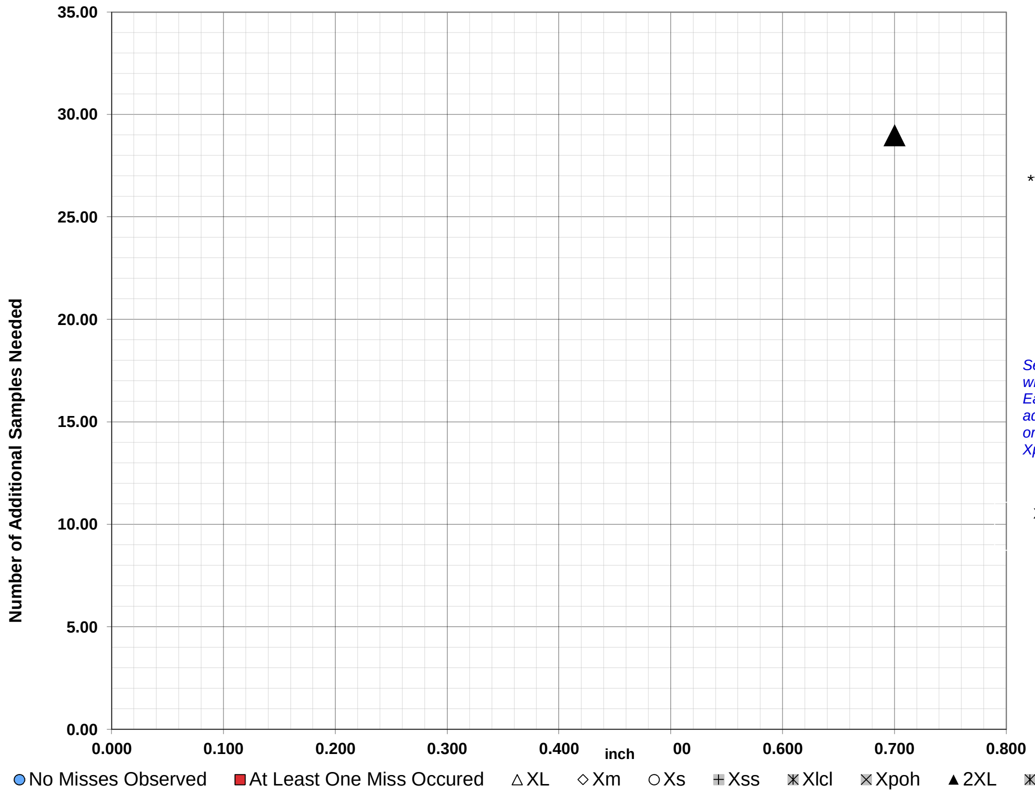


TABLE C

	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

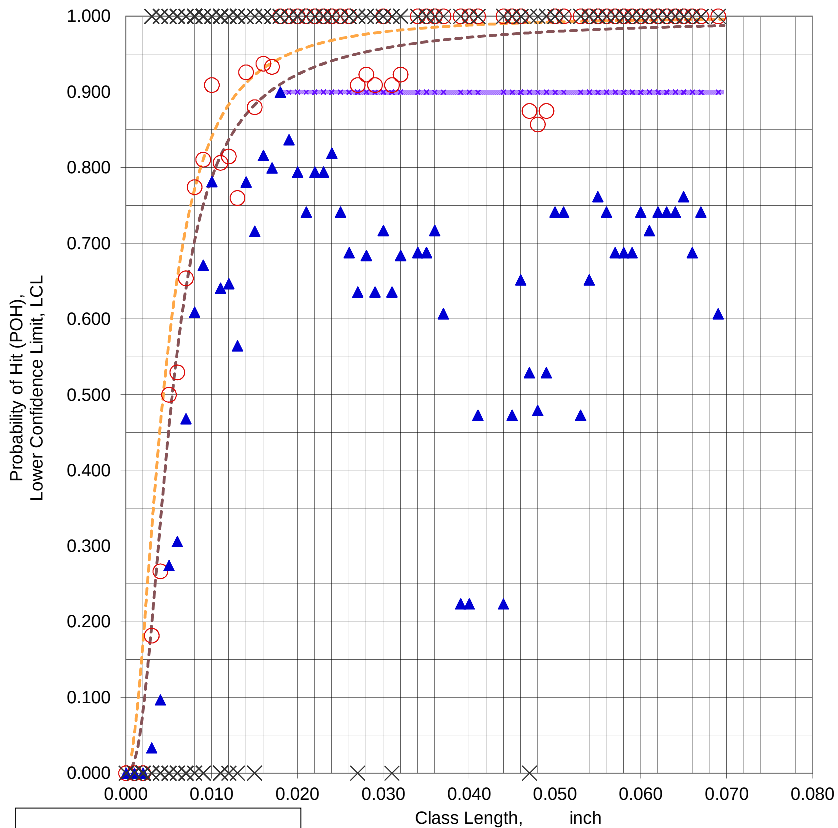
TABLE B*

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.



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 = 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

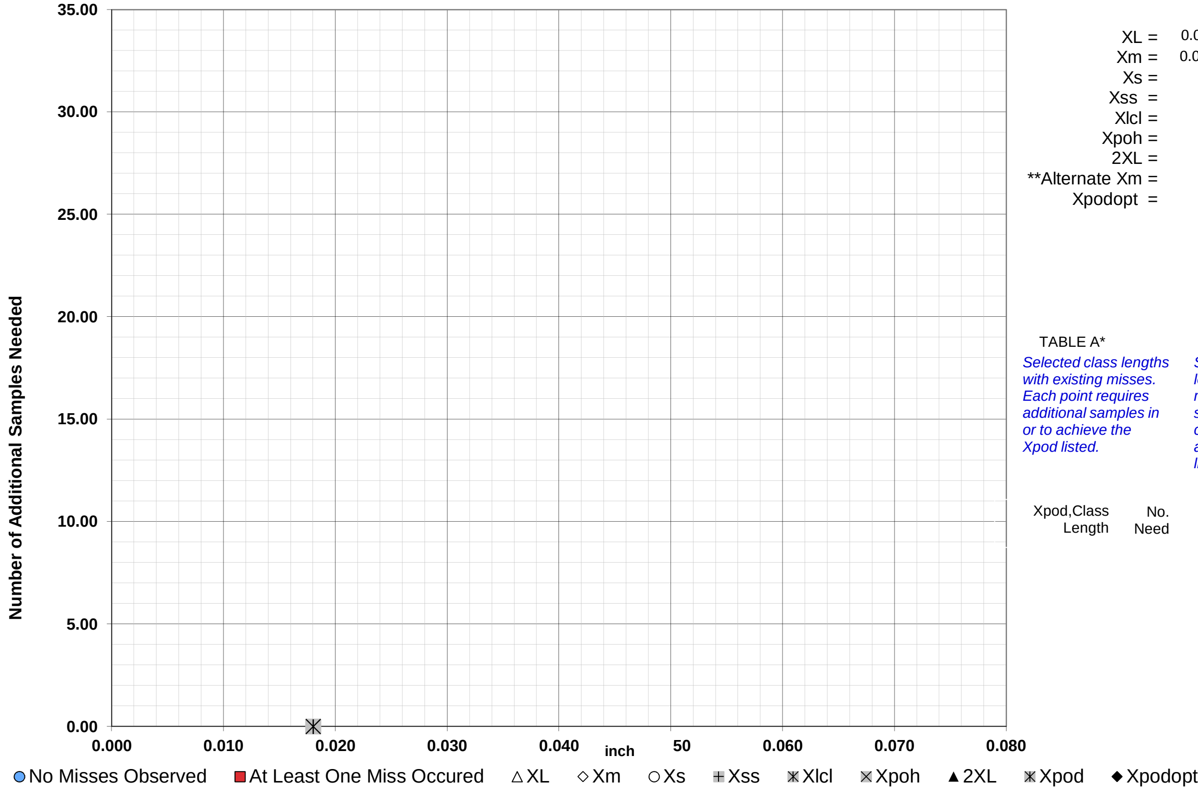


TABLE C

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

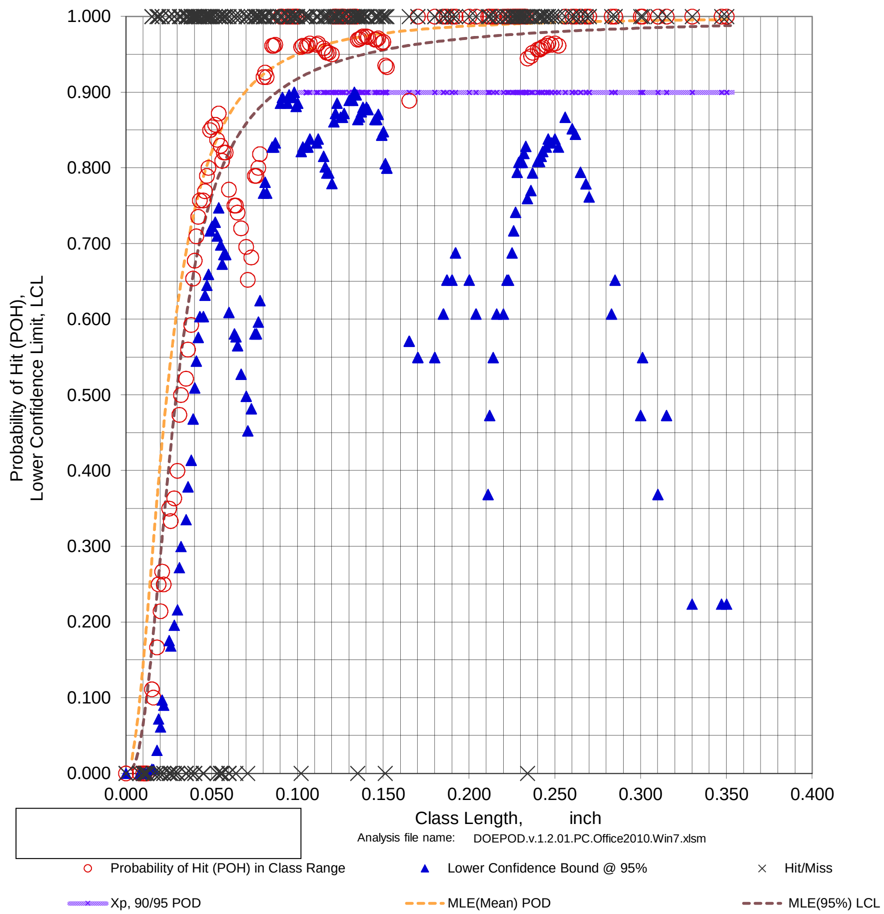
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.

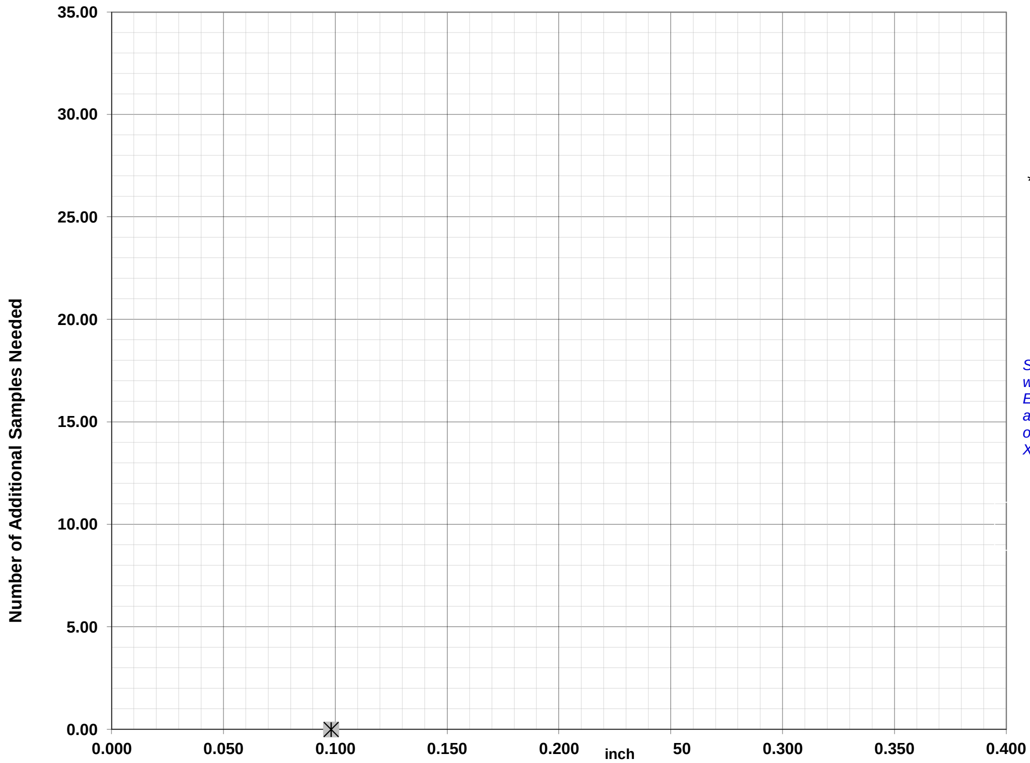
Survey/Optimum Xpoh = 0.000 inch Samples

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



● No Misses Observed ■ At Least One Miss Occured △ XL ◇ Xm ○ Xs ⊞ Xss ⋇ Xlcl ⋇ Xpoh ▲ 2XL ⋇ Xpod ◆ Xpodopt

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*

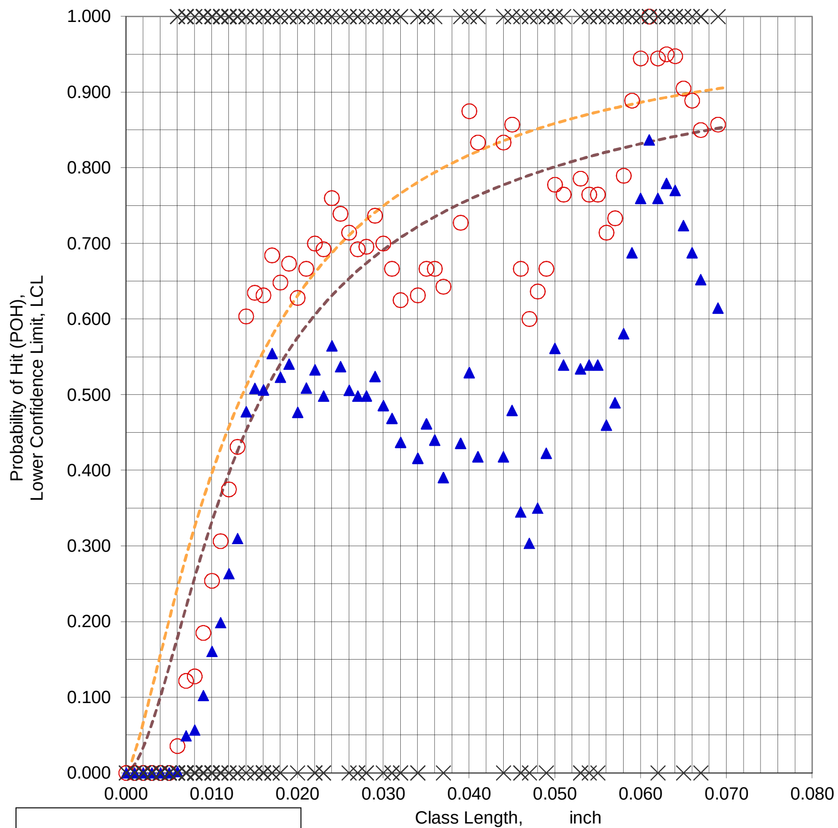
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

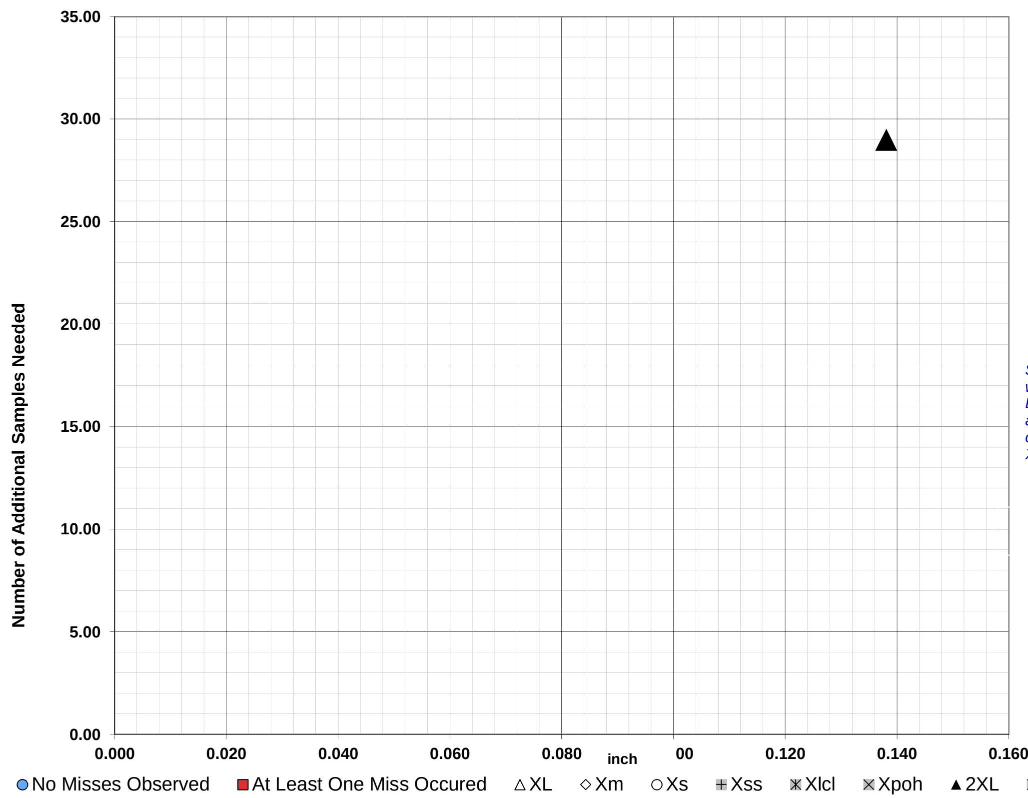


TABLE C

	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*

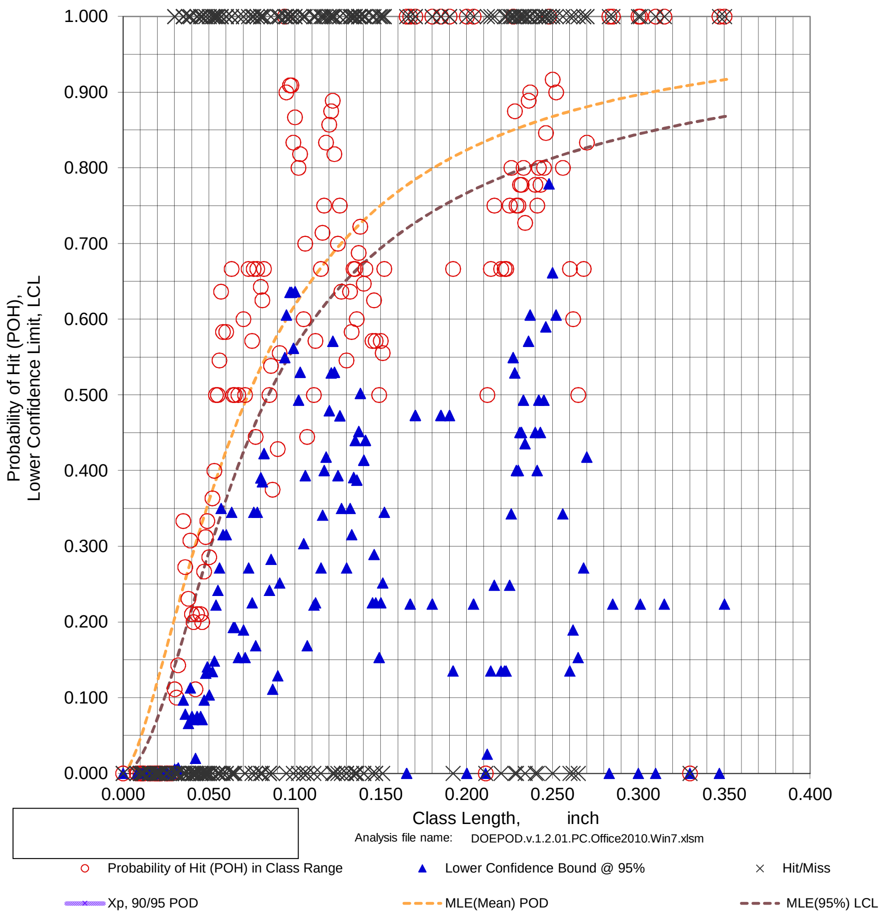
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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

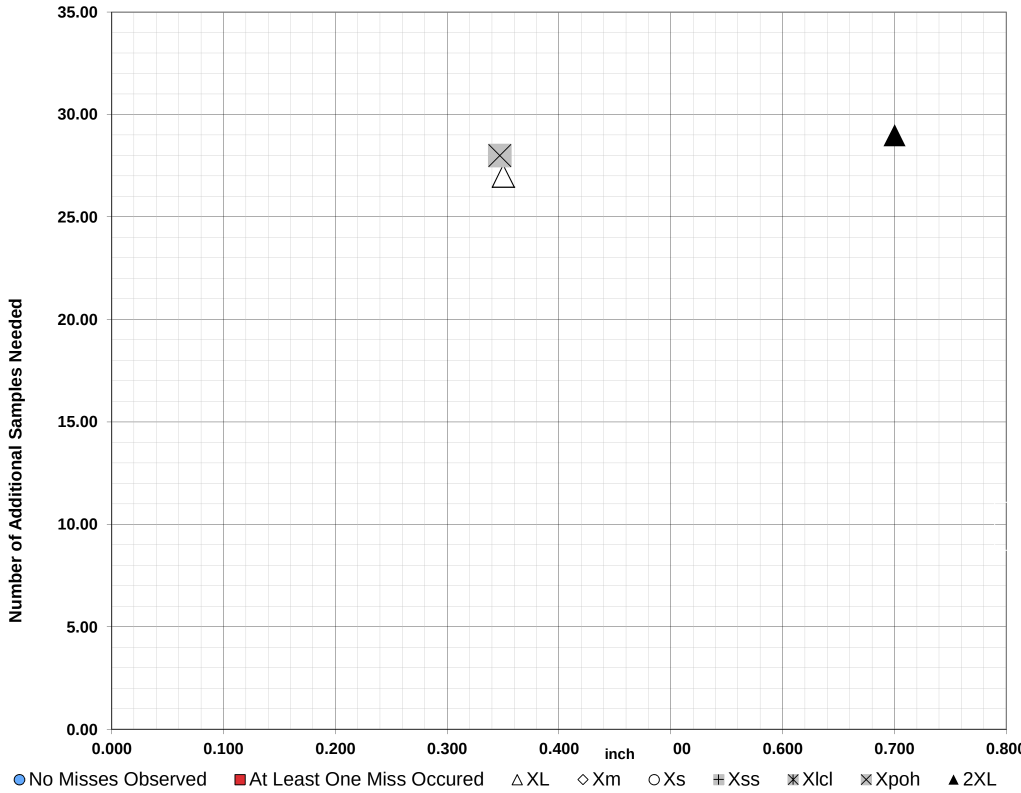


TABLE C

	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

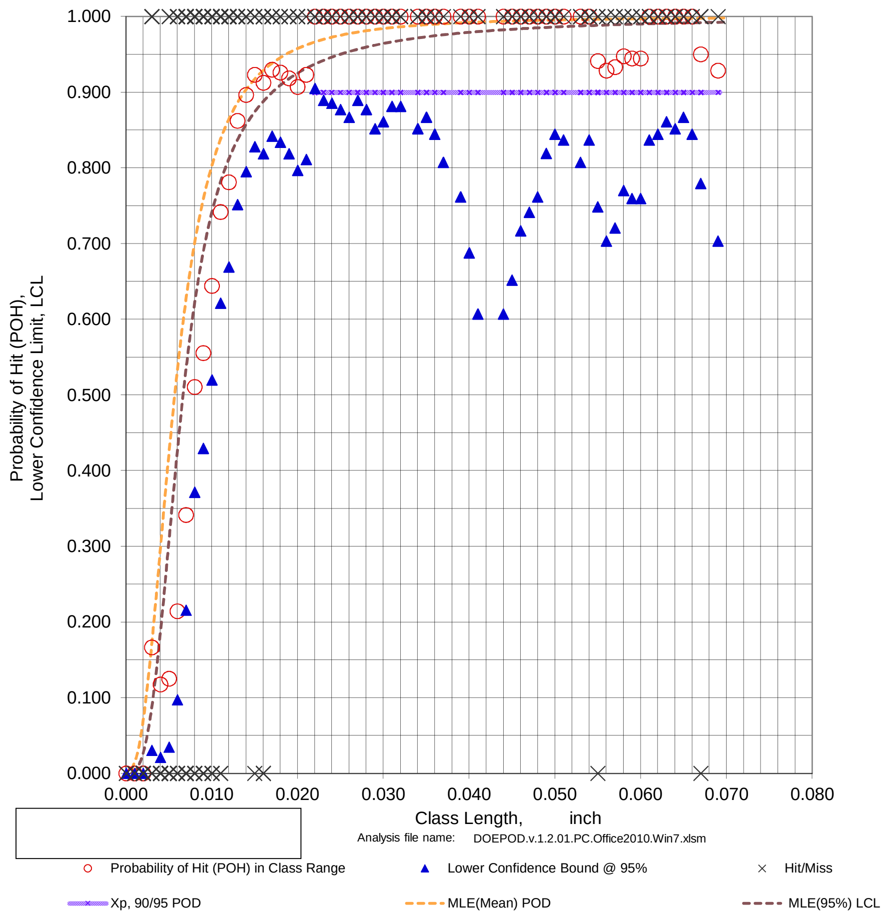
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

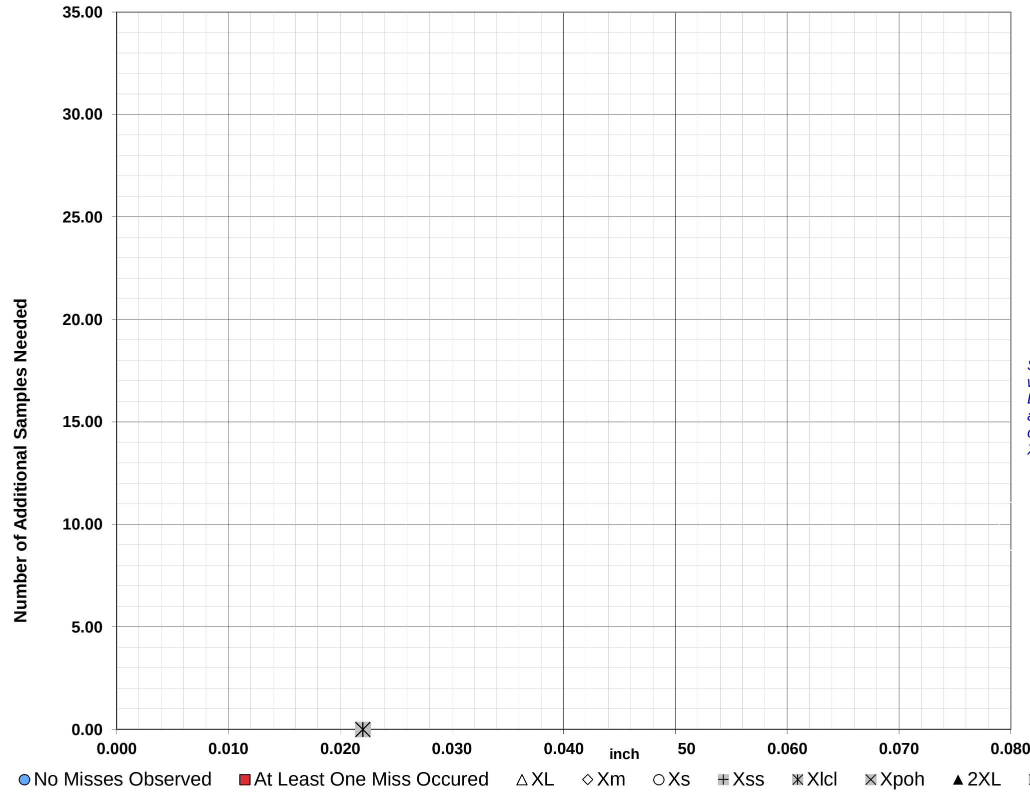


TABLE C

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

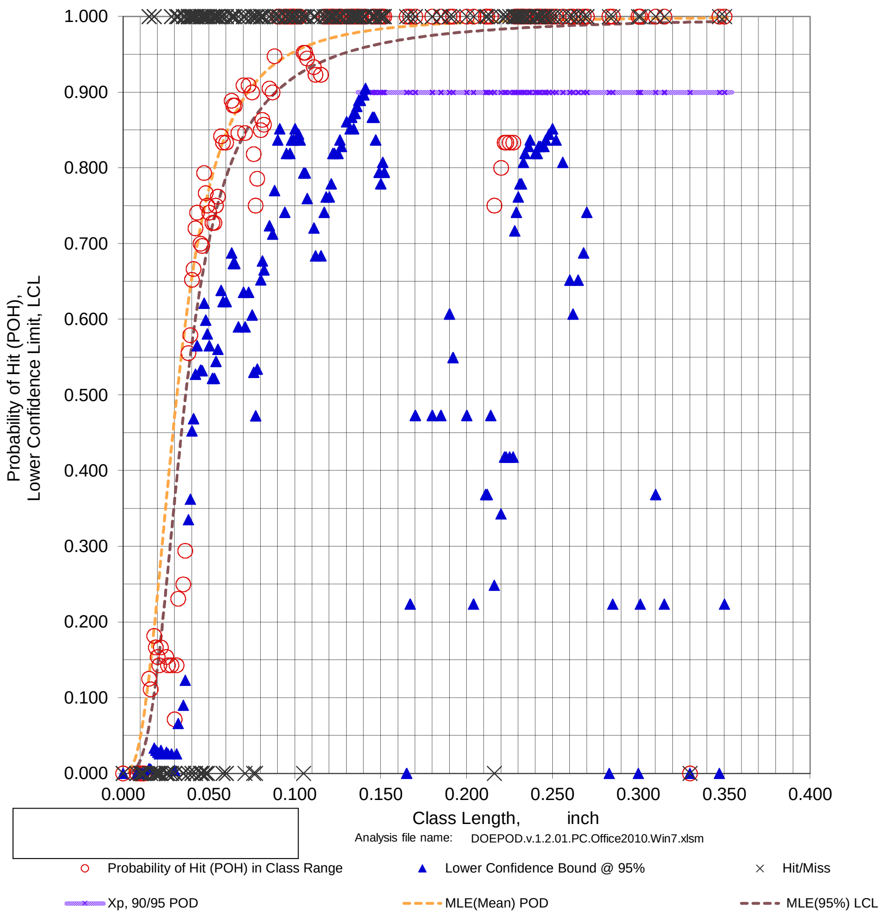
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

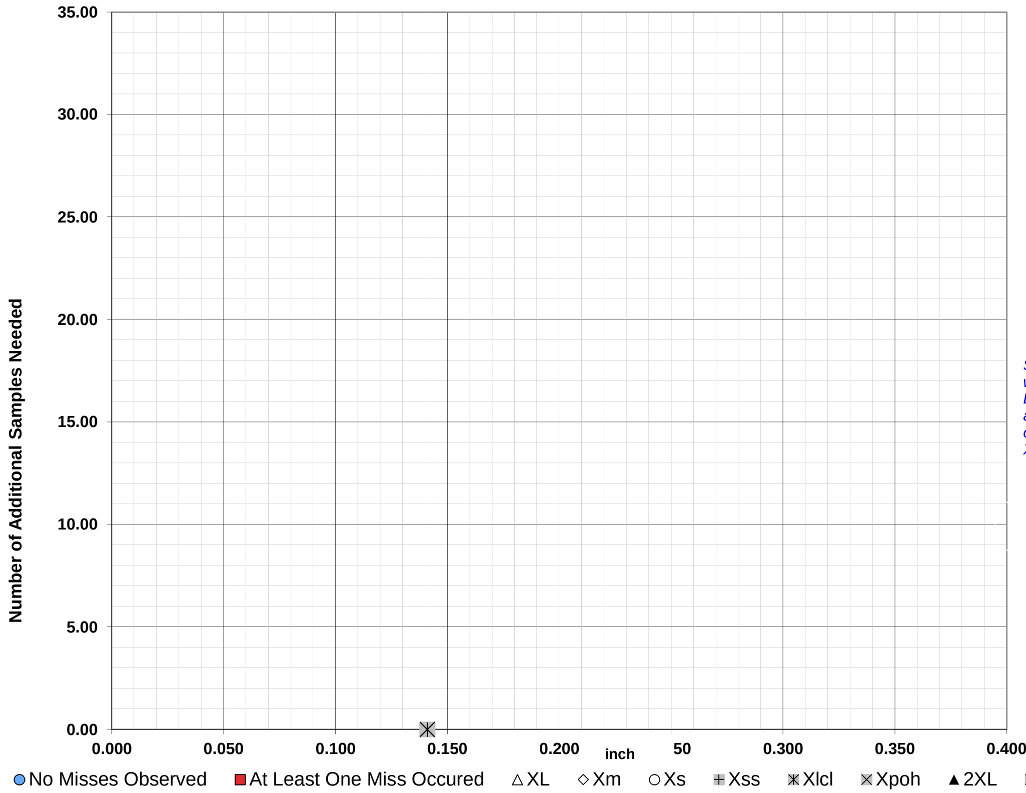


TABLE C

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.

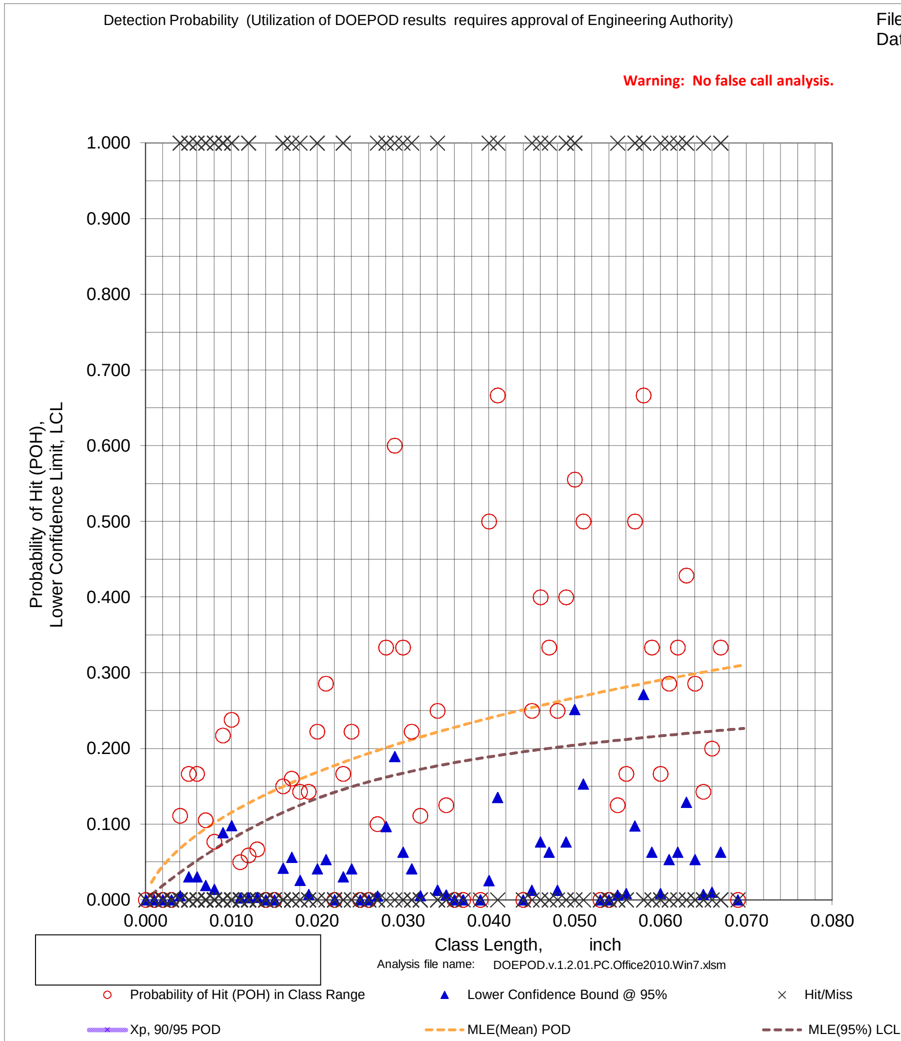
Xpod,Class Length	No. Need

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



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

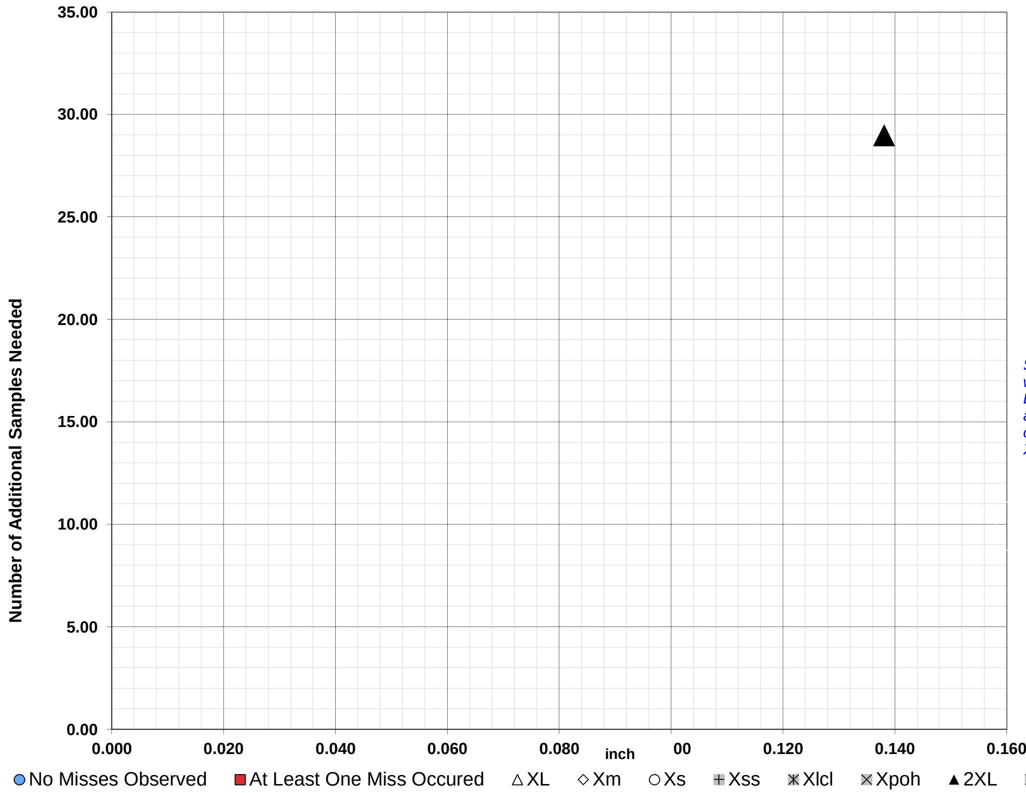


TABLE C

	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*

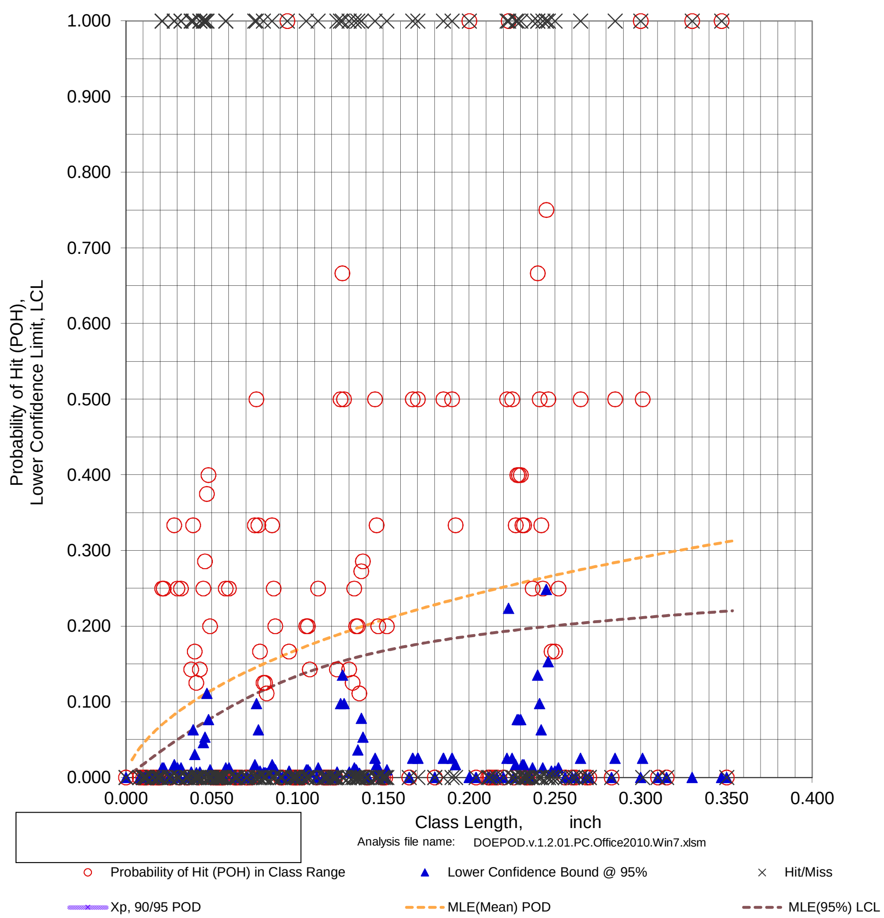
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

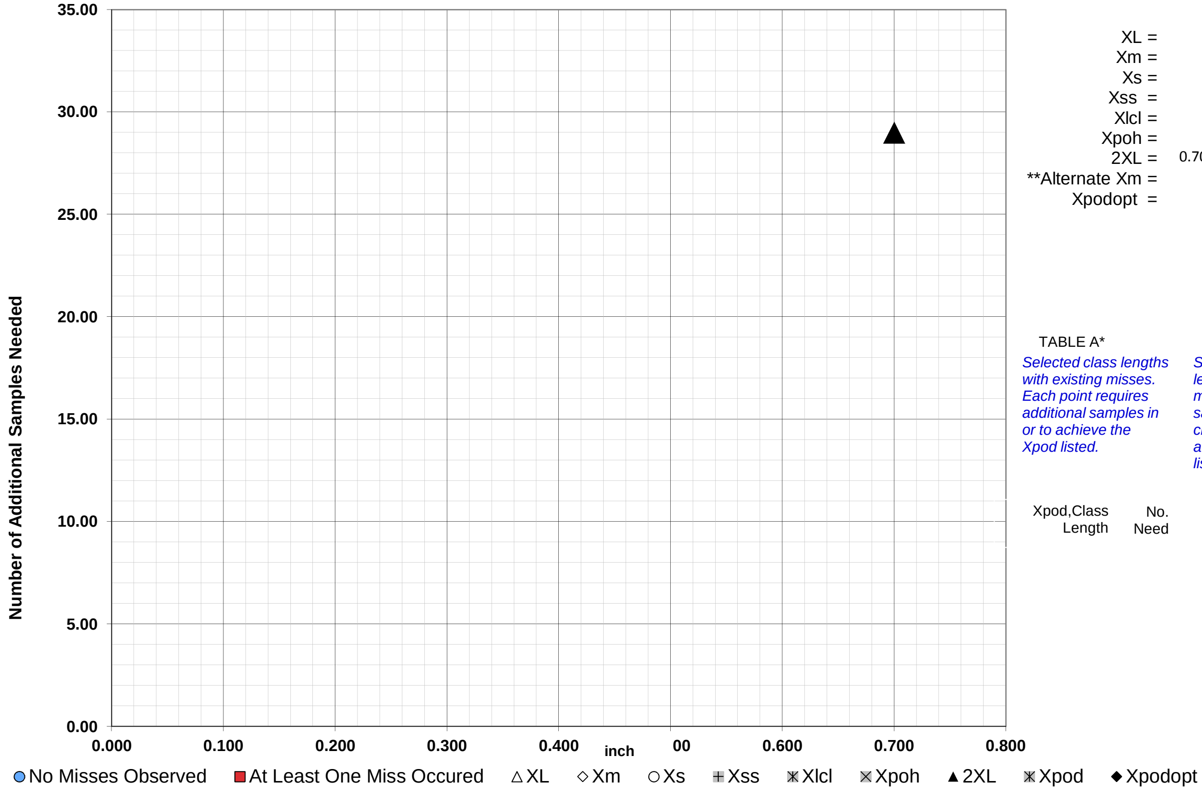


TABLE C

	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

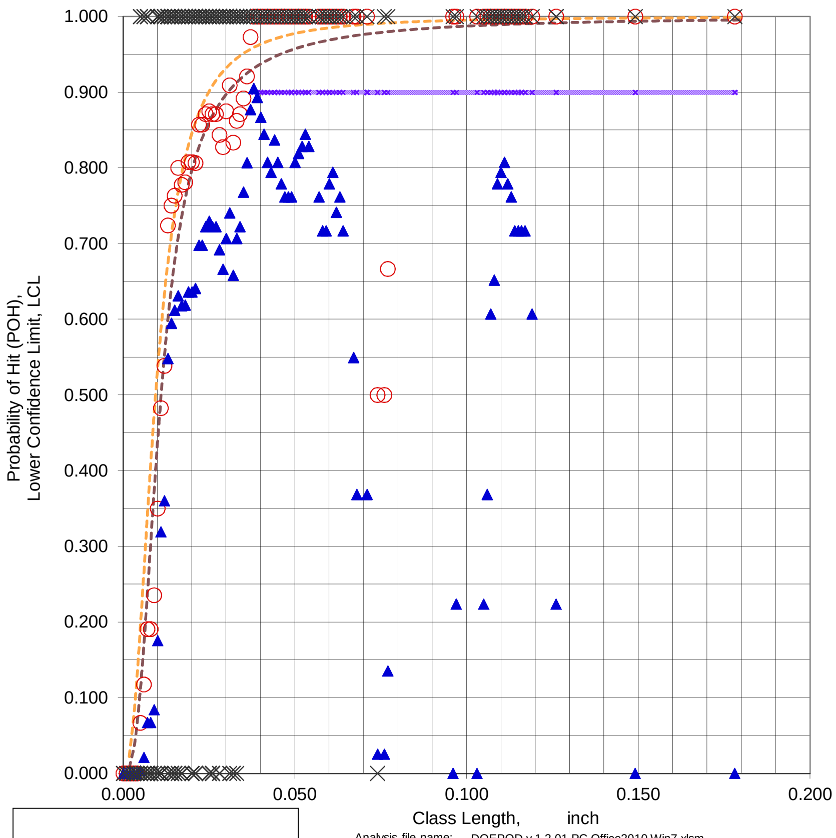
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

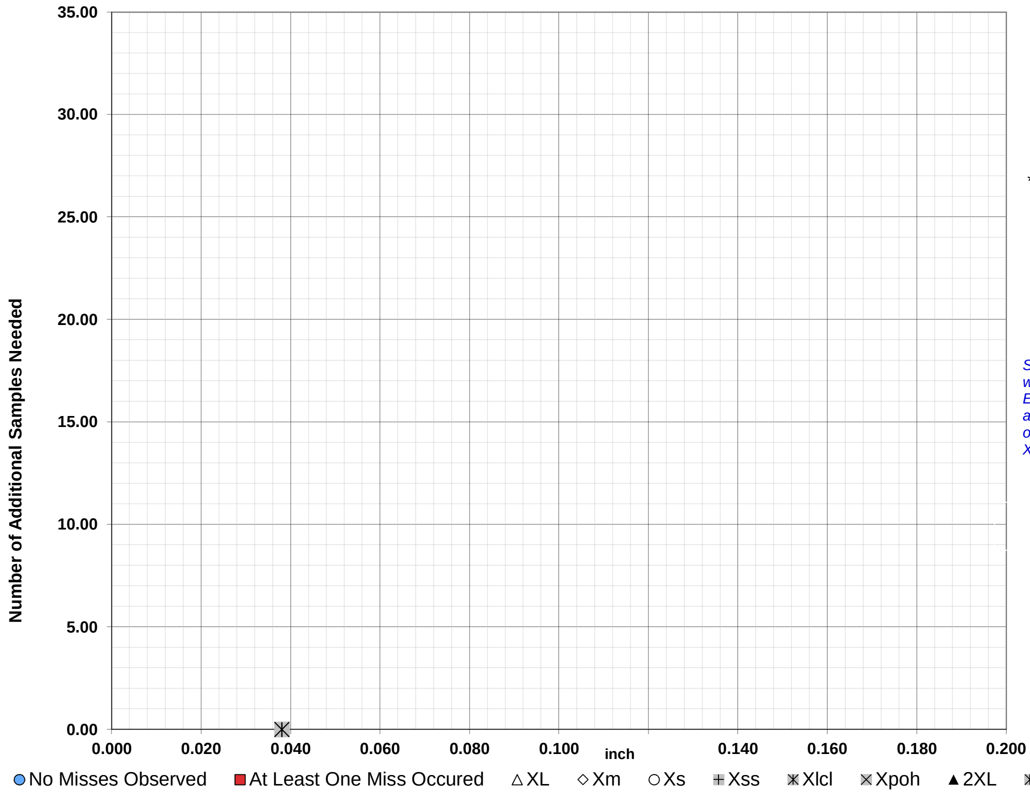


TABLE C

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

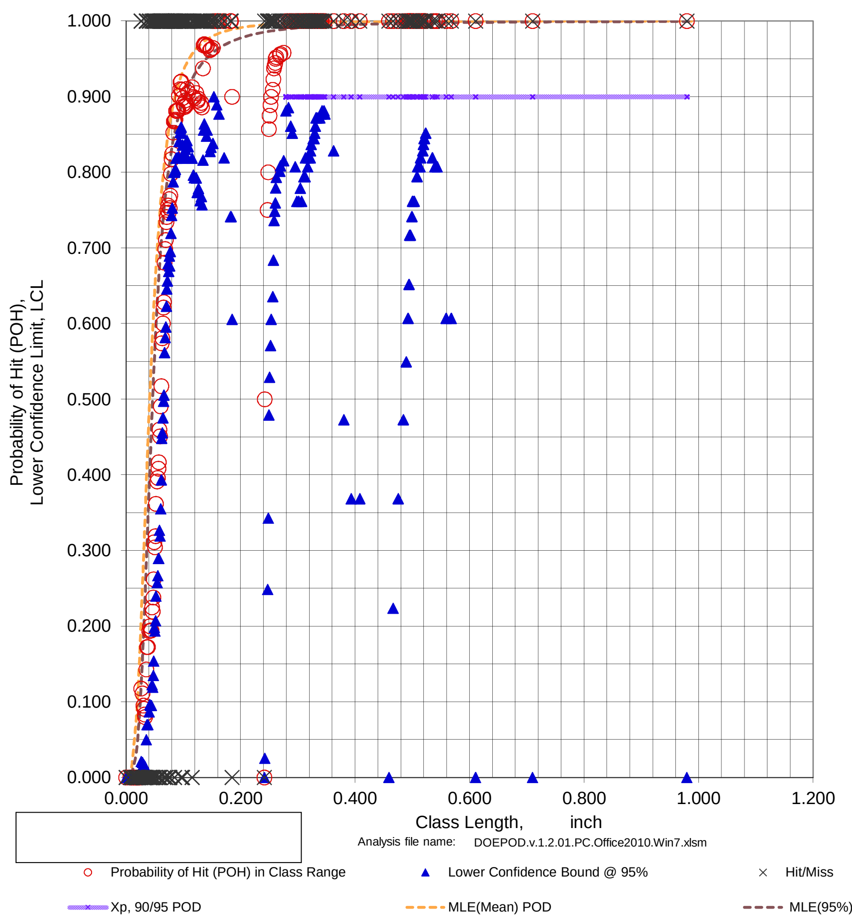
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

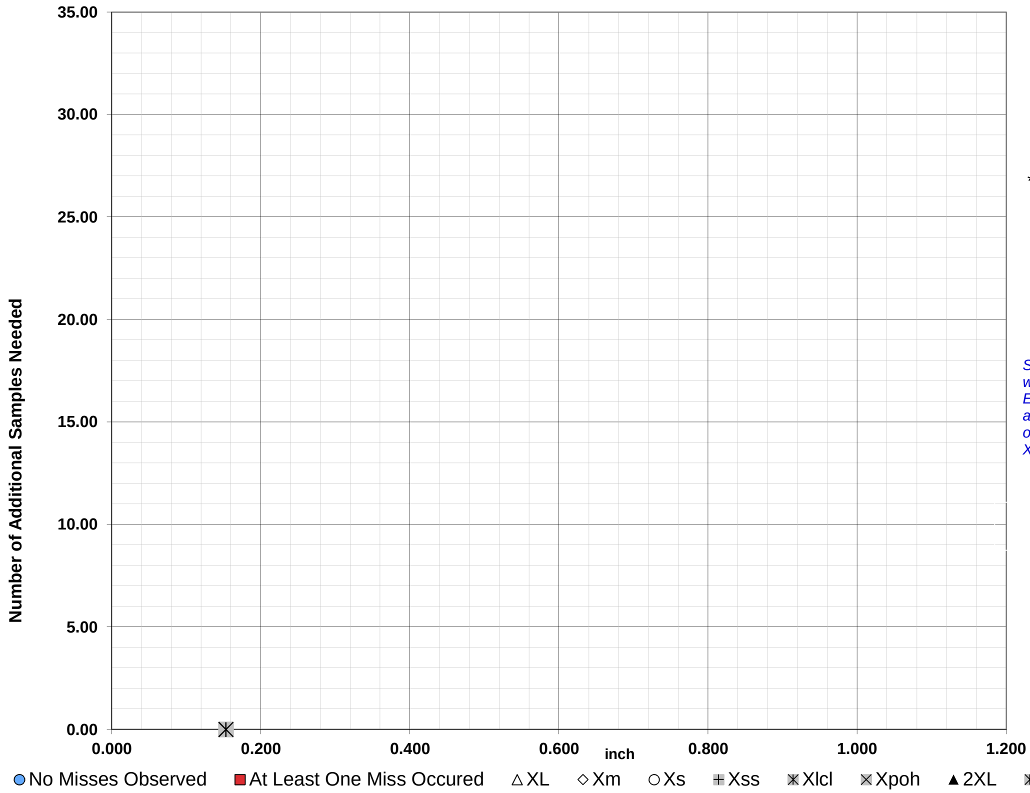


TABLE C

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

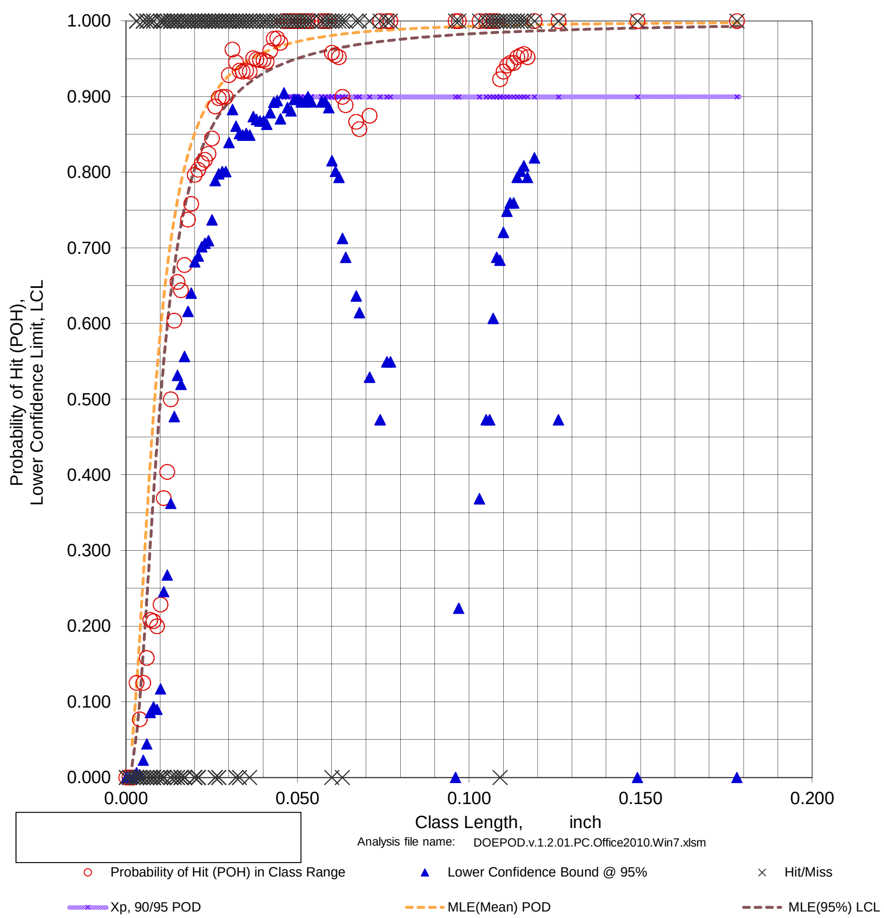
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

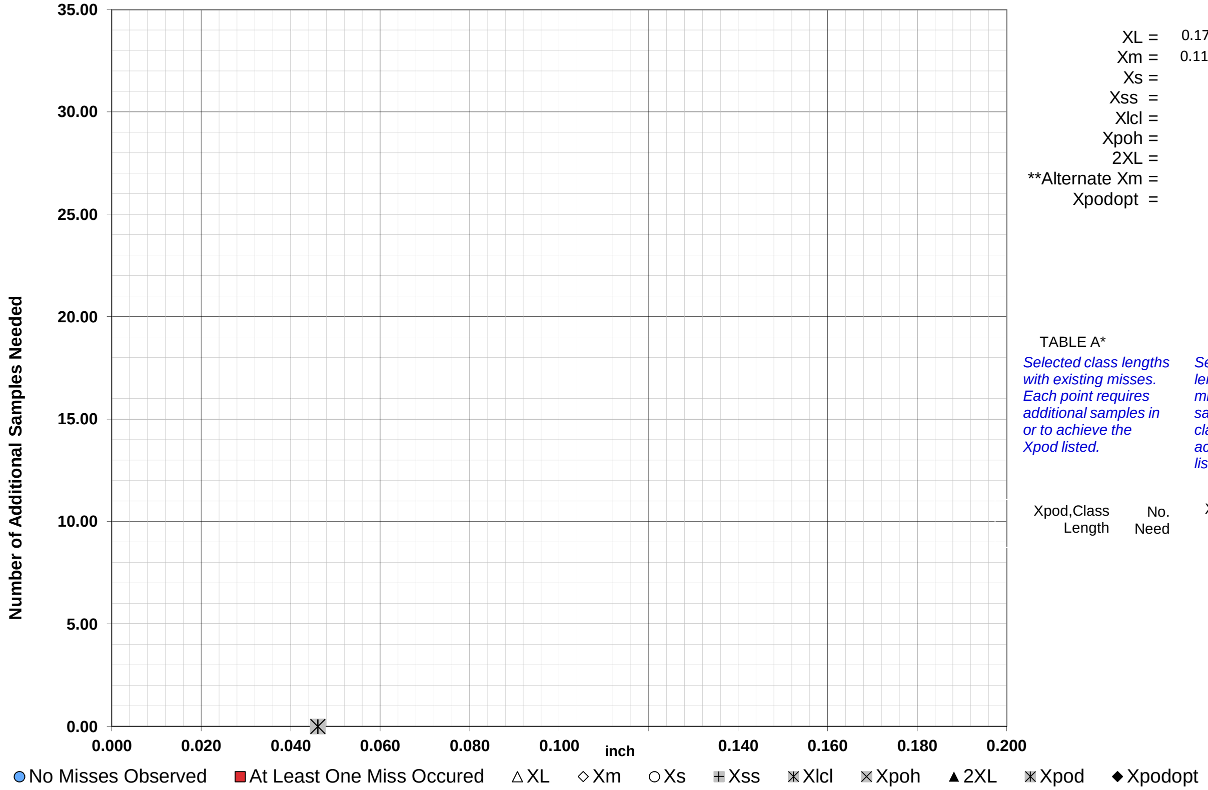


TABLE C

	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

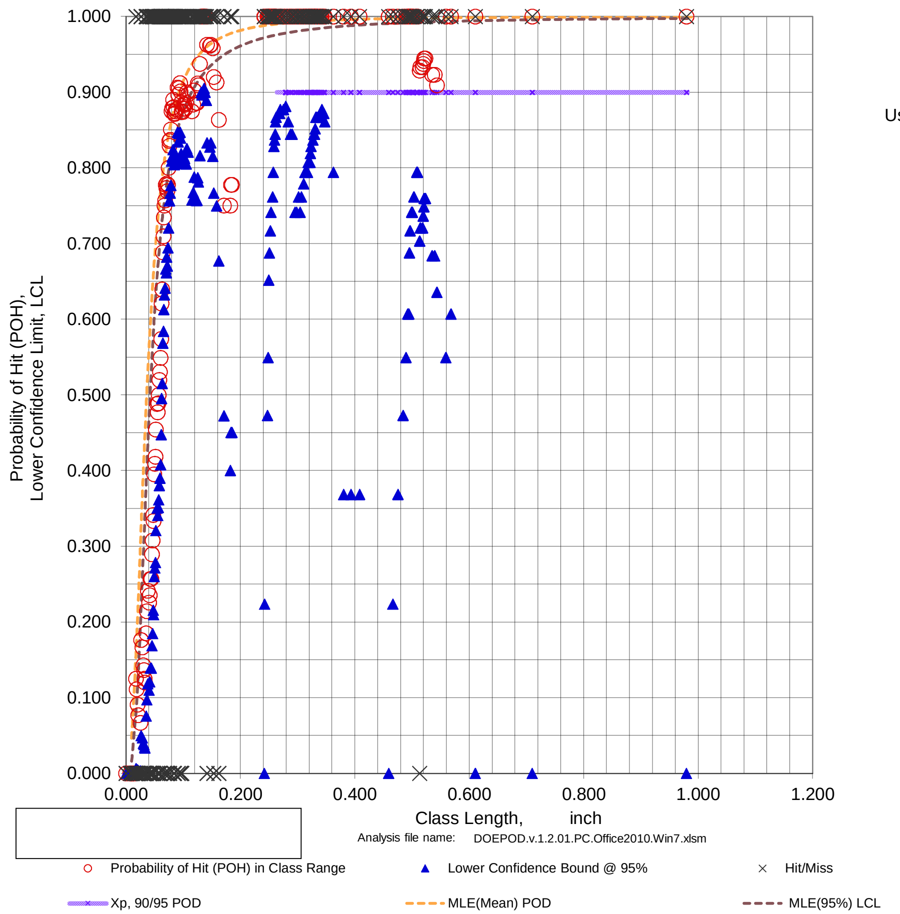
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

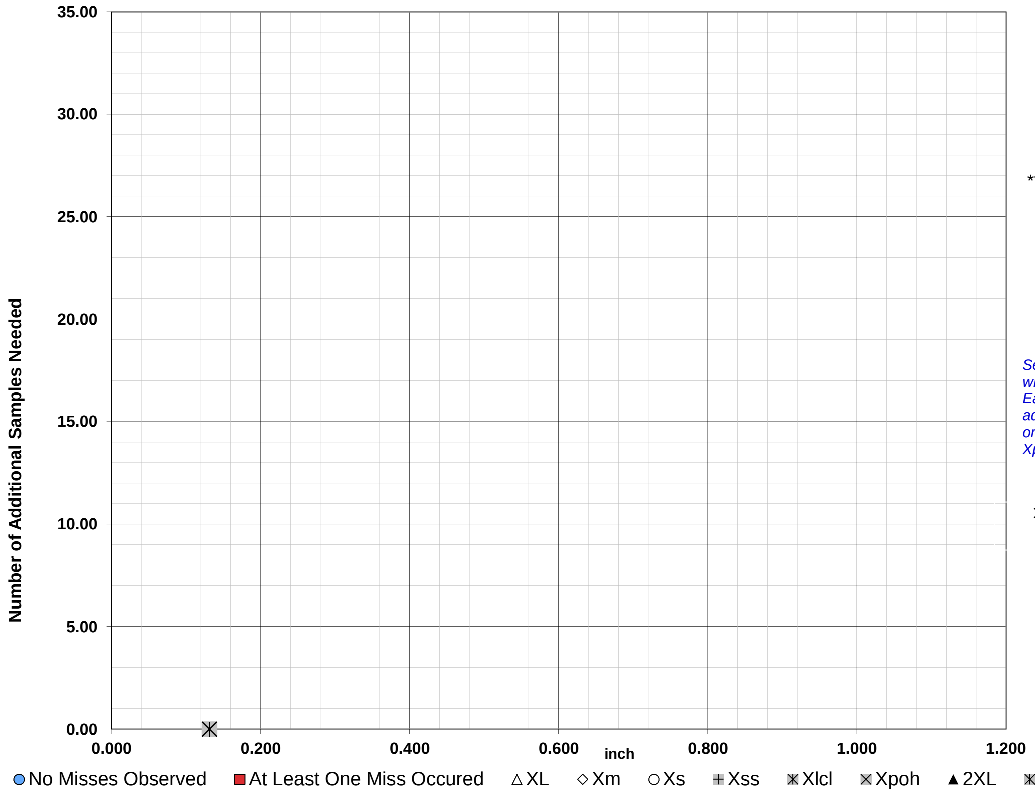


TABLE C

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

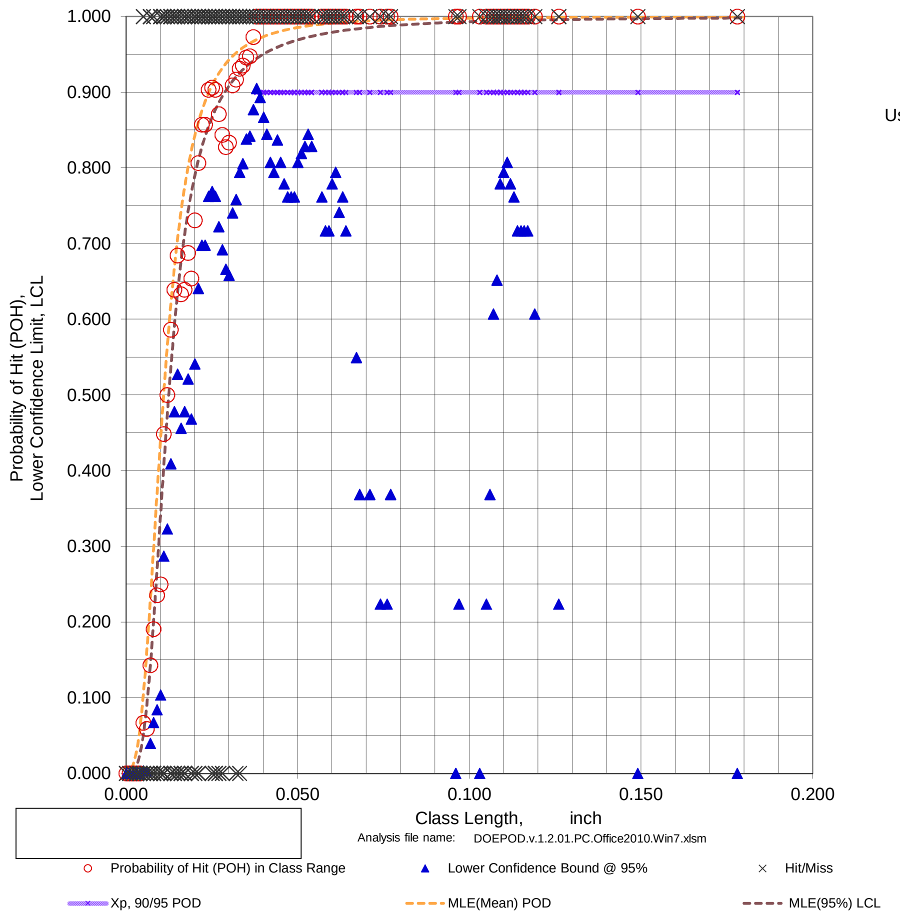
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

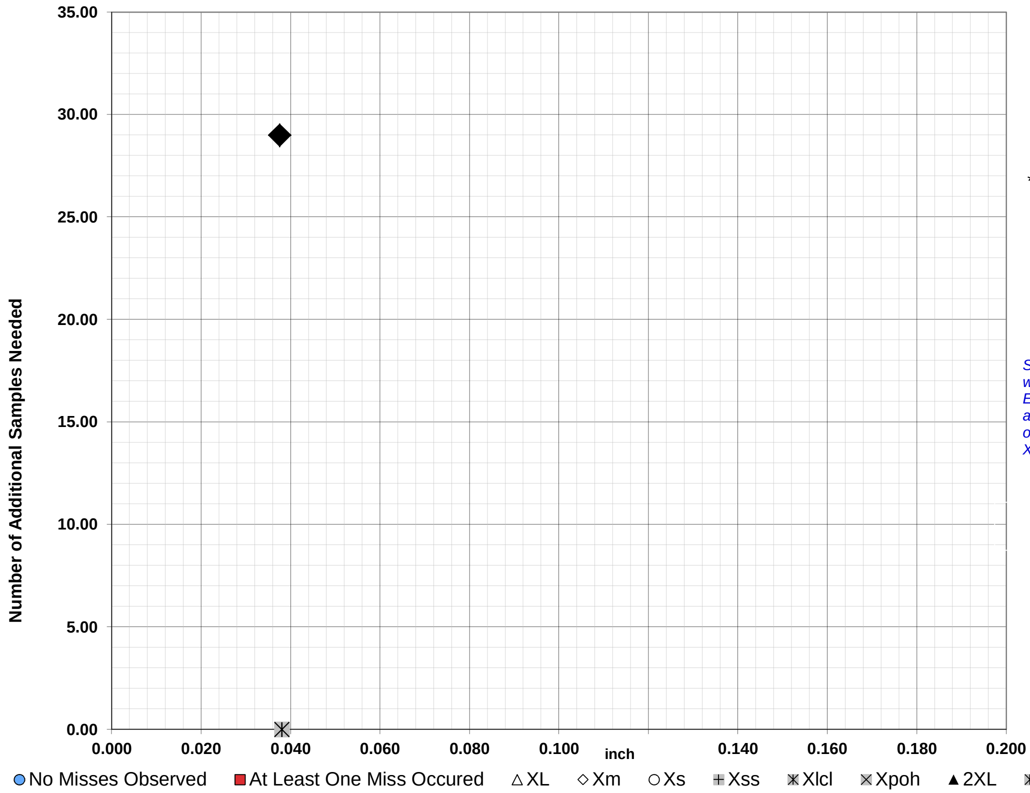


TABLE C

	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

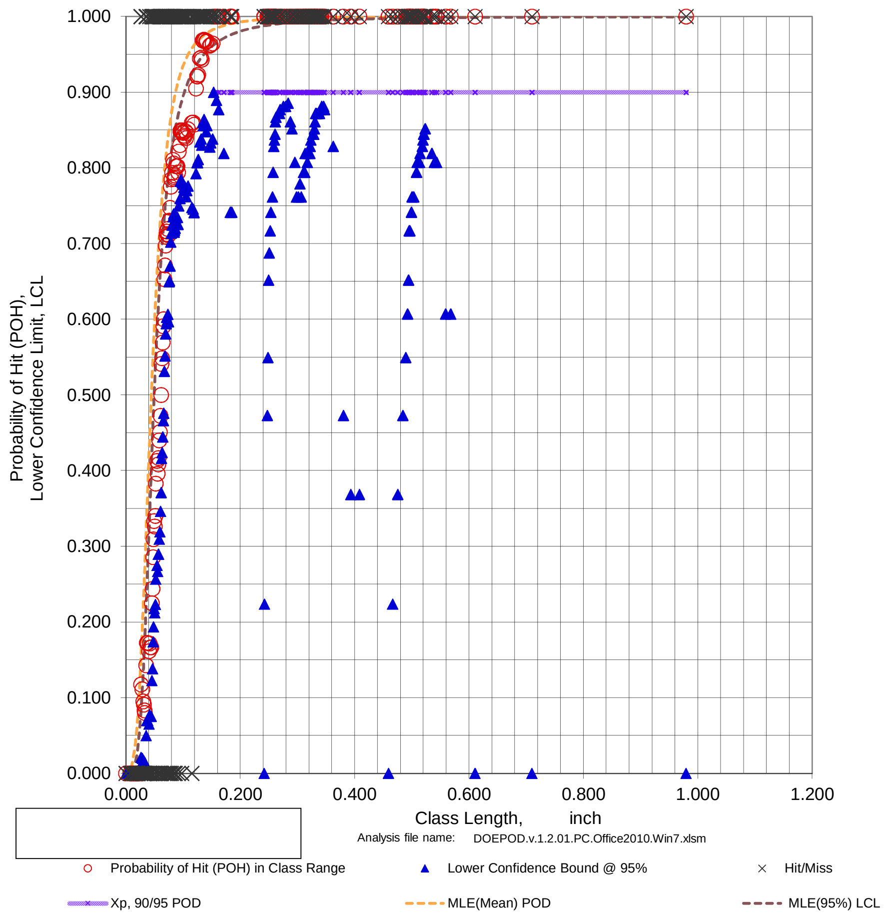
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

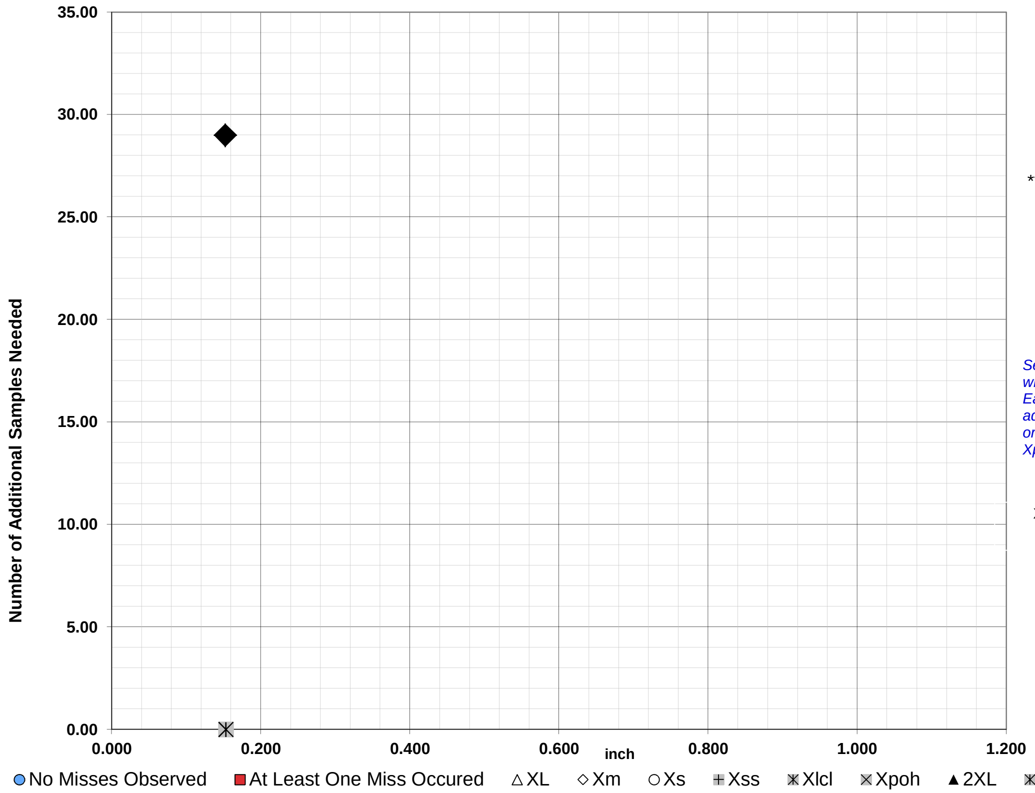


TABLE C

	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*

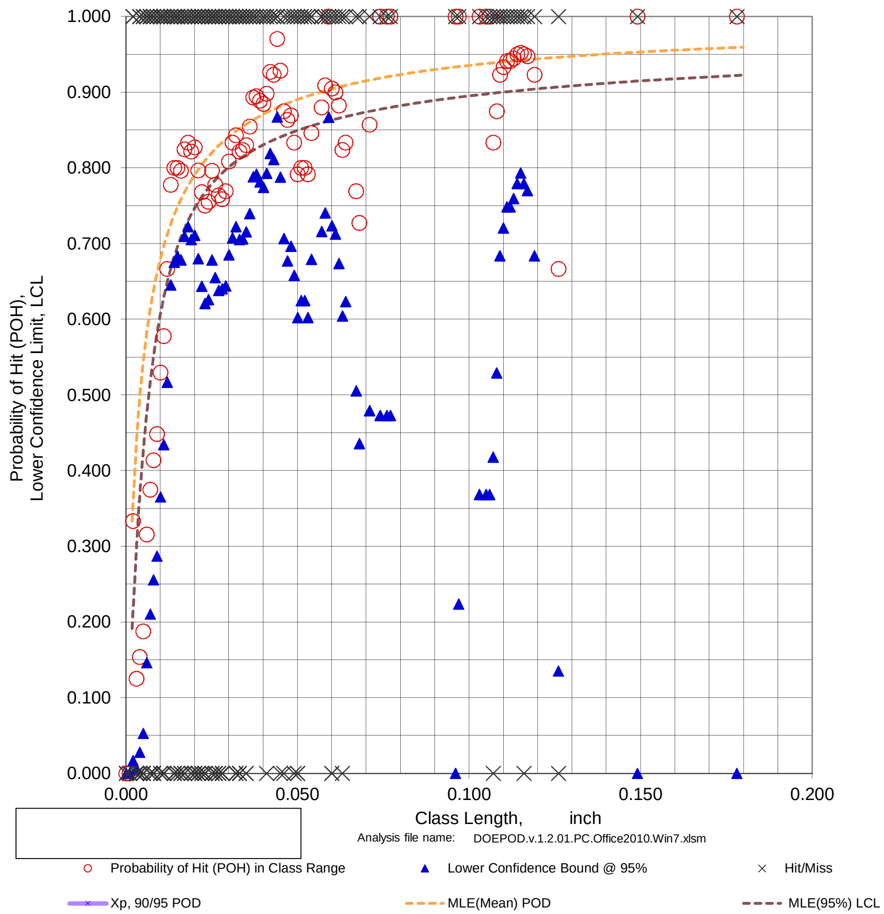
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

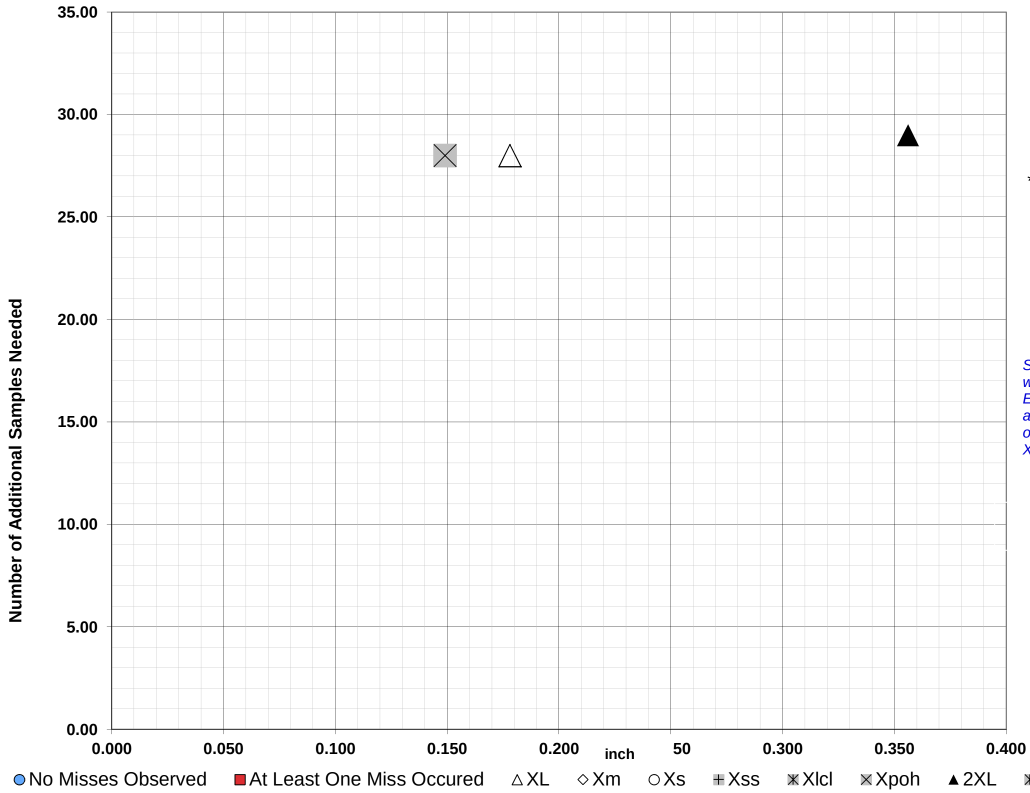


TABLE C

	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

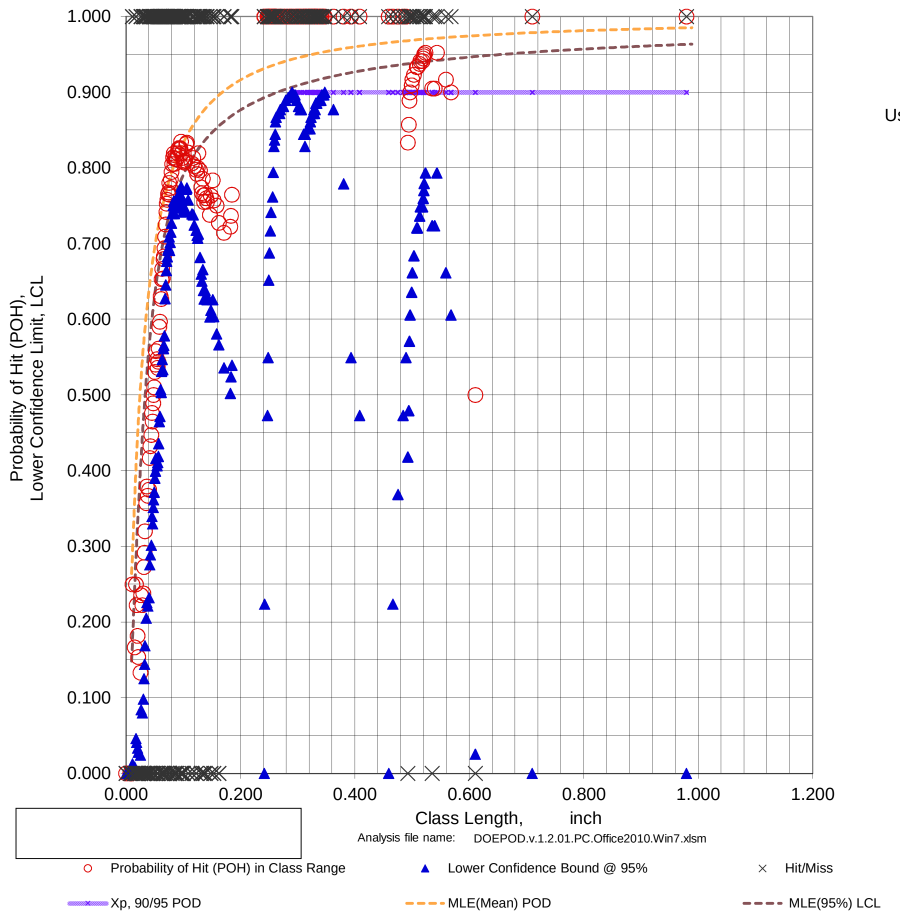
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

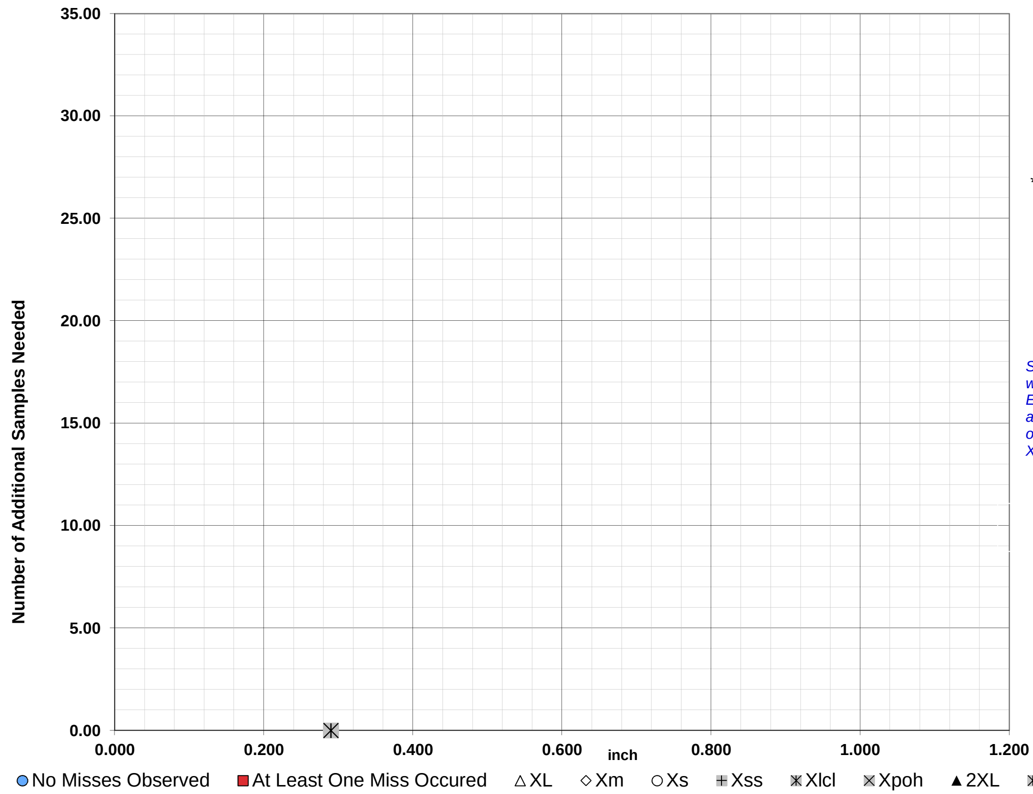


TABLE C

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*

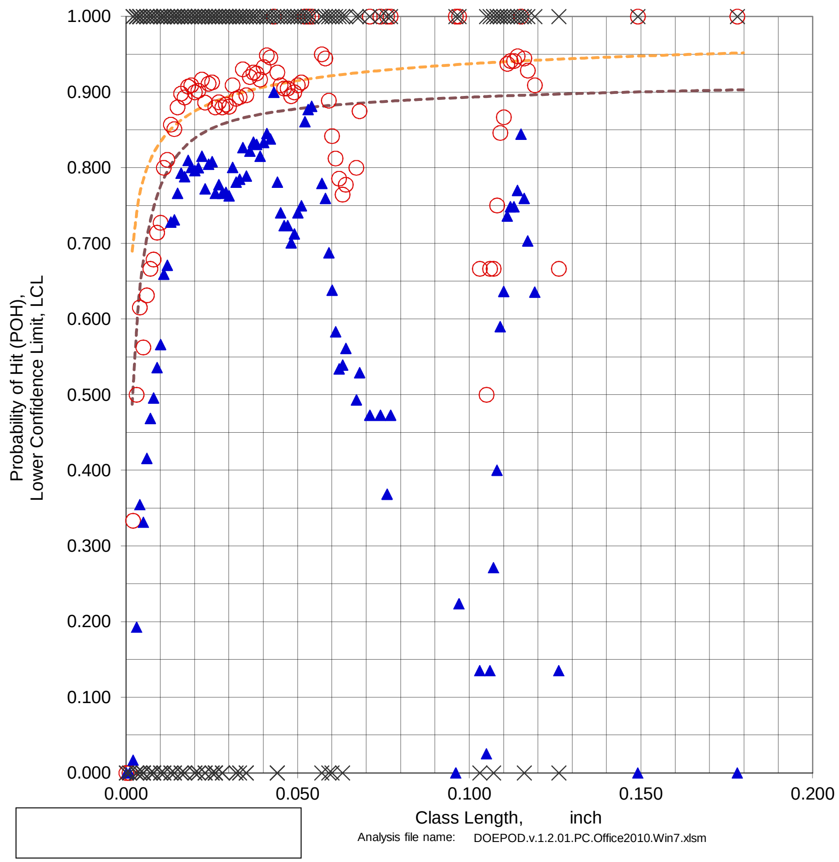
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

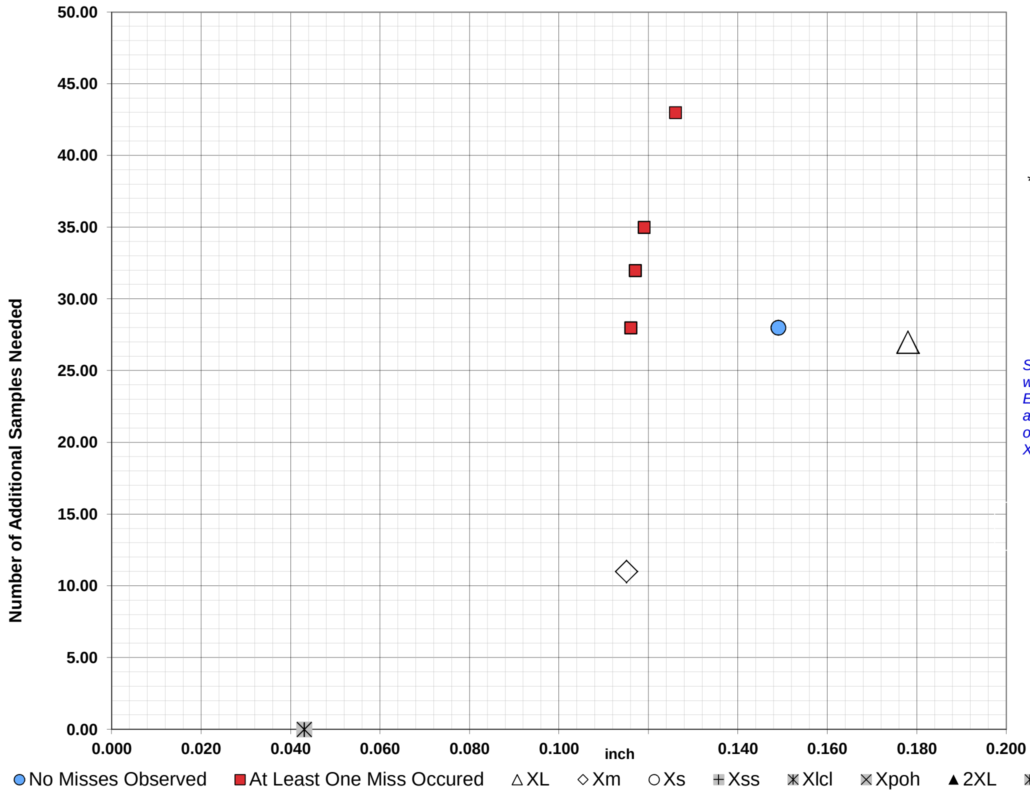


TABLE C

	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.

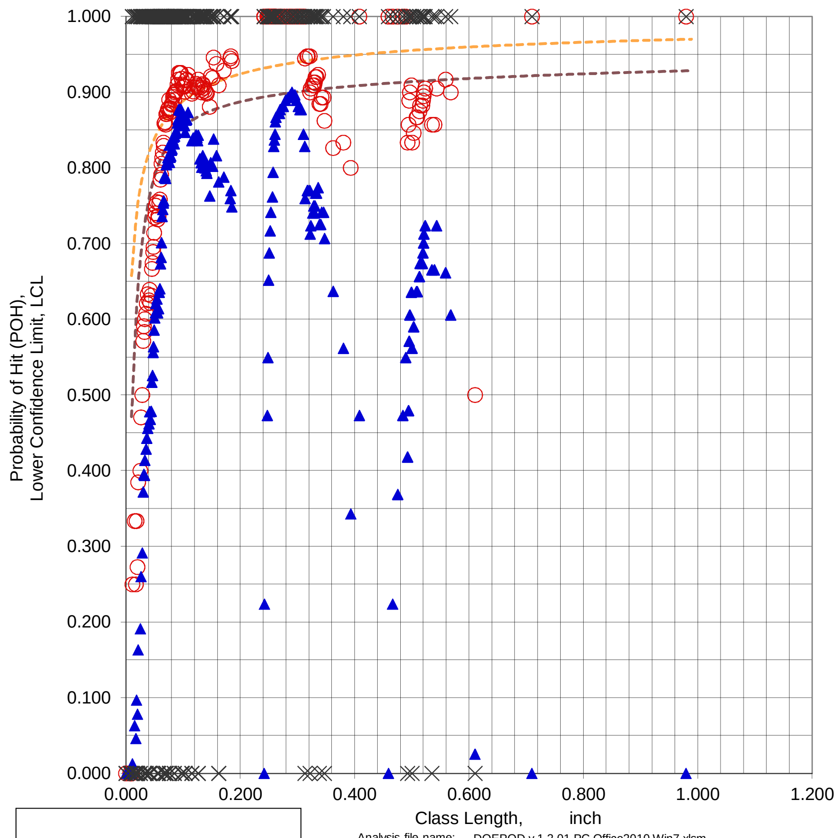
Xpod,Class Length	No. Need
0.1490	28

* 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.



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 =	**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

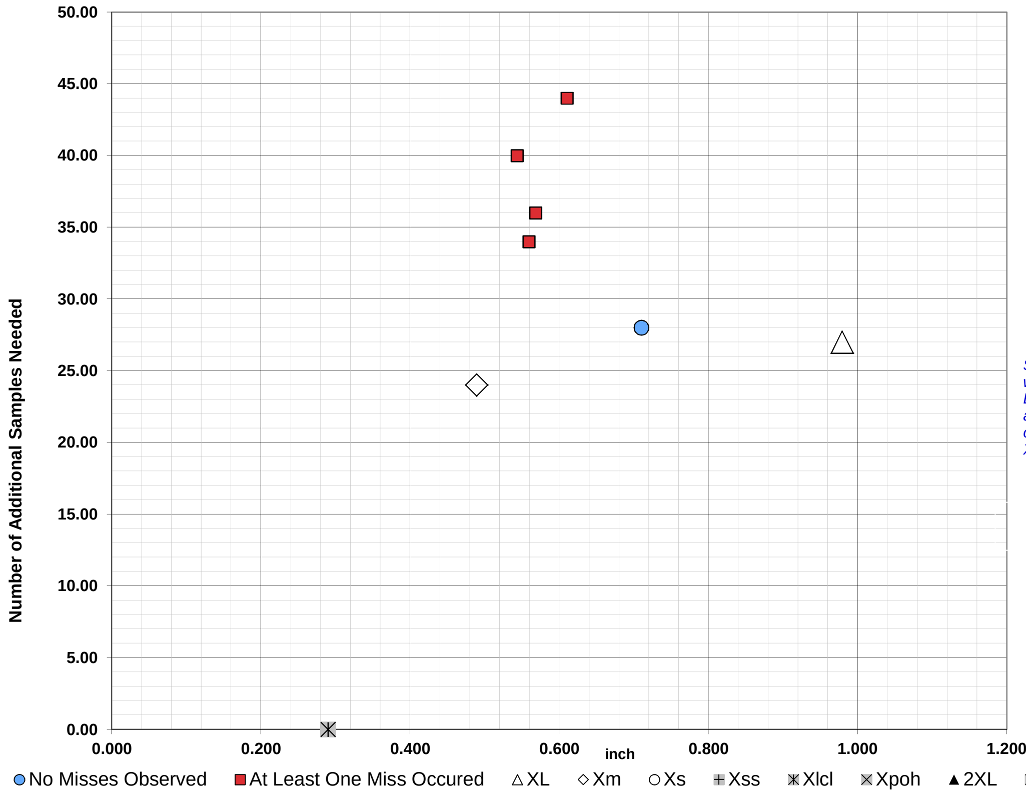


TABLE C

	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

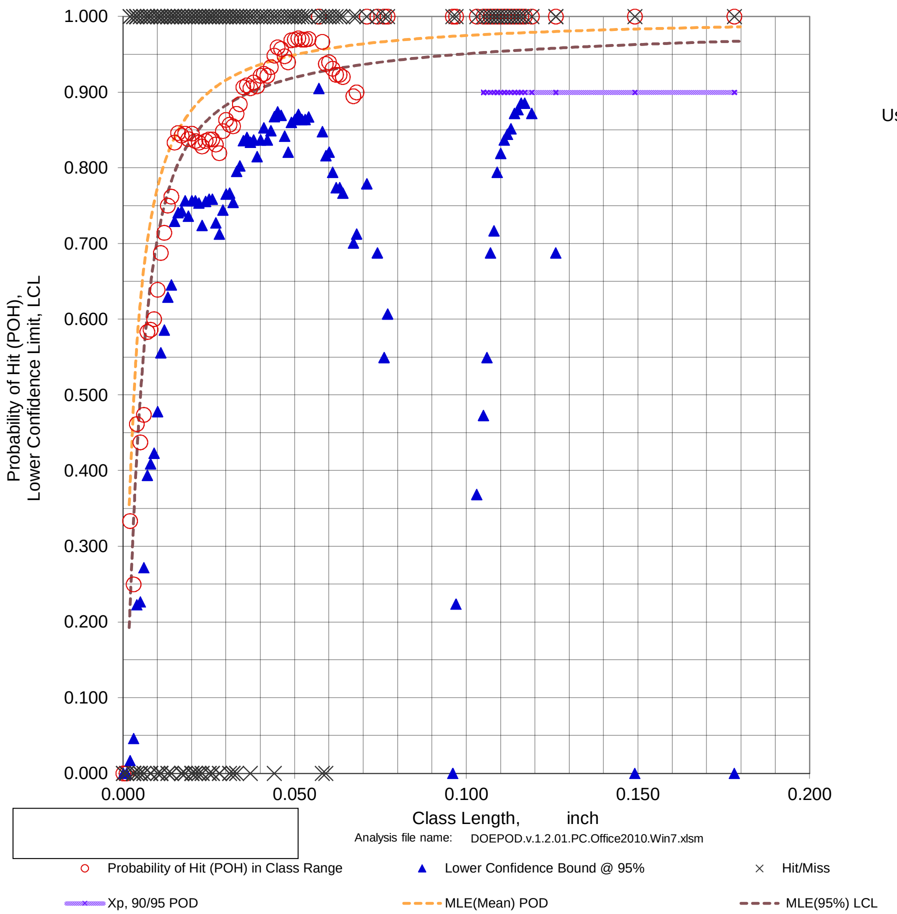
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

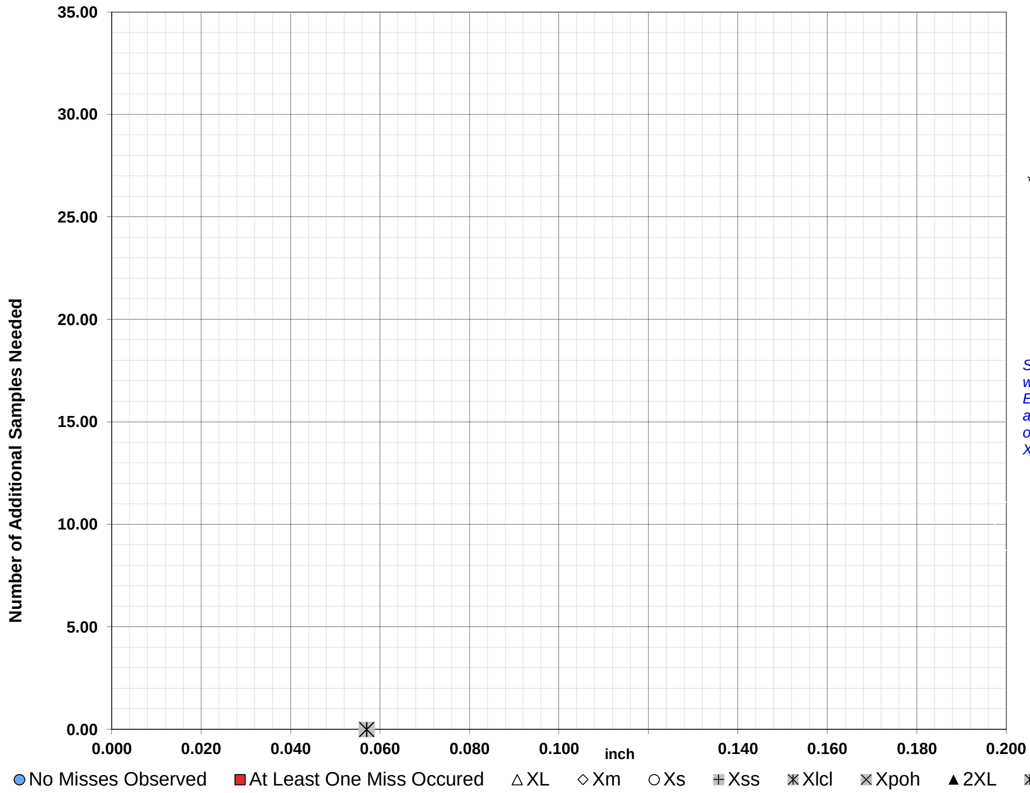


TABLE C

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

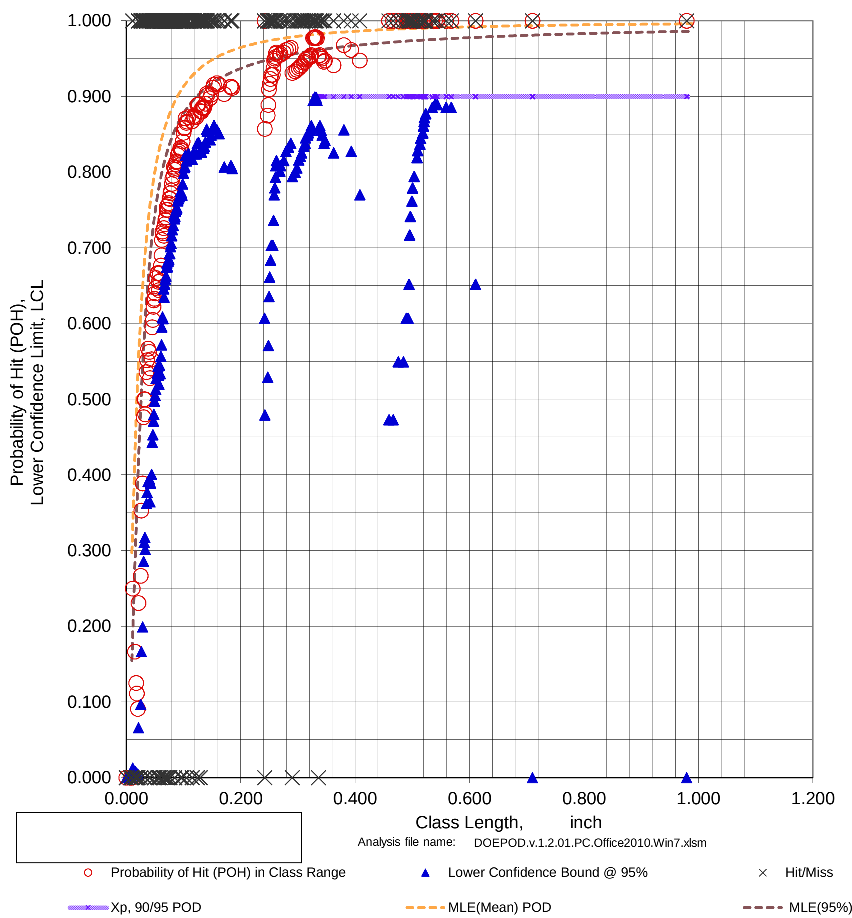
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

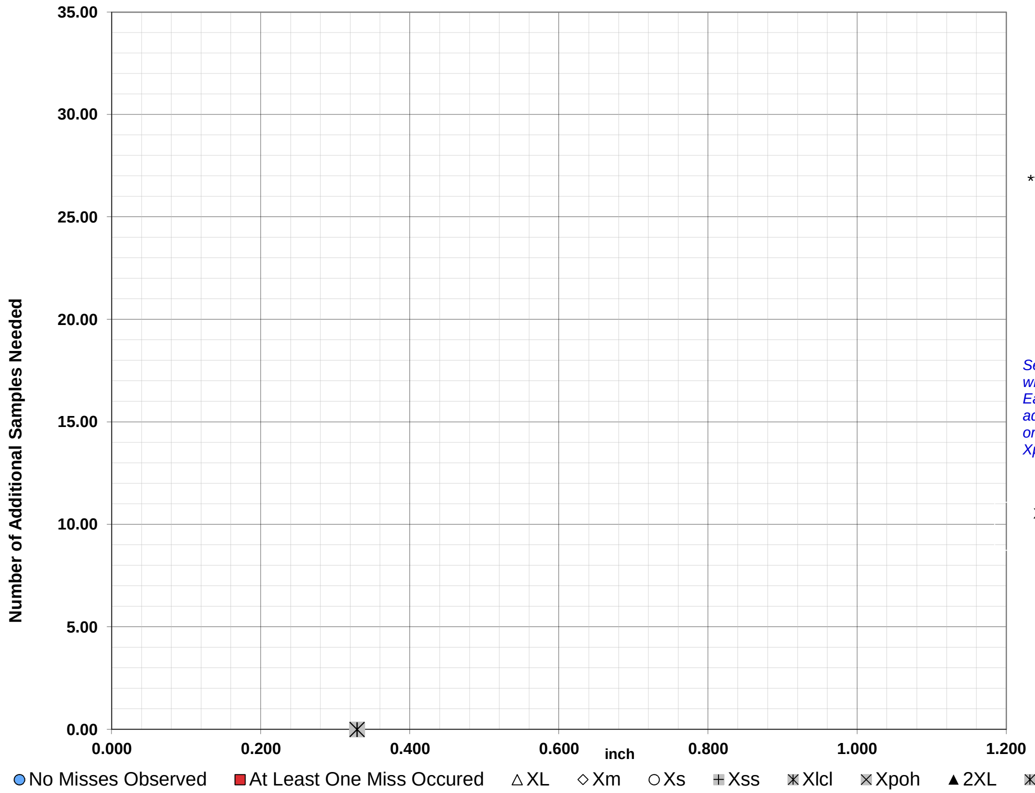


TABLE C

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

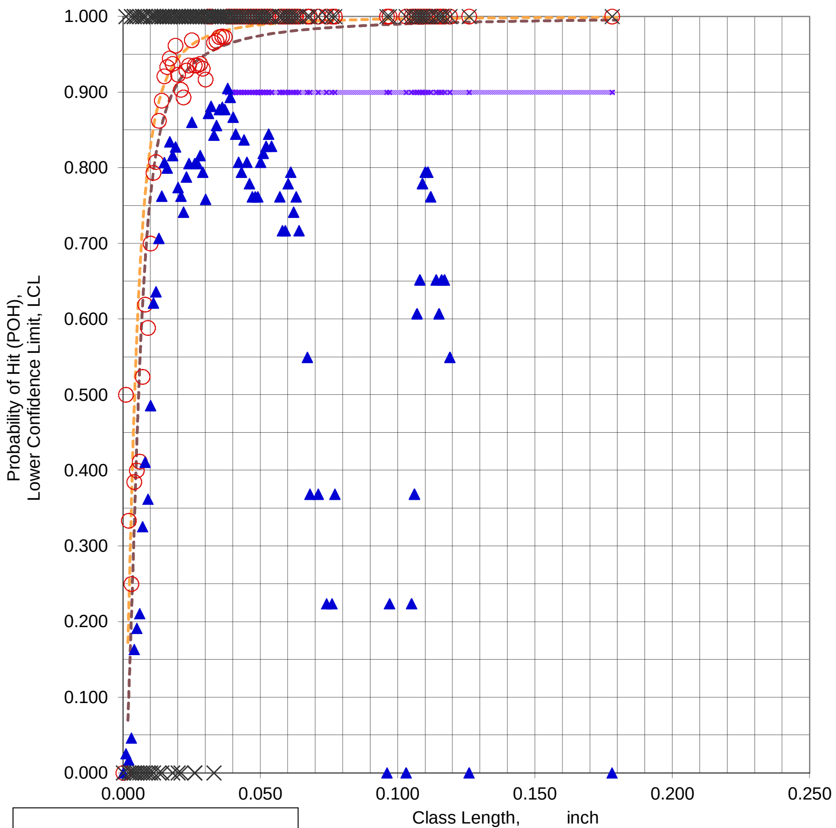
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = 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

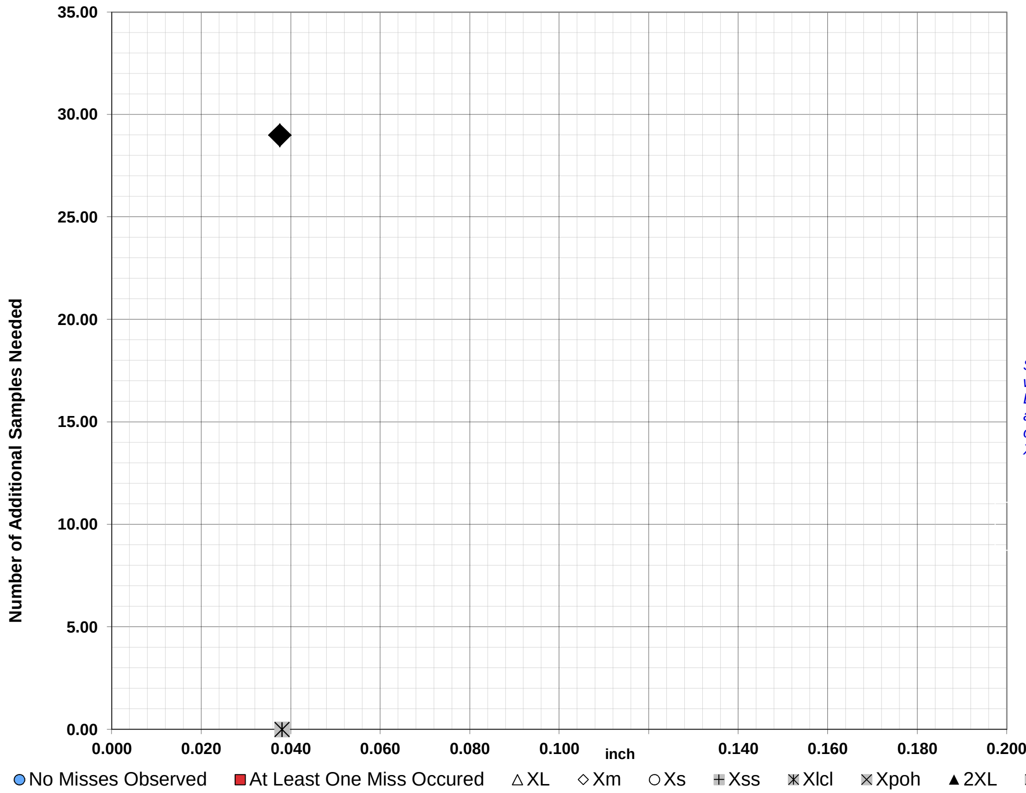


TABLE C

	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

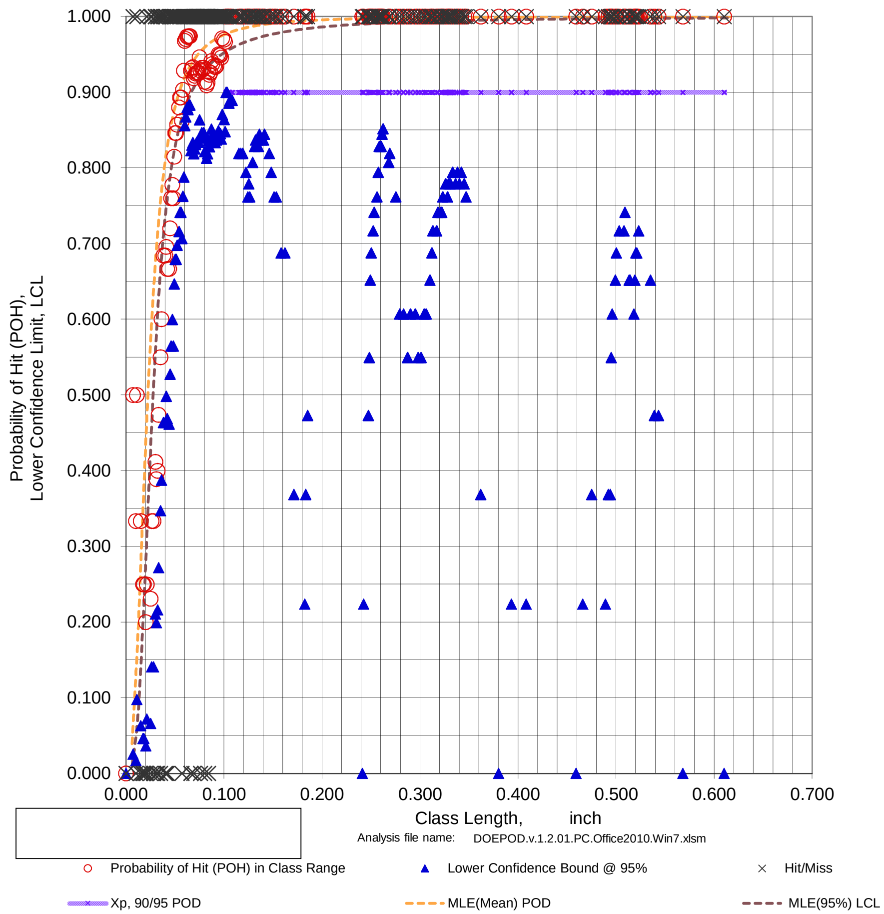
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

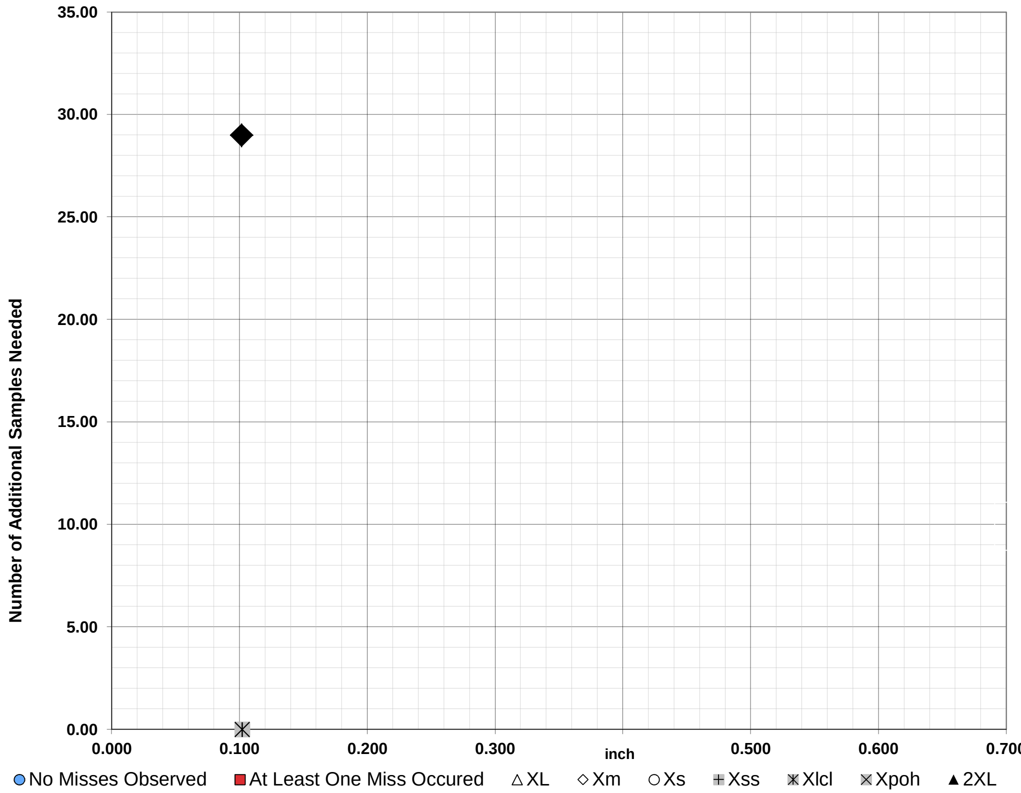


TABLE C

	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

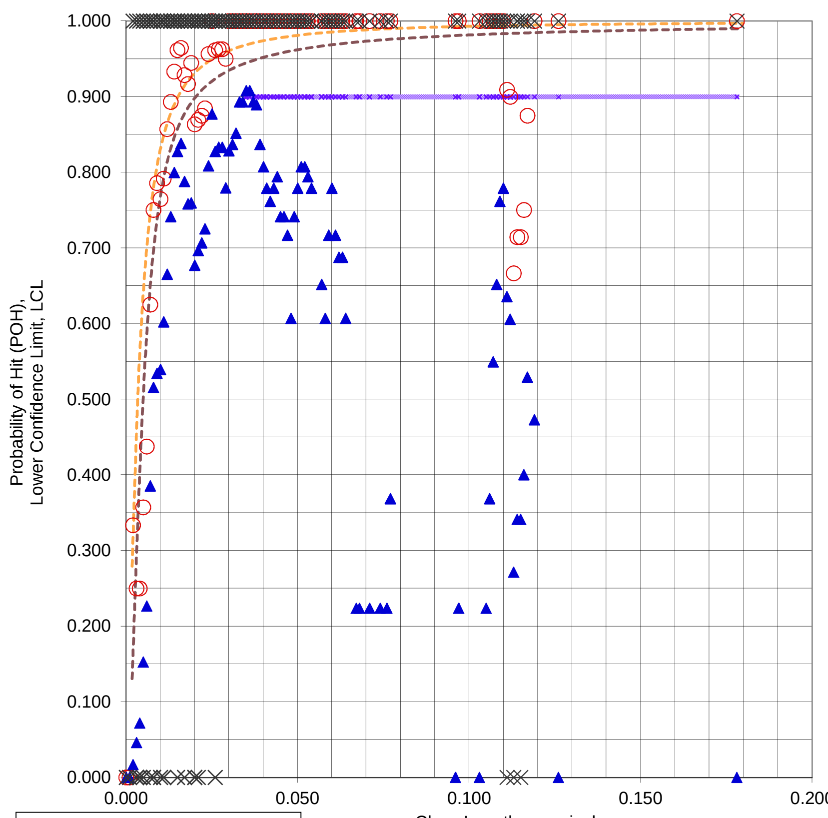
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

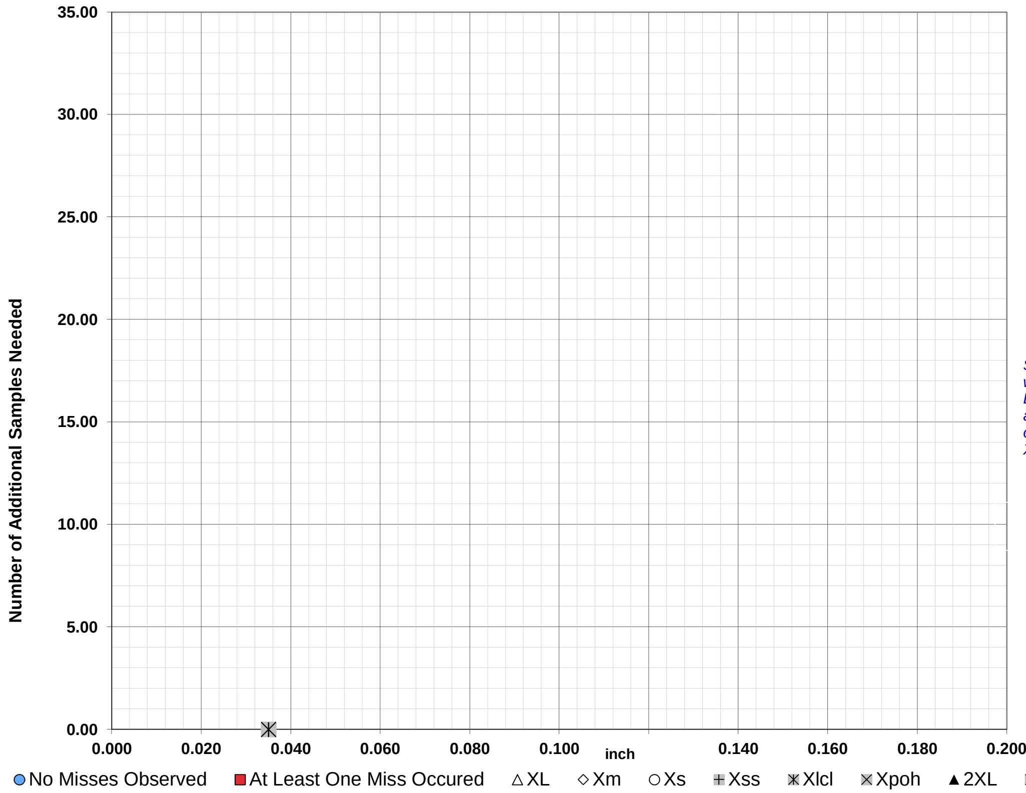


TABLE C

	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

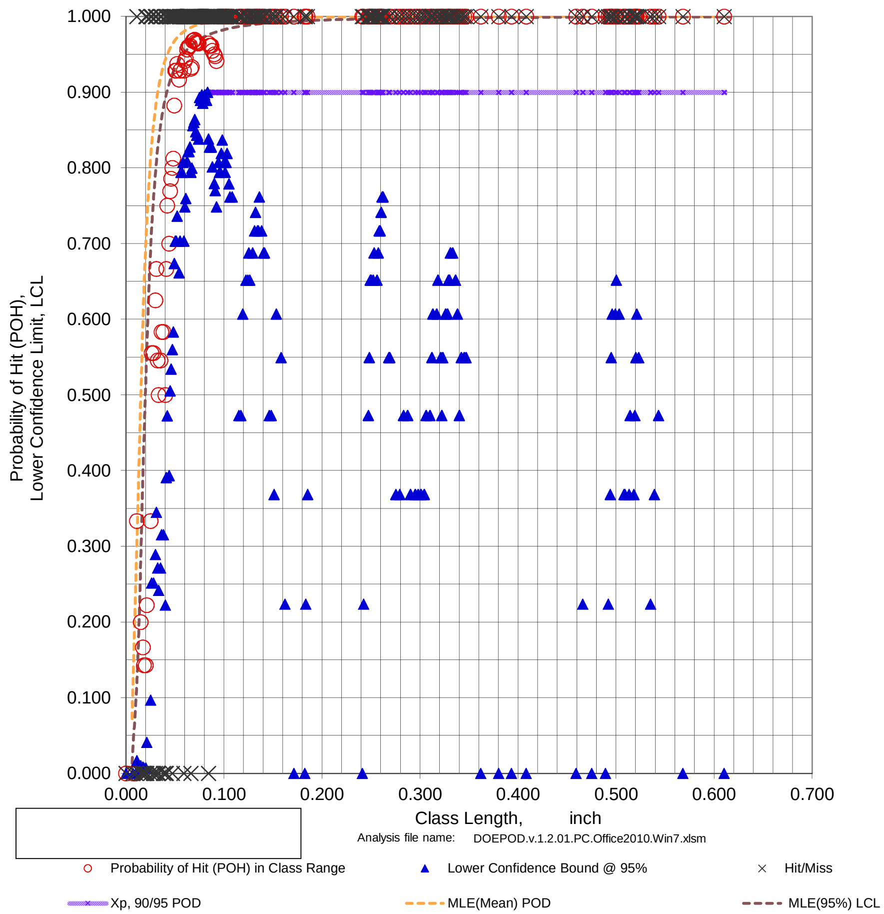
Classlength @ Best LCL = inch

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

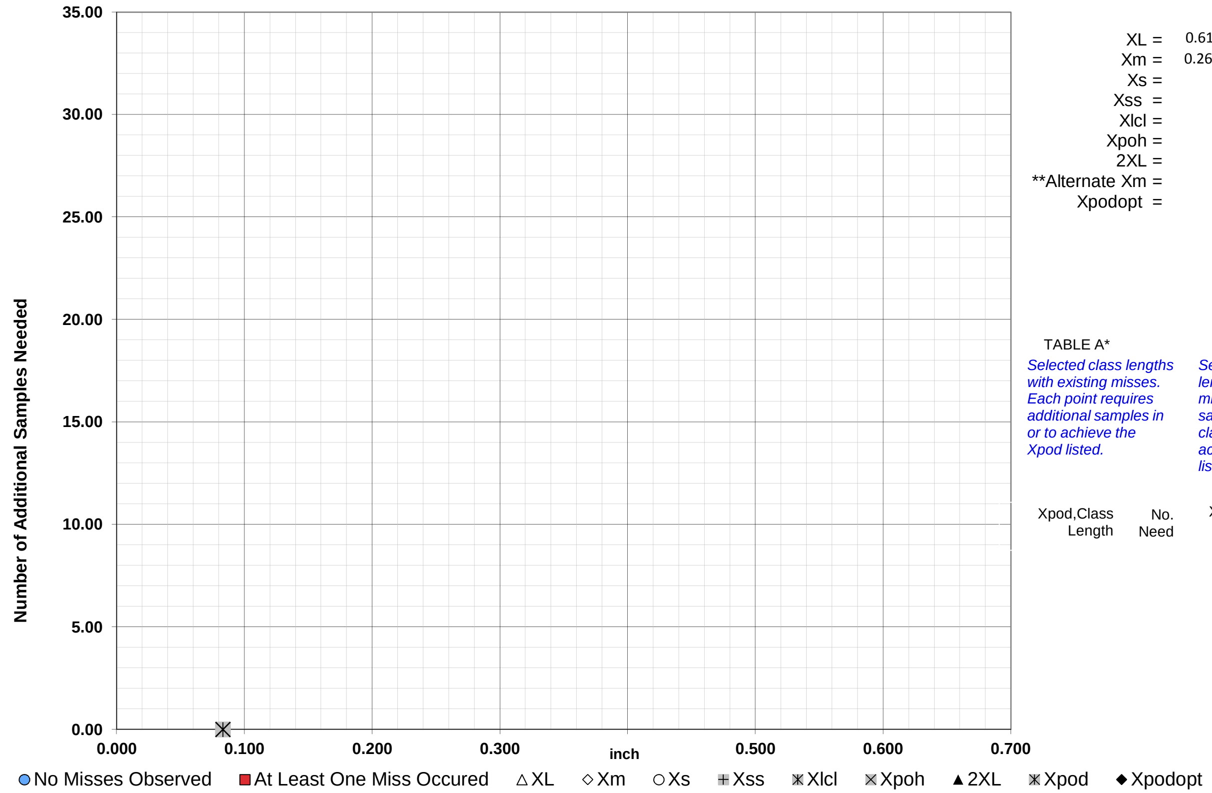


TABLE C

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.

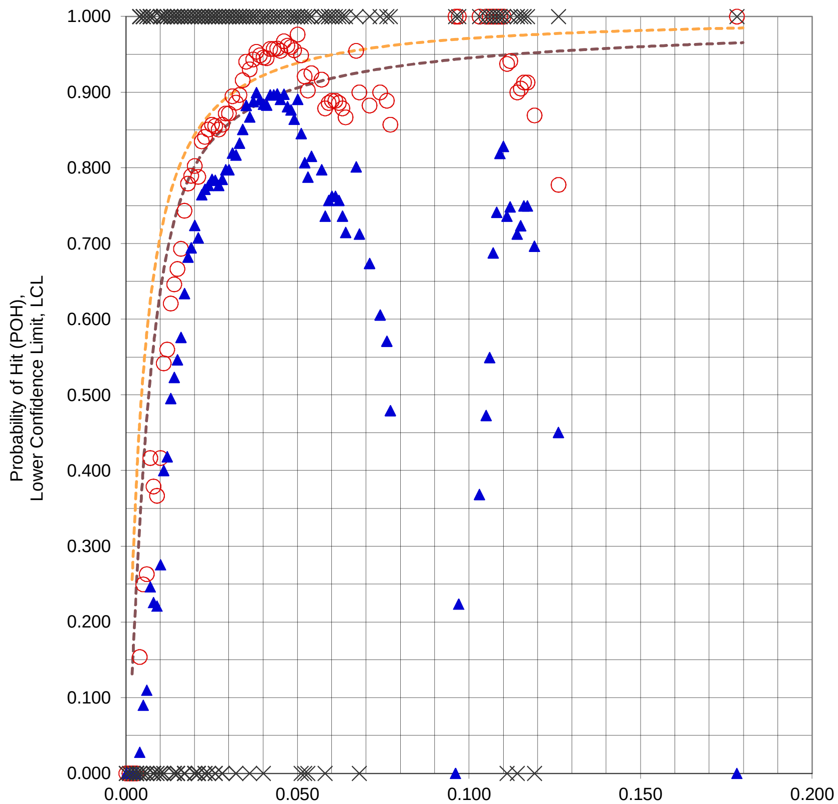
Xpod,Class Length	No. Need

* 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.



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 =	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

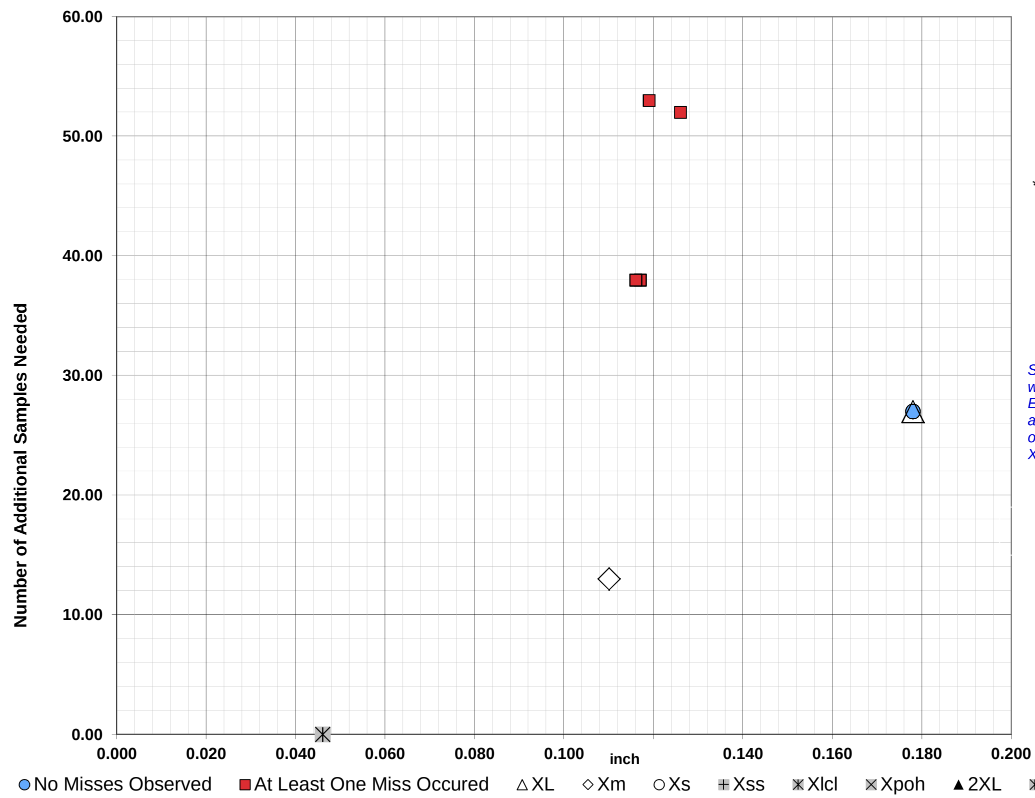


TABLE C

	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

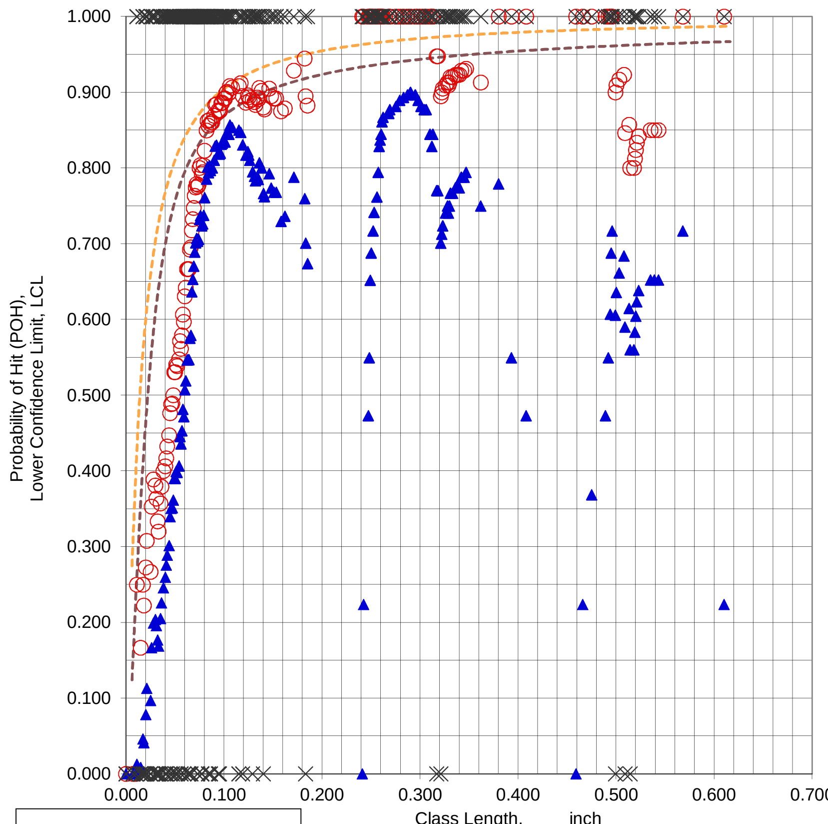
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

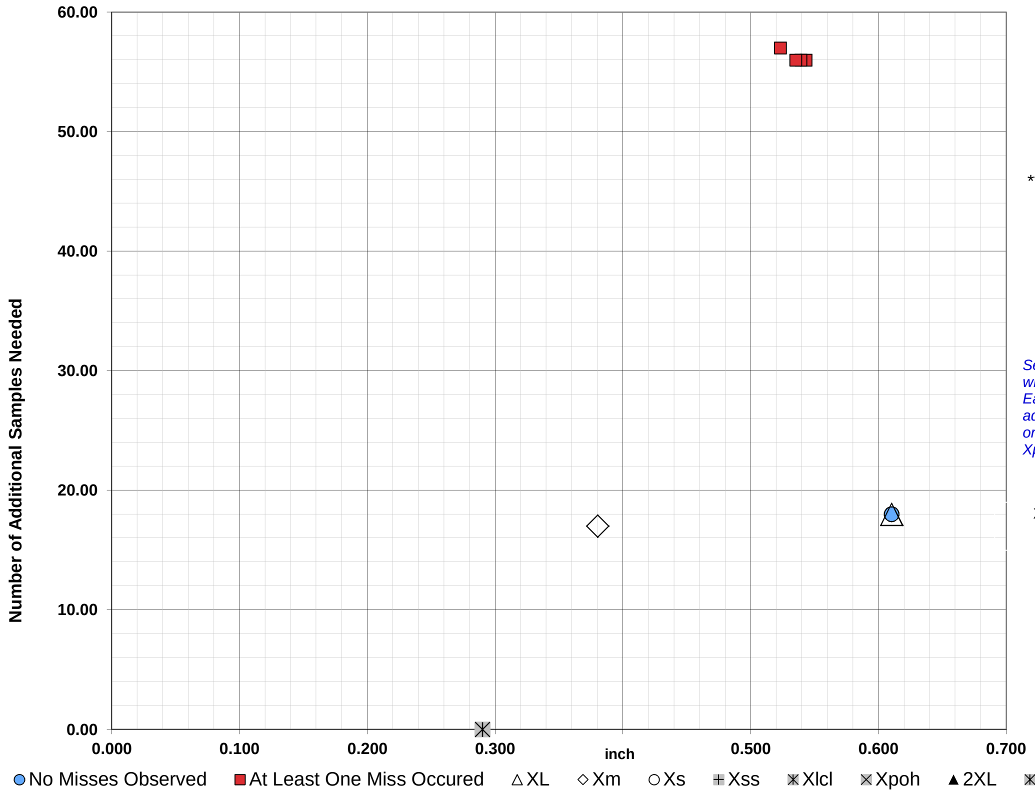


TABLE C

	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

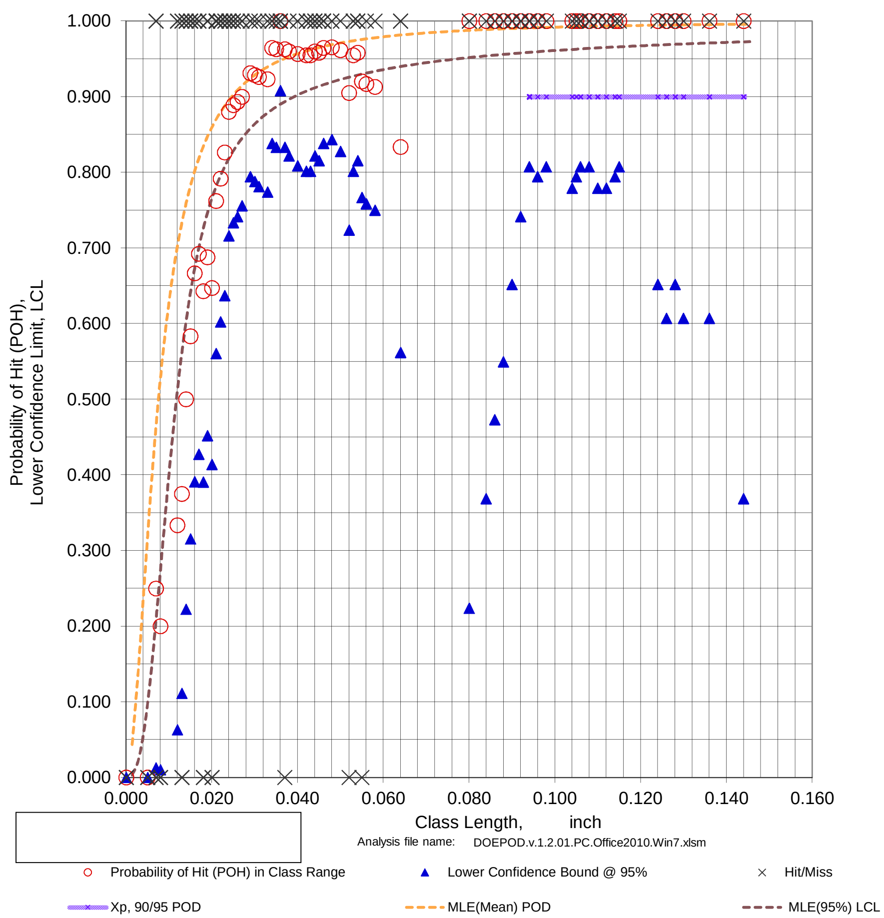
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

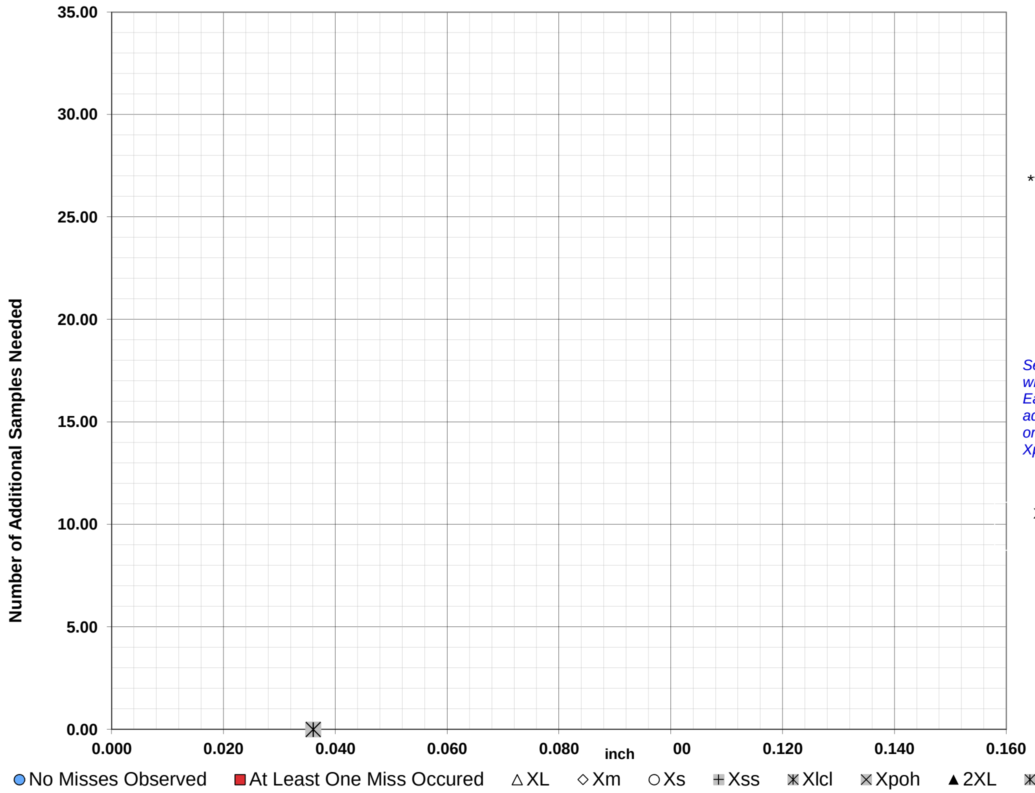


TABLE C

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.

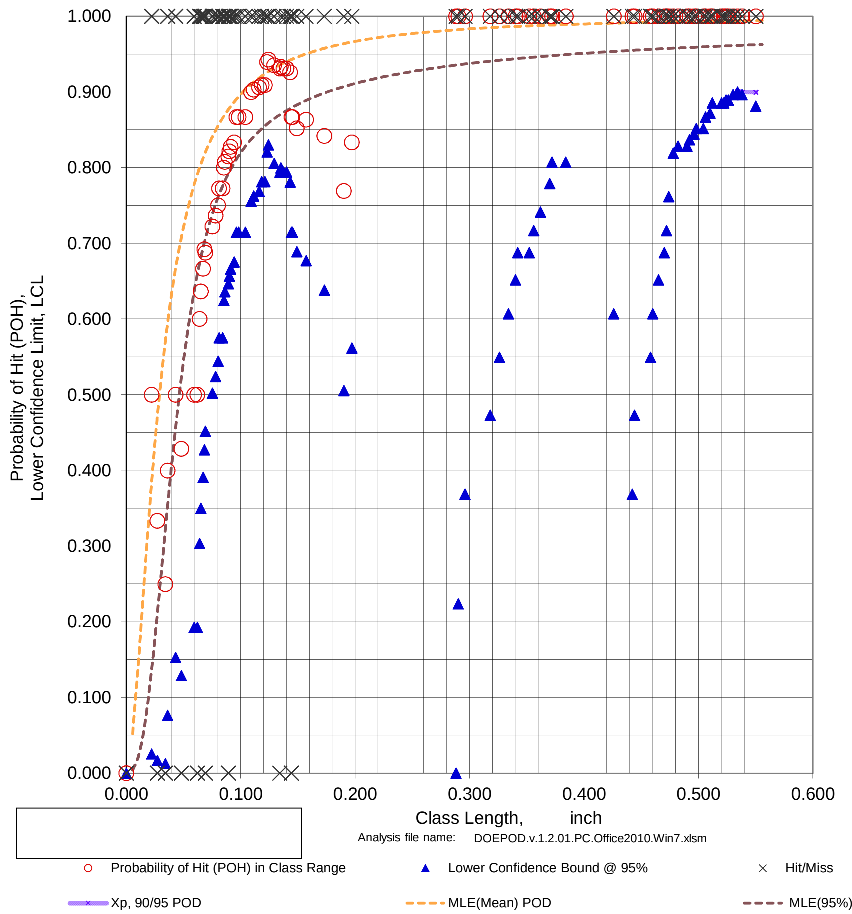
Xpod,Class Length	No. Need

* 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

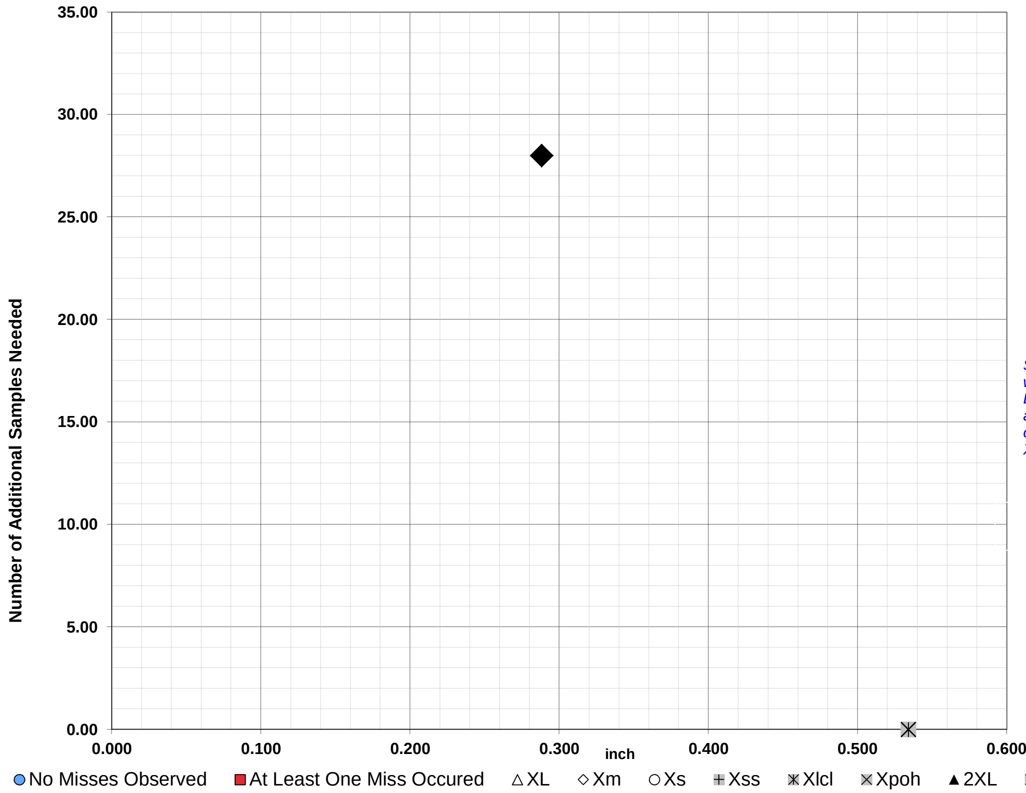


TABLE C

	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

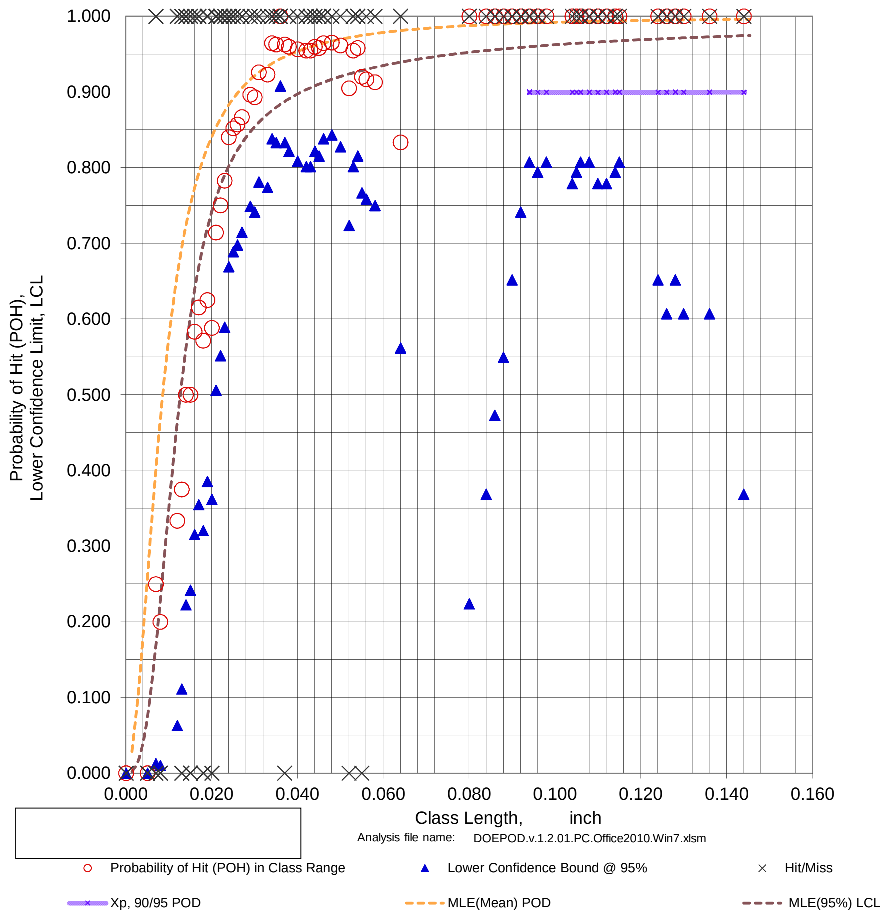
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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 #)

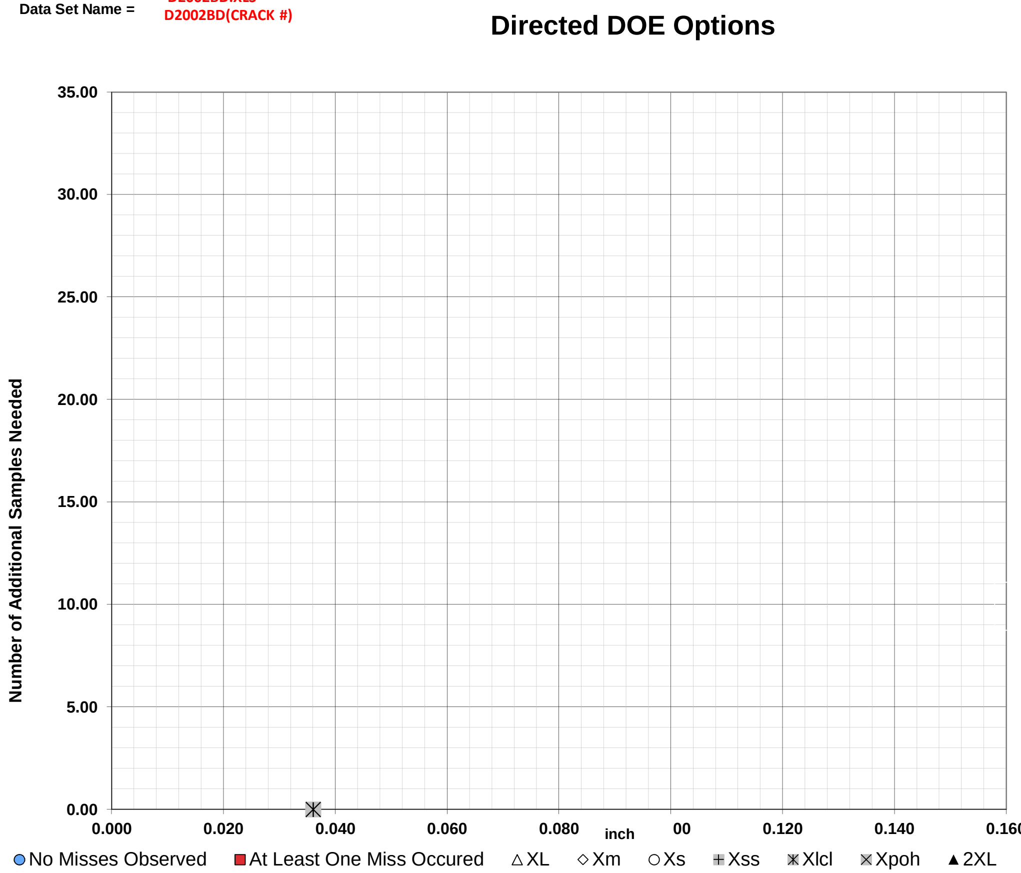


TABLE C

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.

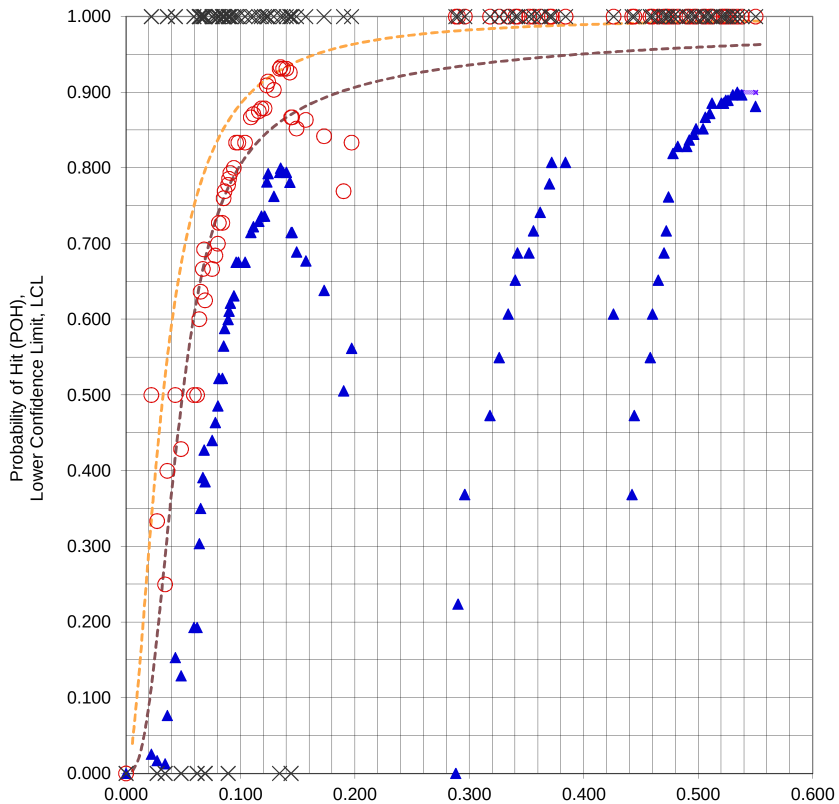
Xpod,Class Length	No. Need

* 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.



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 = 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

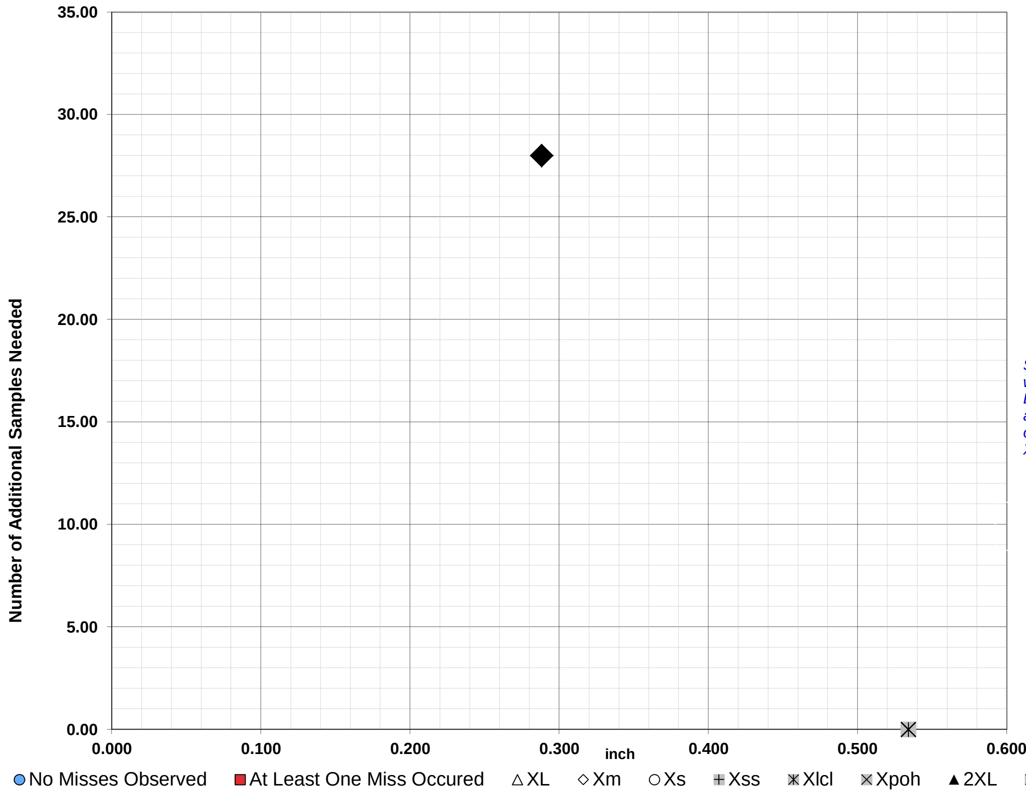


TABLE C

	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

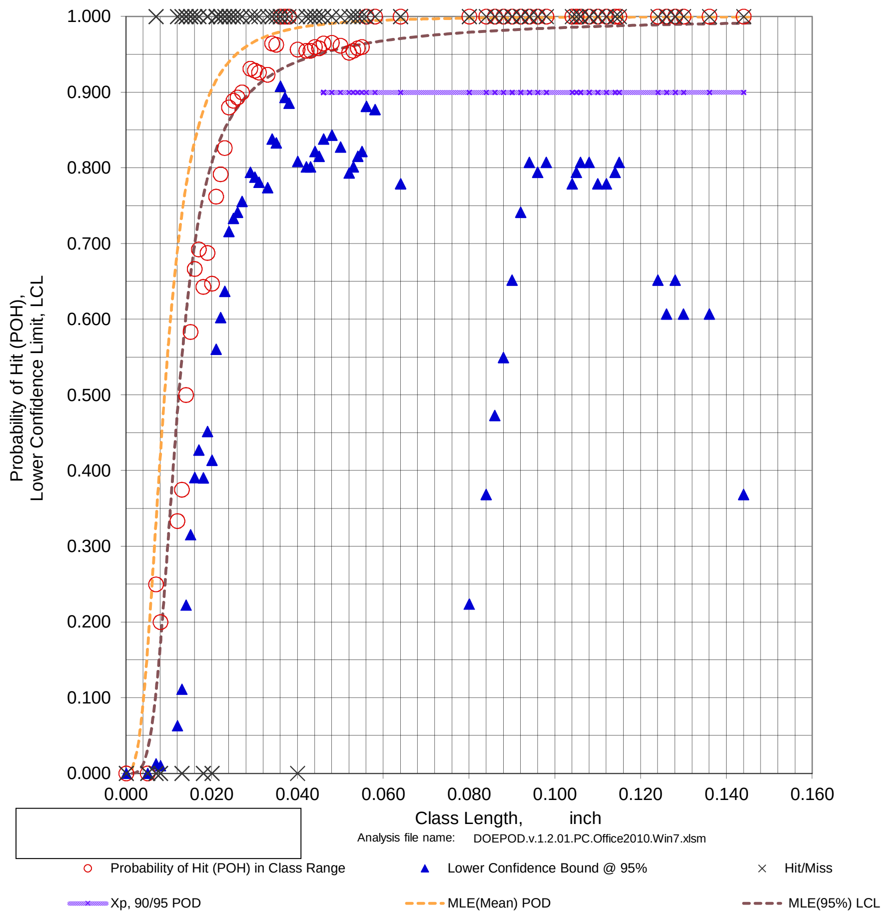
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

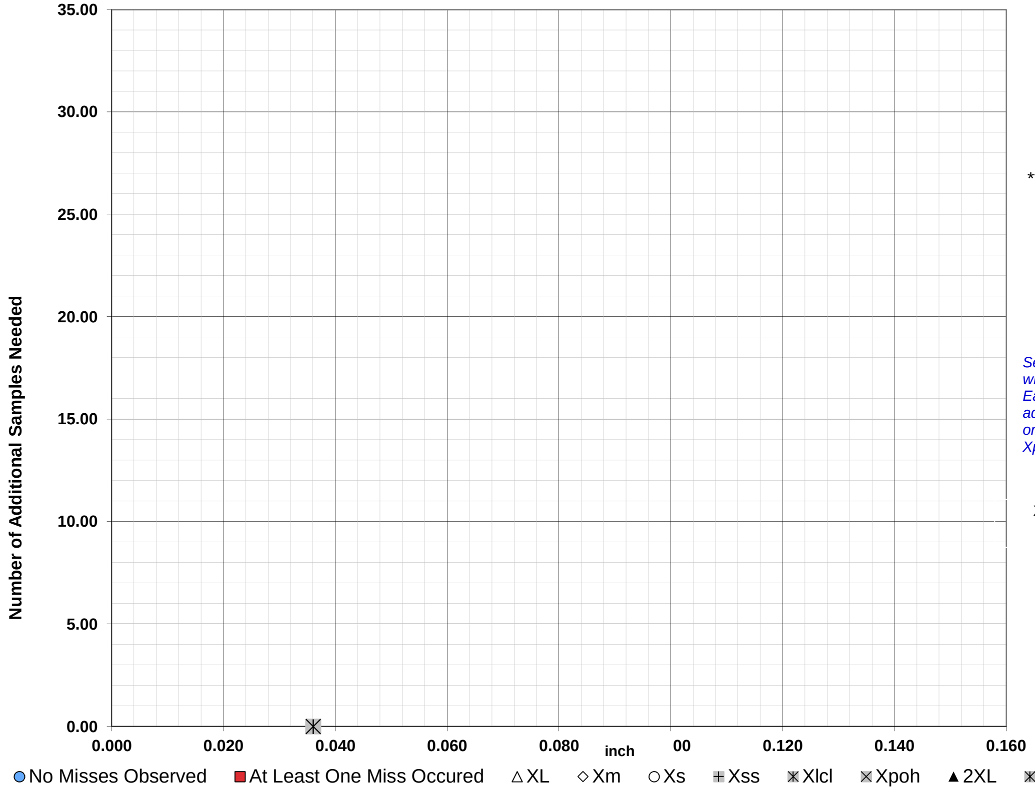


TABLE C

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.

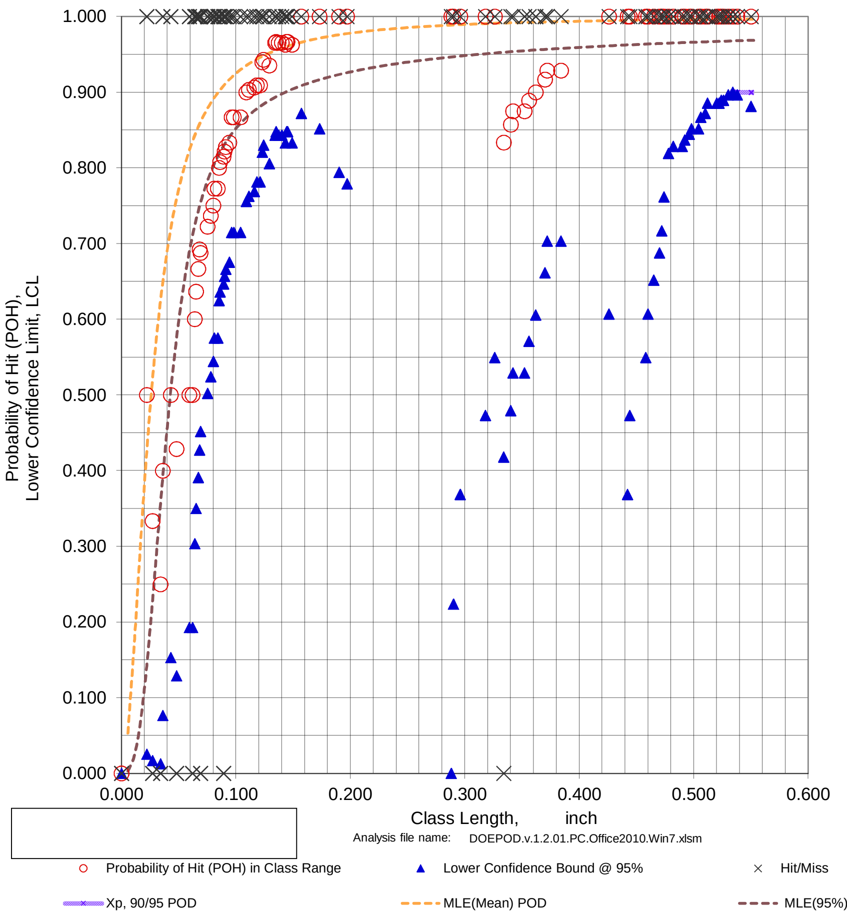
Xpod,Class Length	No. Need

* 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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

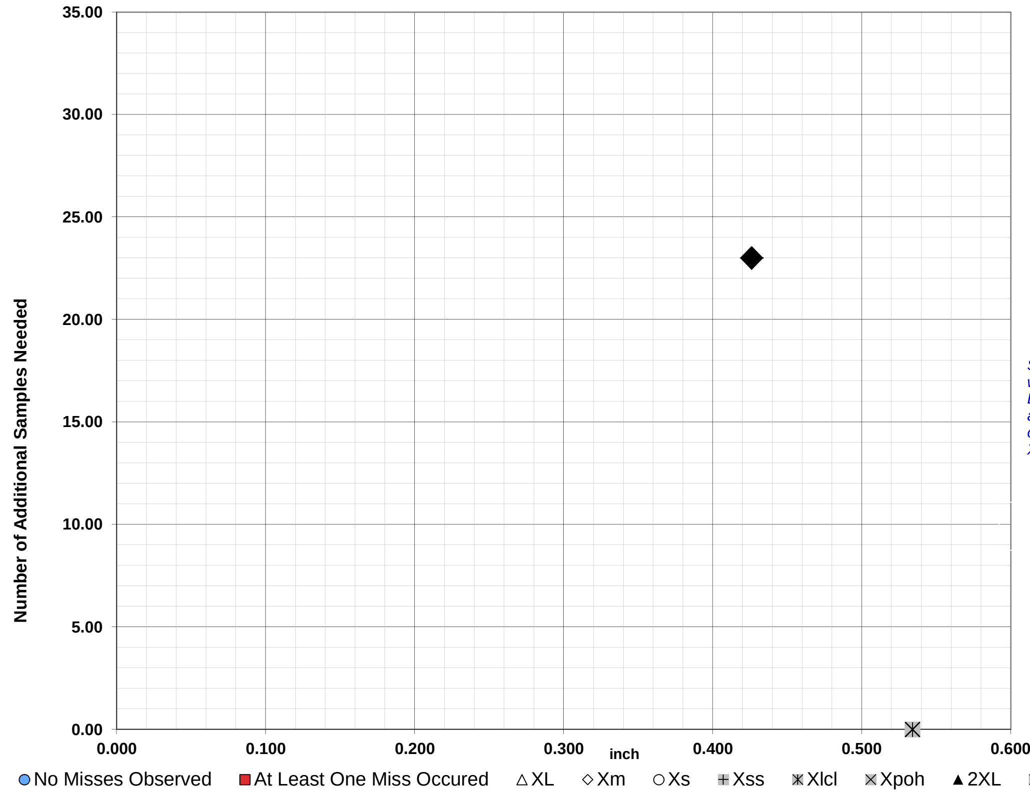


TABLE C

	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

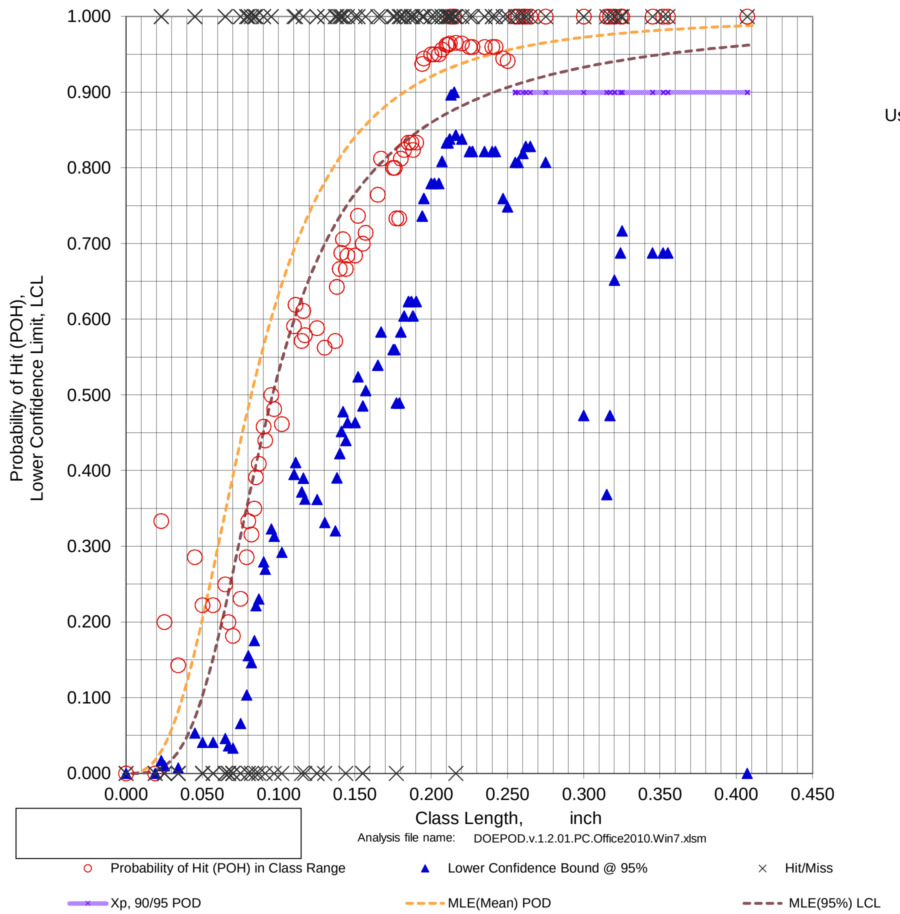
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

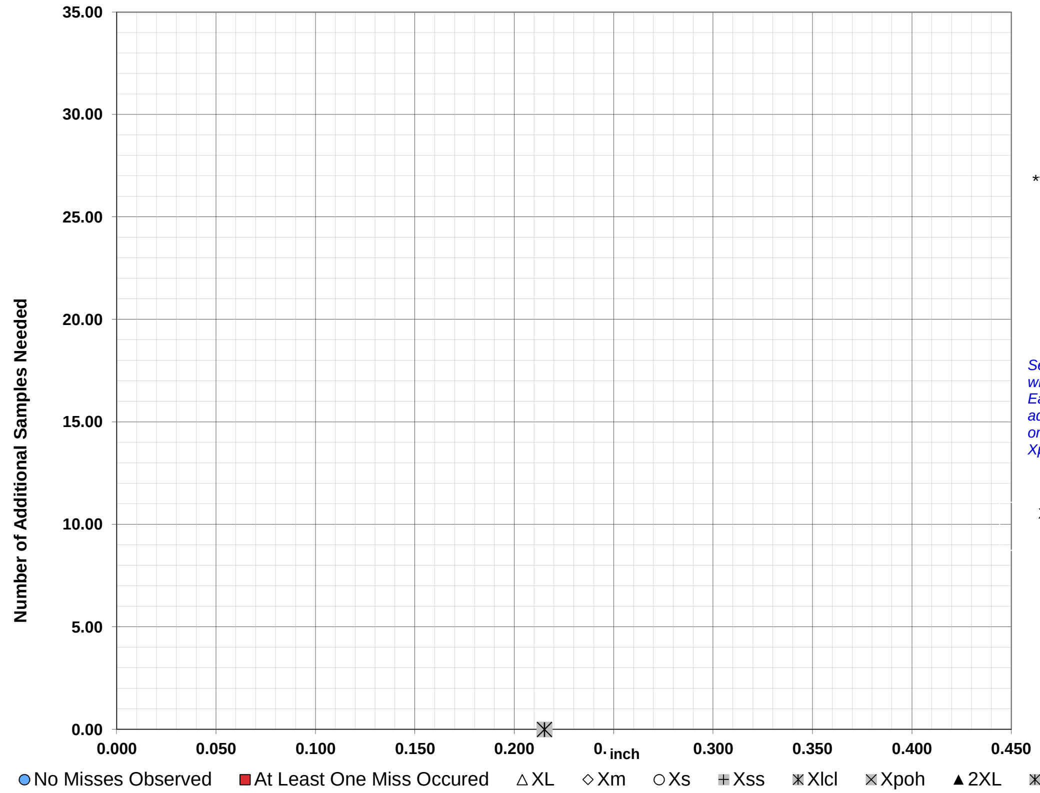


TABLE C

	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

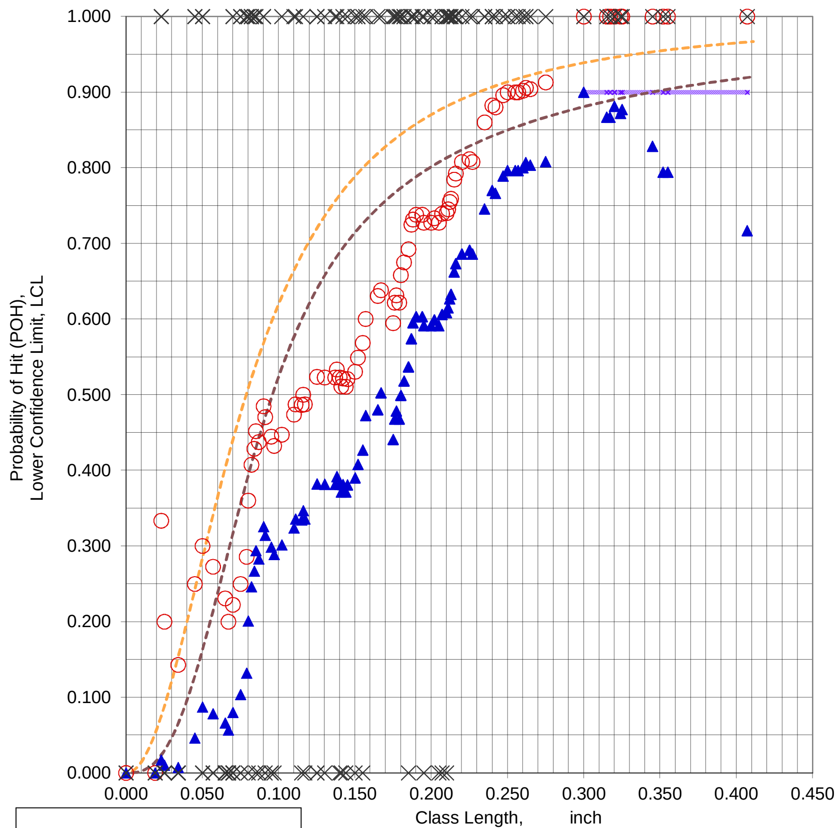
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

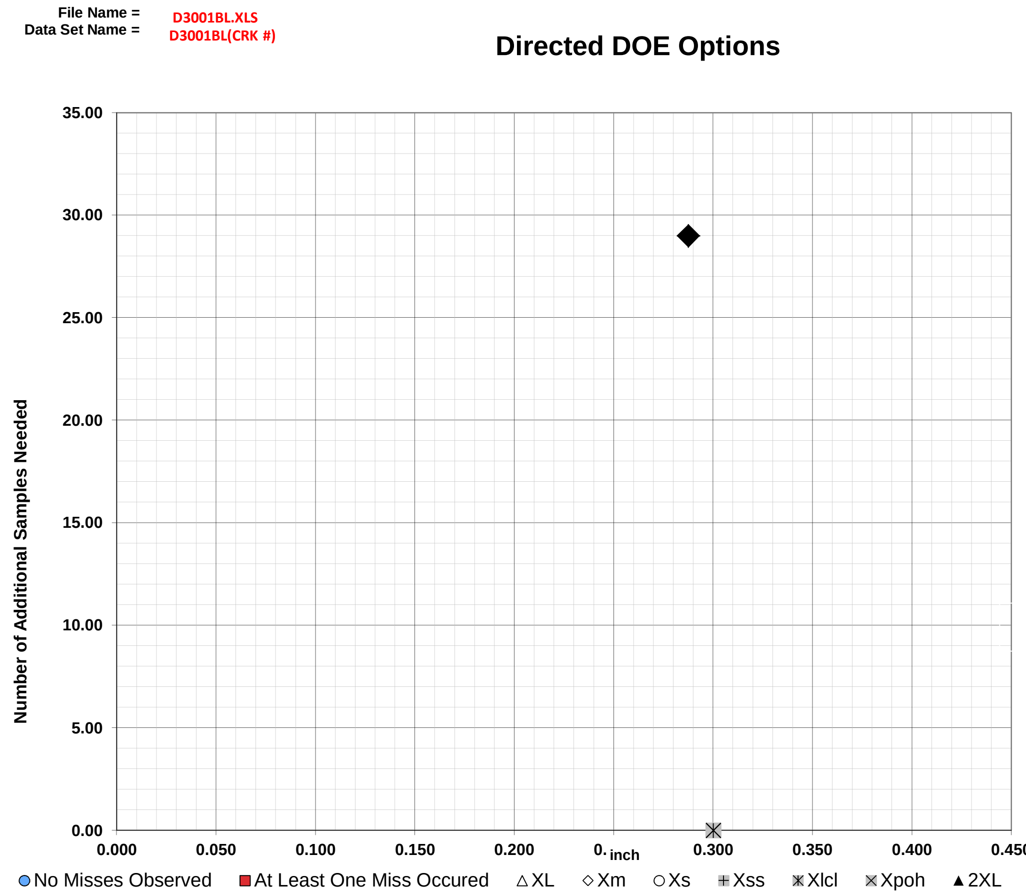


TABLE C

	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

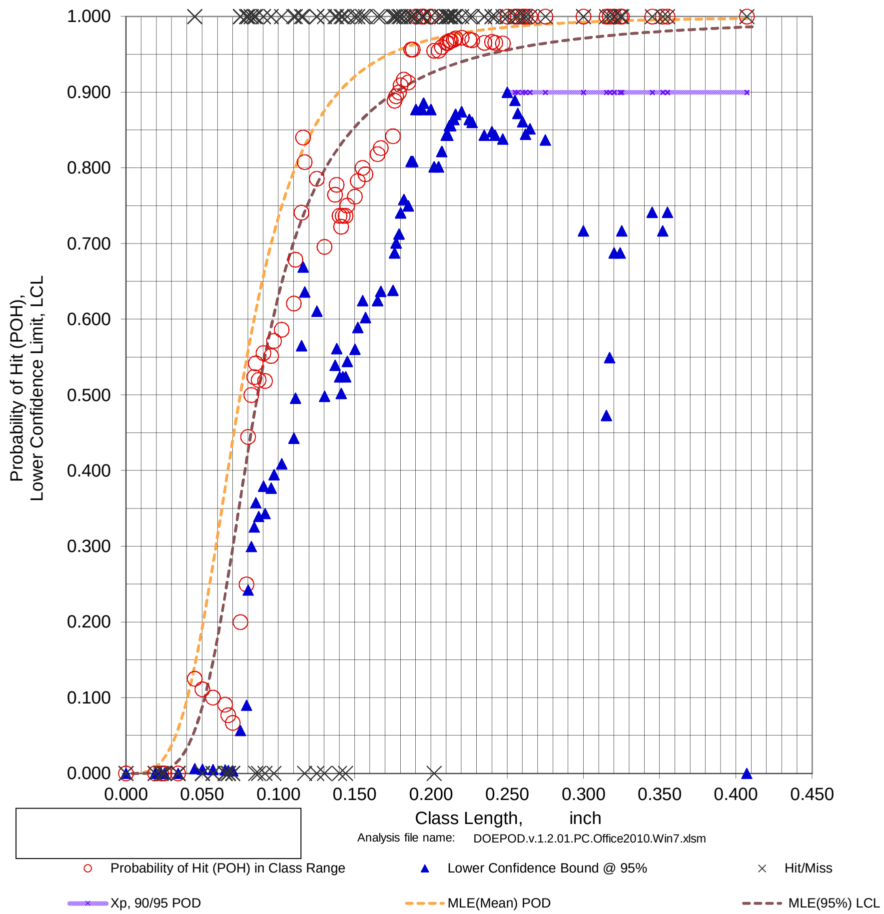
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

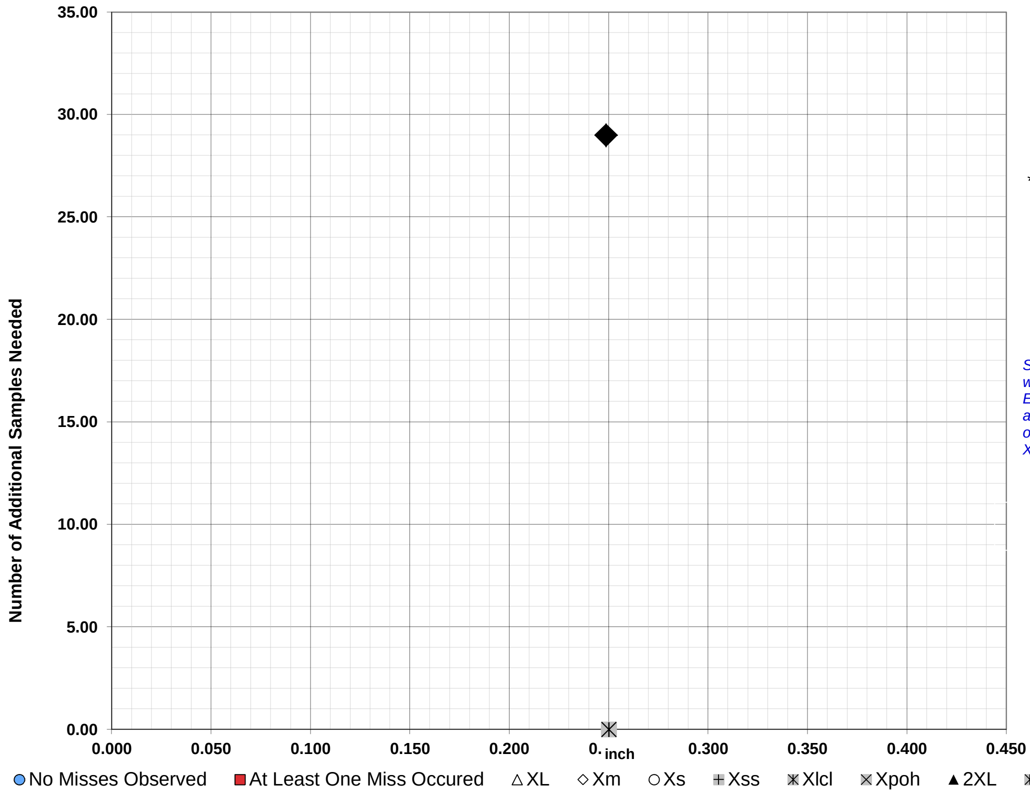


TABLE C

	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*

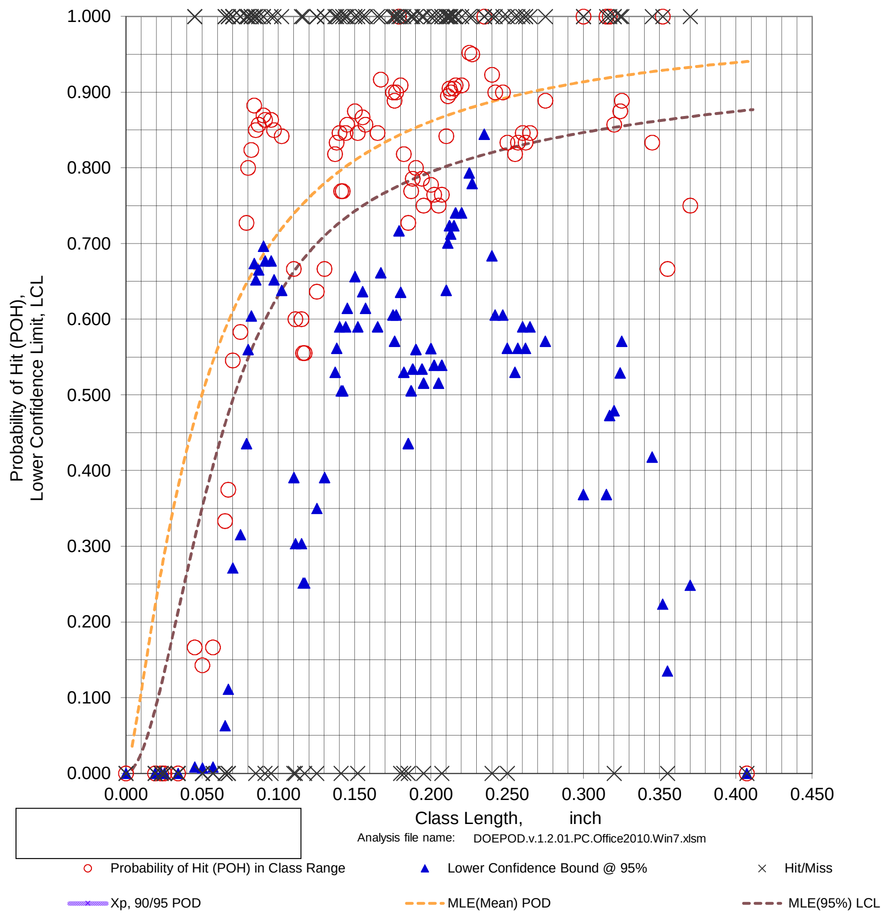
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

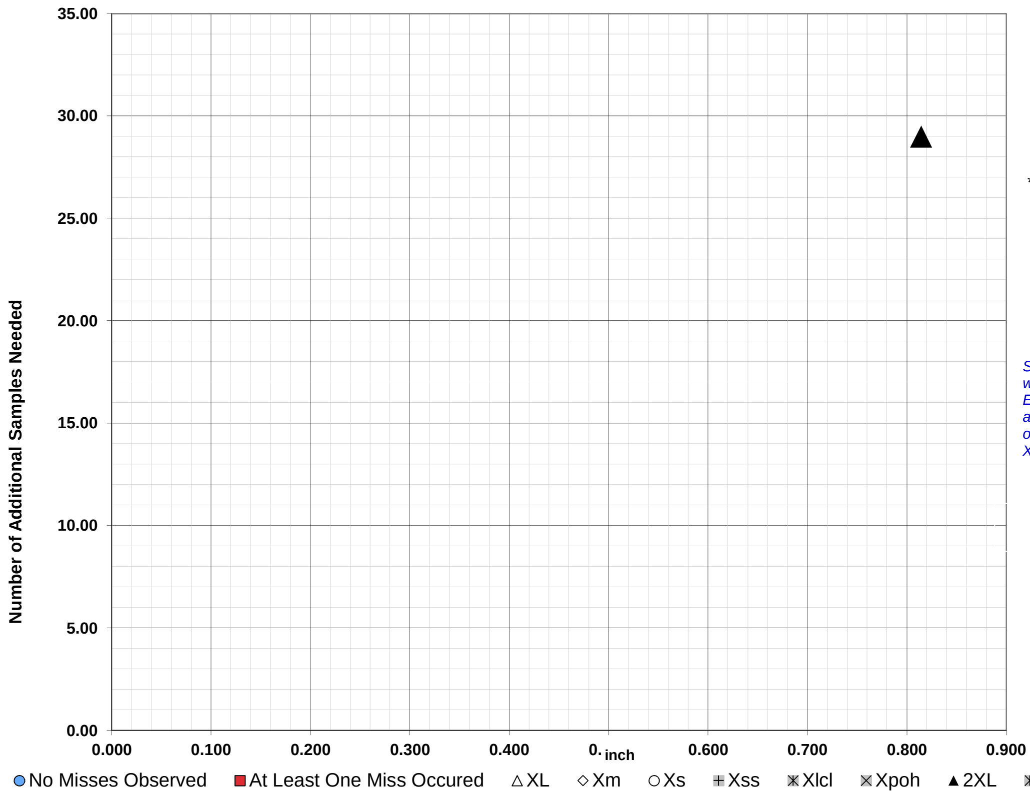


TABLE C

	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

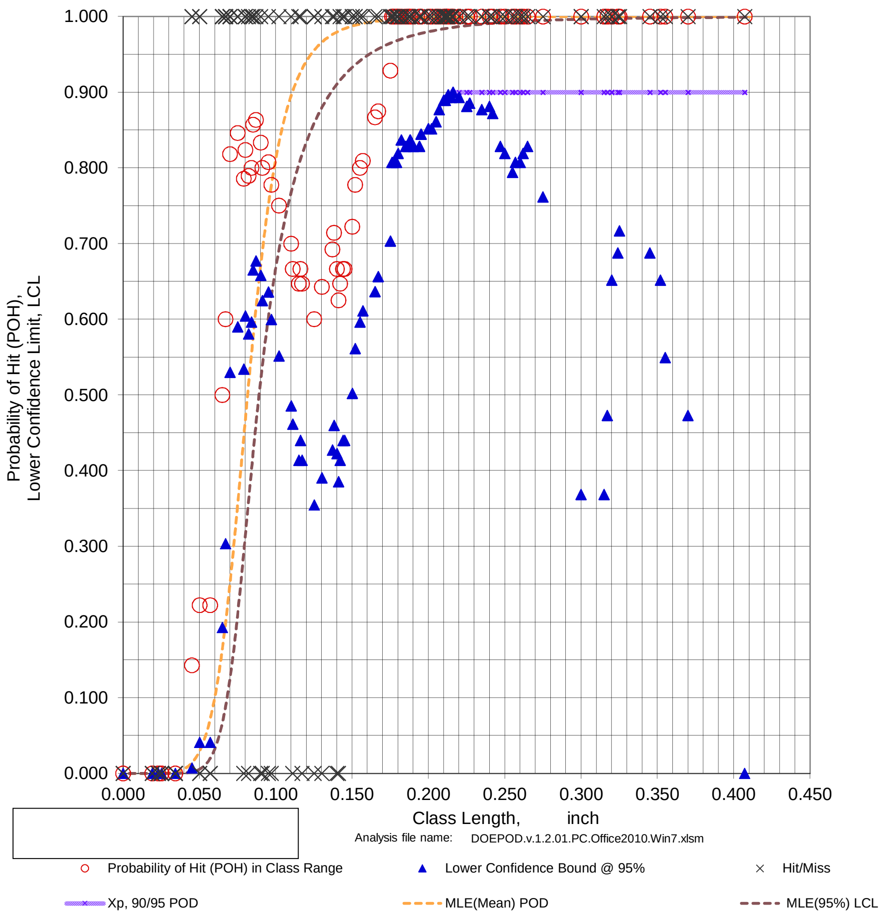
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

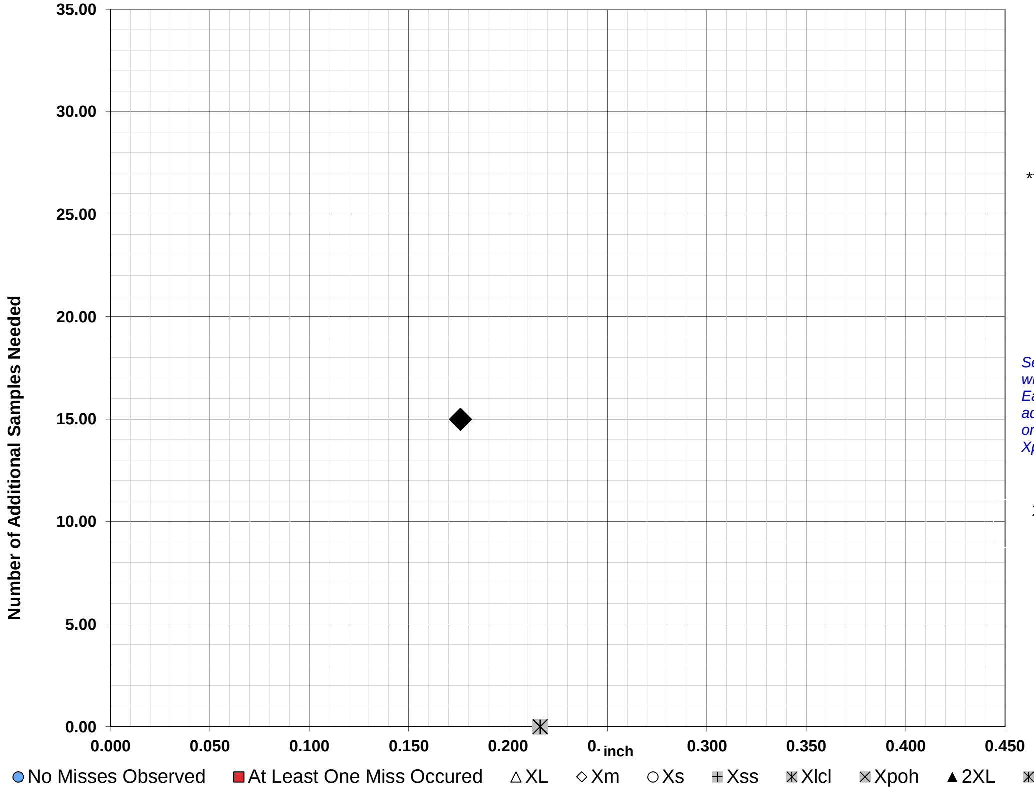


TABLE C

	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

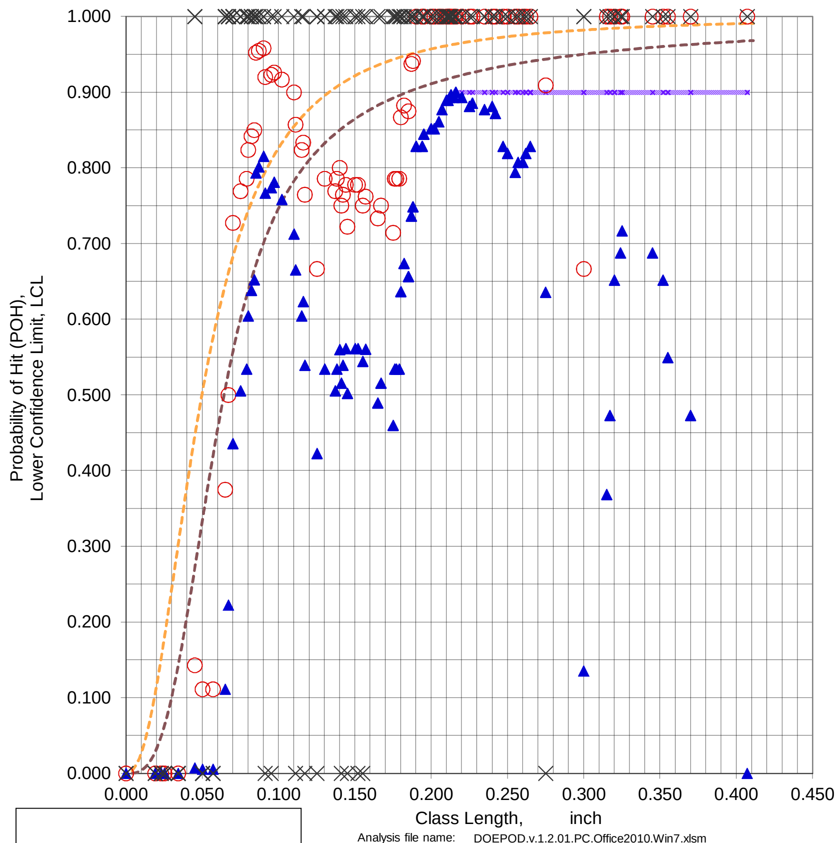
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

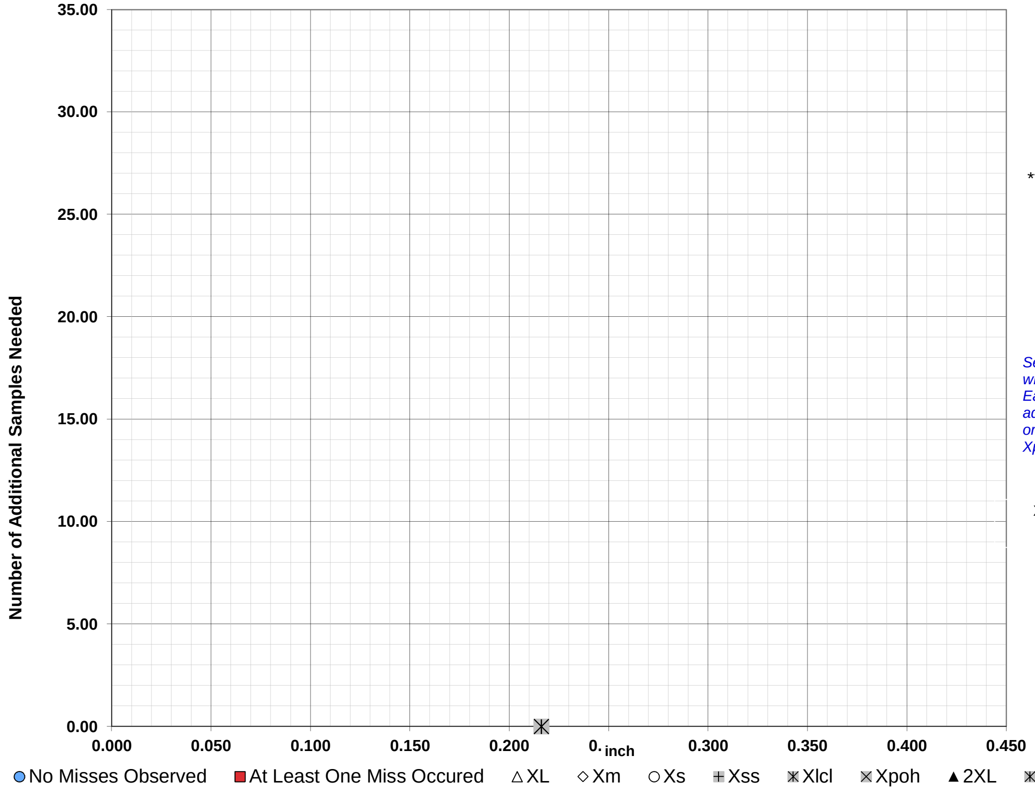


TABLE C

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*

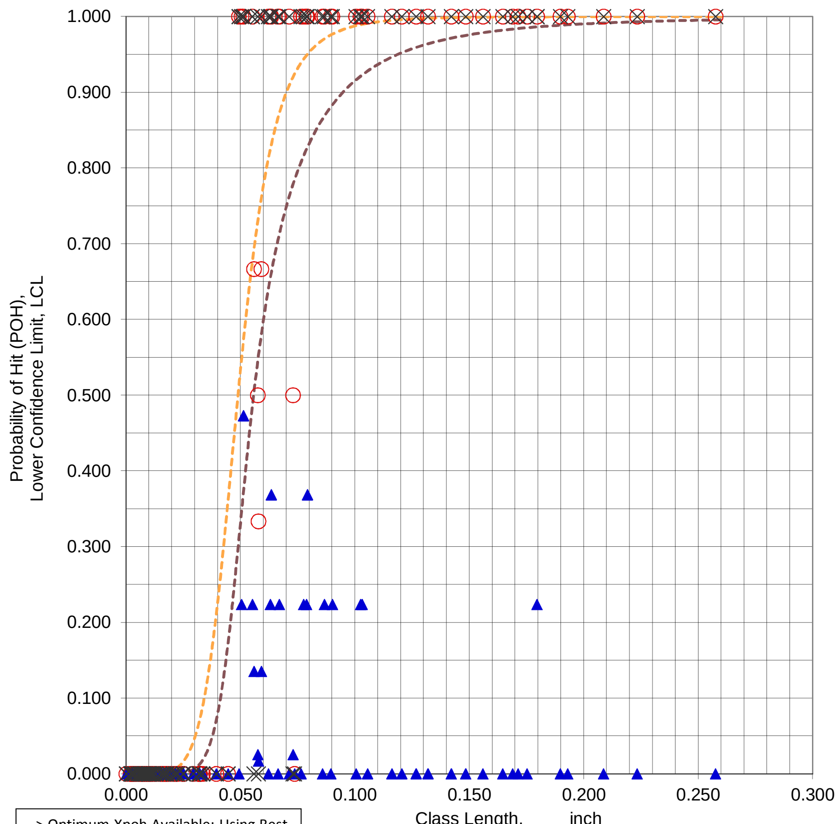
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



--> 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 = 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 #)

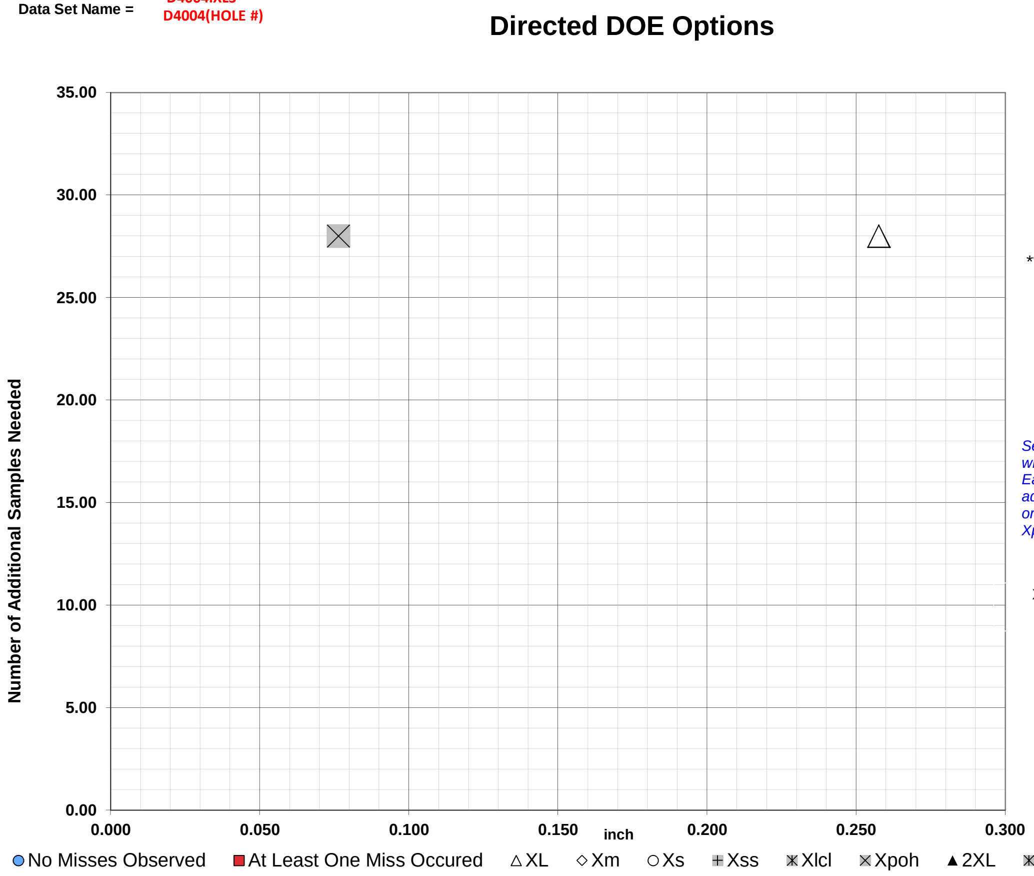


TABLE C

	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*

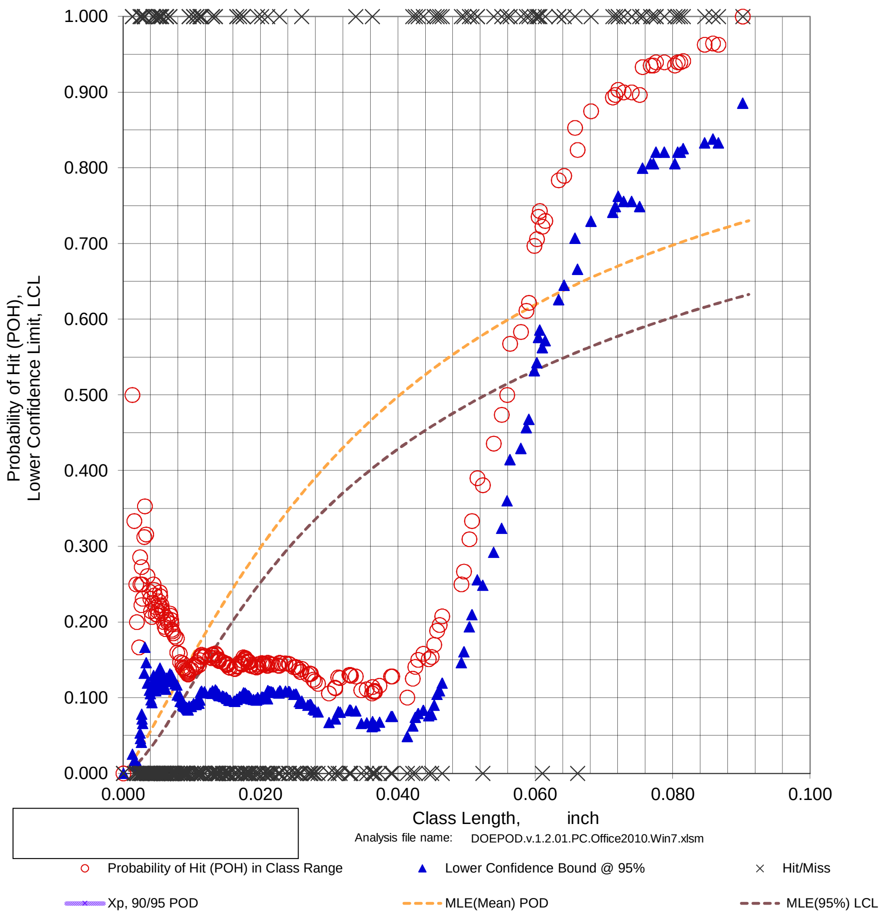
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

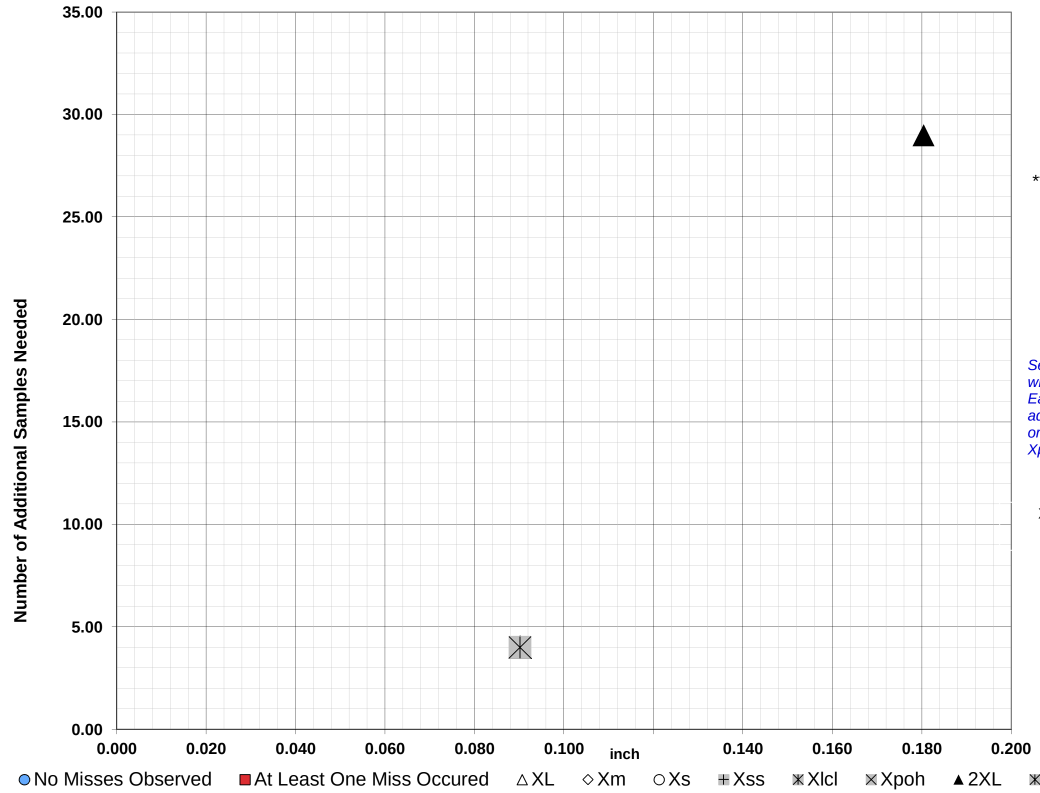


TABLE C

	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*

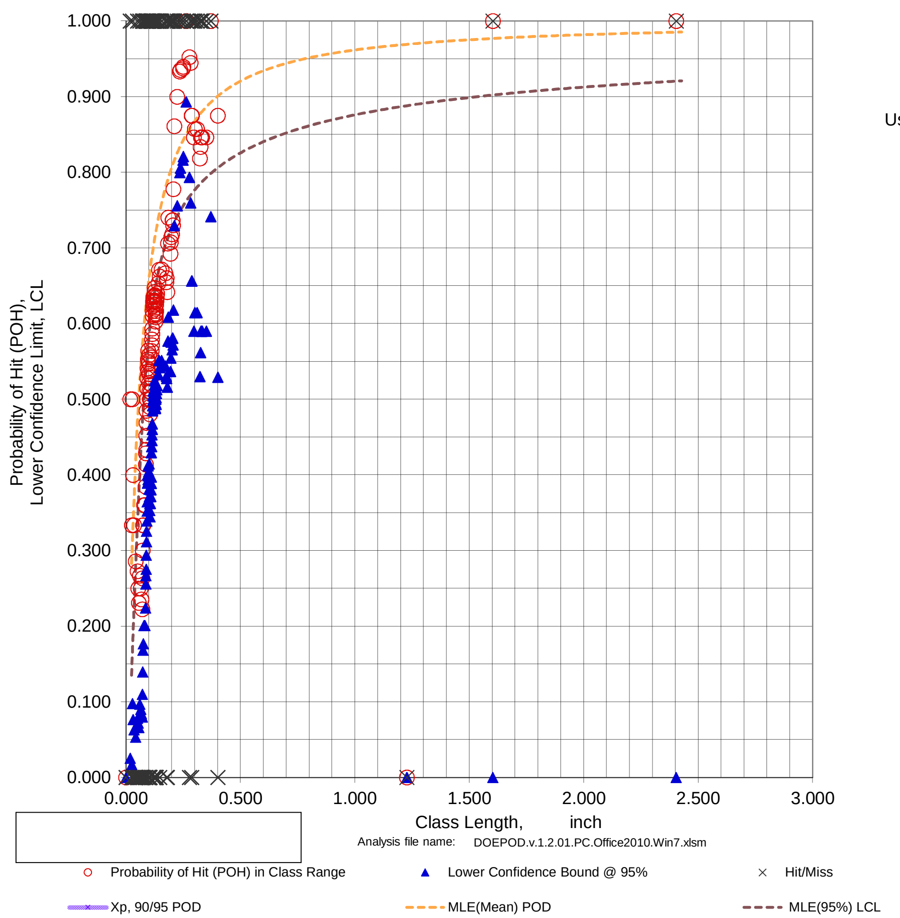
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

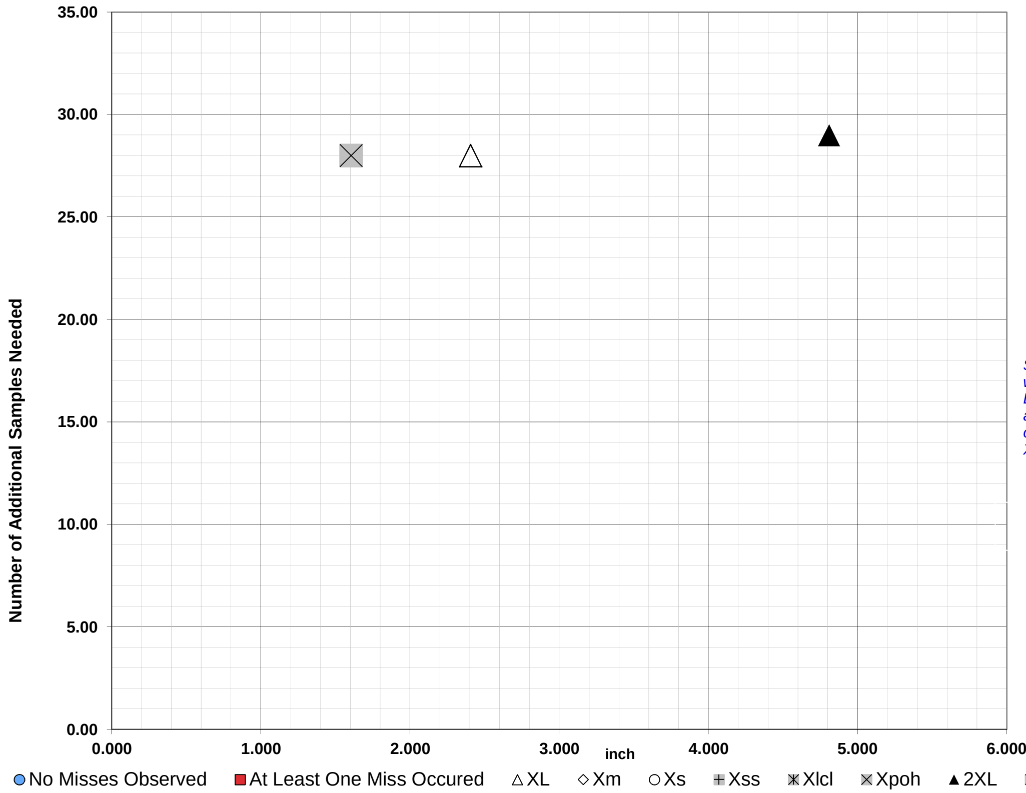


TABLE C

	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*

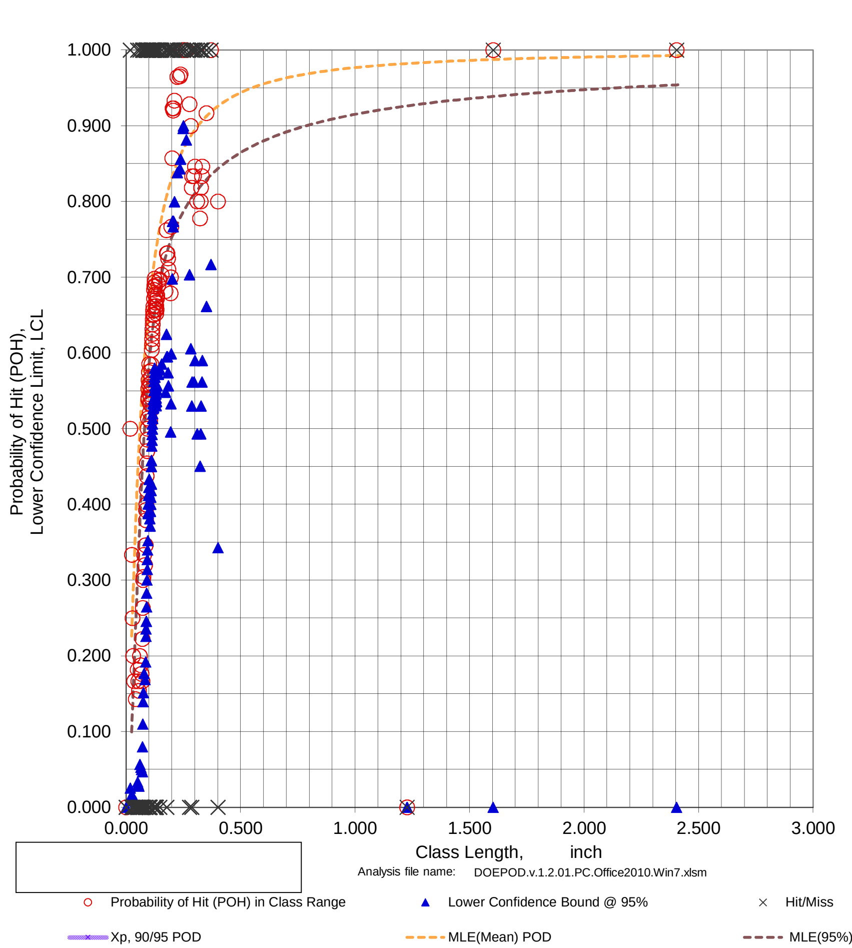
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

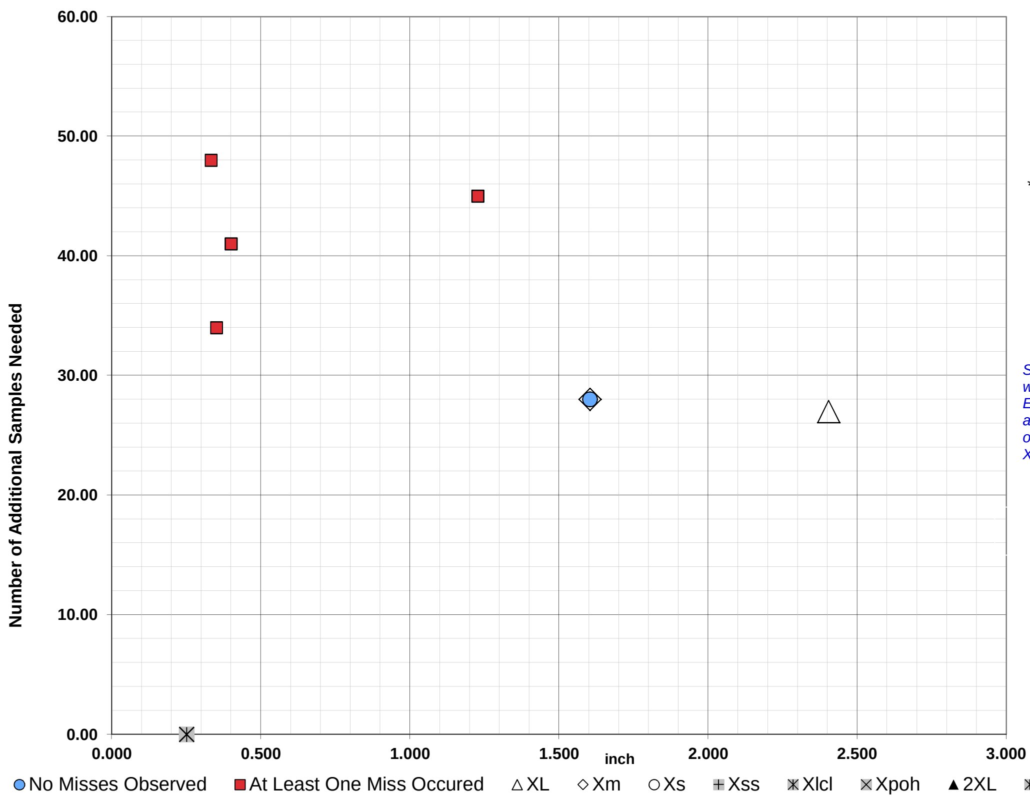


TABLE C

	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.

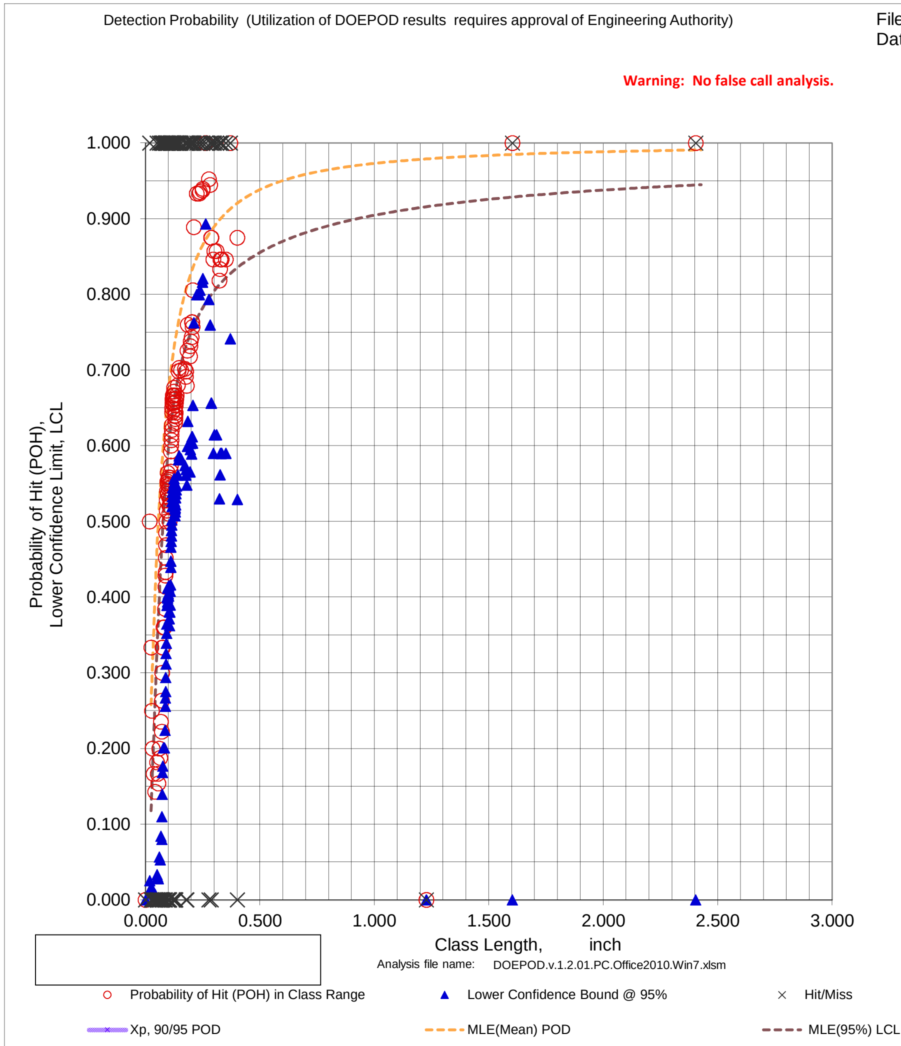
Xpod,Class Length	No. Need
1.2270	45
0.4000	41
0.3500	34
0.3320	48

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



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

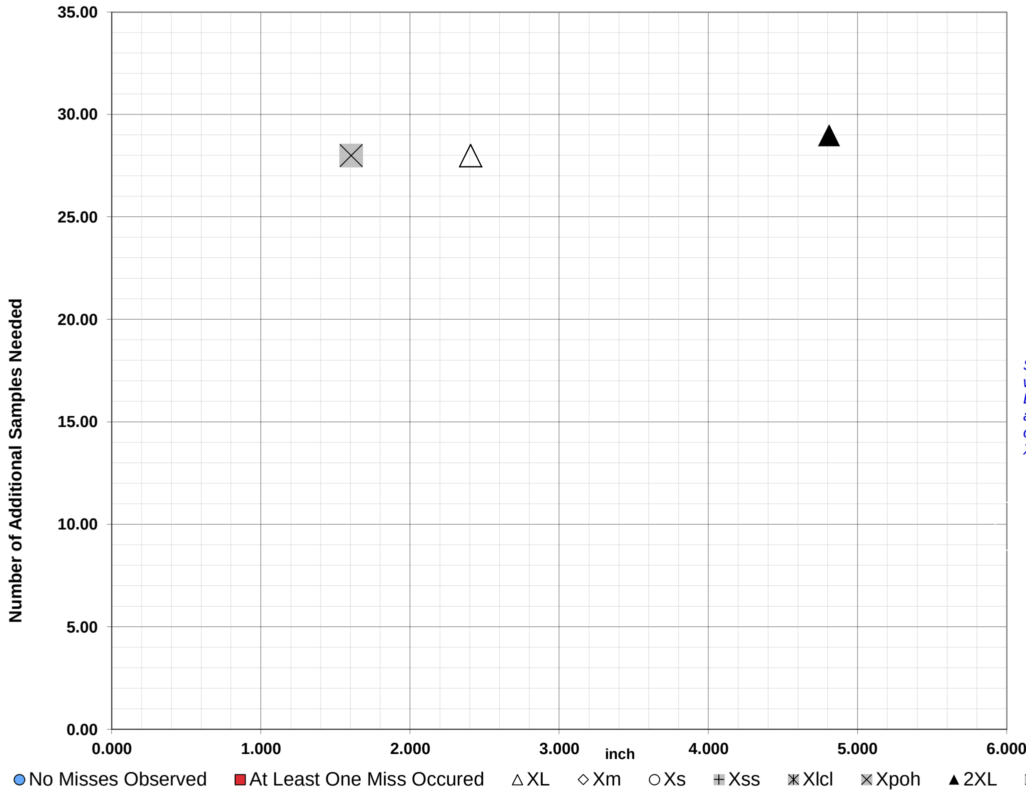


TABLE C

	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.

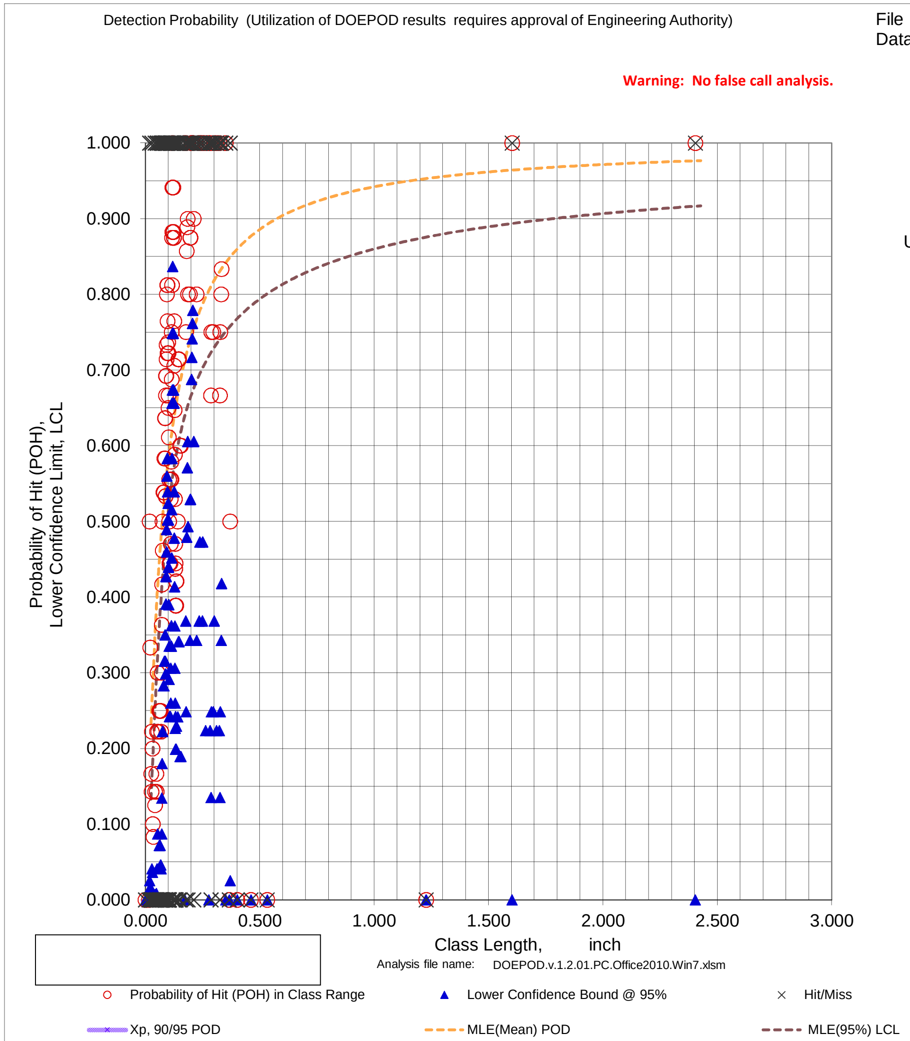
Xpod,Class Length	No. Need

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



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

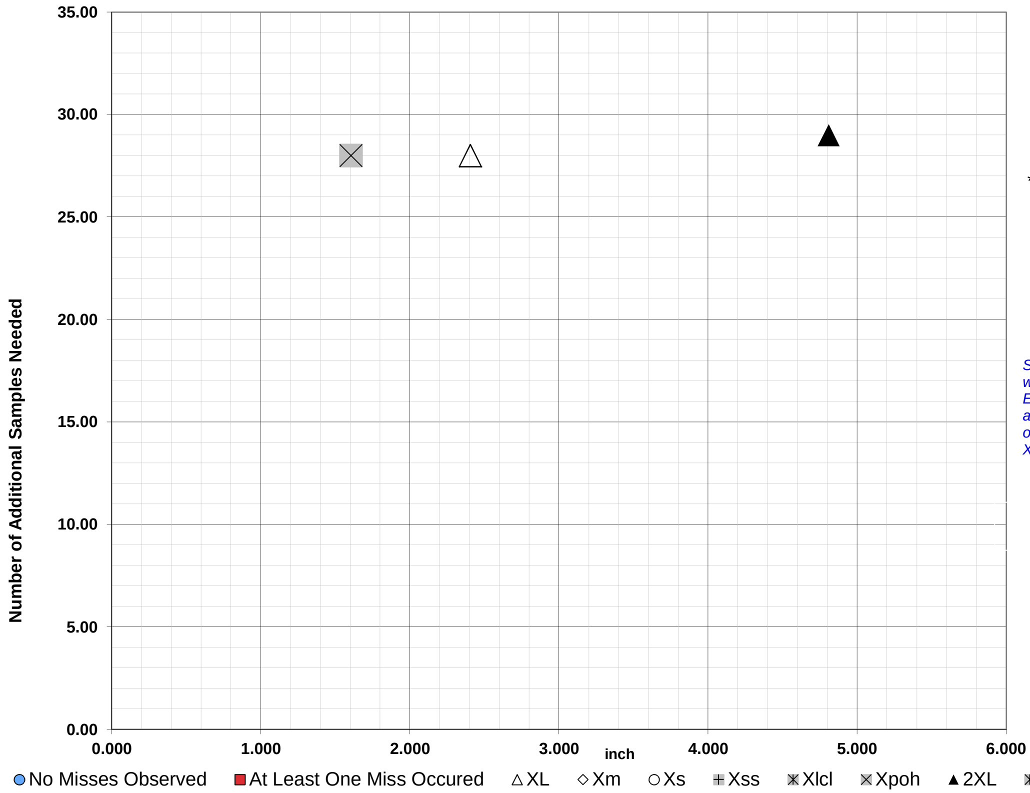


TABLE C

	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*

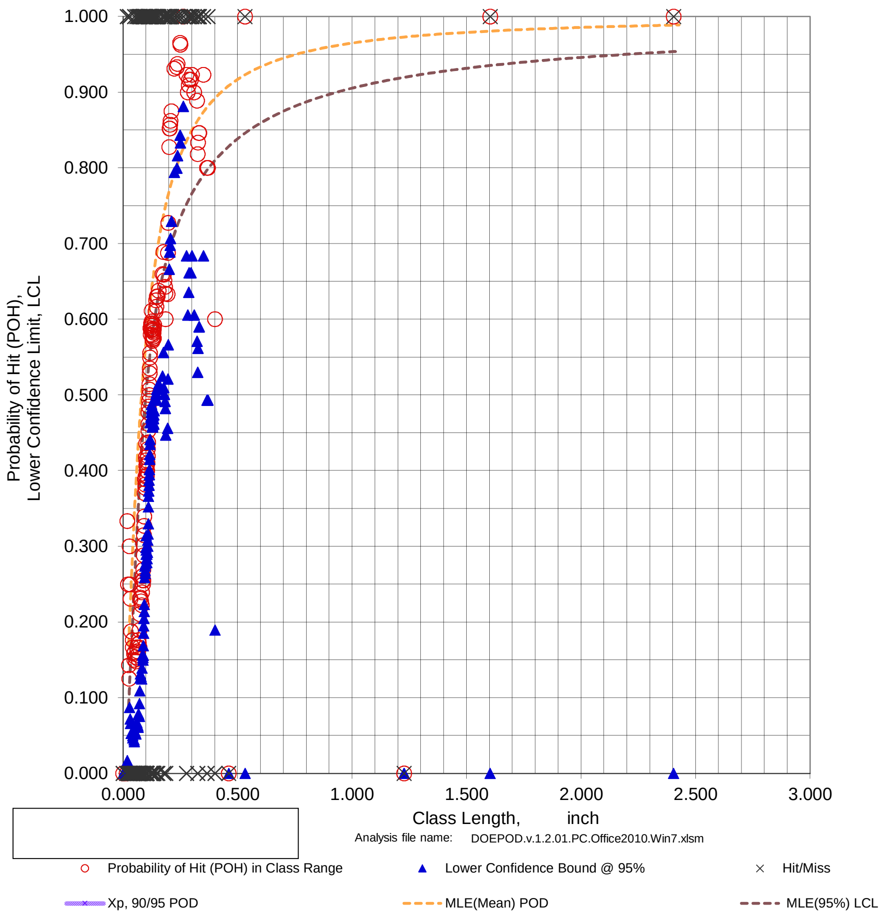
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

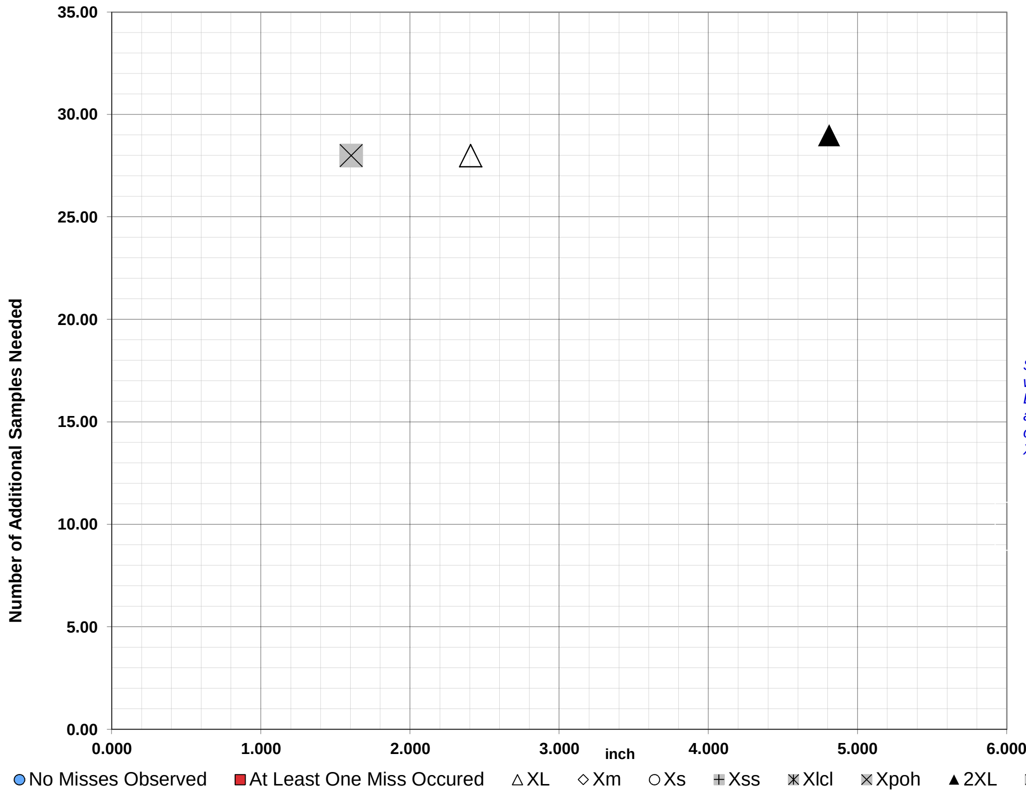


TABLE C

	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

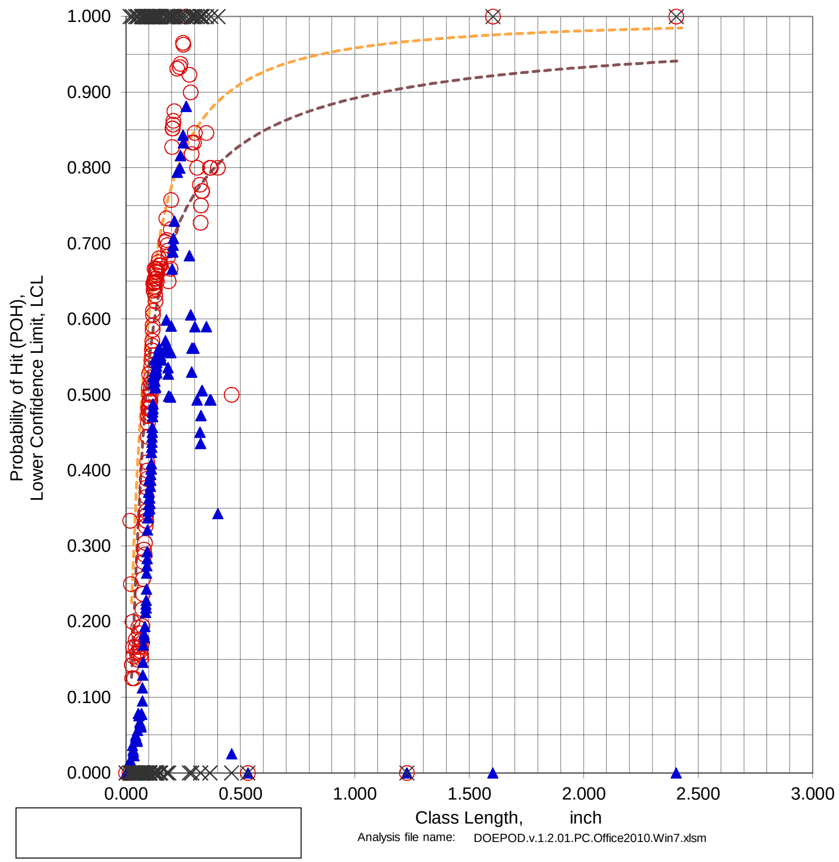
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

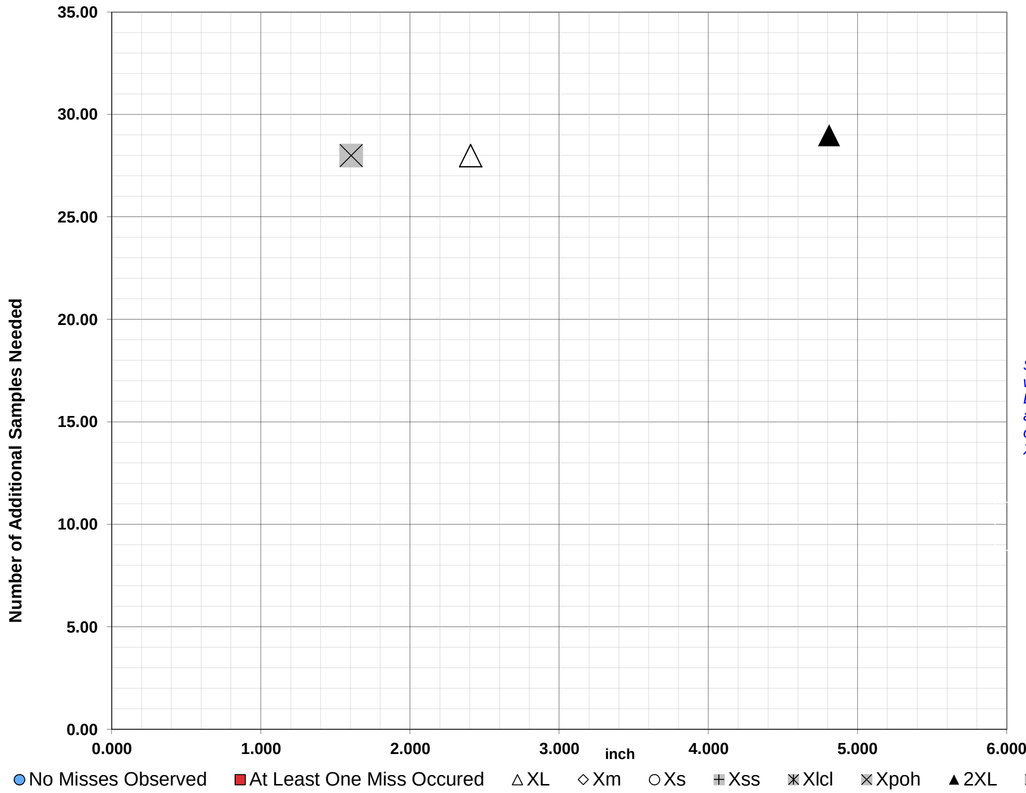


TABLE C

	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

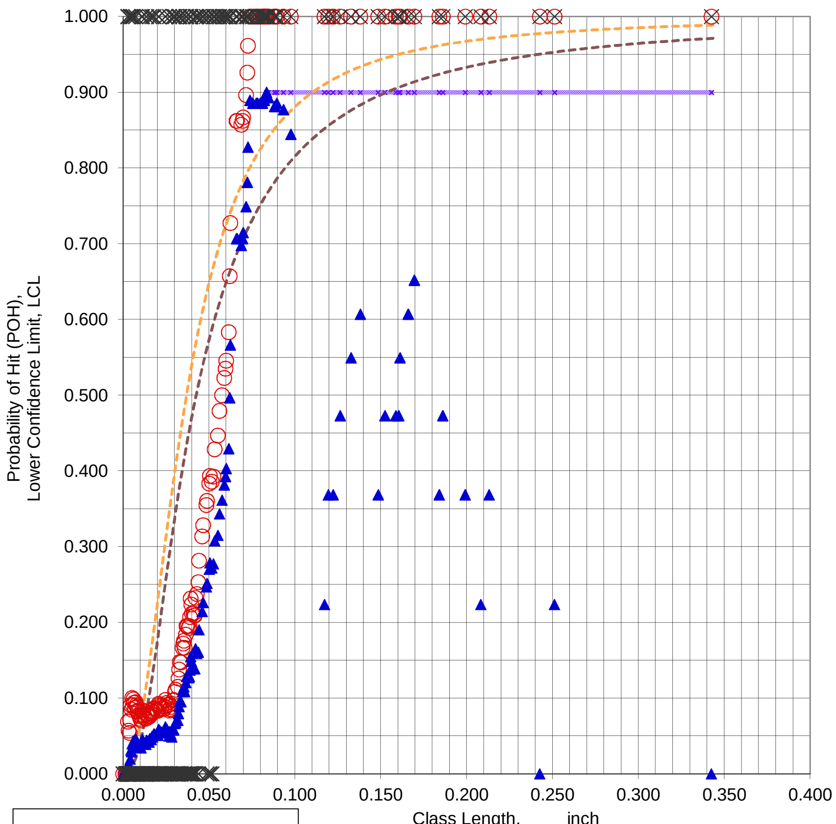
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

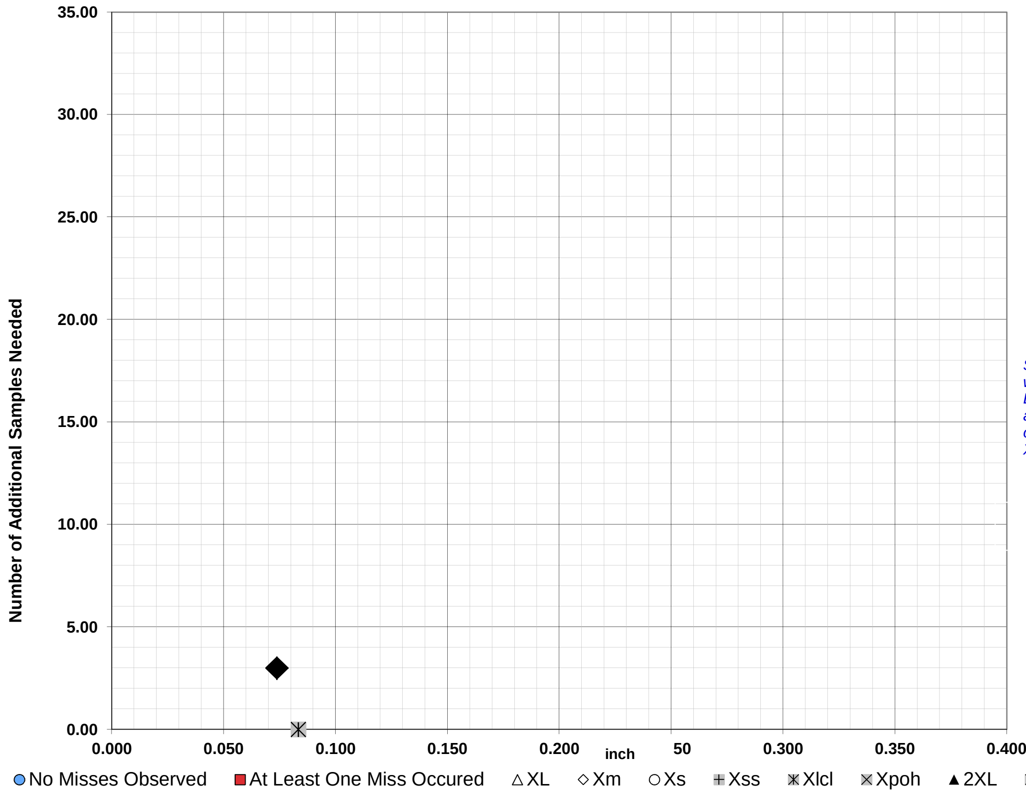


TABLE C

	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

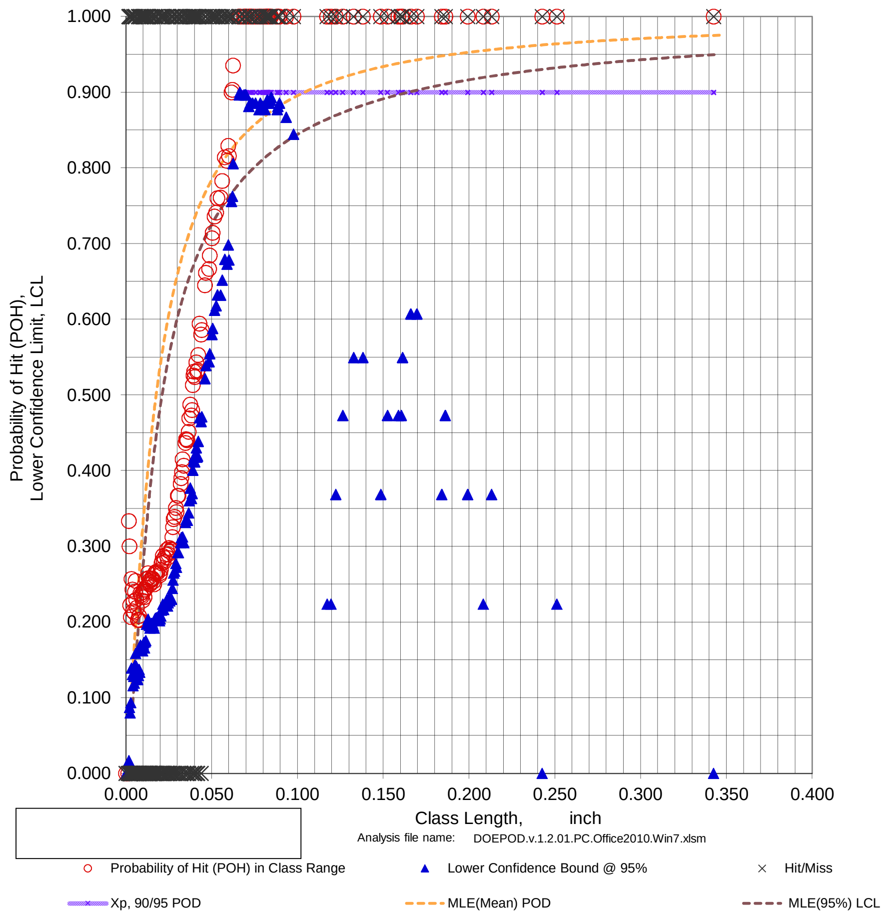
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

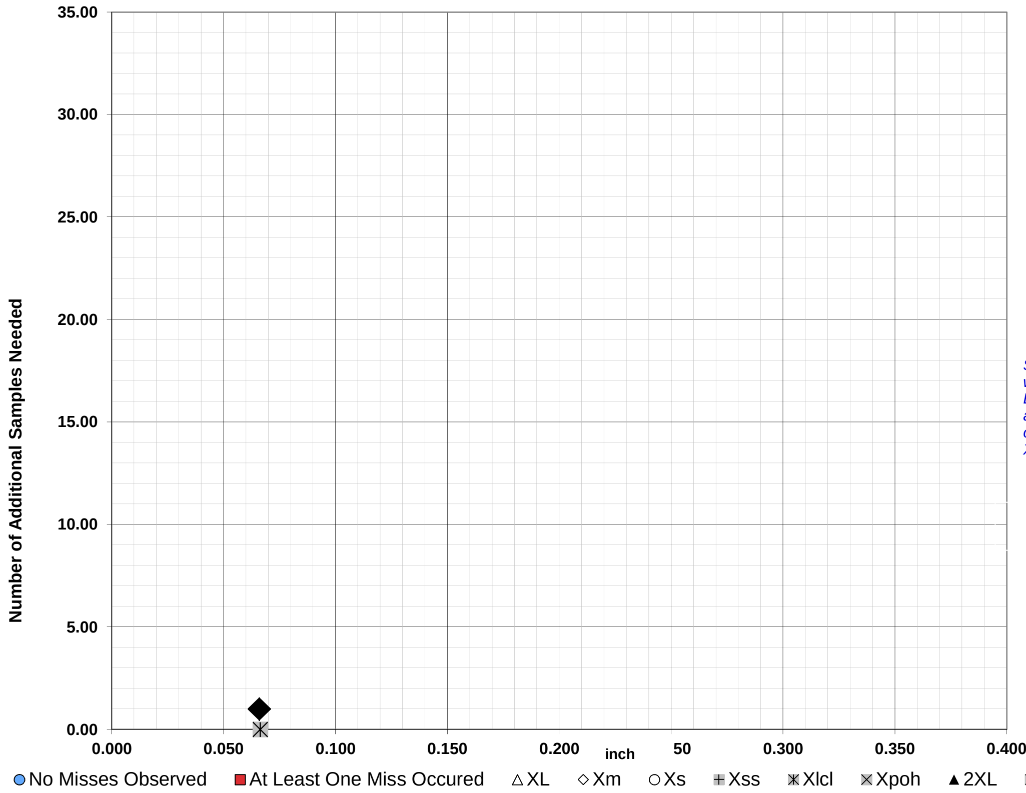


TABLE C

	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

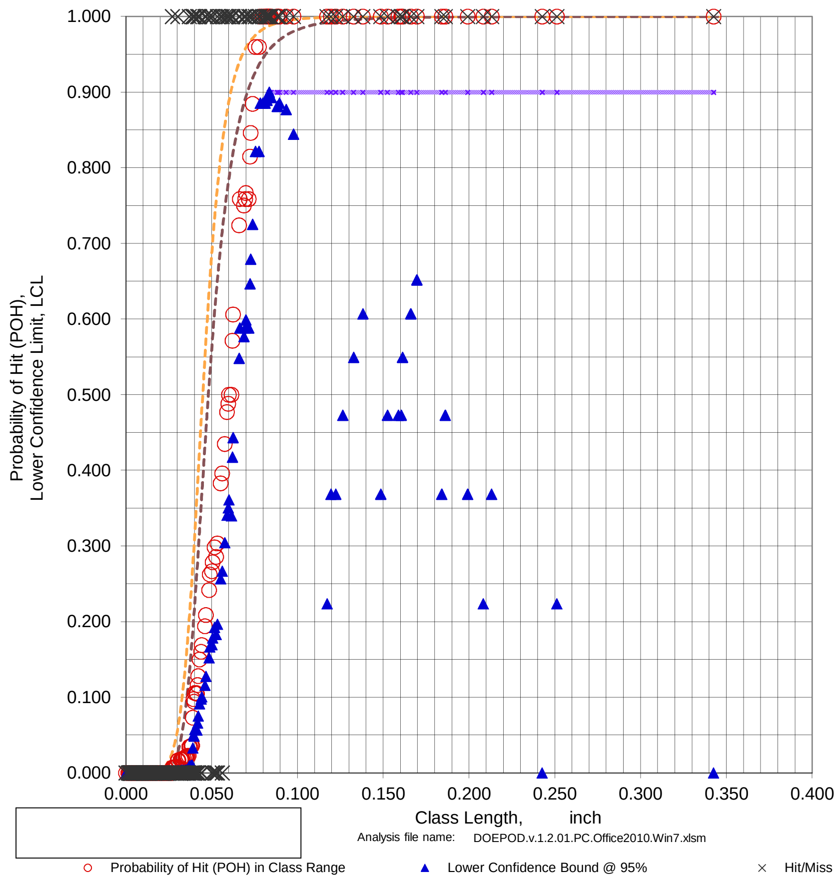
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

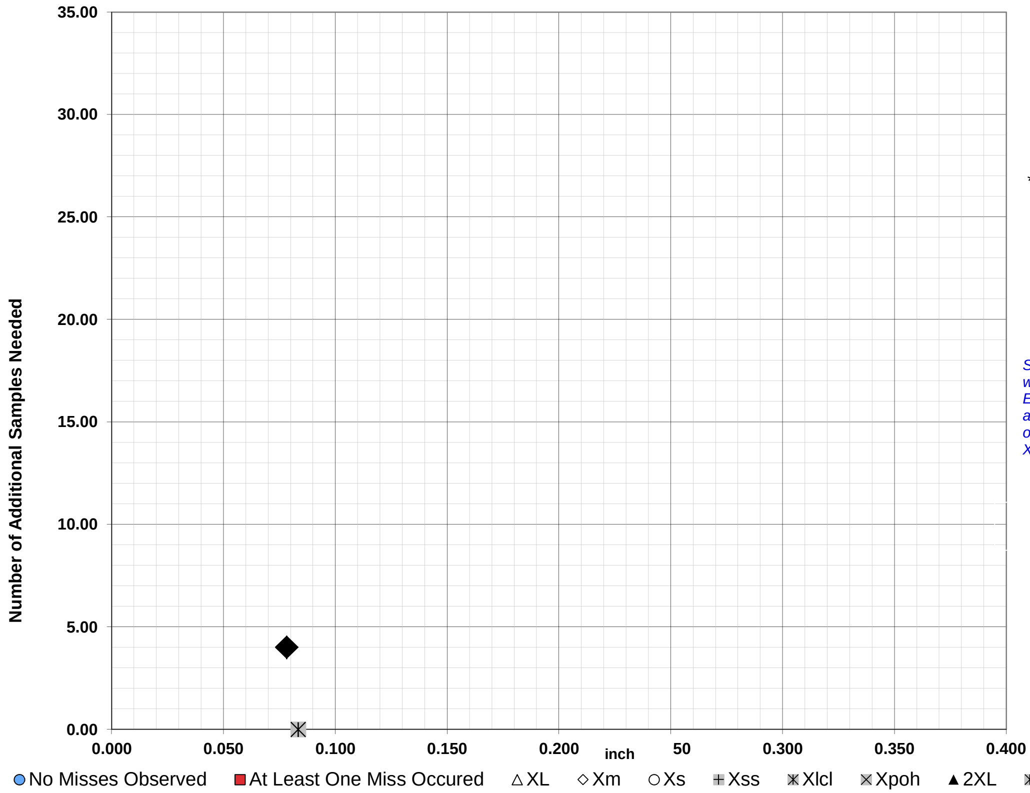


TABLE C

	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*

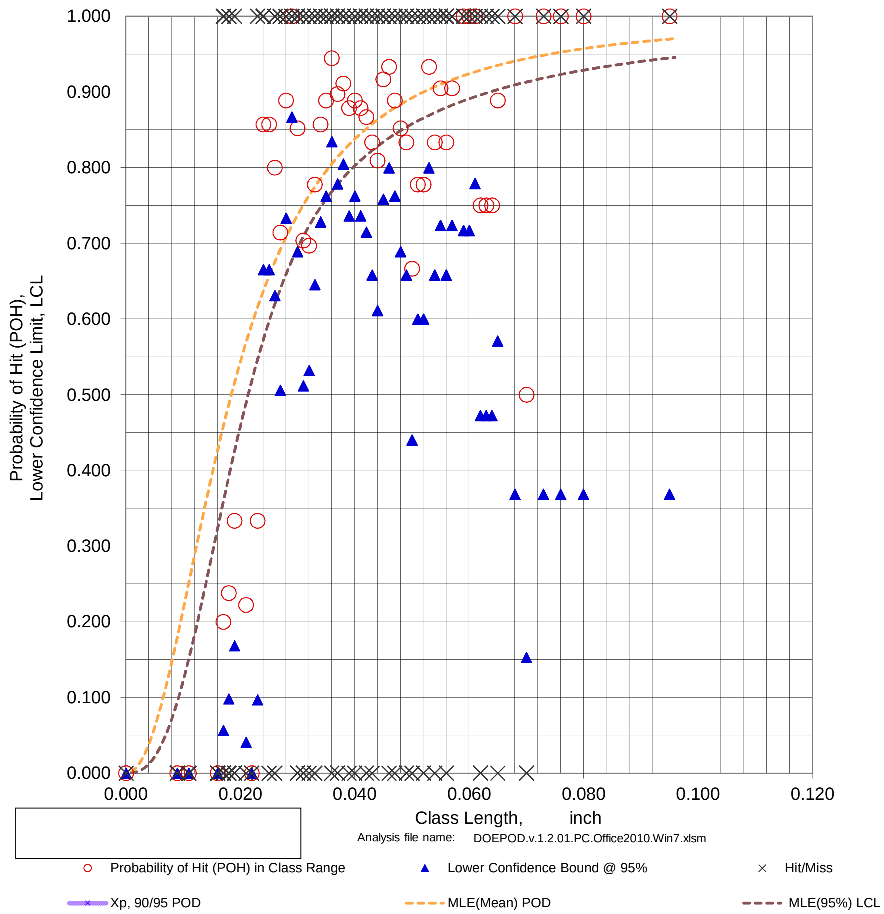
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

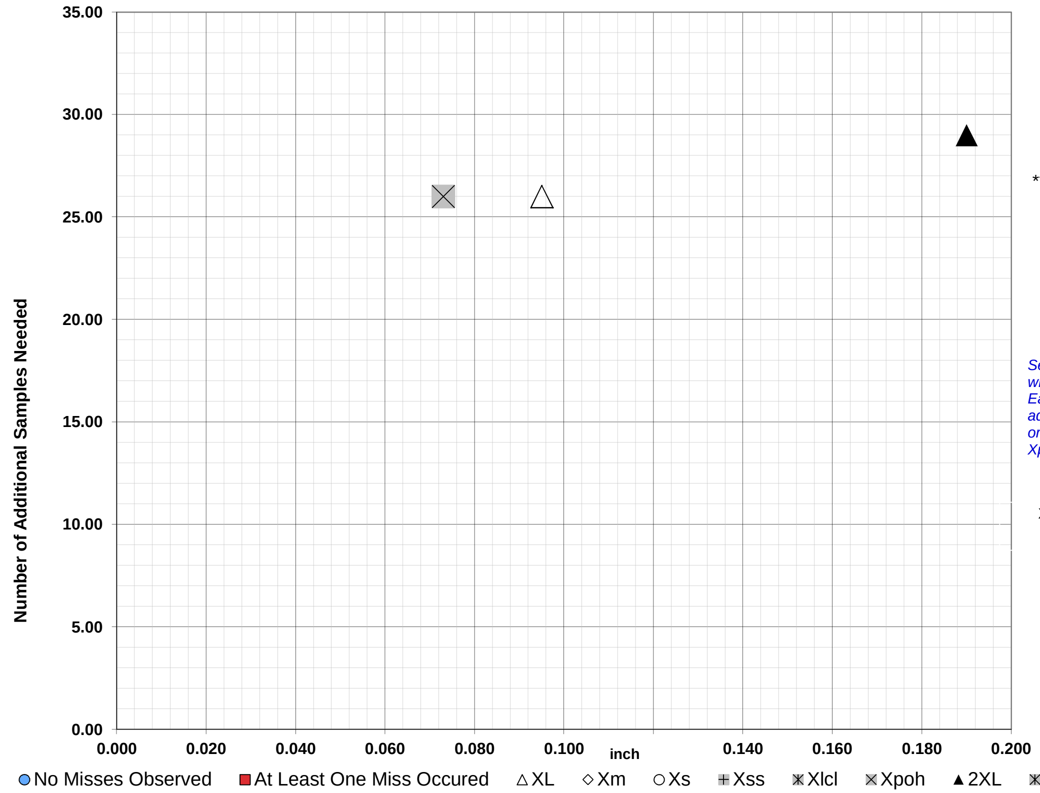


TABLE C

	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.

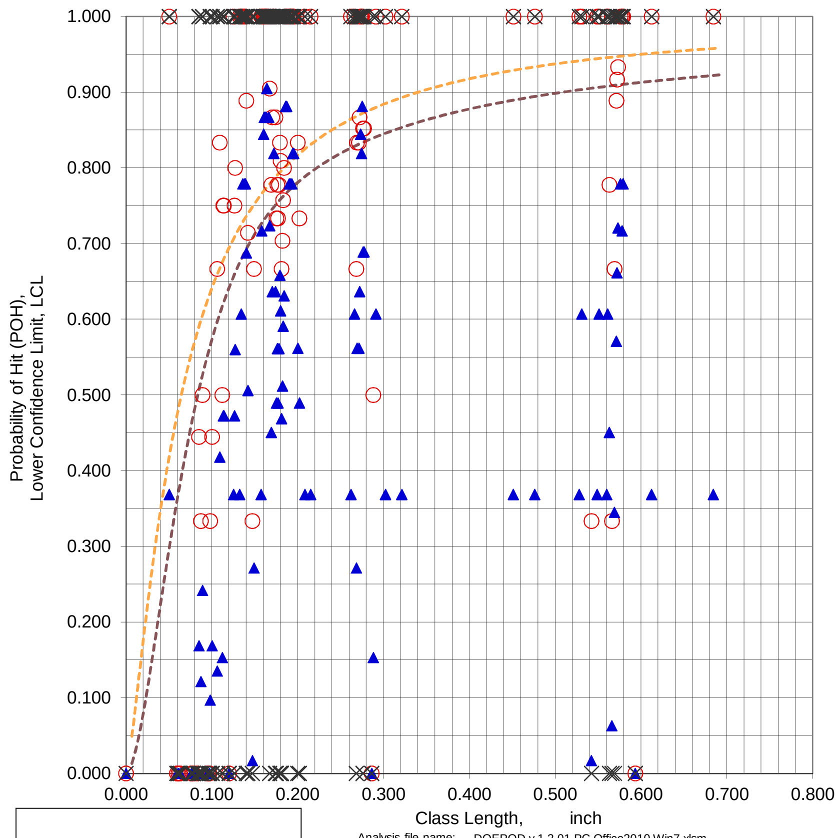
Xpod,Class Length	No. Need

* 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.



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 =	**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

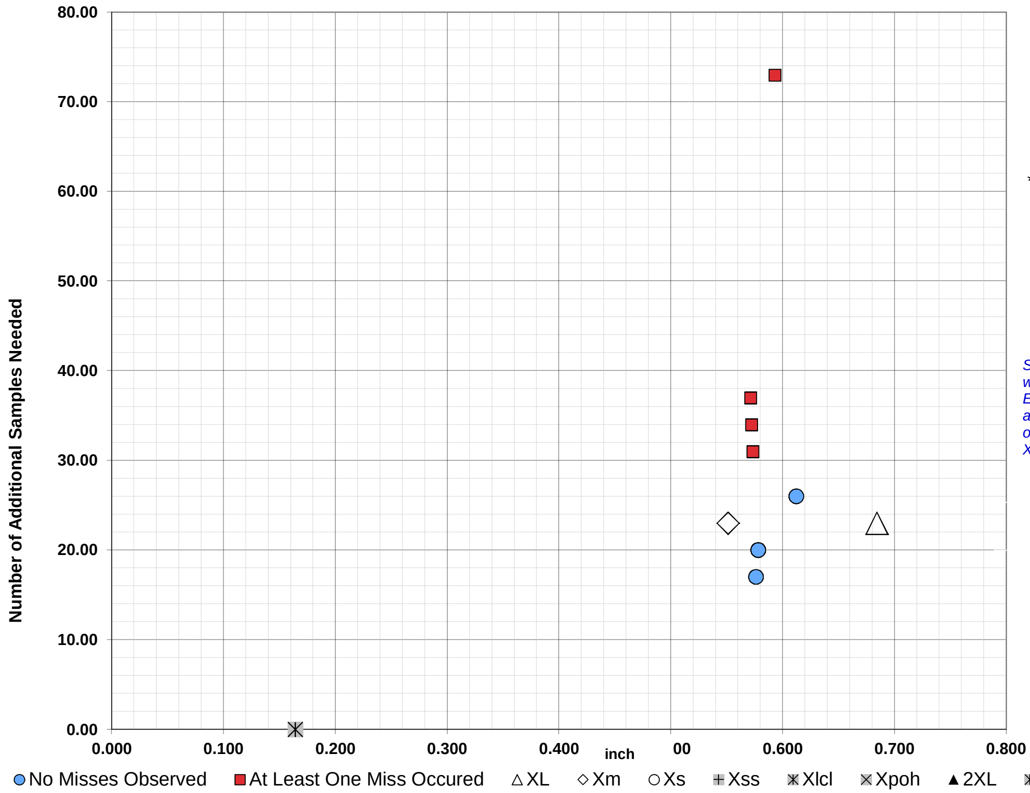


TABLE C

	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

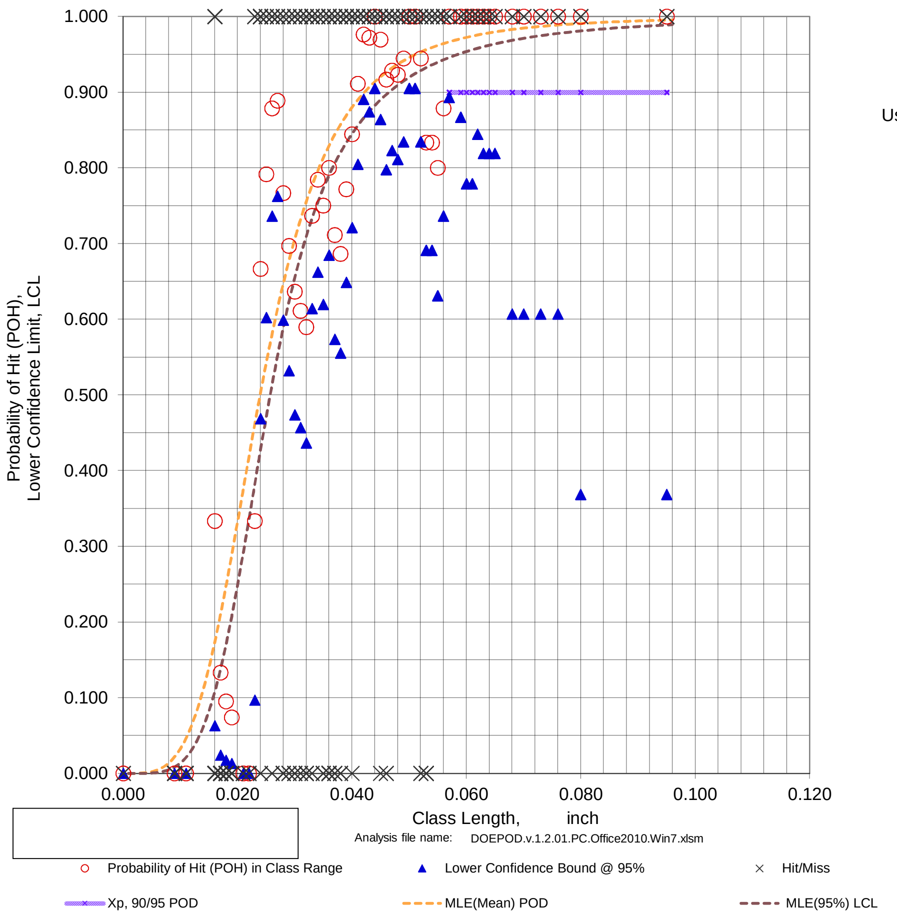
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

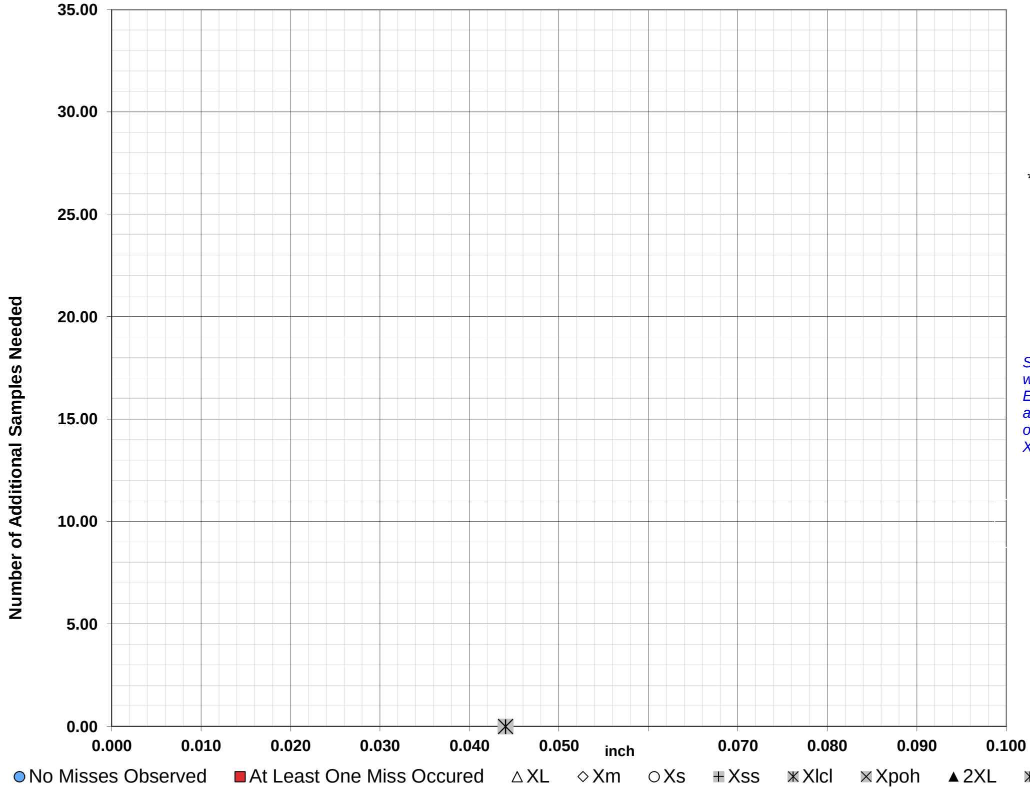


TABLE C

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

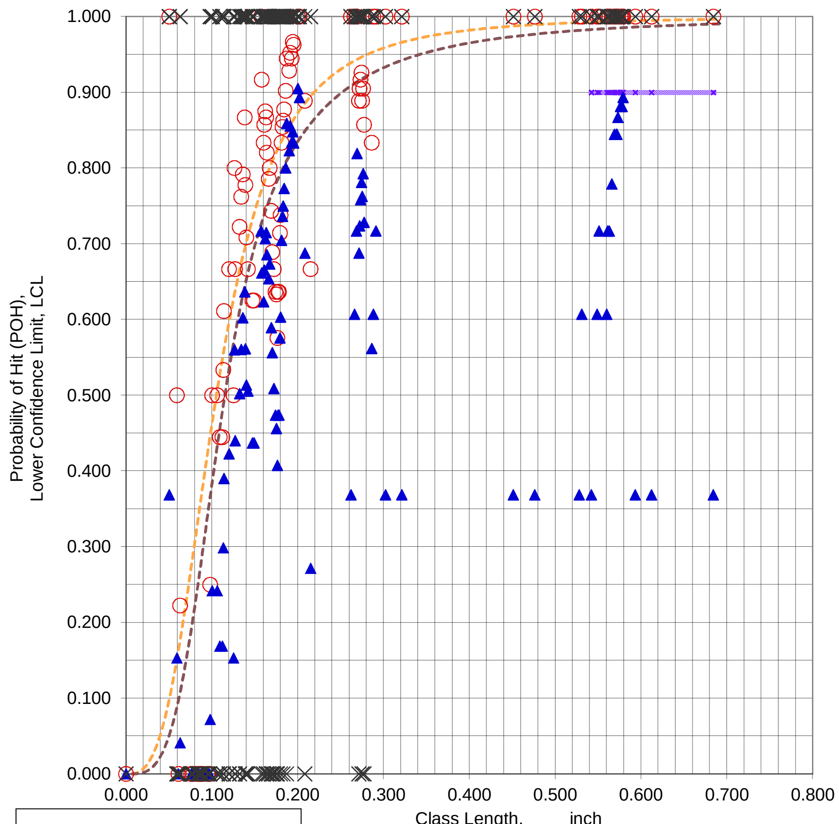
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

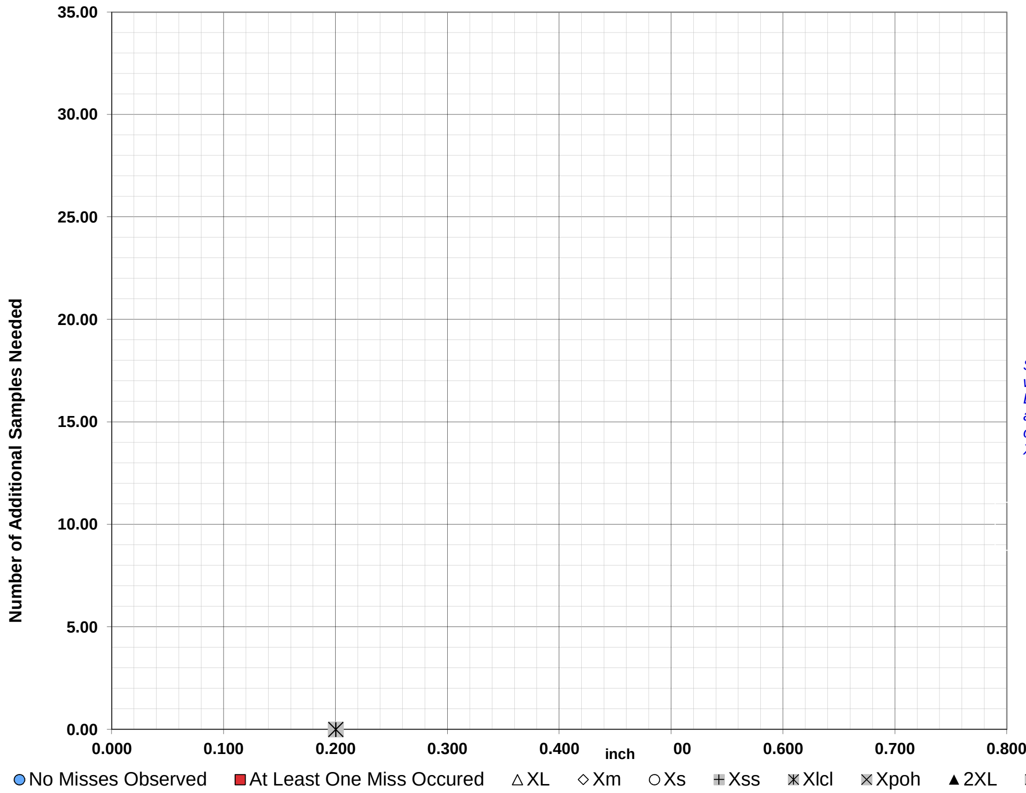


TABLE C

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.

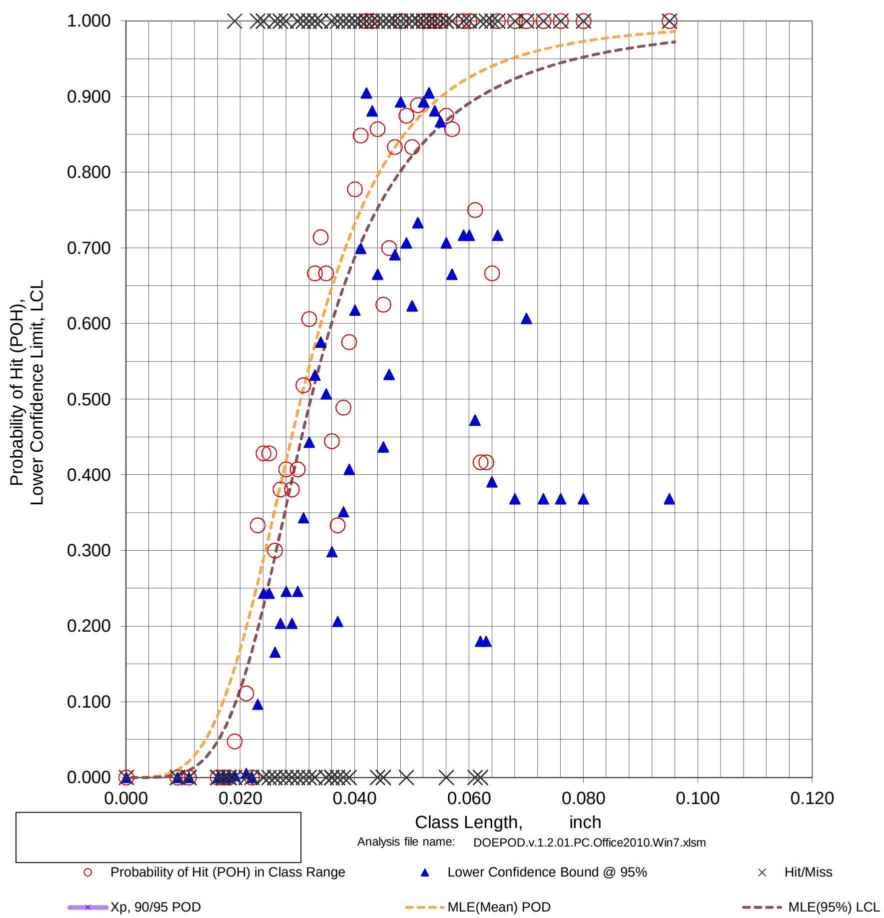
Xpod,Class Length	No. Need

* 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

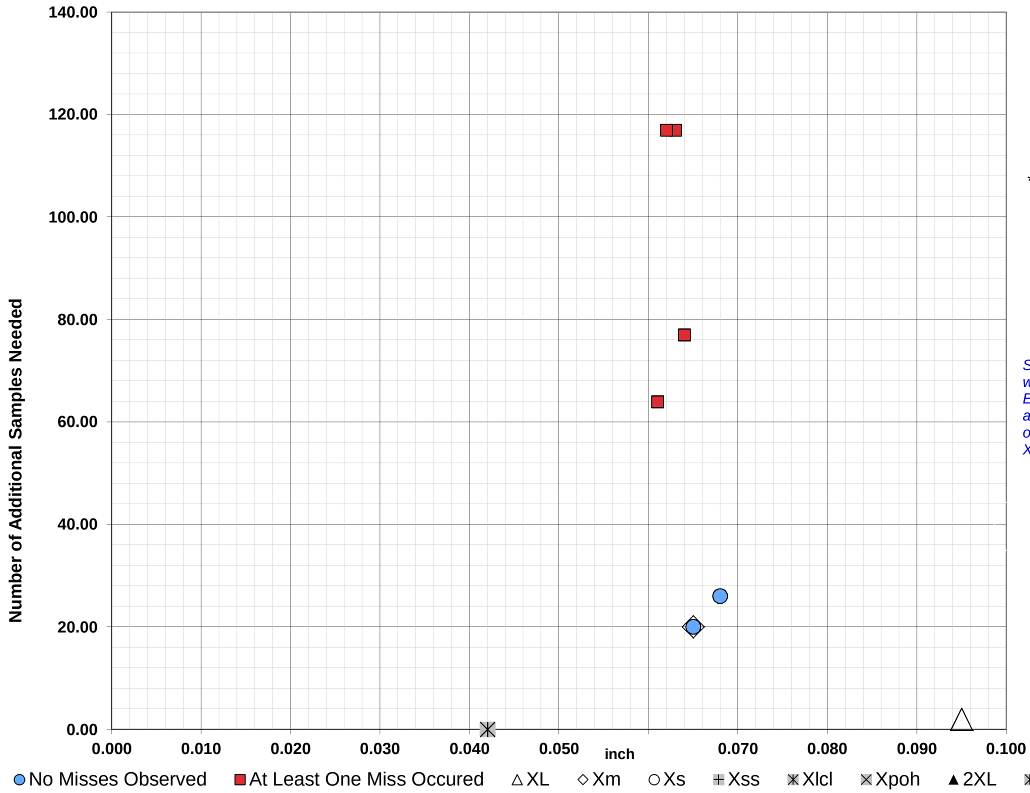


TABLE C

	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.

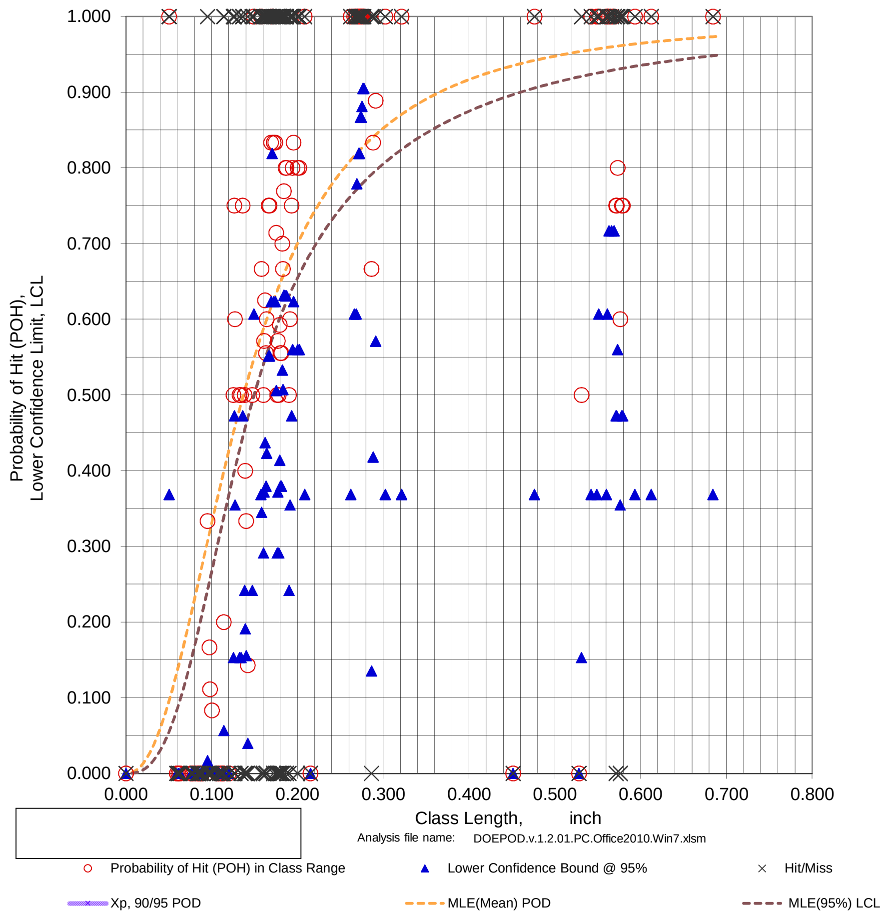
Xpod,Class Length	No. Need
0.0680	26
0.0650	20
0.0650	20

* 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

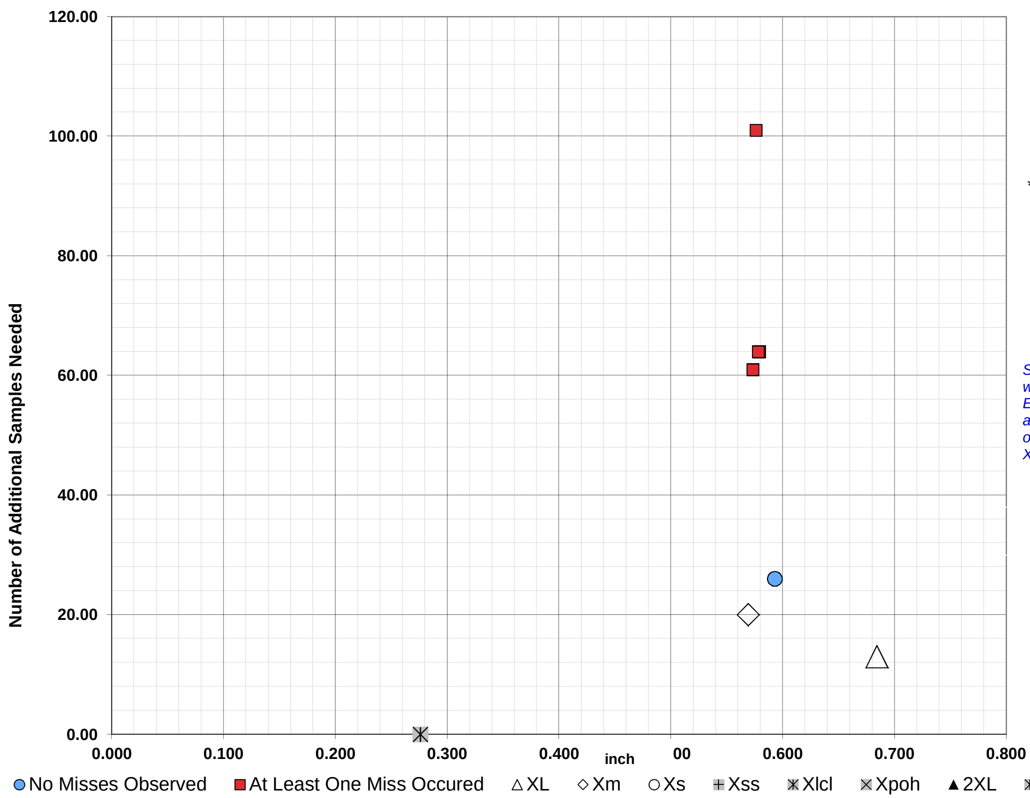


TABLE C

	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.

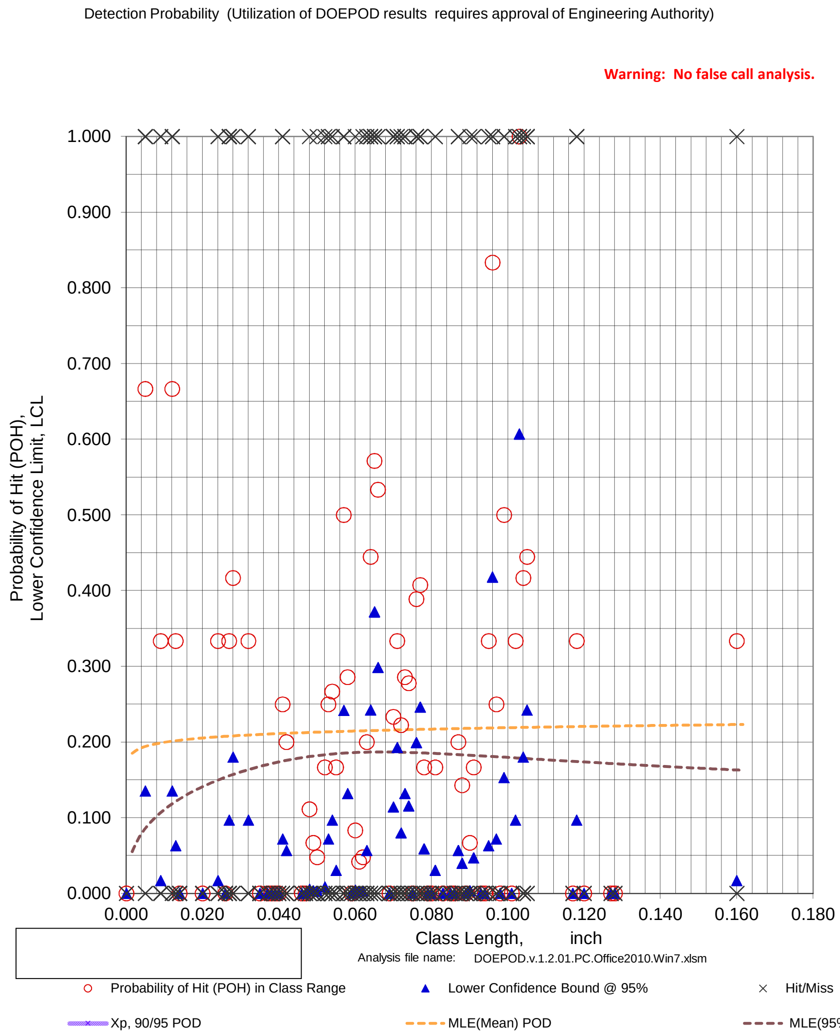
Xpod,Class Length	No. Need
0.5790	64
0.5780	64
0.5760	101
0.5730	61

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



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

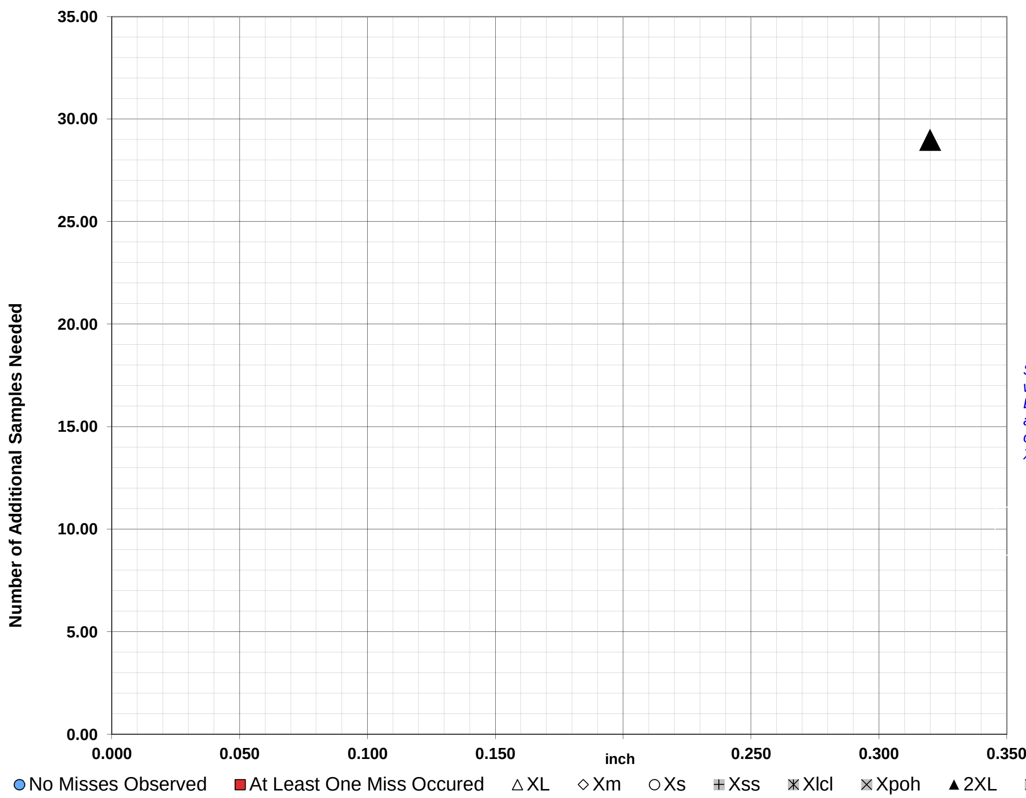


TABLE C

	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*

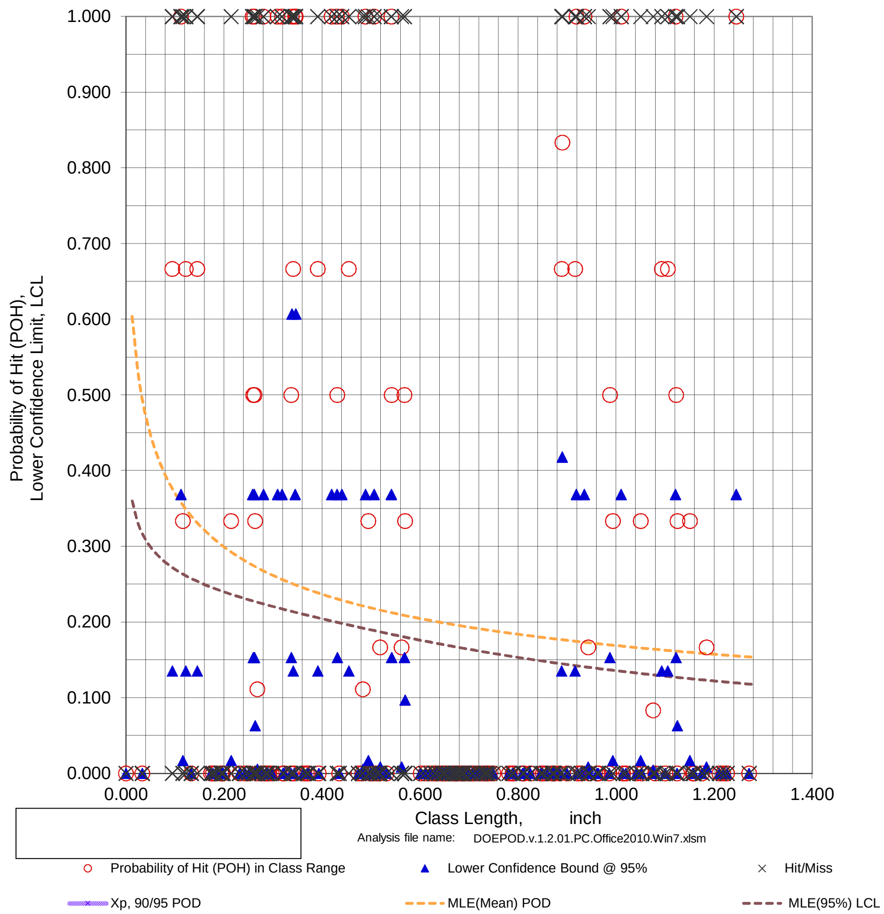
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

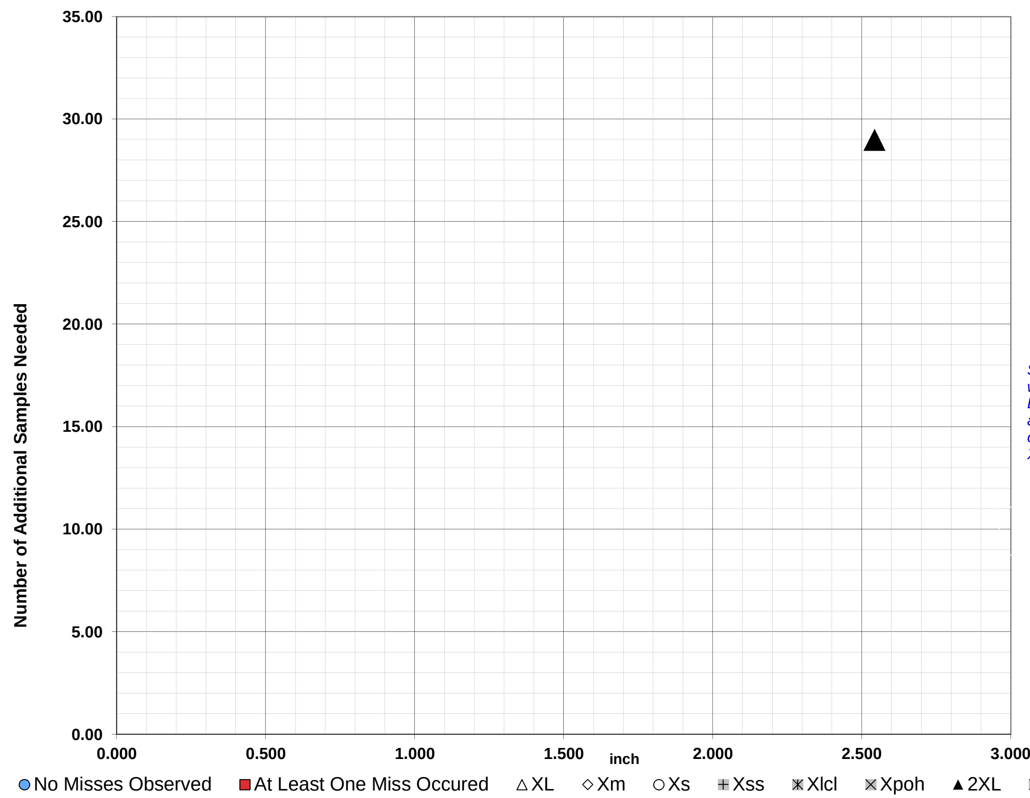


TABLE C

	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*

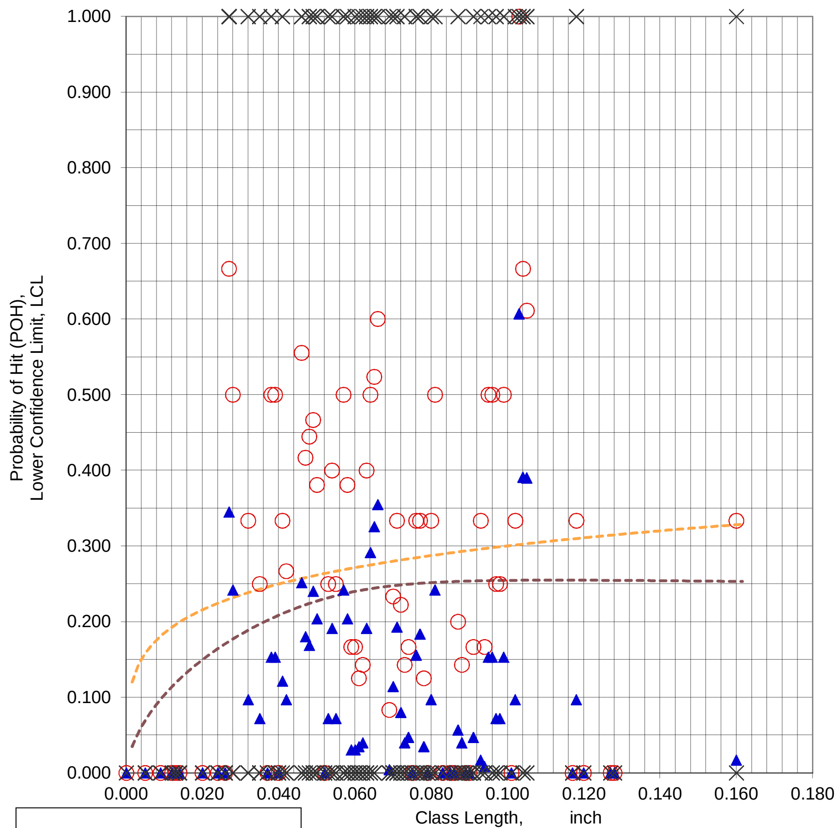
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = **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

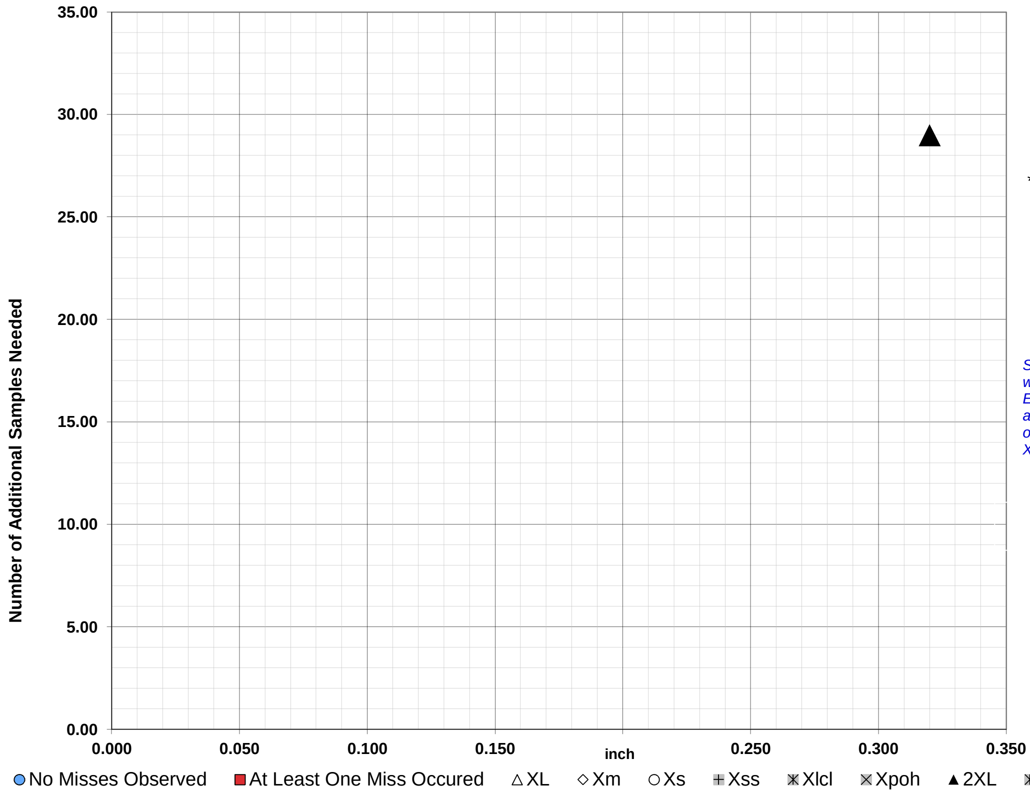


TABLE C

	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*

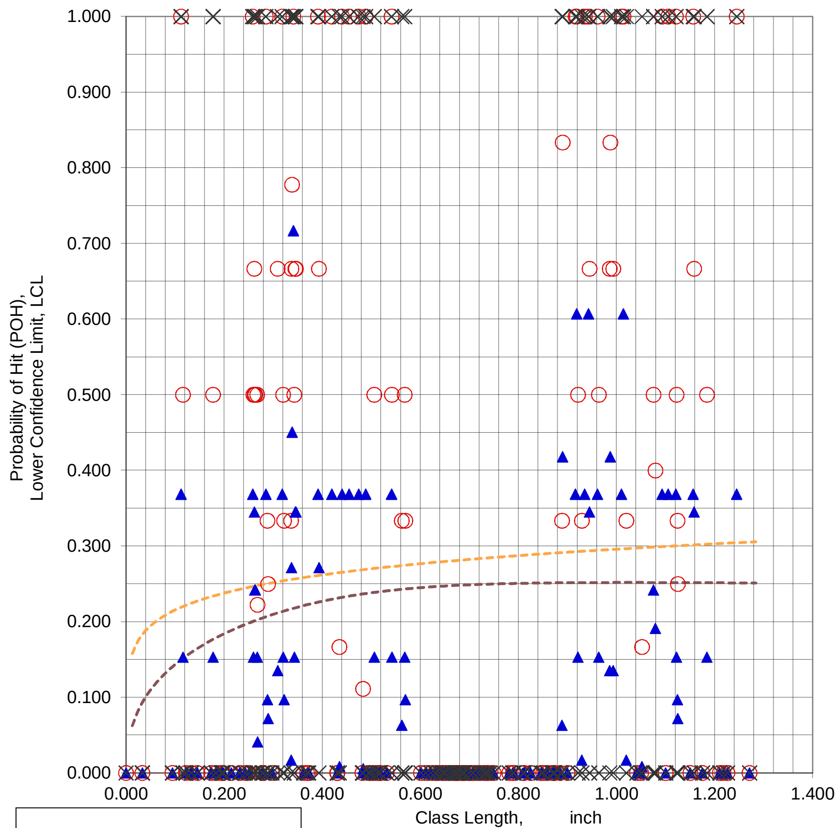
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = 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

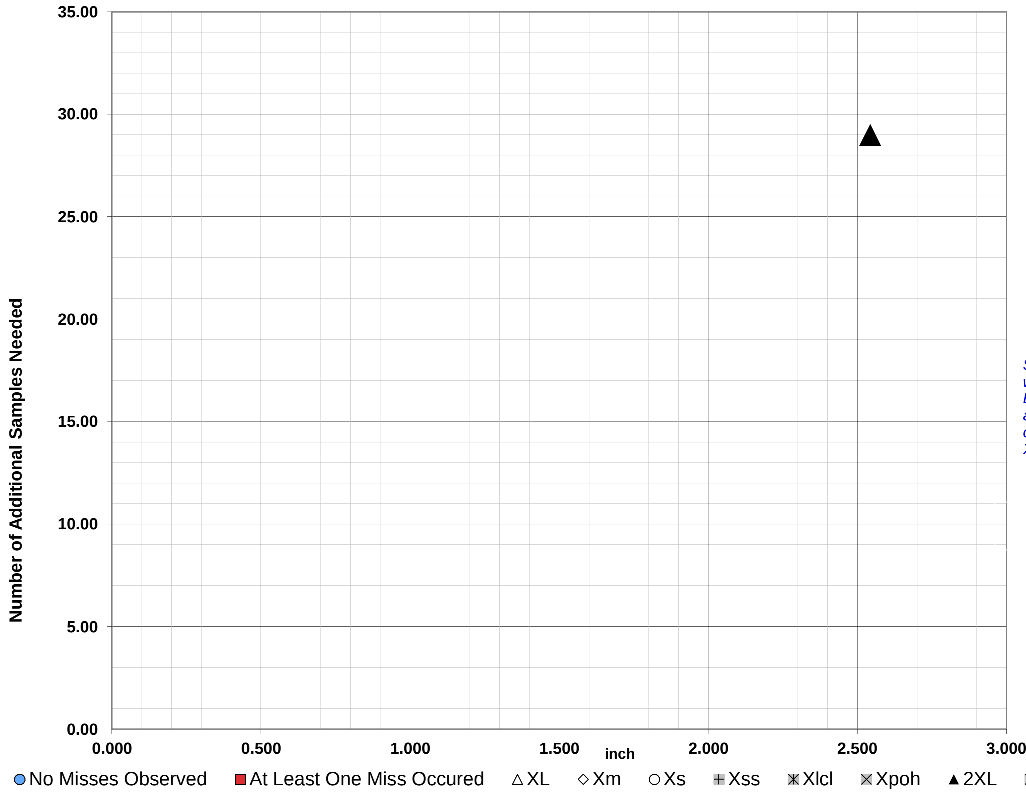


TABLE C

	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

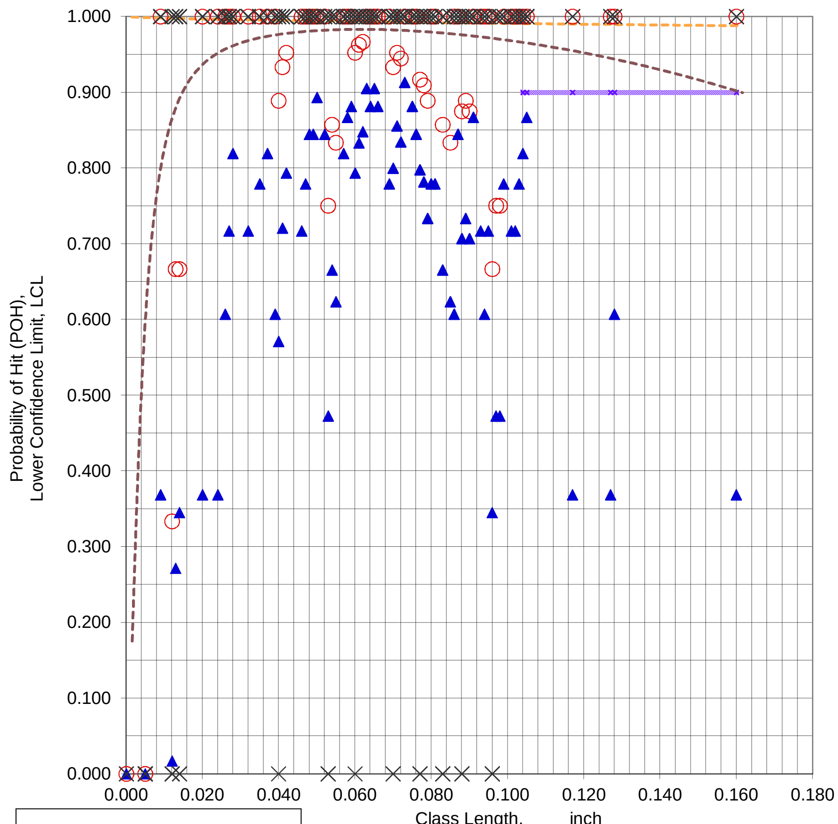
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

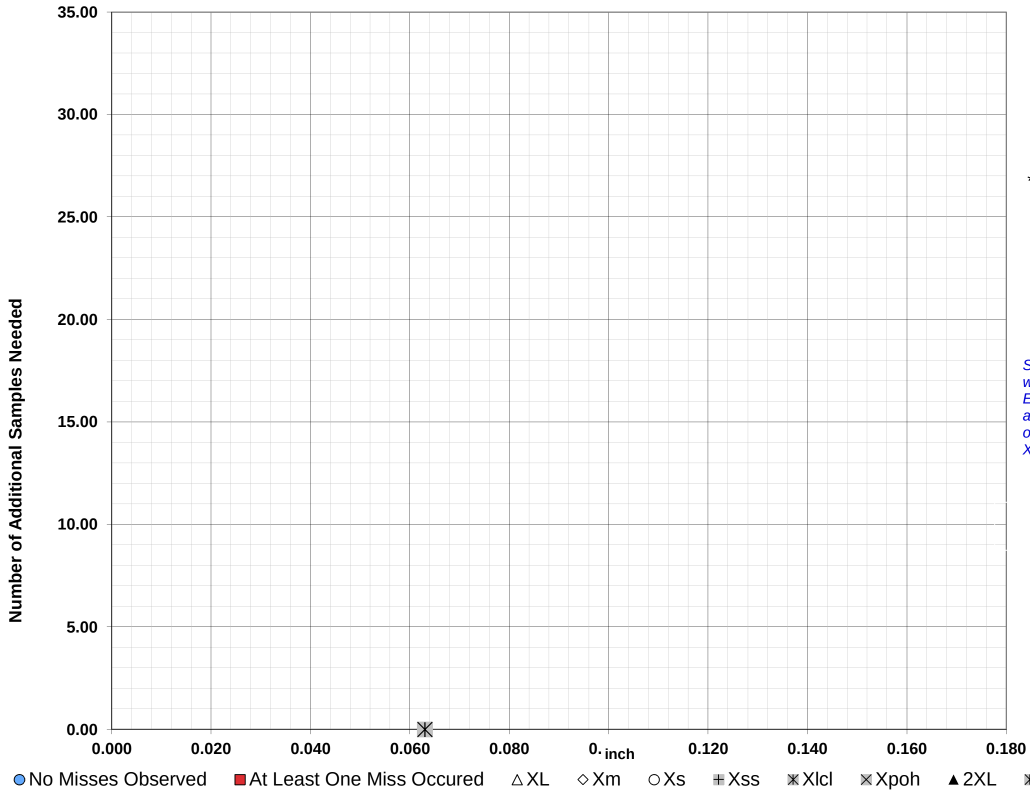


TABLE C

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

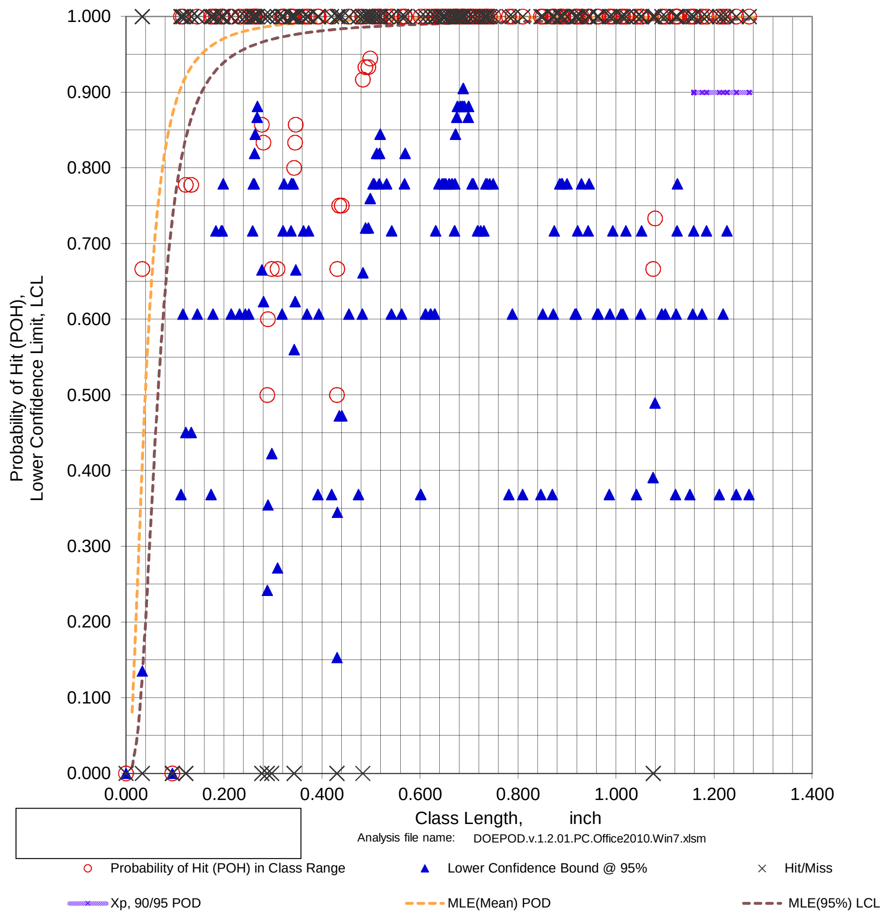
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

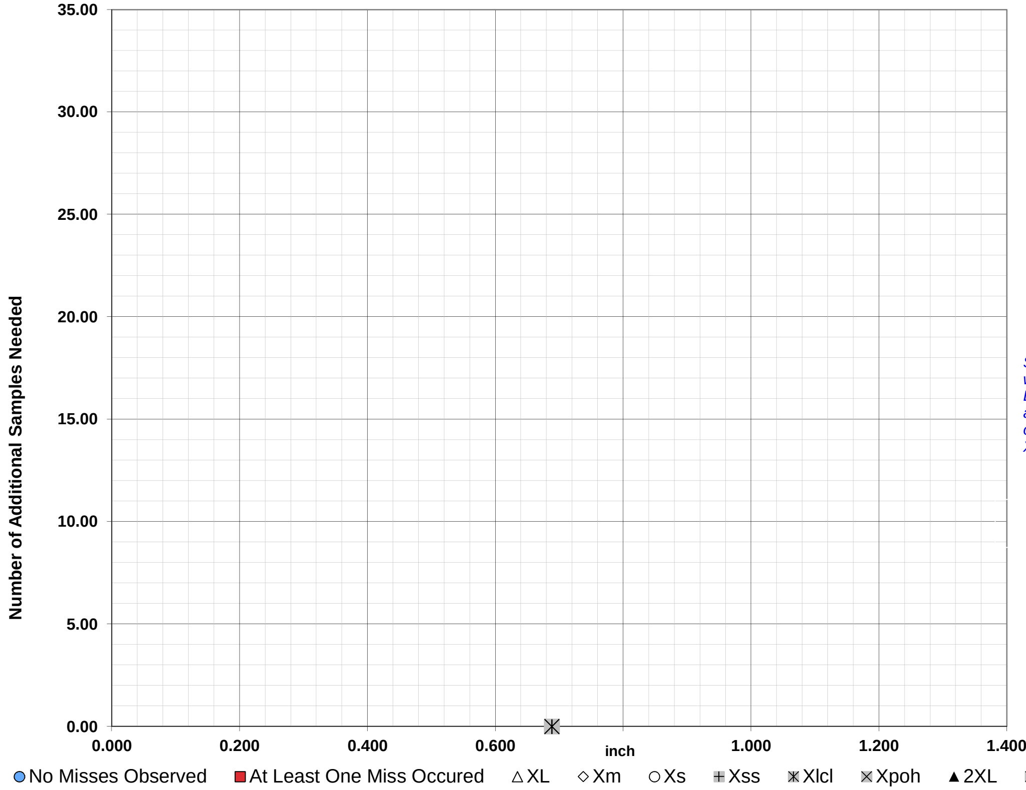


TABLE C

	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*

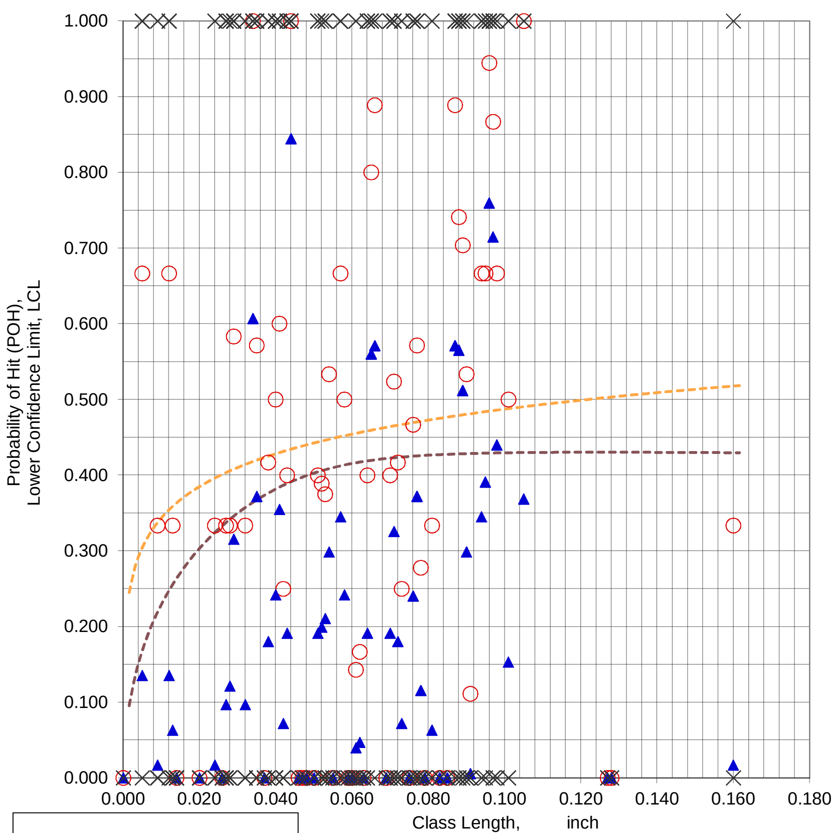
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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.)

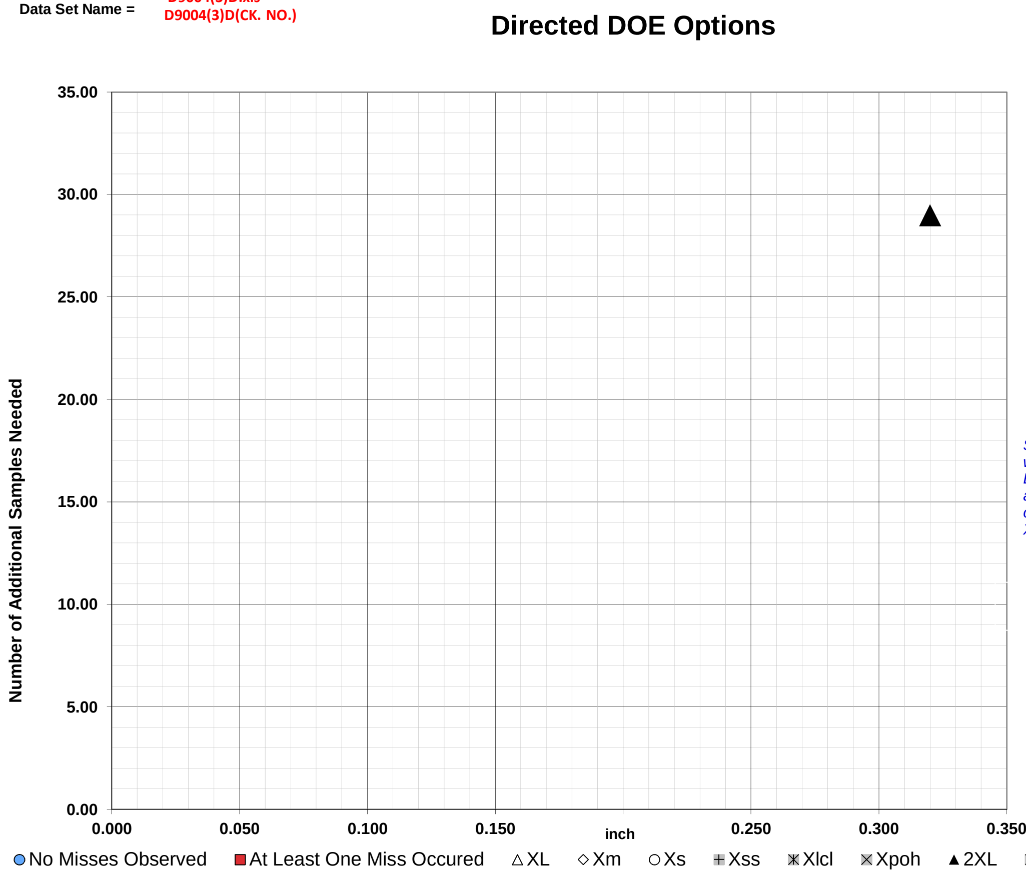


TABLE C

	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.

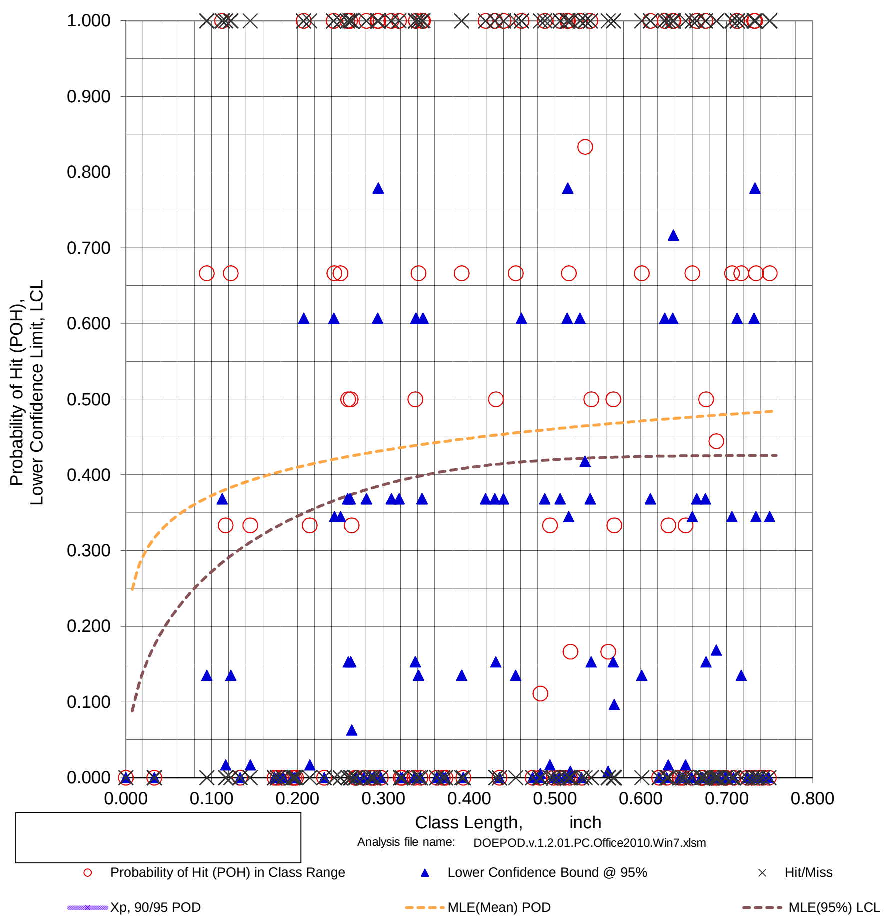
Xpod,Class Length	No. Need

* 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 = 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 =

Warning: No false call analysis.



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

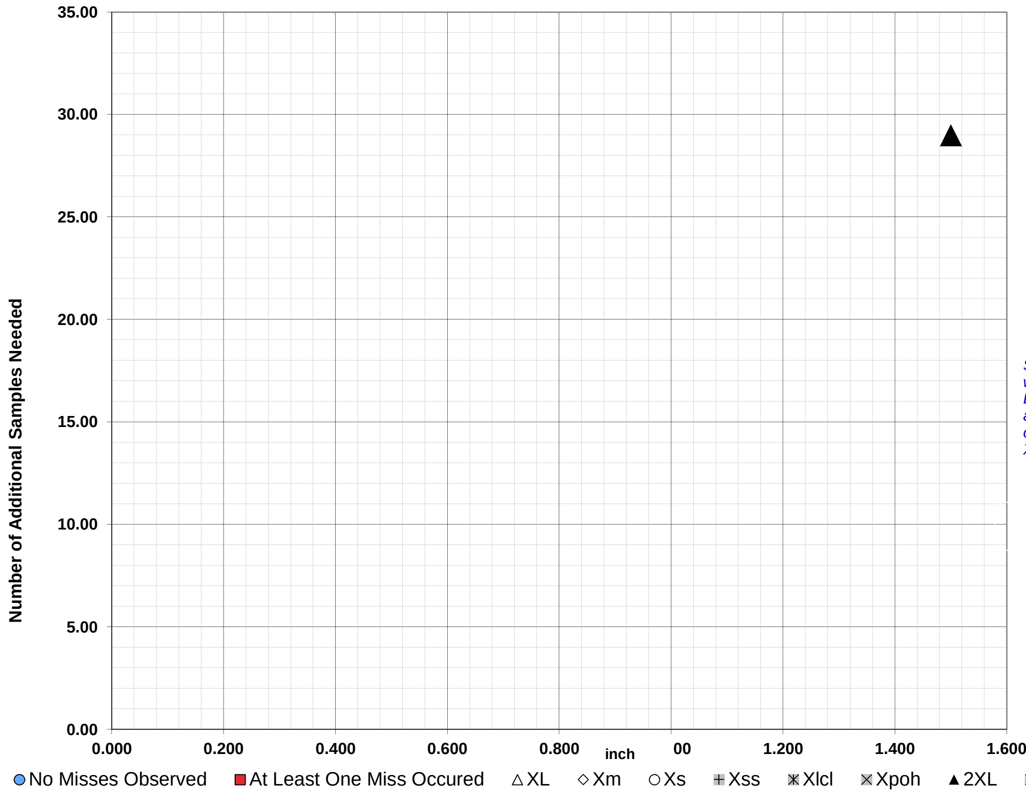


TABLE C

	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*

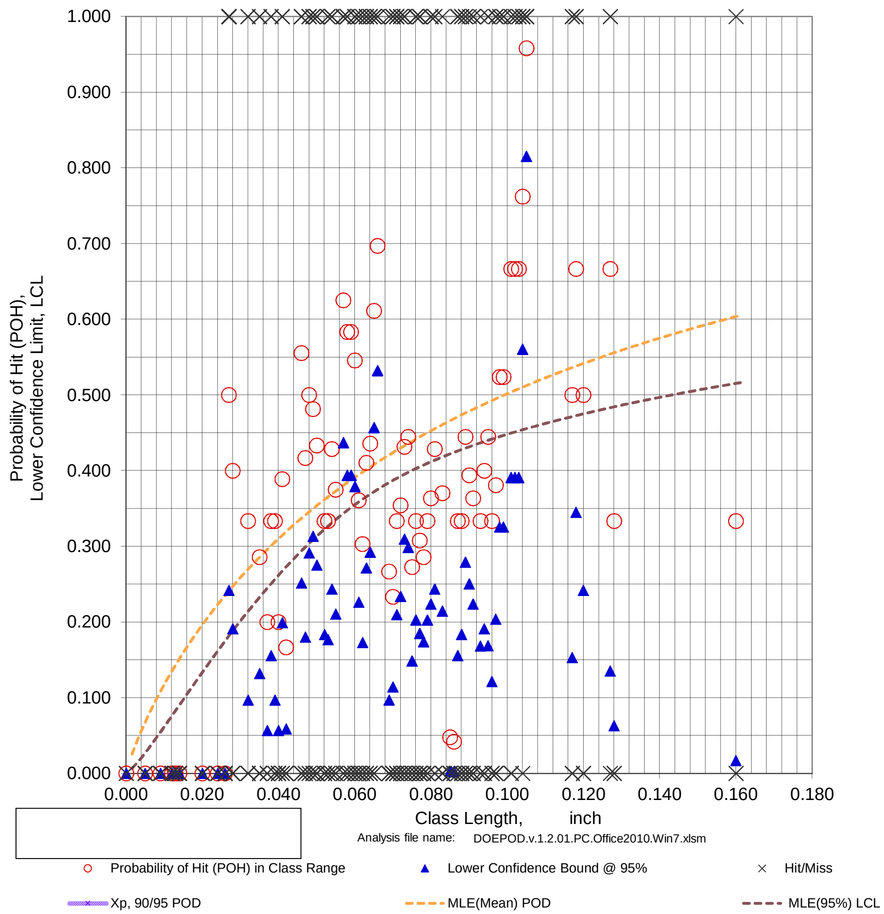
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.)

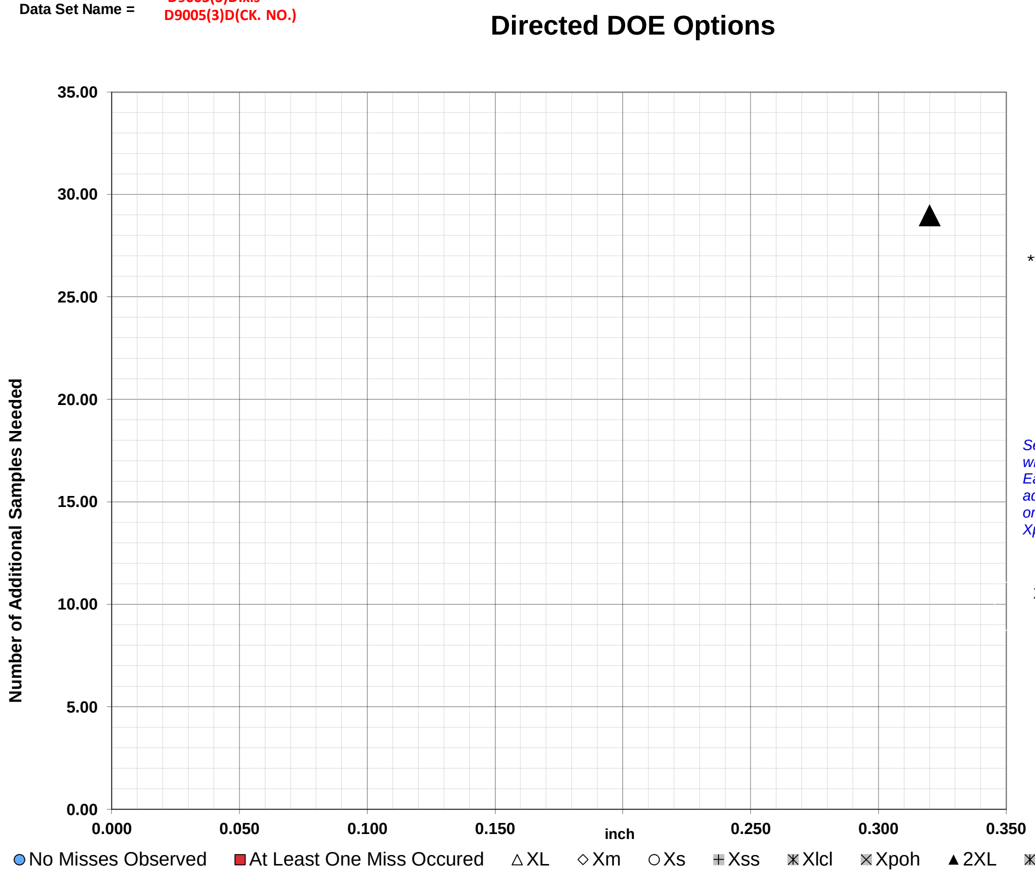


TABLE C

	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*

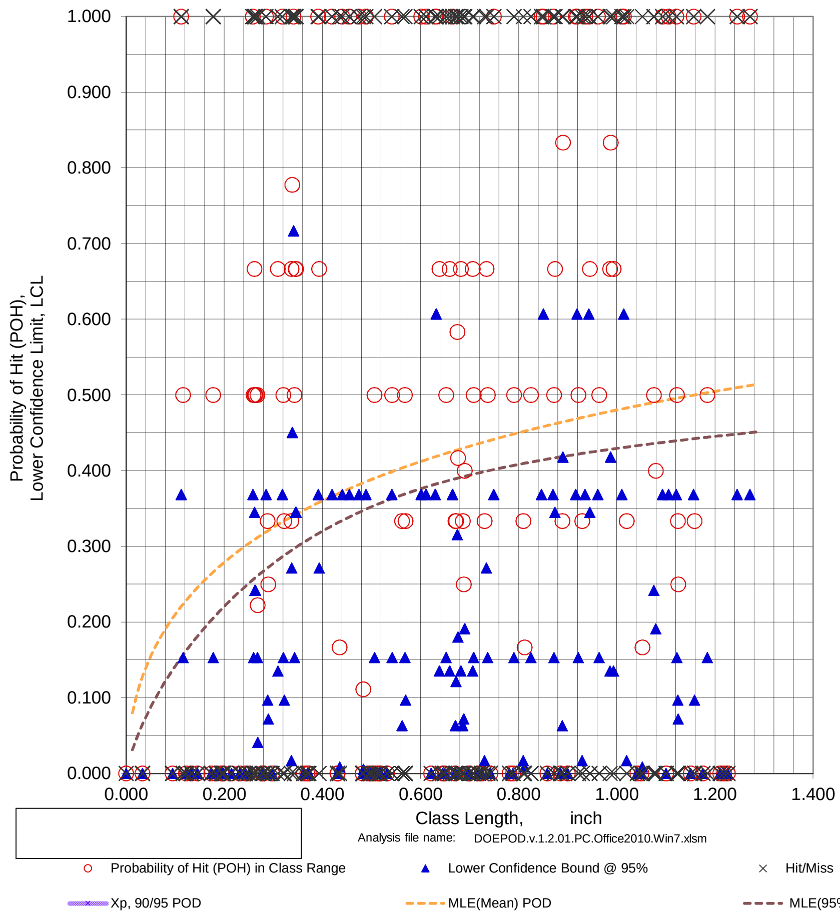
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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 = 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

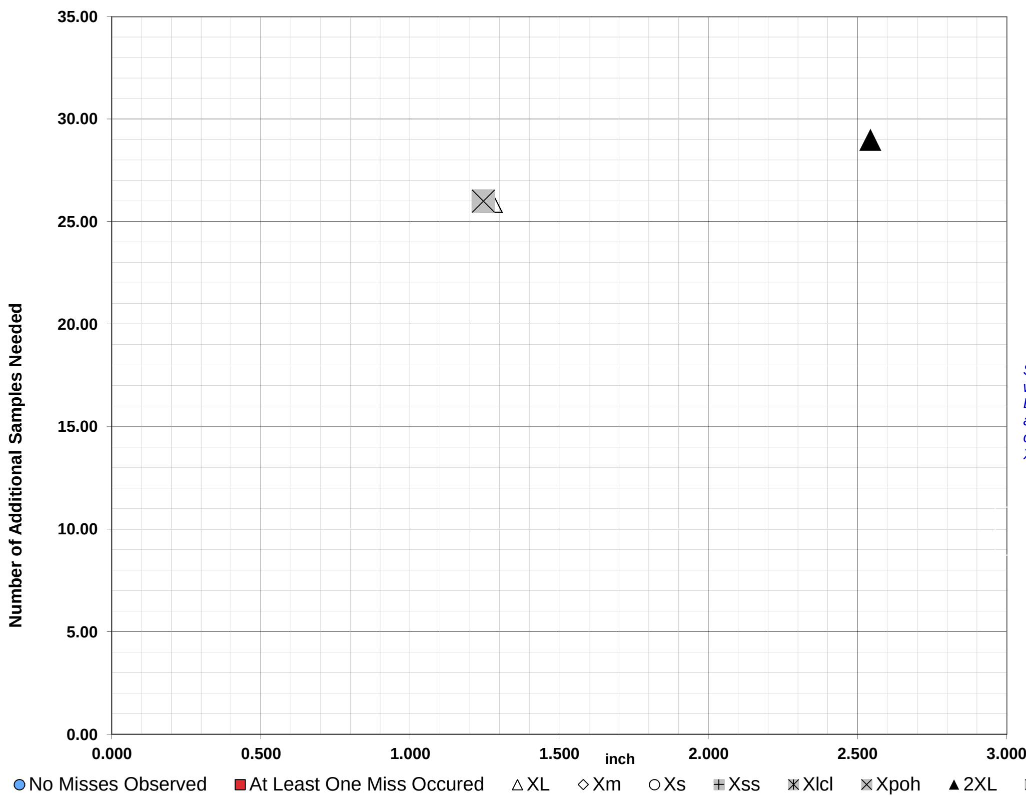


TABLE C

	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

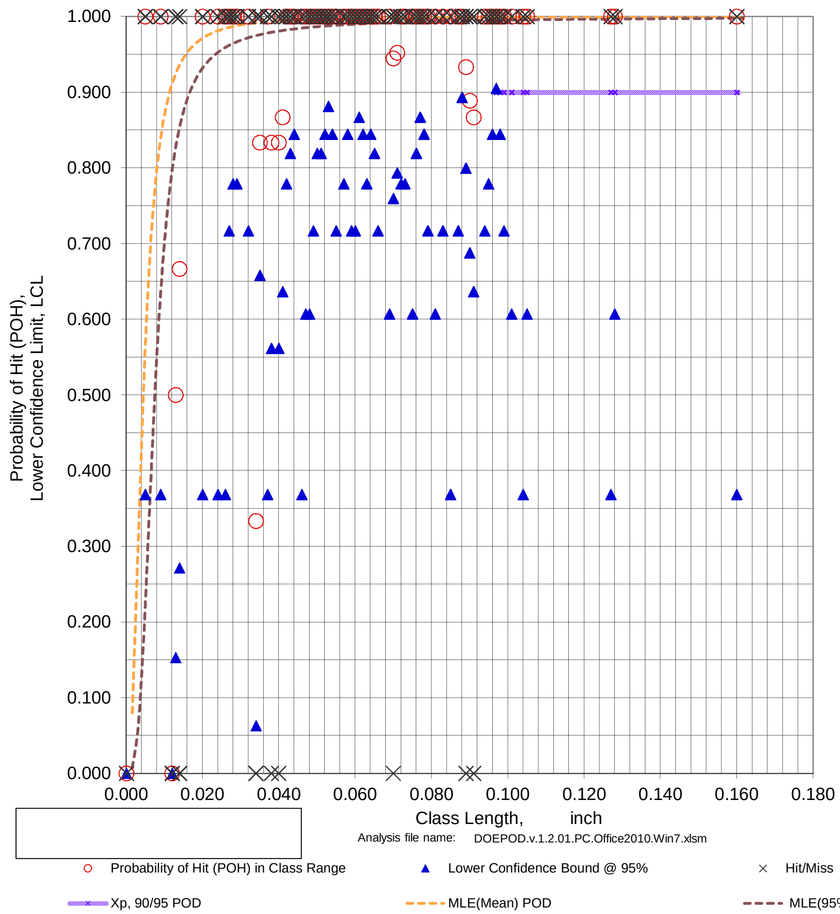
Classlength @ Best LCL = inch

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

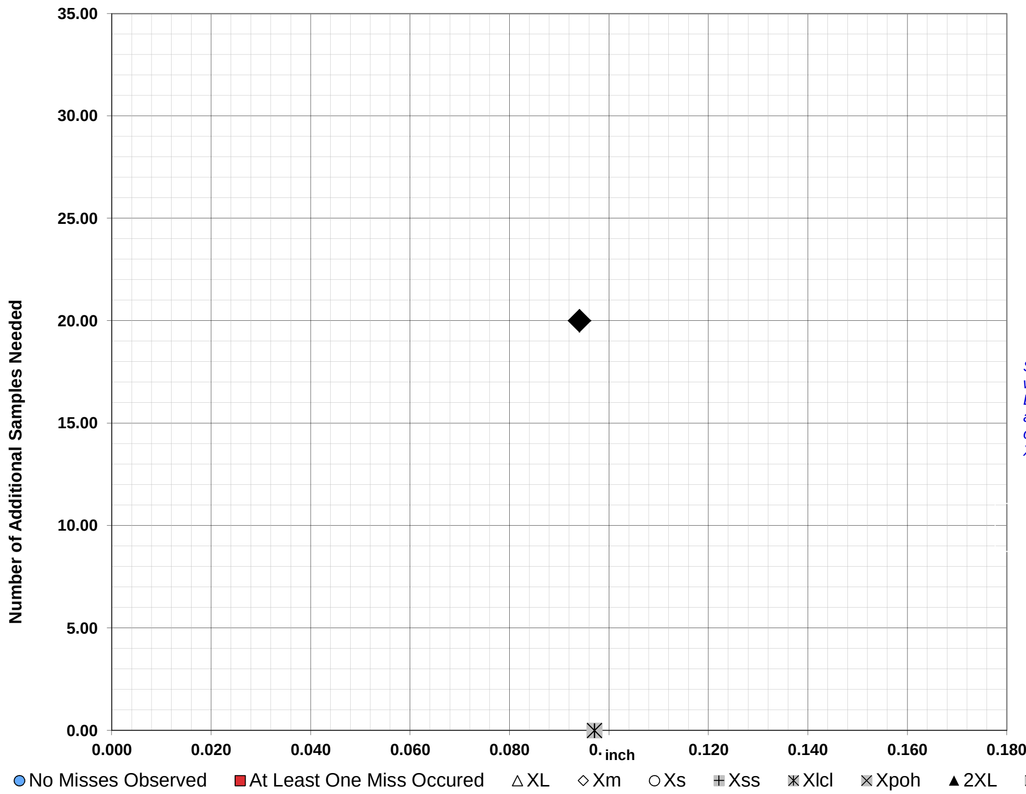


TABLE C

	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

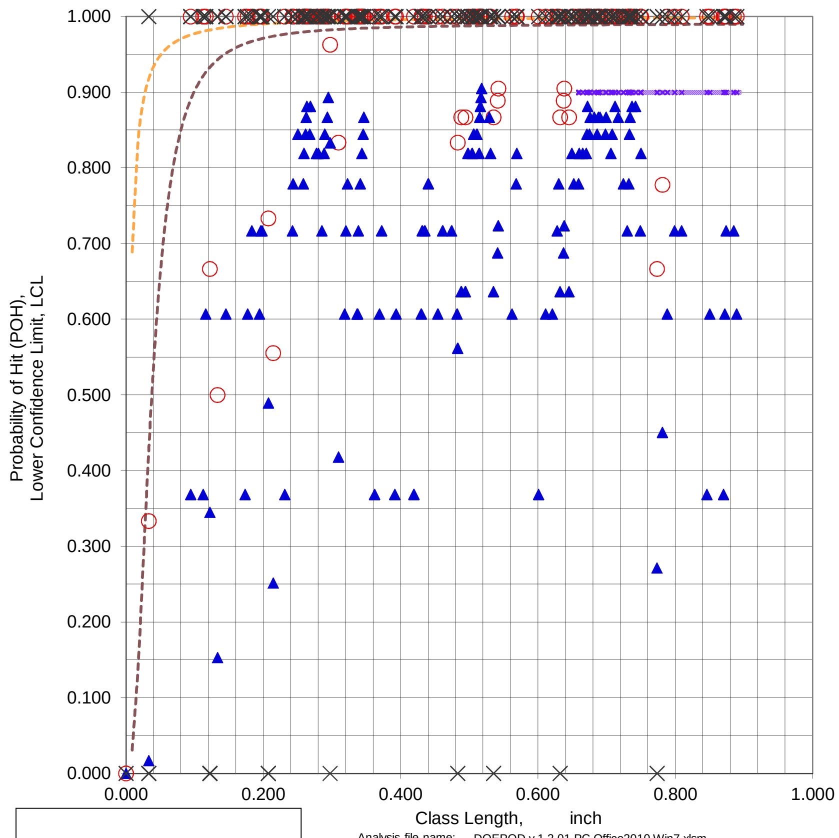
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

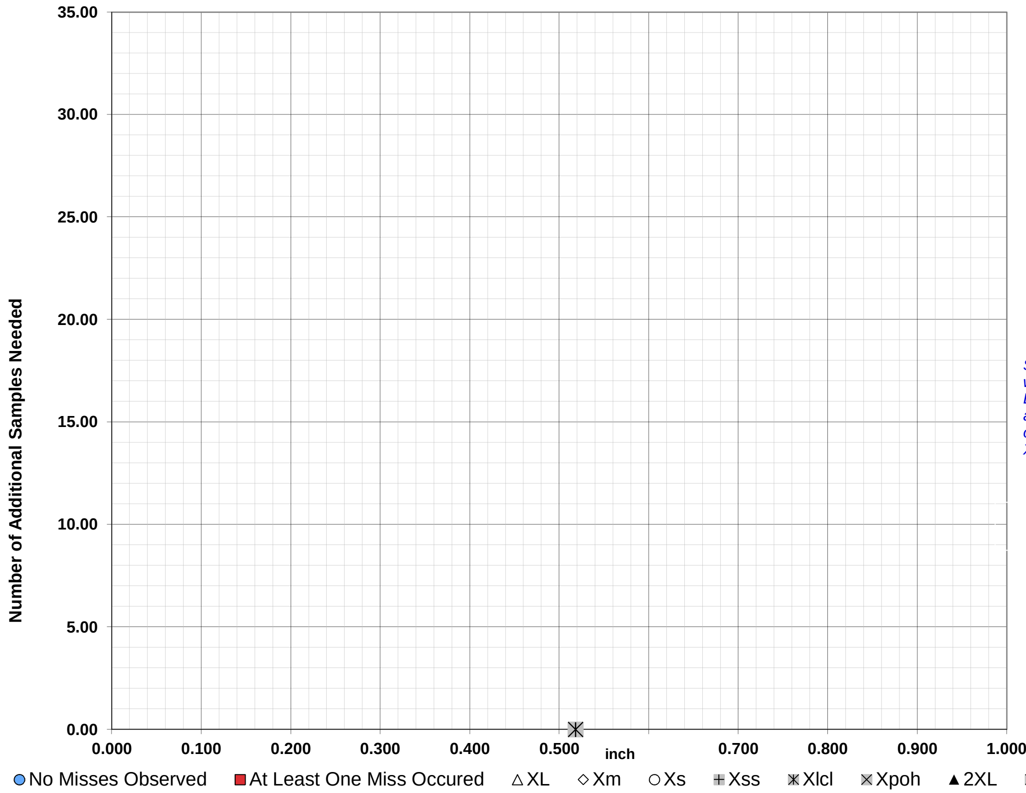


TABLE C

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*

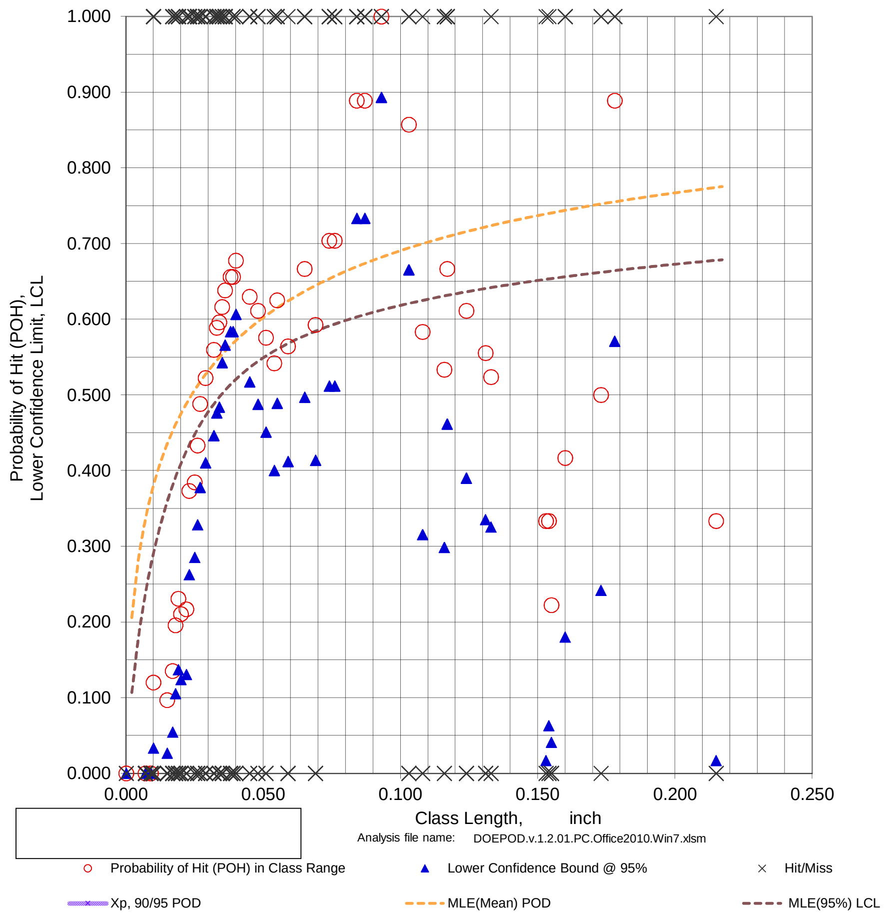
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

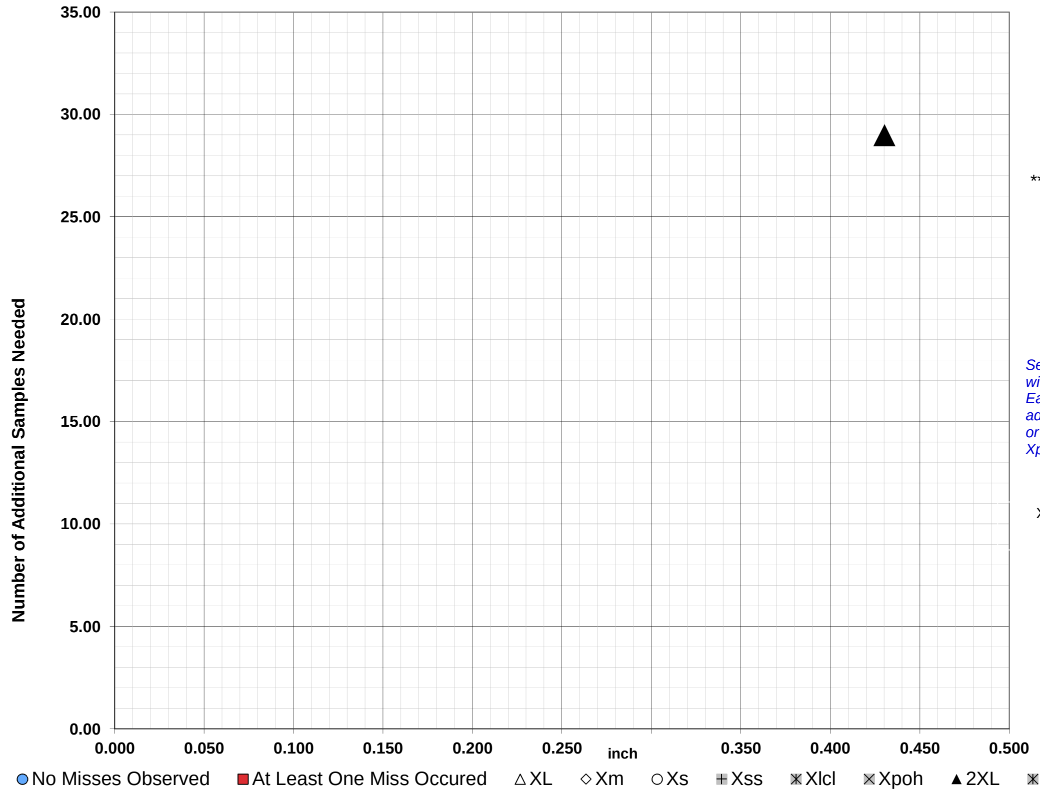


TABLE C

	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*

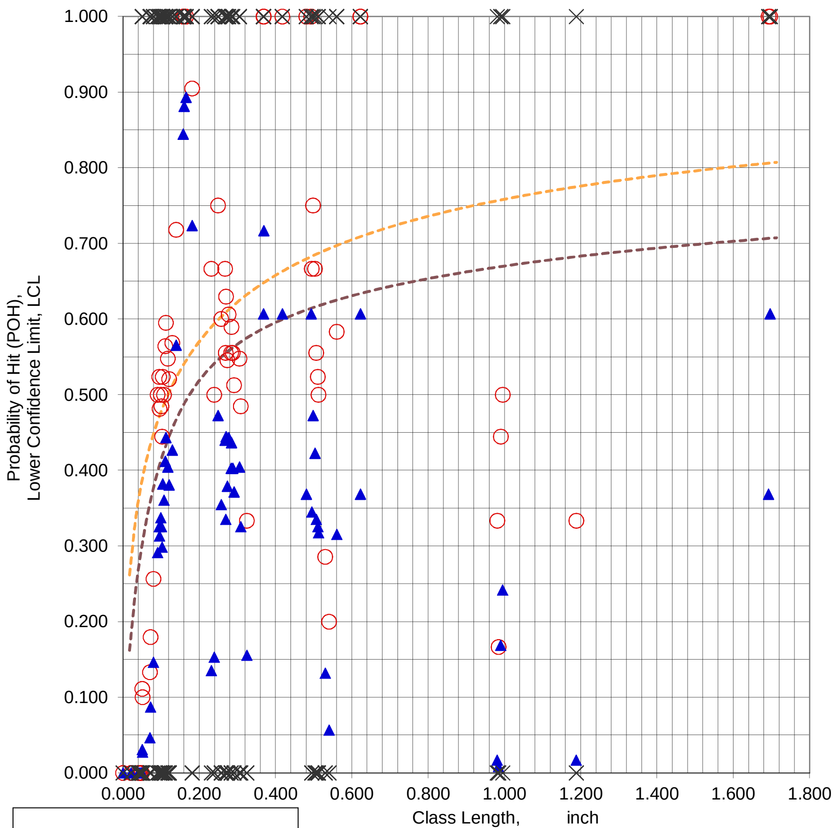
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = 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

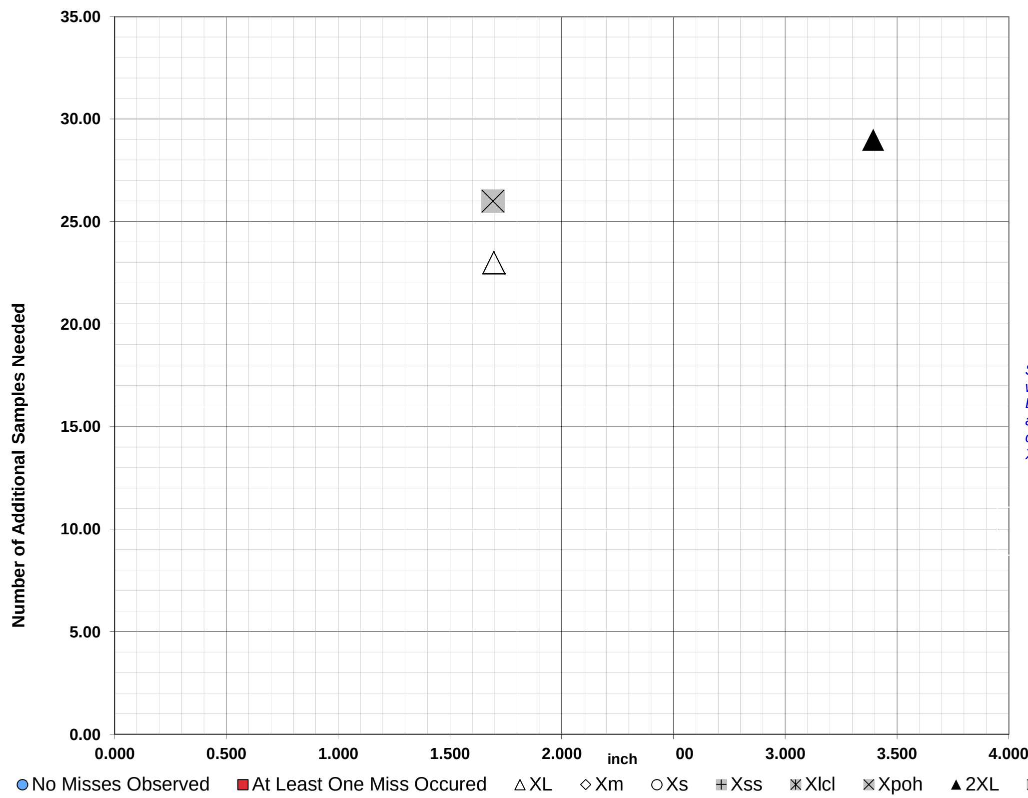


TABLE C

	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*

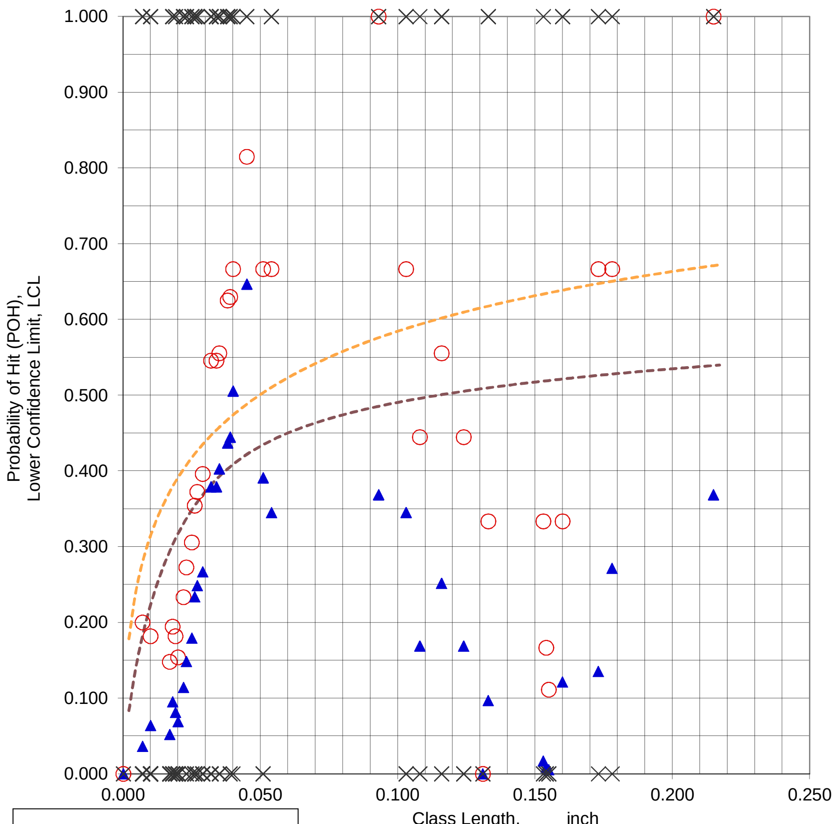
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

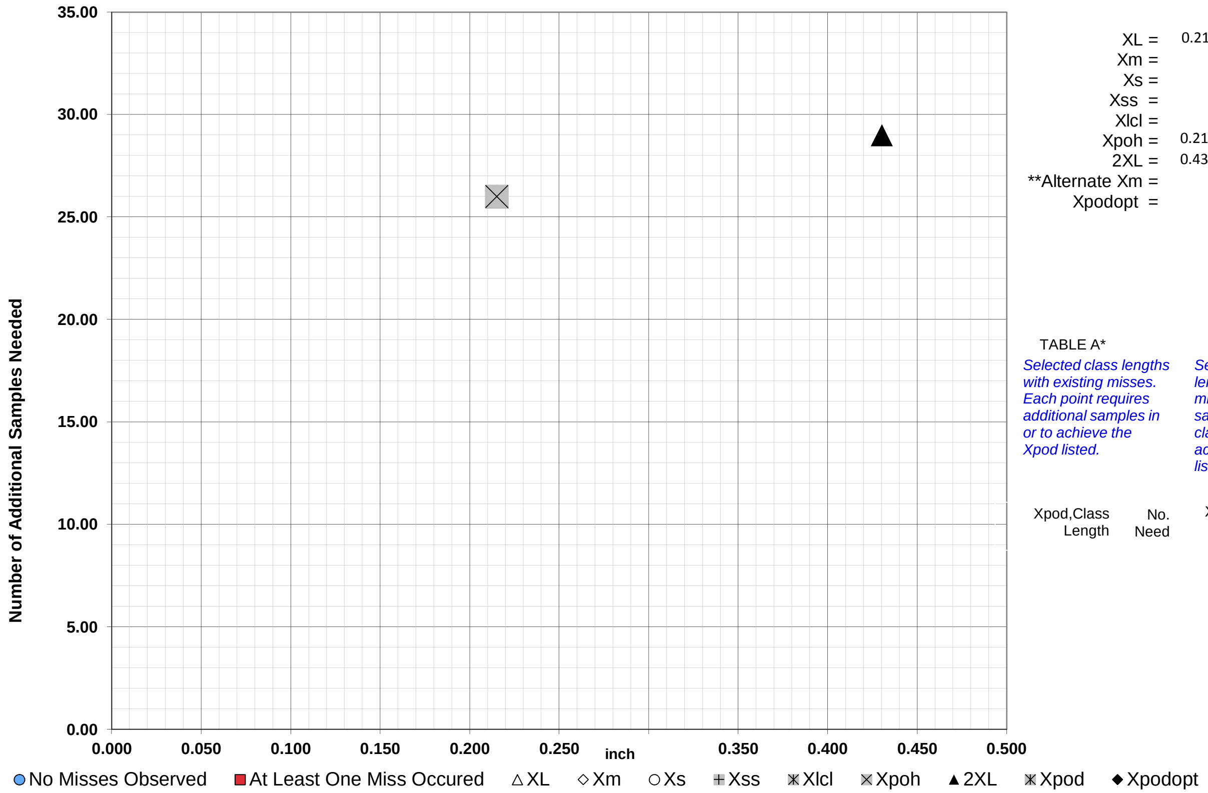


TABLE C

	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*

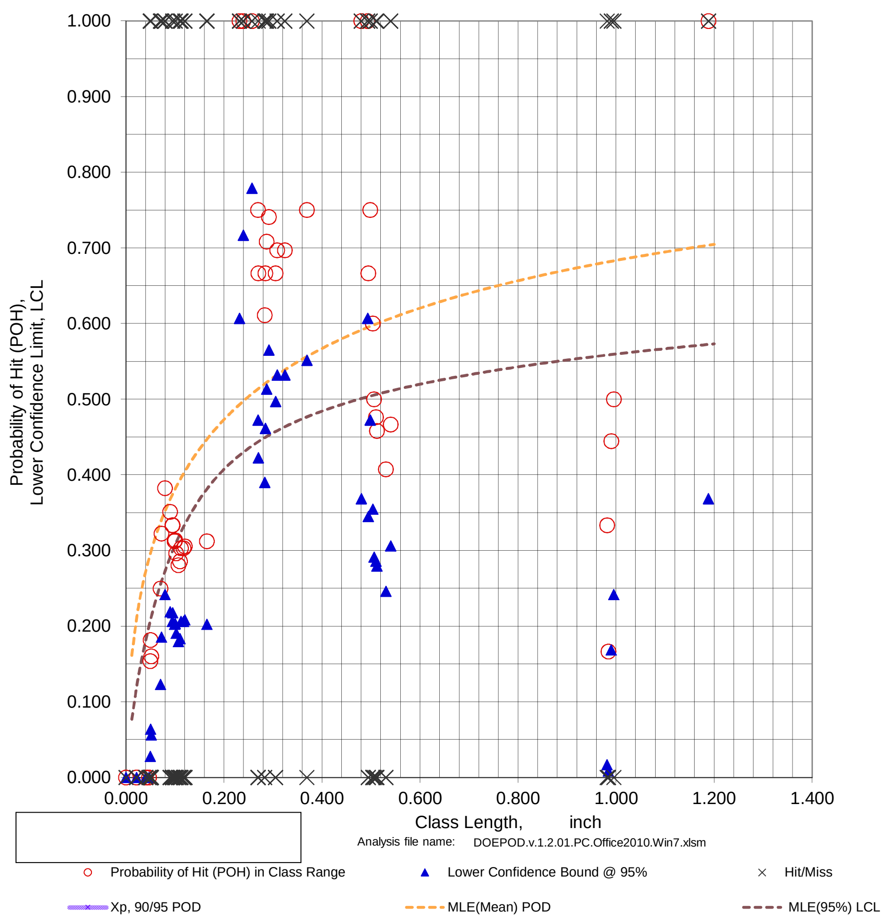
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



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

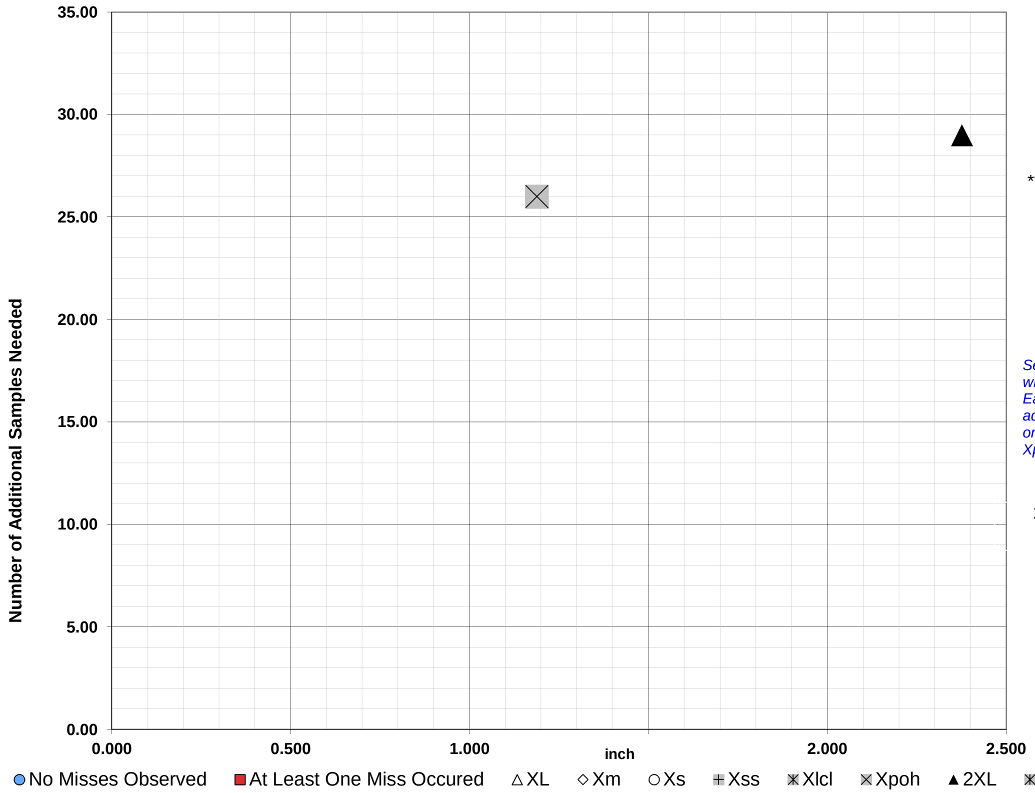


TABLE C

	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.

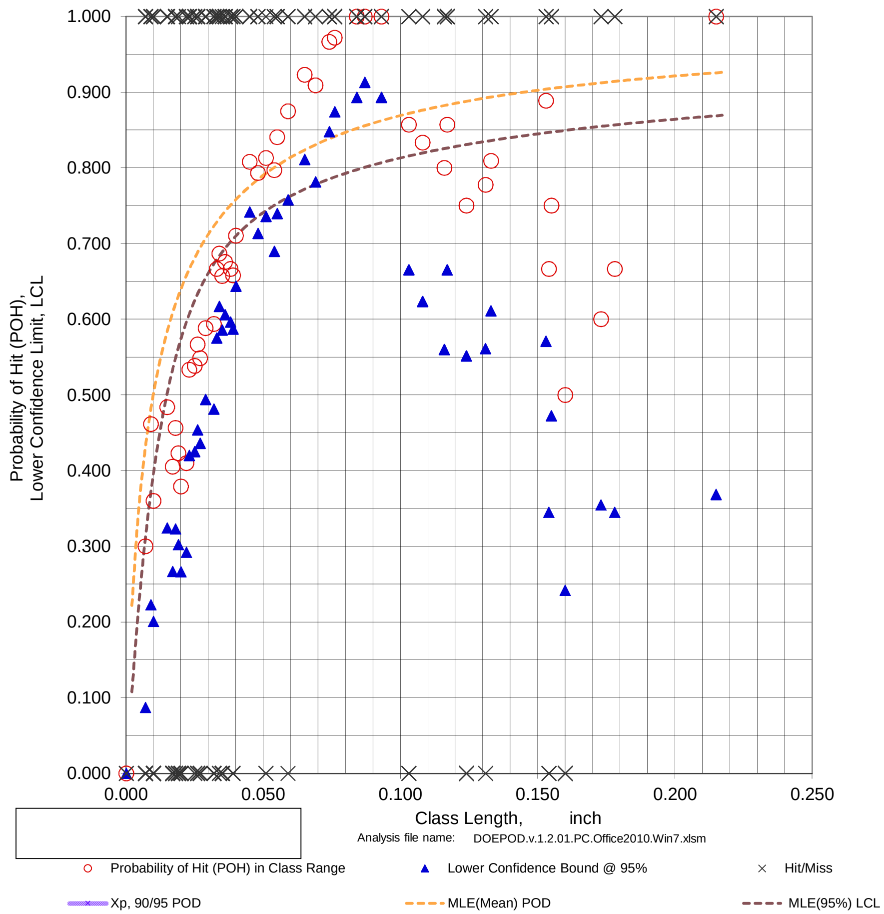
Xpod,Class Length	No. Need

* 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

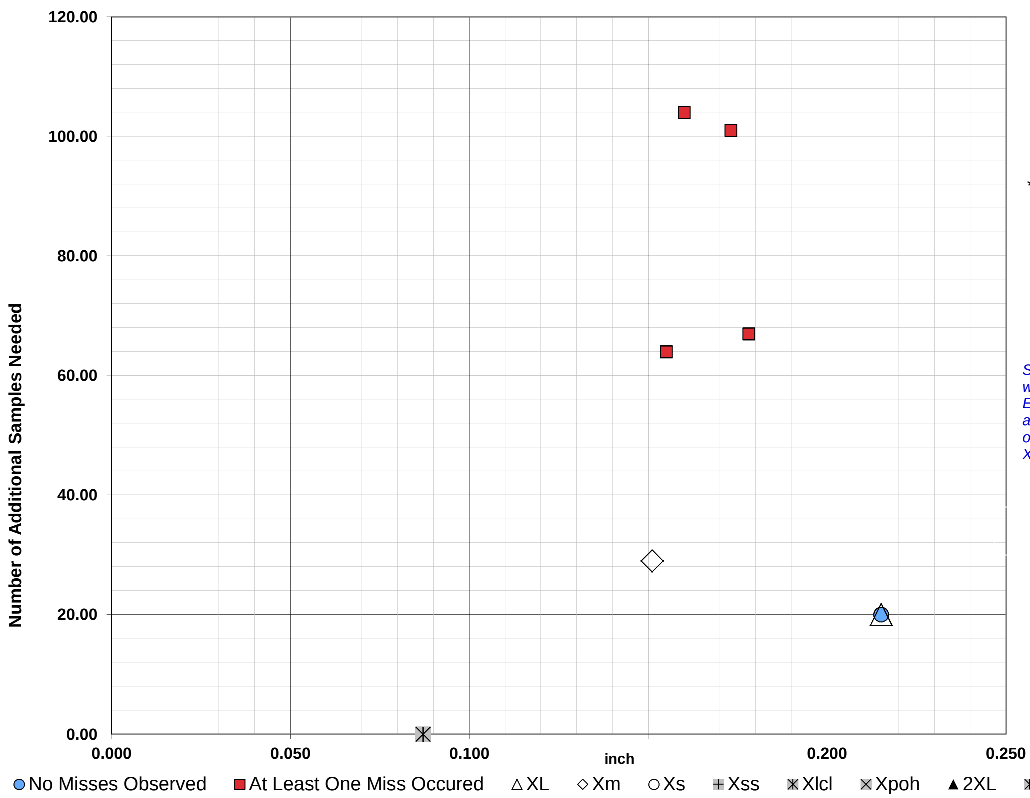


TABLE C

	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

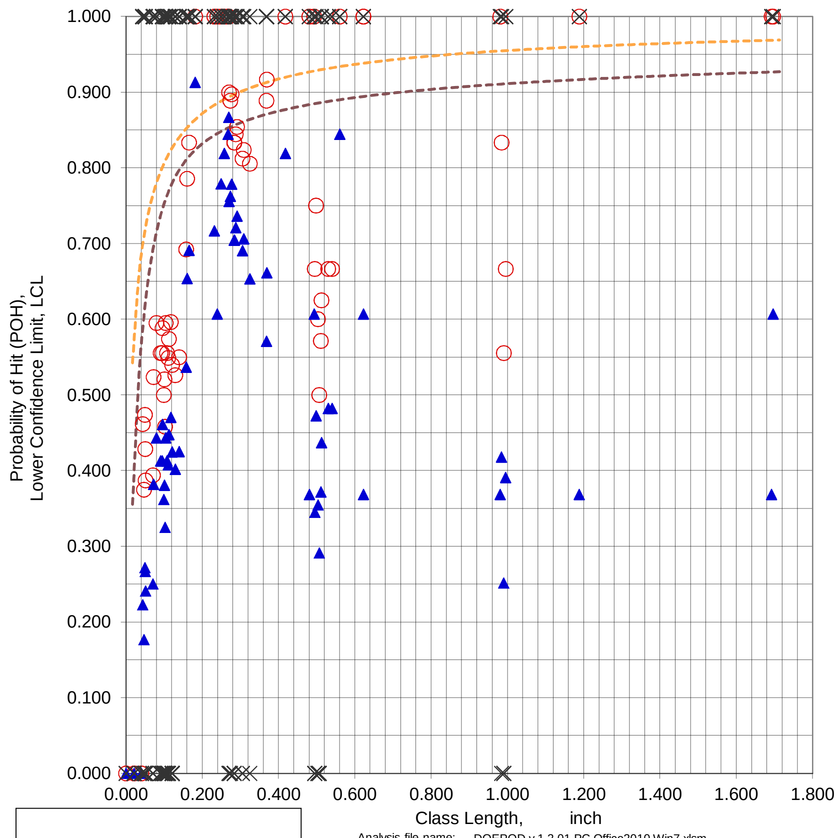
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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



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

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

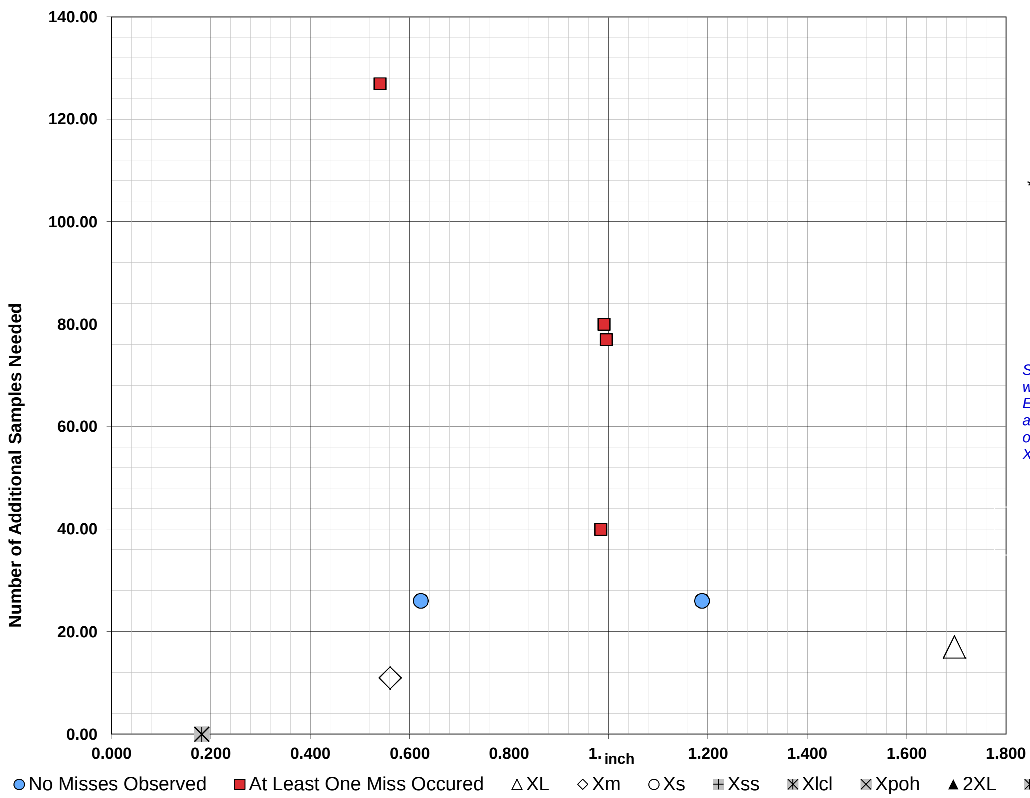


TABLE C

	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*

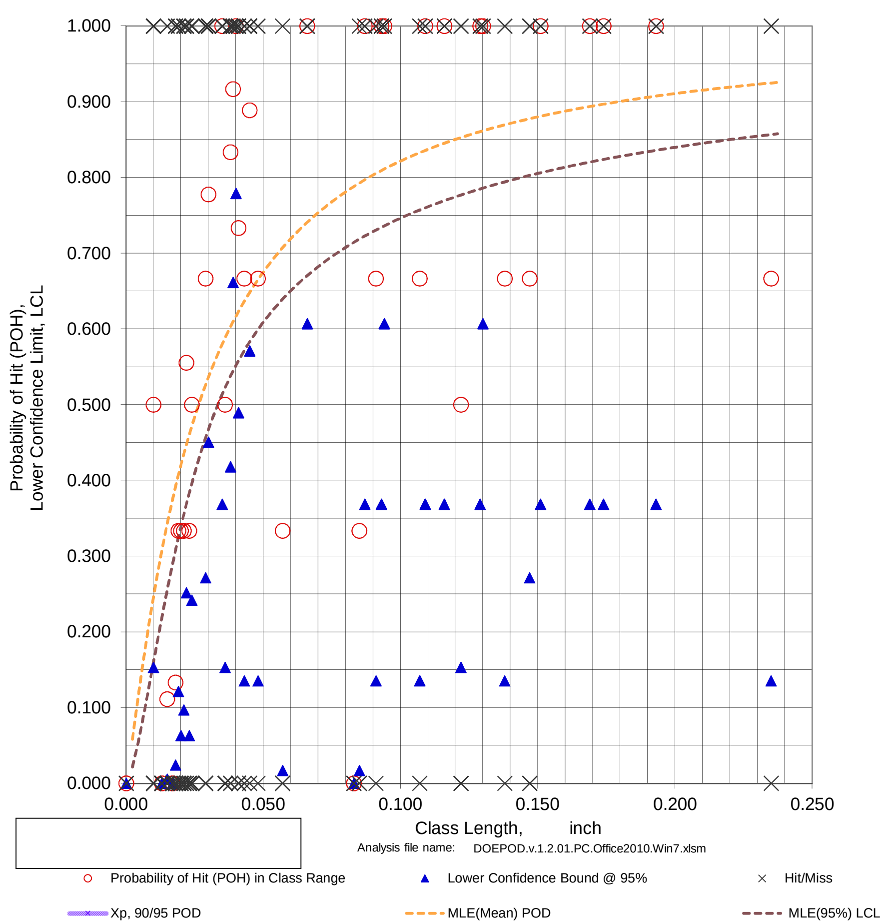
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

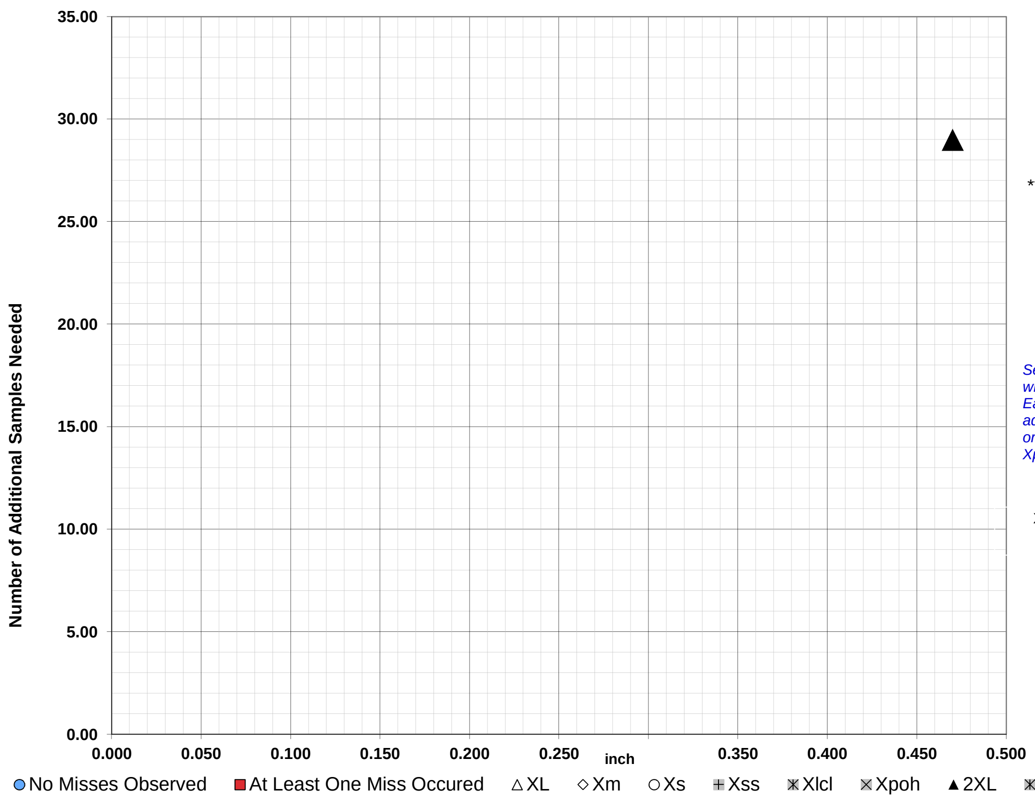


TABLE C

	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*

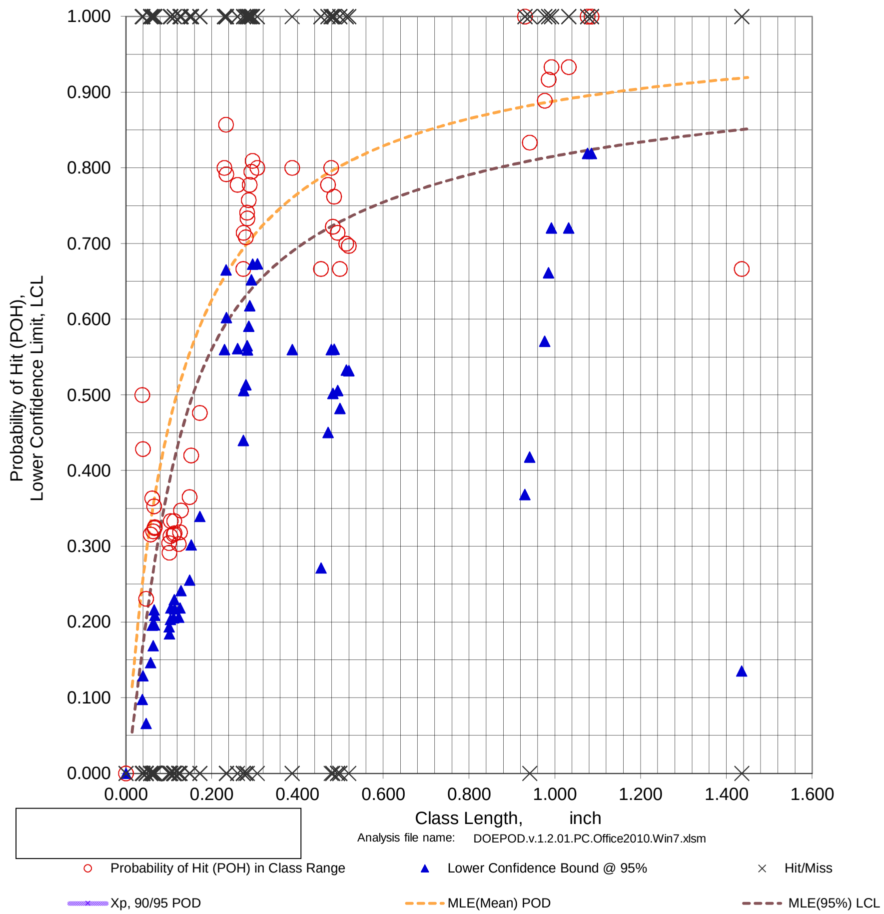
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

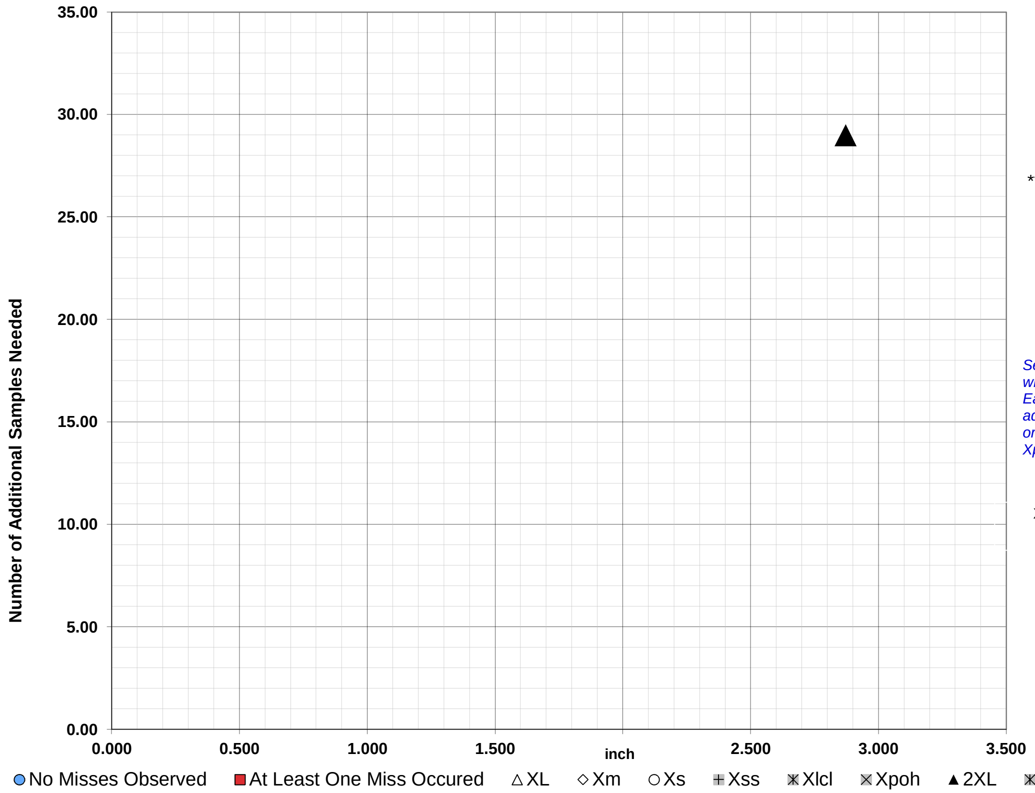


TABLE C

	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.

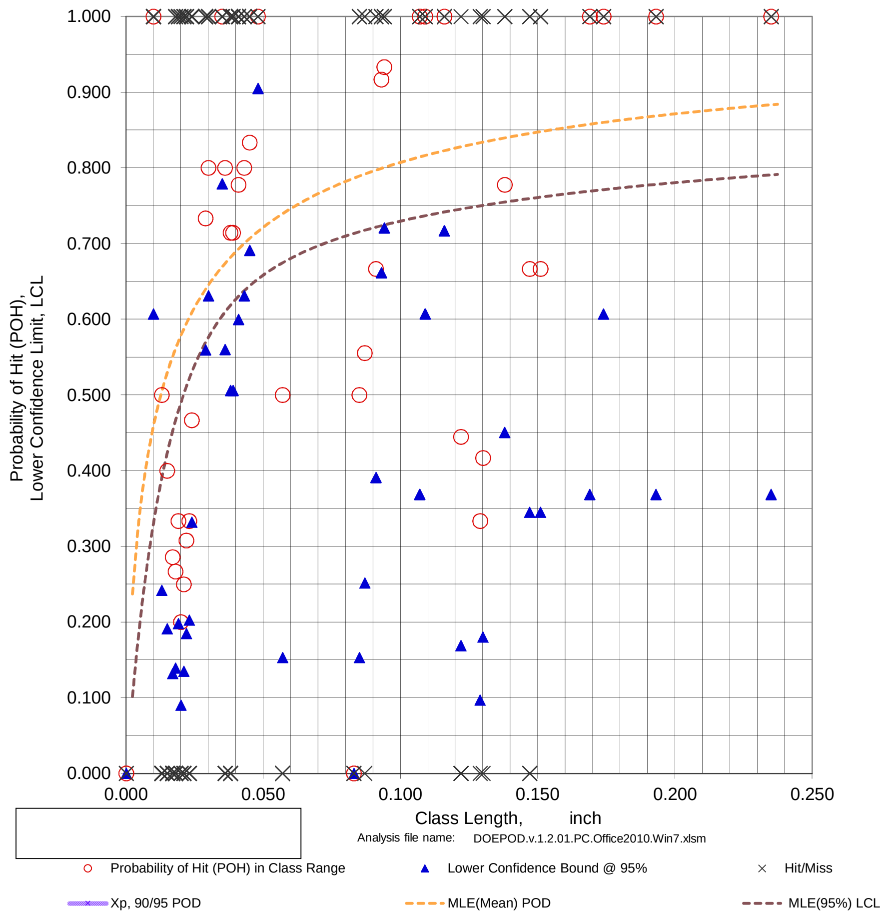
Xpod,Class Length	No. Need

* 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

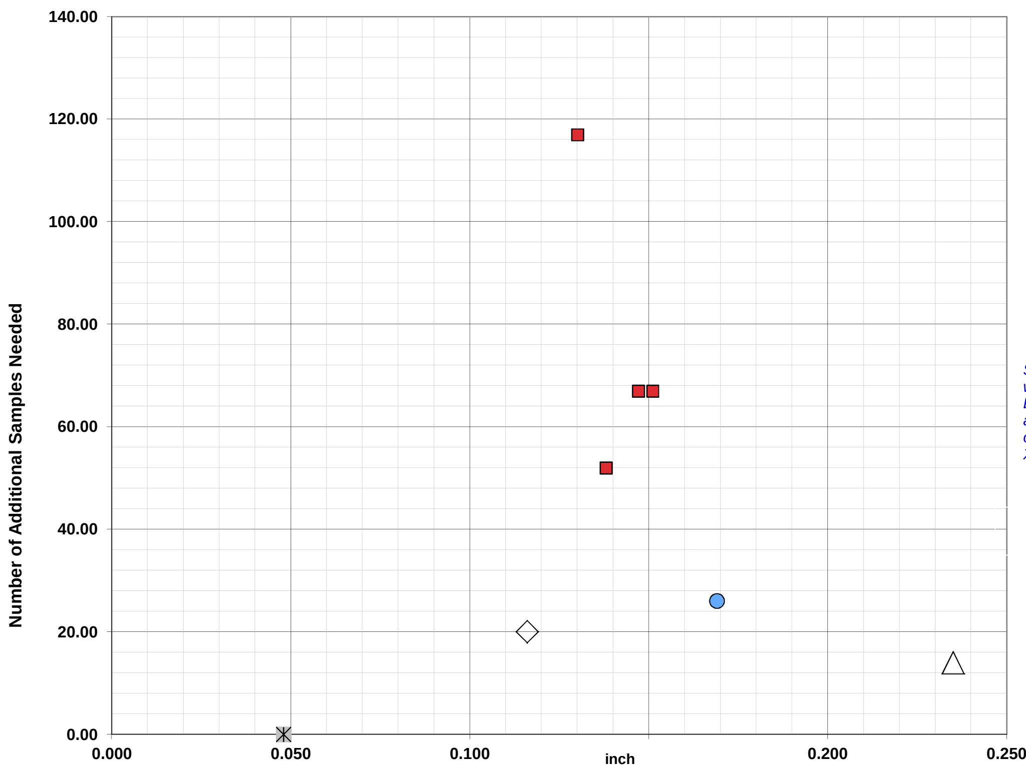
Opt. POD classlength, Xpodopt = inch

Samples Needed @Xpodopt =

Xp = inch

File Name = DB002(3)D.xls
Data Set Name = DB002(3)D(CK. NO.)

Directed DOE Options



○ No Misses Observed ■ At Least One Miss Occured △ XL ◇ Xm ○ Xs ⊞ Xss ⋇ Xlcl ⊠ Xpoh ▲ 2XL ⋇ Xpod ◆ Xpodopt

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.

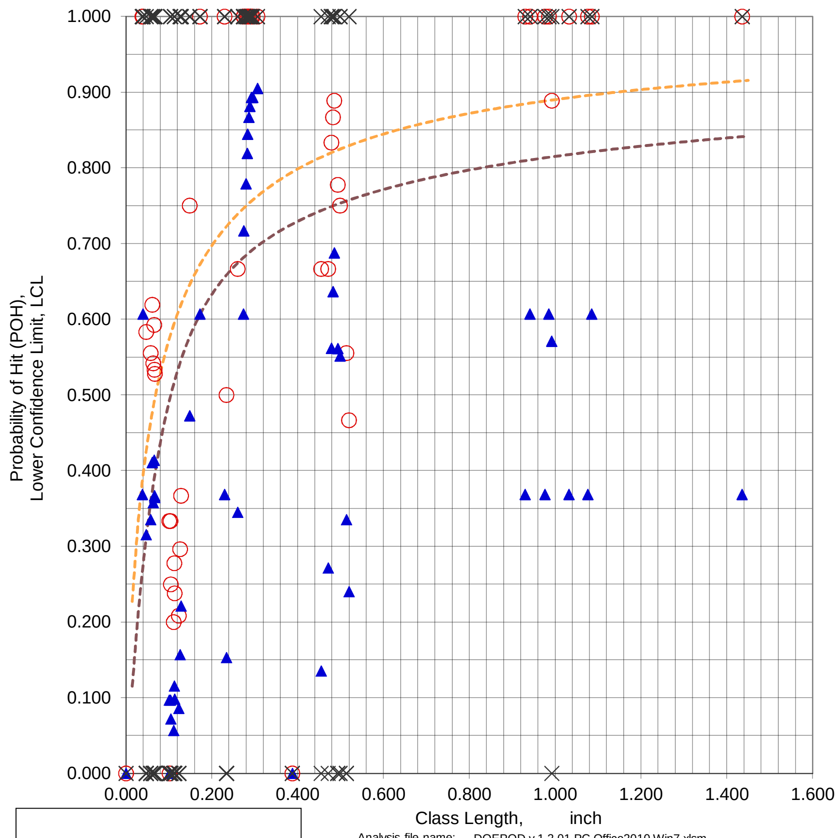
Xpod,Class Length	No. Need
0.1690	26

* 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.



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 =	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

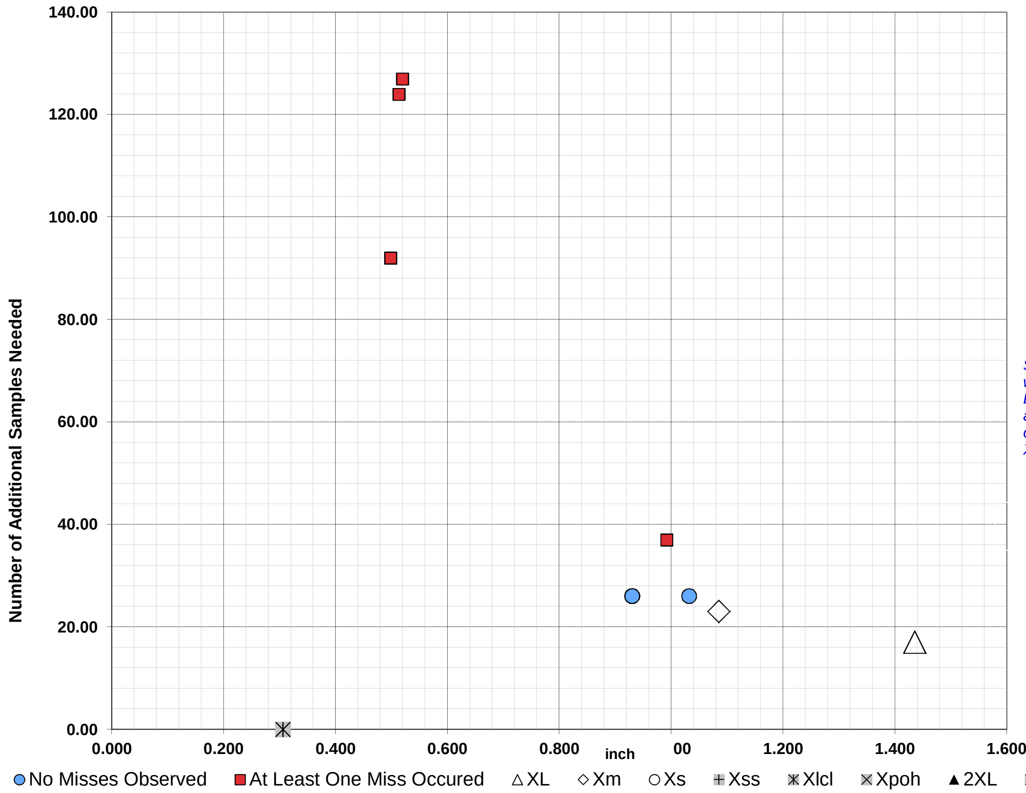


TABLE C

	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*

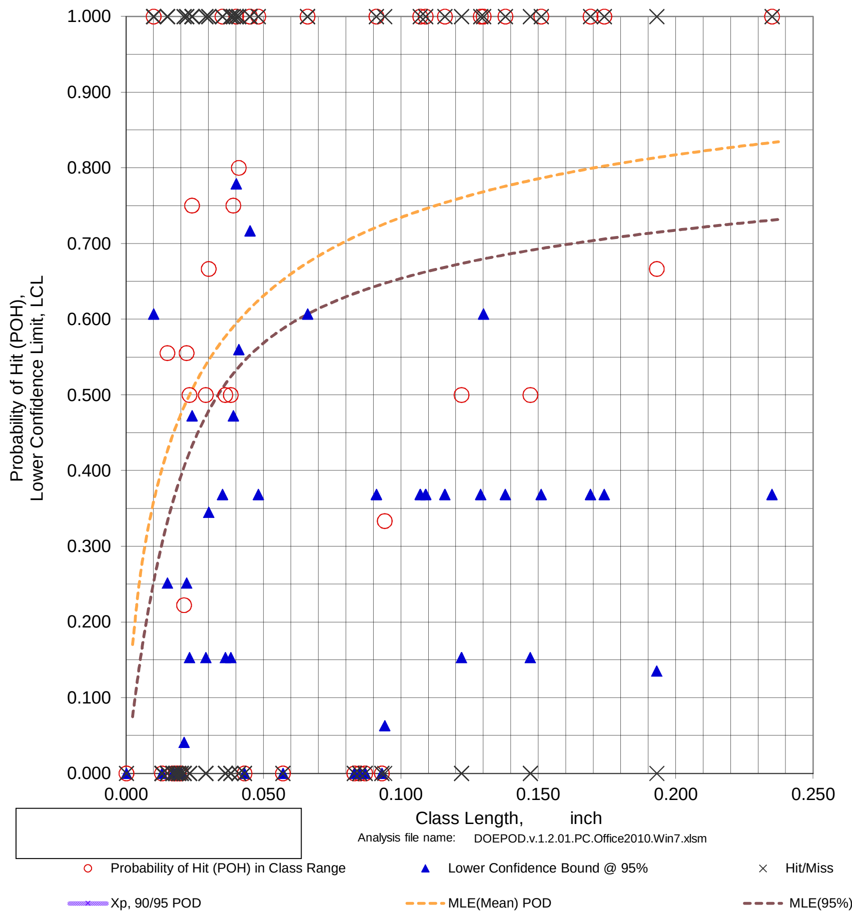
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

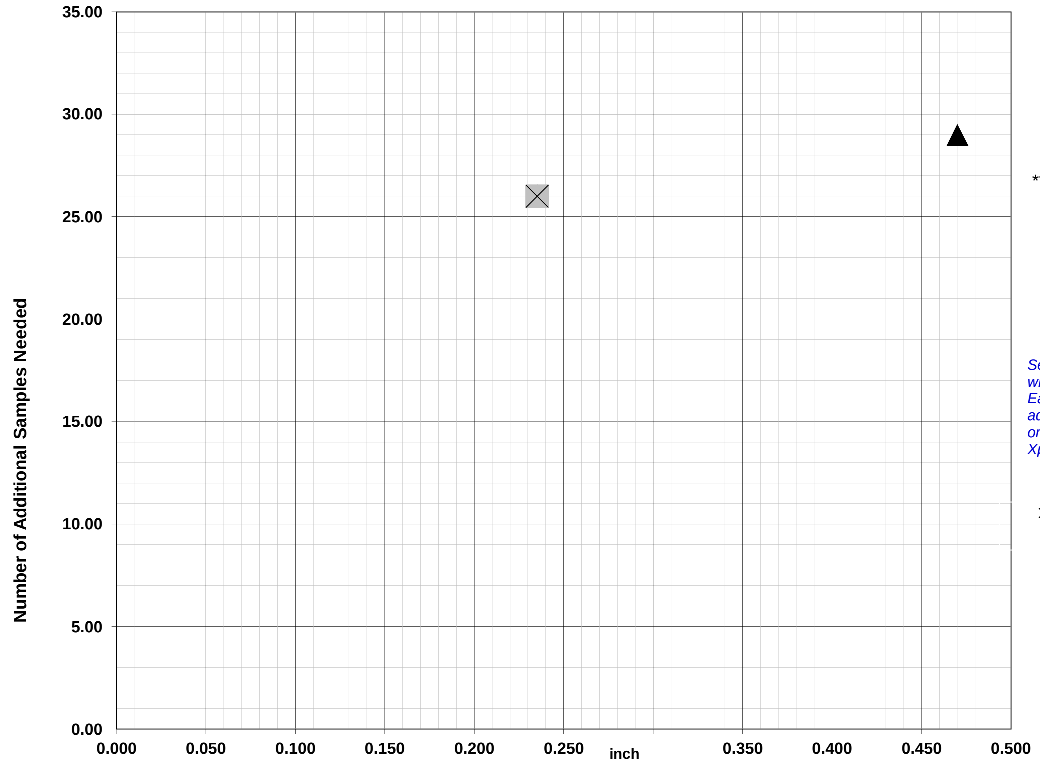


TABLE C

	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*

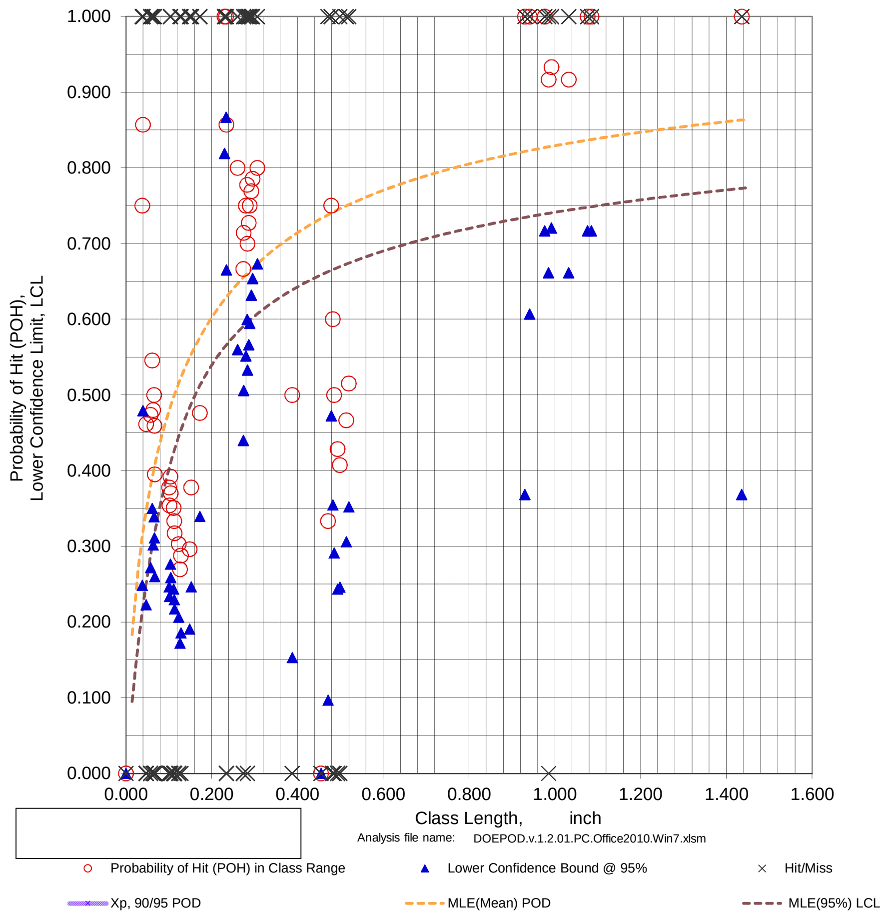
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.

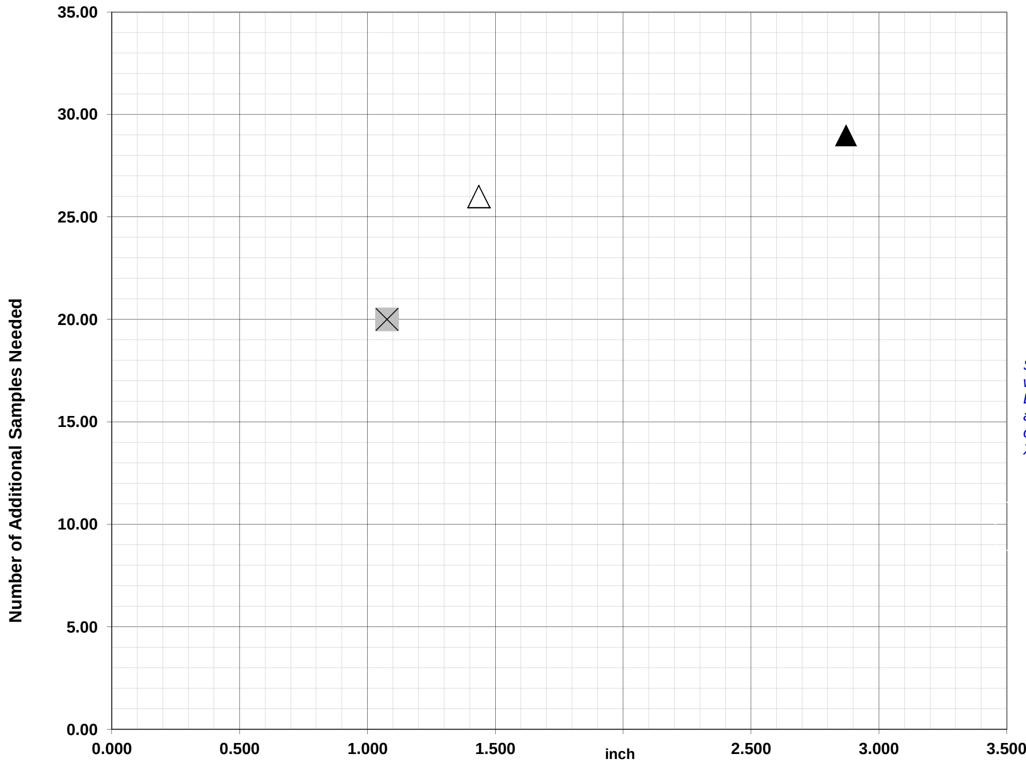
Survey/Optimum Xpoh = 0.9920 -0.006 inch 26 Samples

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



No Misses Observed At Least One Miss Occured △XL ◇Xm ○Xs Xss Xlcl Xpoh ▲2XL Xpod ◆Xpodopt

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

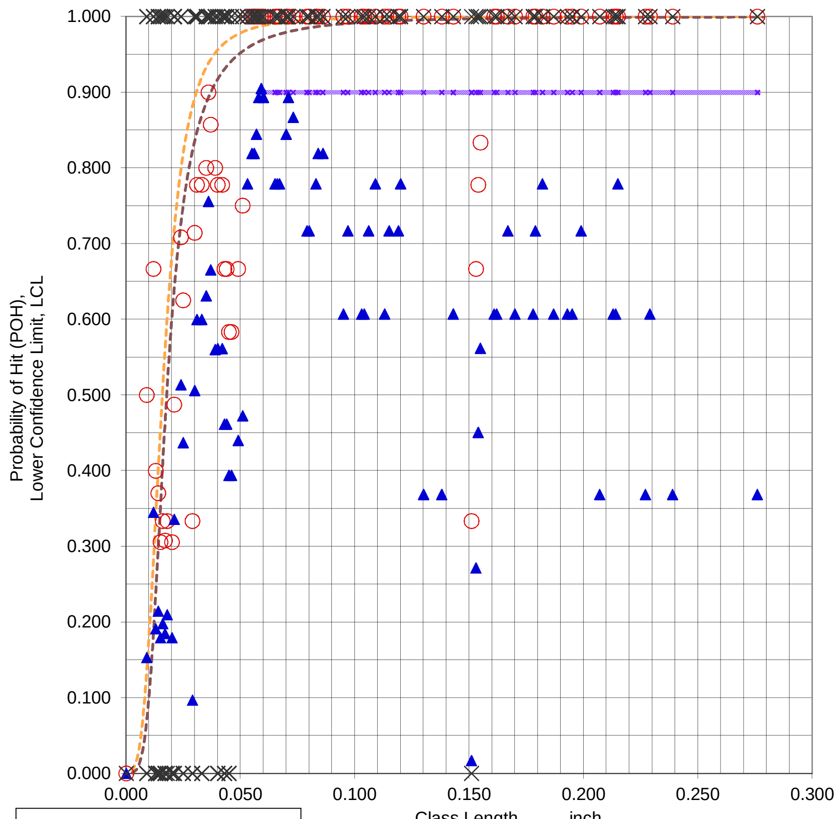
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod = 1.0000



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

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

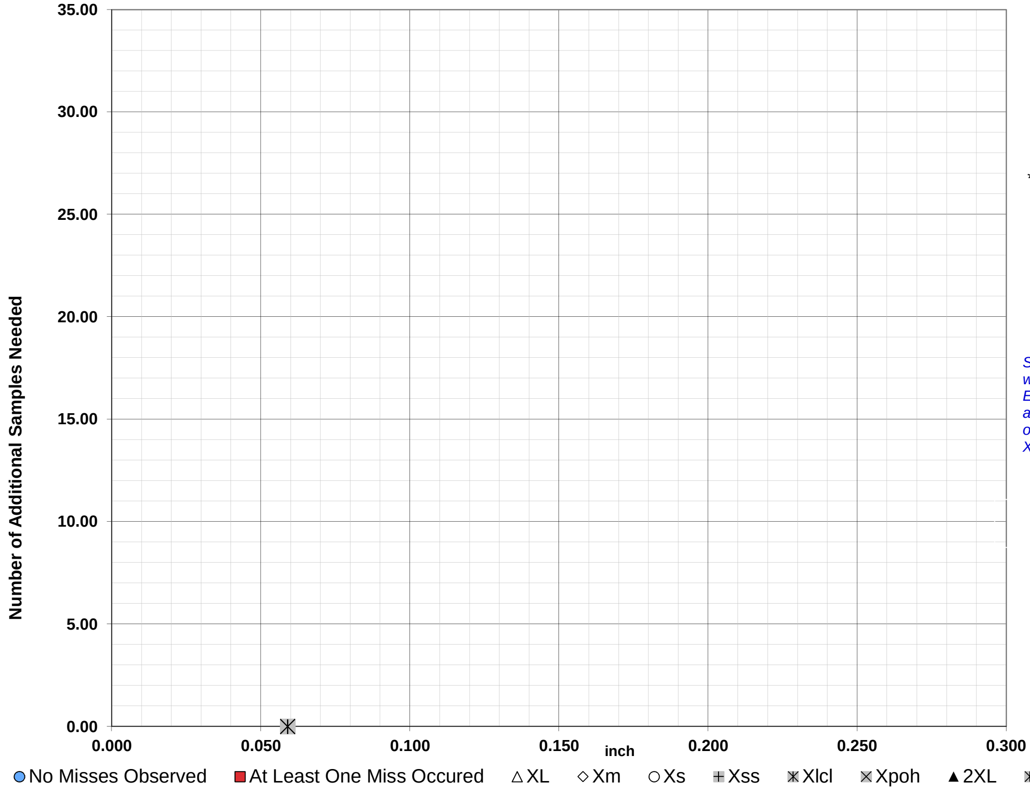


TABLE C

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

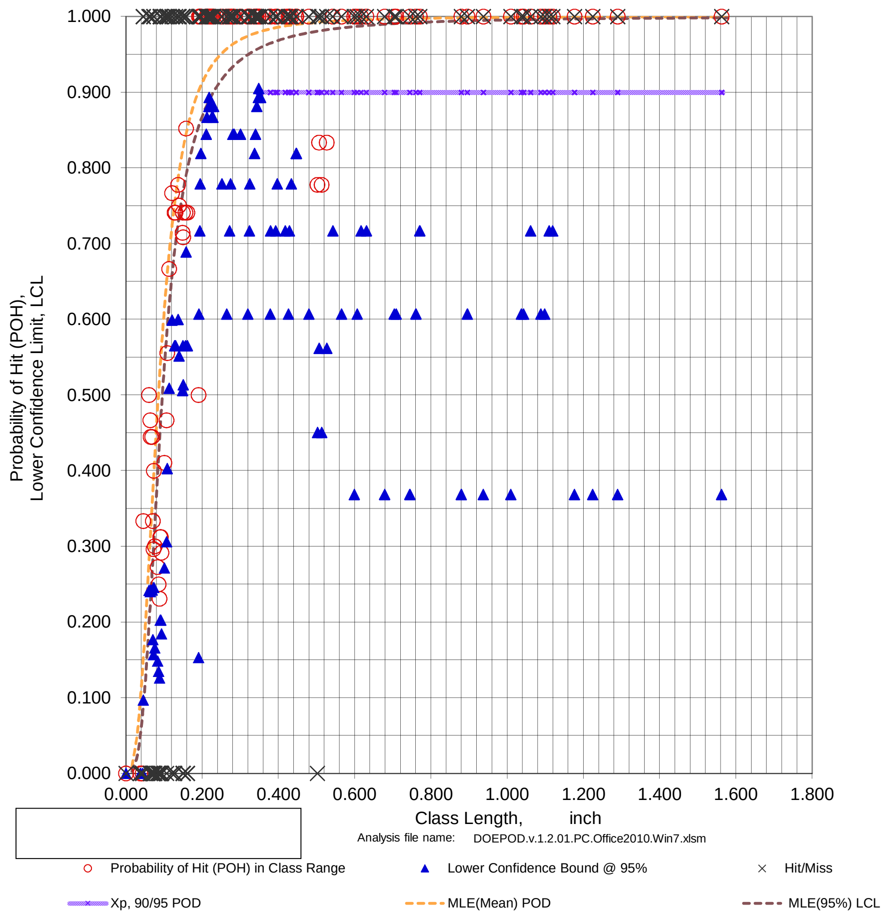
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

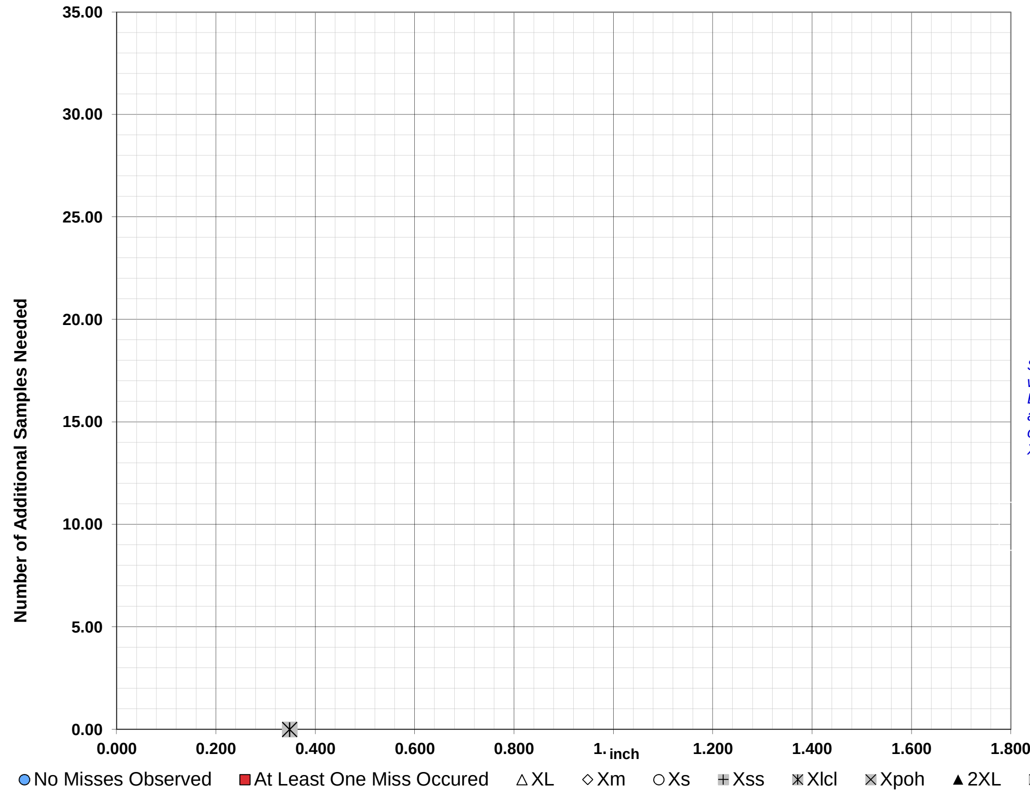


TABLE C

	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.

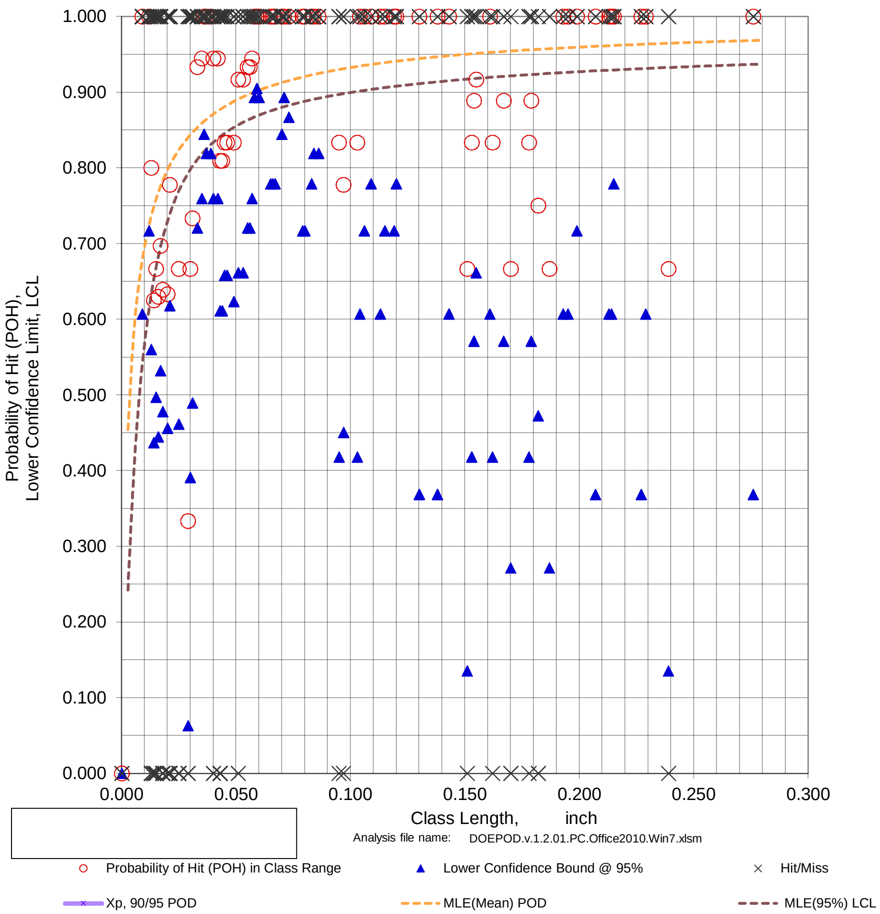
Xpod,Class Length	No. Need

* 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

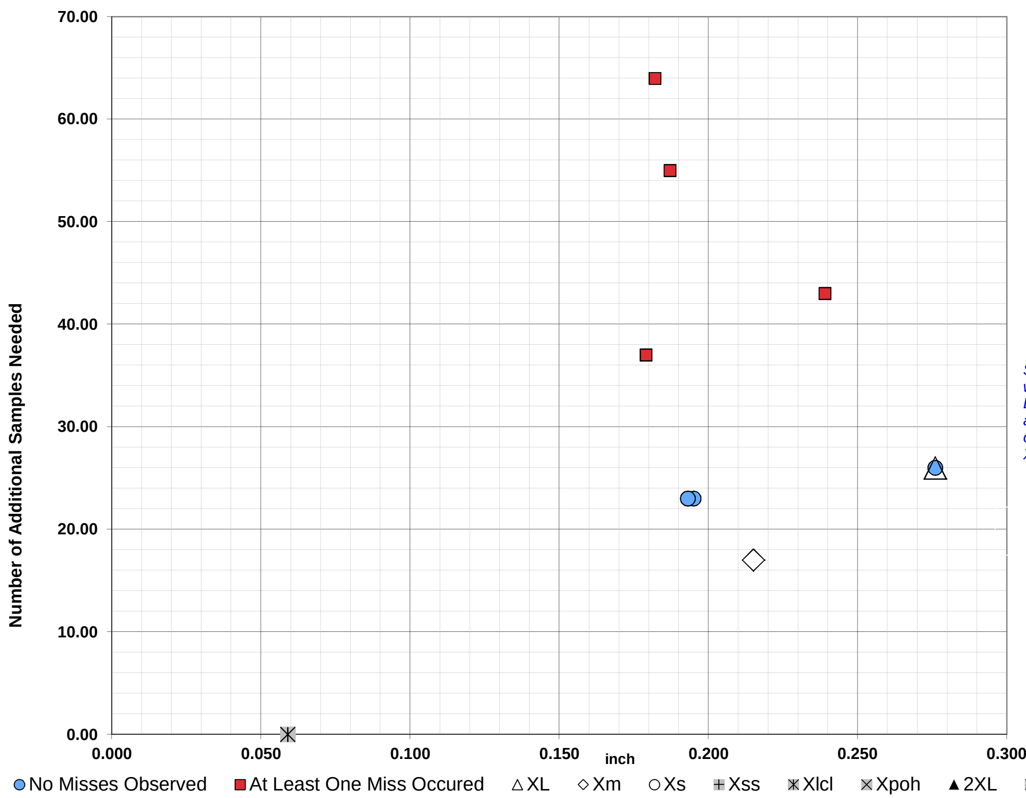


TABLE C

	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

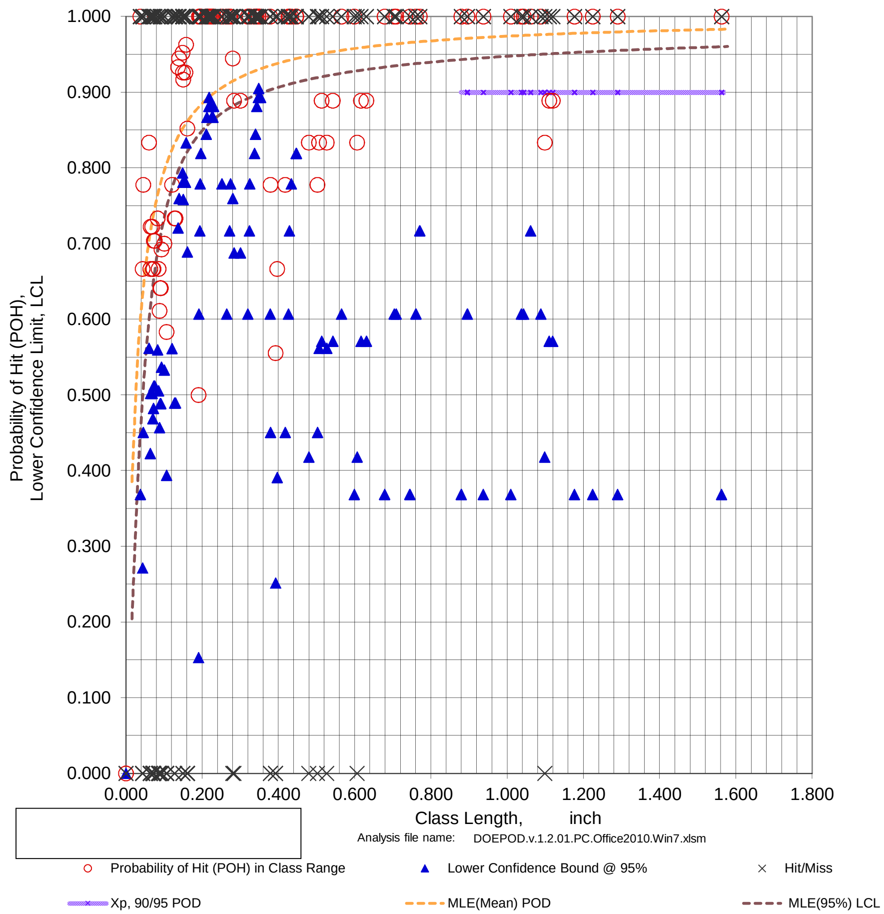
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

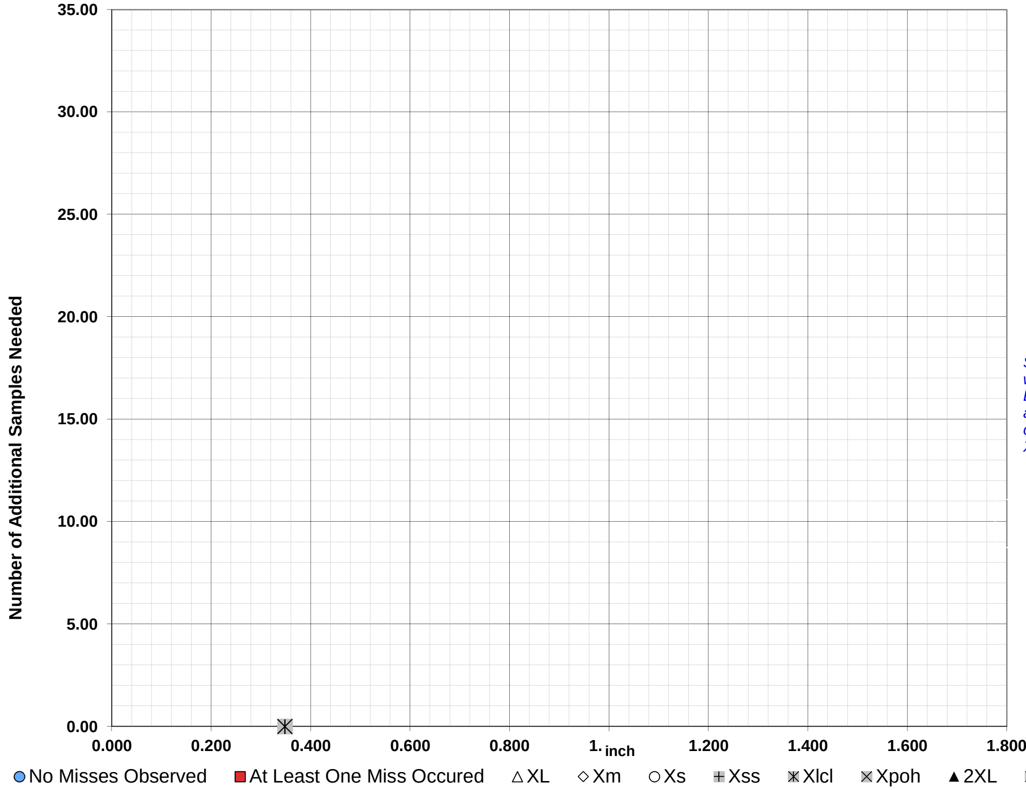


TABLE C

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

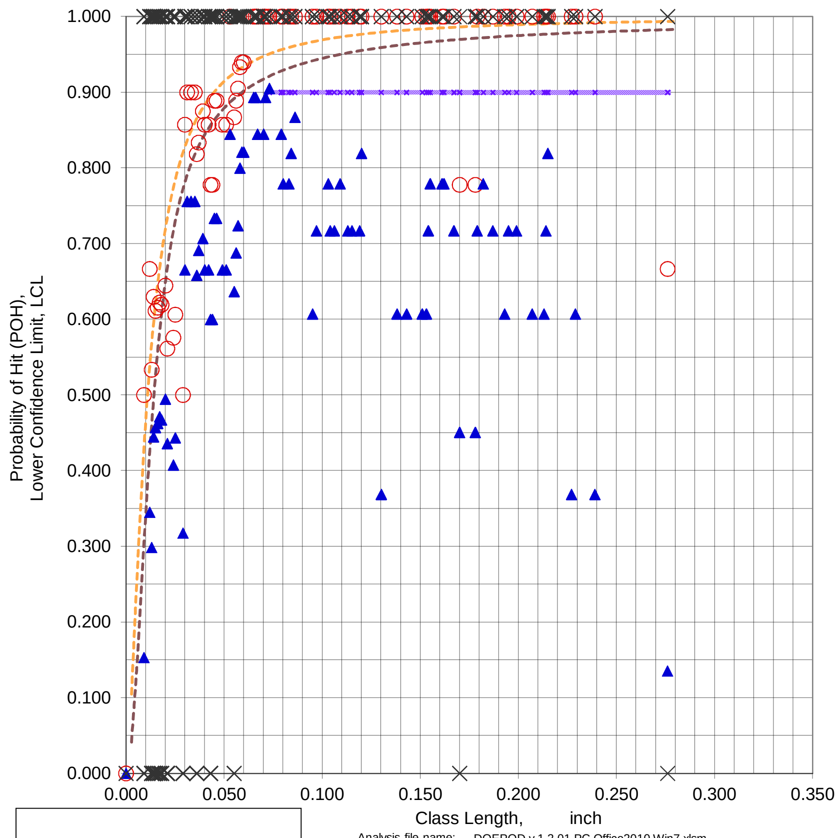
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 =	**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

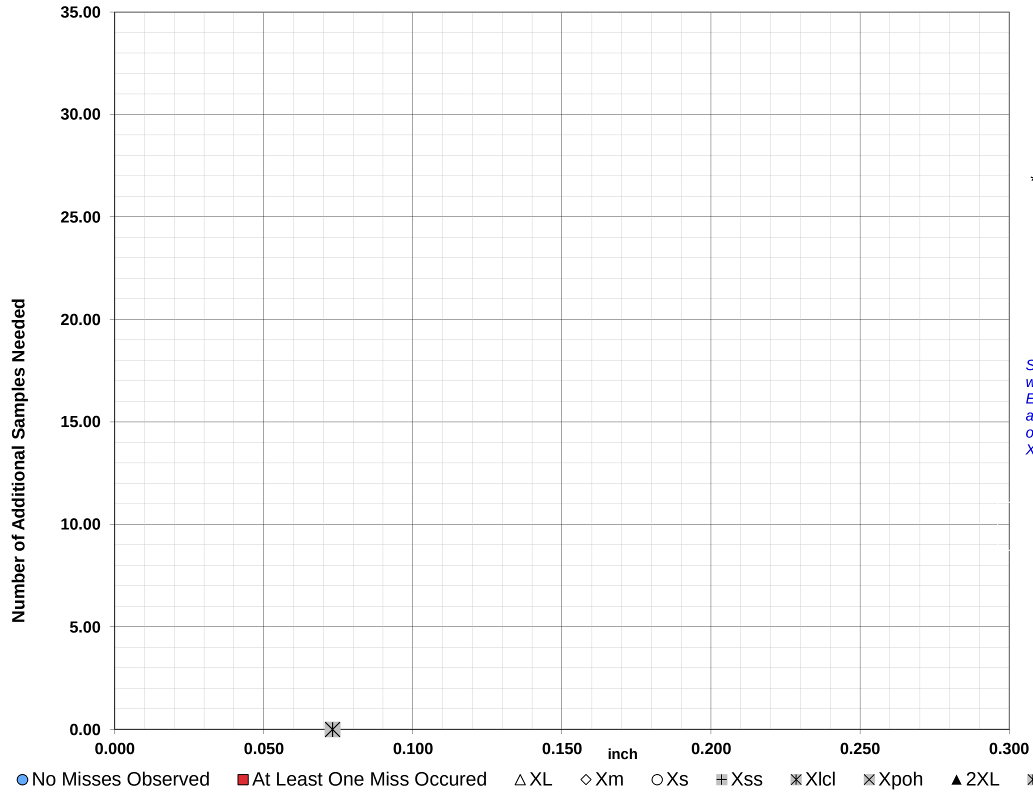


TABLE C

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

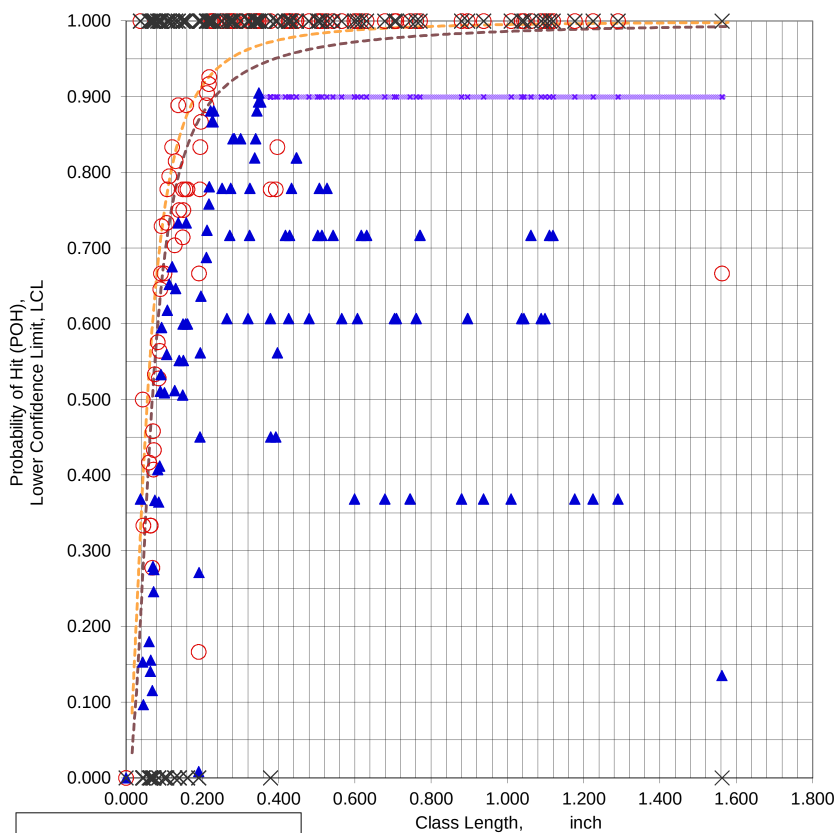
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = **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

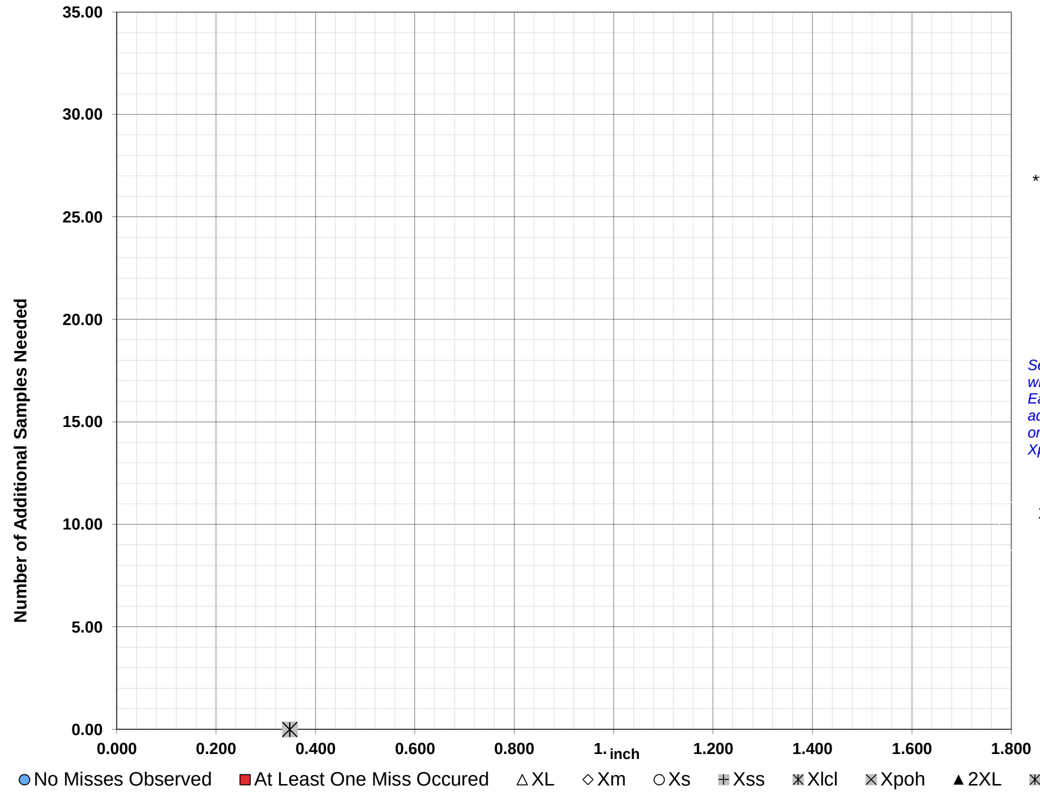


TABLE C

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*

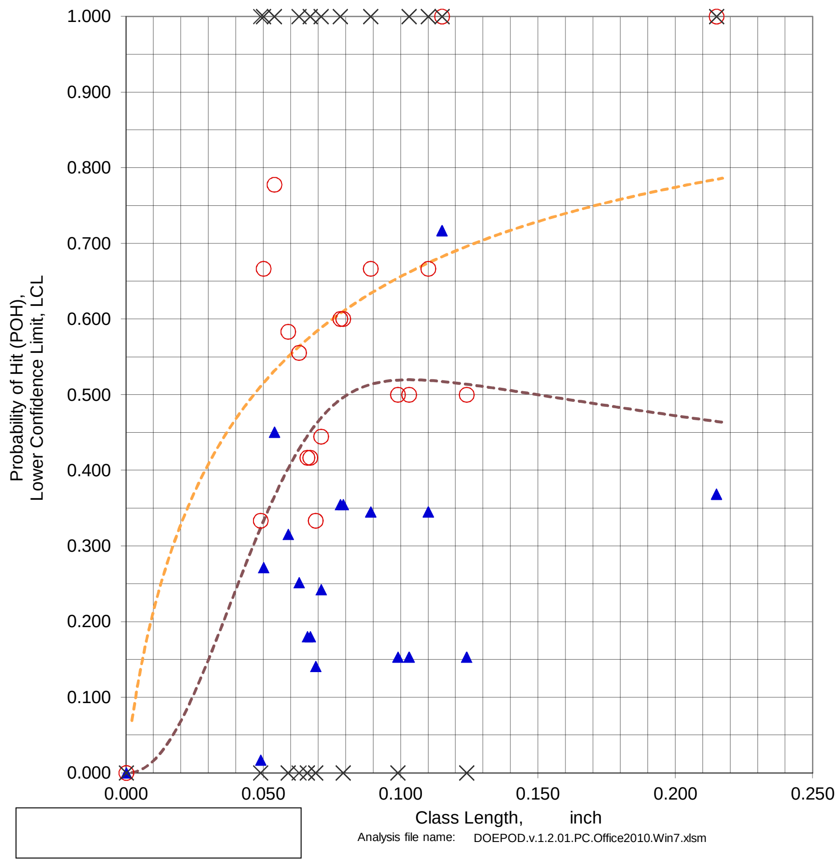
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = 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

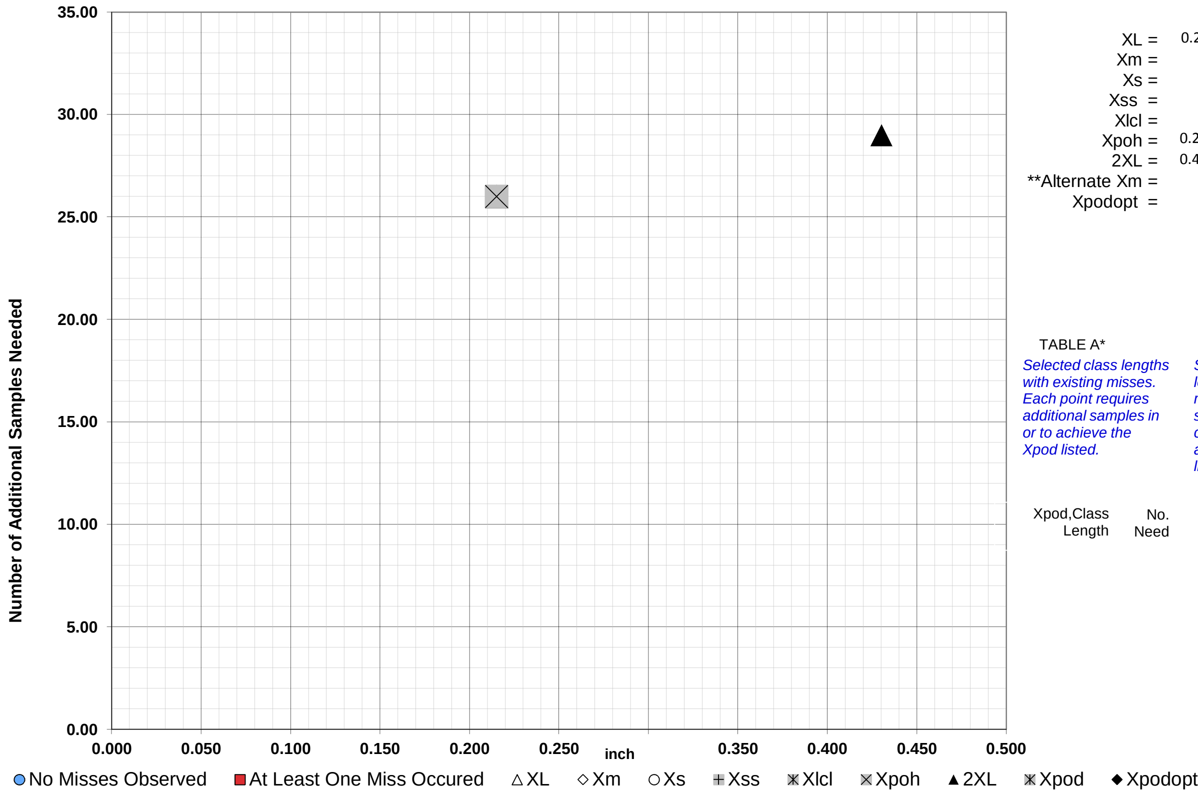


TABLE C

	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.

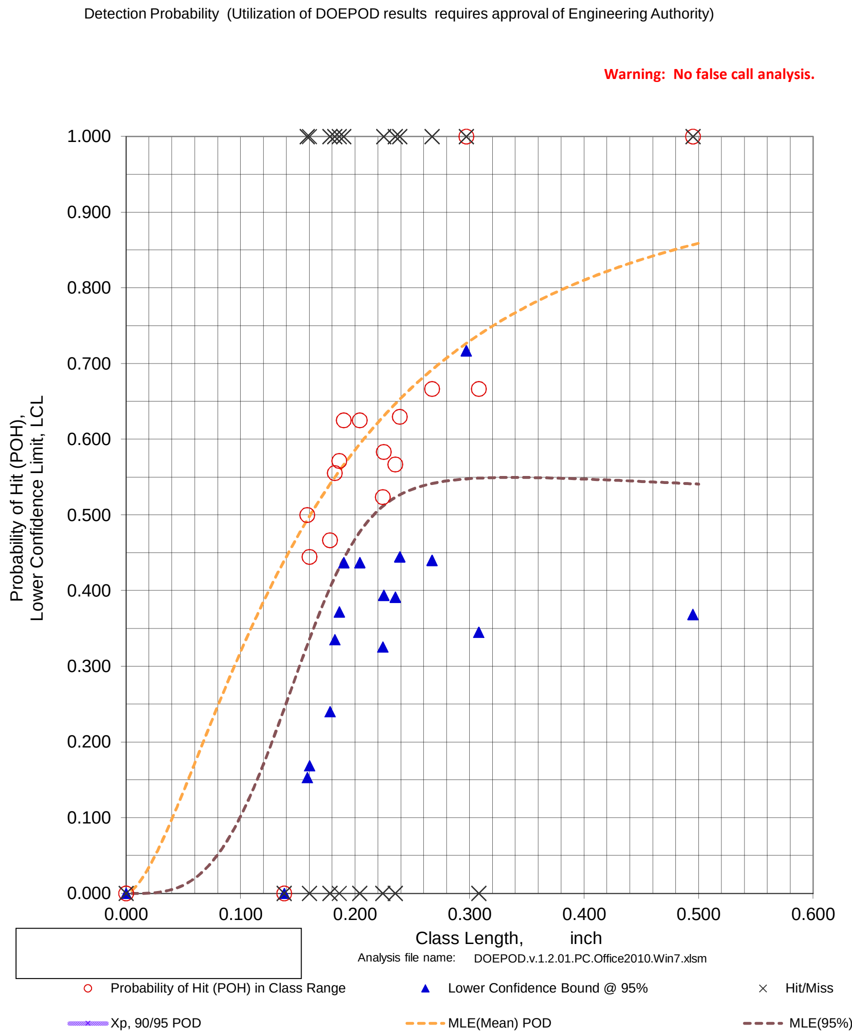
Xpod,Class Length	No. Need

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



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

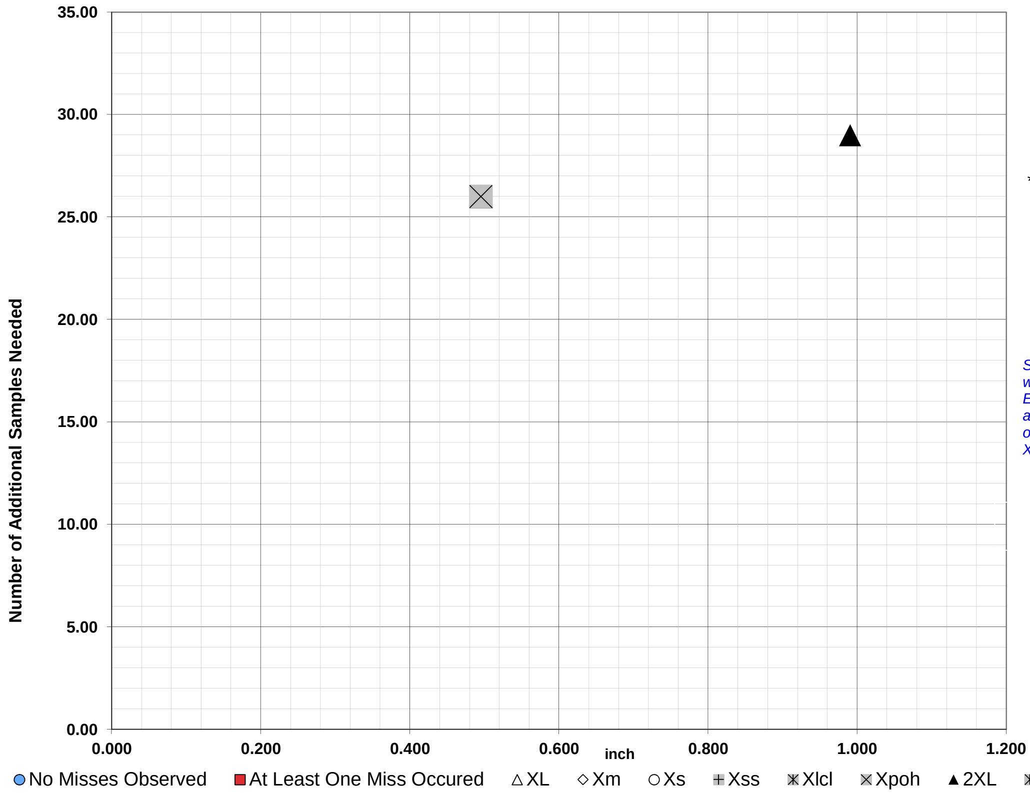


TABLE C

	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*

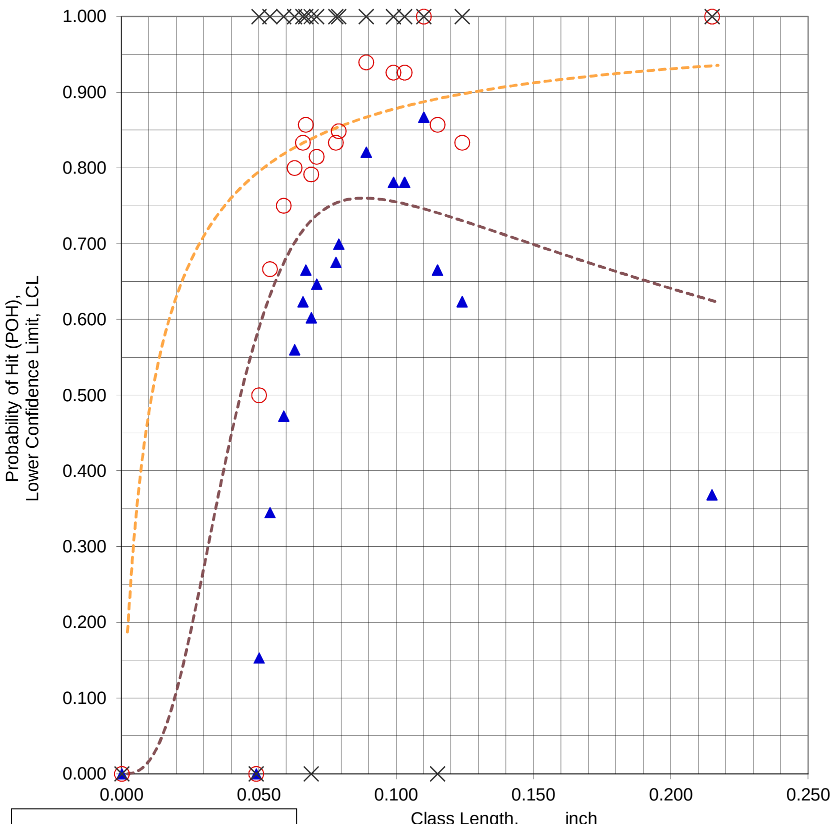
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

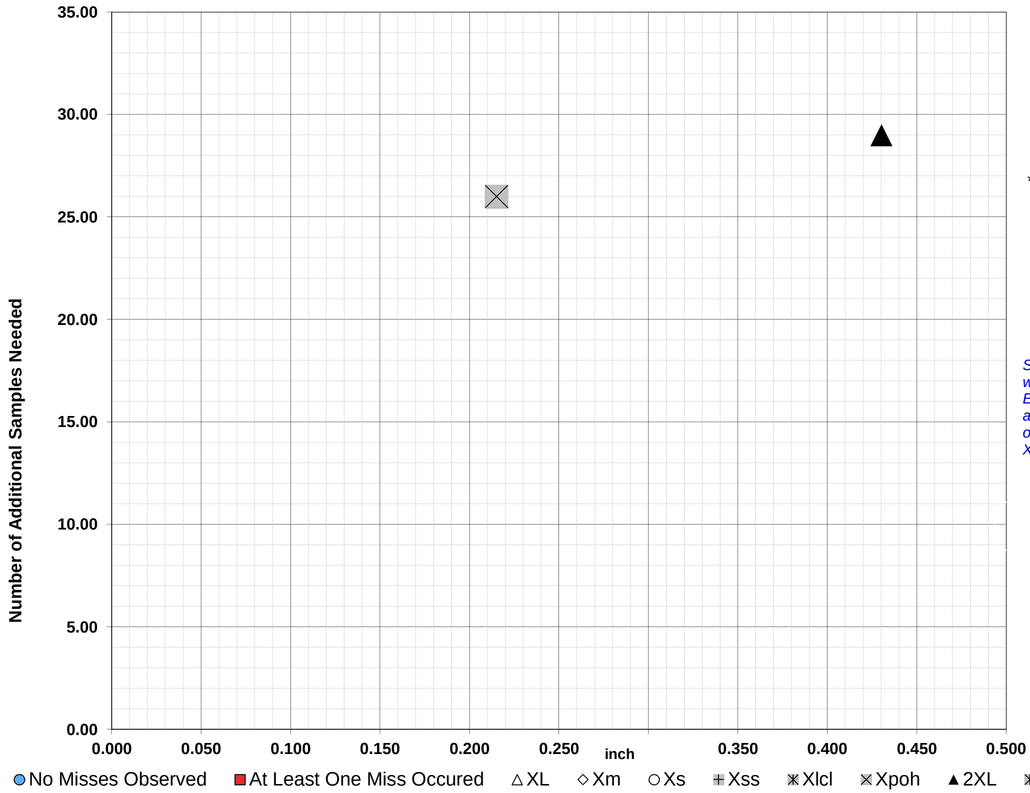


TABLE C

	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*

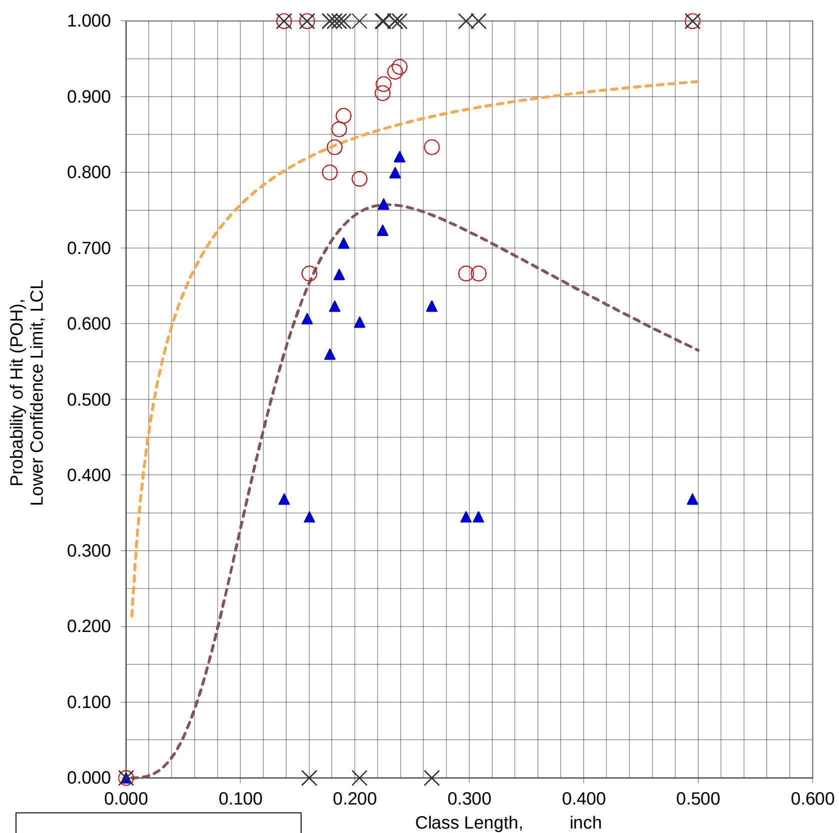
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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.

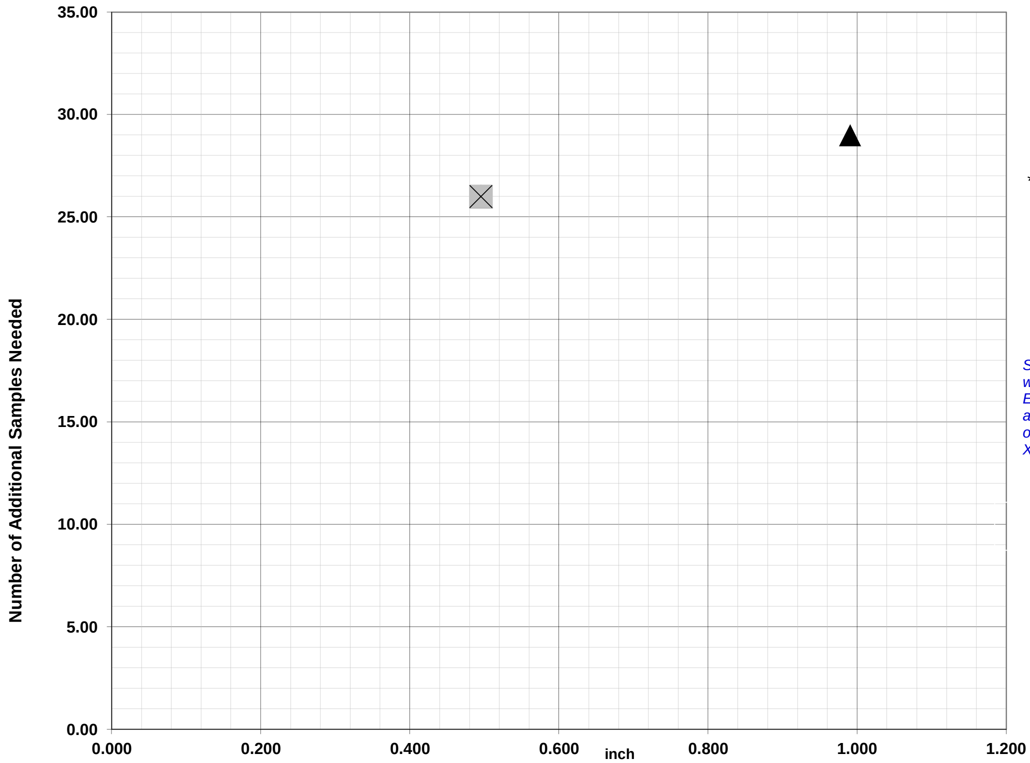
Survey/Optimum Xpoh = 0.2970 -0.029 inch 26 Samples

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



No Misses Observed | At Least One Miss Occured | △ XL | ◇ Xm | ○ Xs | Xss | Xlcl | Xpoh | ▲ 2XL | Xpod | ◆ Xpodopt

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*

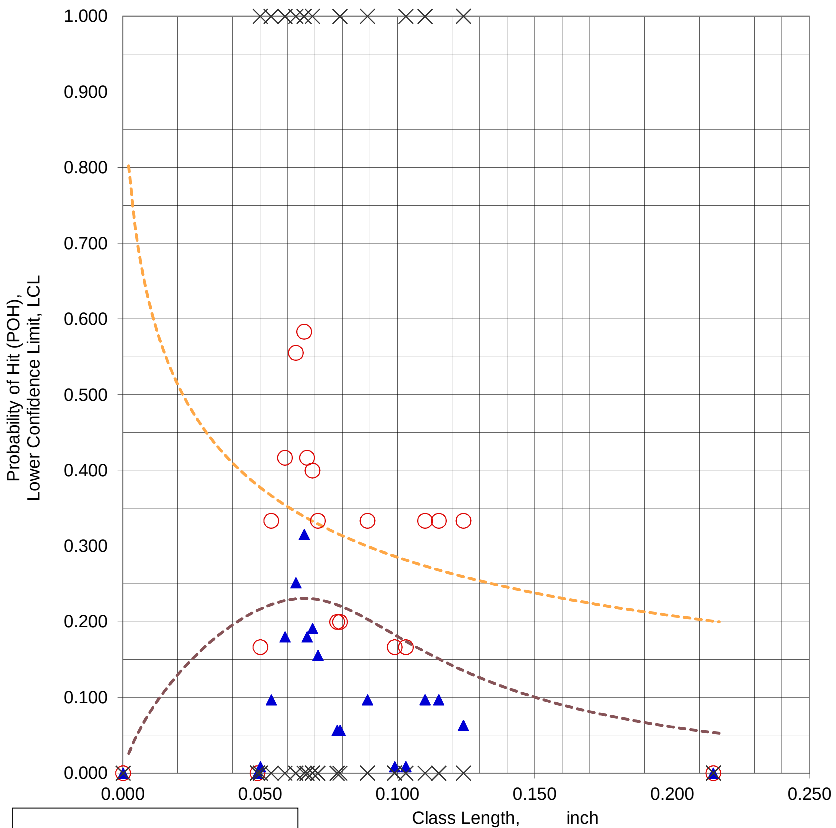
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

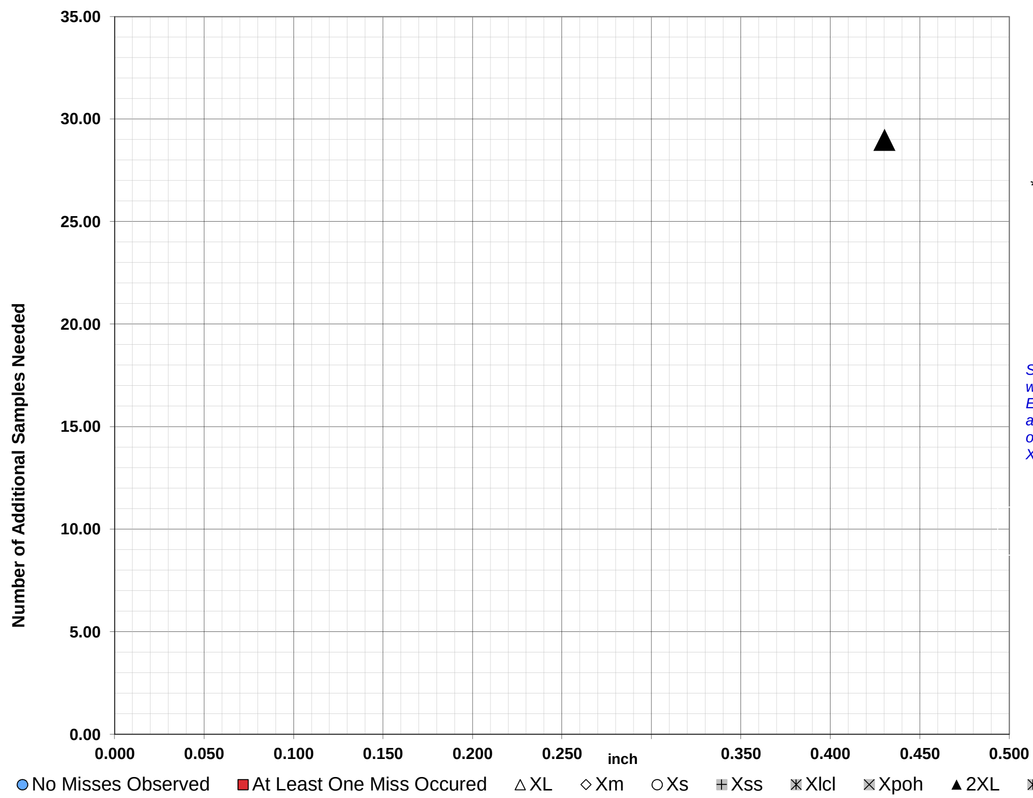


TABLE C

	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*

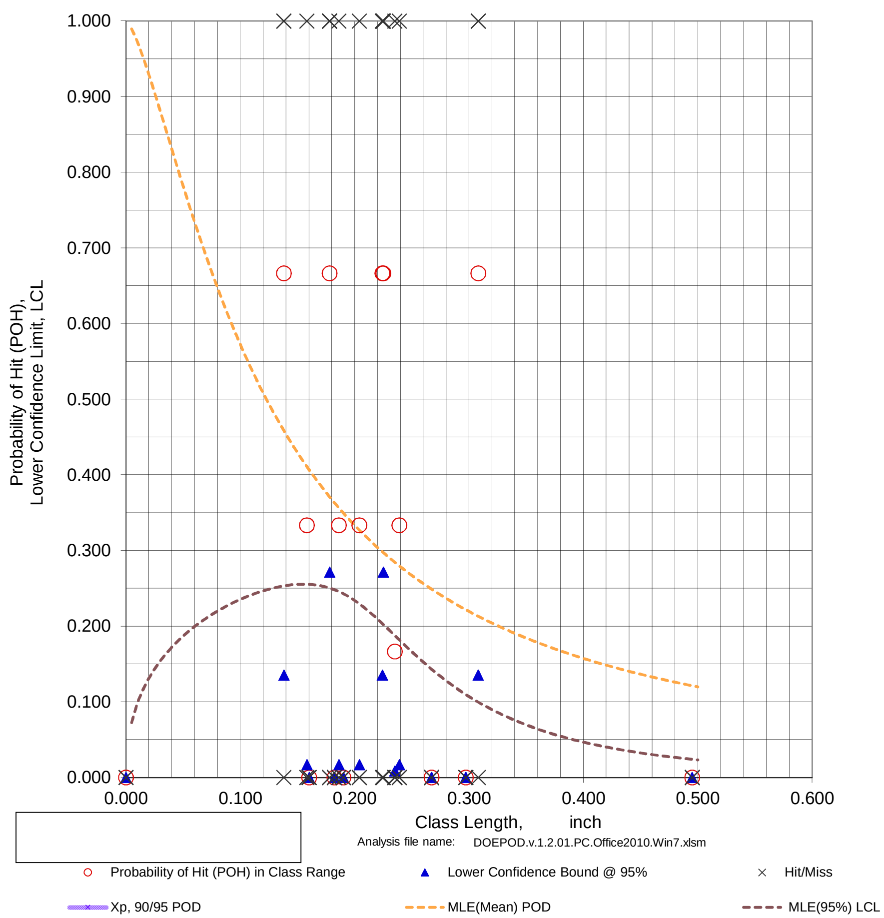
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.)

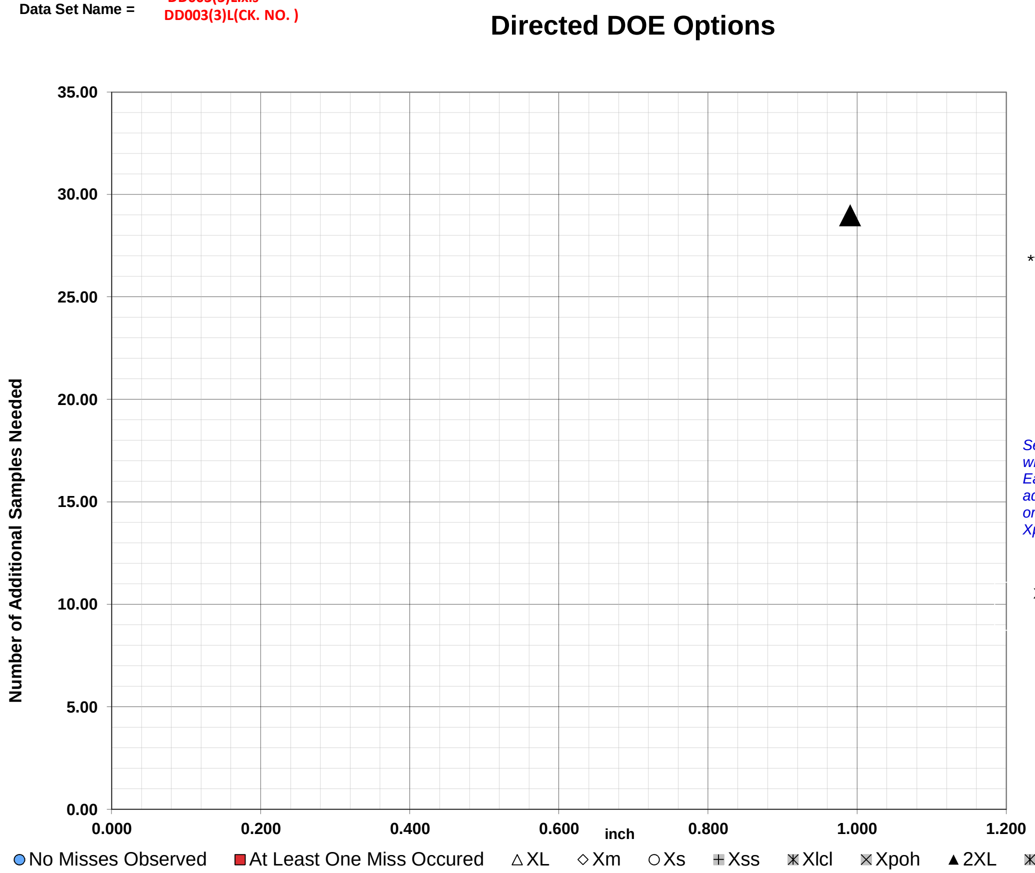


TABLE C

	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*

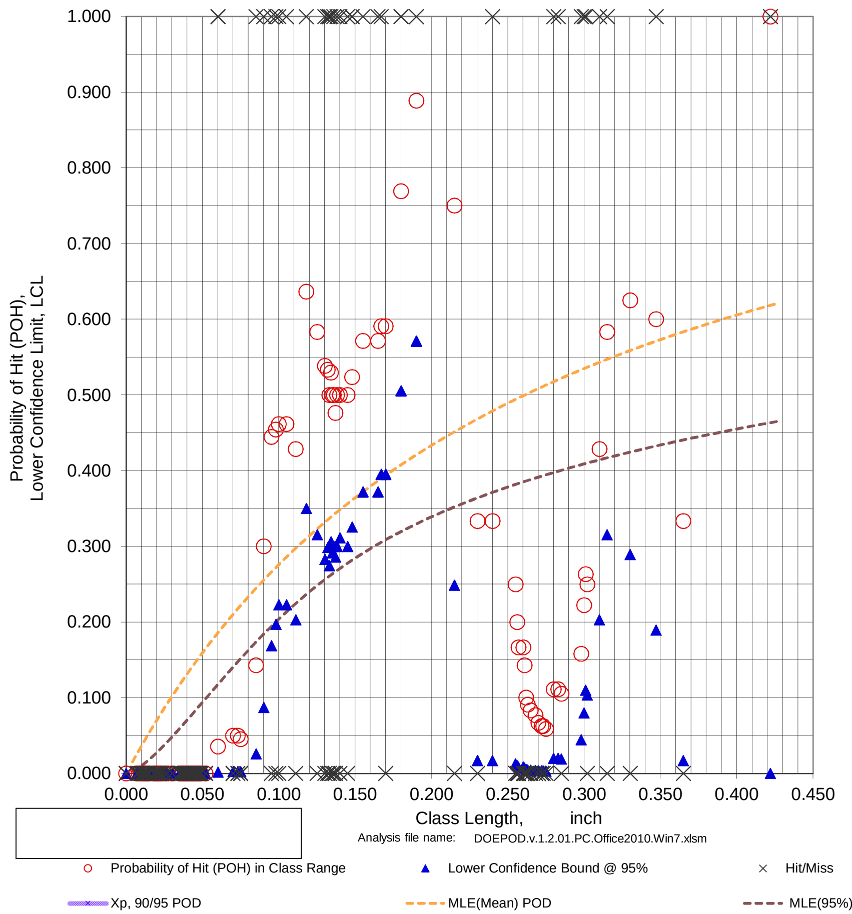
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

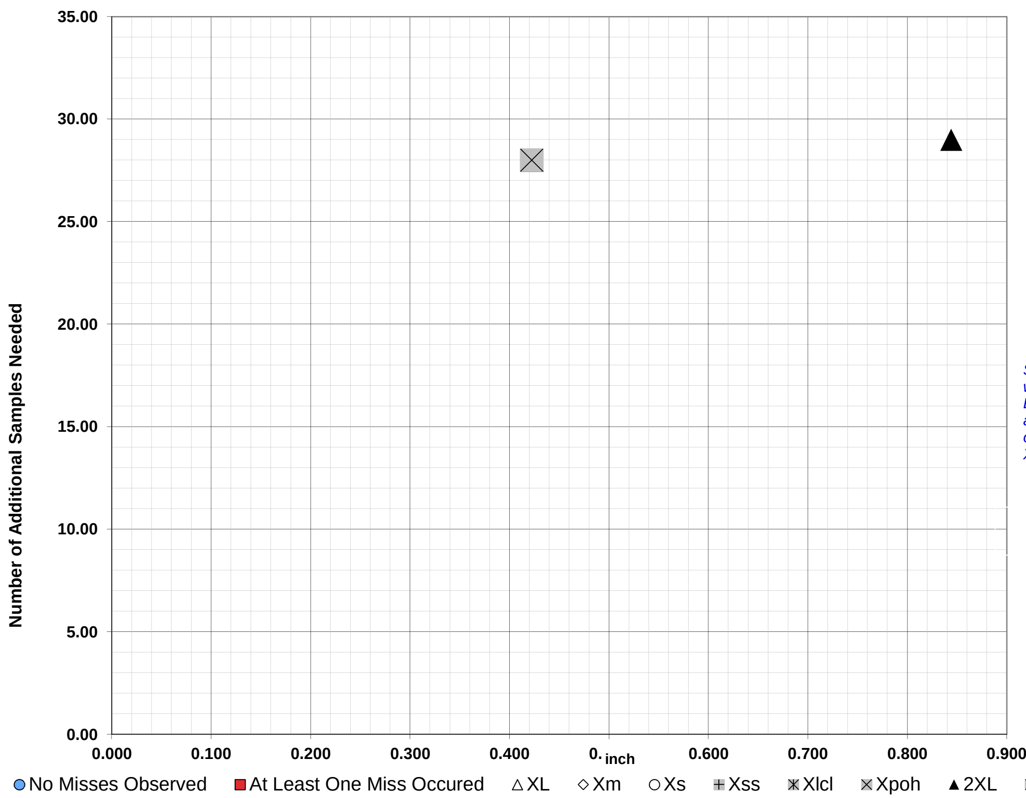


TABLE C

	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*

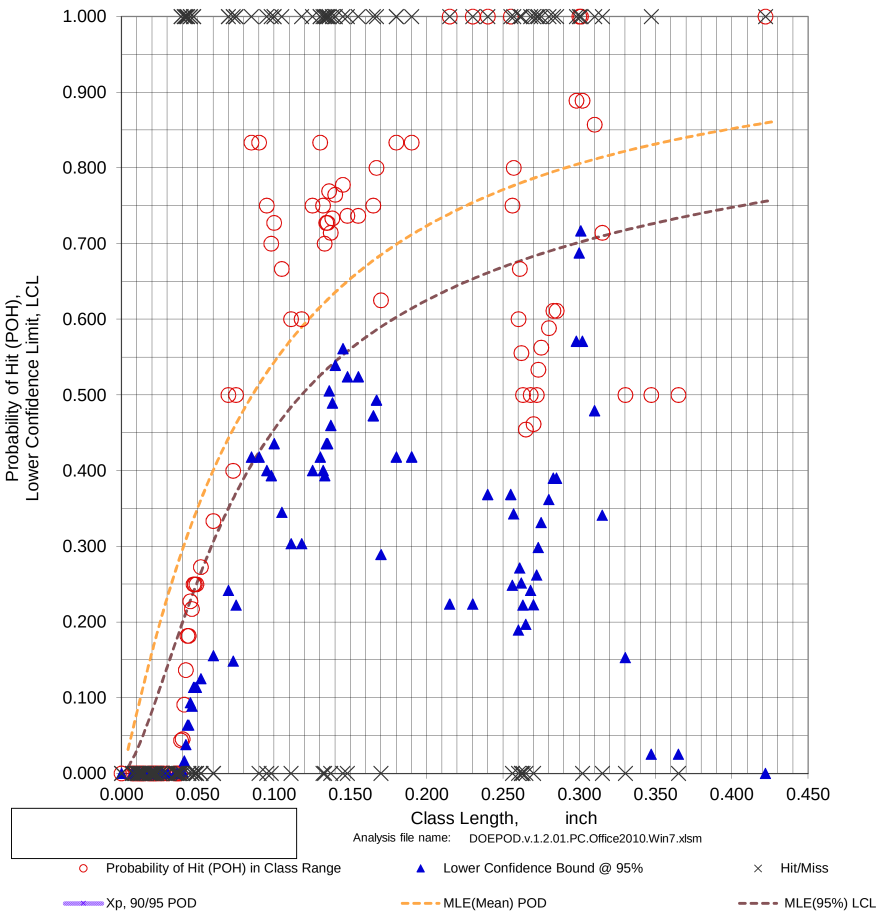
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

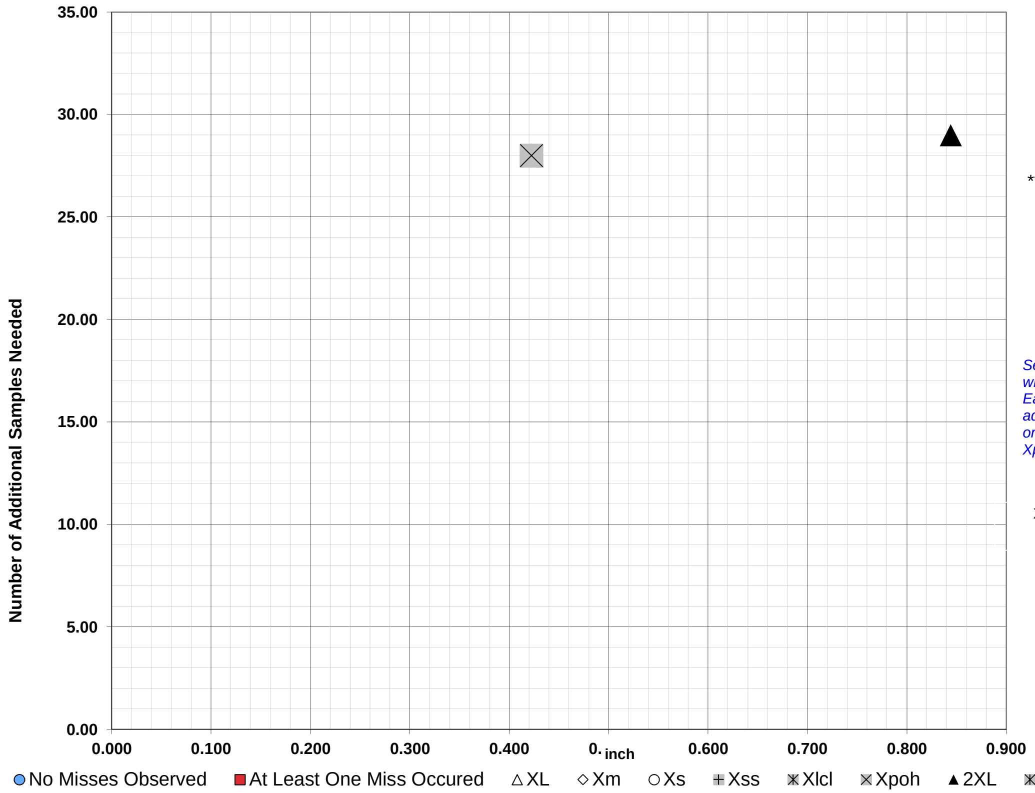


TABLE C

	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.

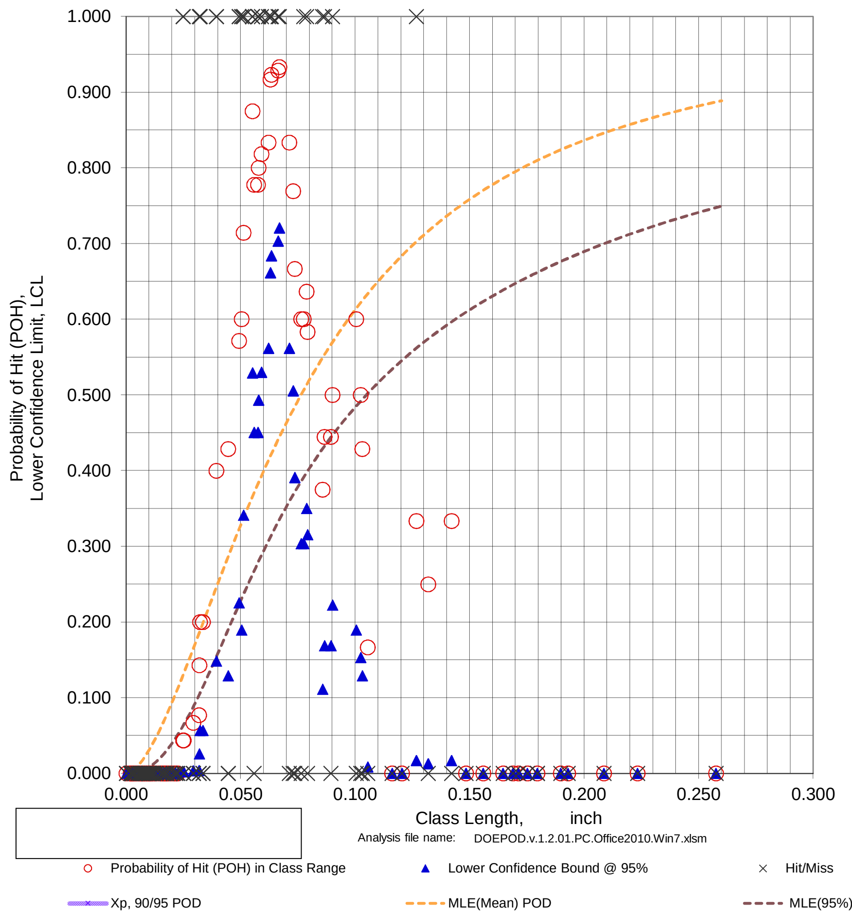
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



File Name = E2006.XLS
Data Set Name = E2006(HOLE #)
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

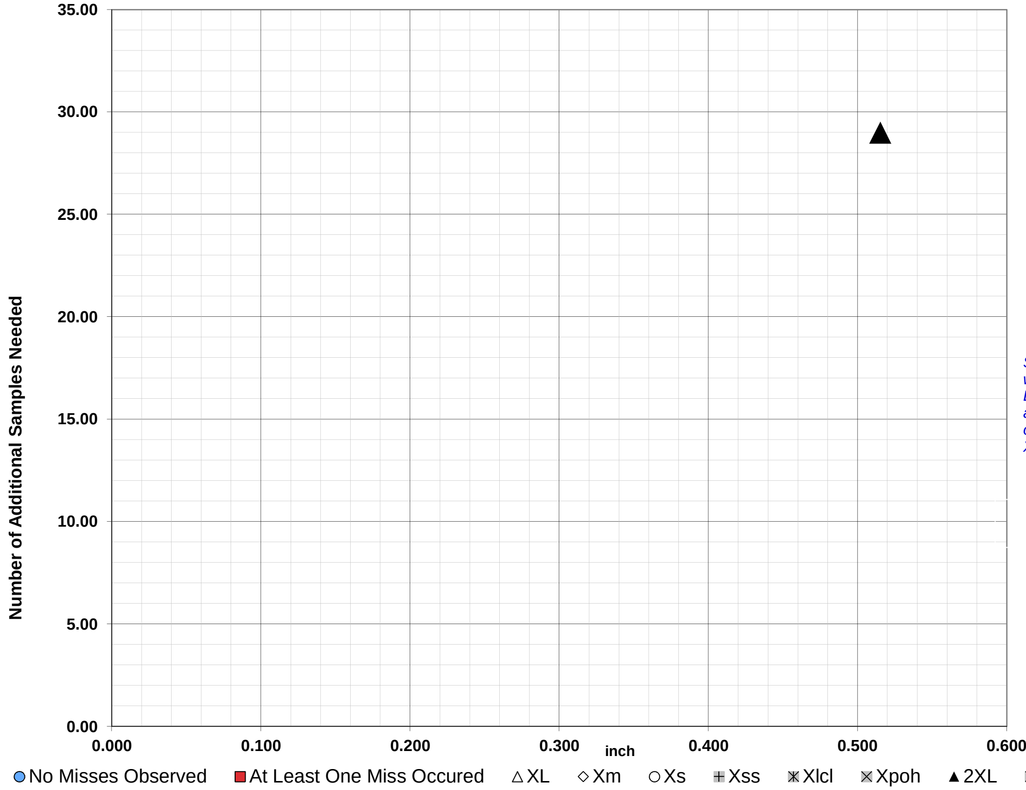


TABLE C

	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

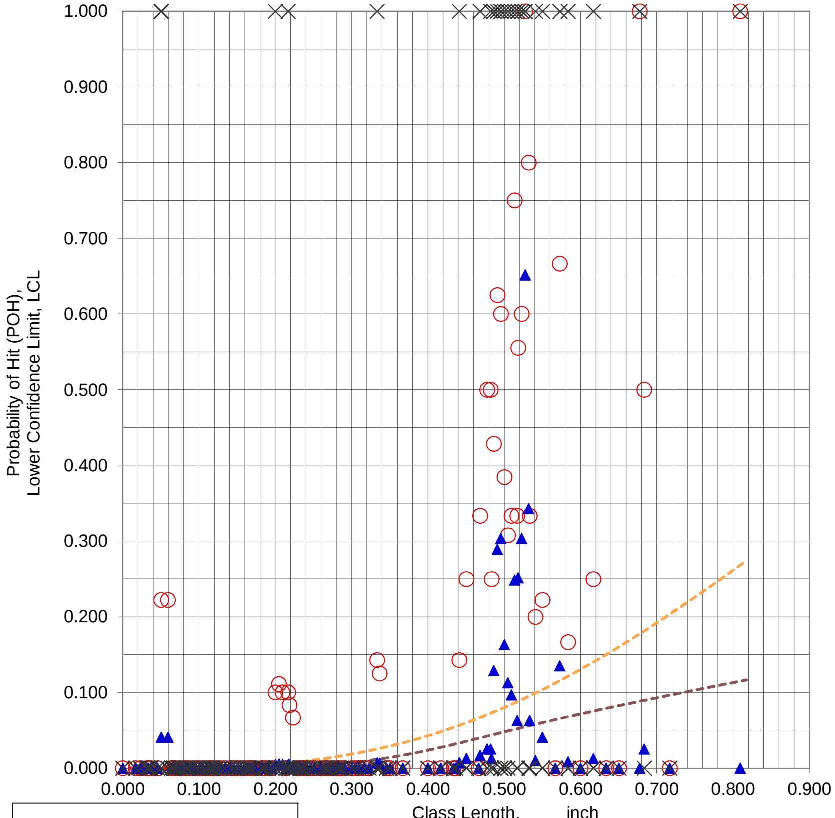
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F10001AA.XLS
Data Set Name = F10001AA(CRACK #)
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 =



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

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

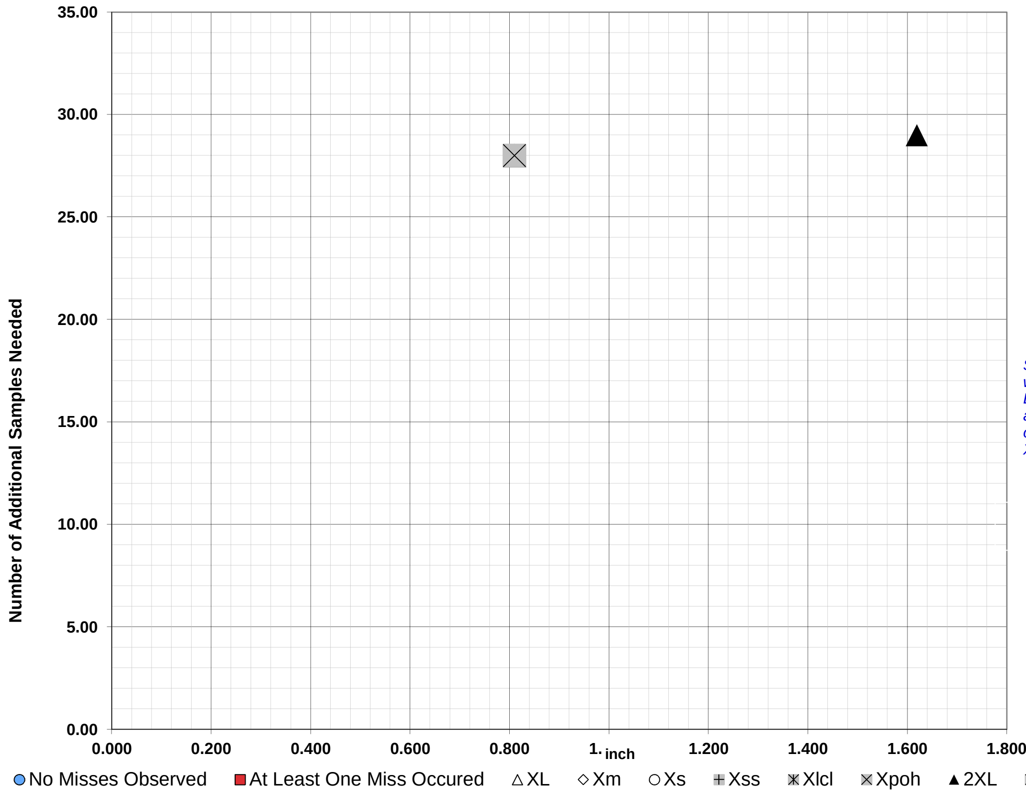


TABLE C

	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.

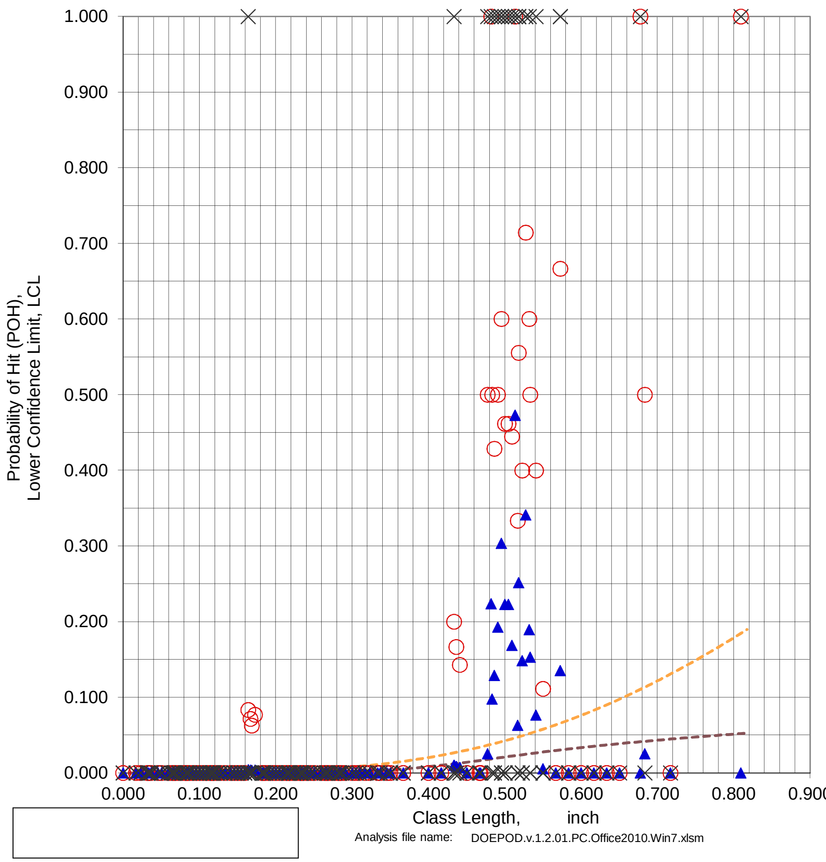
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



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 = F10001BA.XLS

Data Set Name = F10001BA(CRACK #)

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

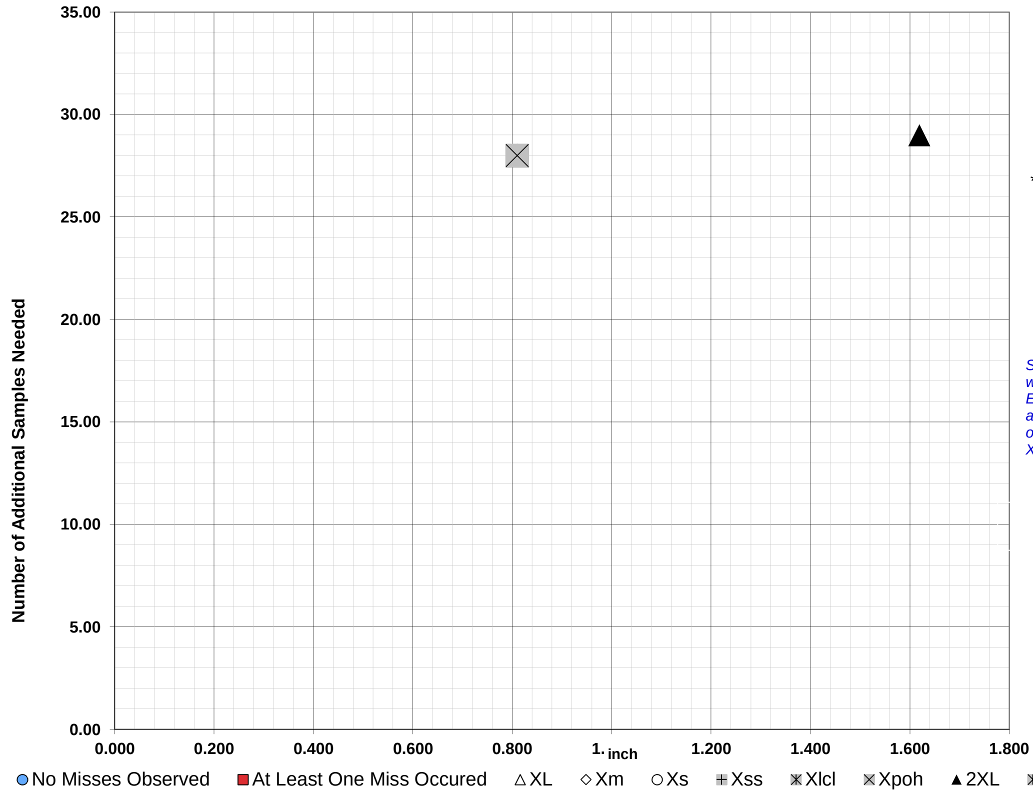


TABLE C

	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*

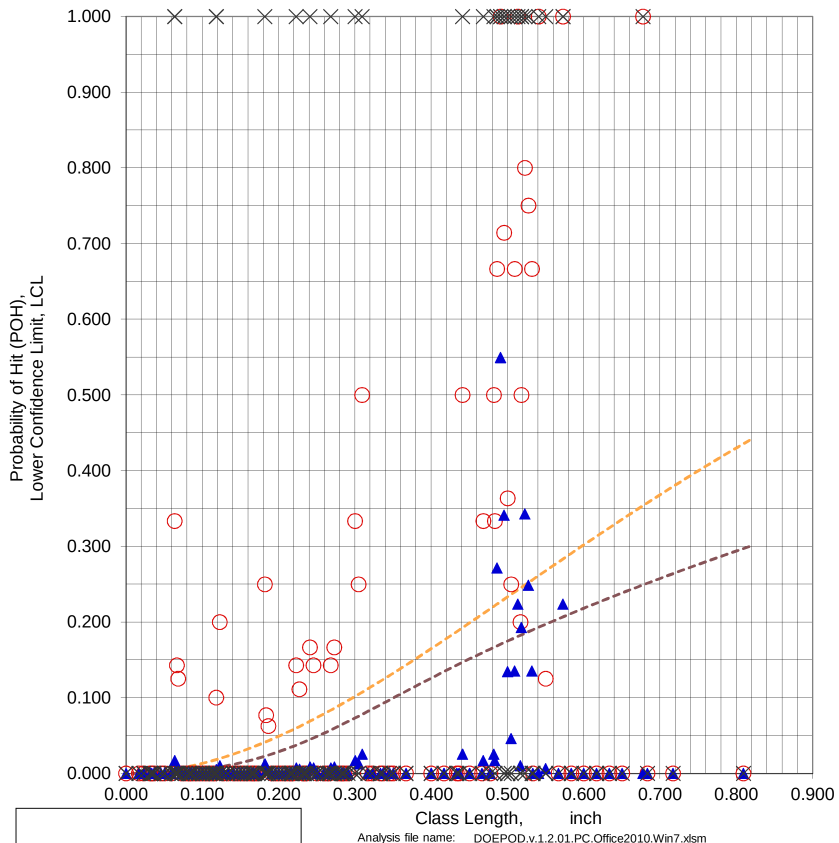
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = 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

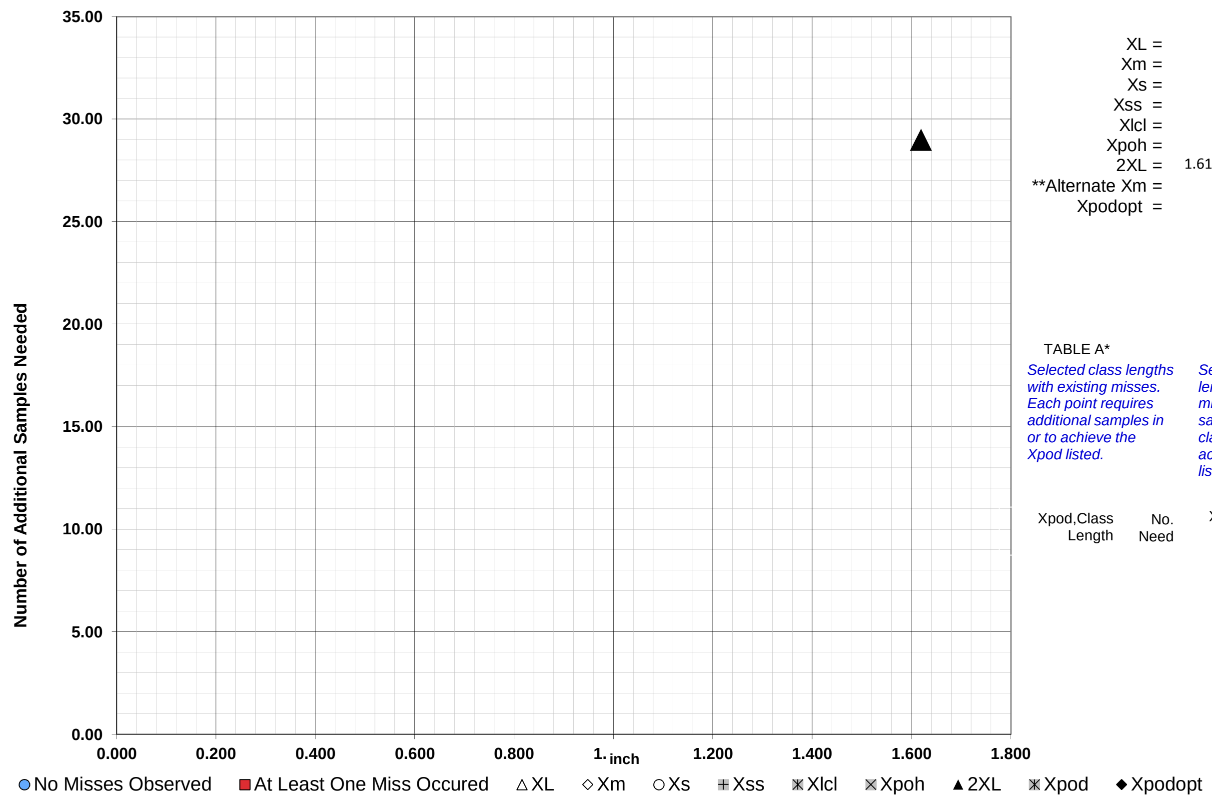


TABLE C

	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

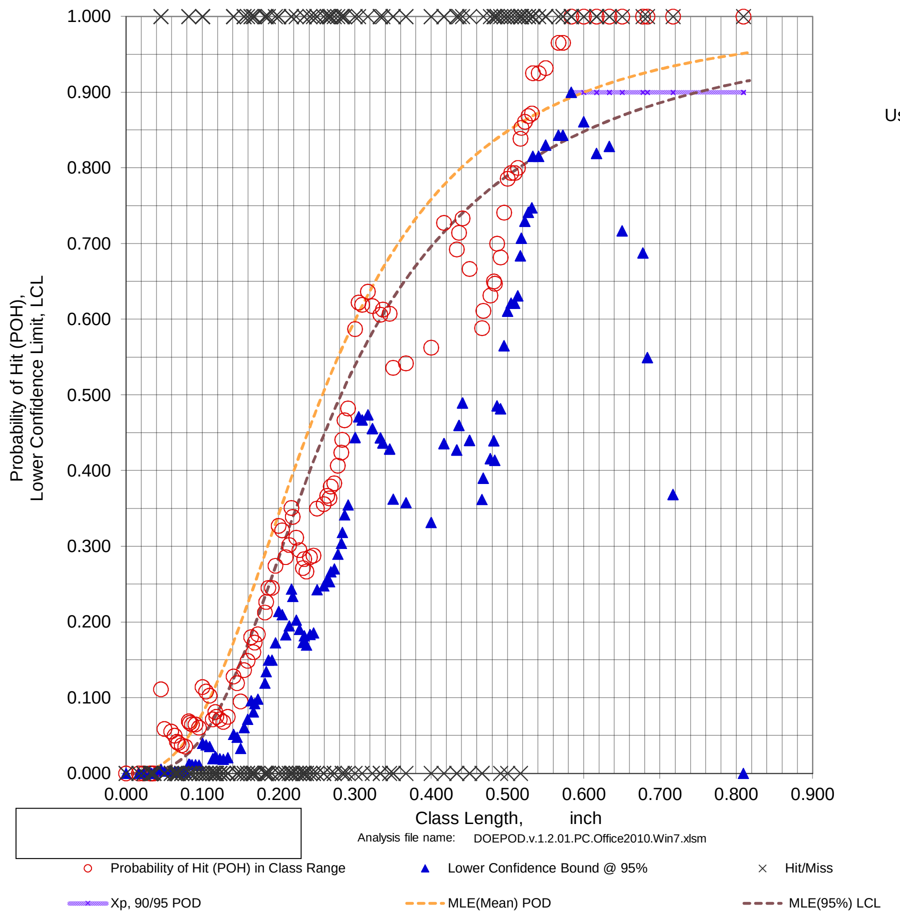
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

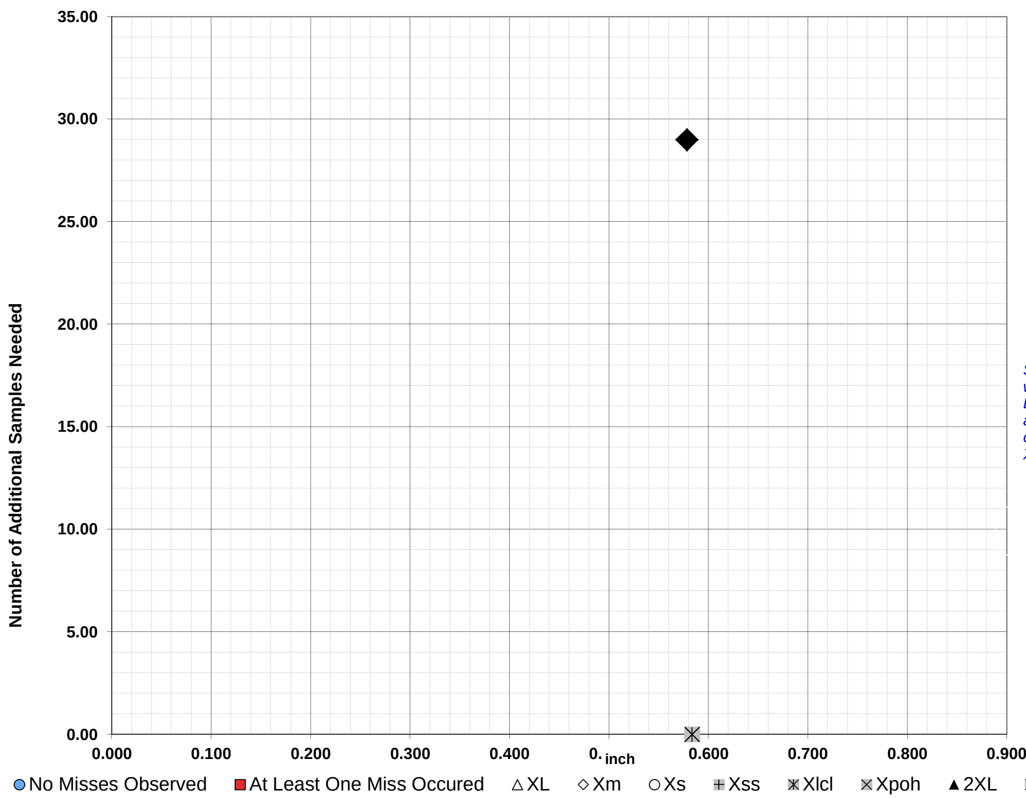


TABLE C

	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

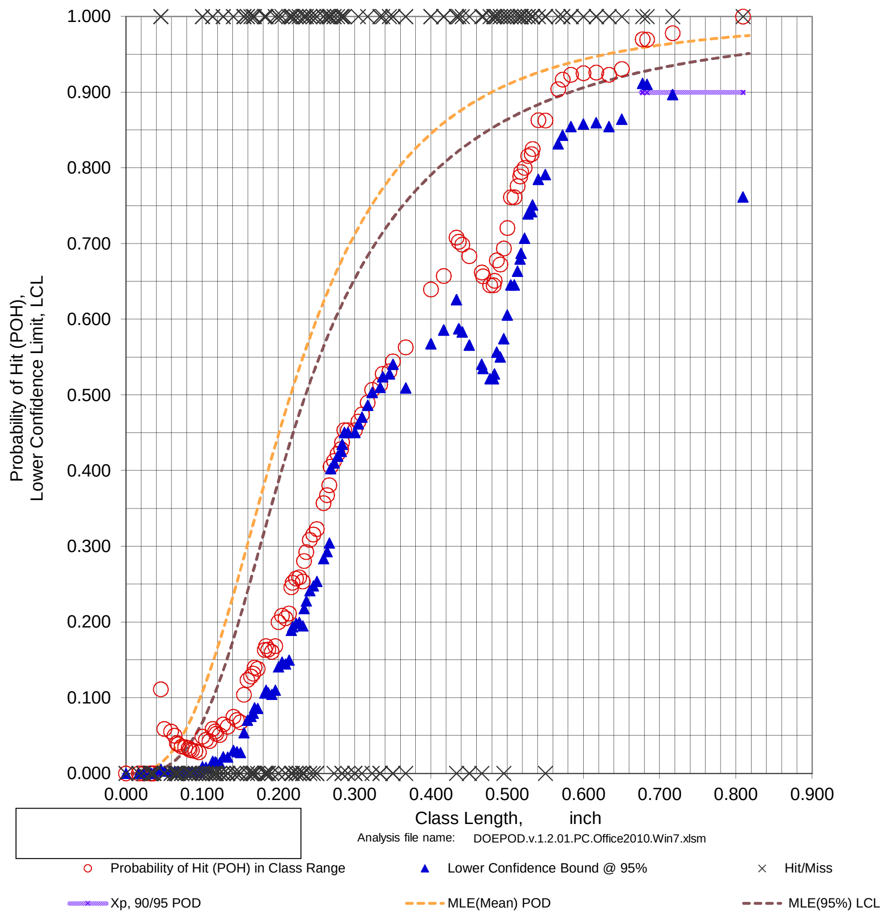
TABLE B*

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

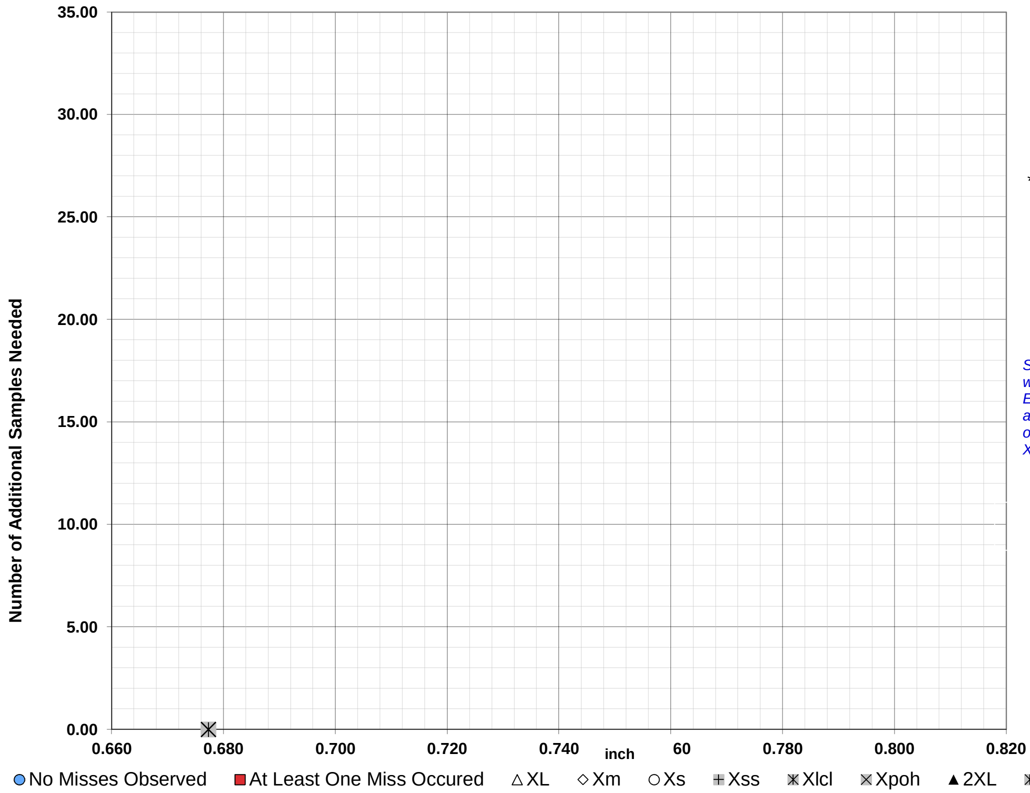


TABLE C

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

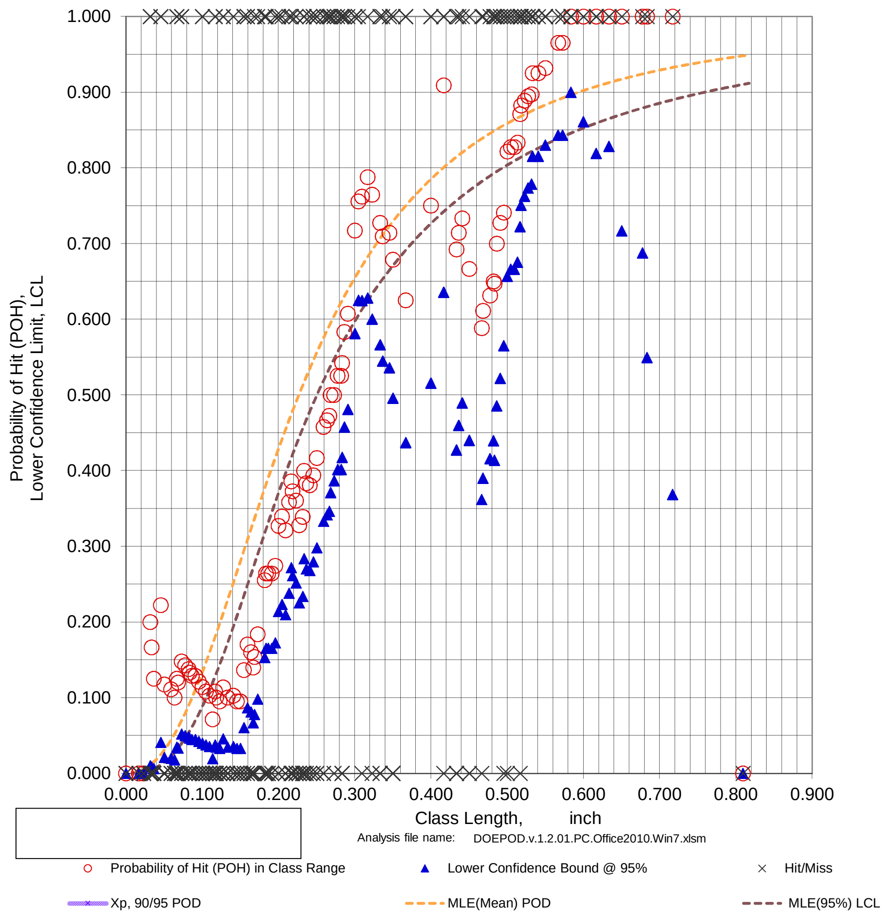
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

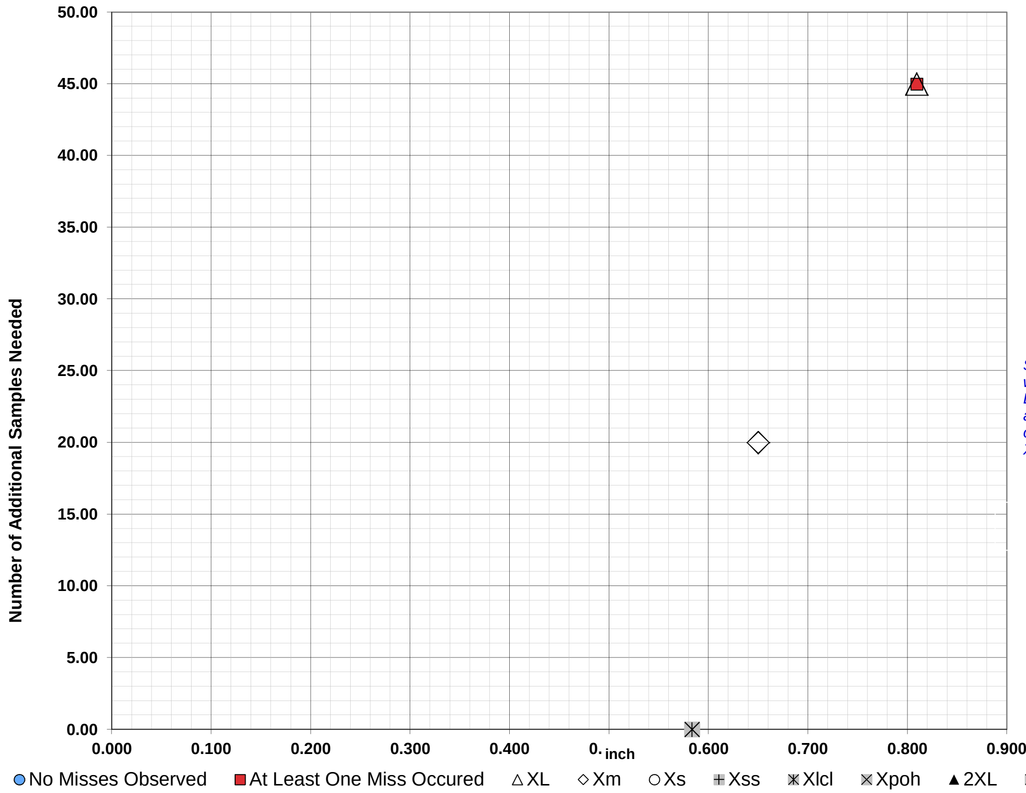


TABLE C

	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.

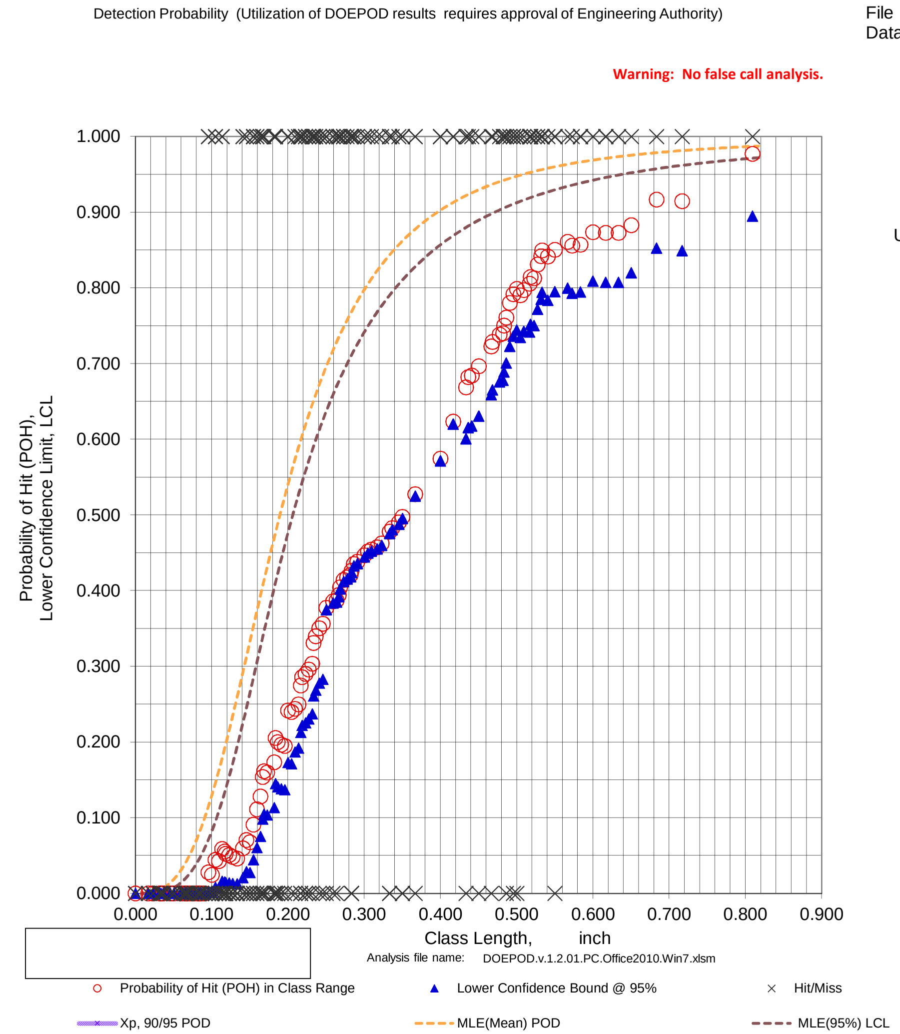
Xpod,Class Length	No. Need
0.8091	45

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



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

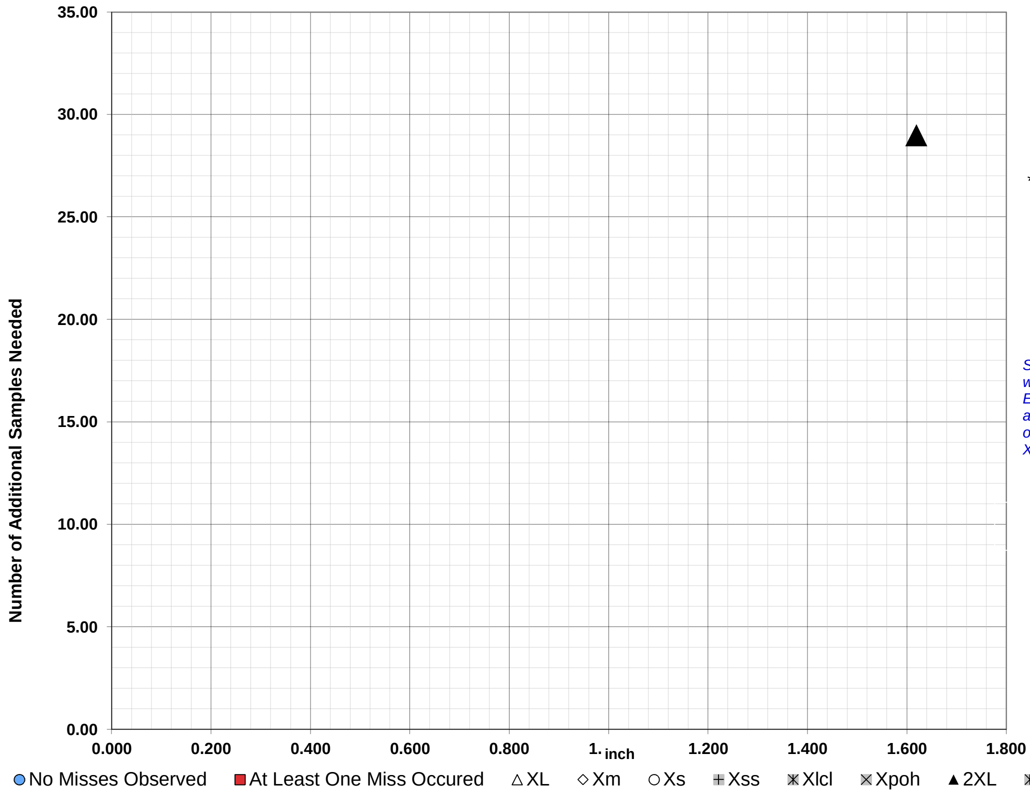


TABLE C

	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

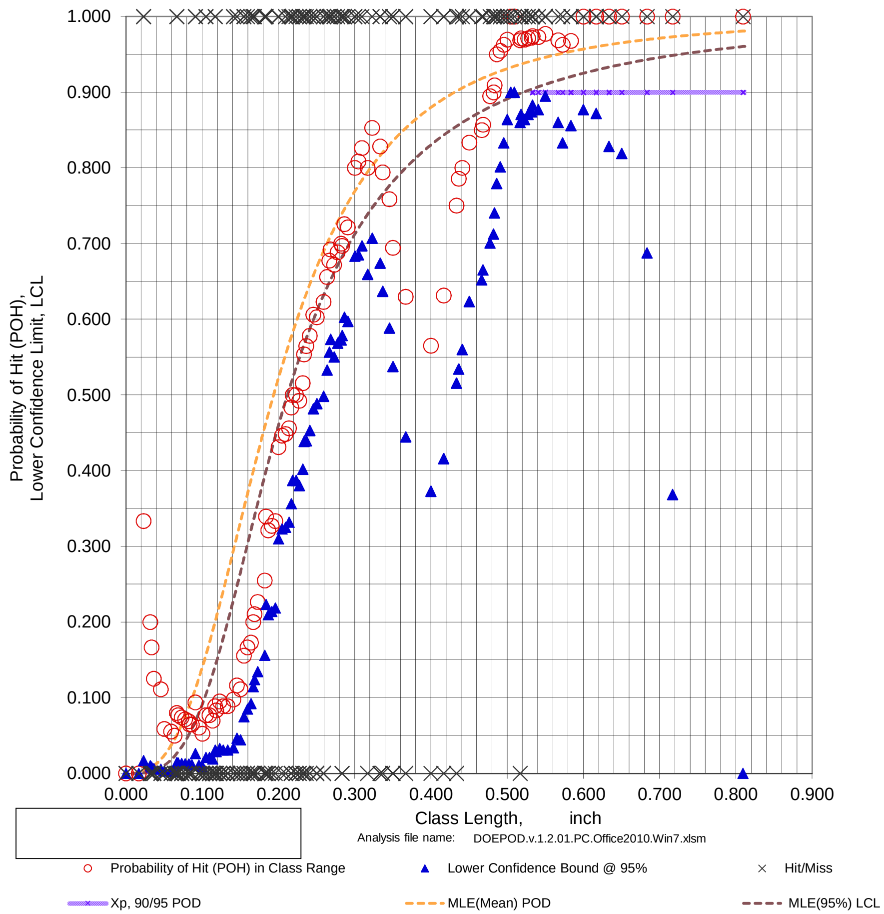
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

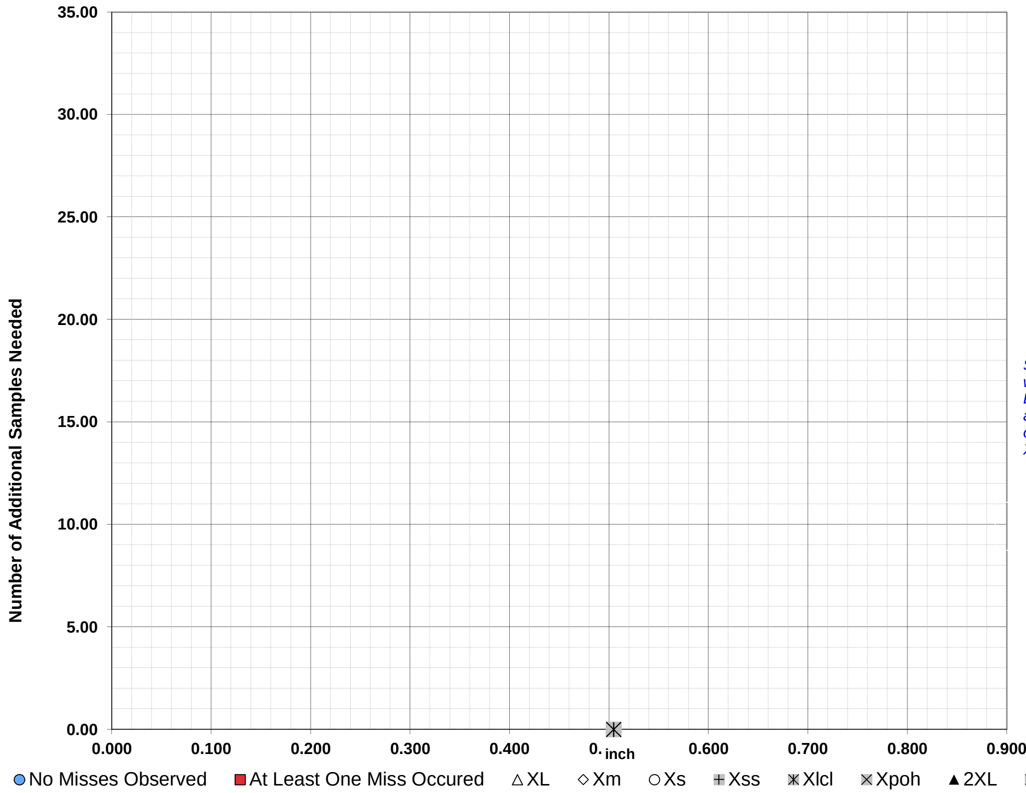


TABLE C

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

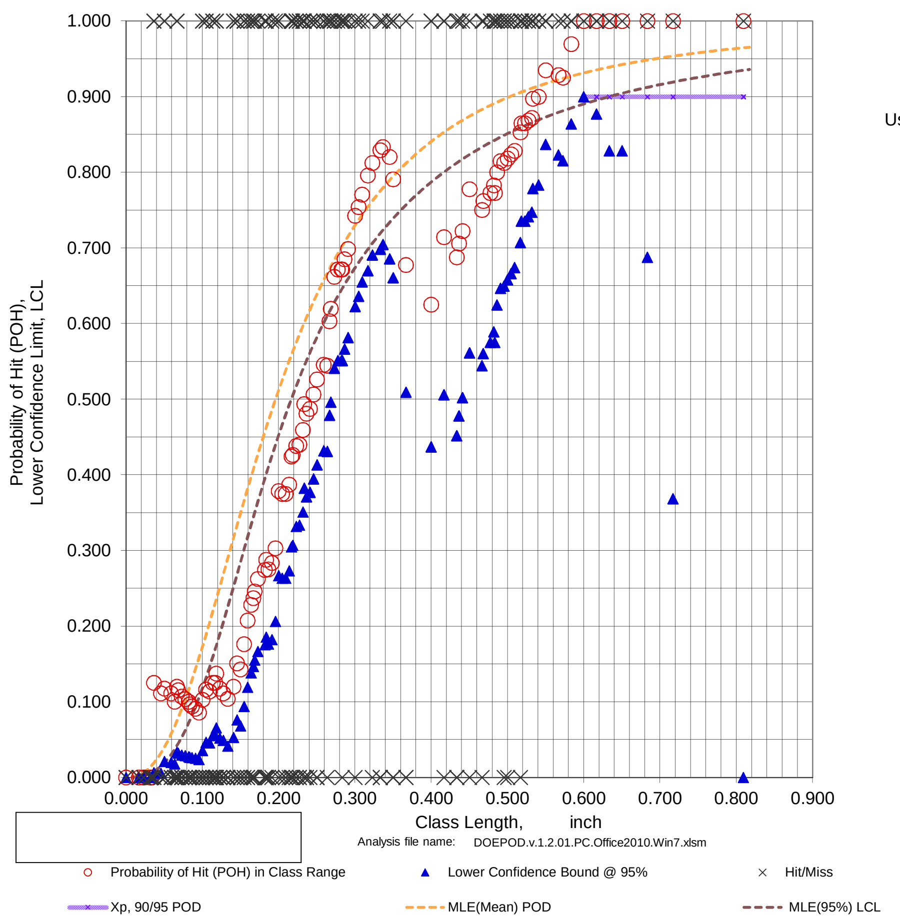
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

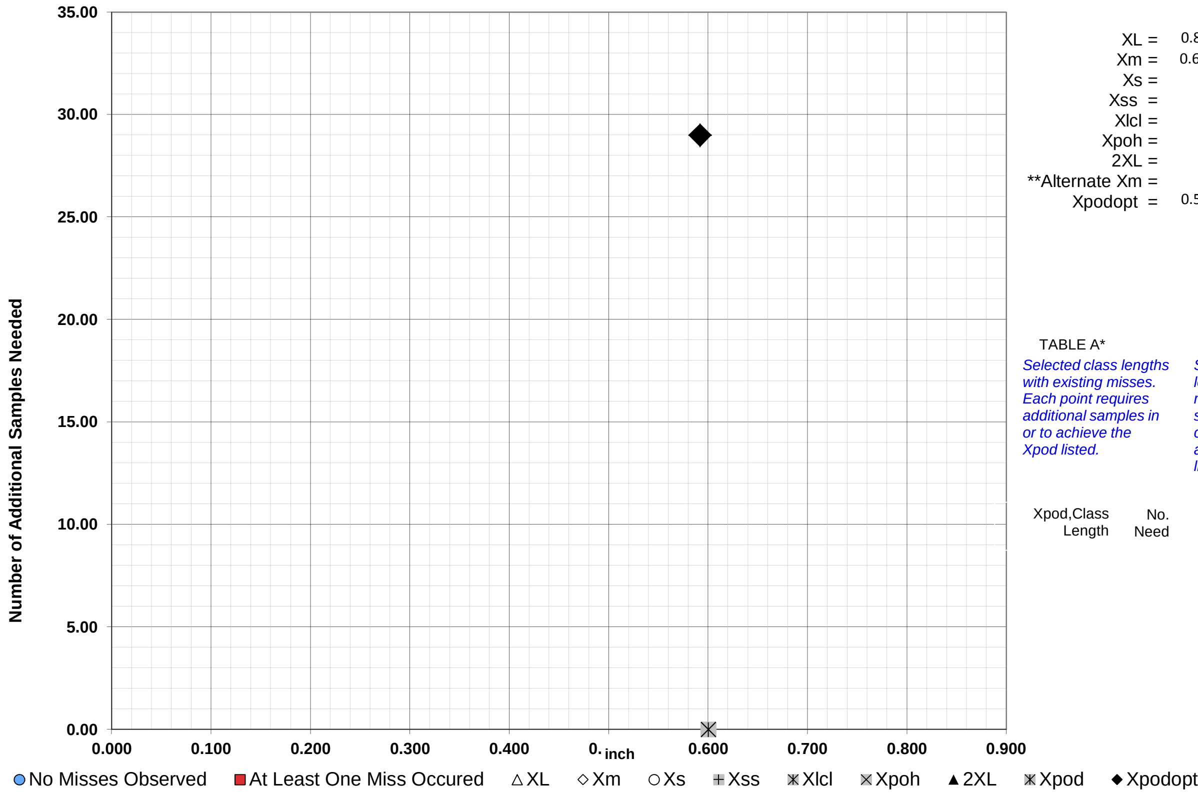


TABLE C

	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*

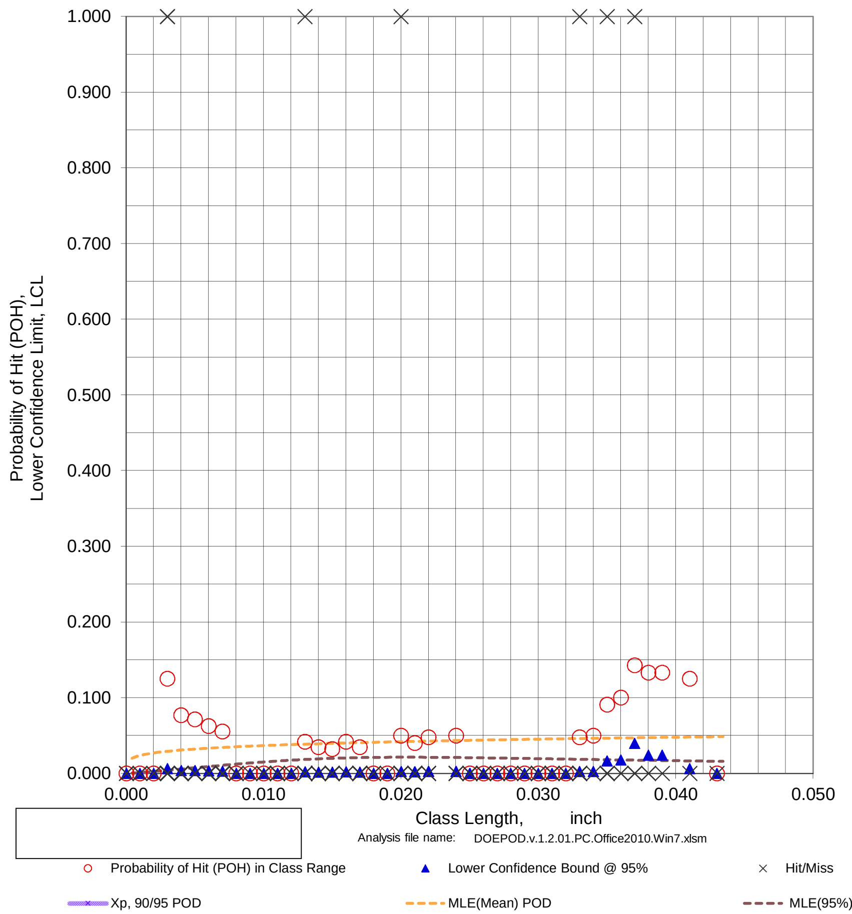
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

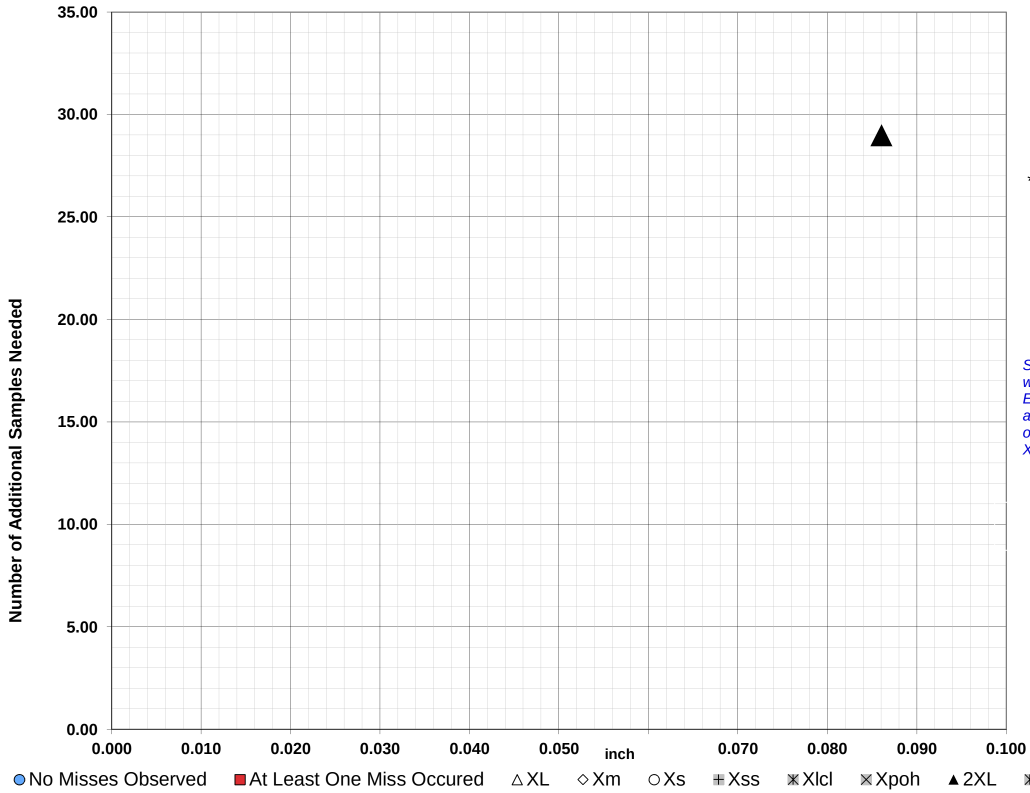


TABLE C

	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

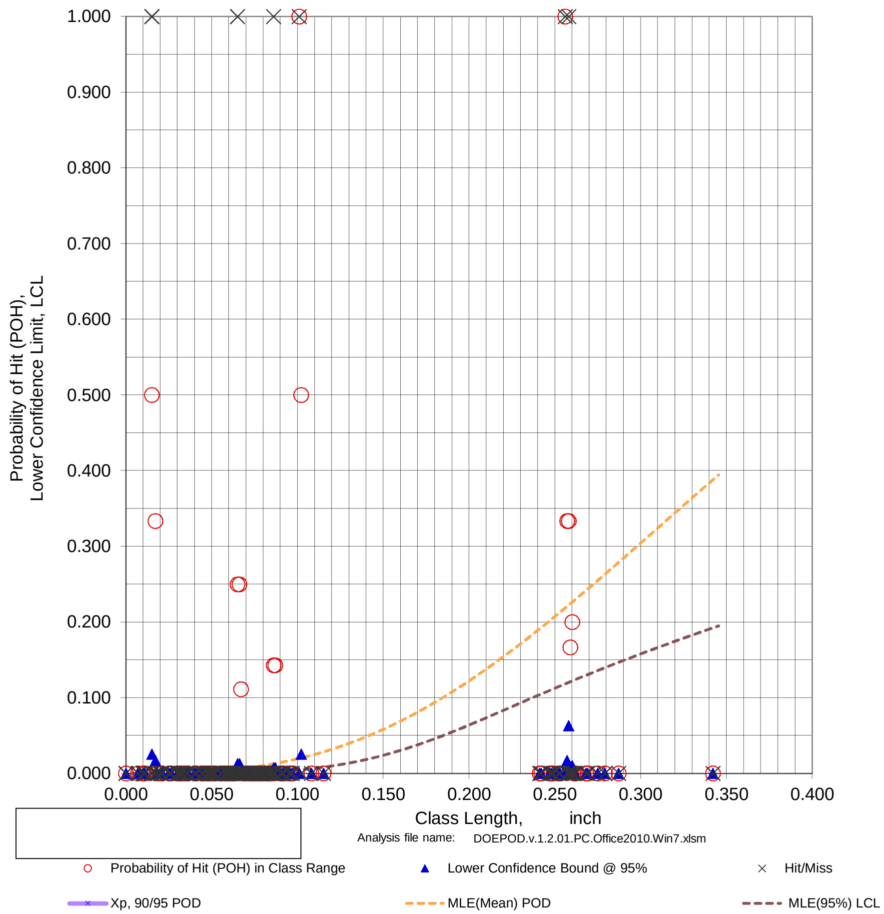
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F10601AL.XLS
Data Set Name = F10601AL(CRACK #)
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 #)

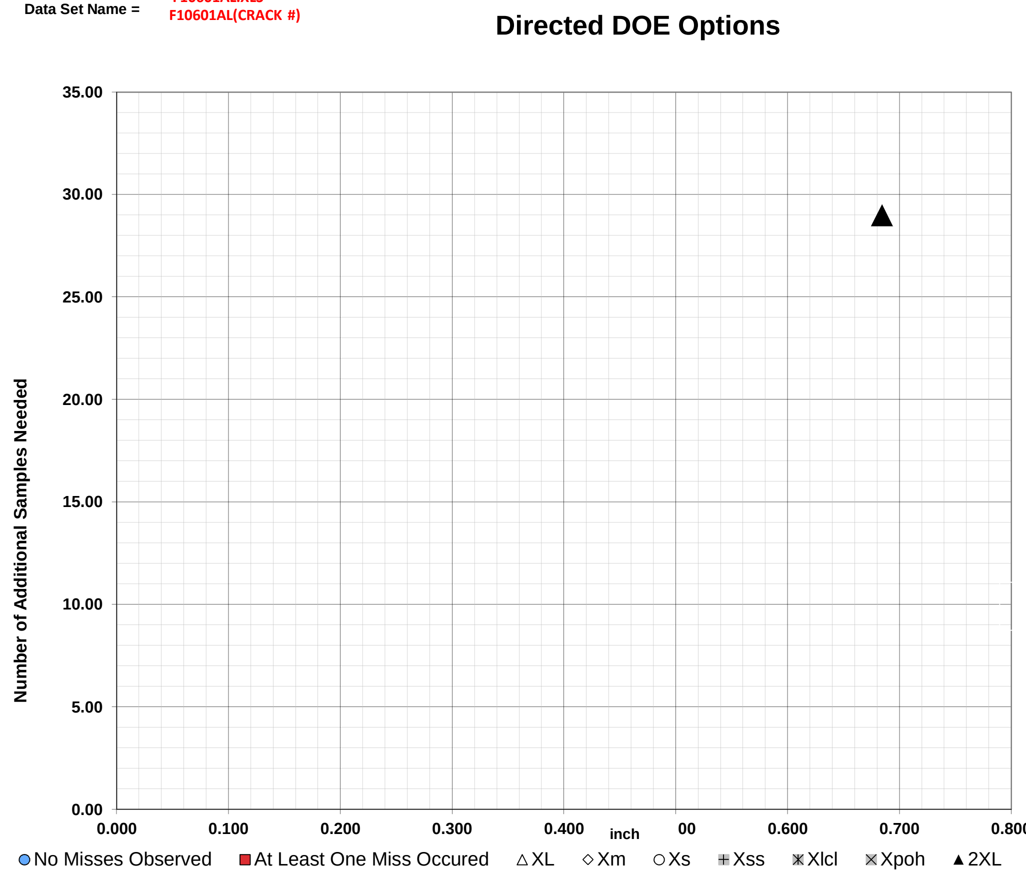


TABLE C

	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

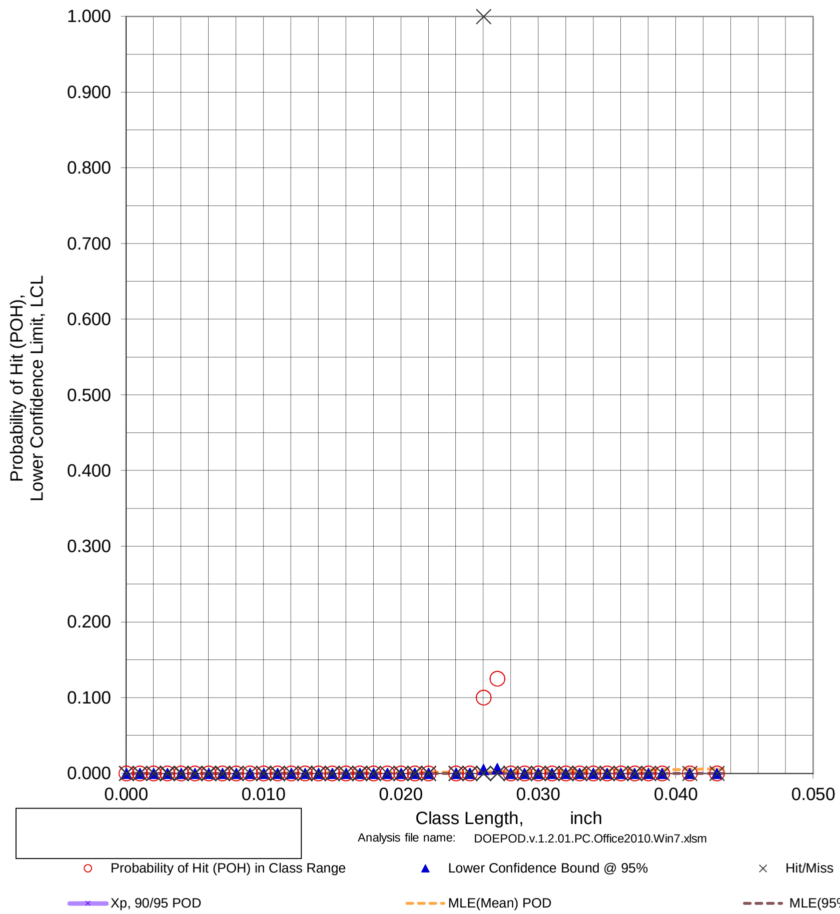
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F10601BD.XLS
Data Set Name = F10601BD(CRACK #)
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

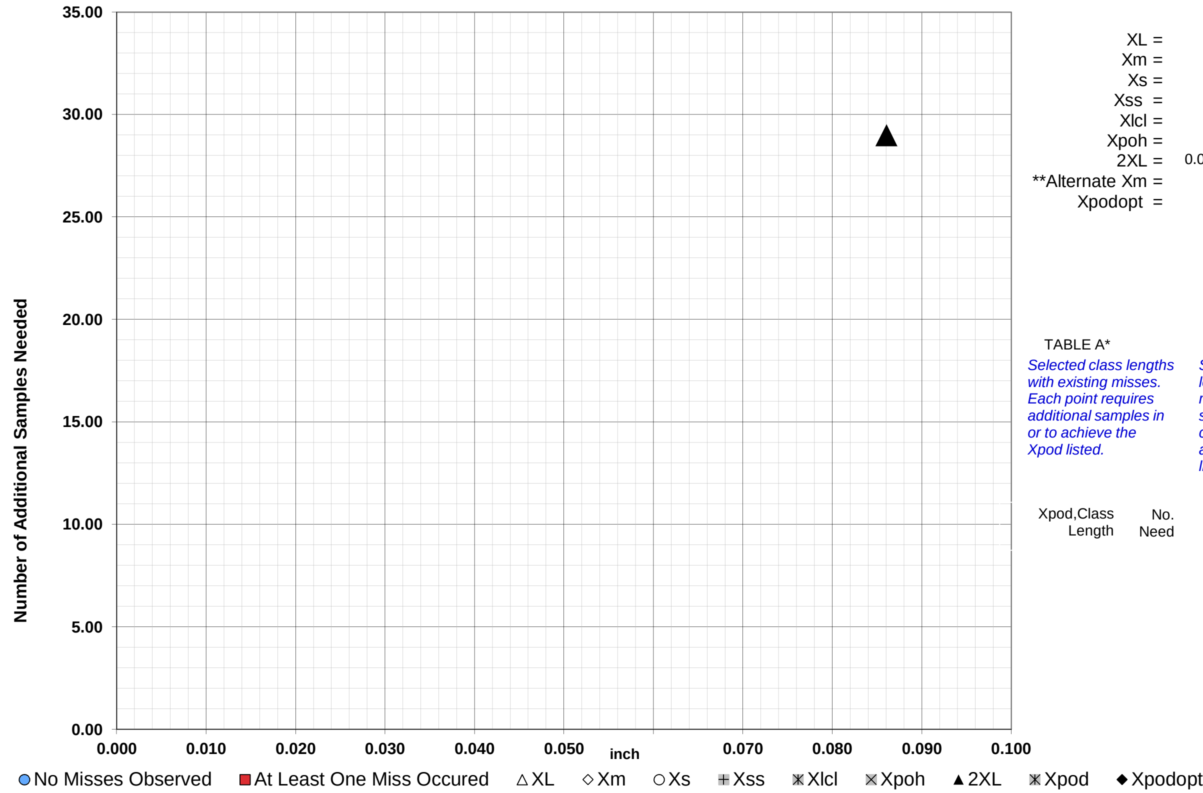


TABLE C

	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

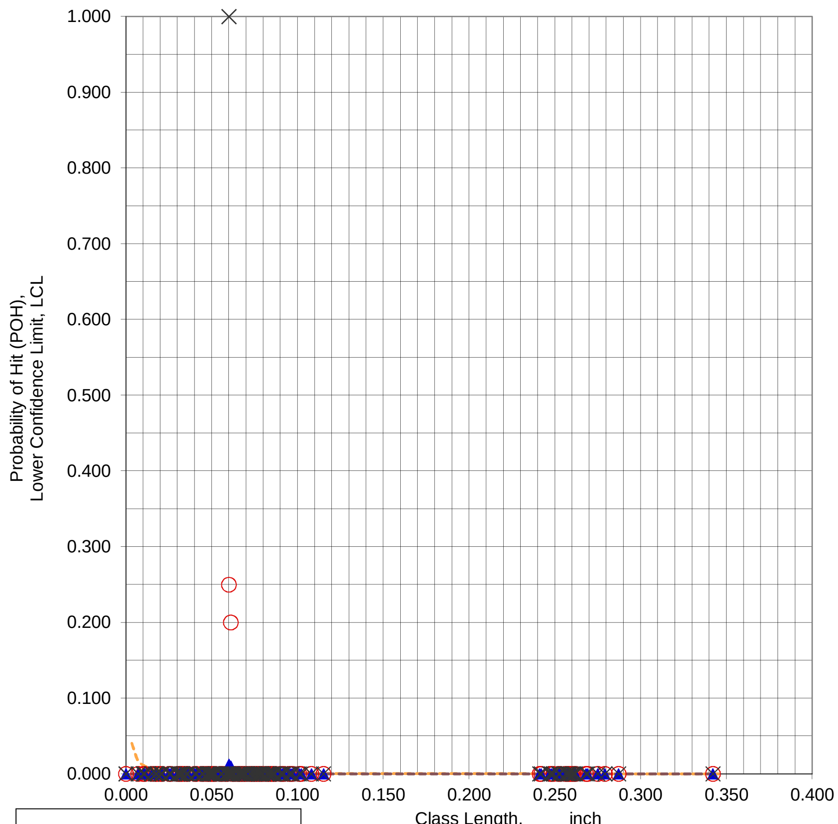
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F10601BL.XLS
Data Set Name = F10601BL(CRACK #)
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 =



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

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

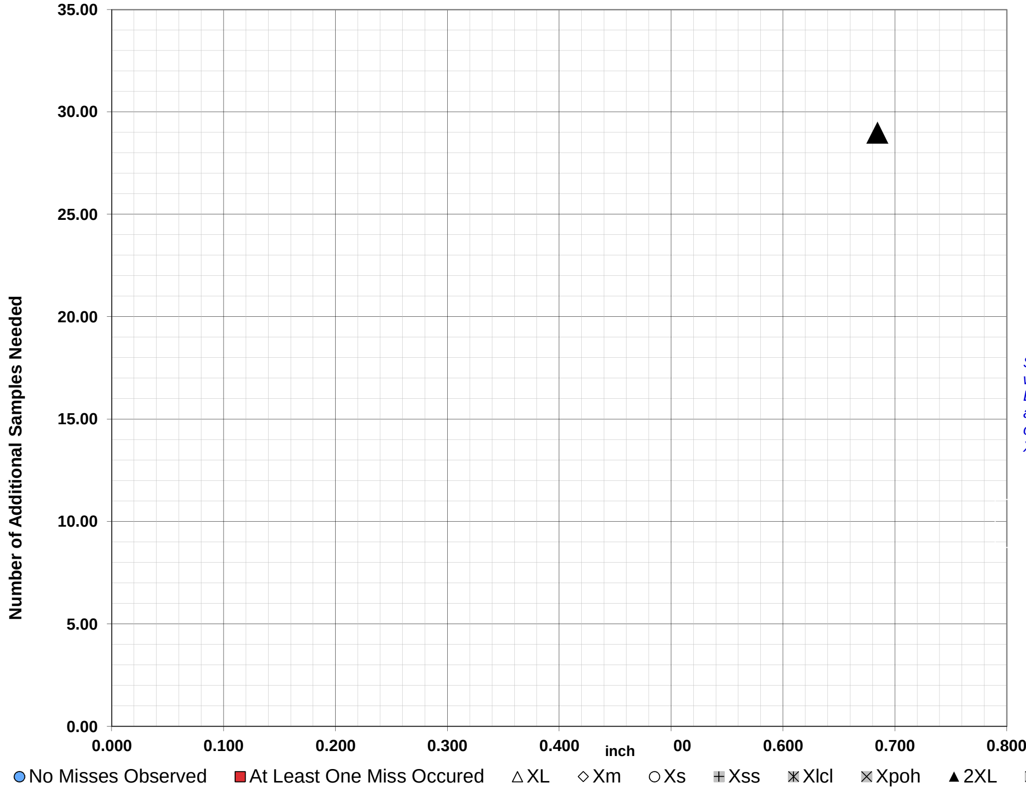


TABLE C

	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

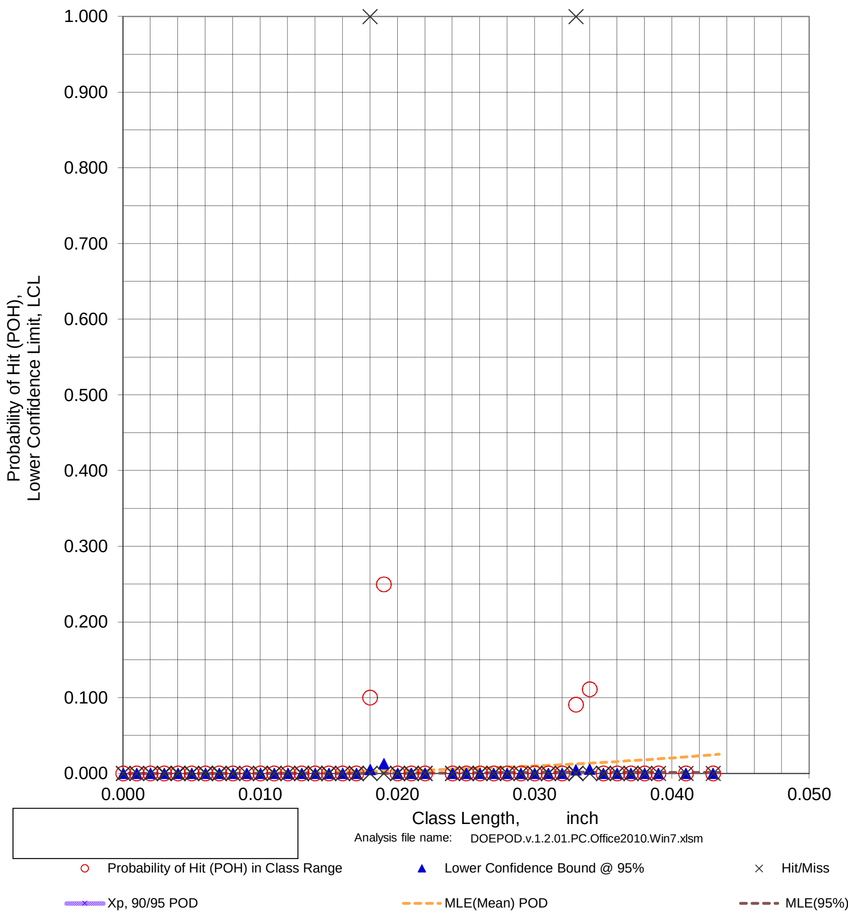
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

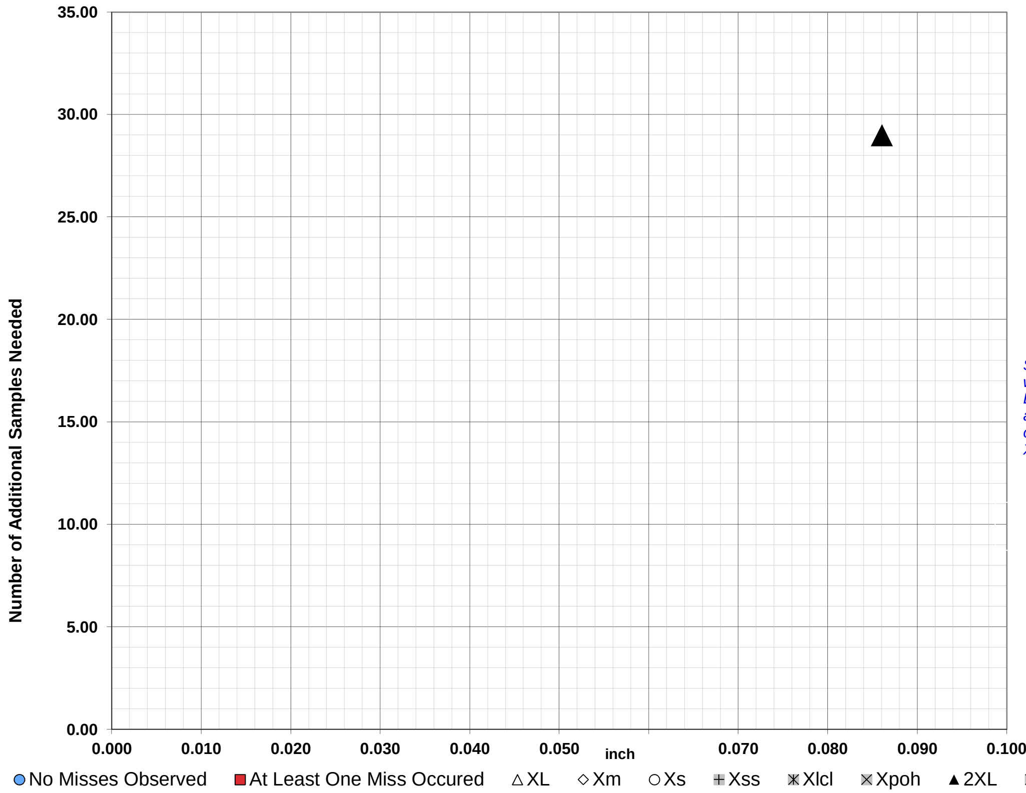


TABLE C

	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

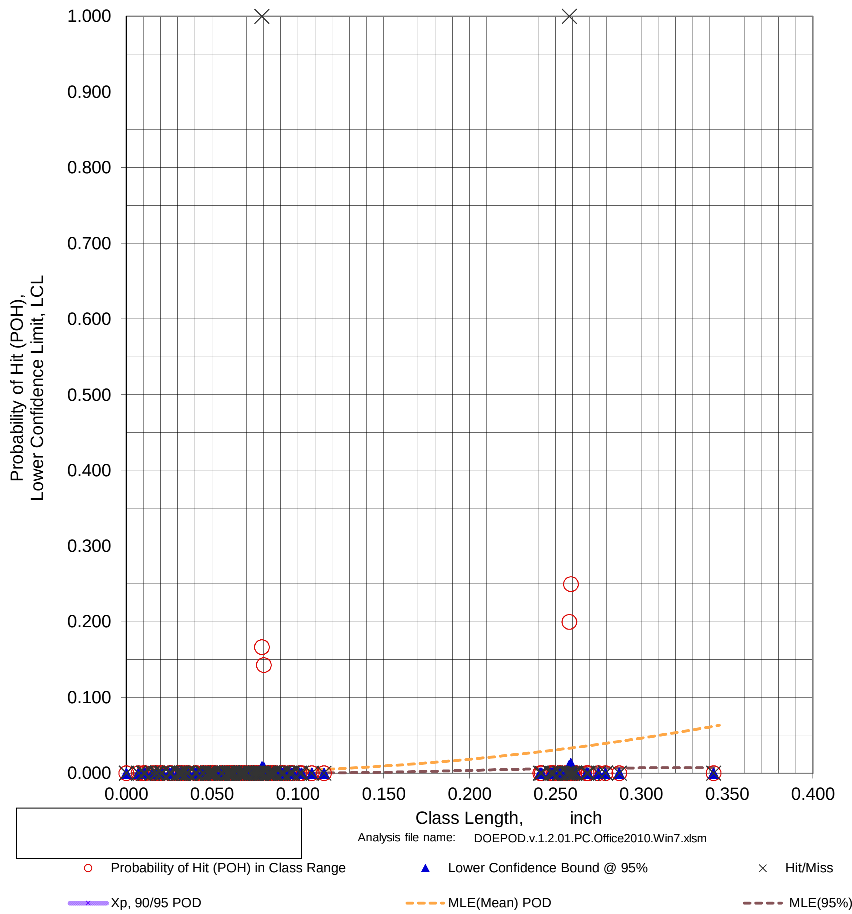
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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 #)

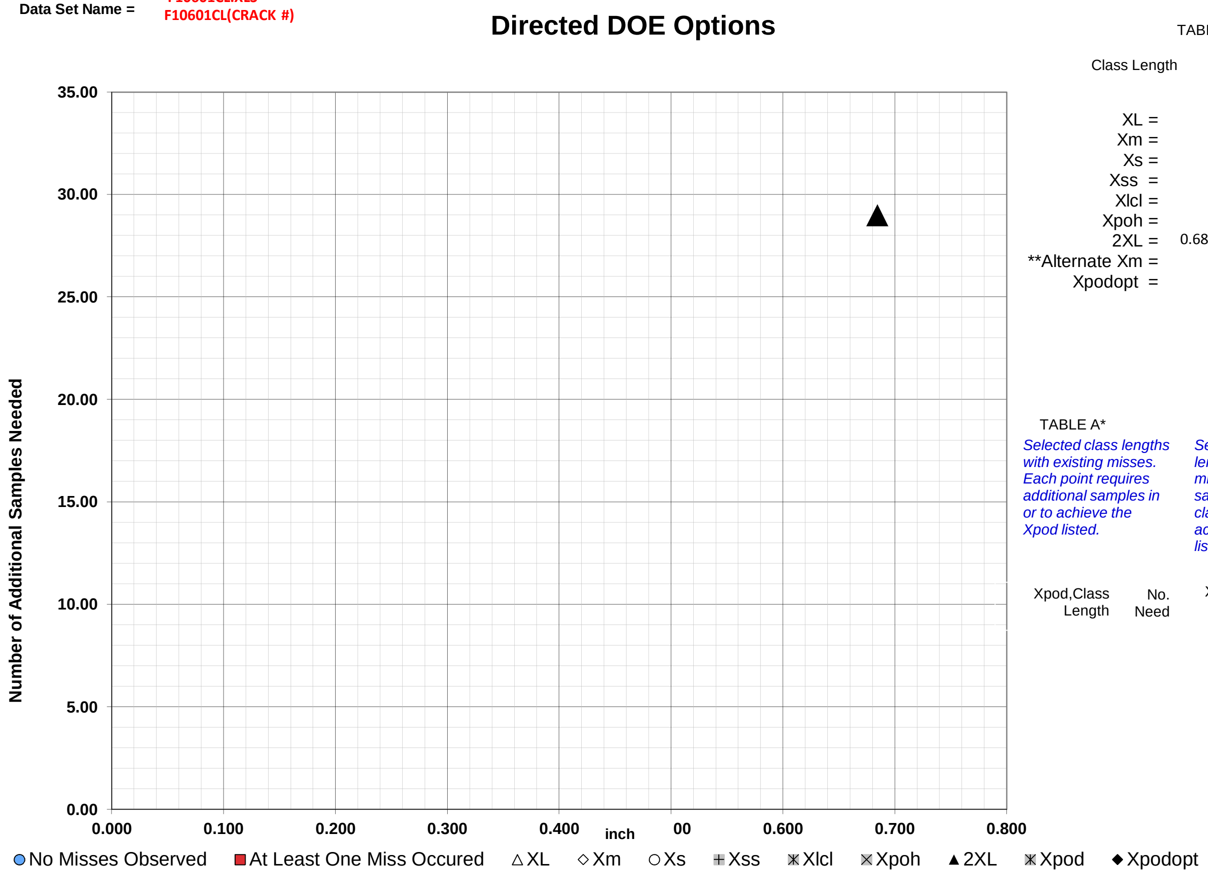


TABLE C

	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

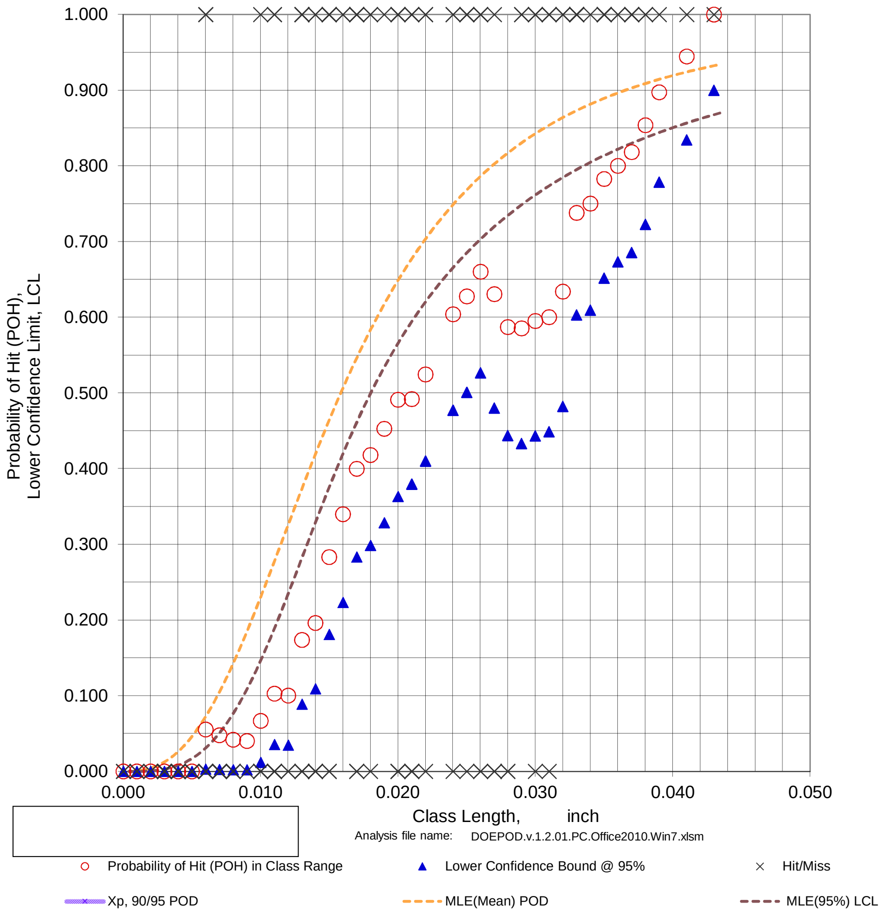
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

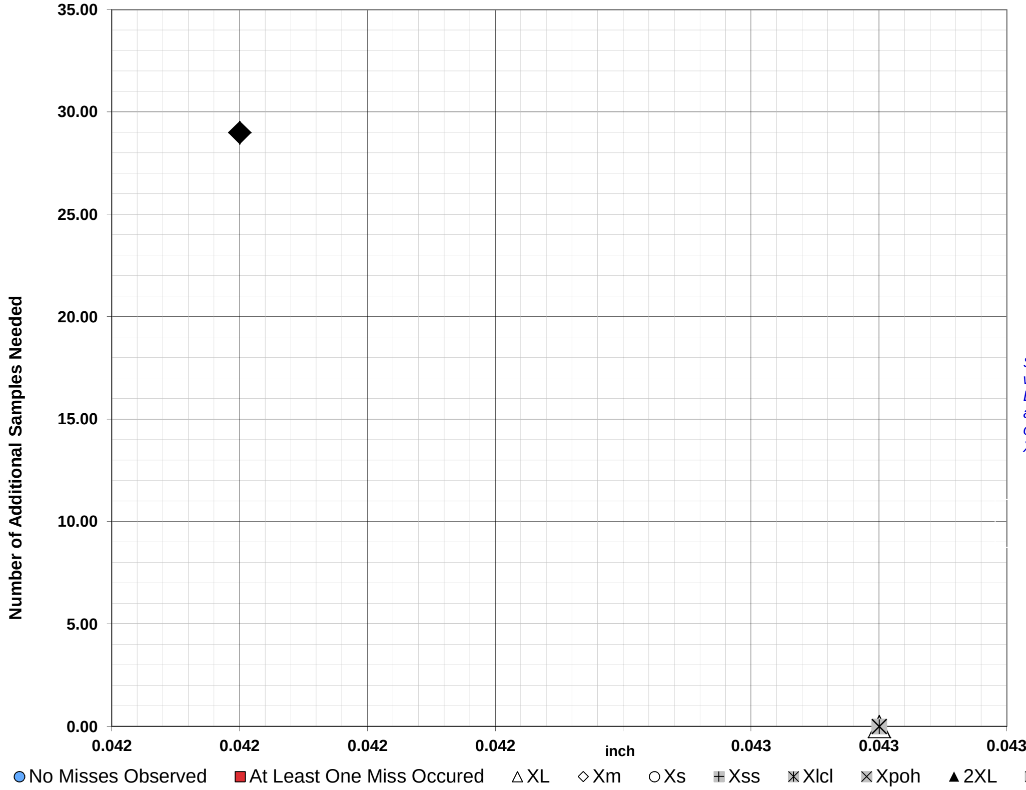


TABLE C

	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*

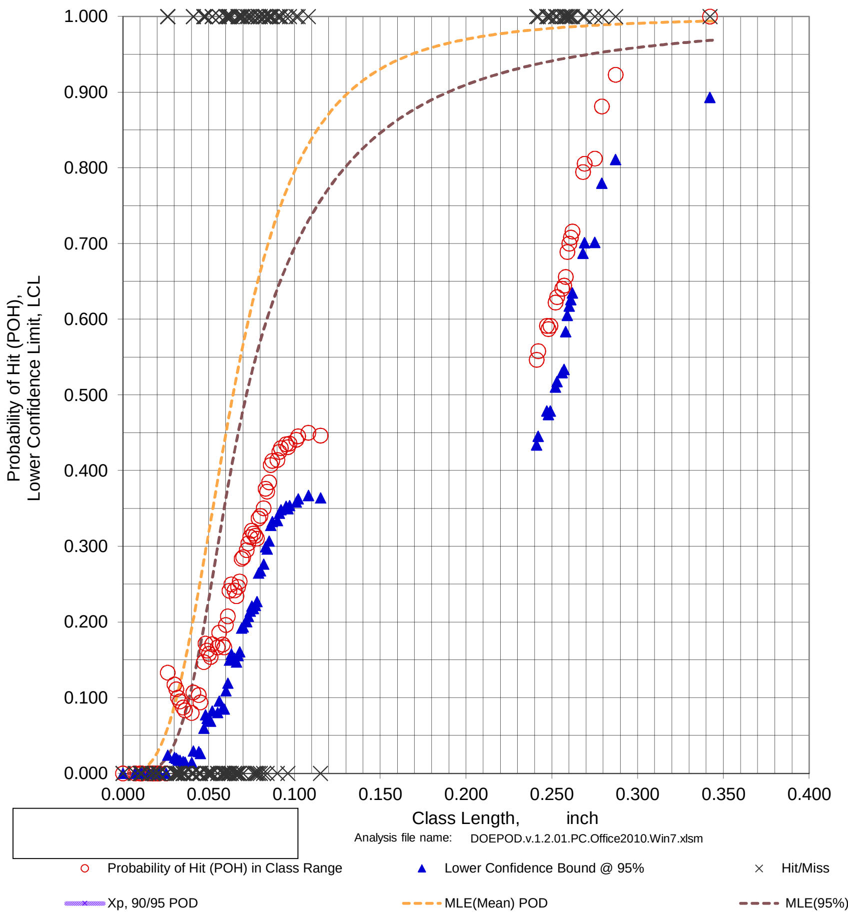
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

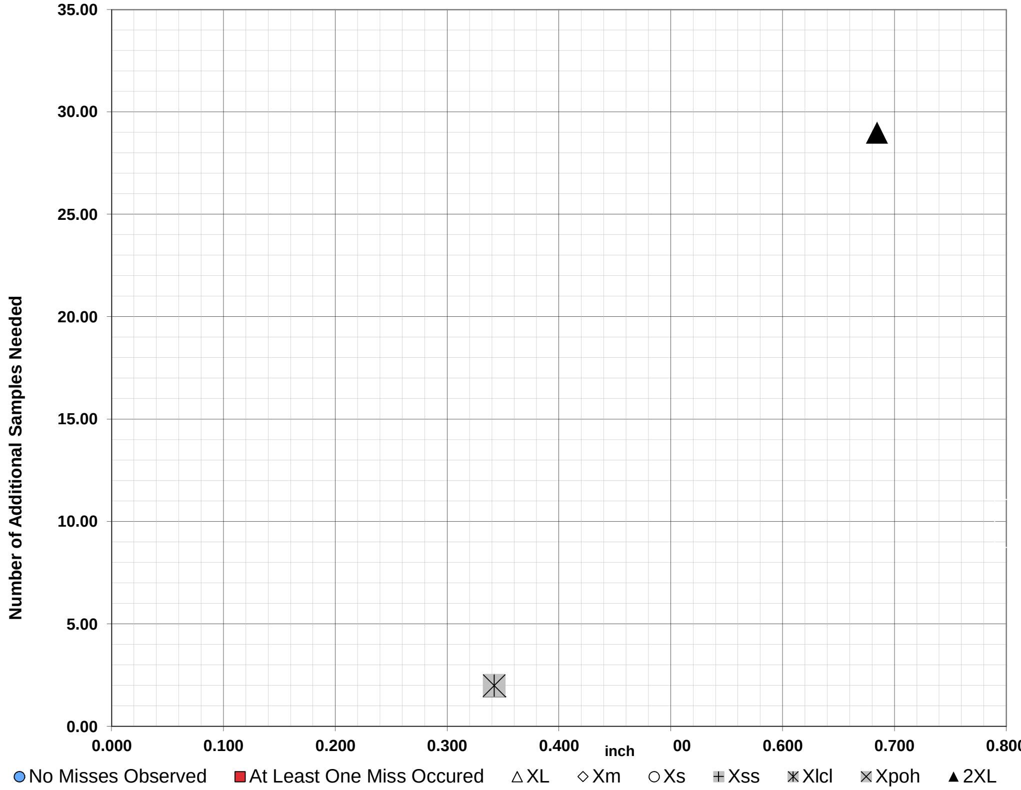


TABLE C

	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*

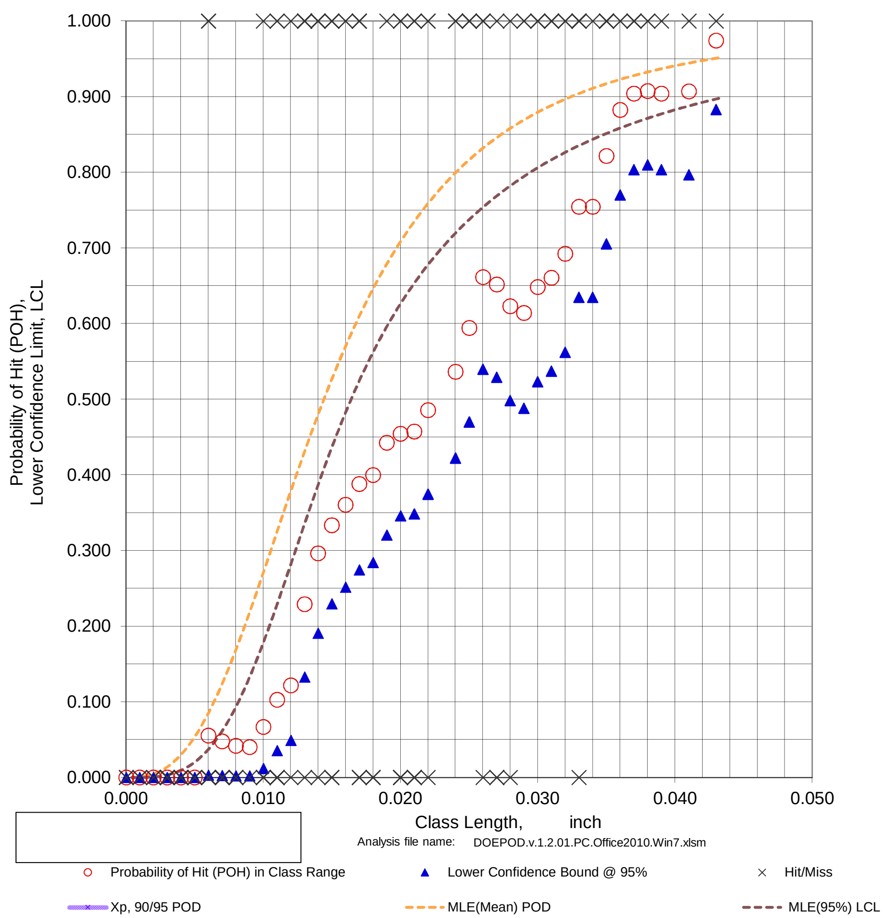
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

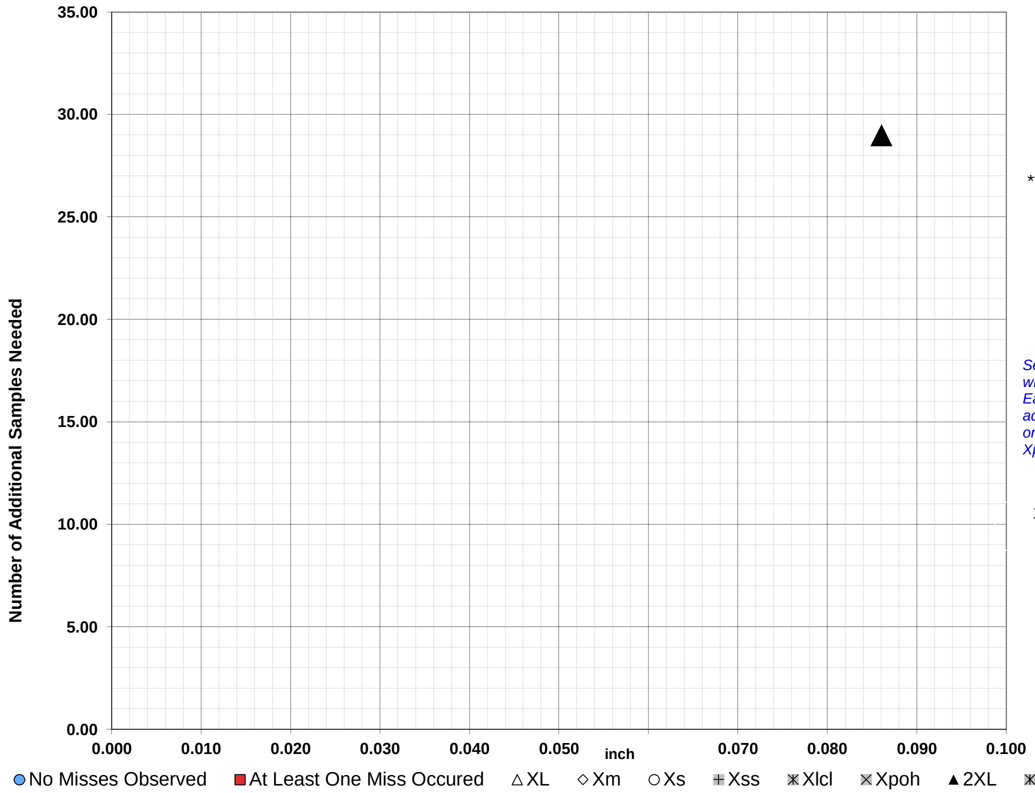


TABLE C

	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

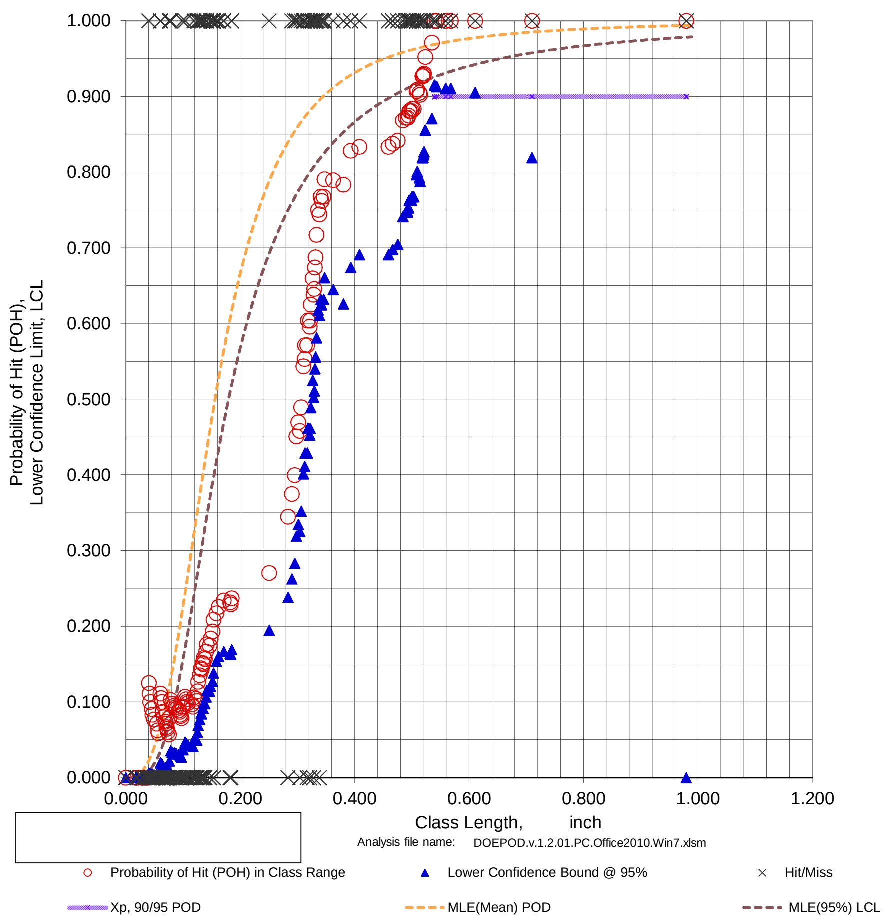
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

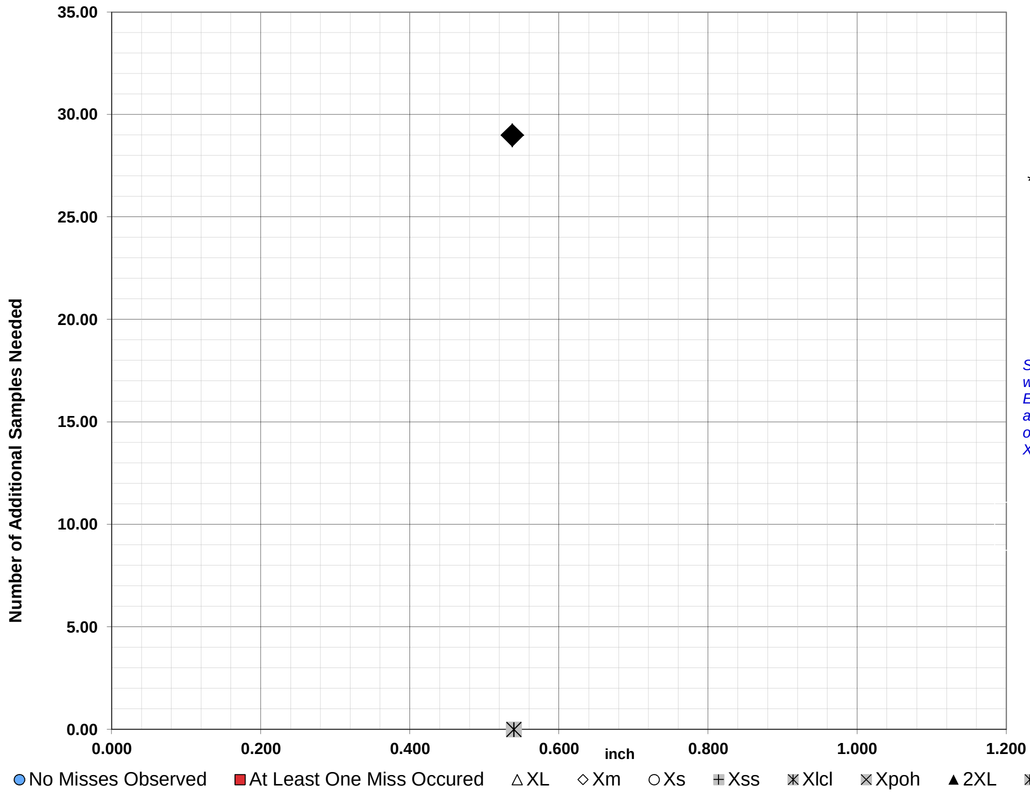


TABLE C

	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

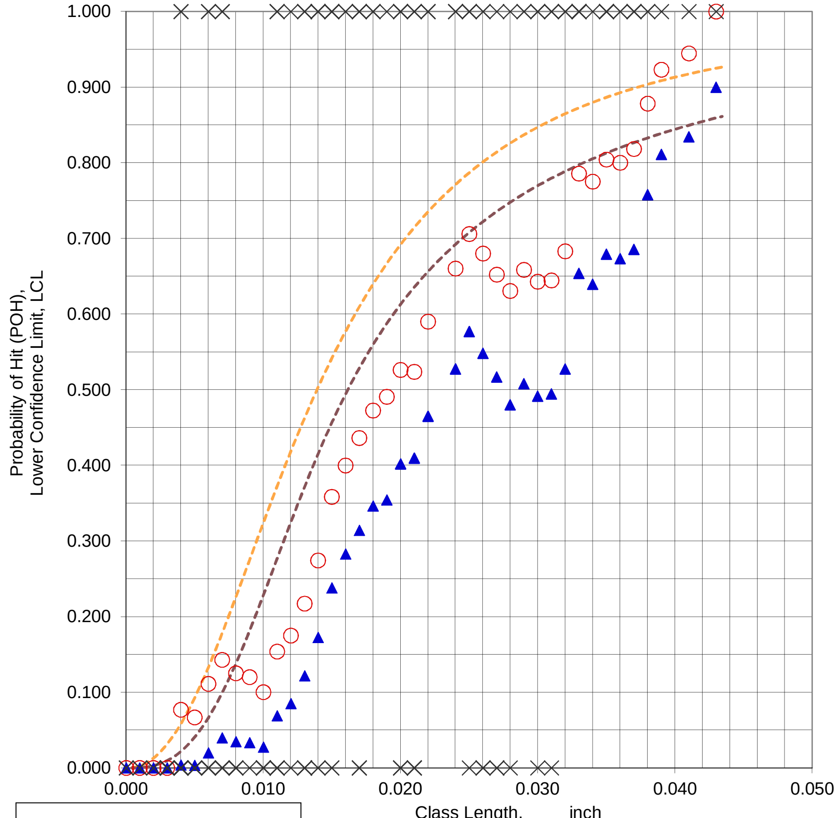
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 =	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

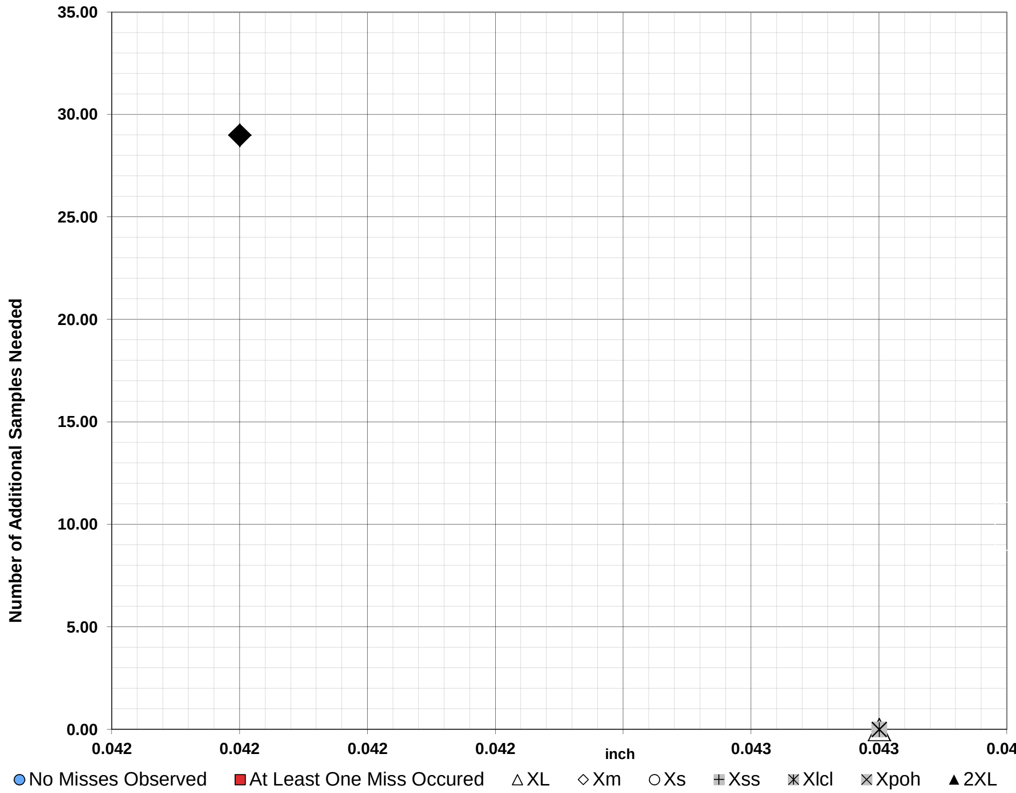


TABLE C

	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*

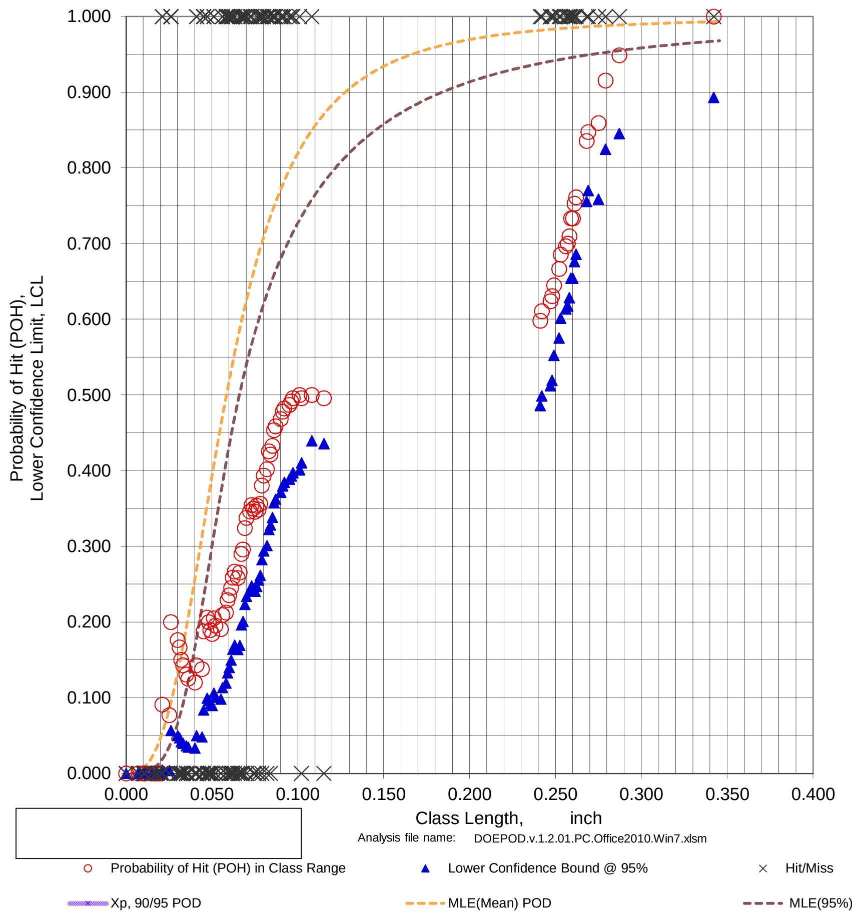
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

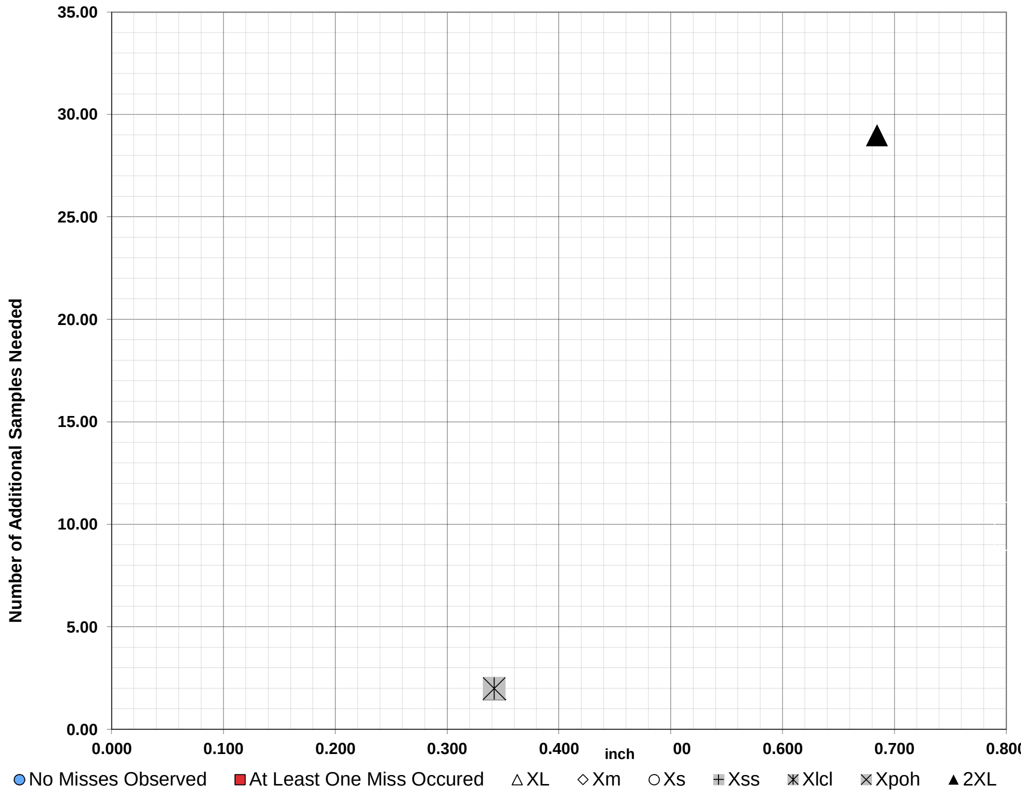


TABLE C

	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*

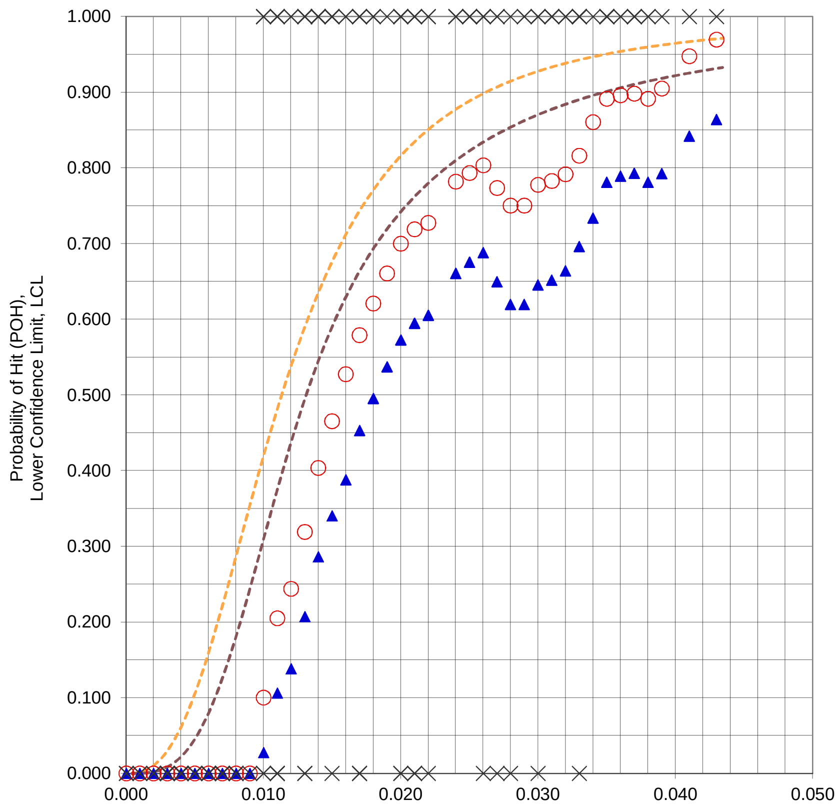
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

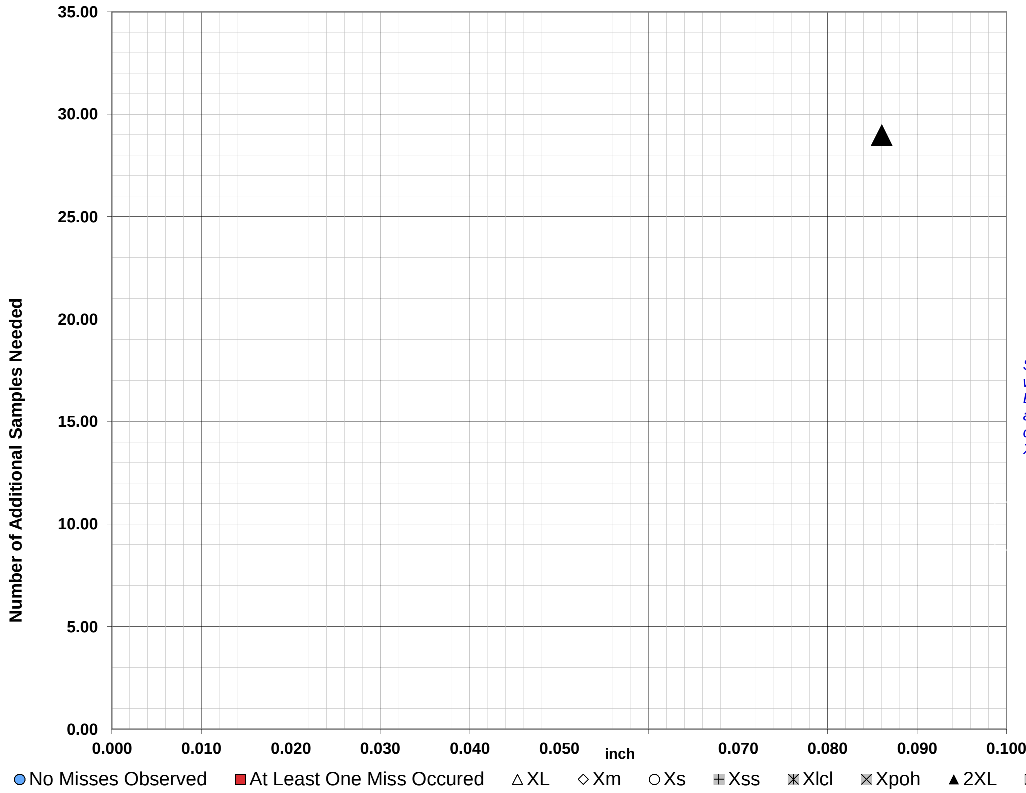


TABLE C

	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*

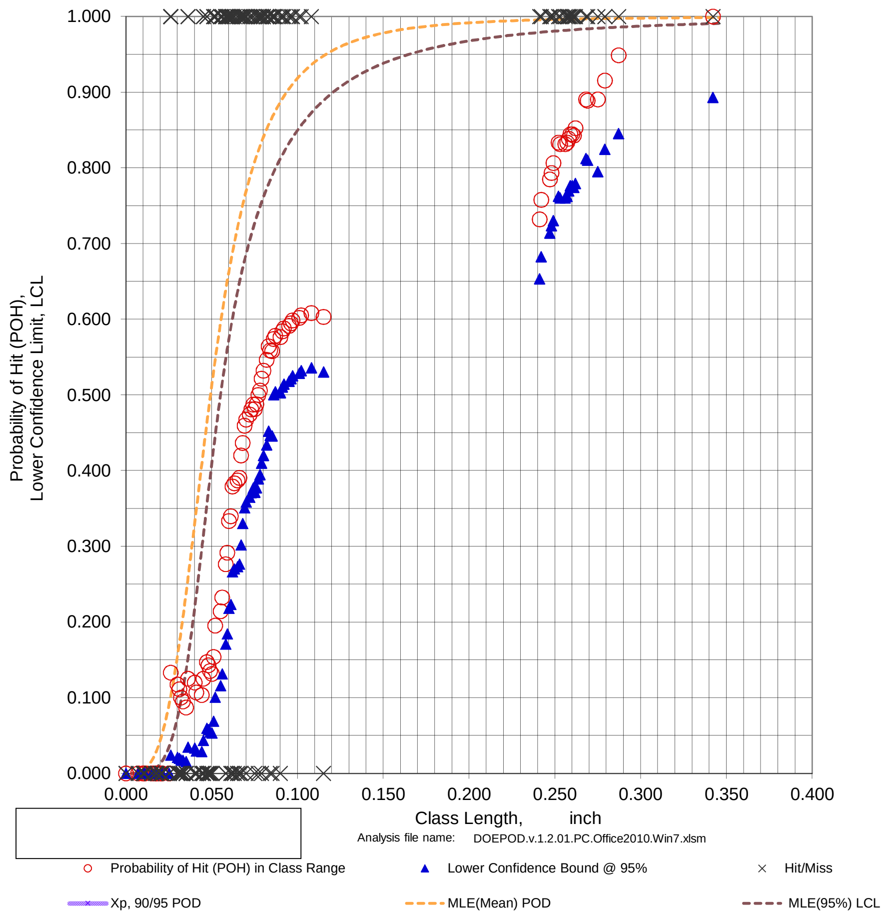
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

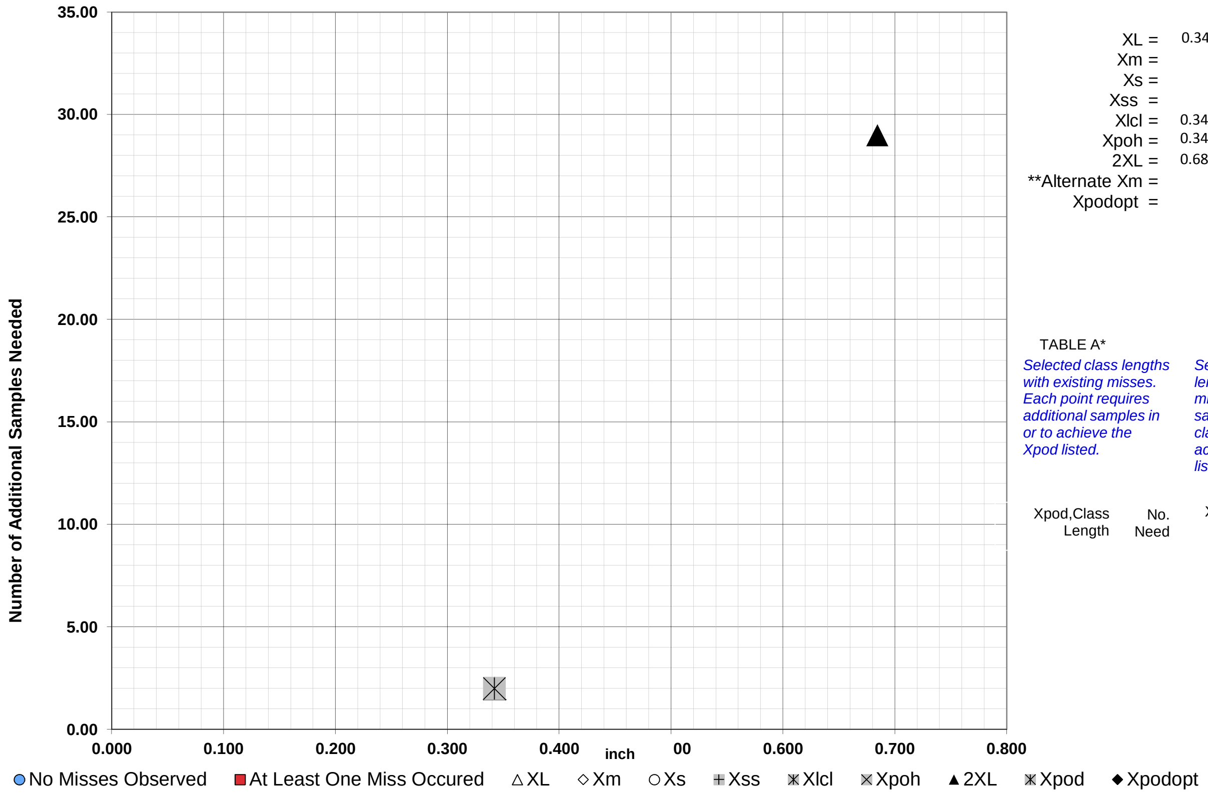


TABLE C

	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

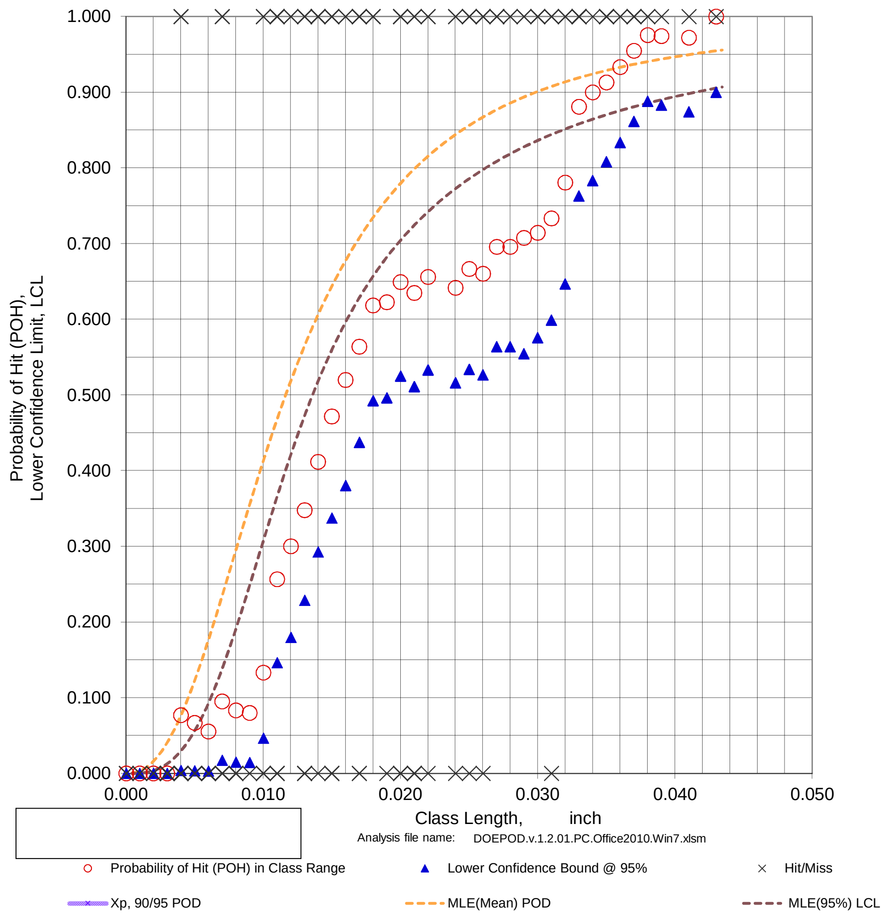
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

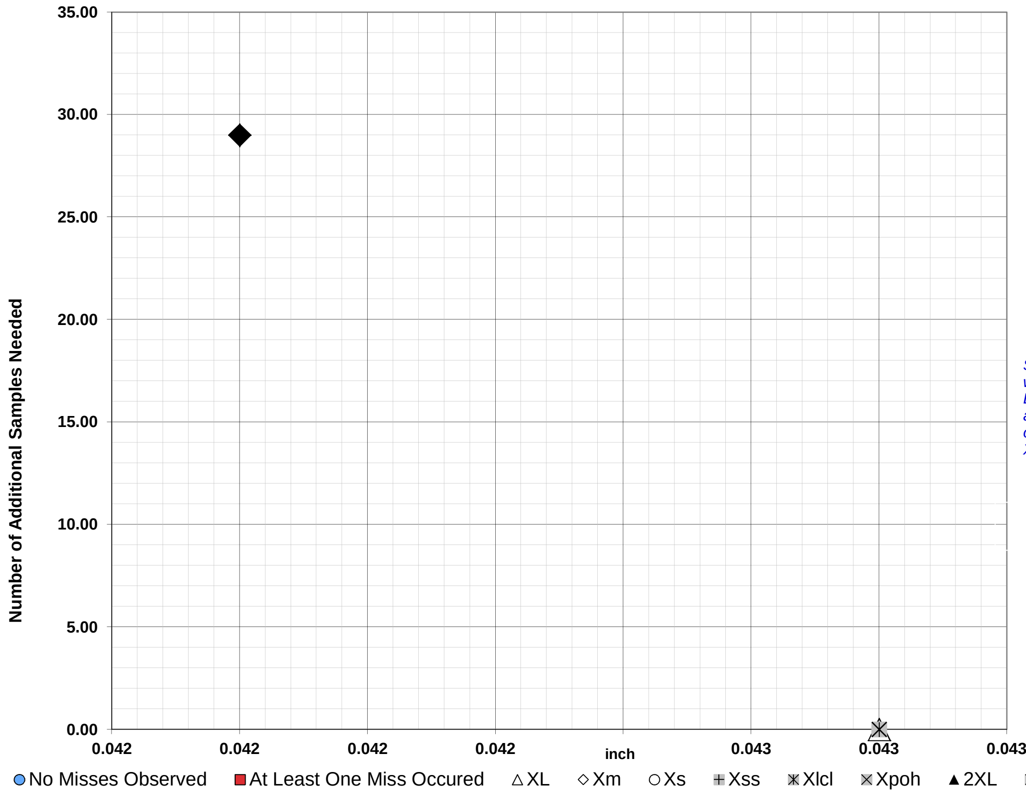


TABLE C

	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.

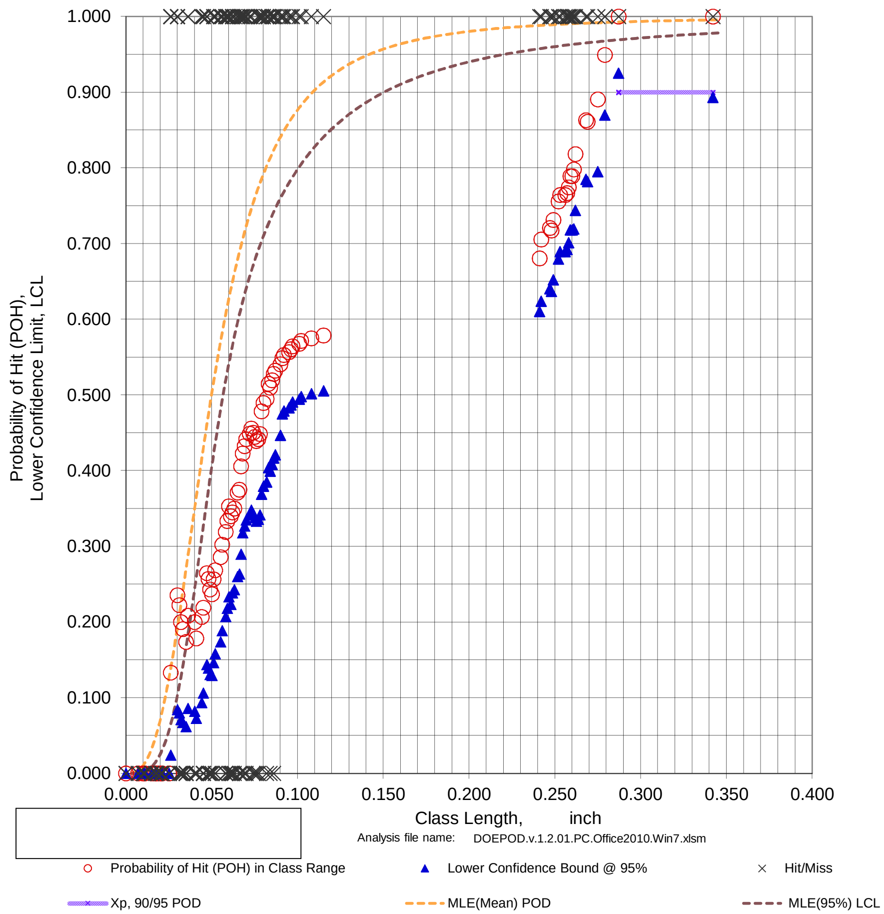
Xpod,Class Length	No. Need

* 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

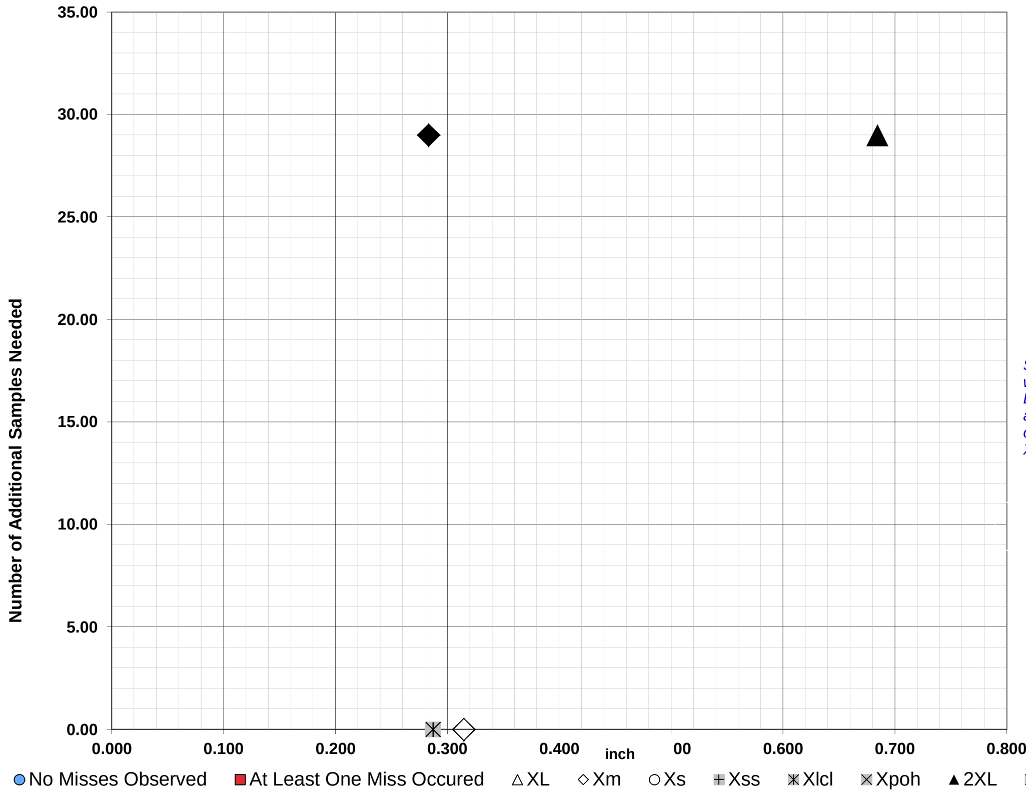


TABLE C

	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

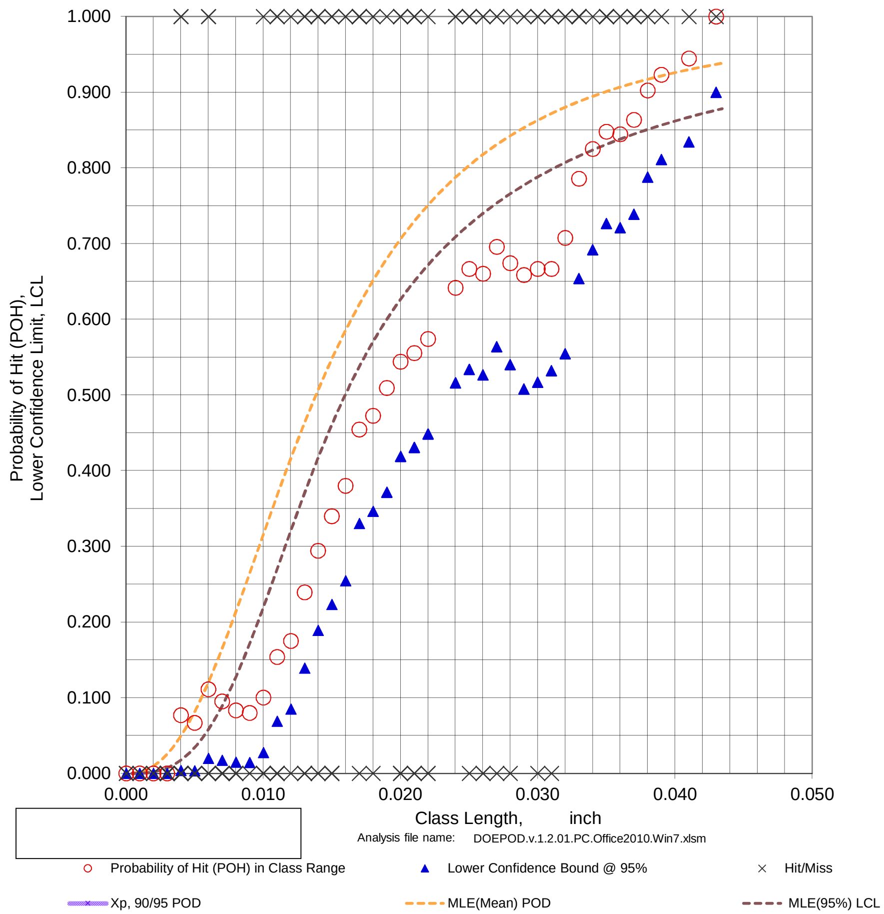
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

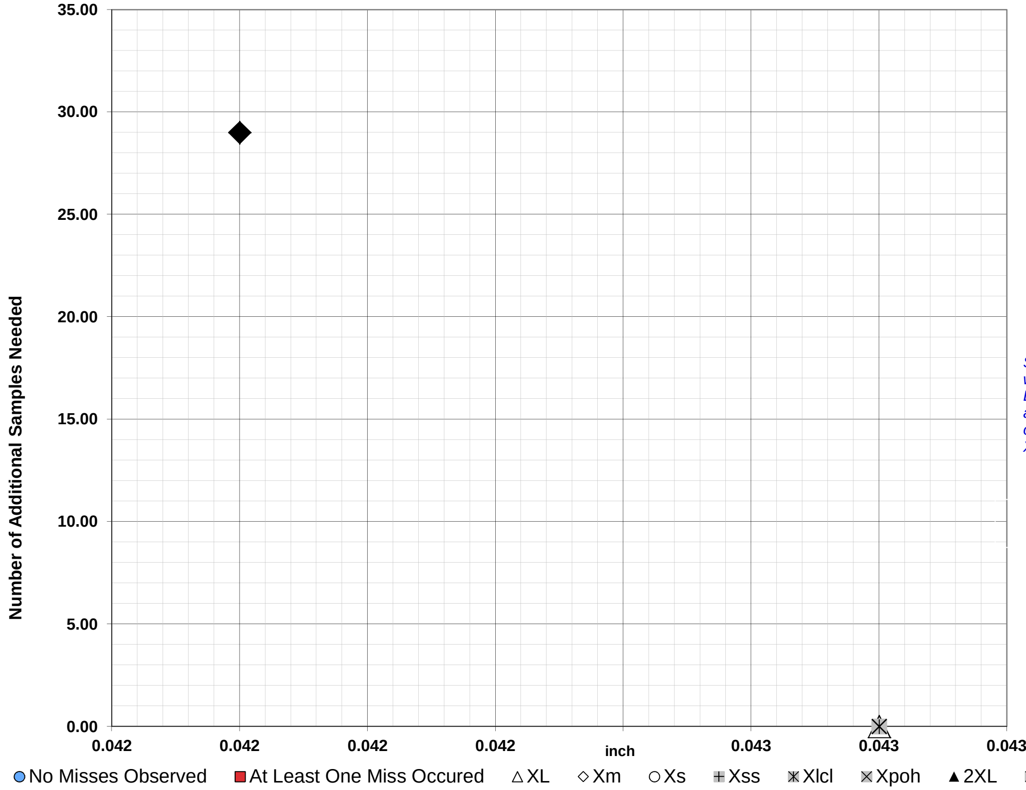


TABLE C

	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*

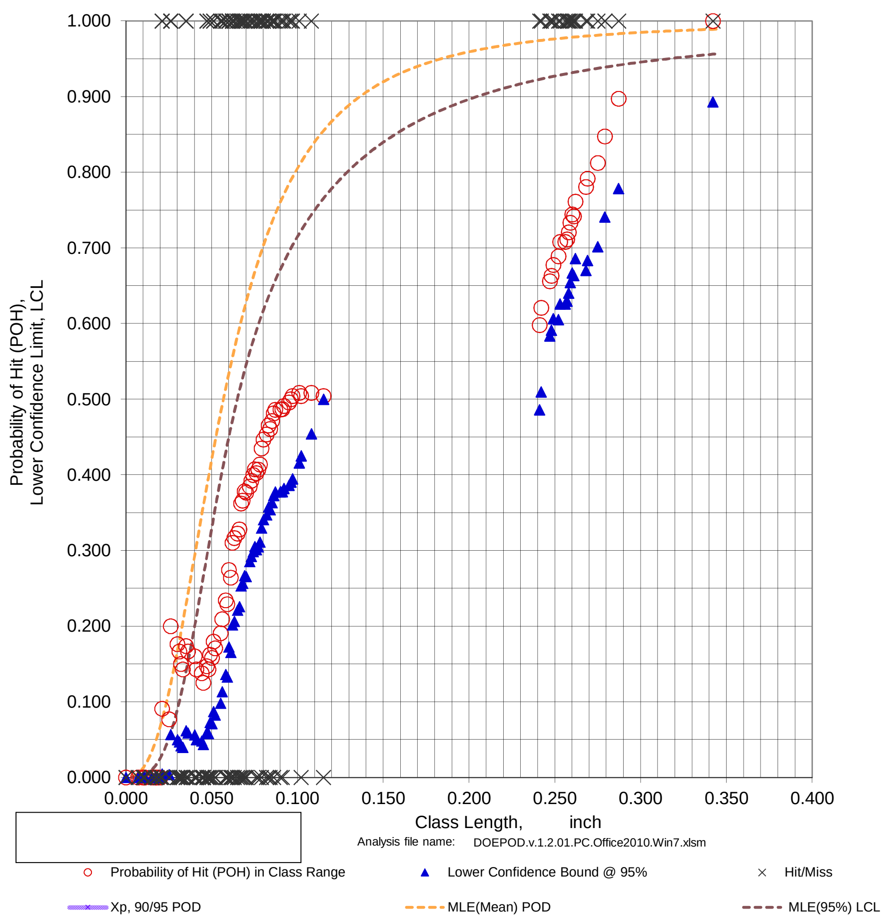
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

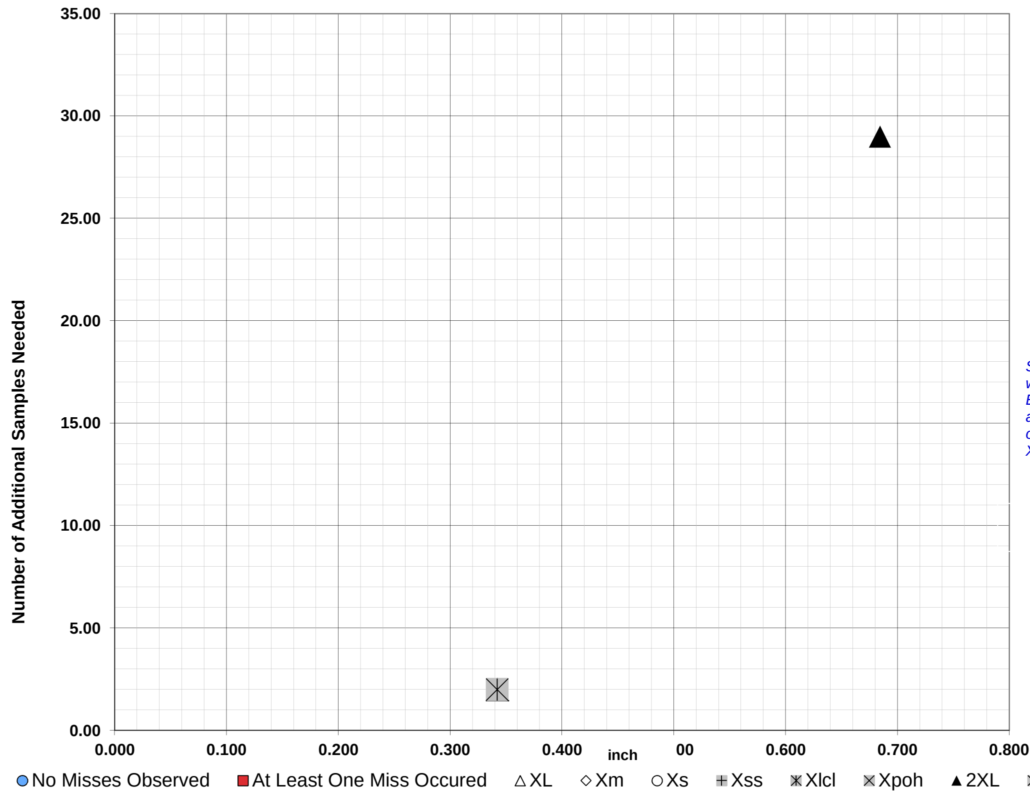


TABLE C

	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.

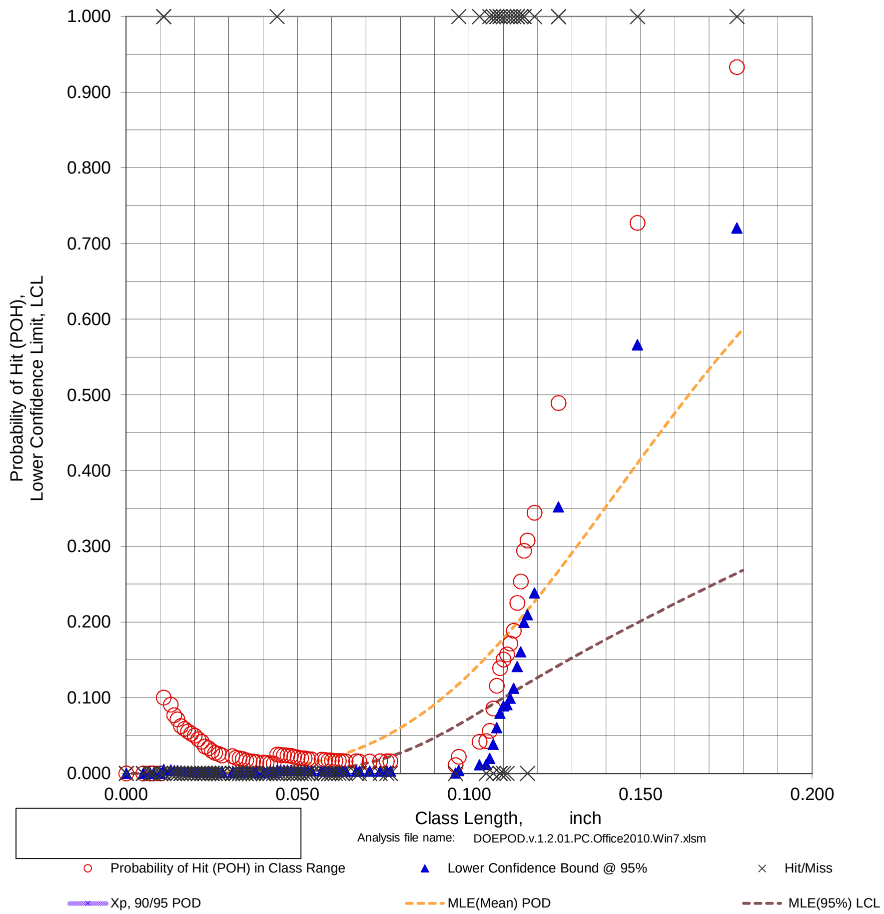
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



File Name = F12201AD.XLS
Data Set Name = F12201AD(CRACK #)
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

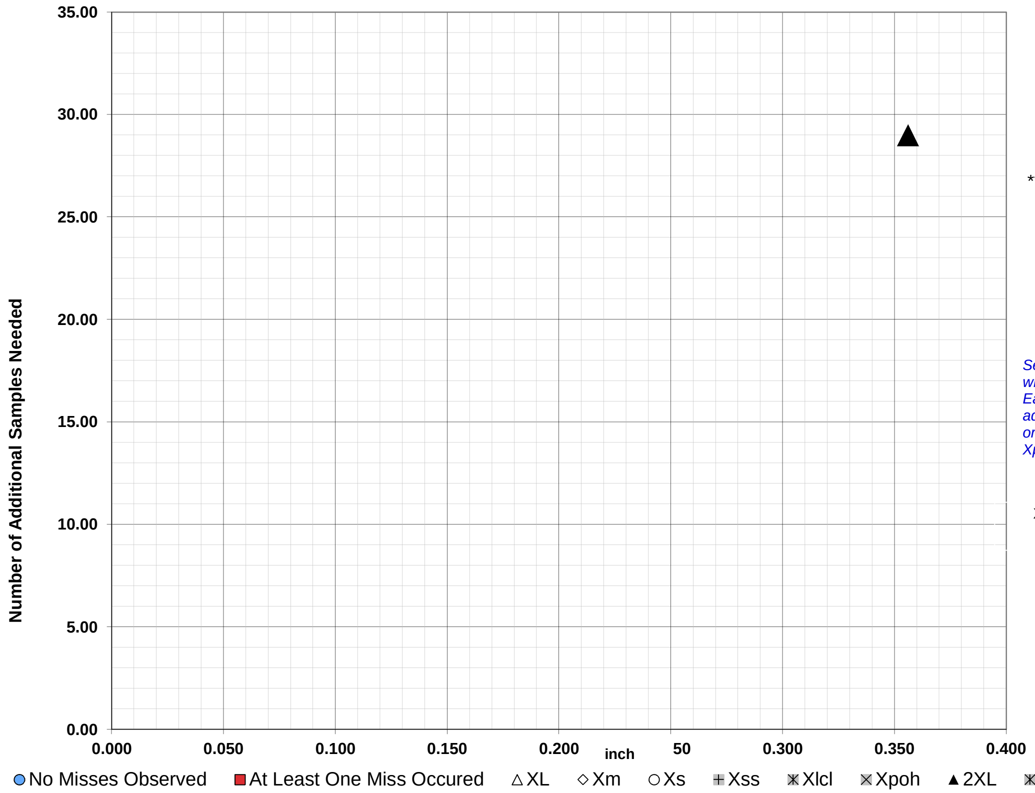


TABLE C

	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

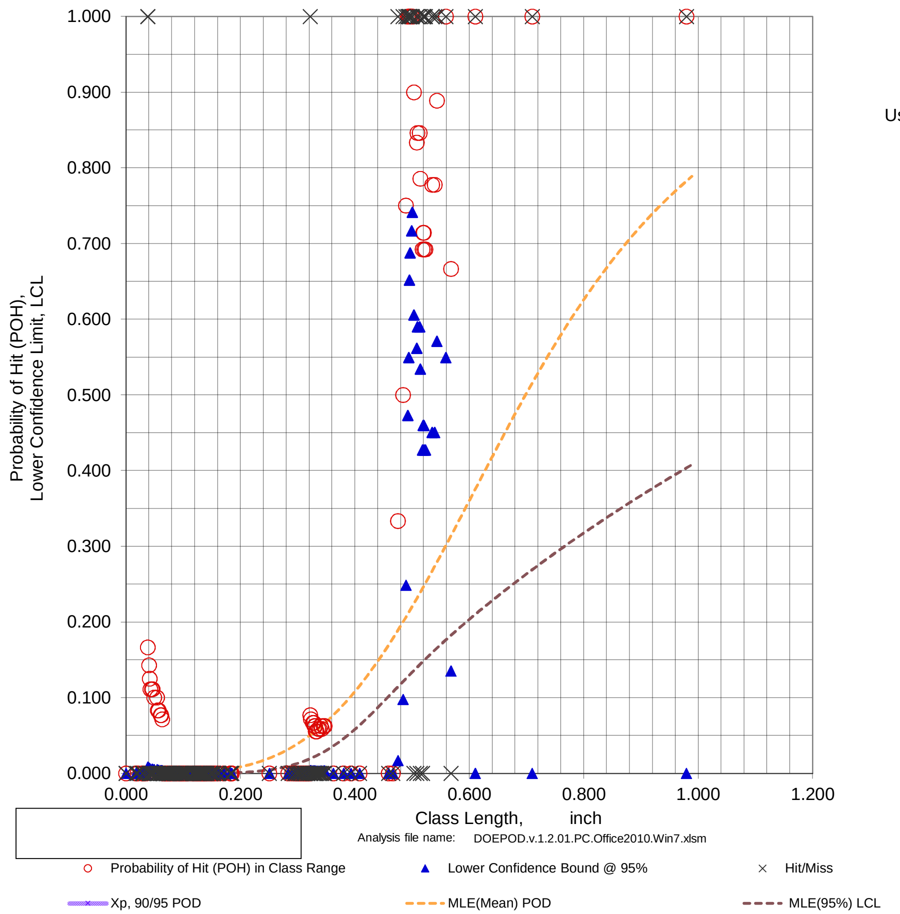
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F12201AL.XLS
Data Set Name = F12201AL(CRACK #)
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

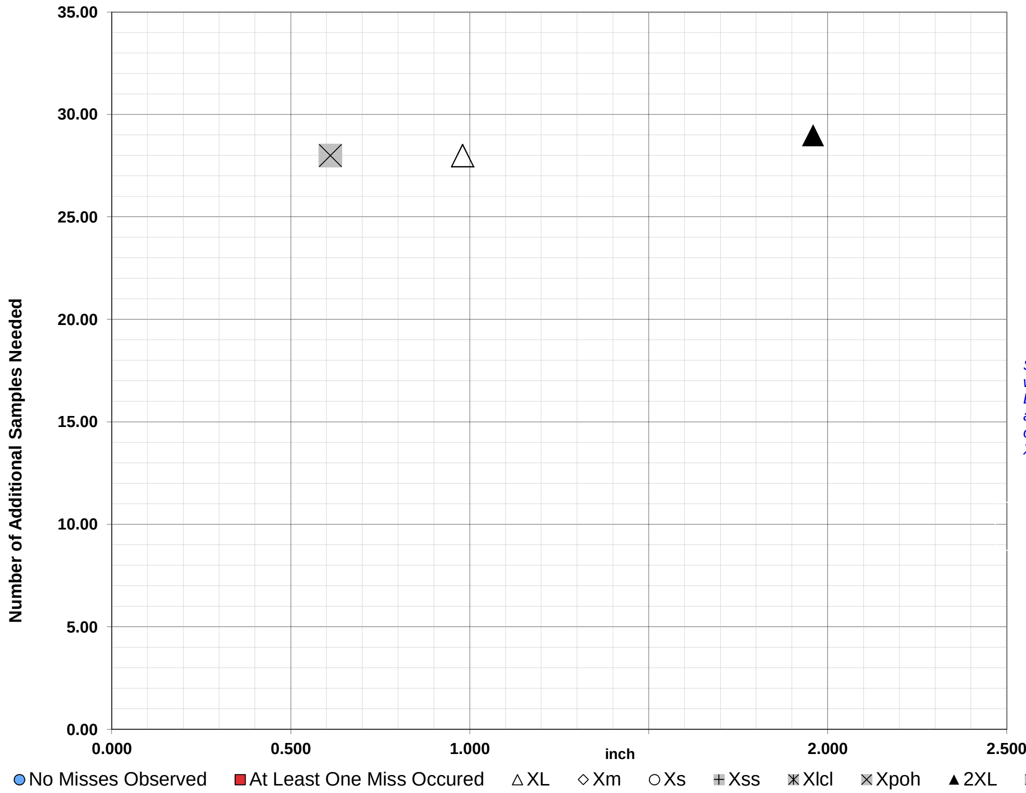


TABLE C

	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*

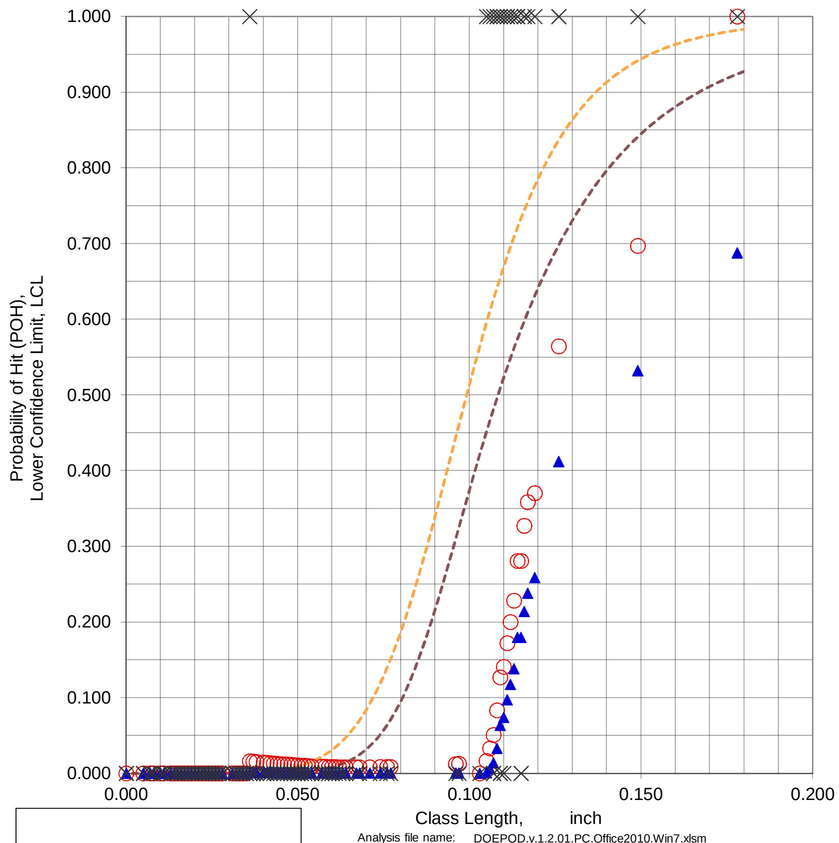
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = **F12201BD.XLS**
Data Set Name = **F12201BD(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

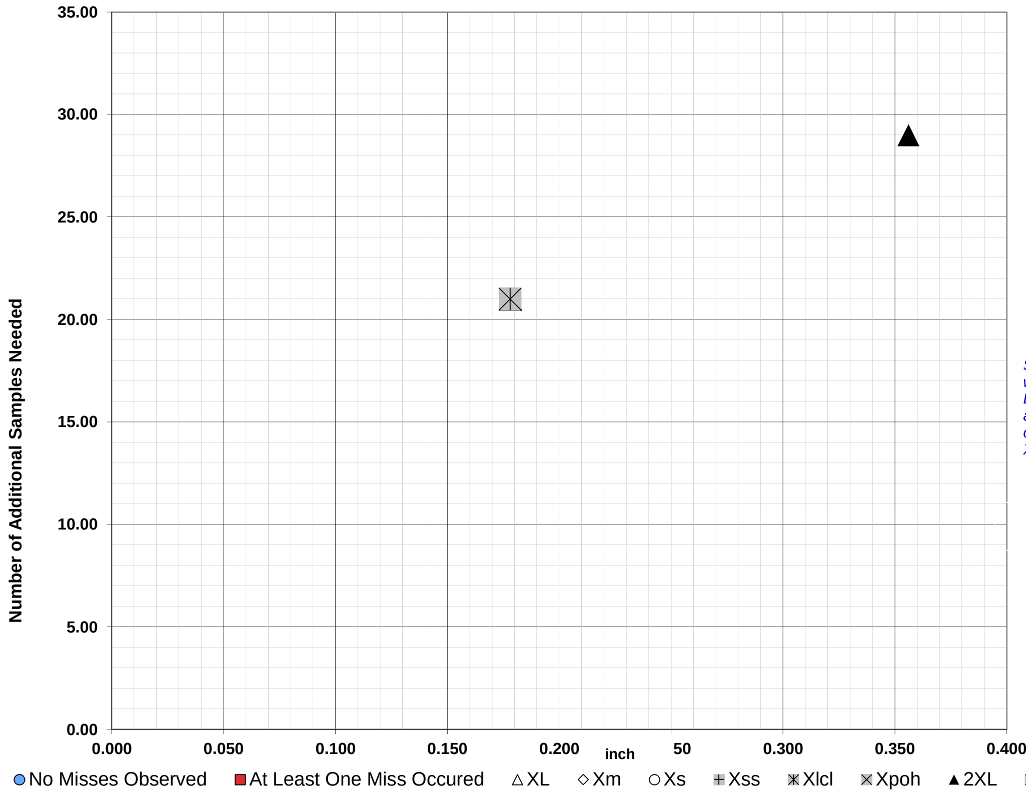


TABLE C

	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*

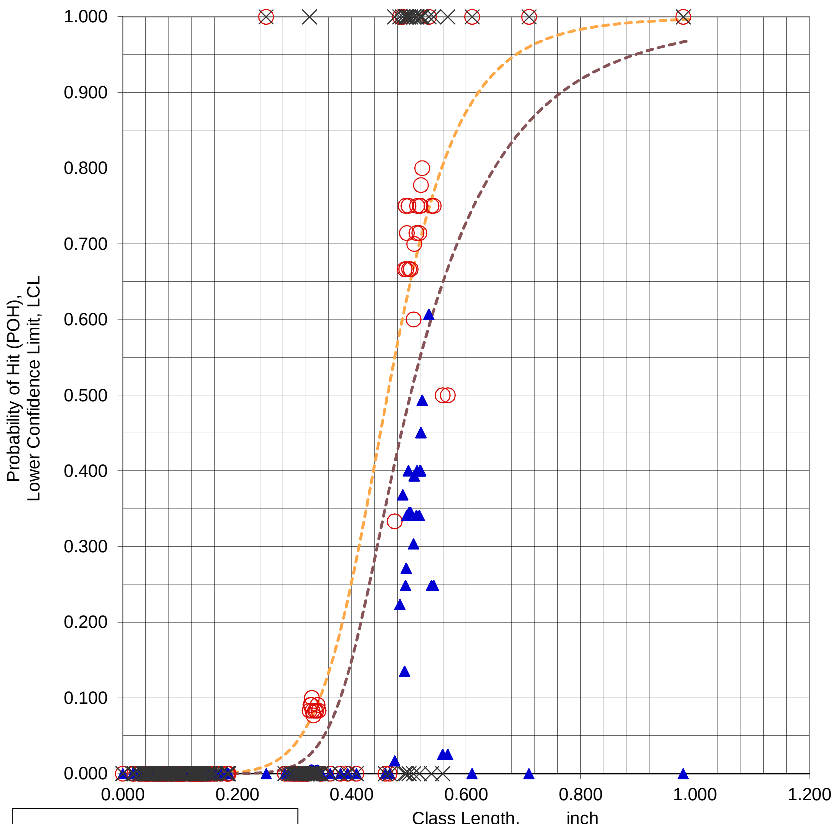
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

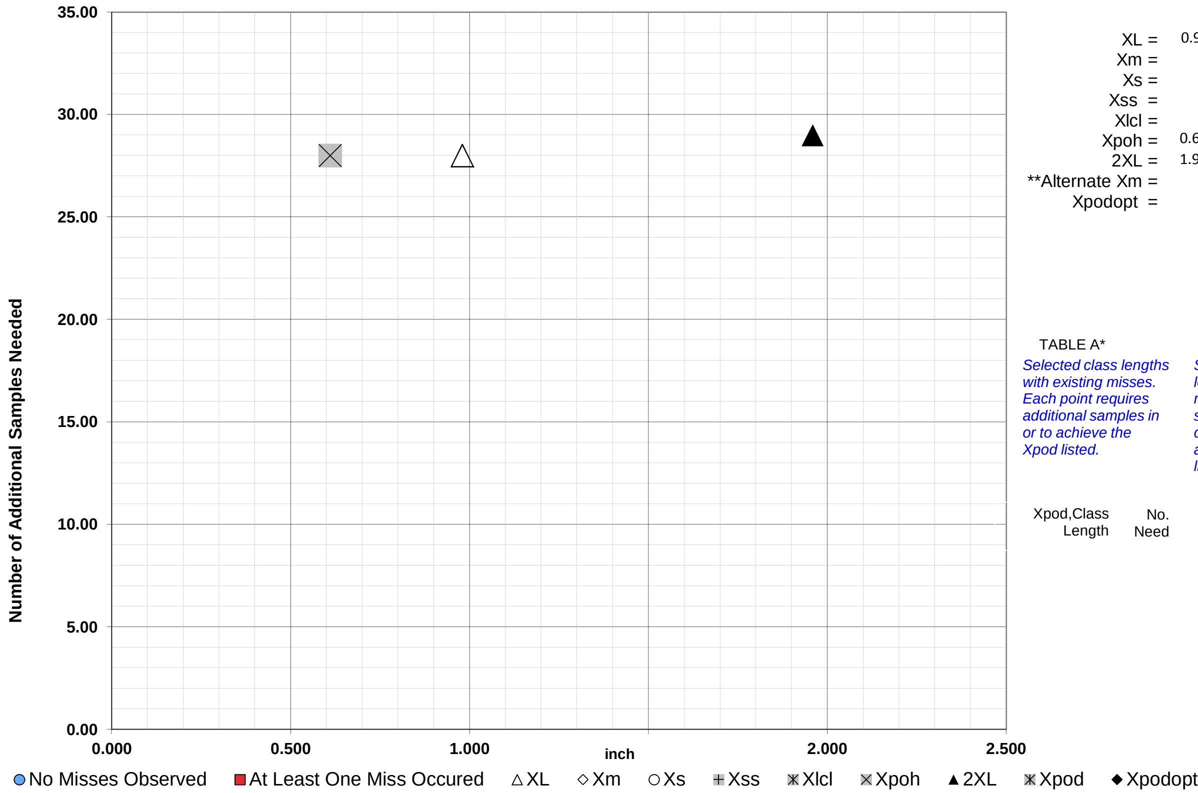


TABLE C

	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*

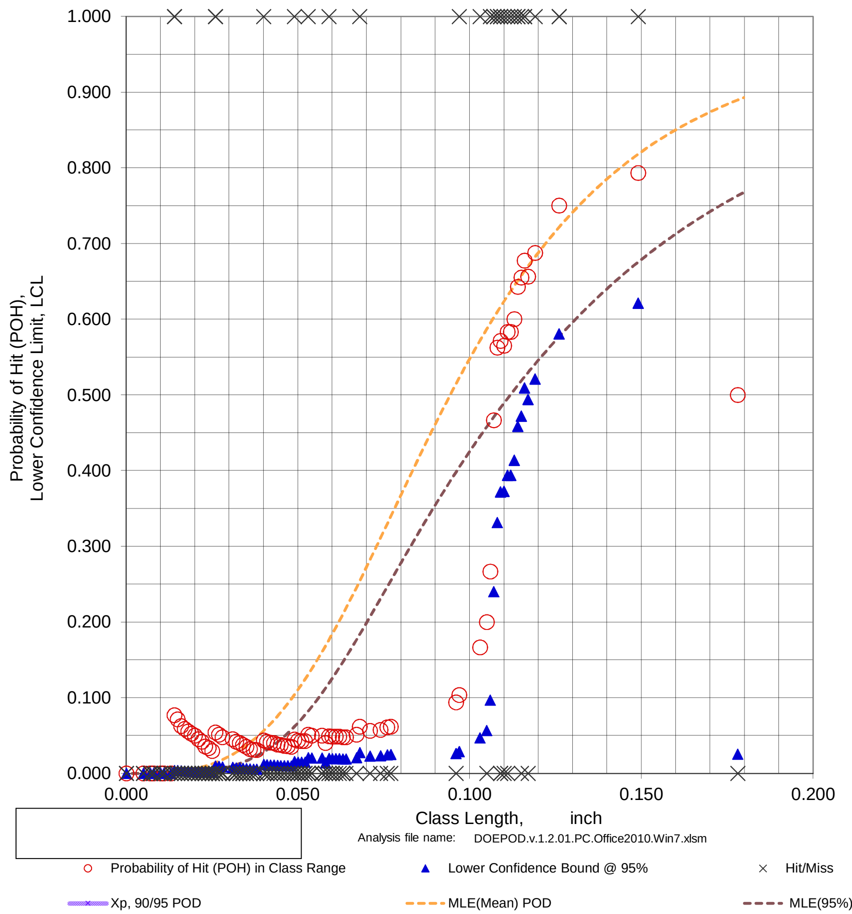
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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 #)

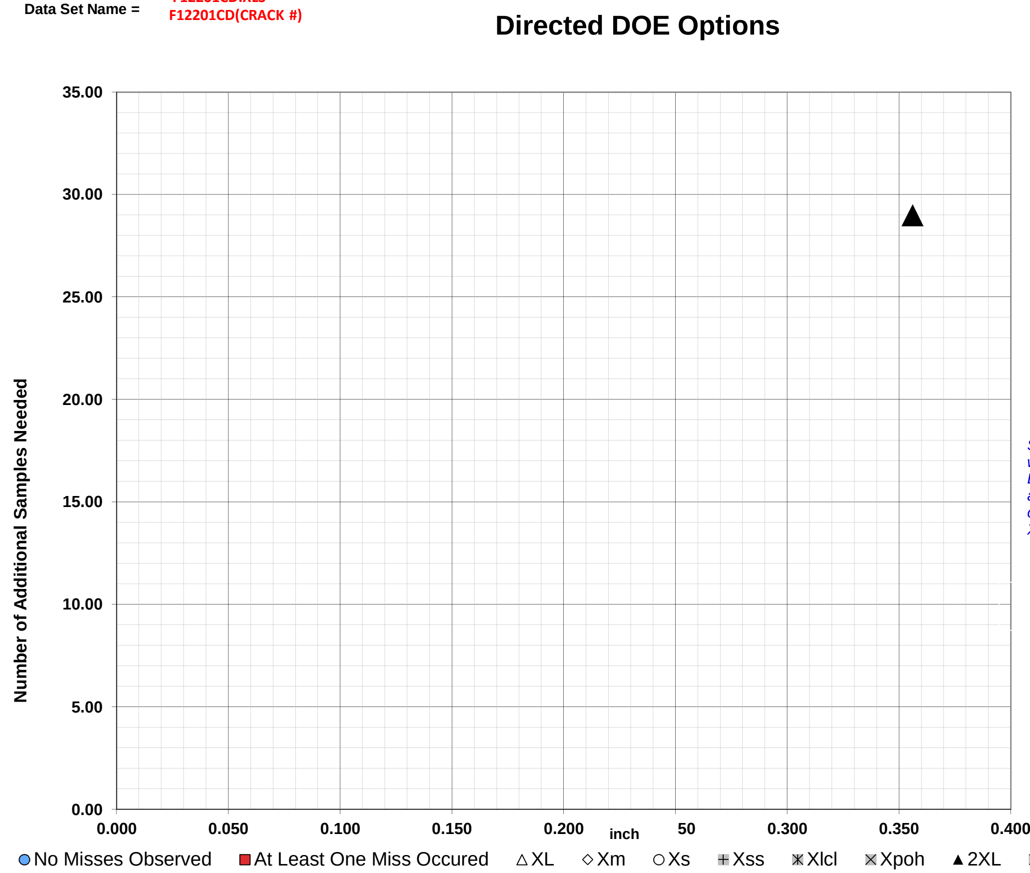


TABLE C

	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.

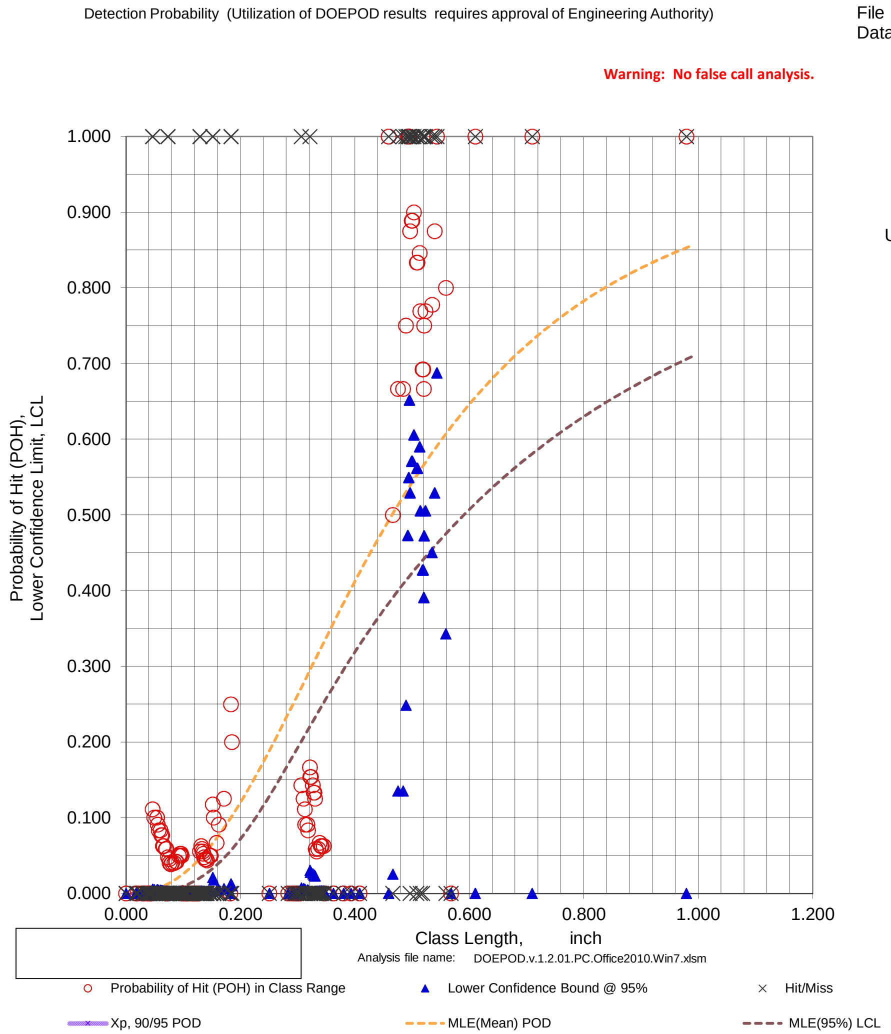
Xpod,Class Length	No. Need

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



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

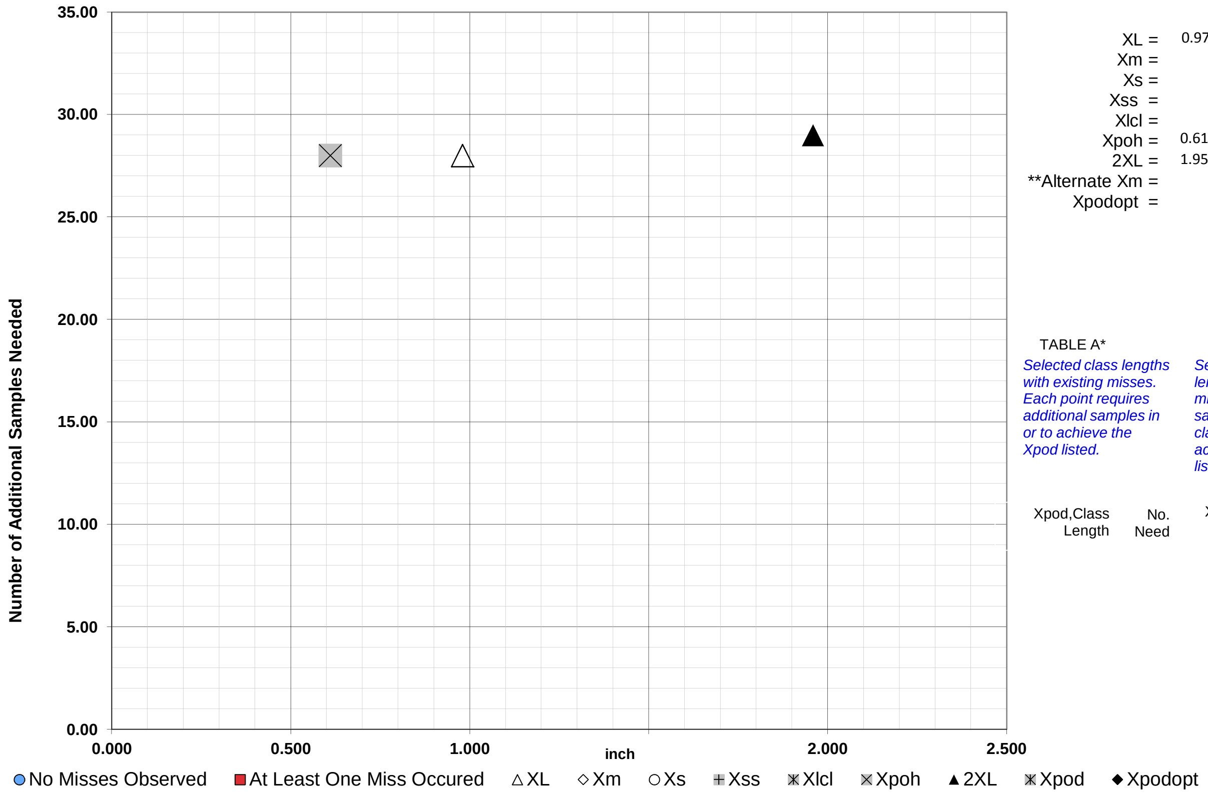


TABLE C

	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*

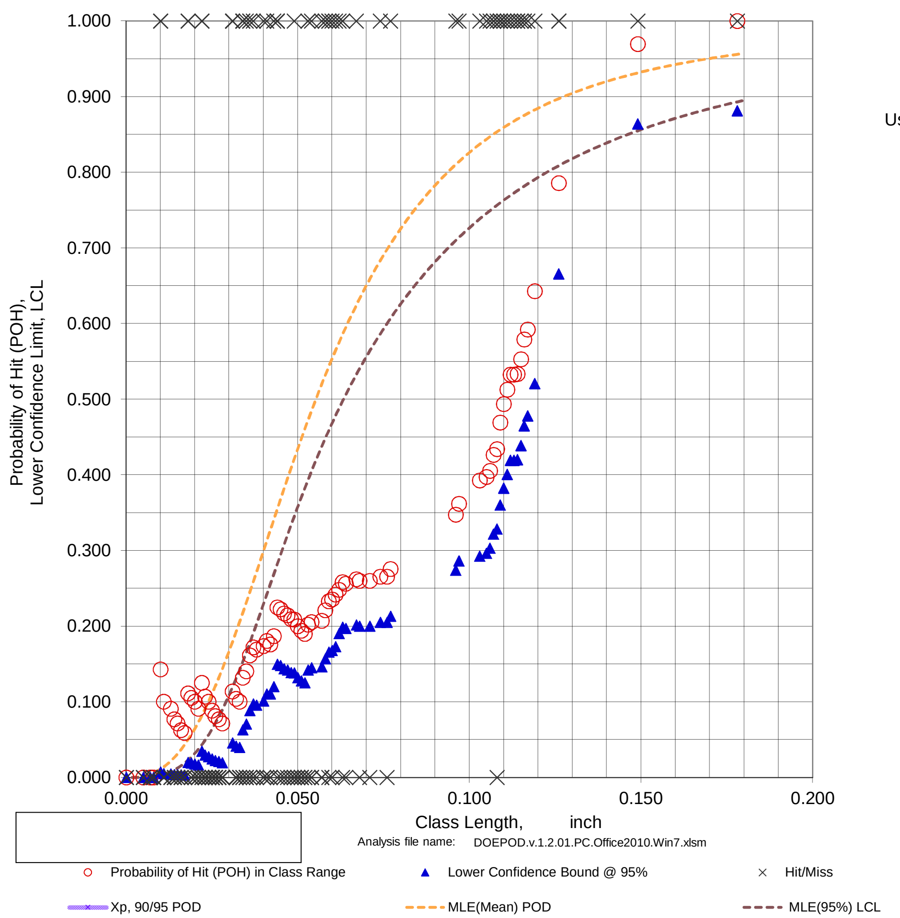
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

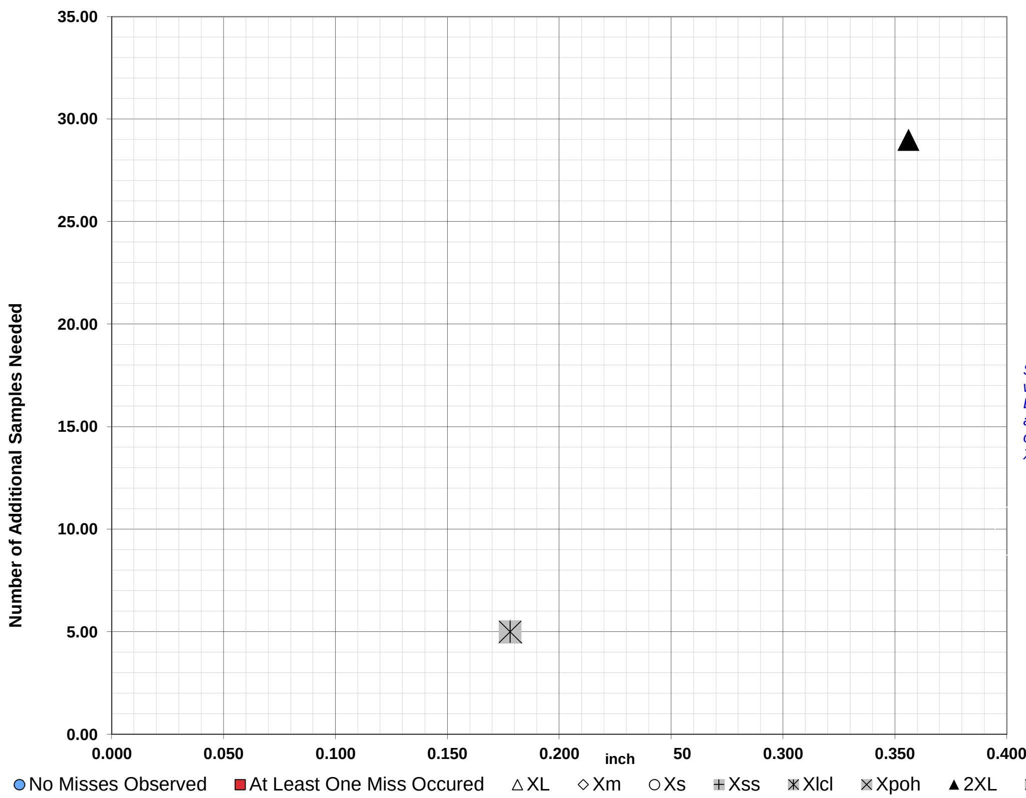


TABLE C

	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*

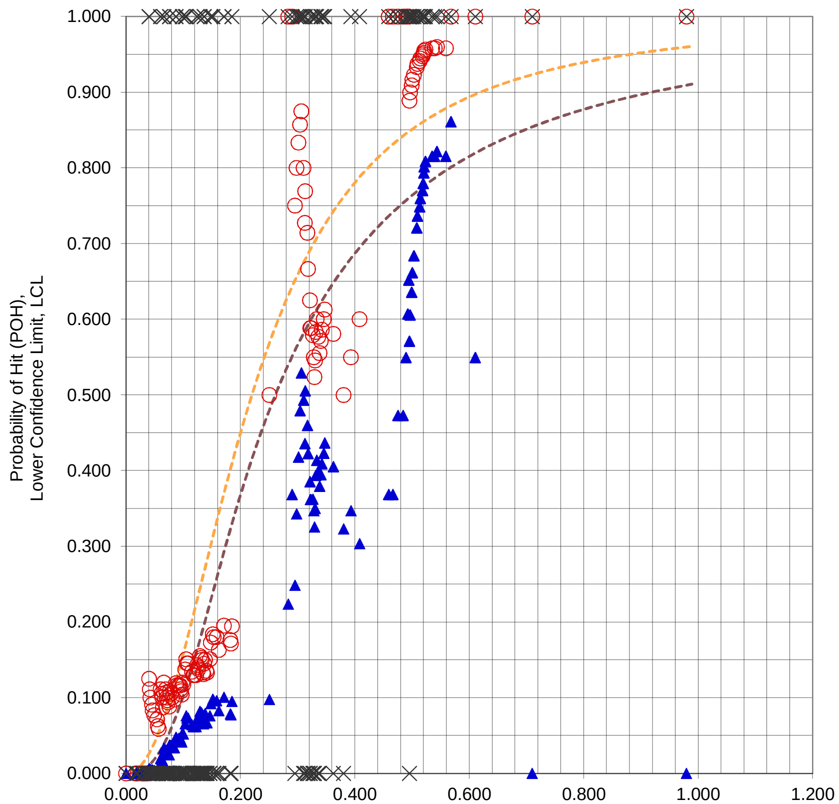
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

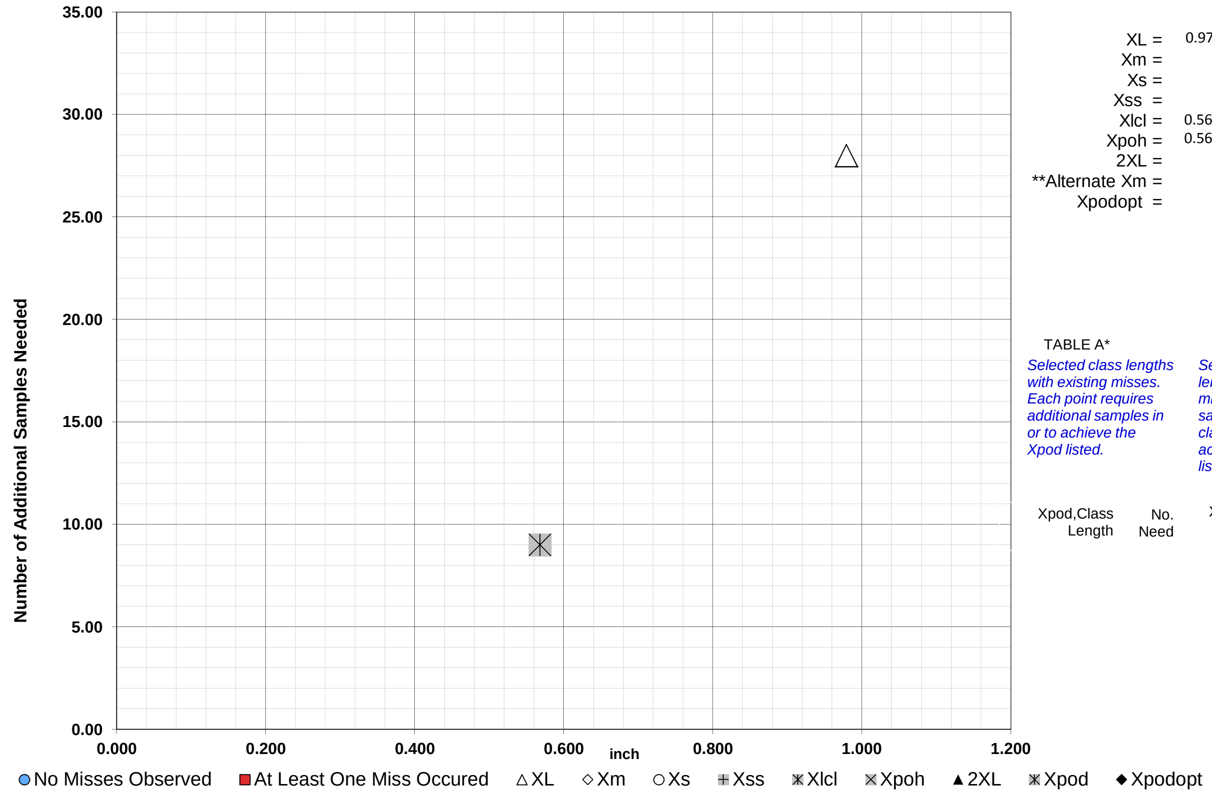


TABLE C

	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*

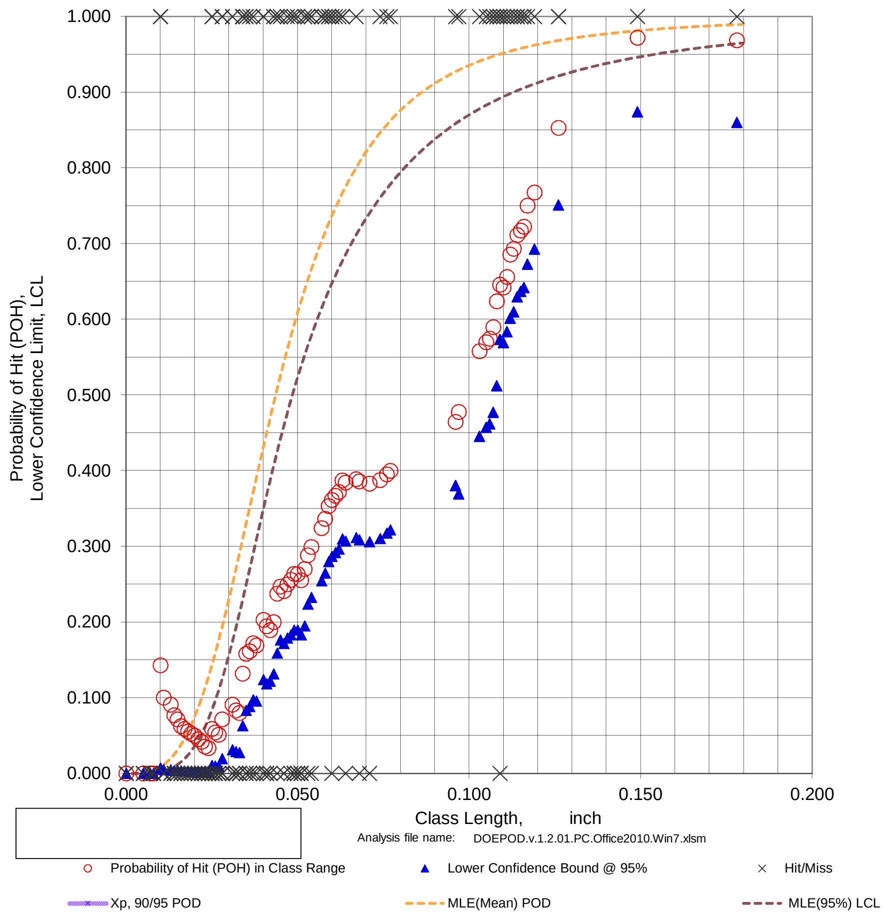
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

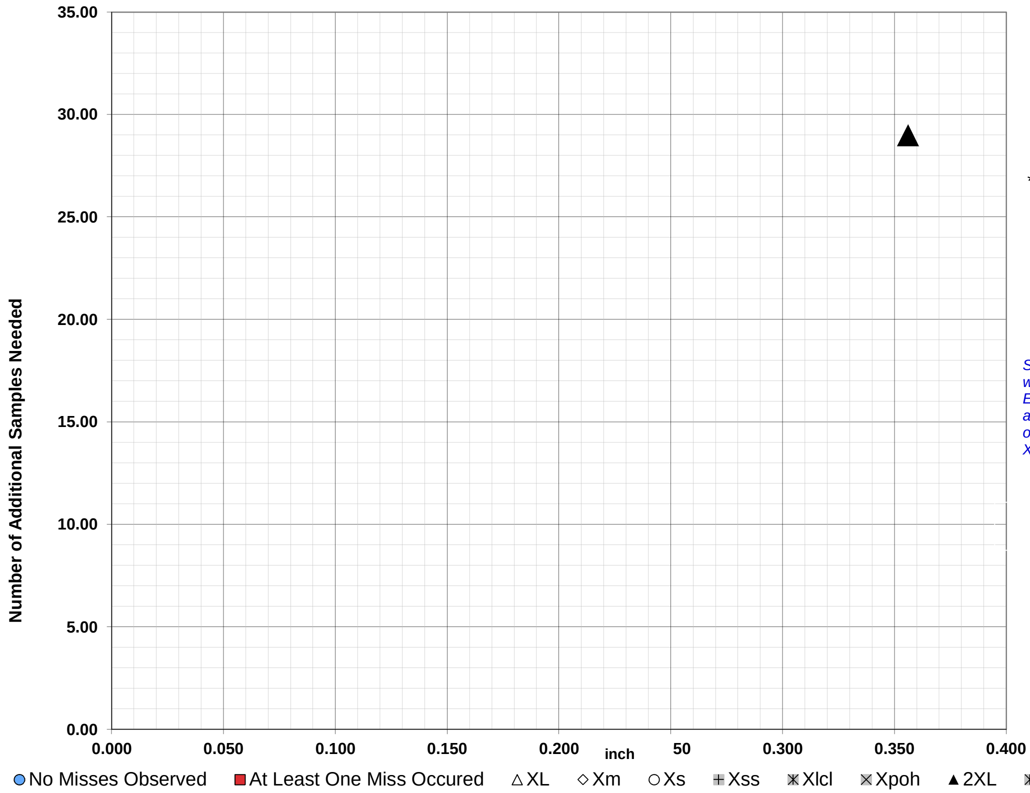


TABLE C

	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

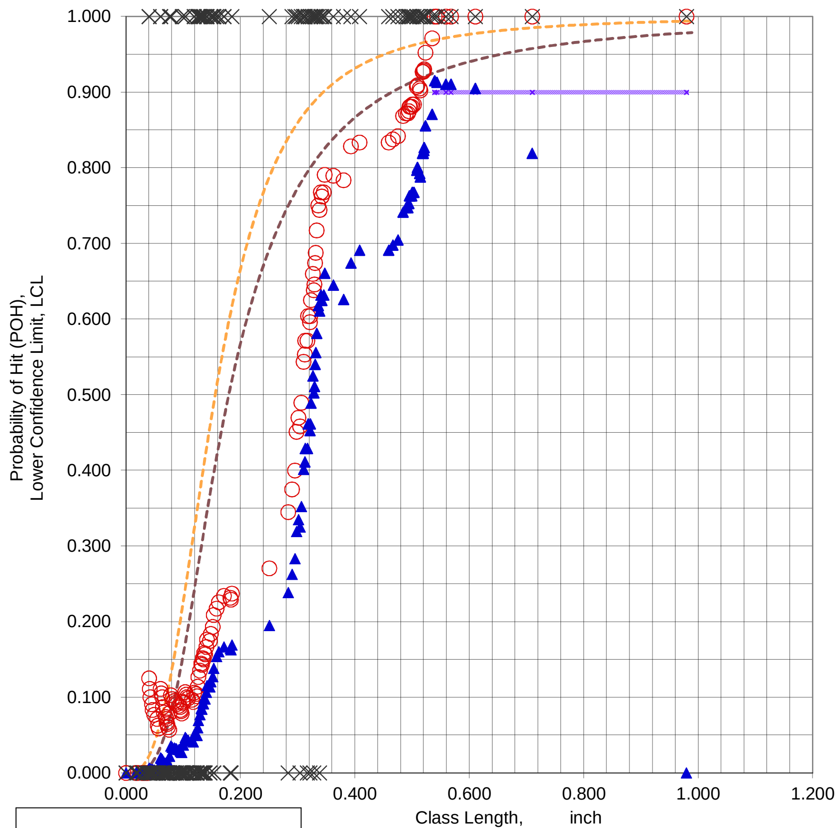
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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 = 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

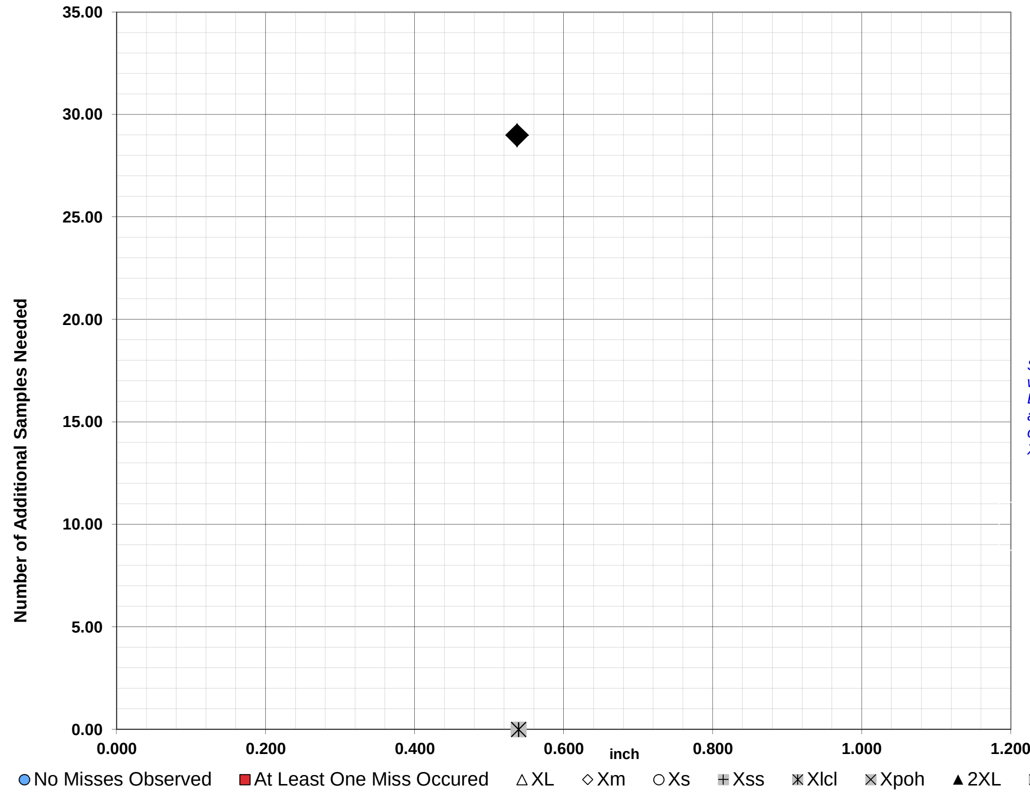


TABLE C

	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*

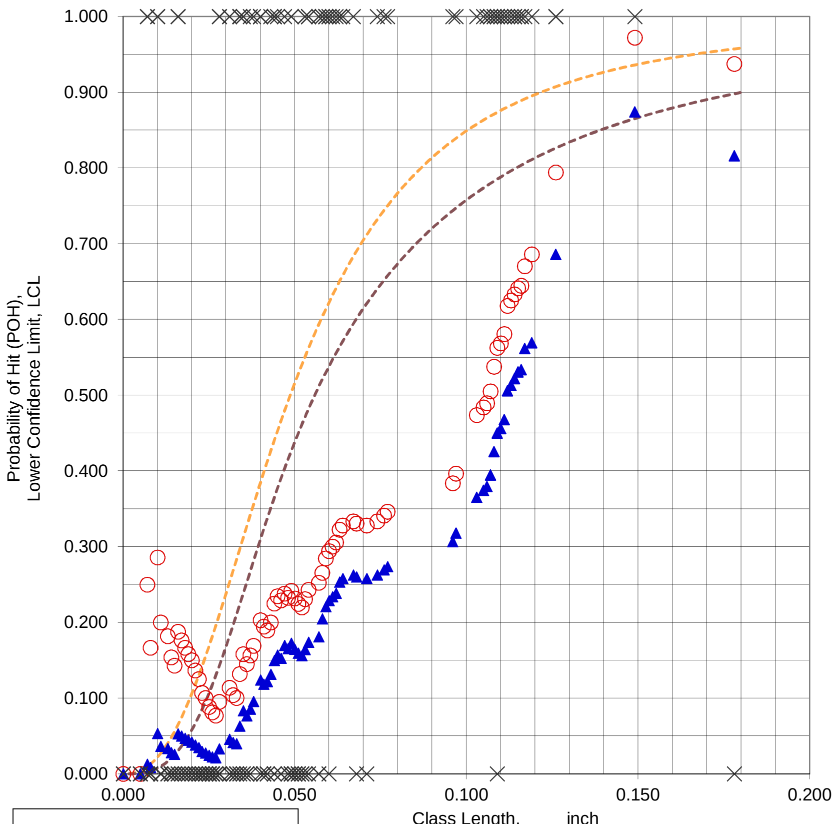
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

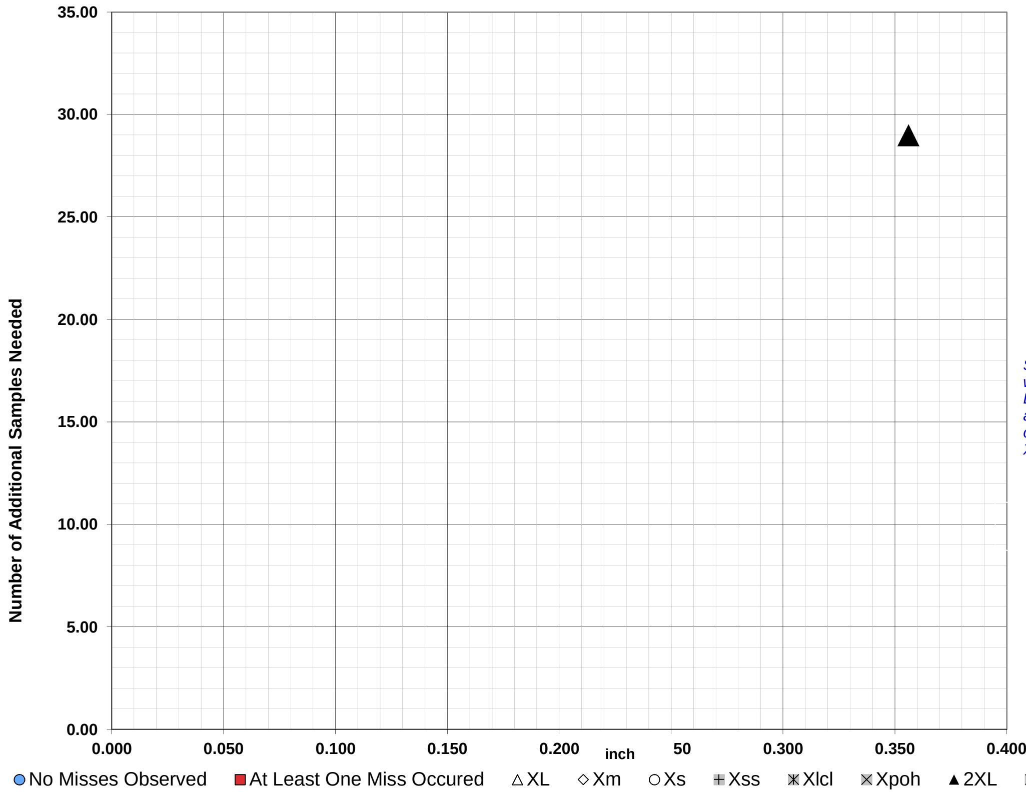


TABLE C

	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*

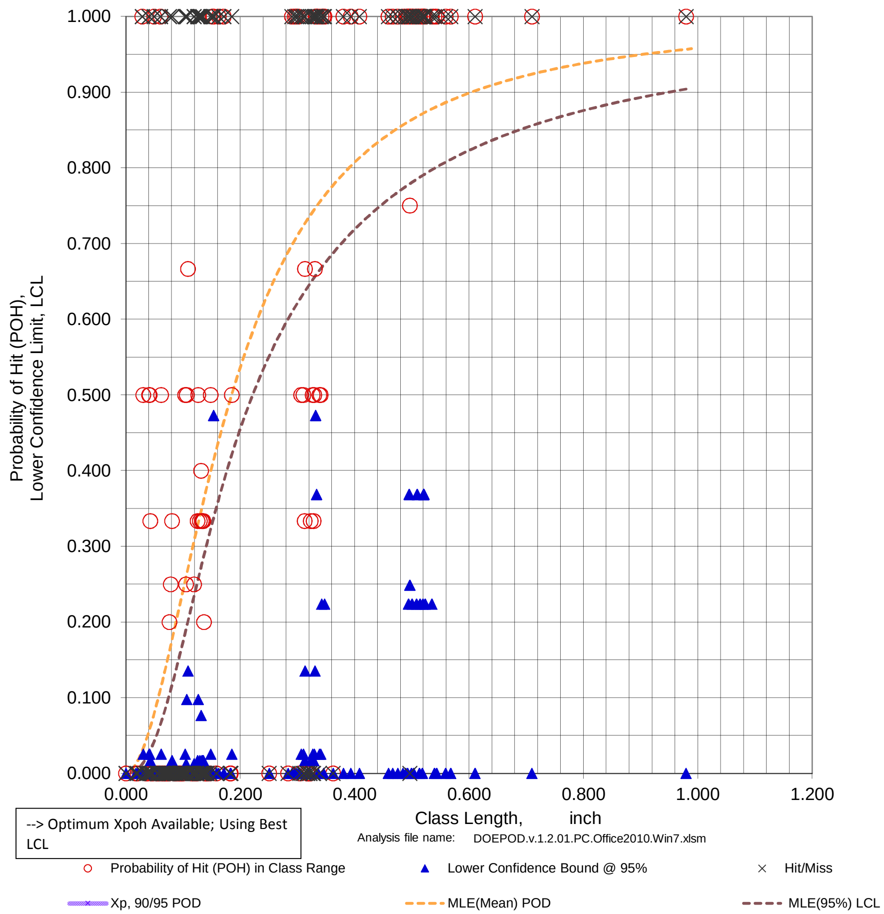
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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 #)

Directed DOE Options

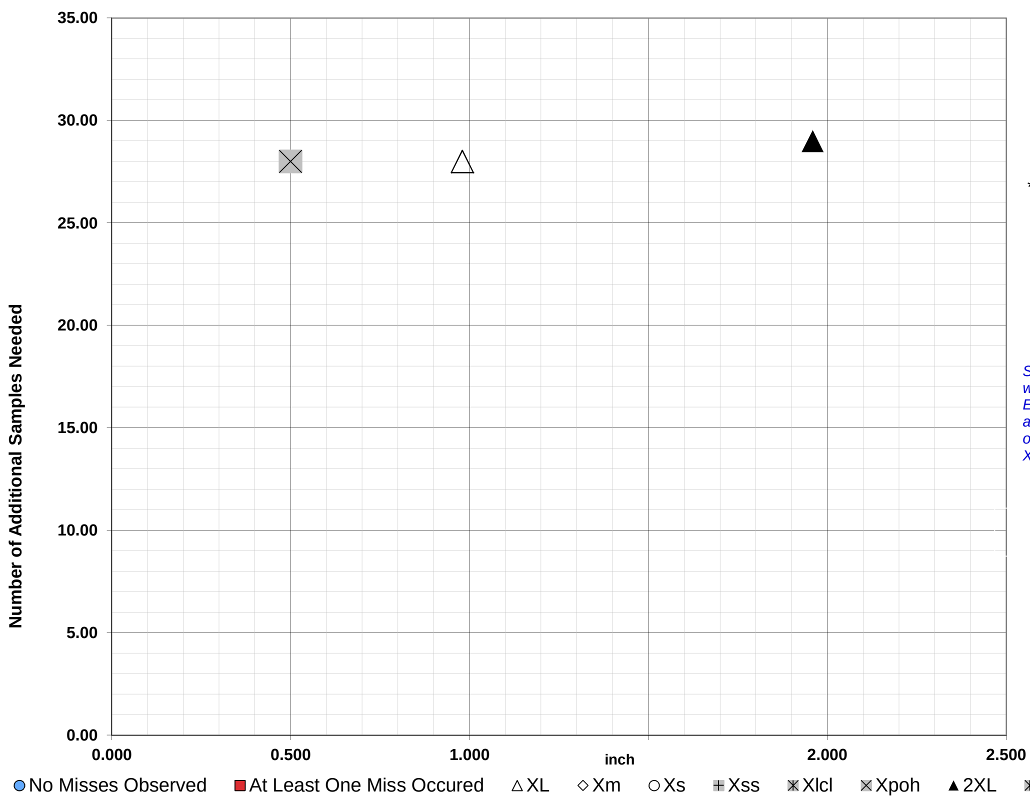


TABLE C

	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*

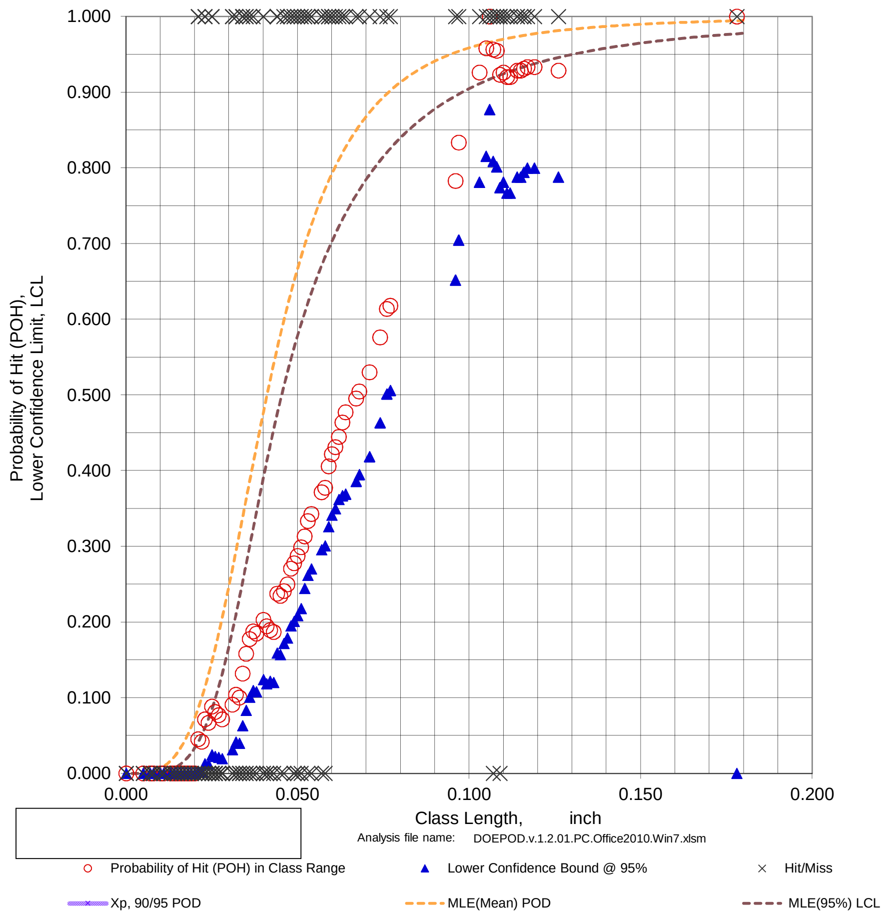
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

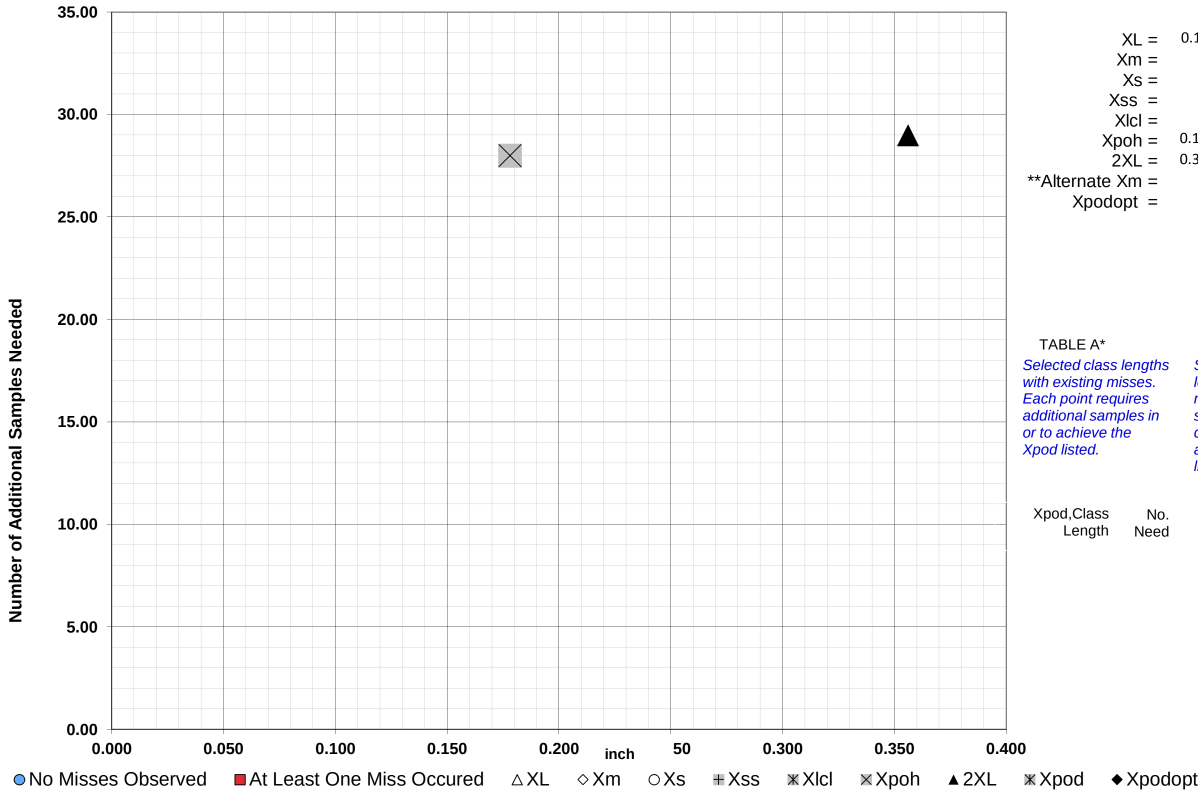


TABLE C

	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*

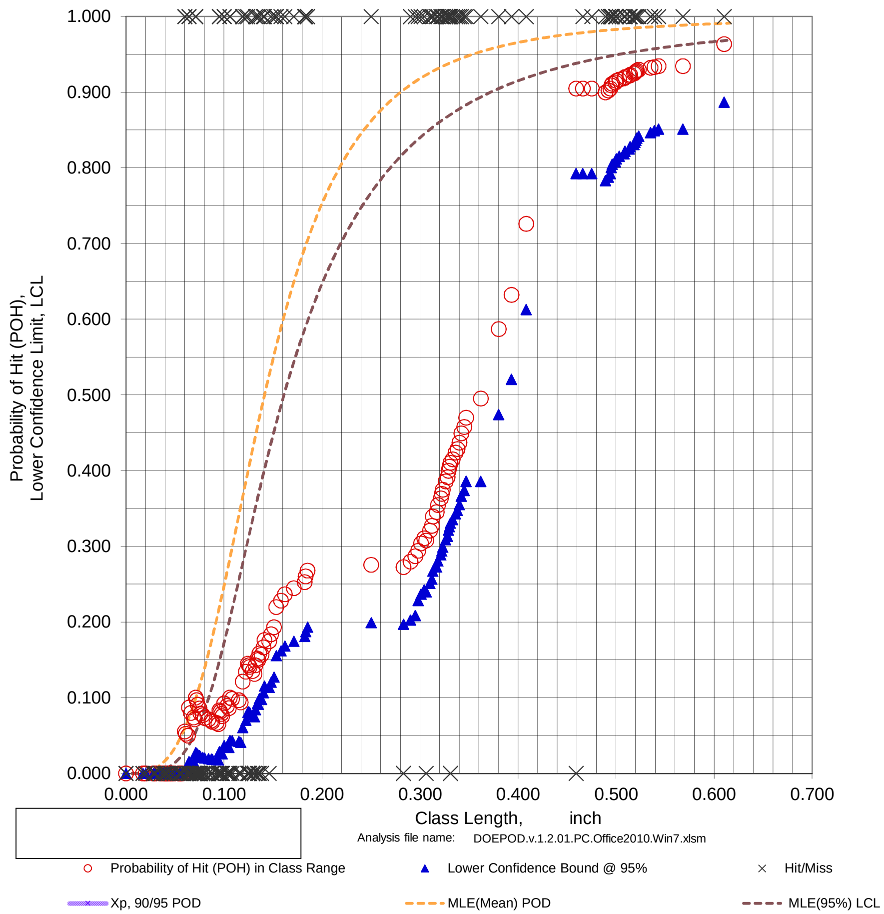
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

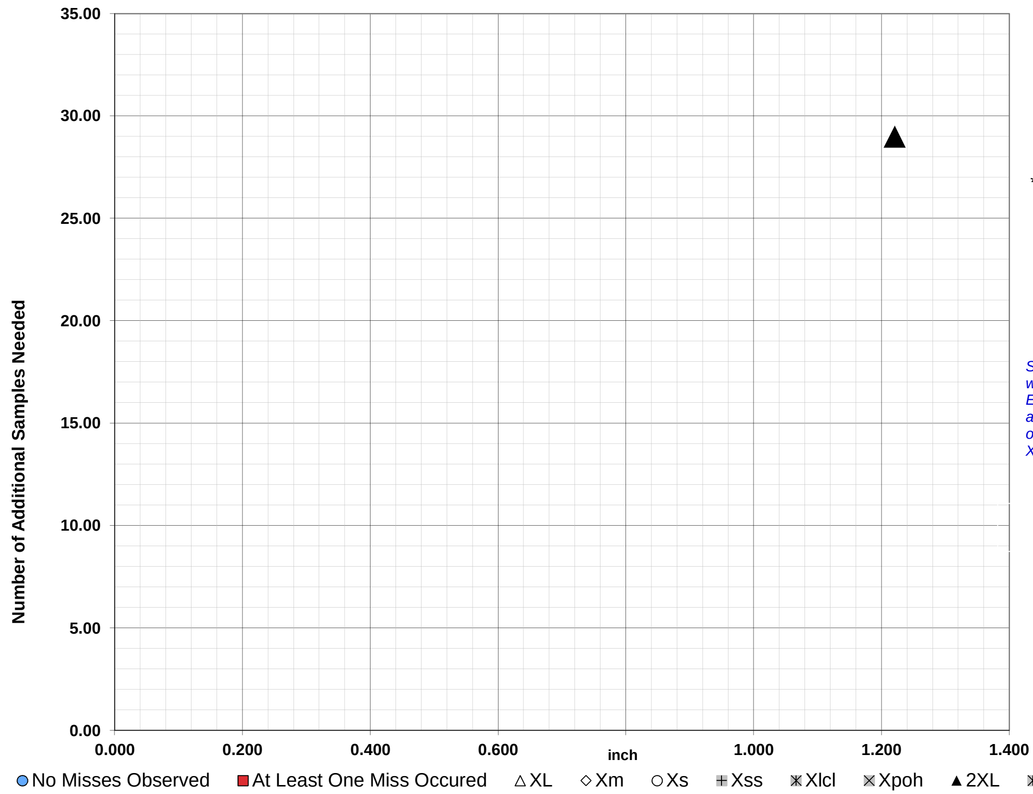


TABLE C

	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.

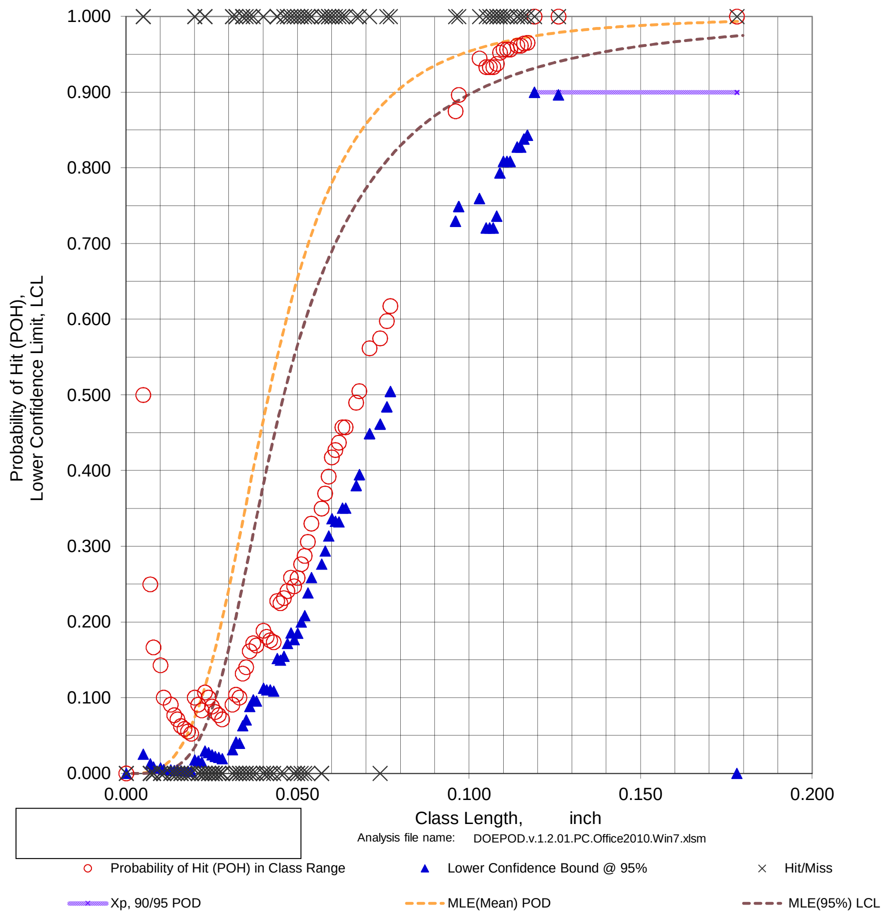
Xpod,Class Length	No. Need

* 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

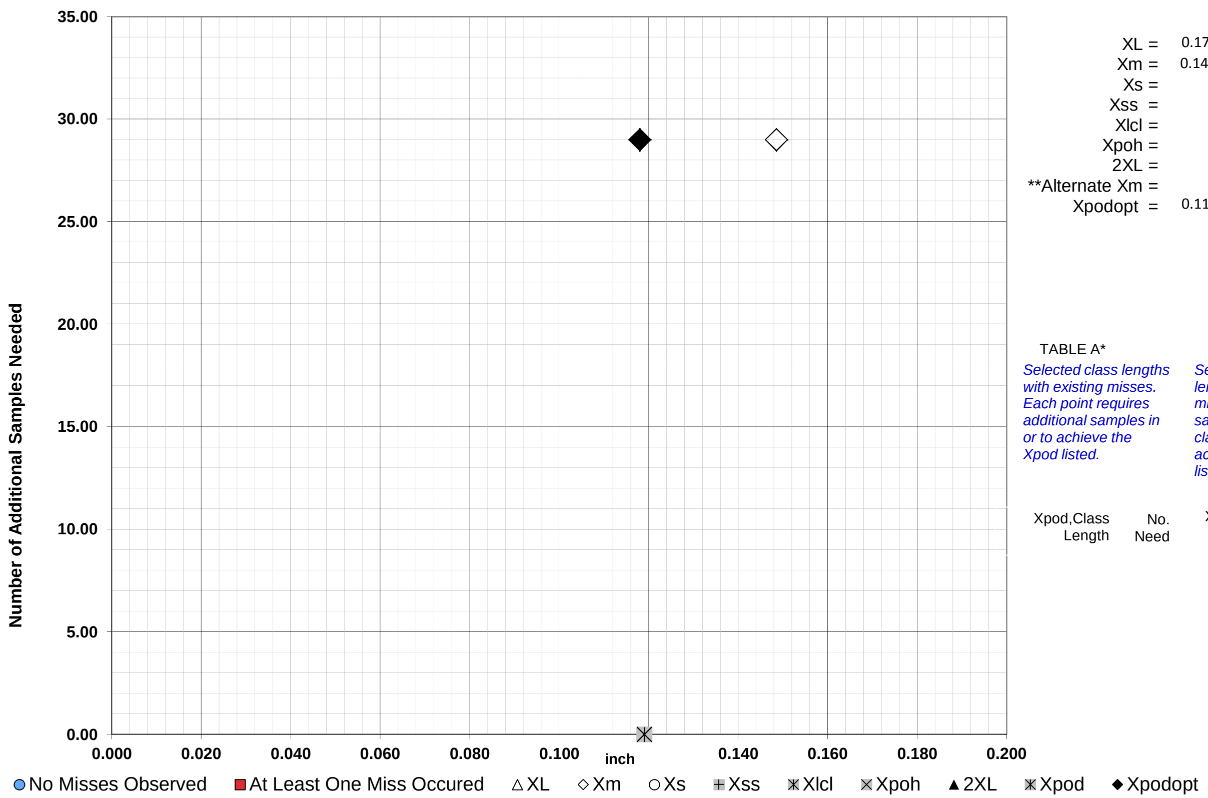


TABLE C

	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.

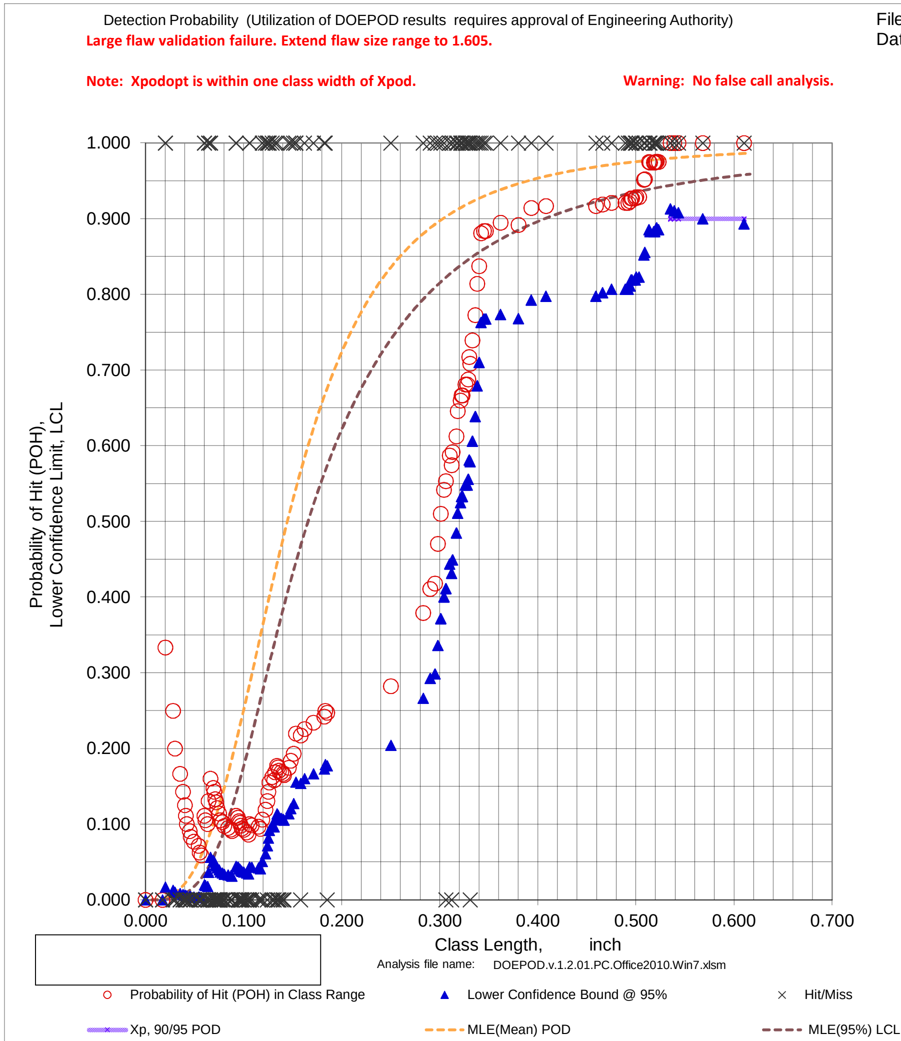
Xpod,Class Length	No. Need

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



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

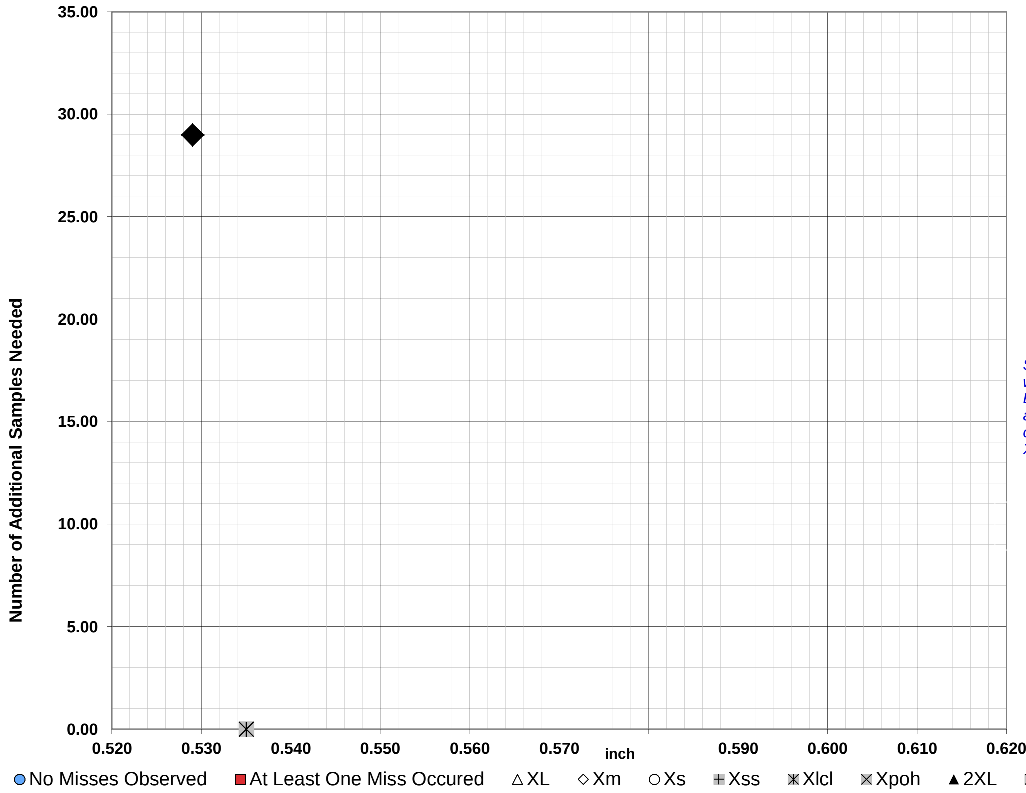


TABLE C

	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.

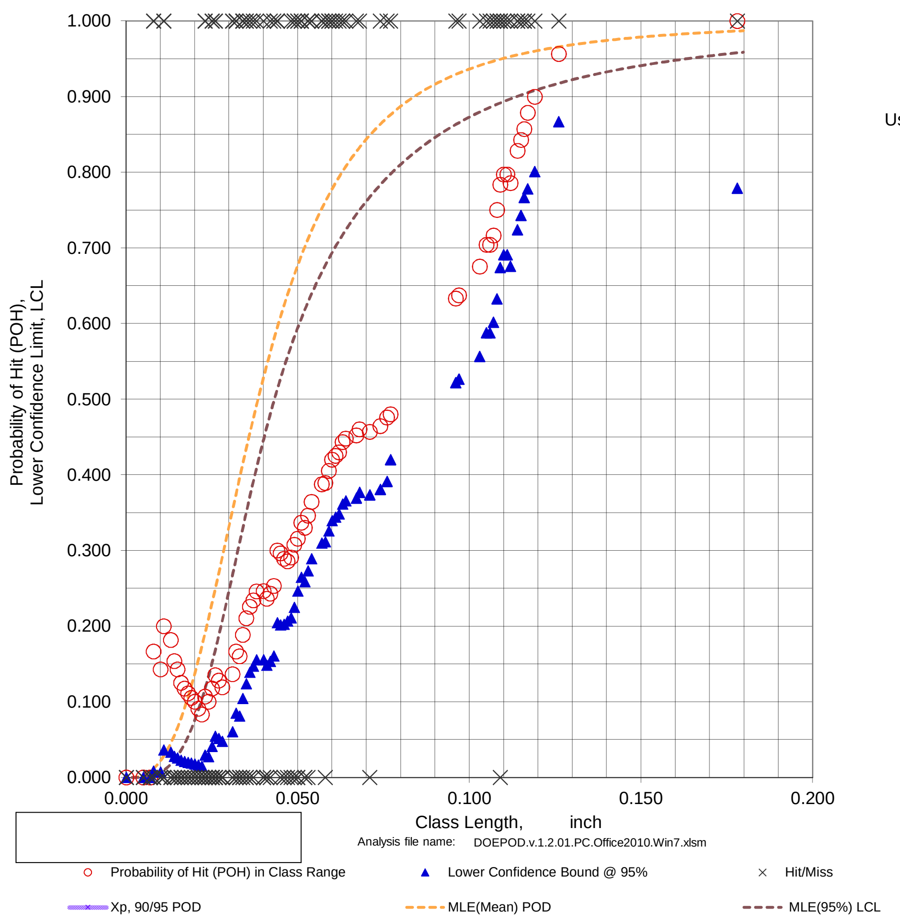
Xpod,Class Length	No. Need

* 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)

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 =

Warning: No false call analysis.



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

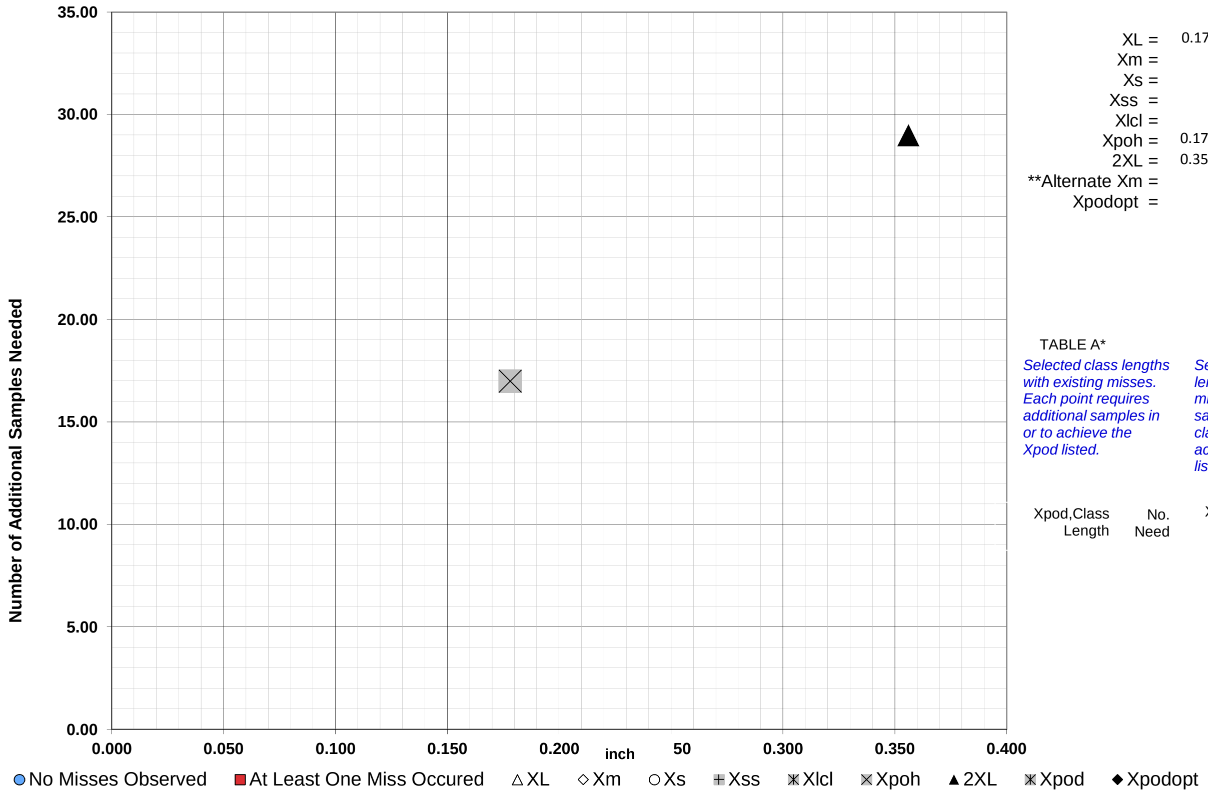


TABLE C

	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.

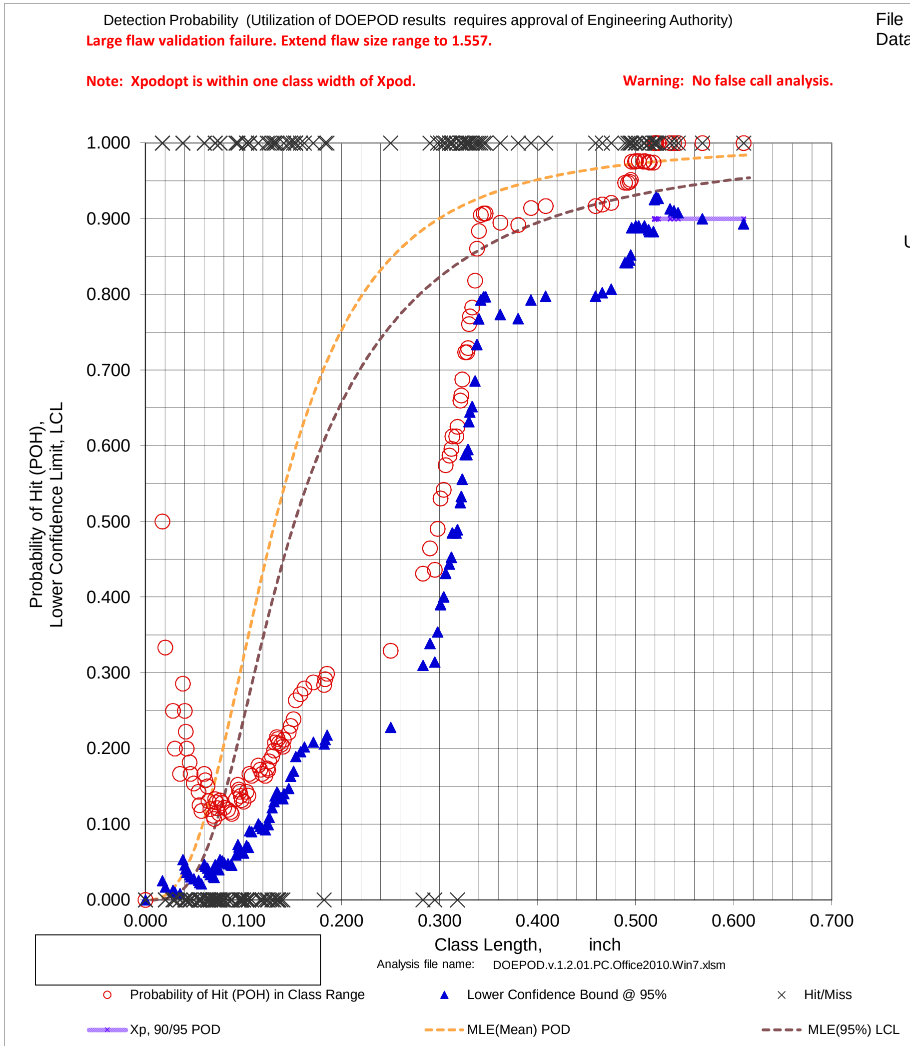
Xpod,Class Length	No. Need

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



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

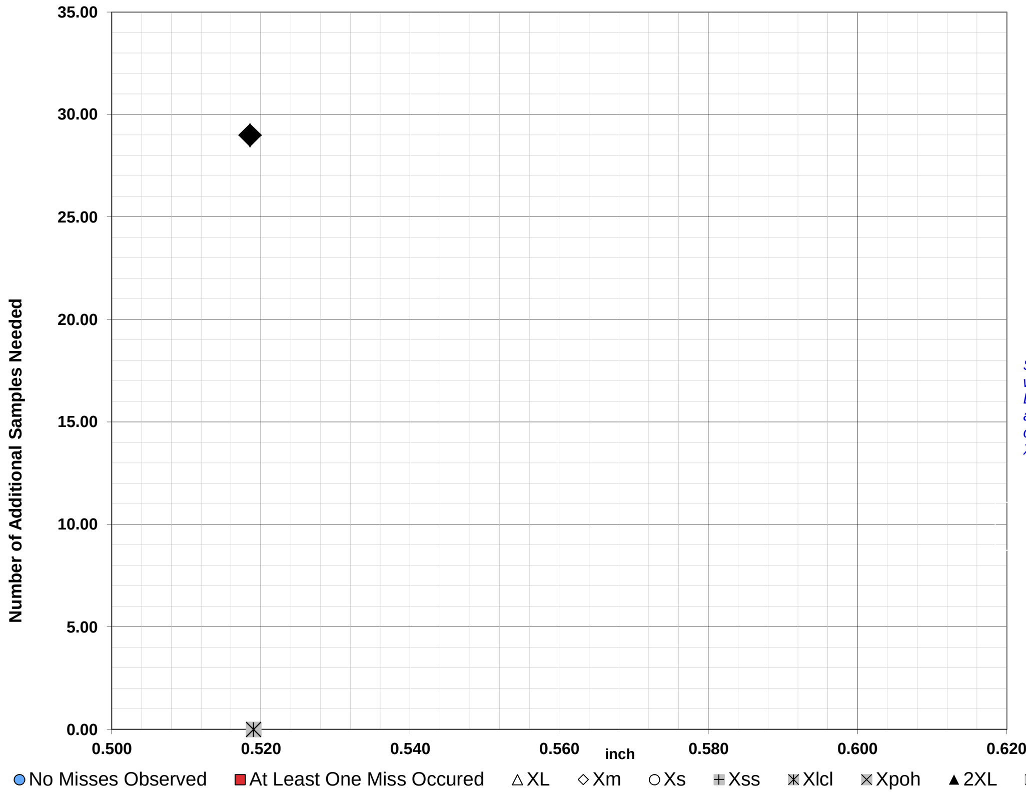


TABLE C

	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*

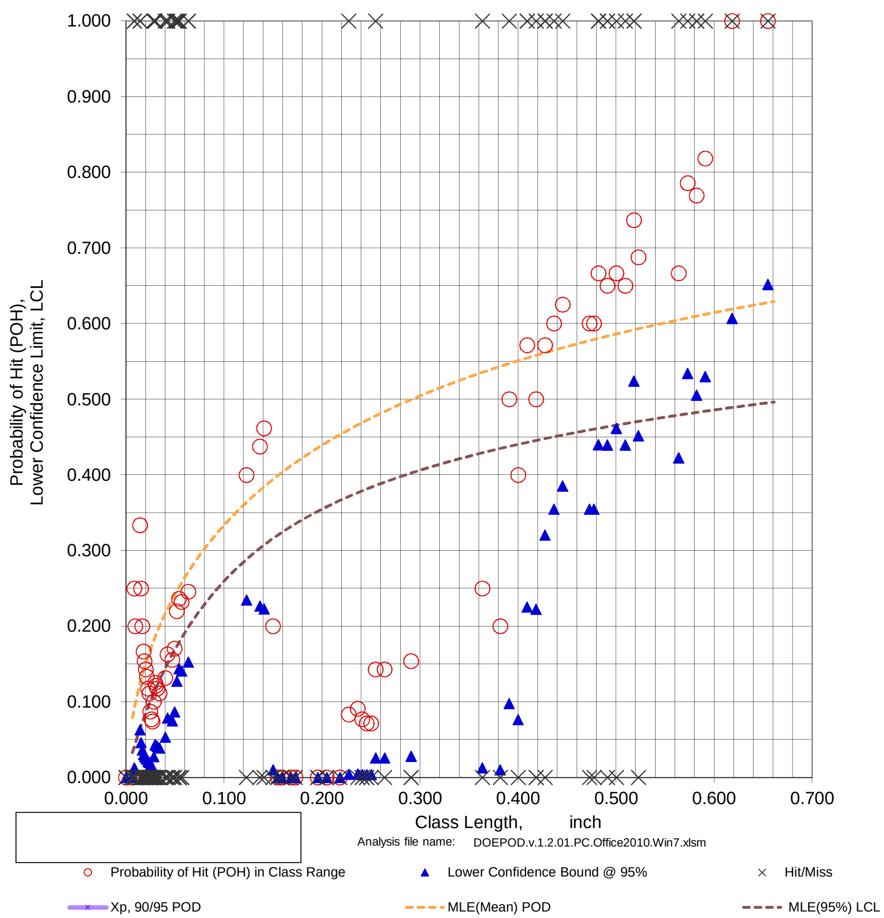
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

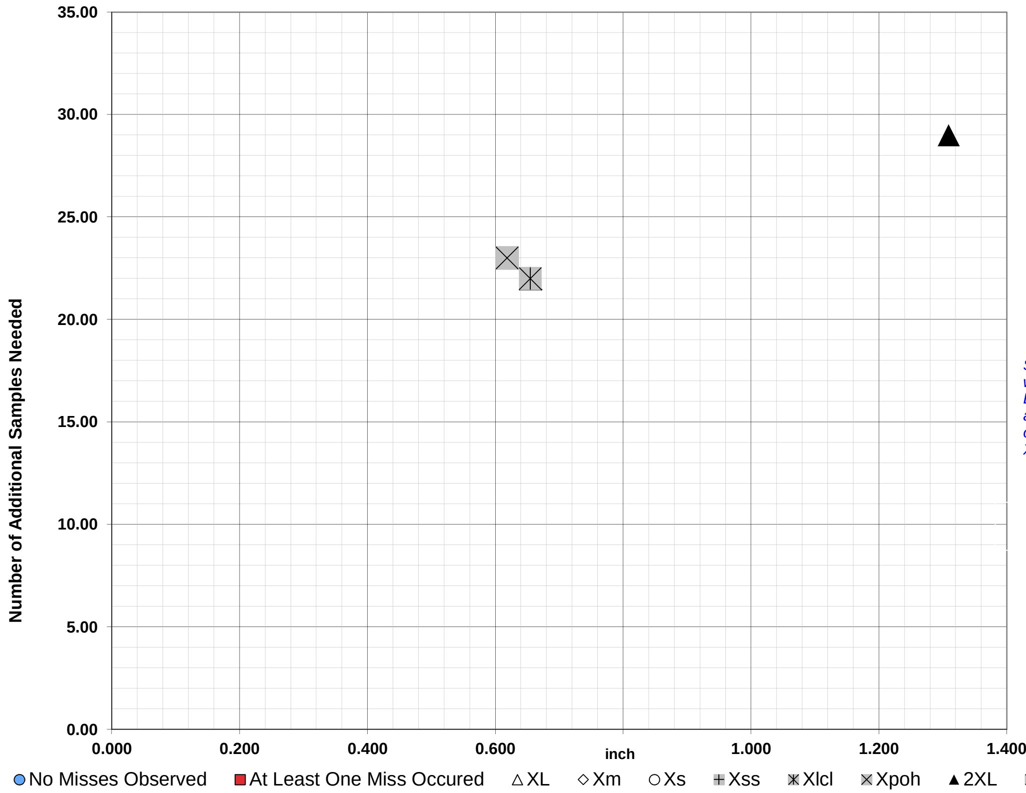


TABLE C

	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*

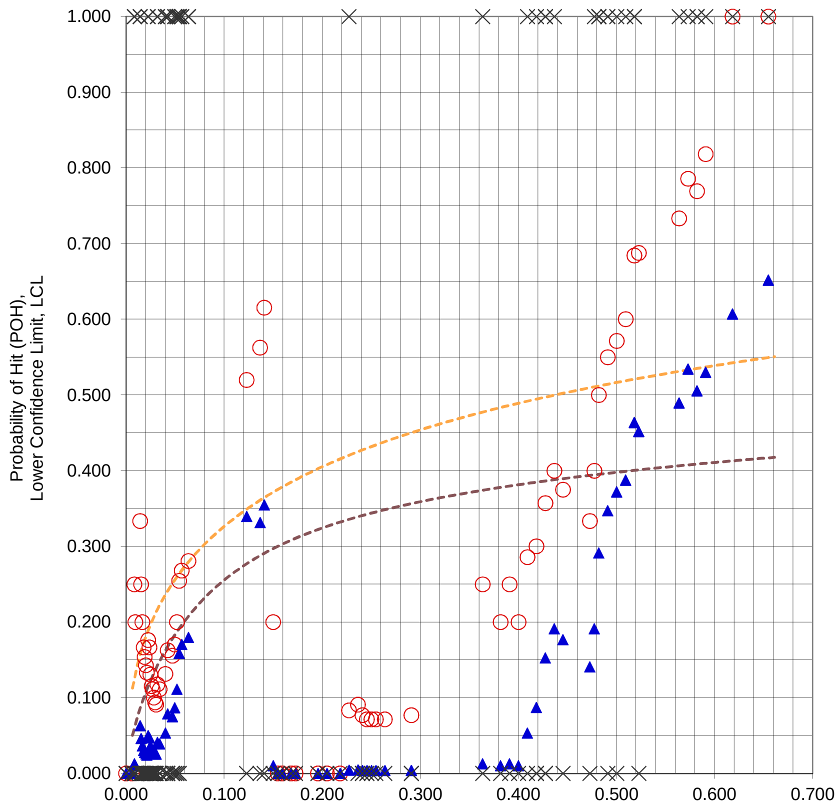
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

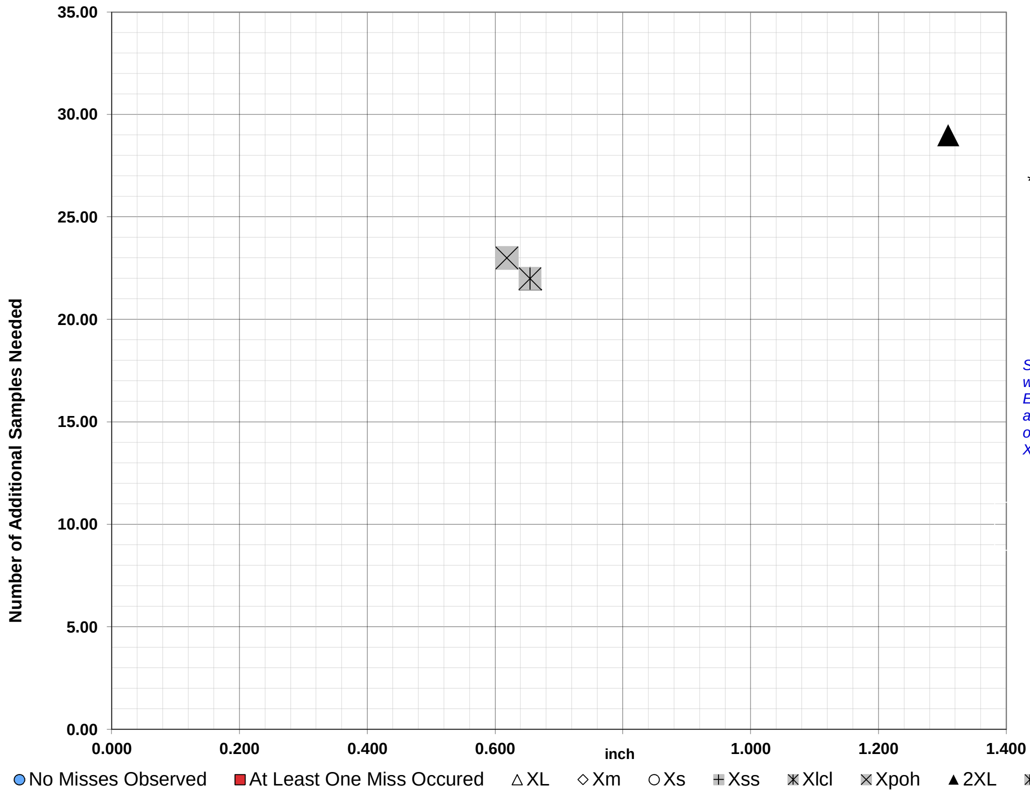


TABLE C

	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

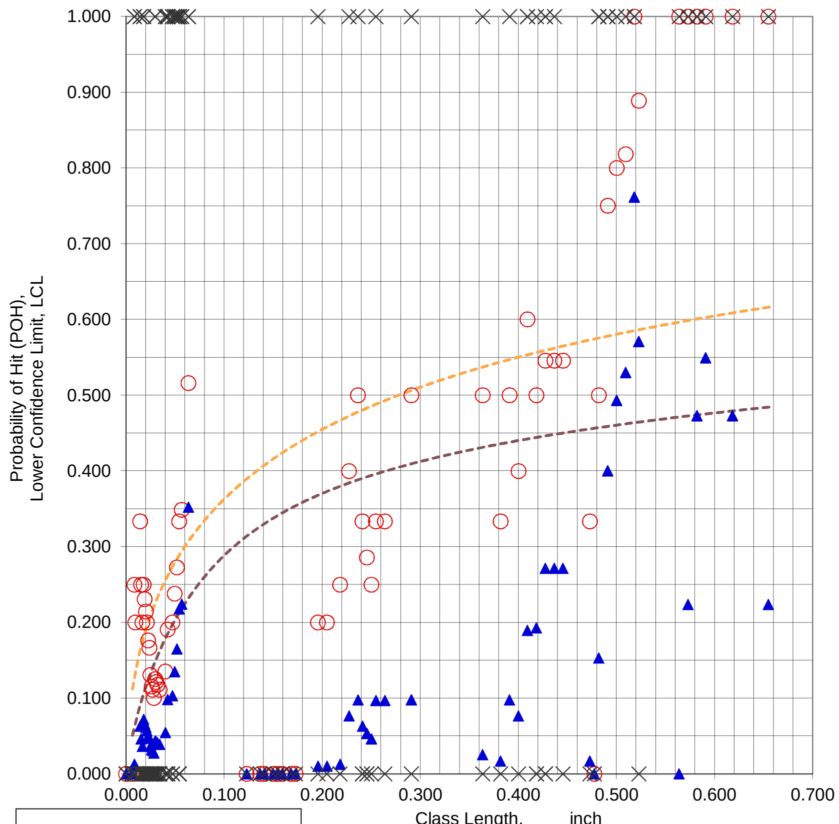
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F20002CA.XLS
Data Set Name = F20002CA(CRACK #)
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 =



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

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

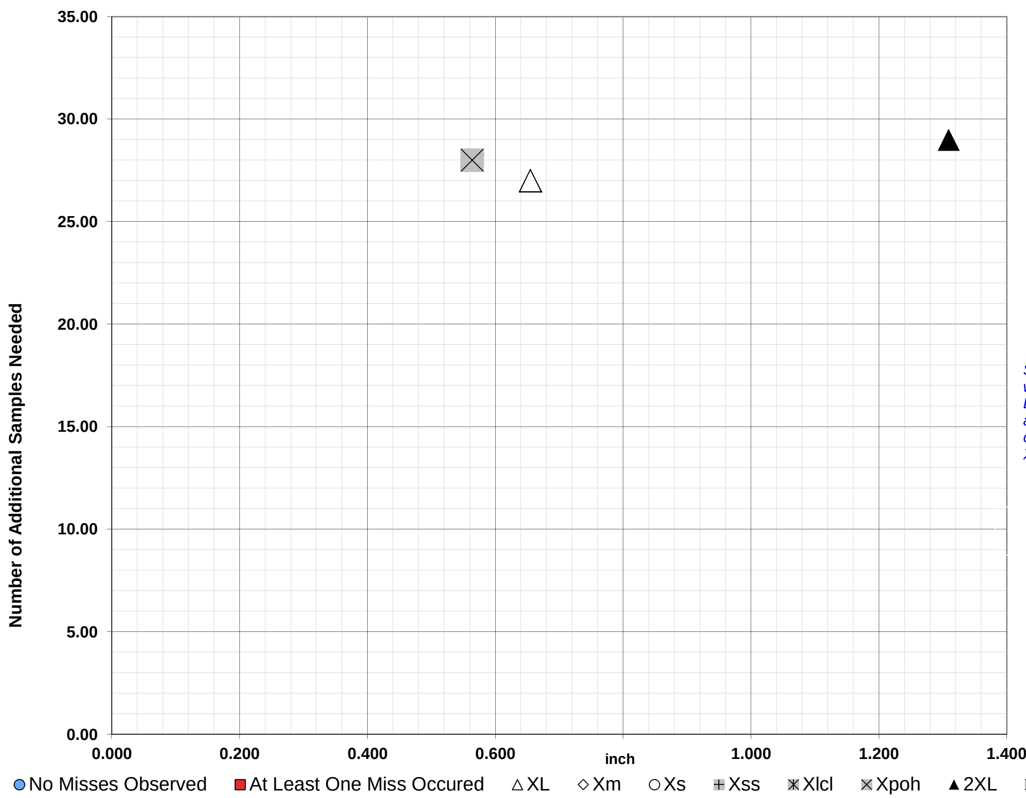


TABLE C

	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*

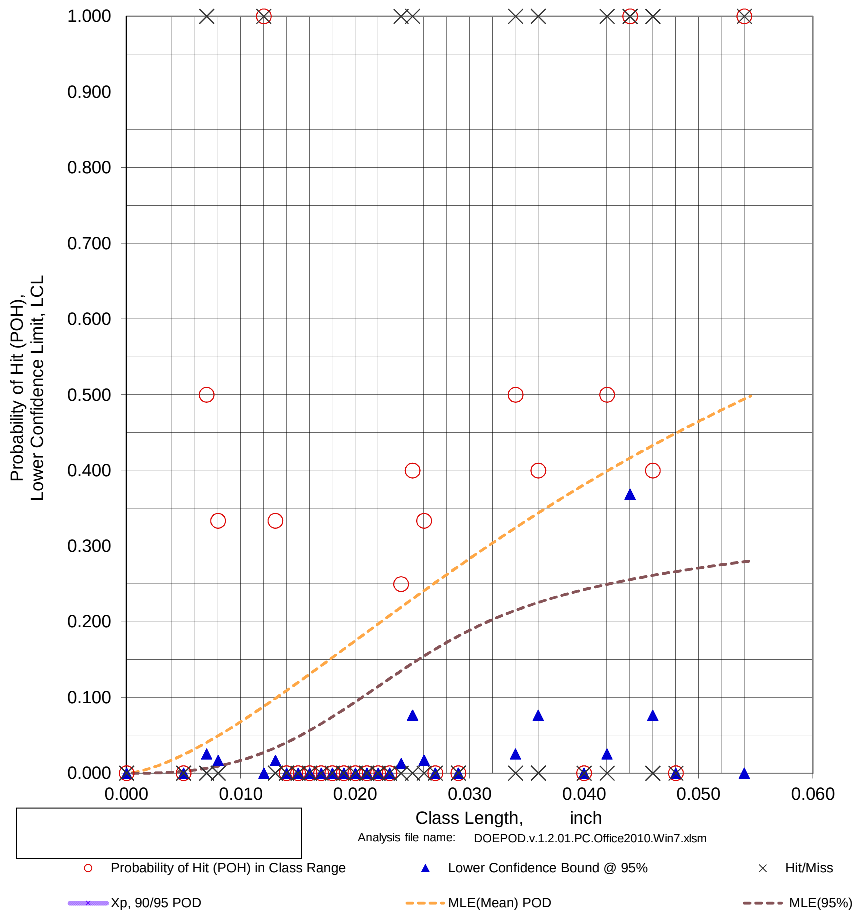
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

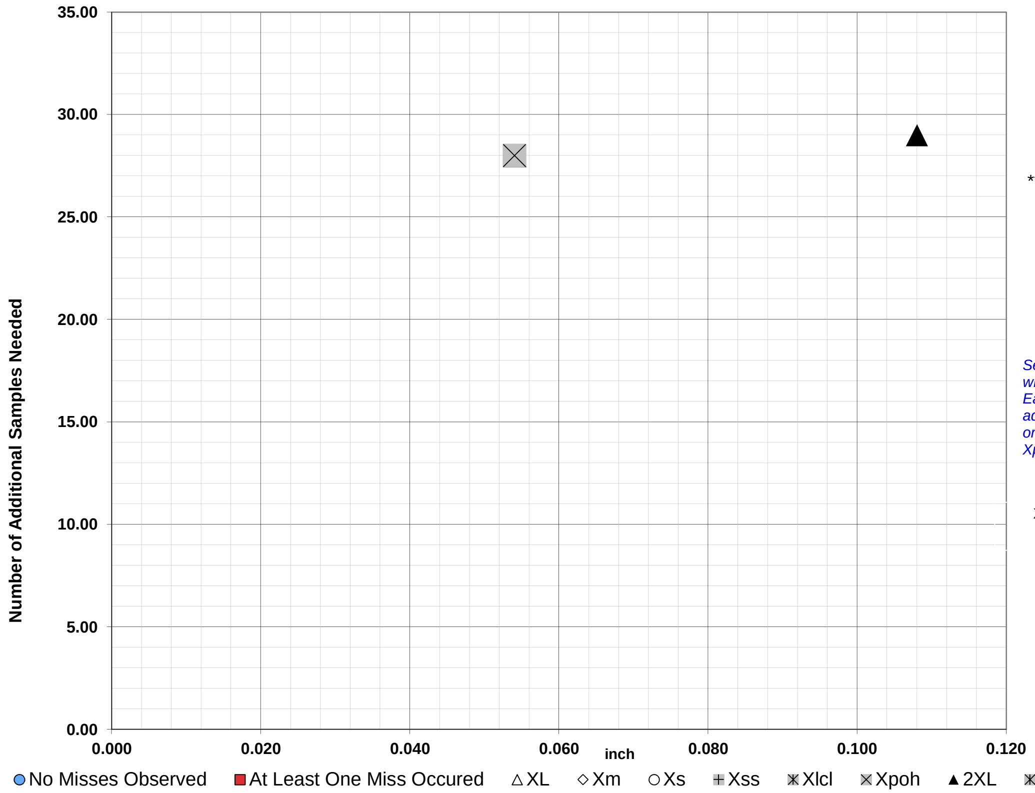


TABLE C

	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

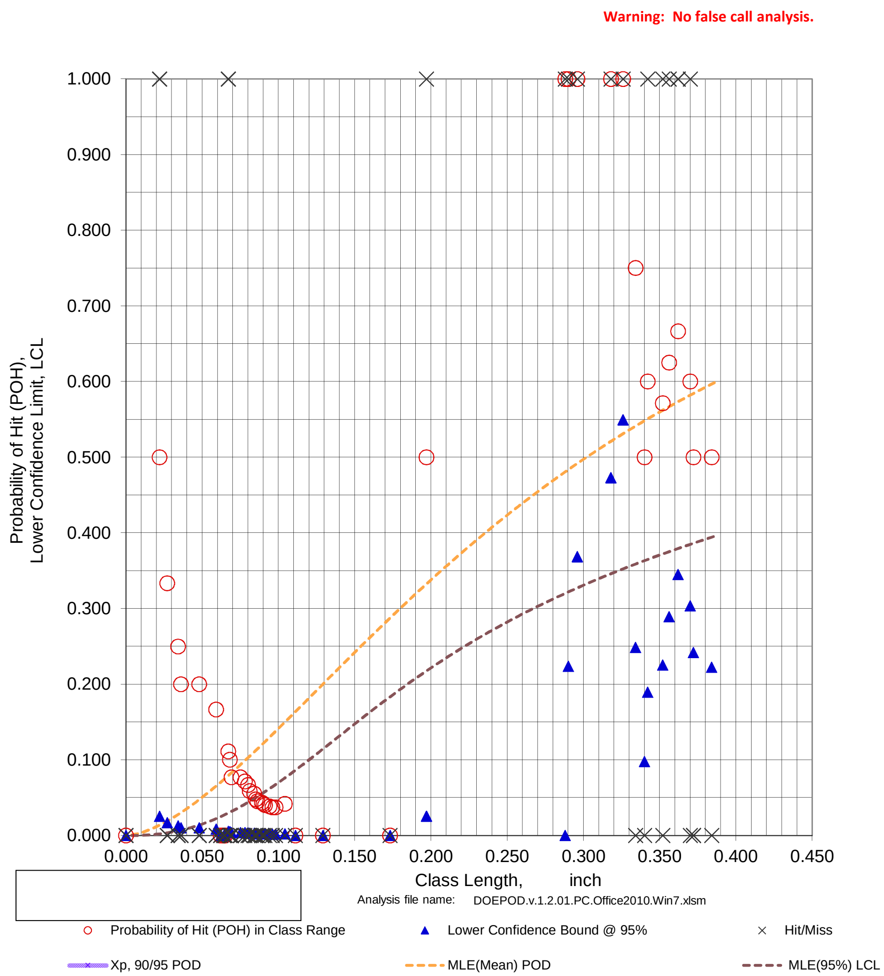
TABLE B*

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)



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

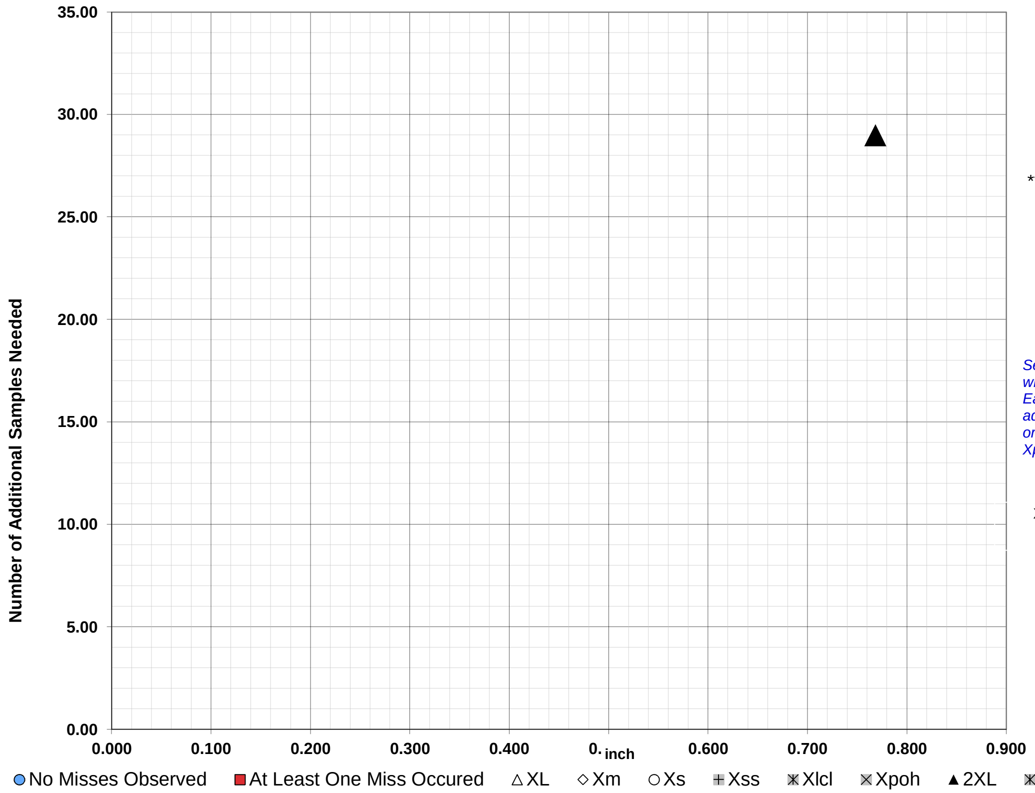


TABLE C

	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*

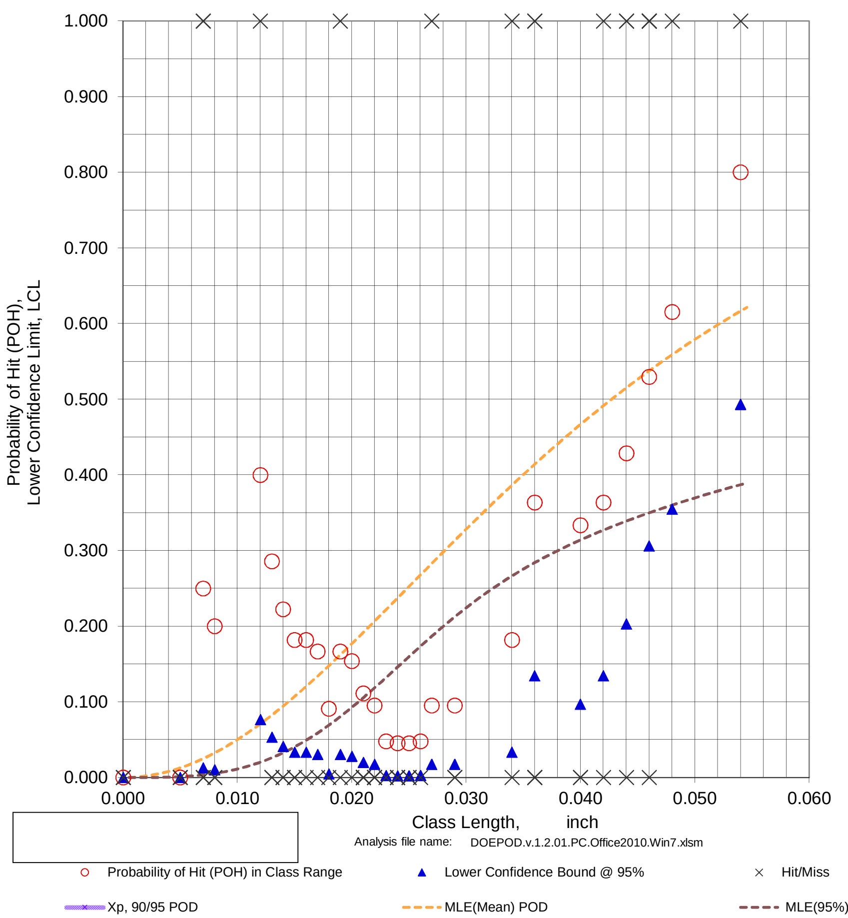
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

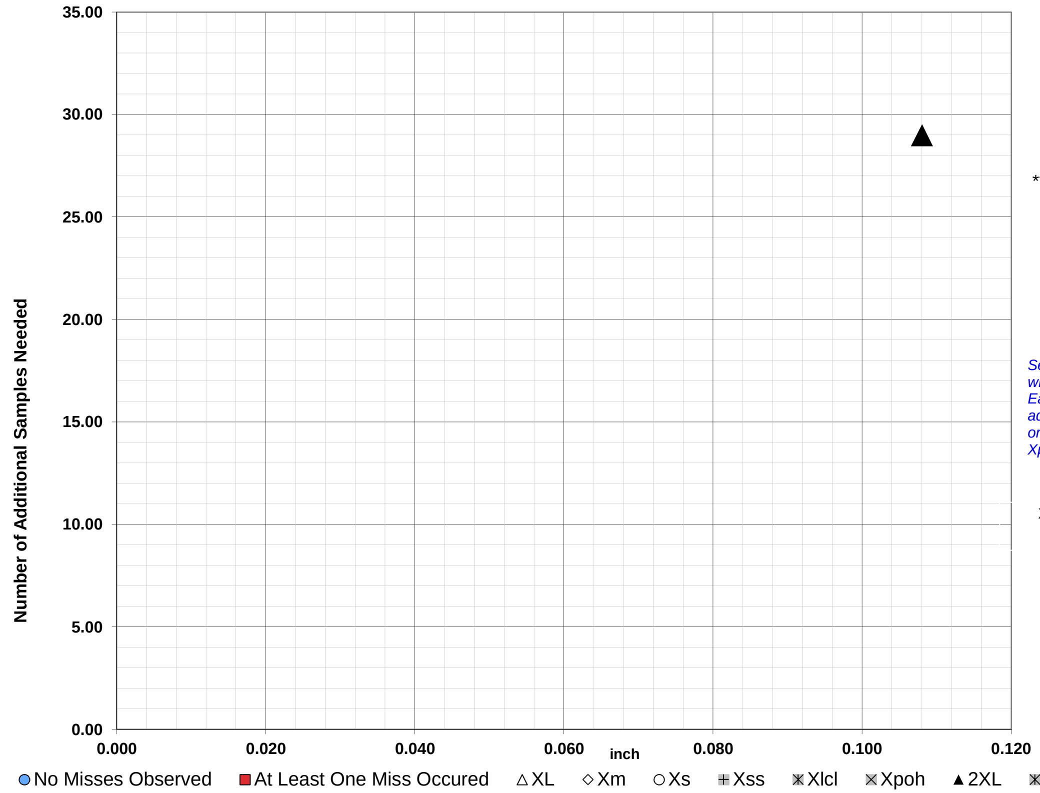


TABLE C

	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*

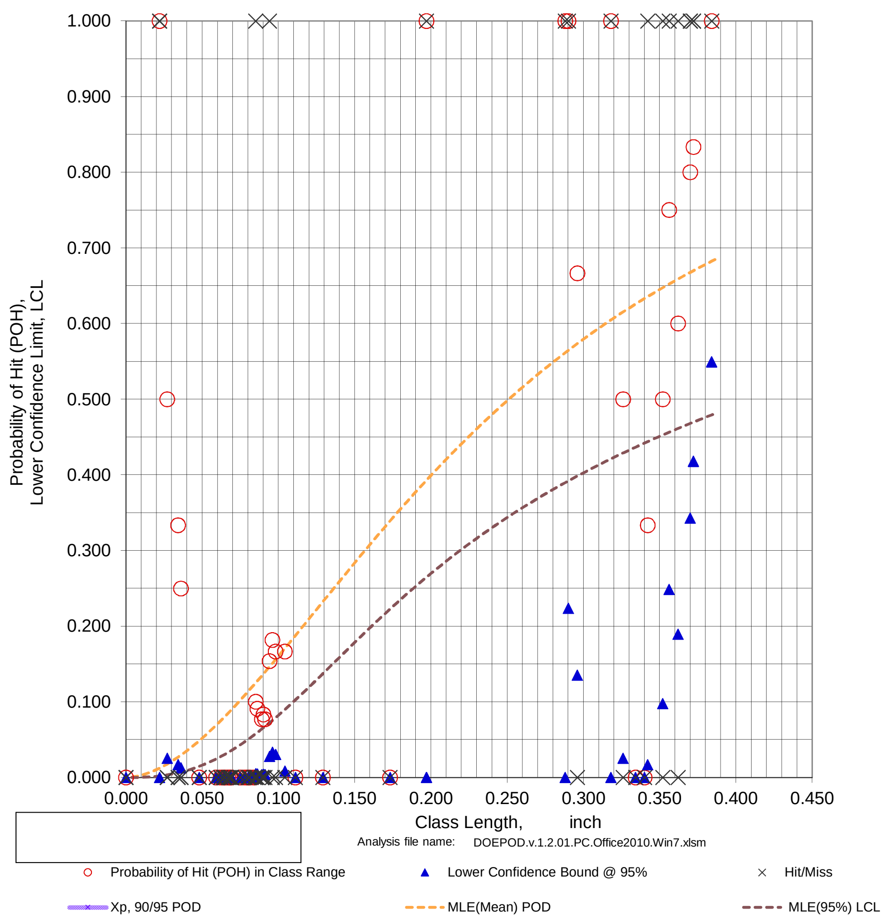
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

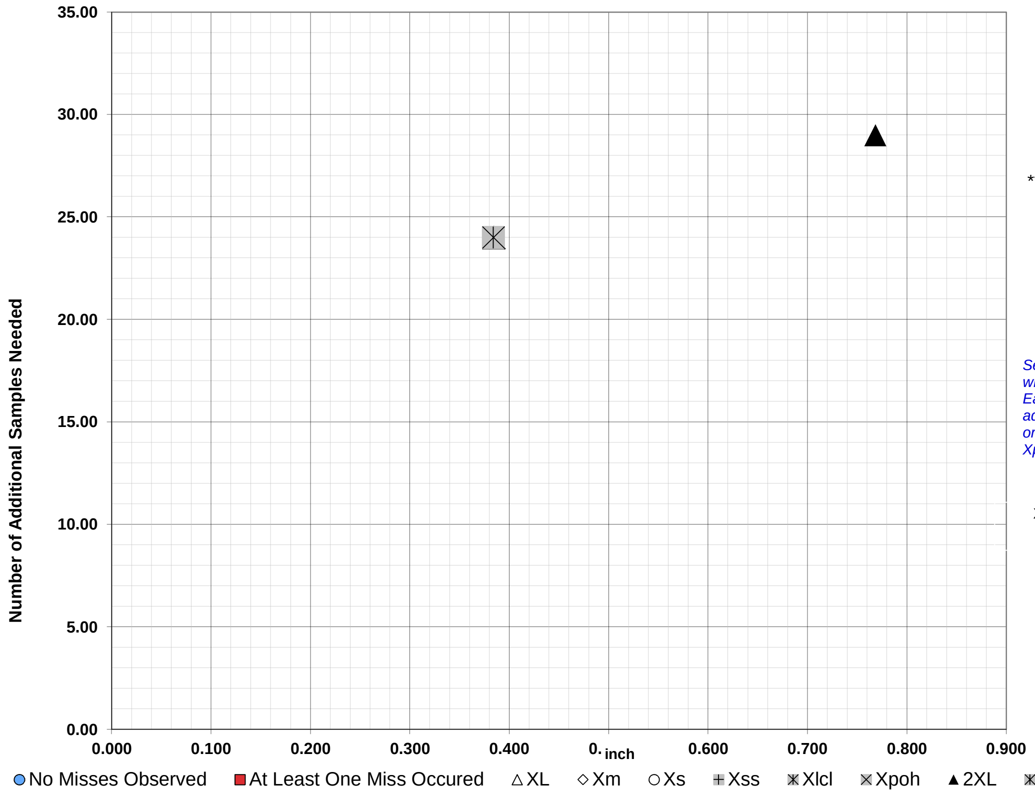


TABLE C

	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*

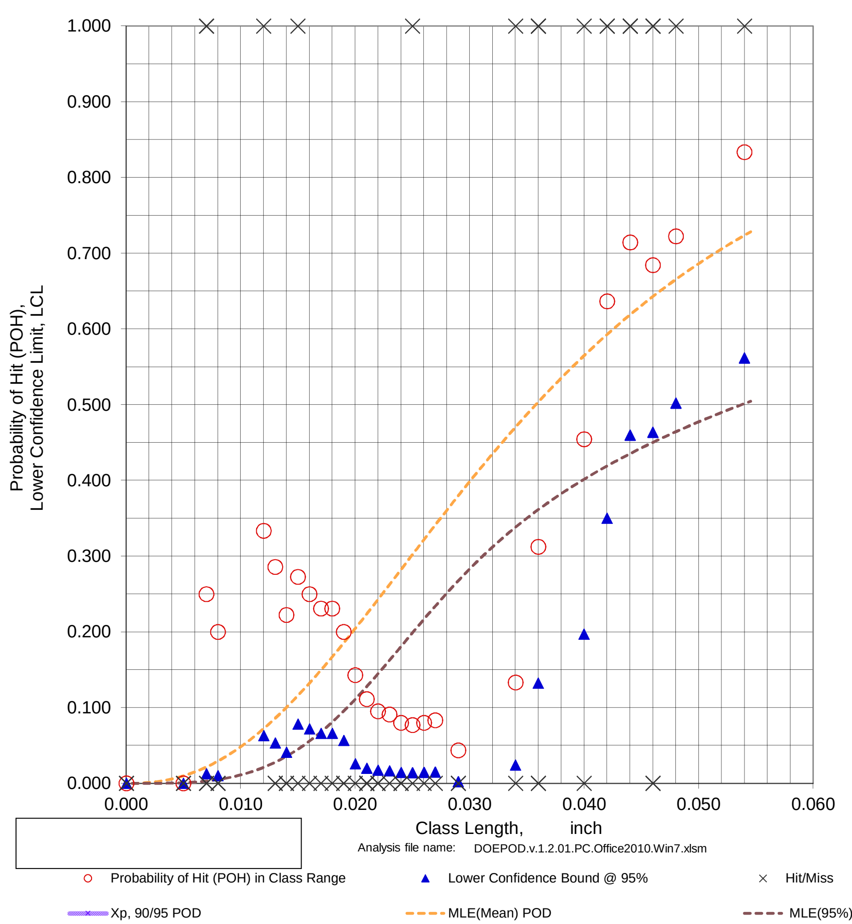
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.

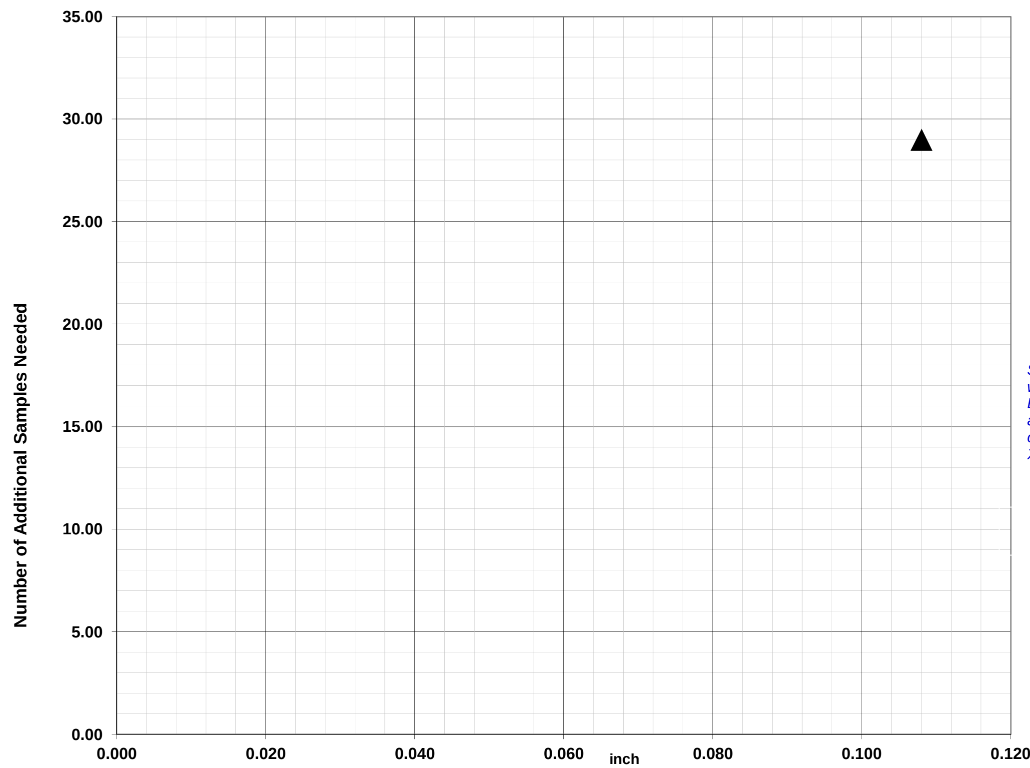
Survey/Optimum Xpoh = 0.0480 -0.001 inch 28 Samples

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



No Misses Observed   At Least One Miss Occured   XL   Xm   Xs   Xss   Xlcl   Xpoh   2XL   Xpod   Xpodopt

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.

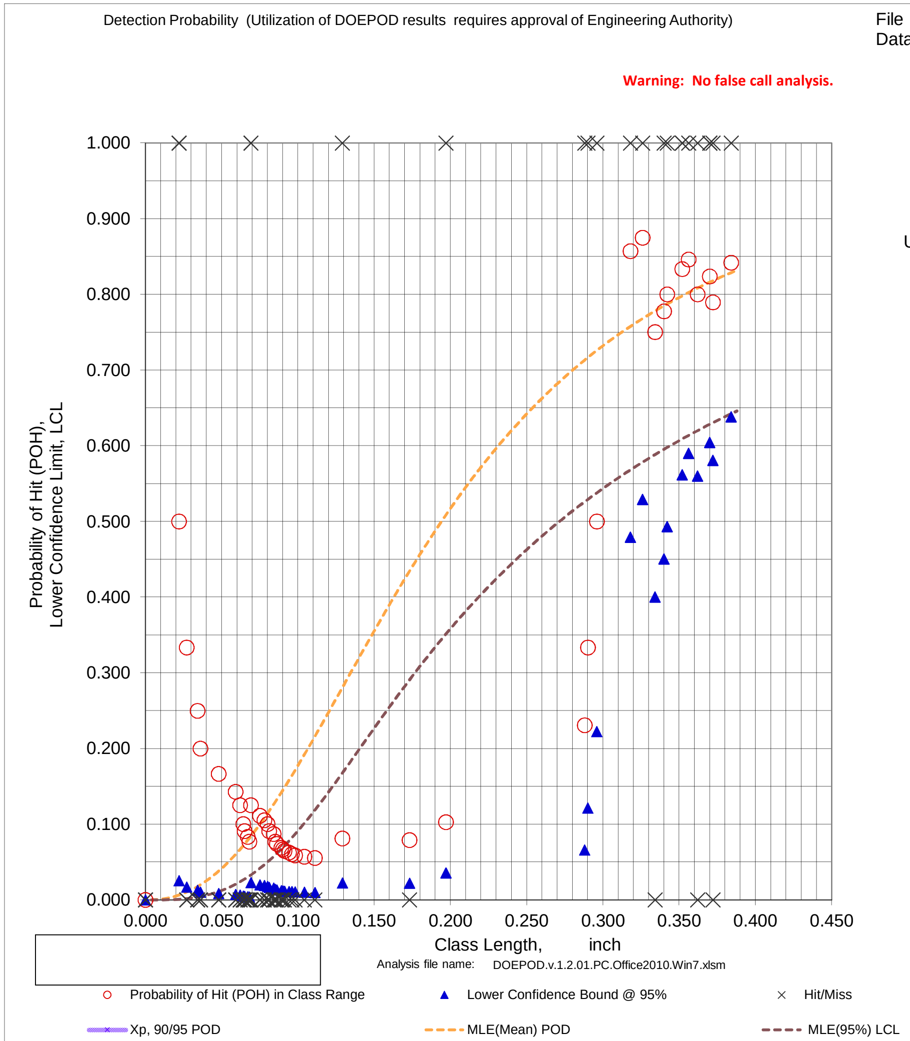
Xpod,Class Length	No. Need

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



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

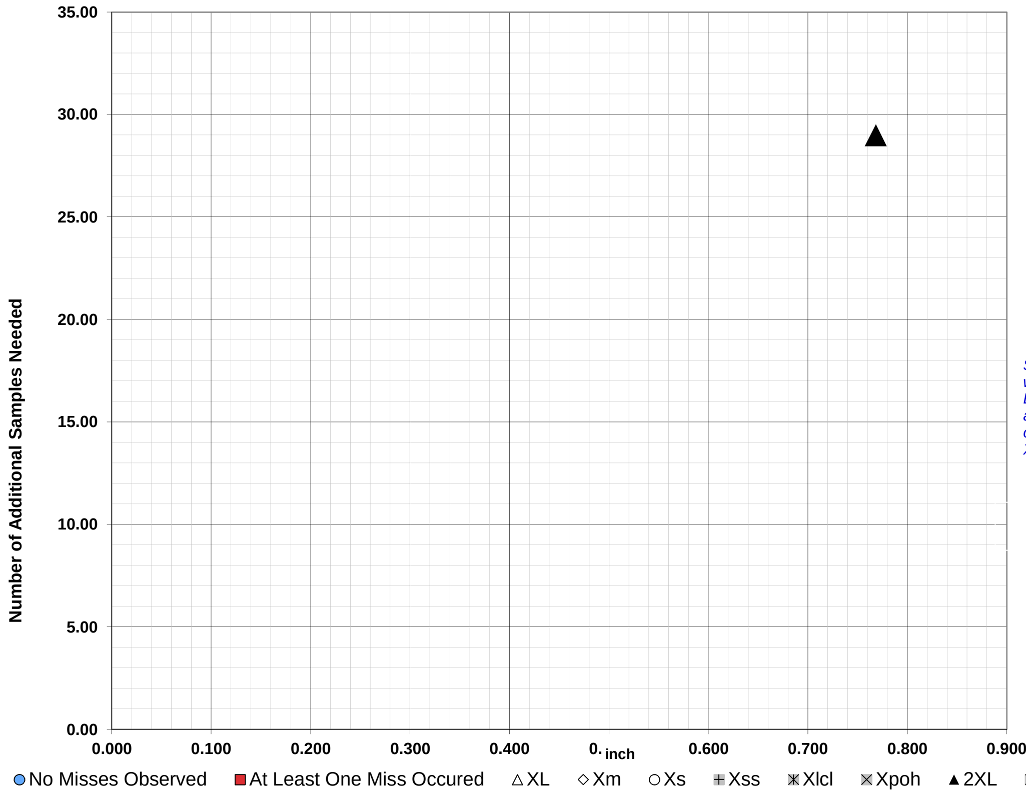


TABLE C

	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*

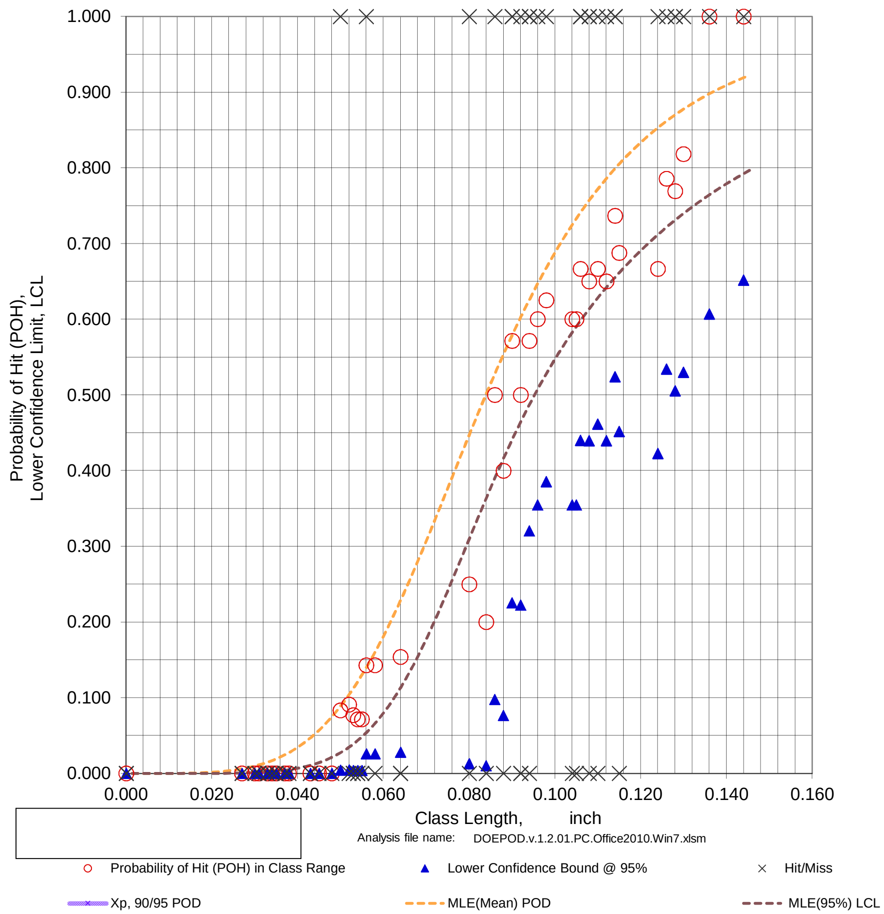
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

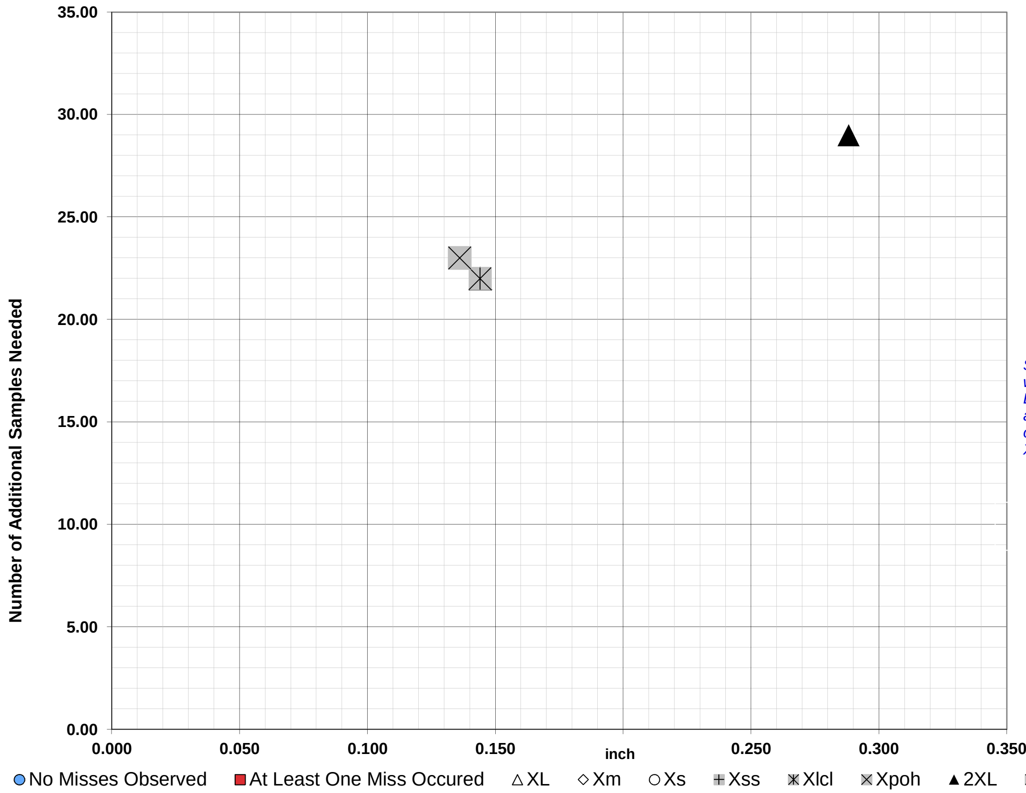


TABLE C

	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*

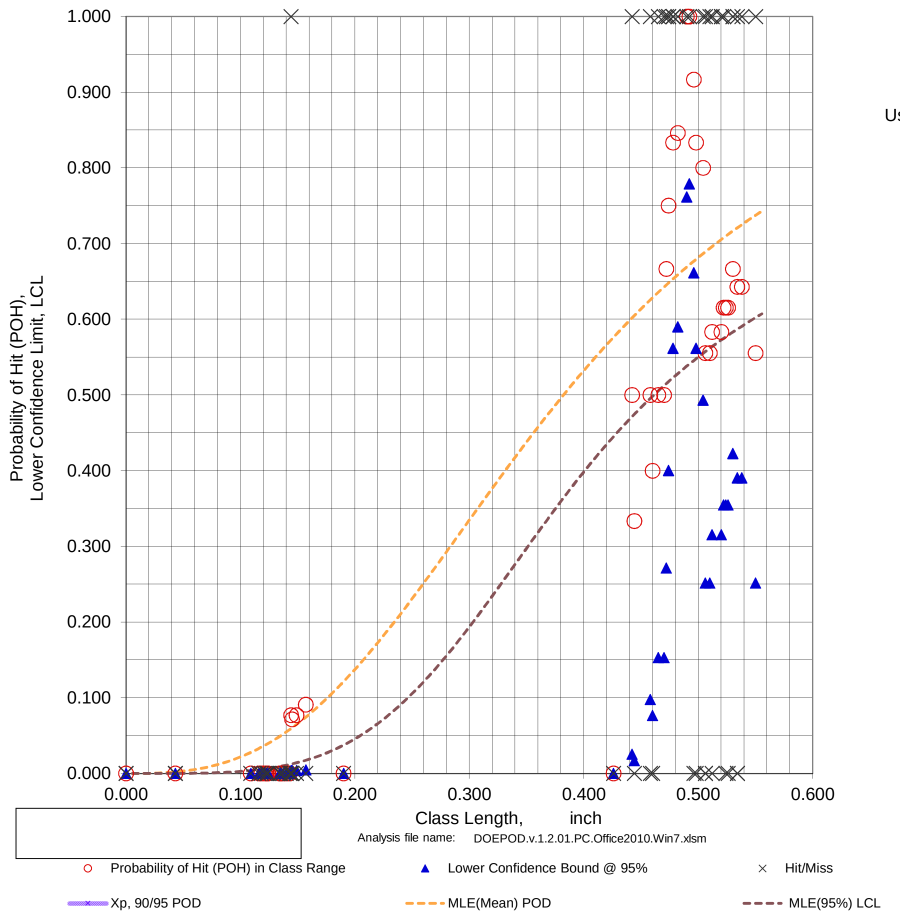
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

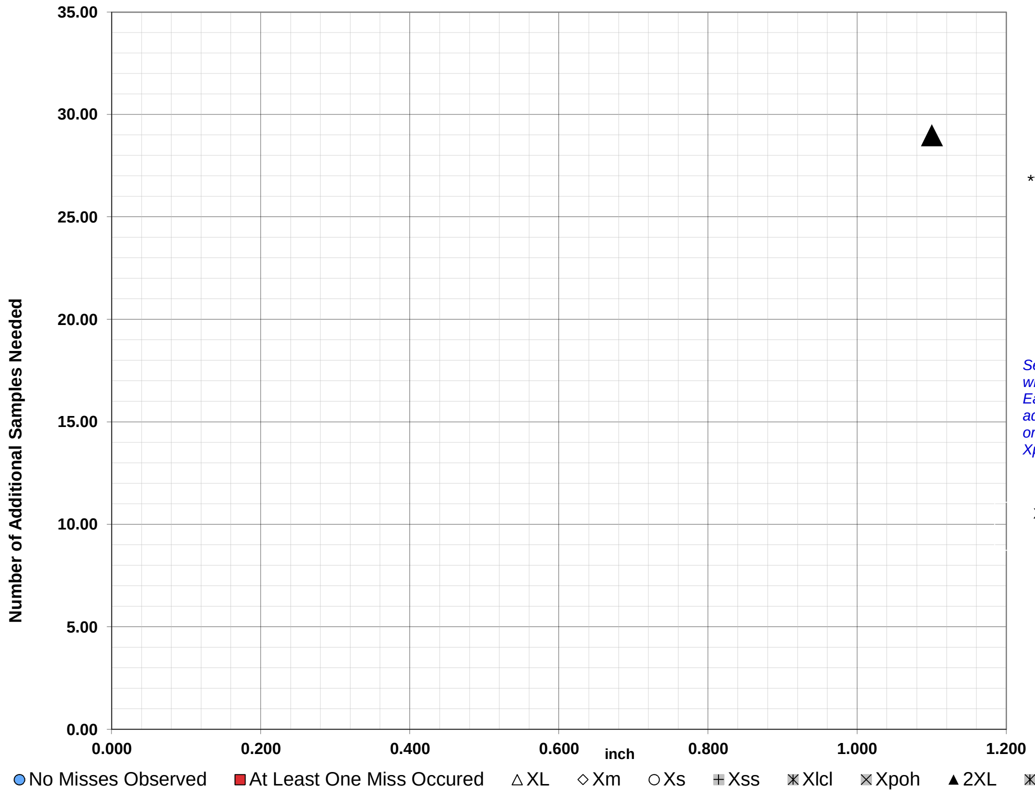


TABLE C

	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*

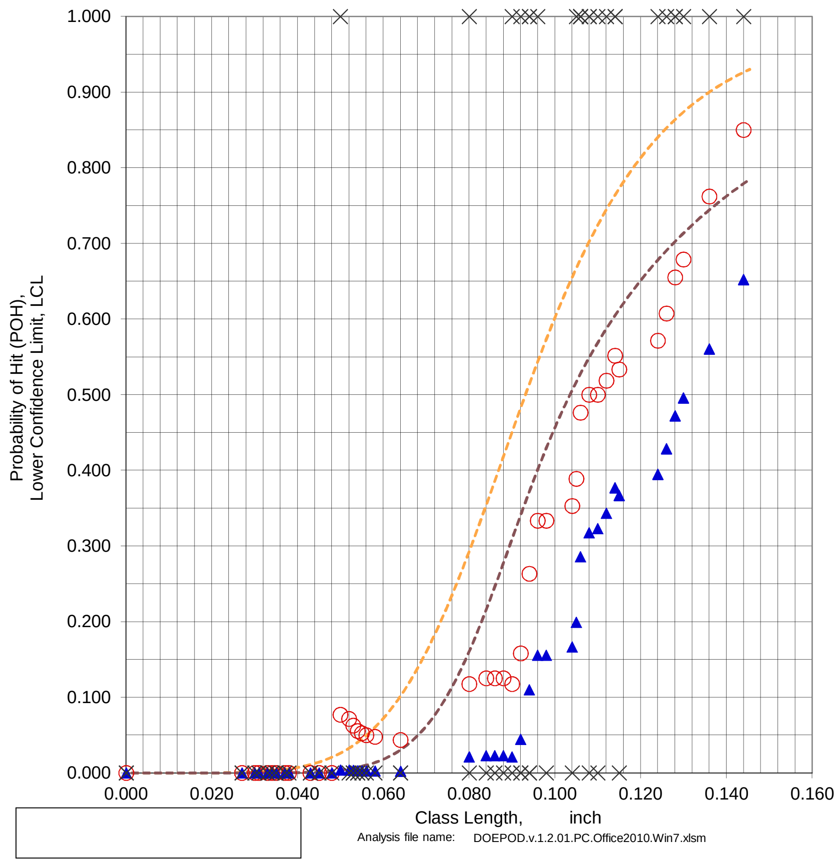
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

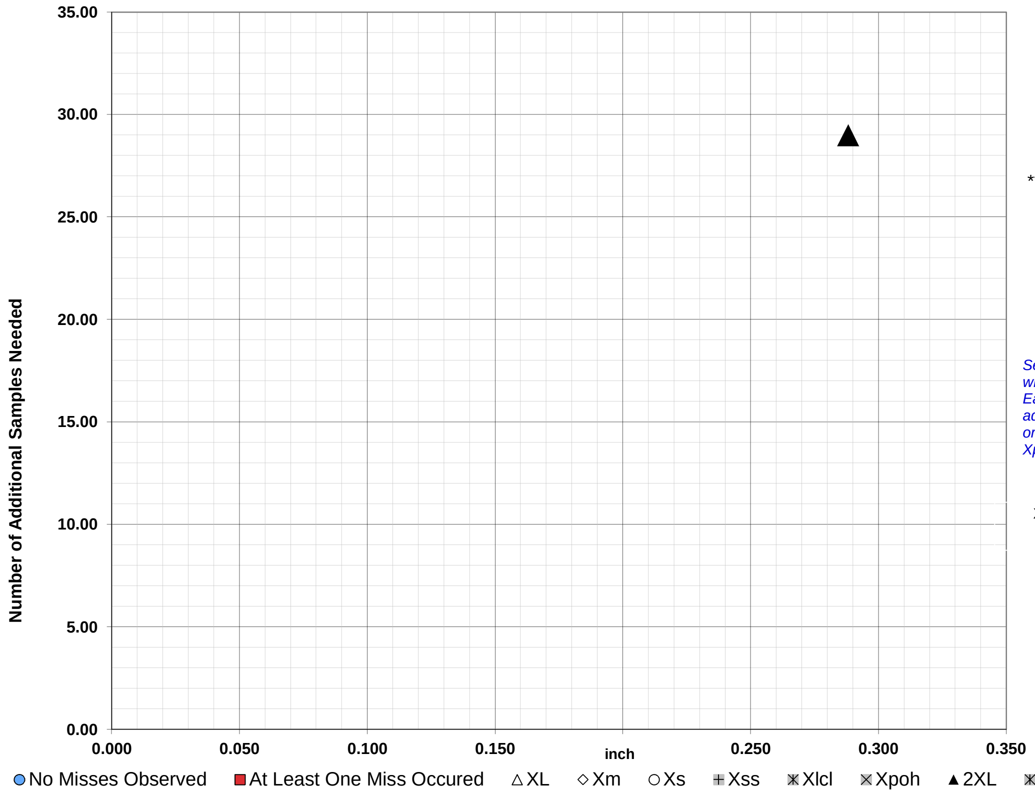


TABLE C

	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*

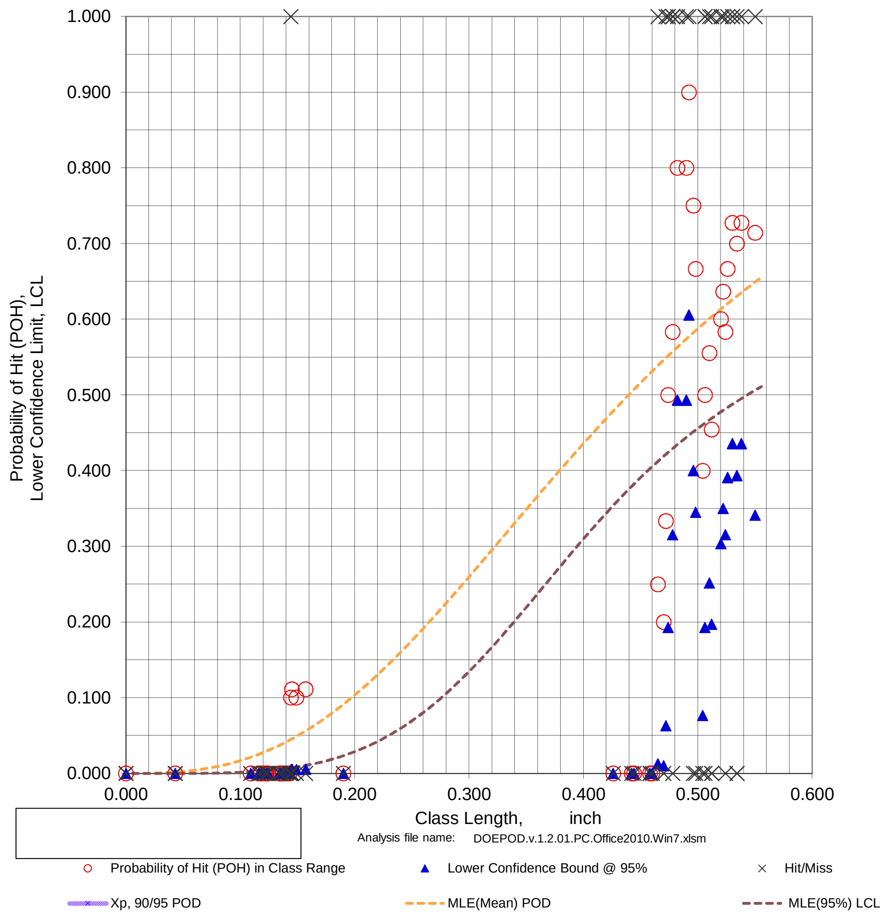
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

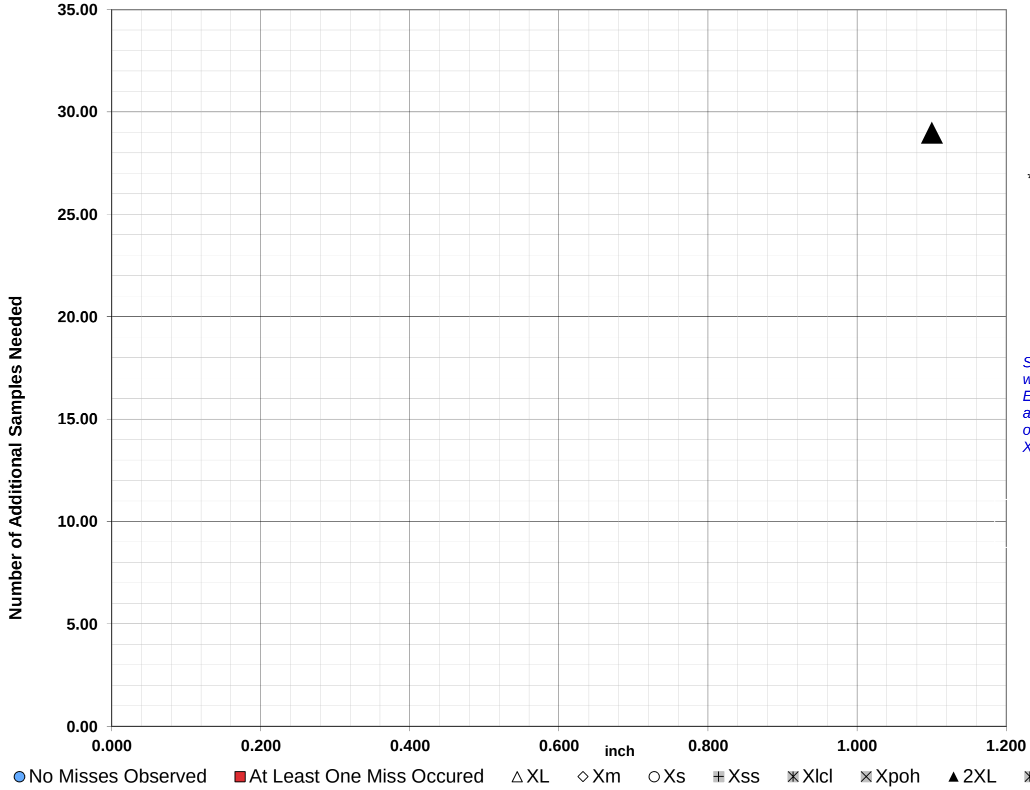


TABLE C

	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*

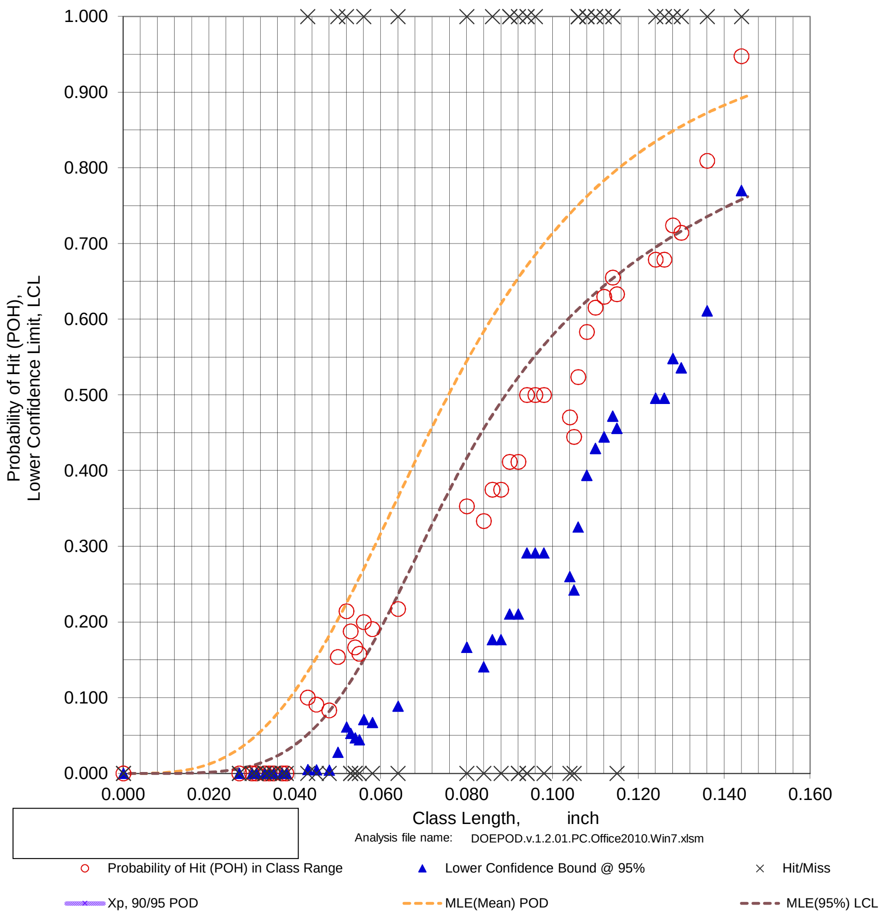
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

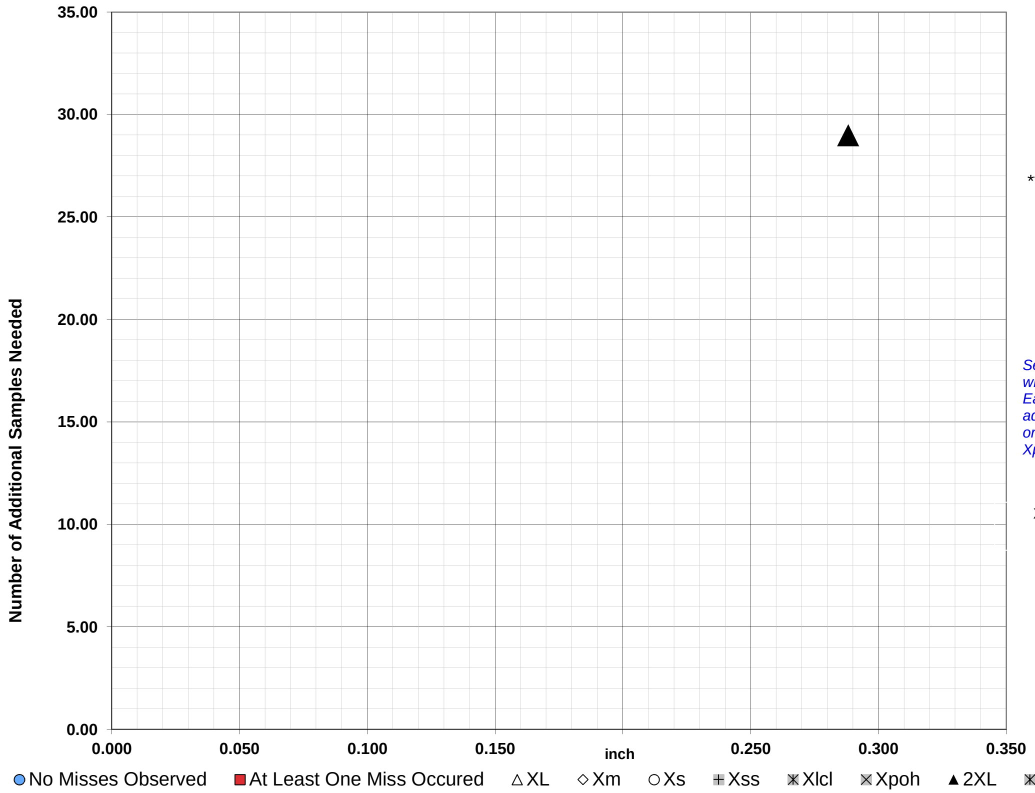


TABLE C

	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*

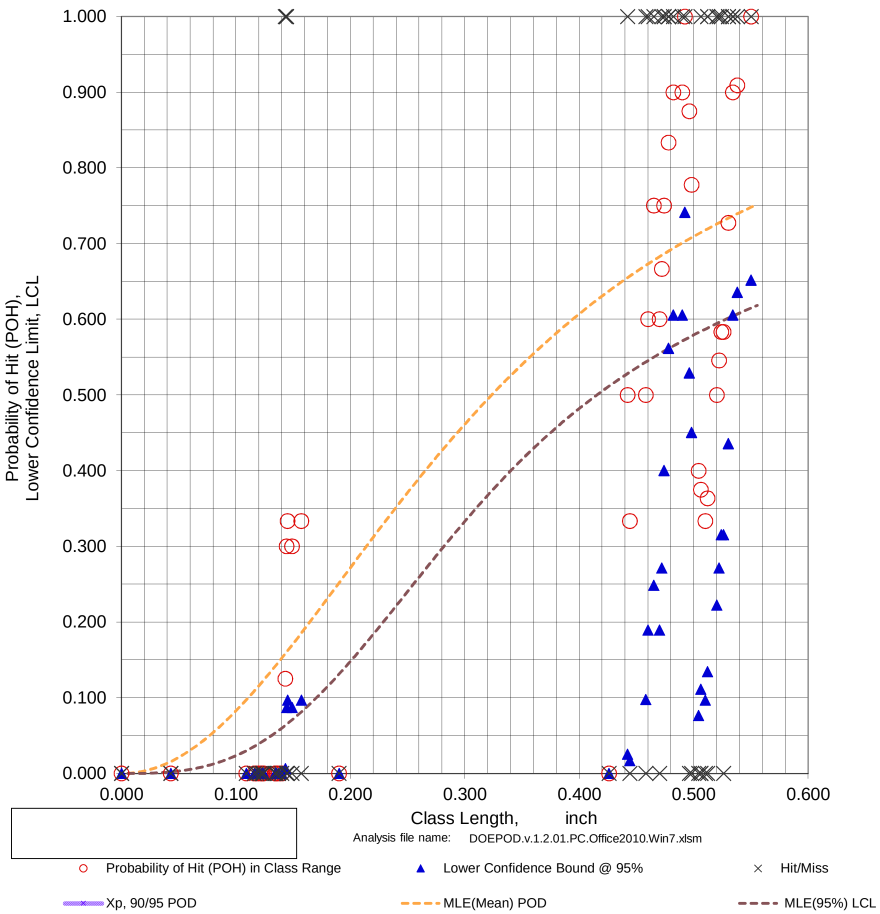
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

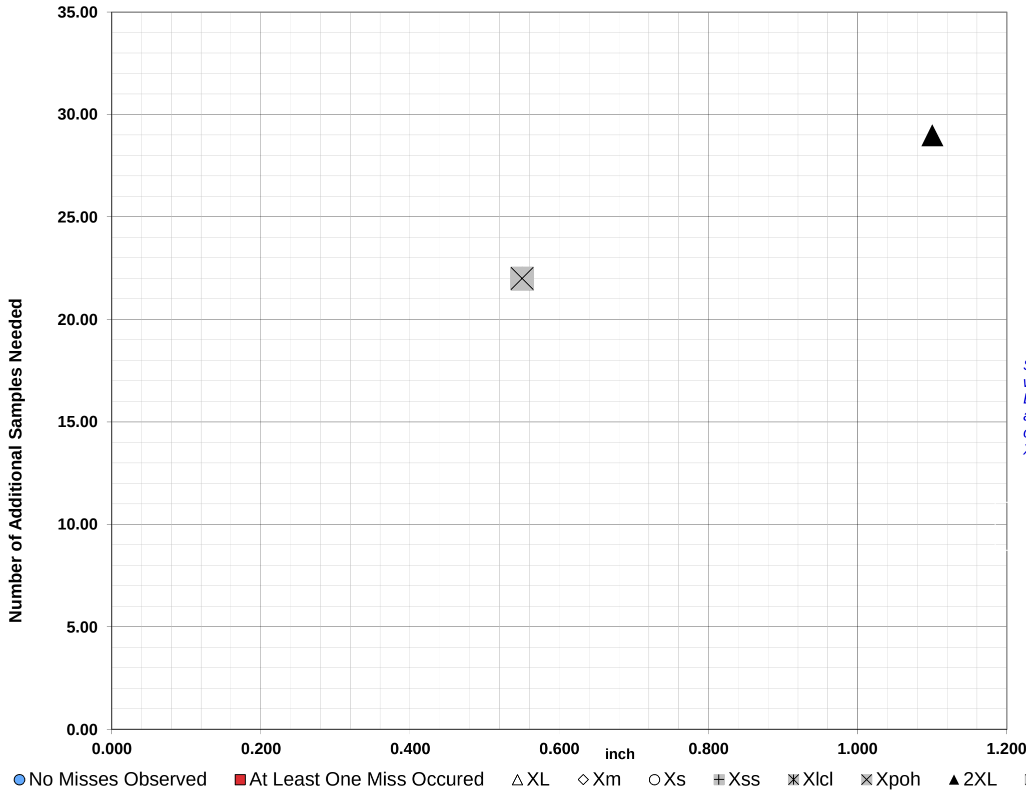


TABLE C

	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*

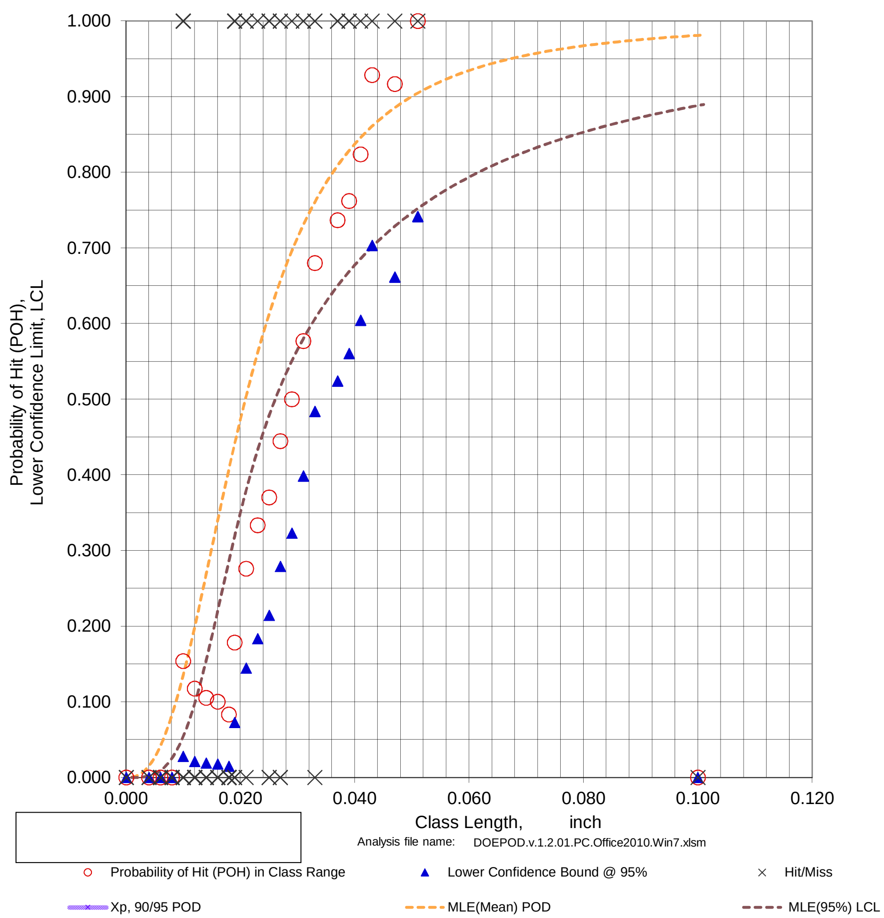
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

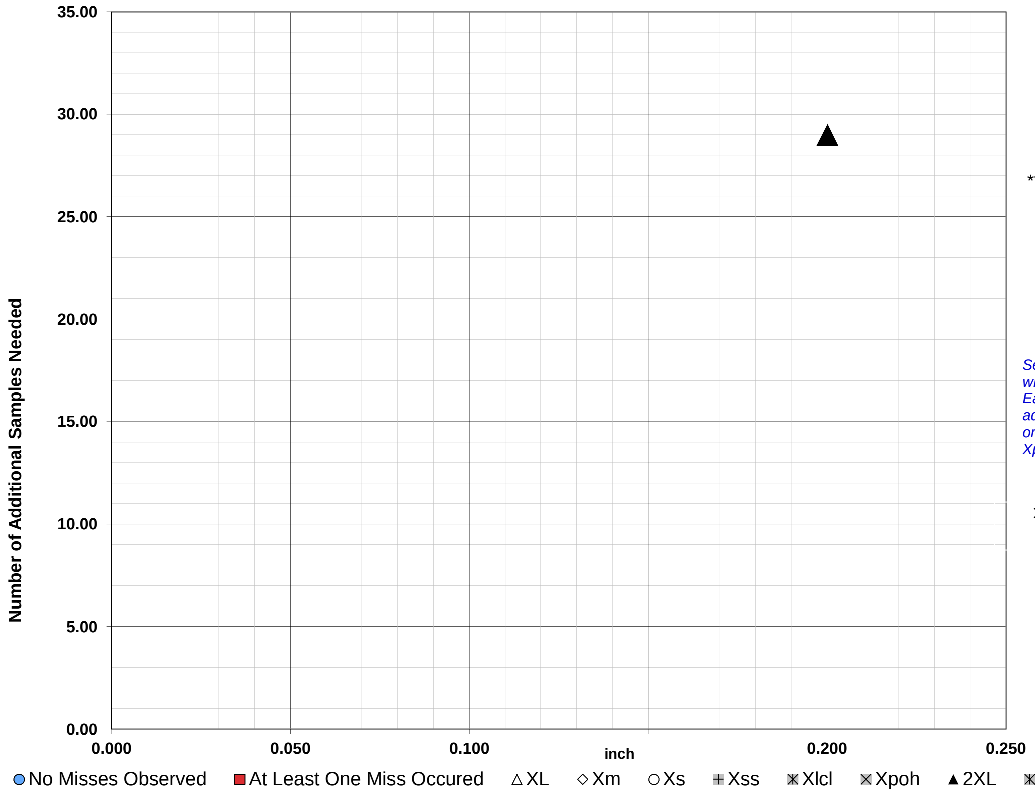


TABLE C

	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*

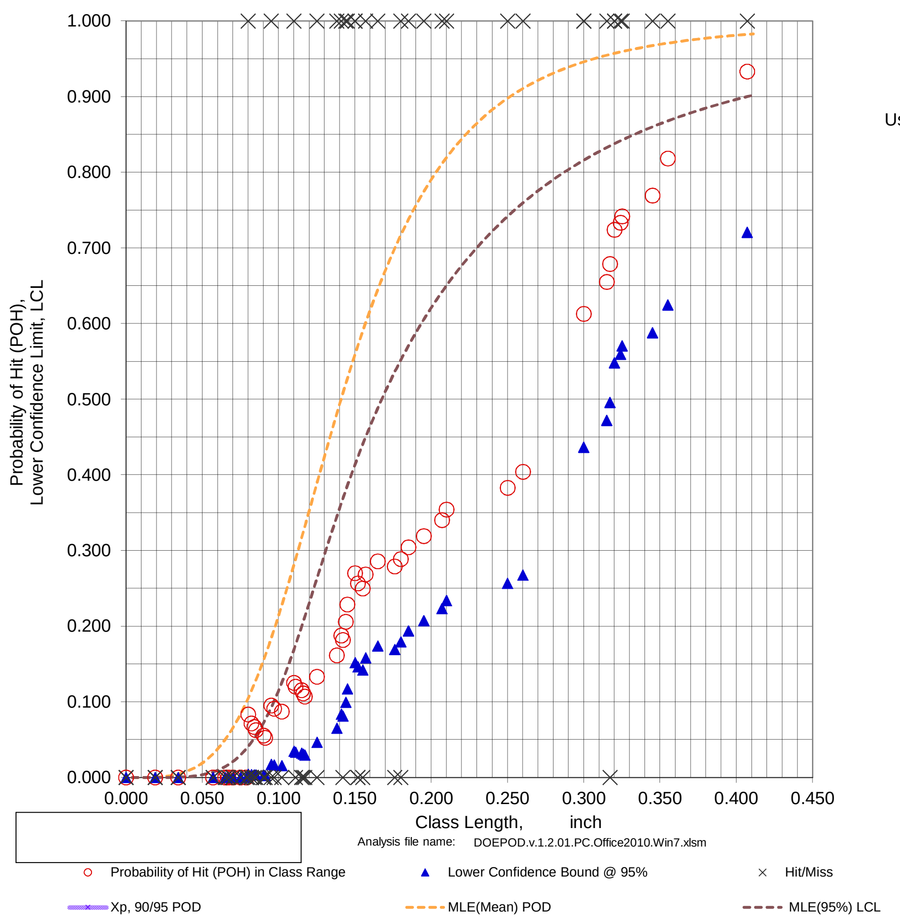
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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 #)

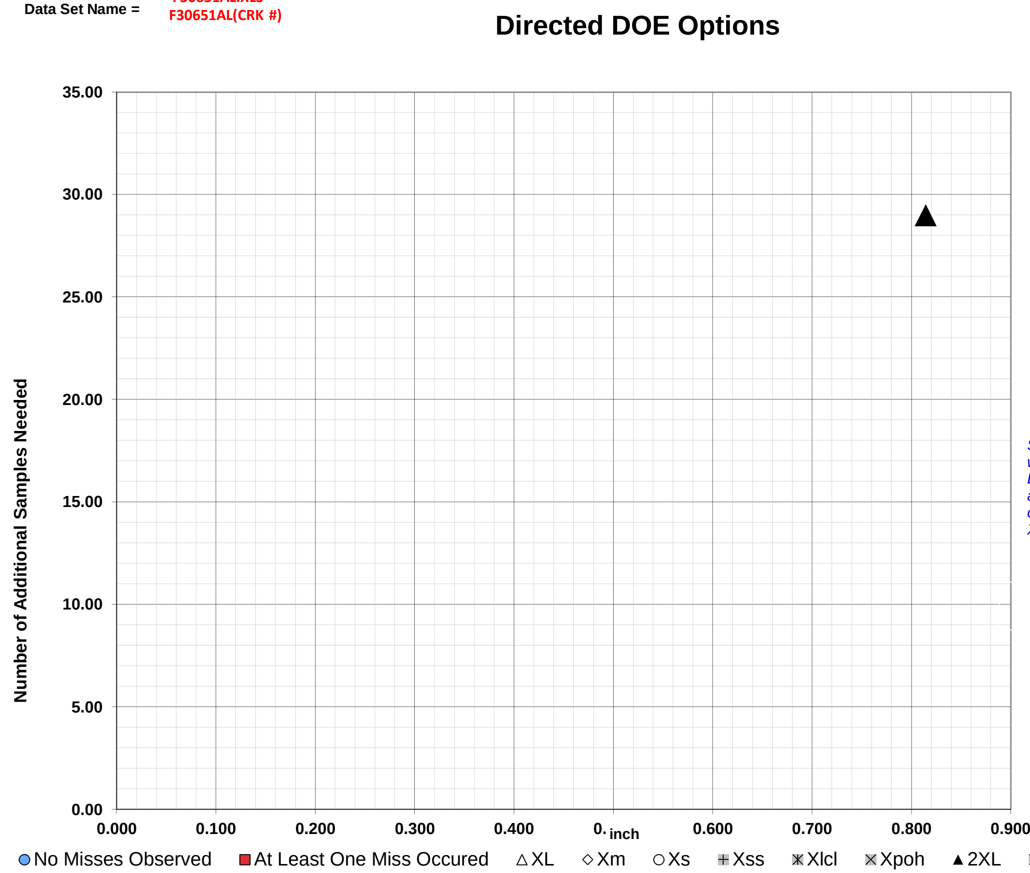


TABLE C

	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*

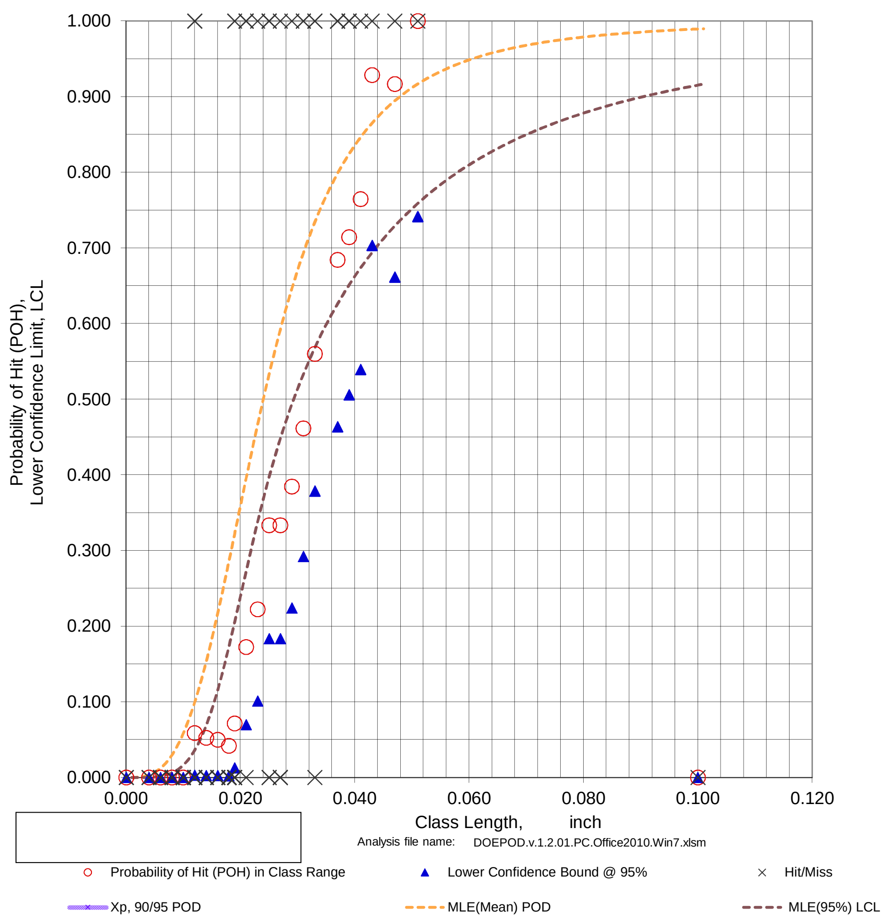
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

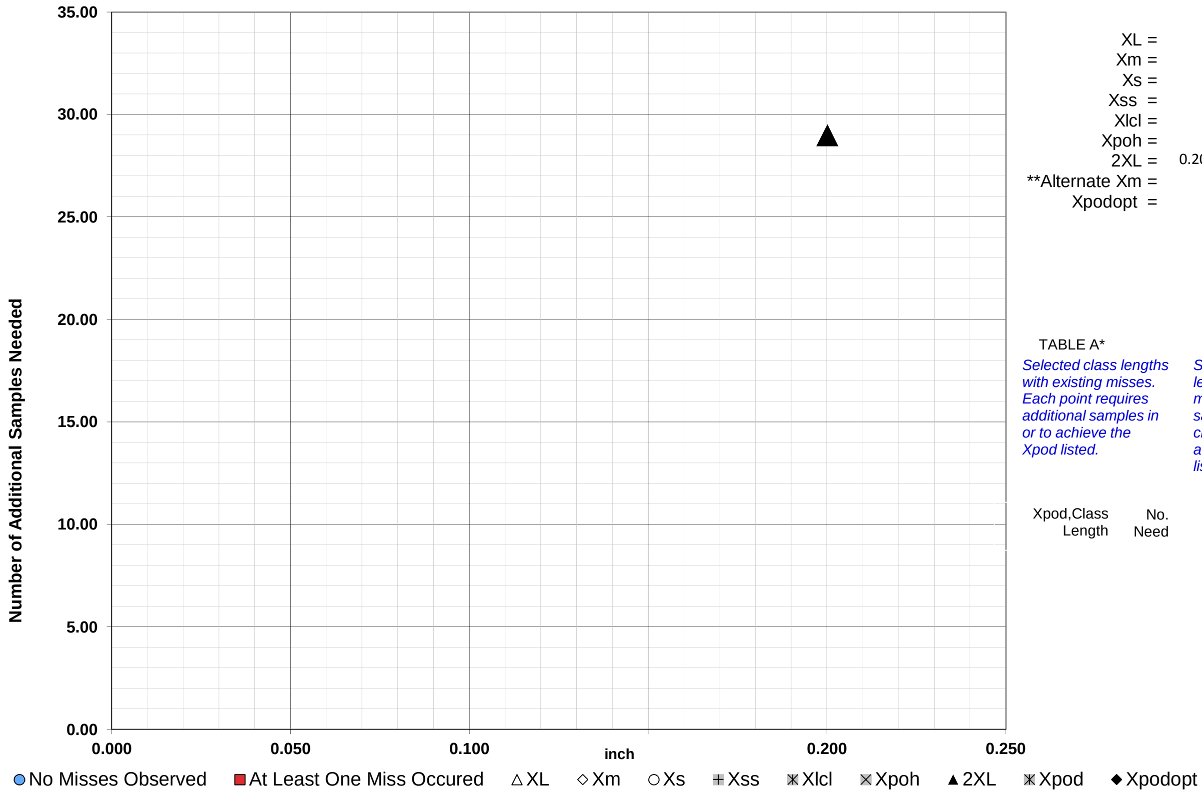


TABLE C

	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*

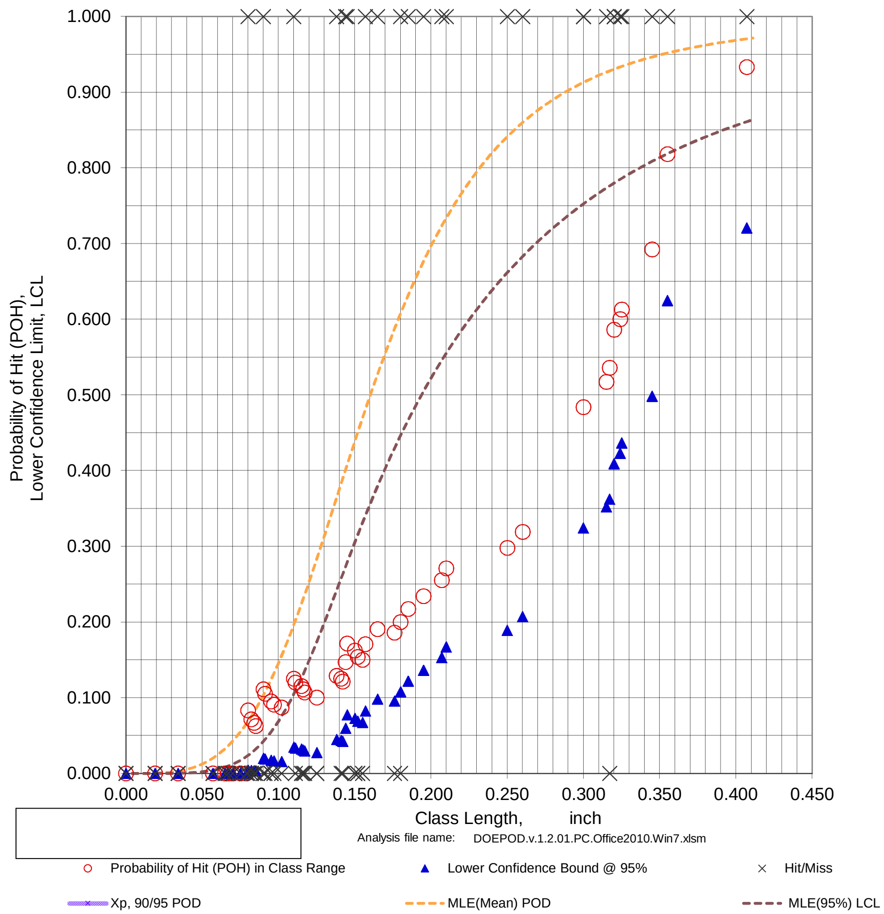
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

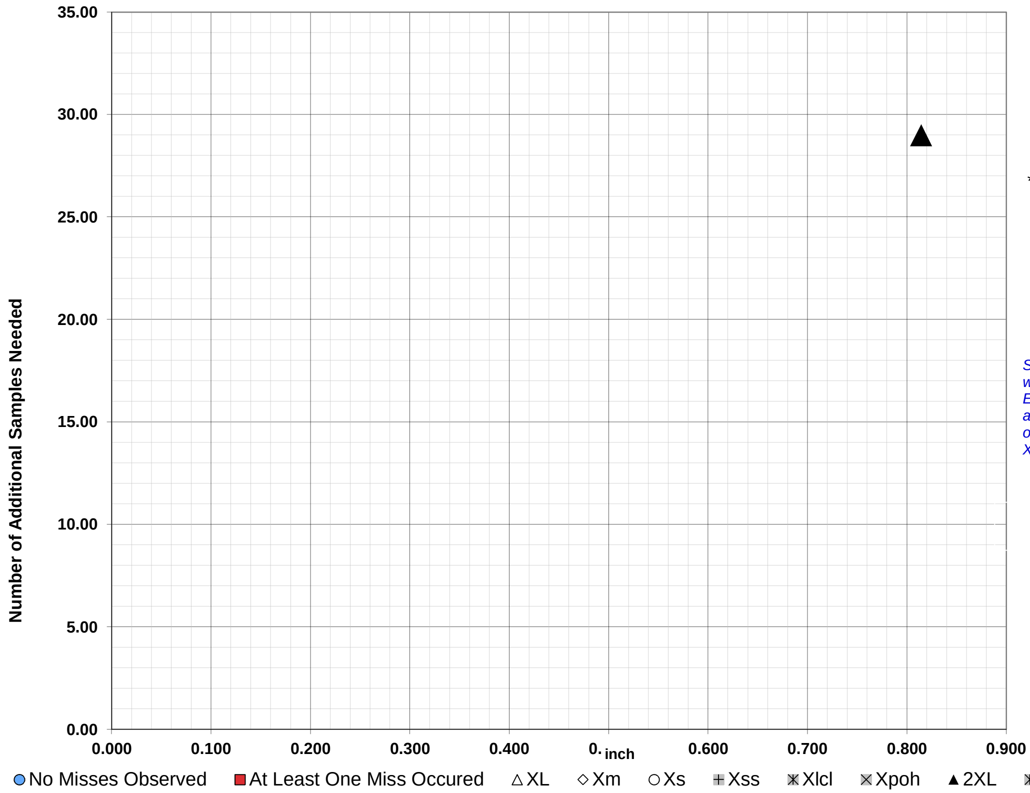


TABLE C

	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*

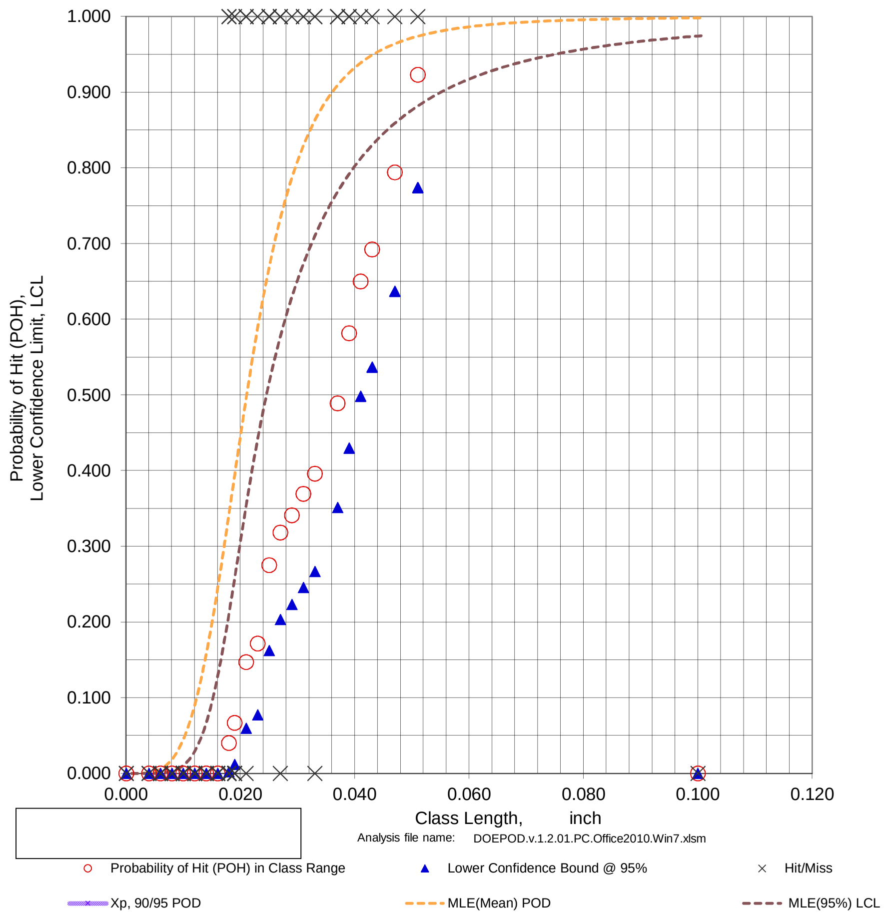
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

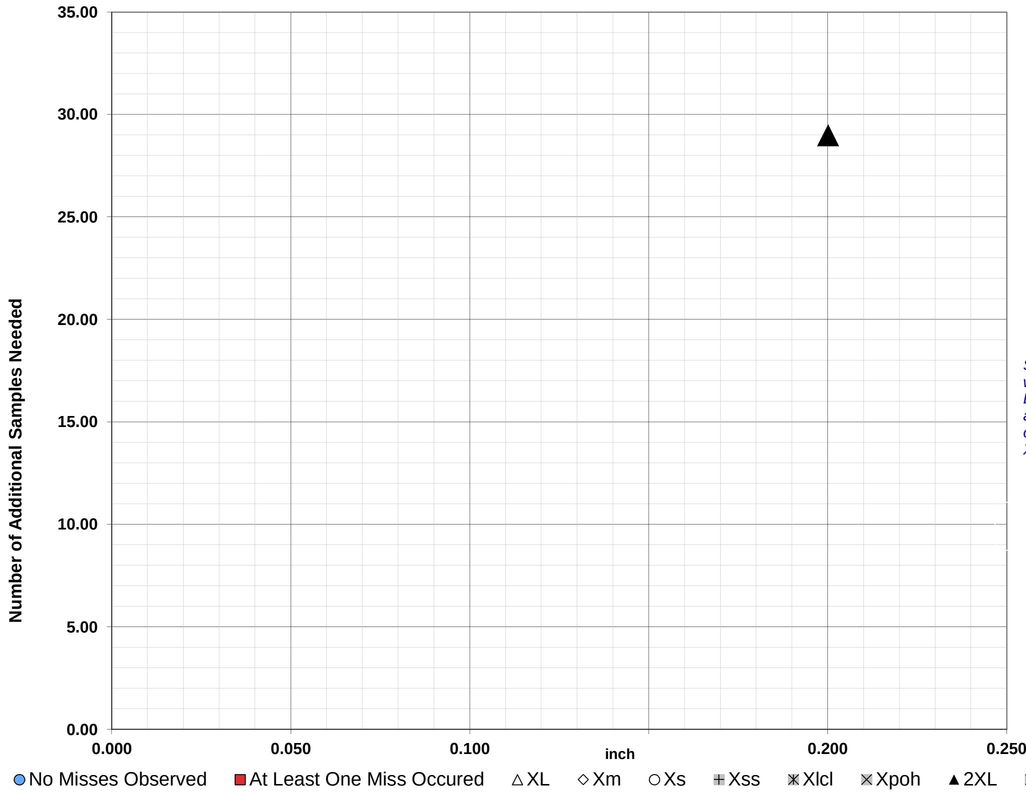


TABLE C

	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

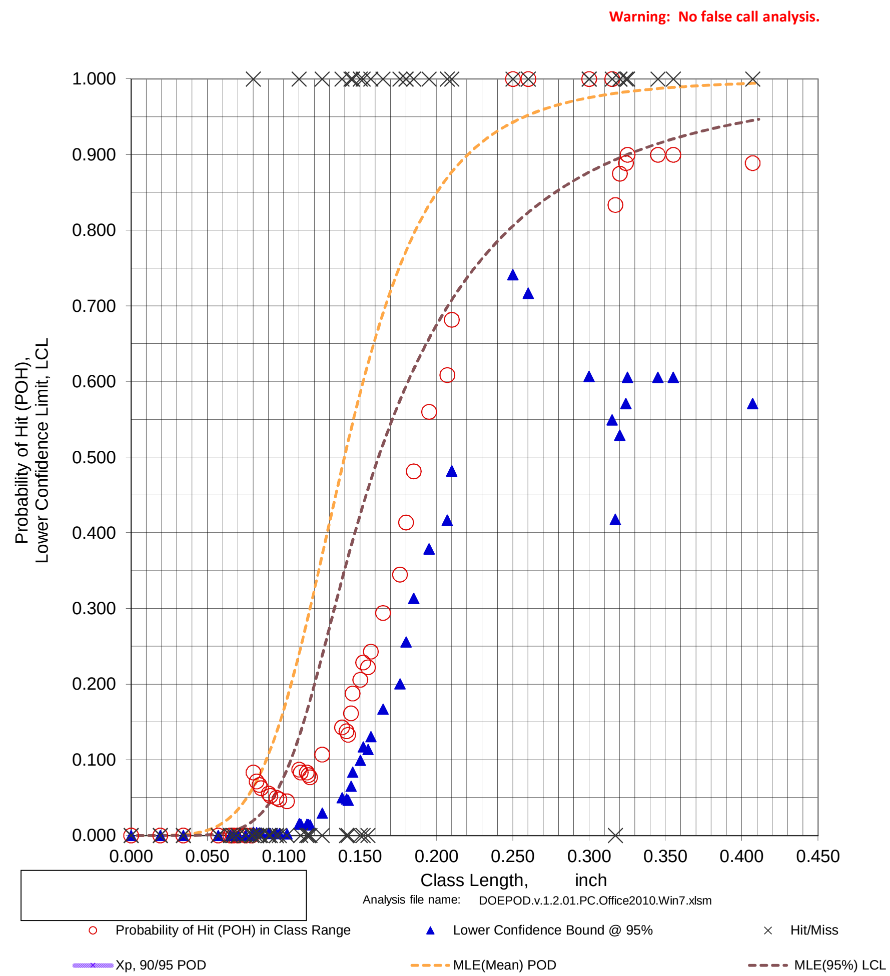
TABLE B*

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)



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

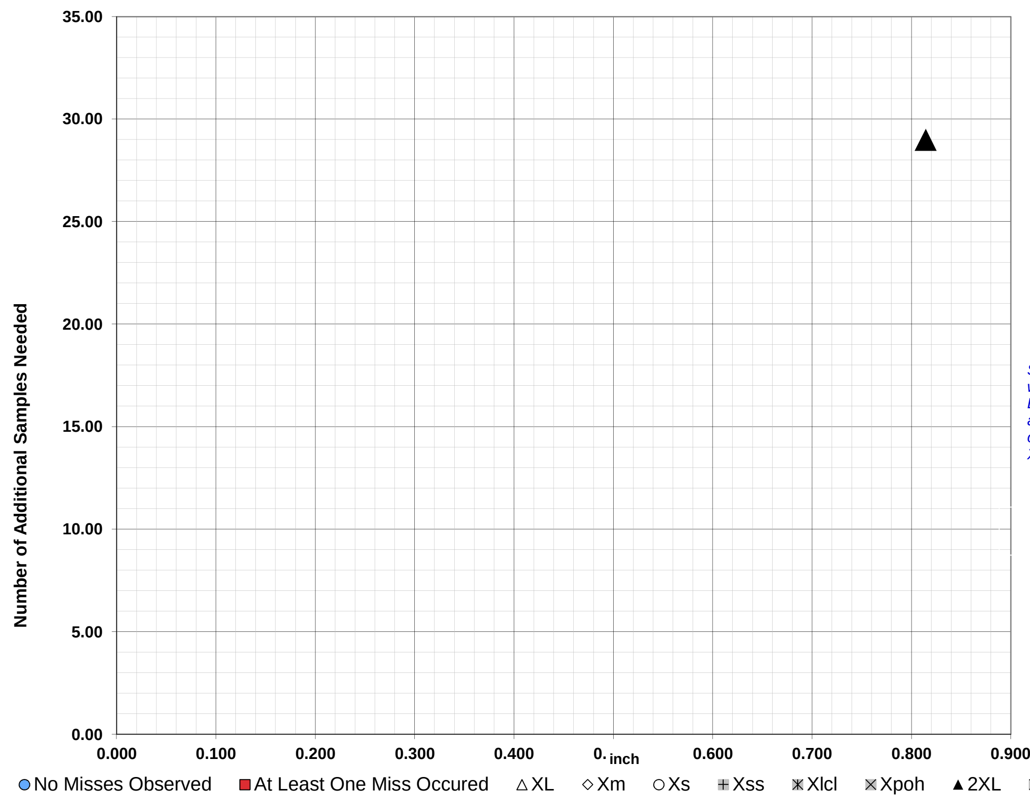


TABLE C

	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*

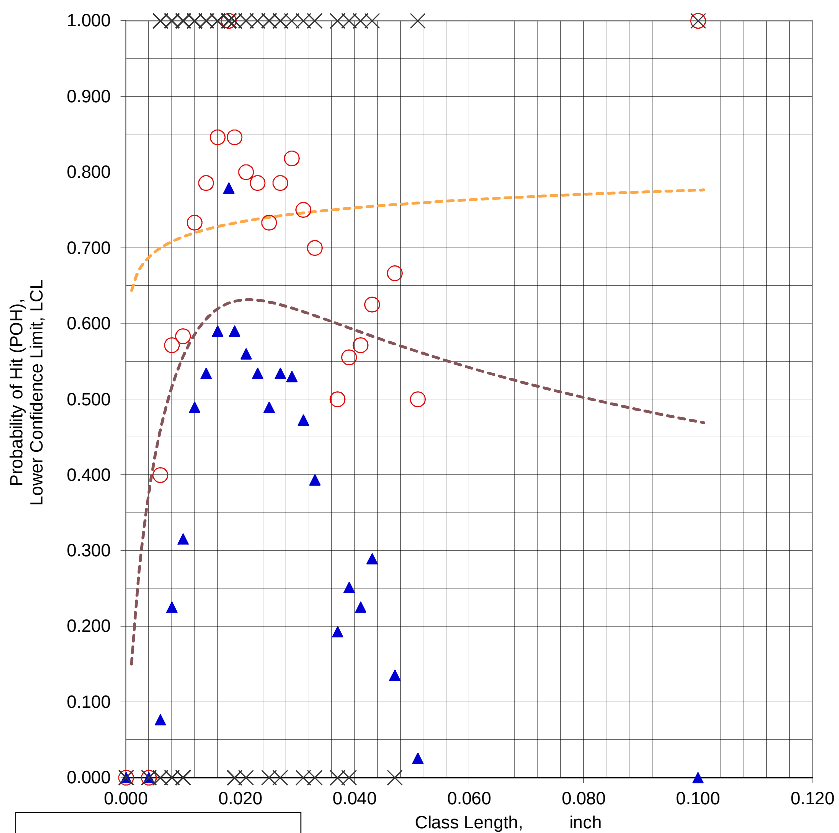
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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 = **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

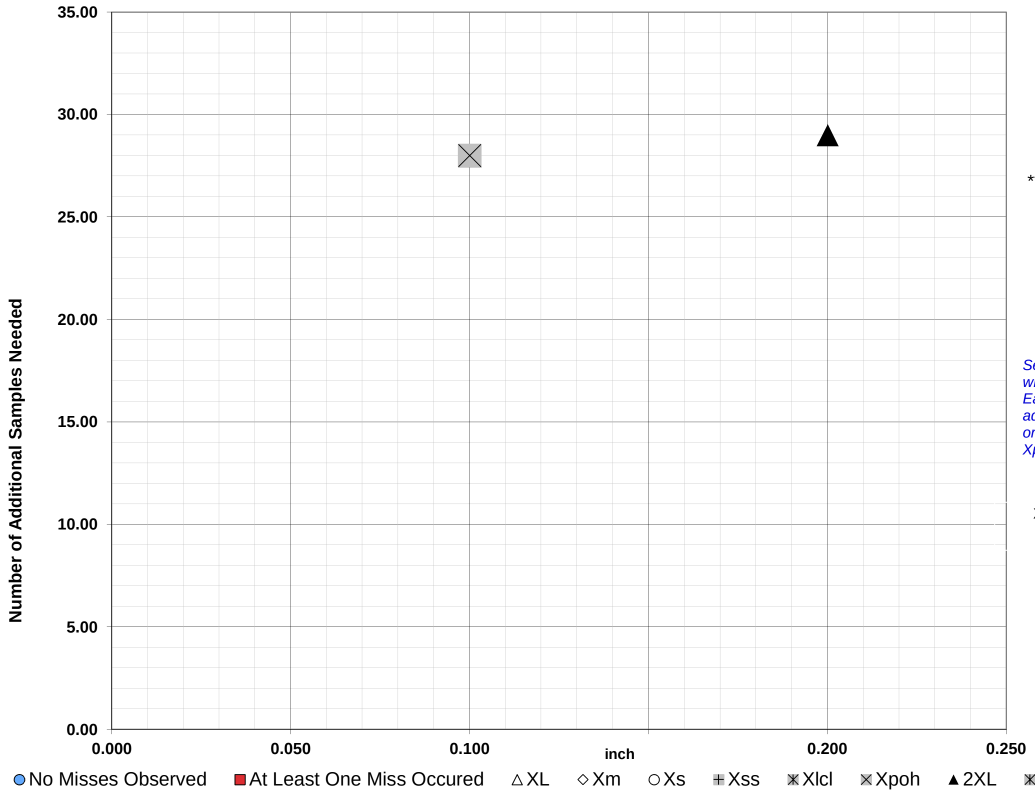


TABLE C

	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.

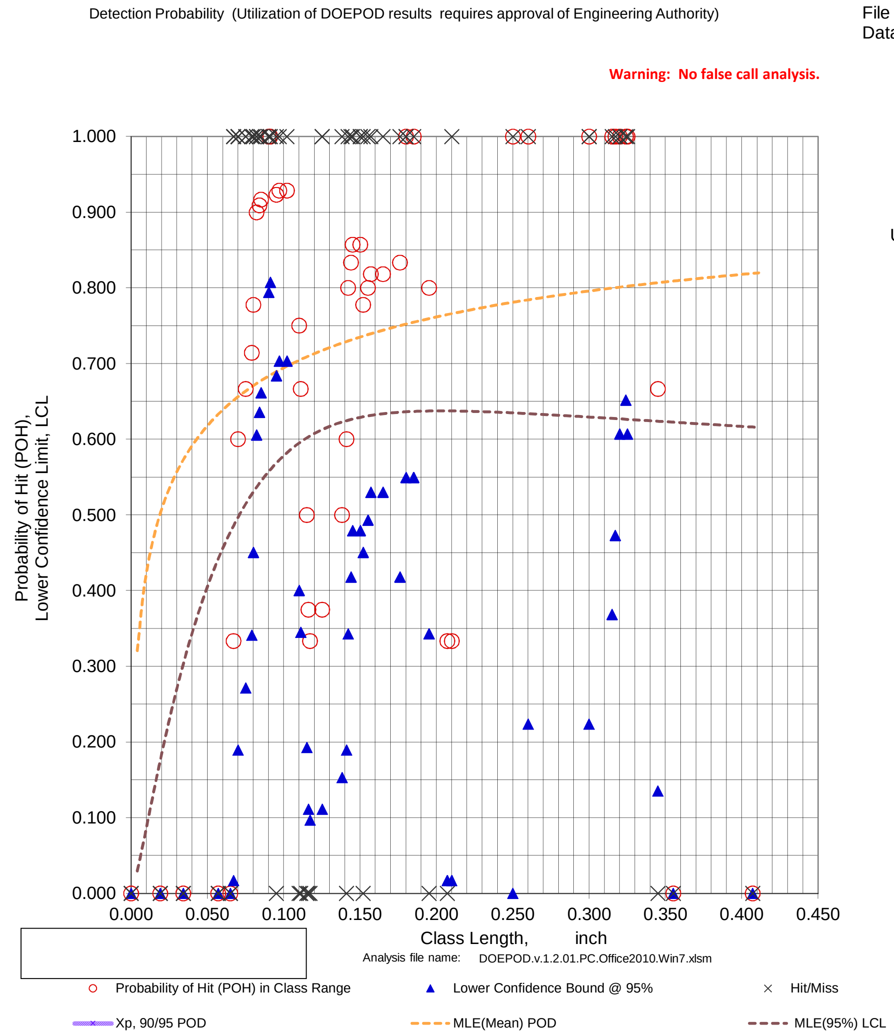
Xpod,Class Length	No. Need

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



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

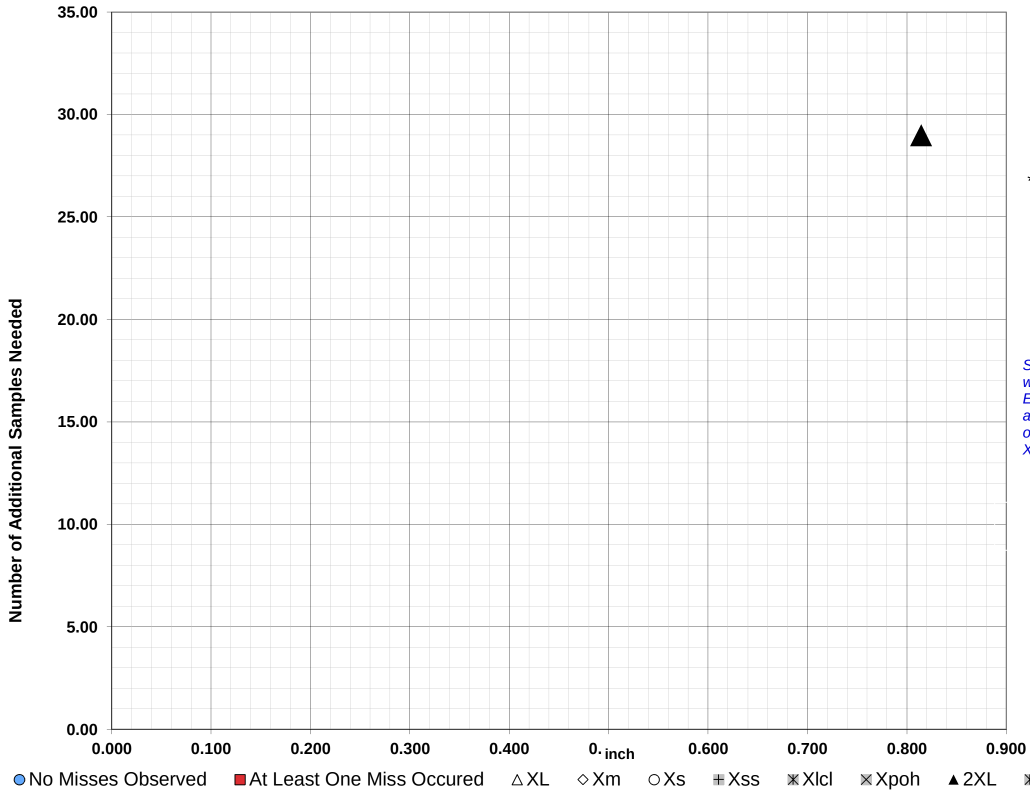


TABLE C

	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*

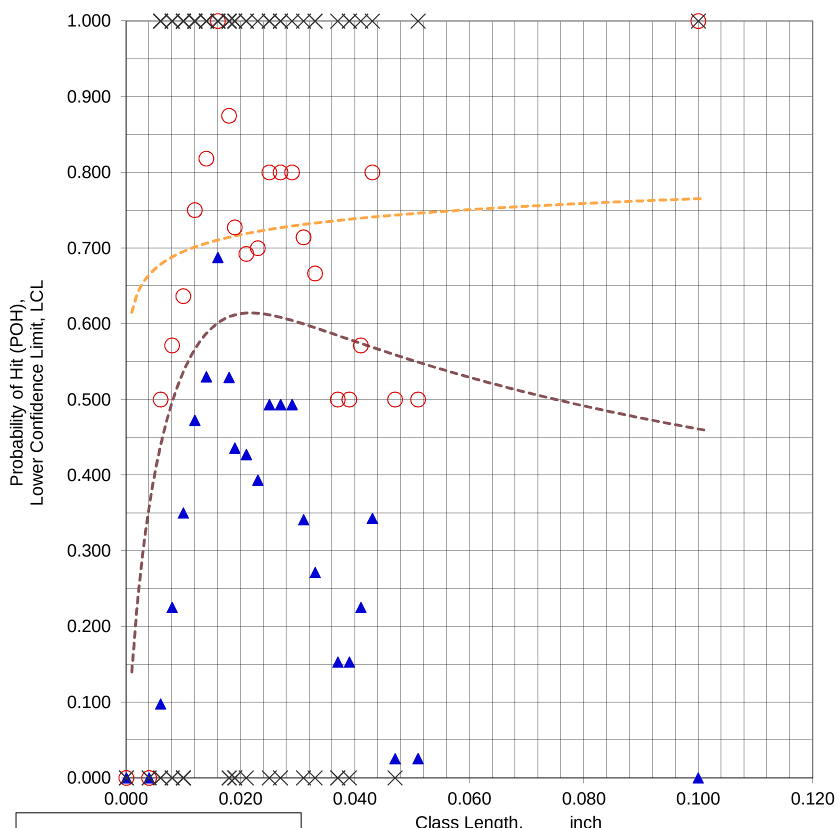
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

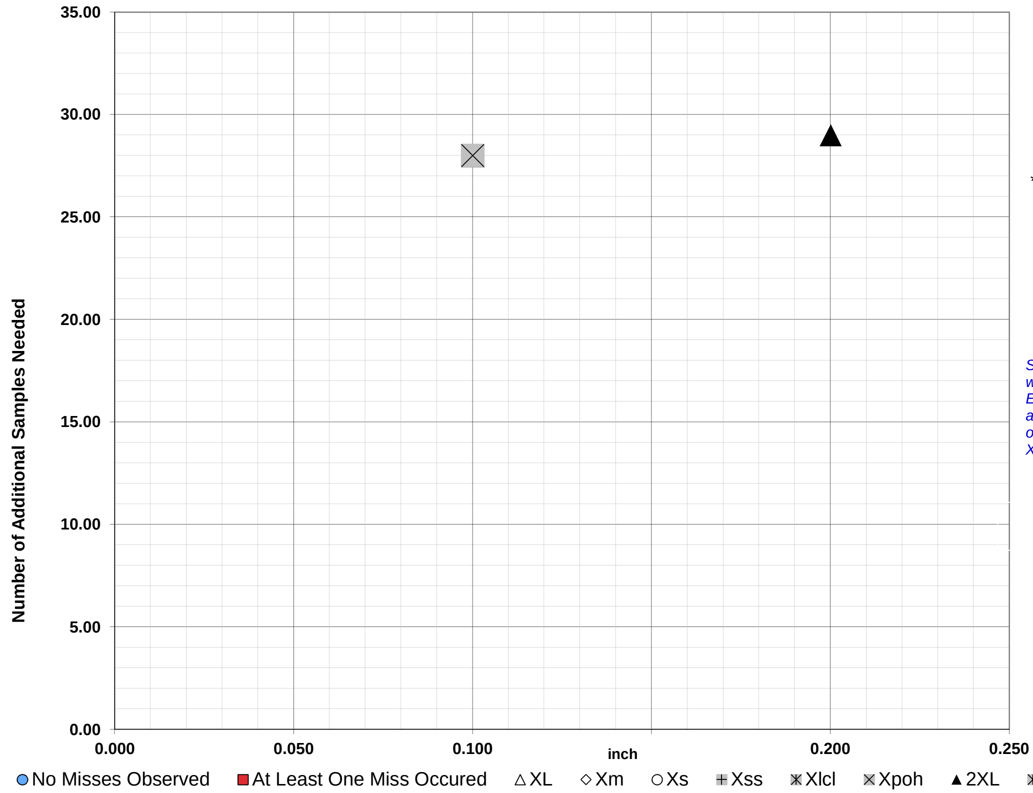


TABLE C

	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*

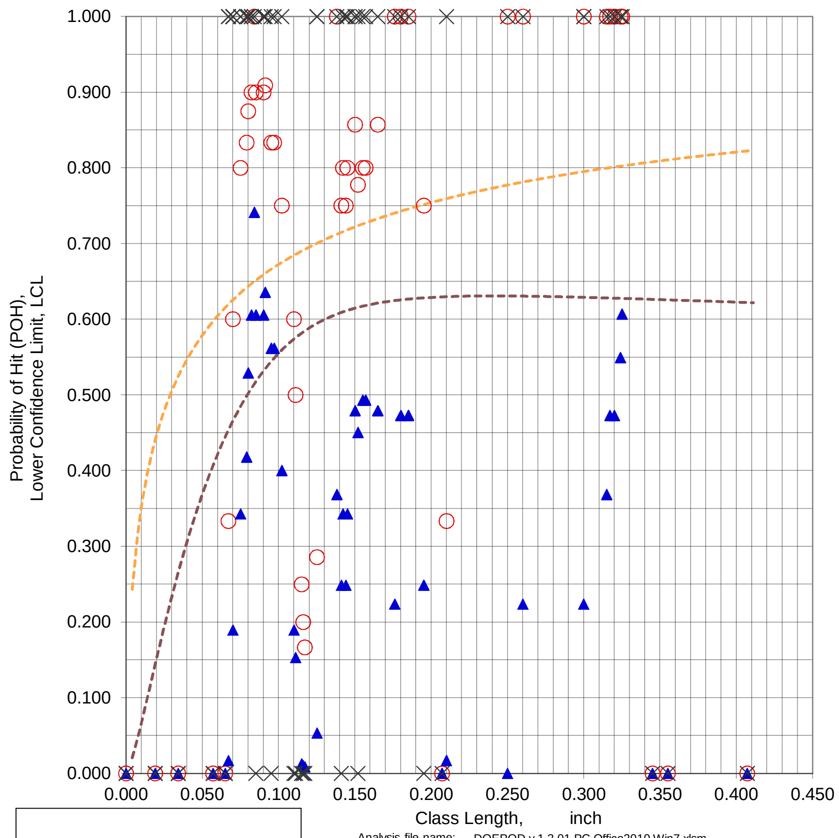
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

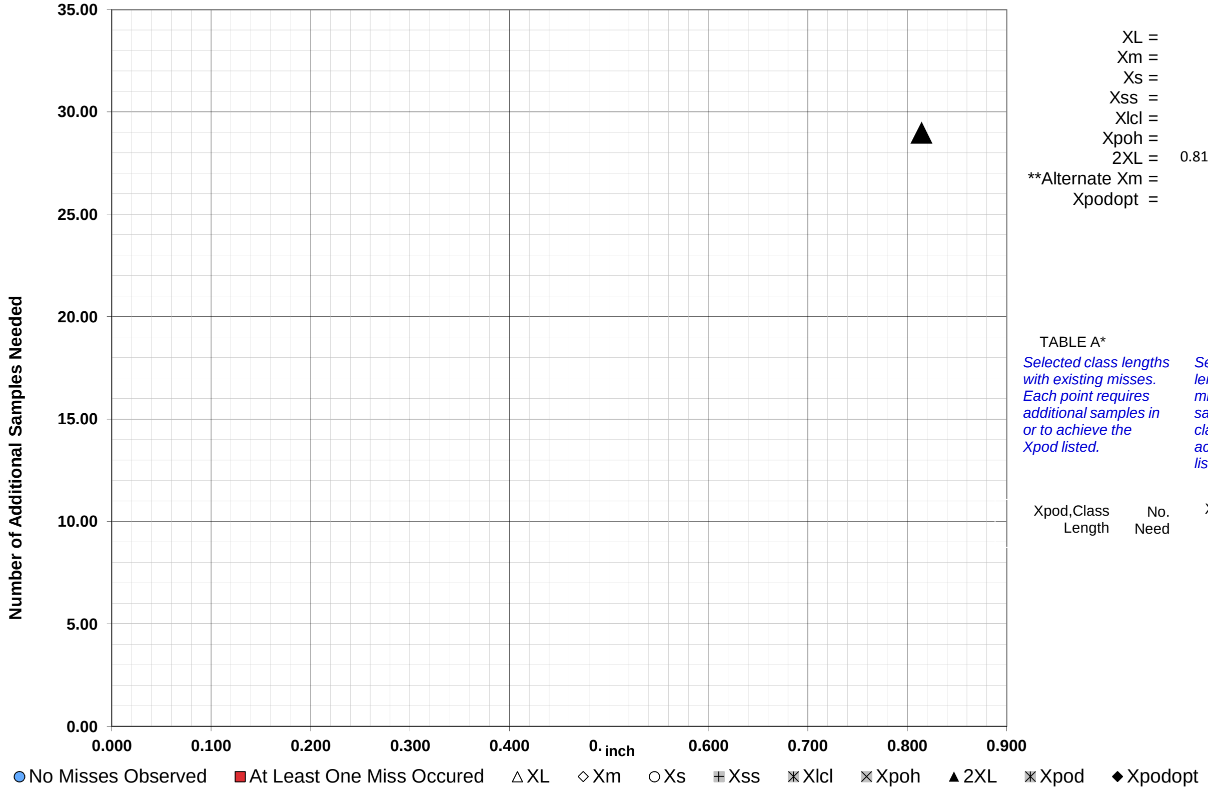


TABLE C

	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*

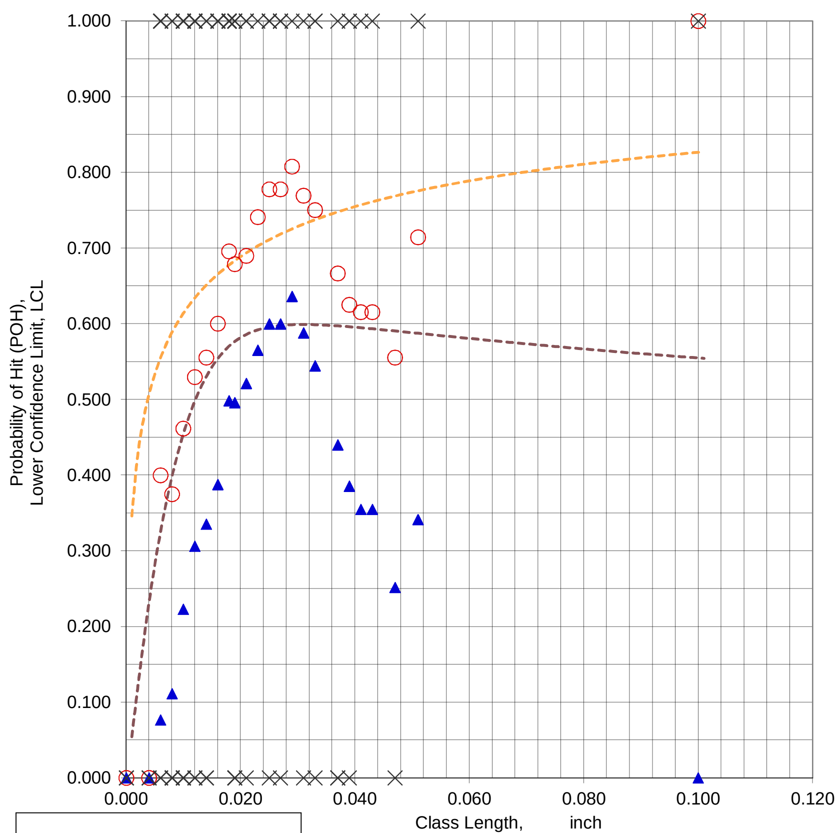
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

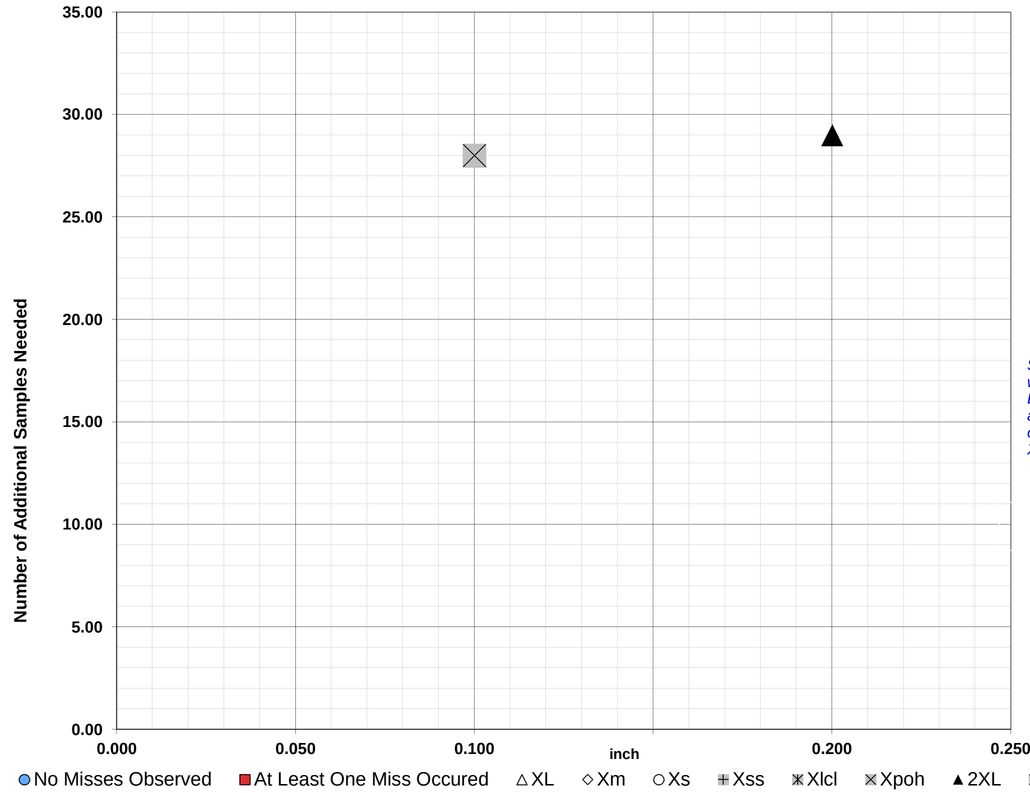


TABLE C

	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*

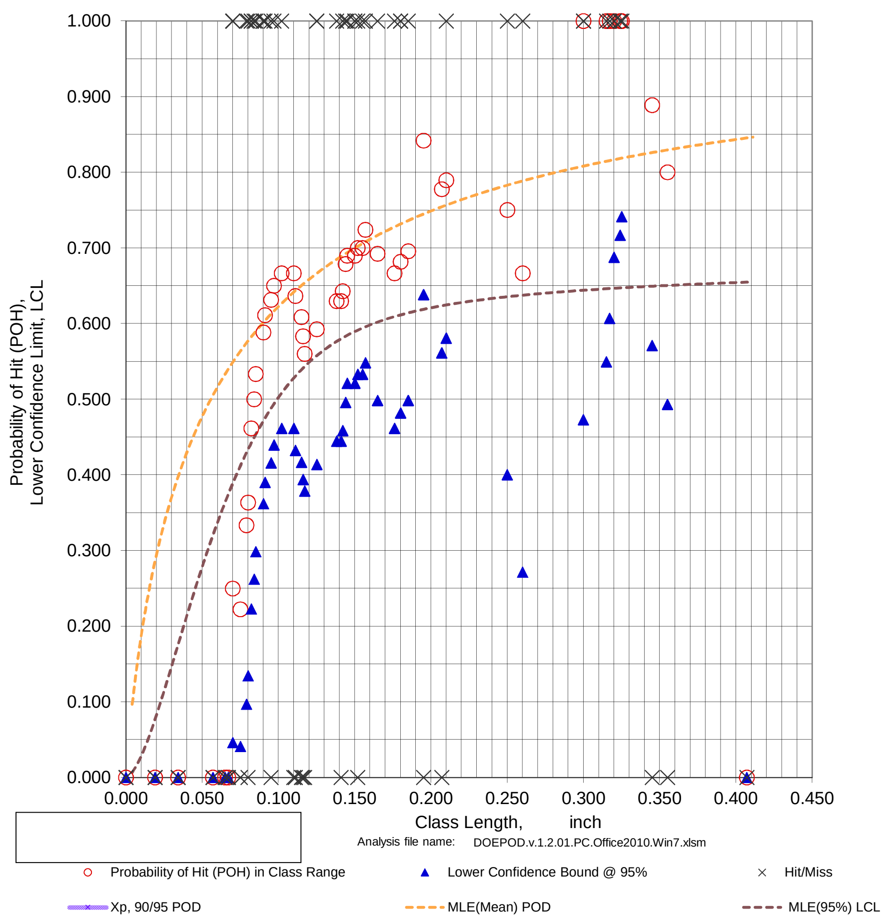
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.

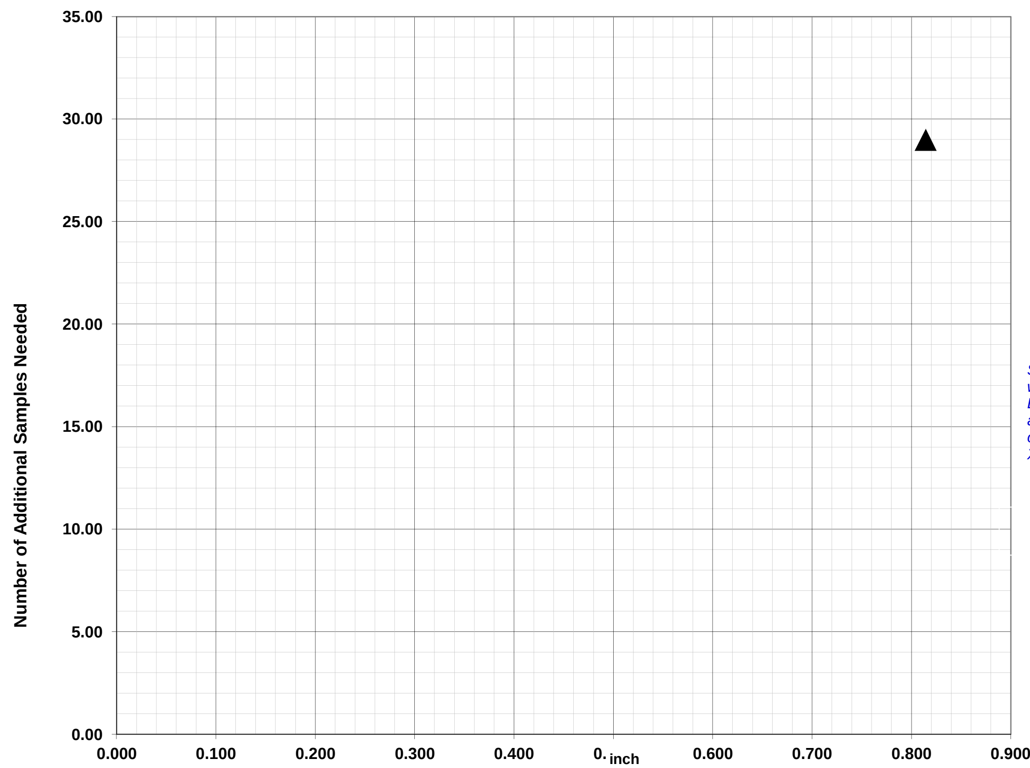
Survey/Optimum Xpoh = 0.000 inch Samples

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



● No Misses Observed ■ At Least One Miss Occured △ XL ◇ Xm ○ Xs Xss Xlcl Xpoh ▲ 2XL Xpod ◆ Xpodopt

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*

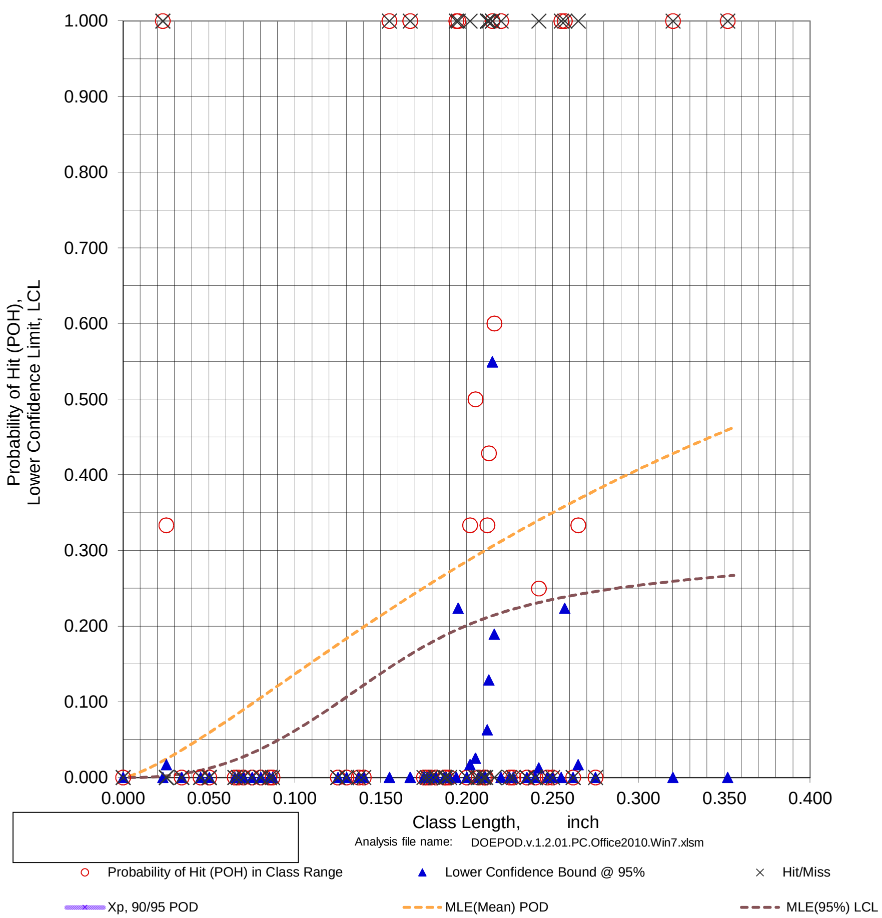
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

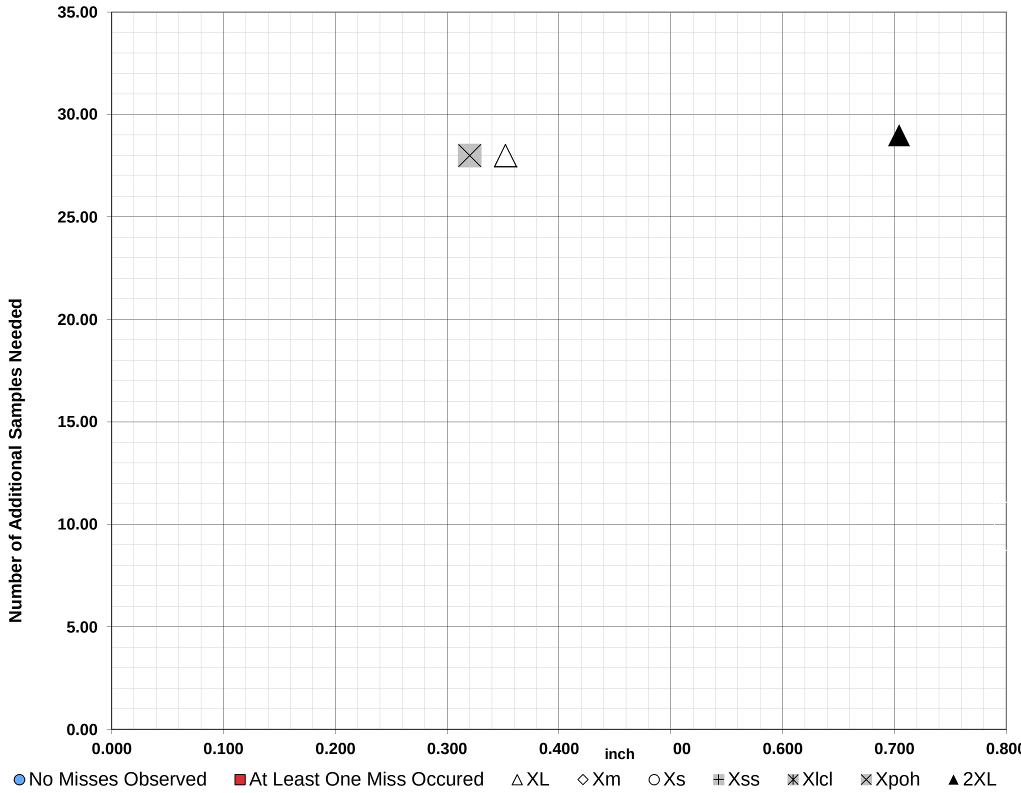


TABLE C

	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*

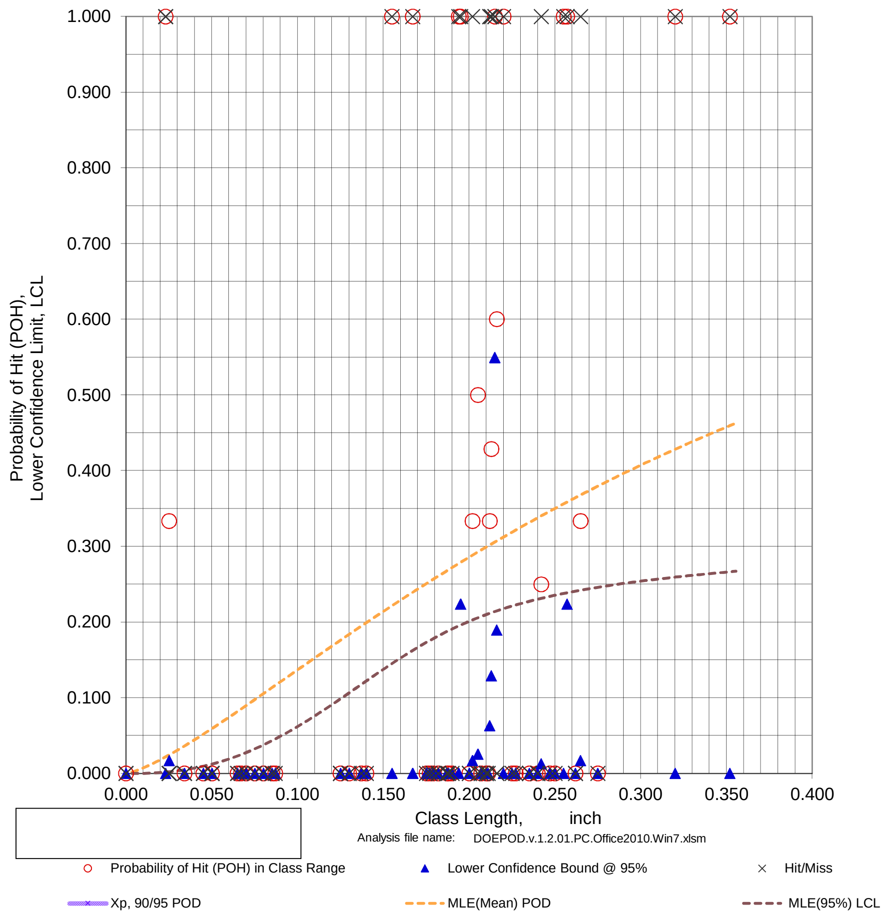
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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

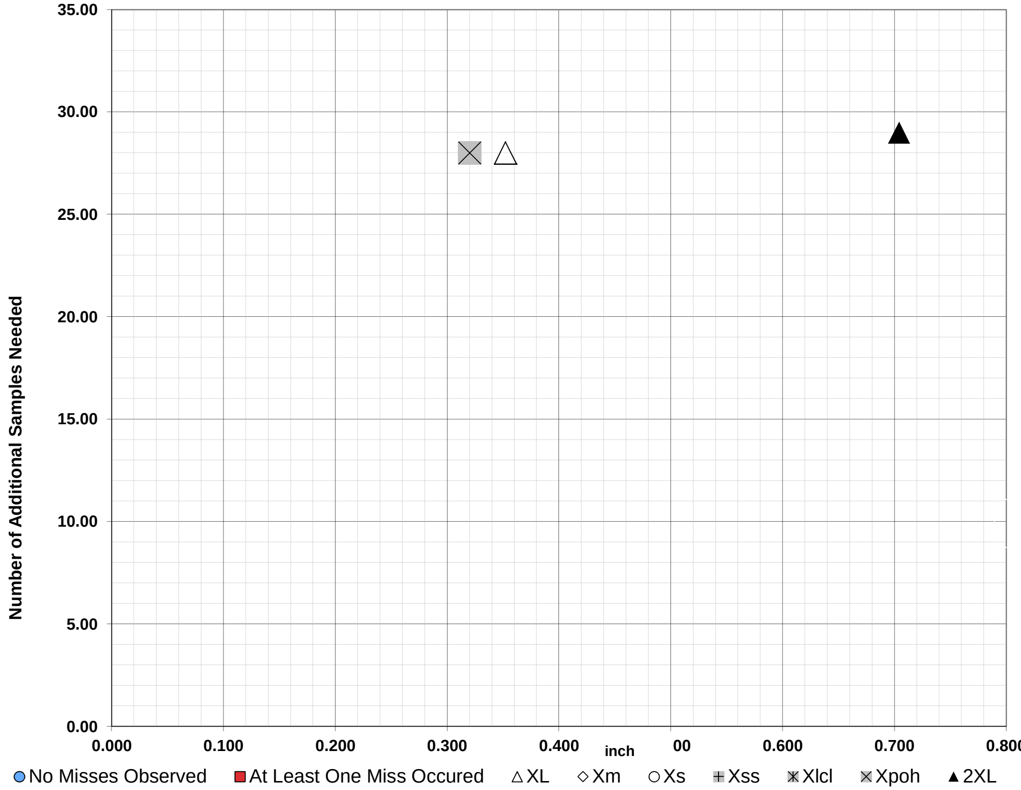


TABLE C

	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.

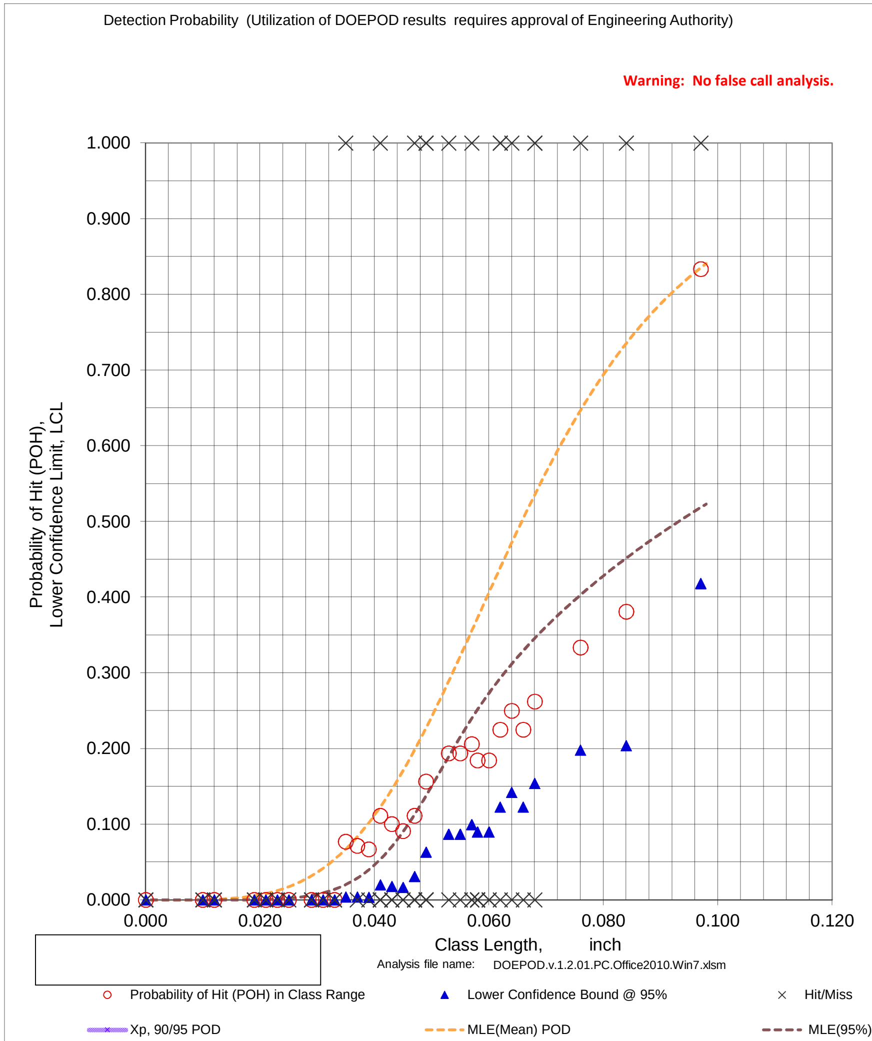
Xpod,Class Length	No. Need

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



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

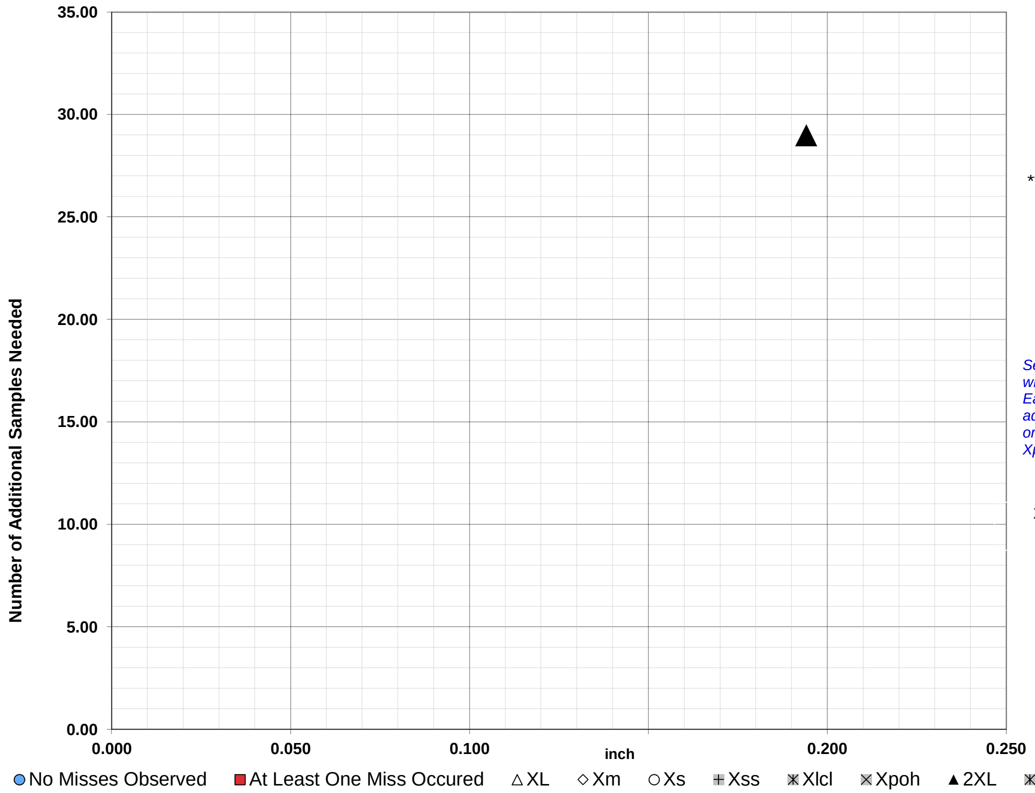


TABLE C

	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*

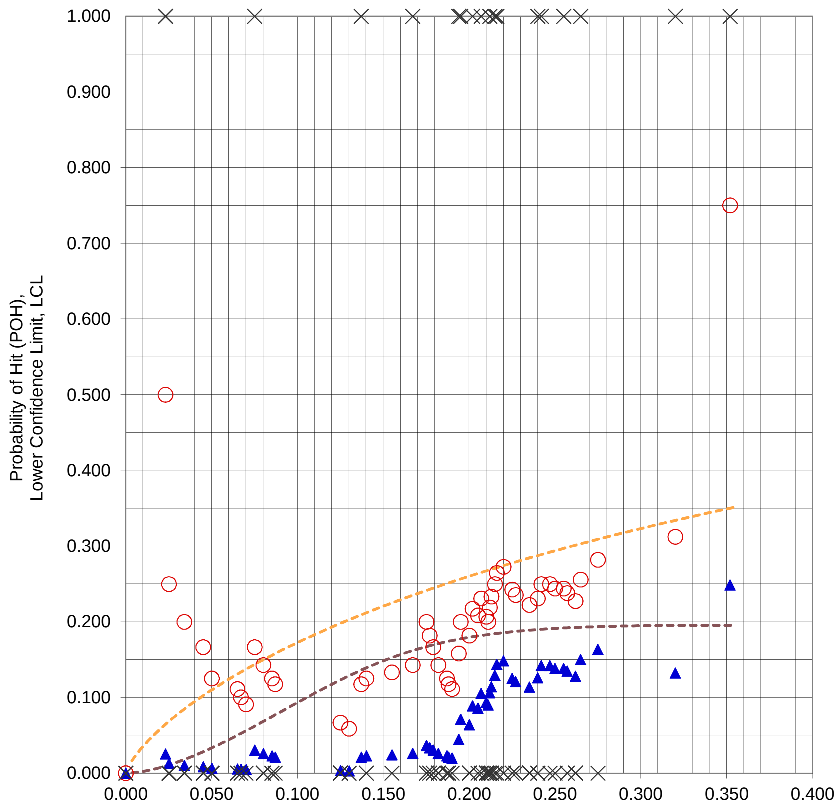
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

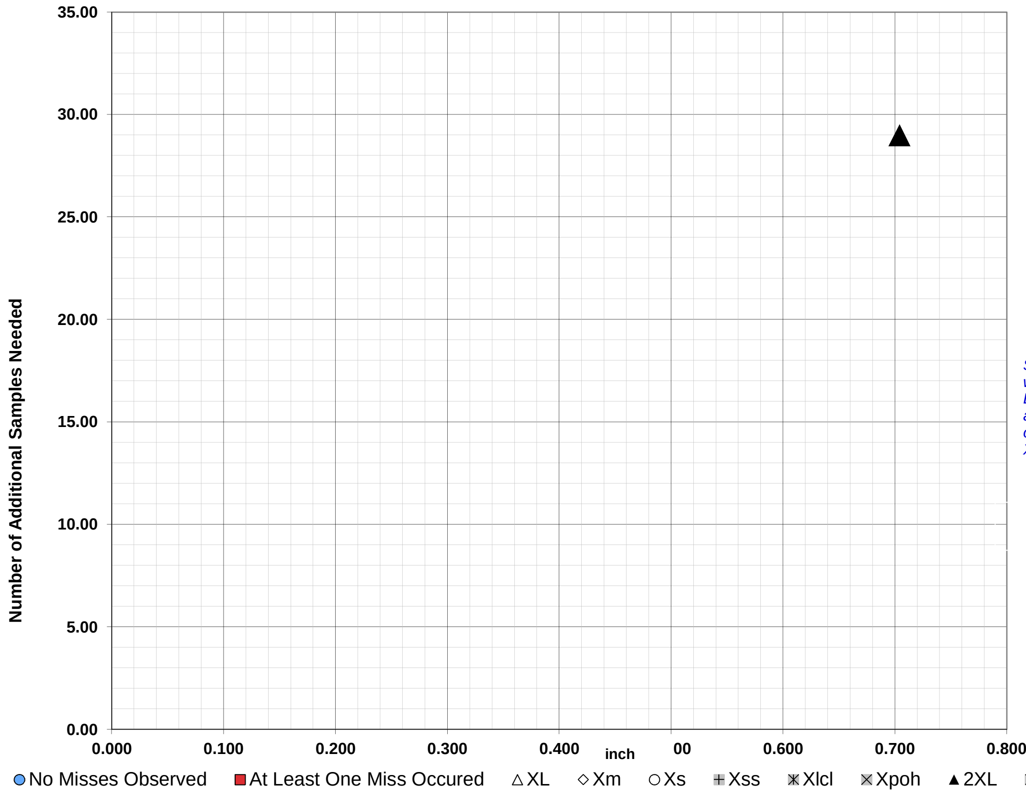


TABLE C

	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*

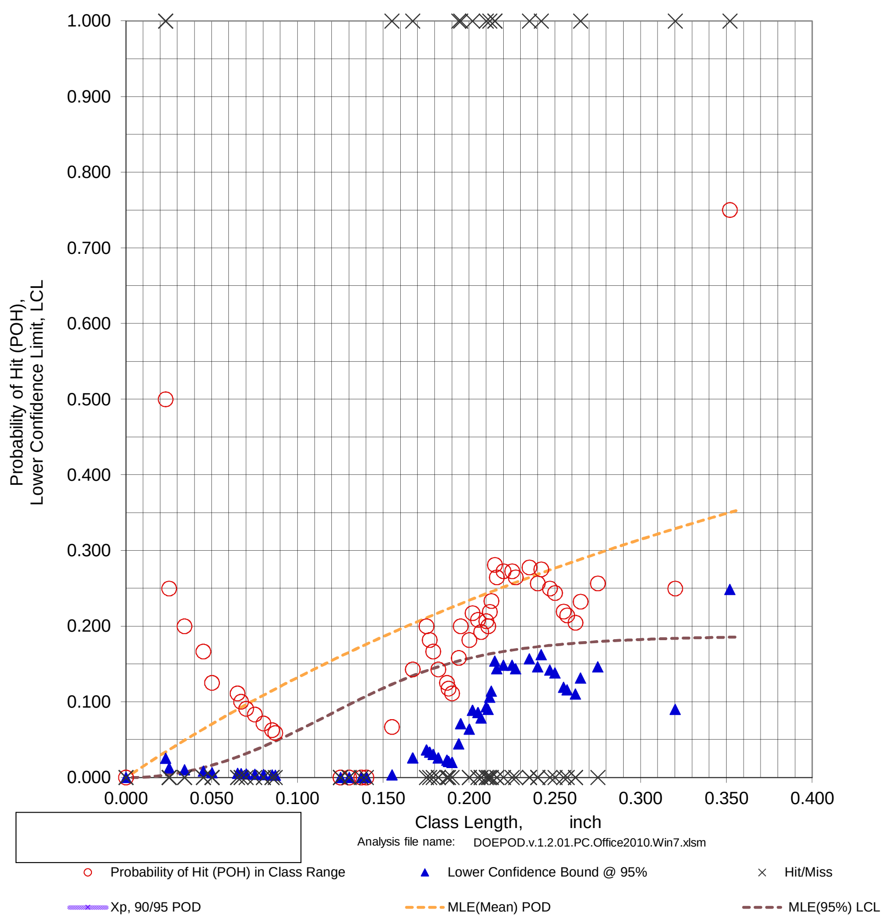
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

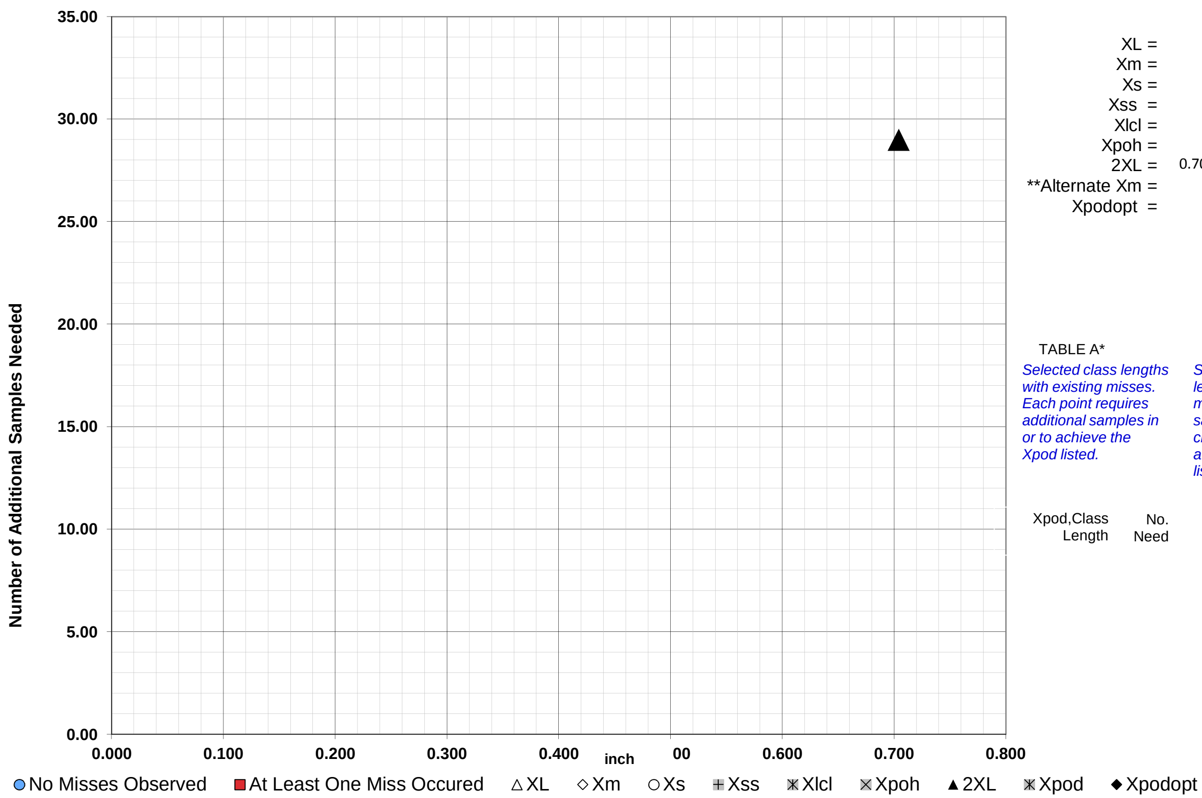


TABLE C

	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*

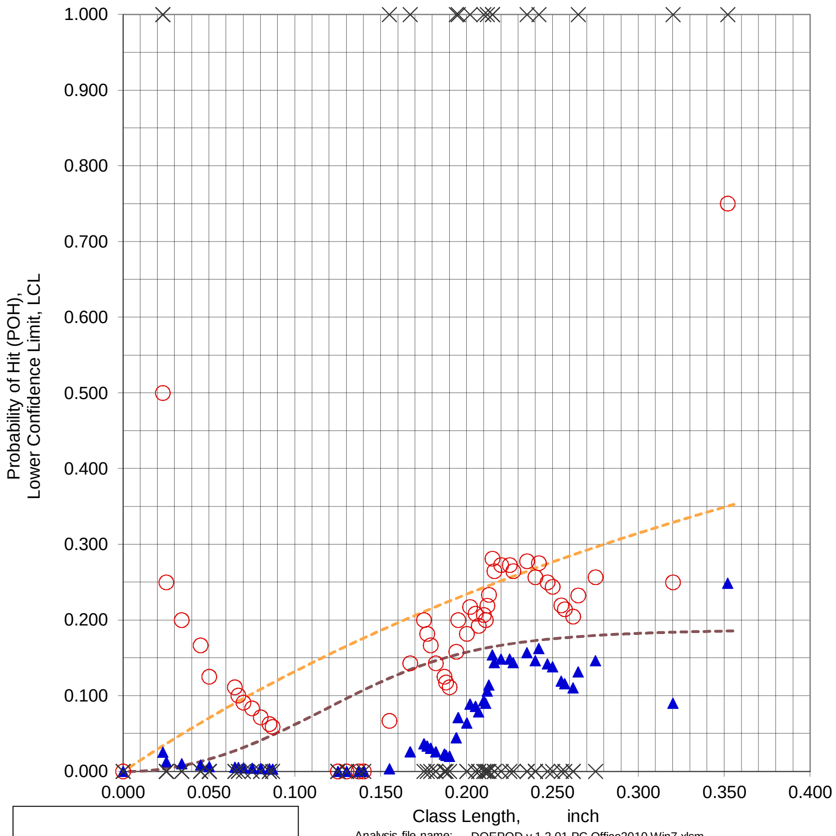
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = **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

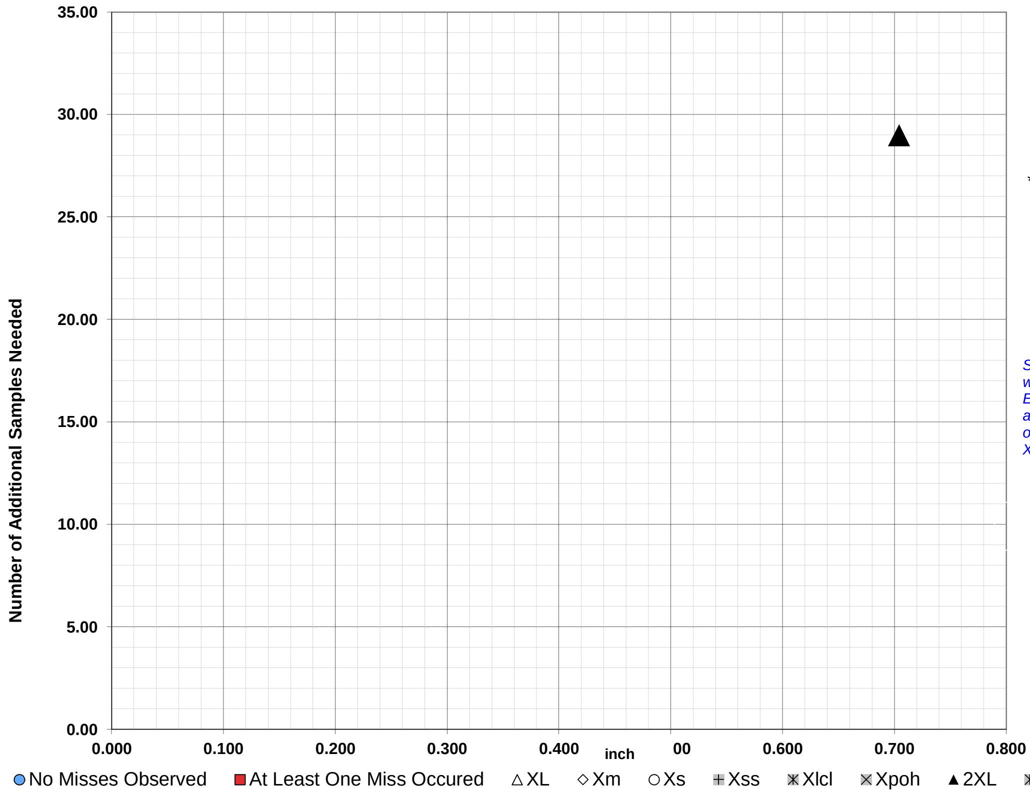


TABLE C

	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*

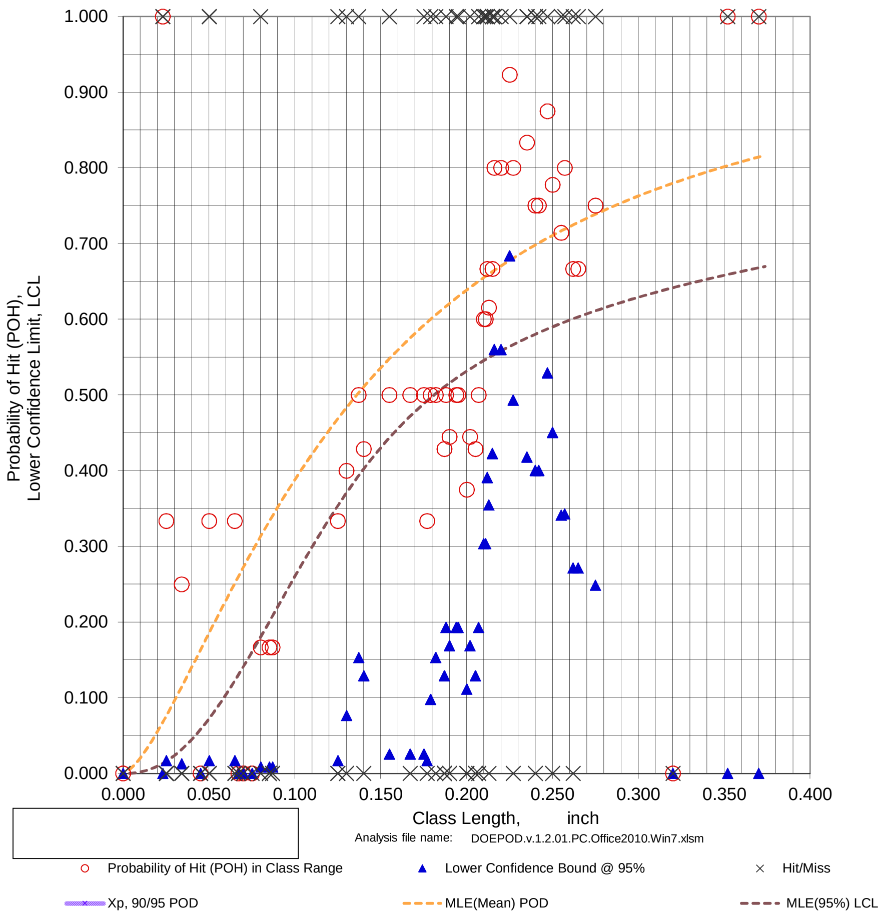
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

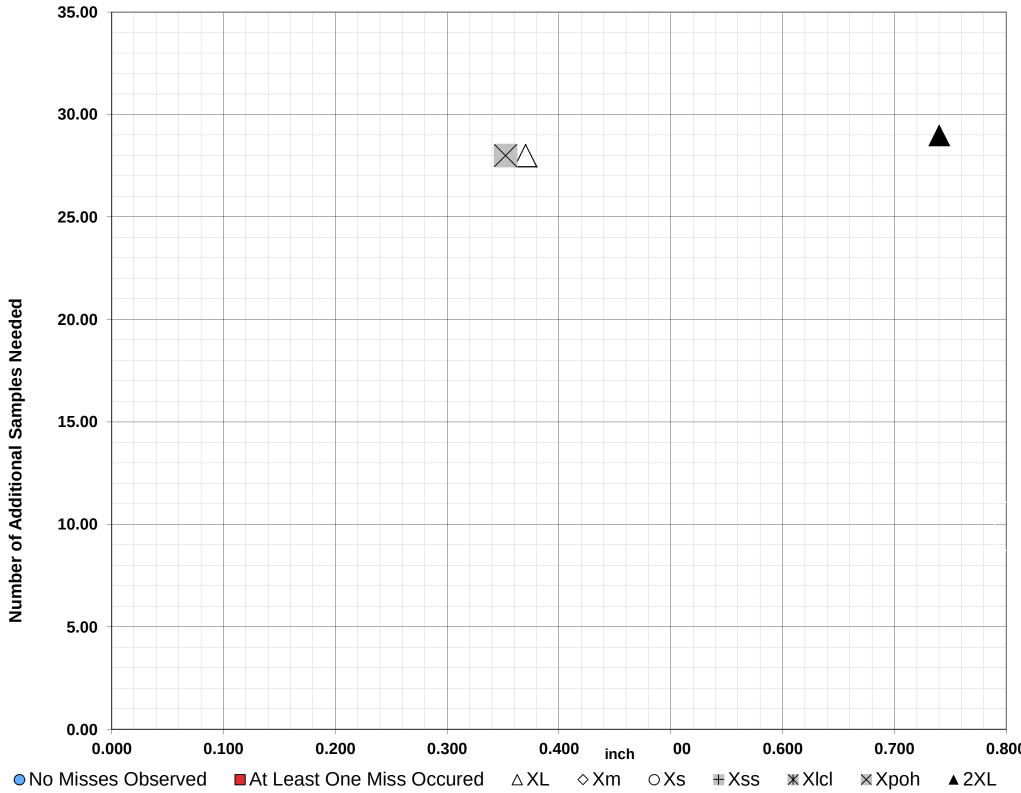


TABLE C

	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*

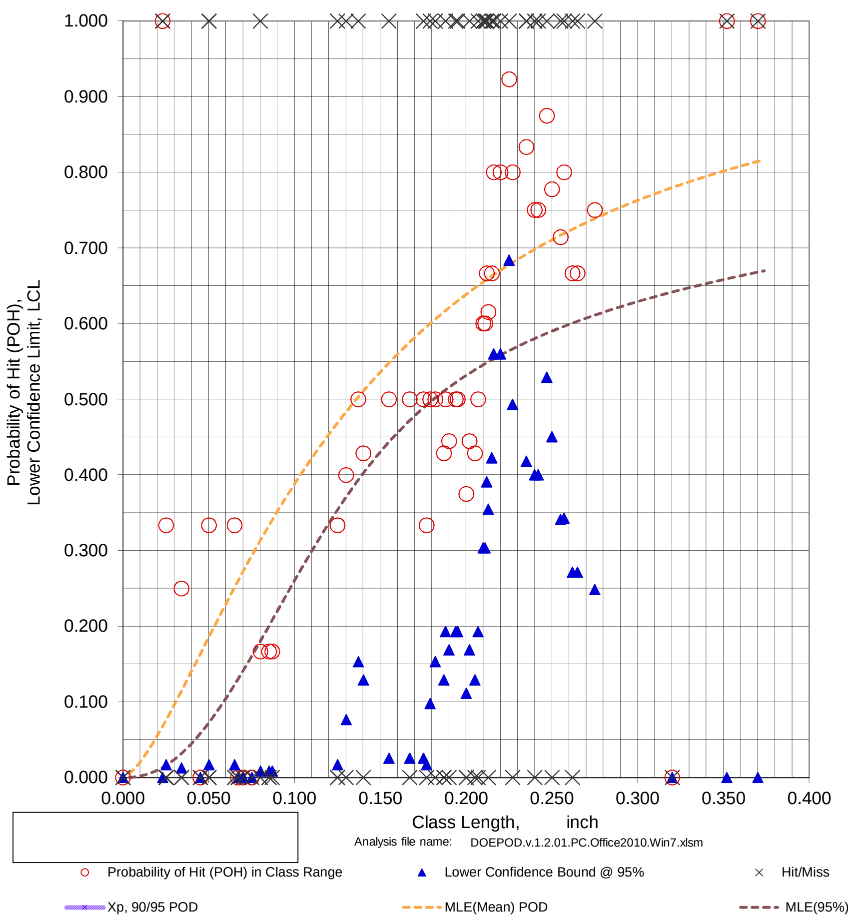
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.

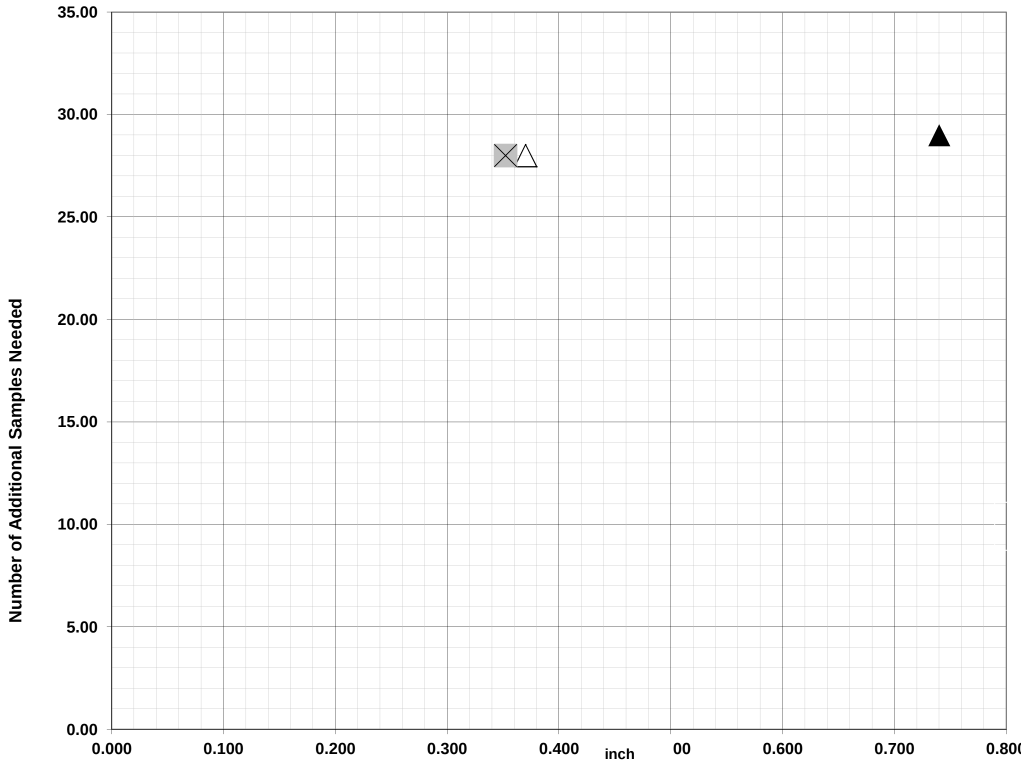
Survey/Optimum Xpoh = 0.3520 -0.031 inch 28 Samples

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



No Misses Observed | At Least One Miss Occured | XL | Xm | Xs | Xss | Xlcl | Xpoh | 2XL | Xpod | Xpodopt

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*

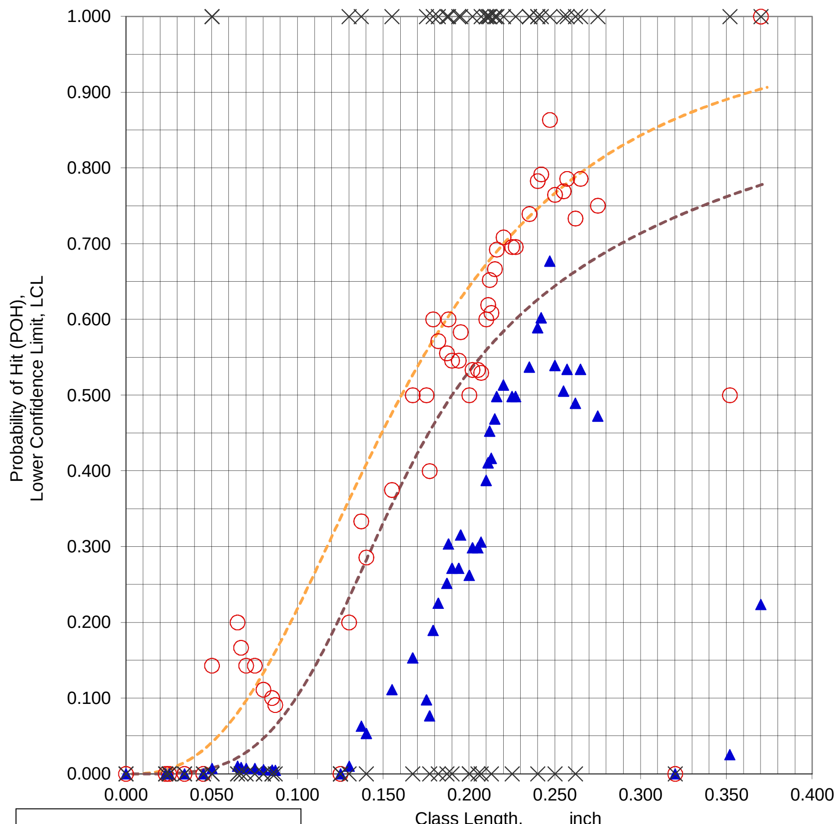
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = **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

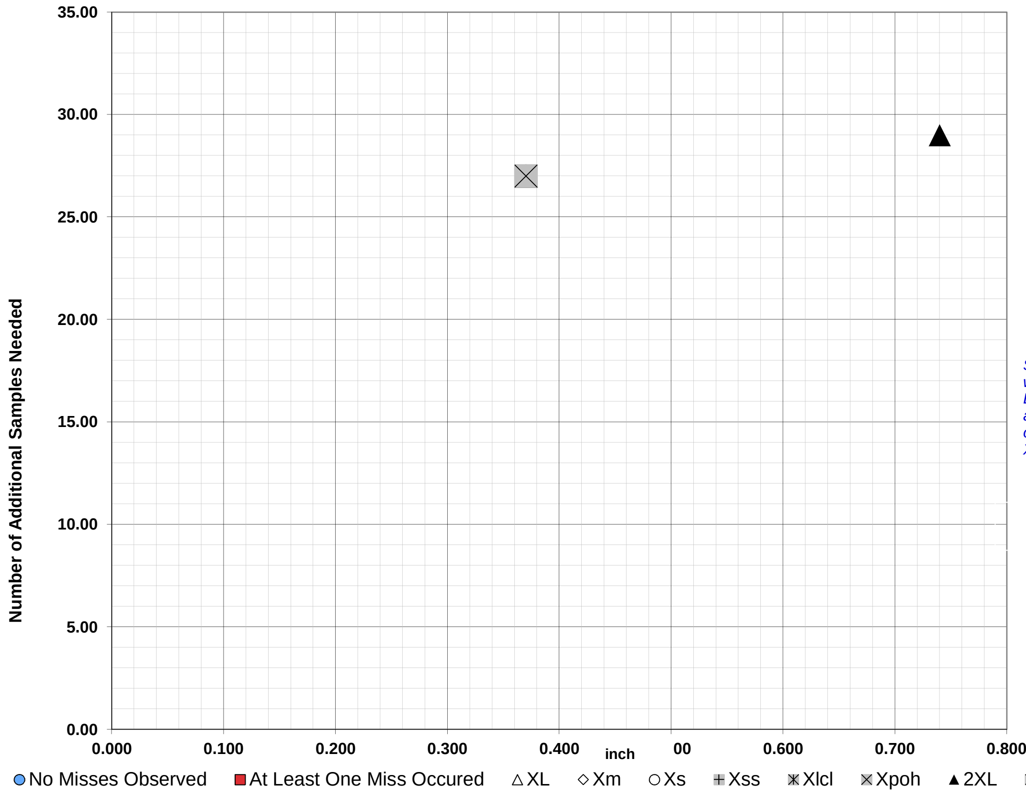


TABLE C

	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*

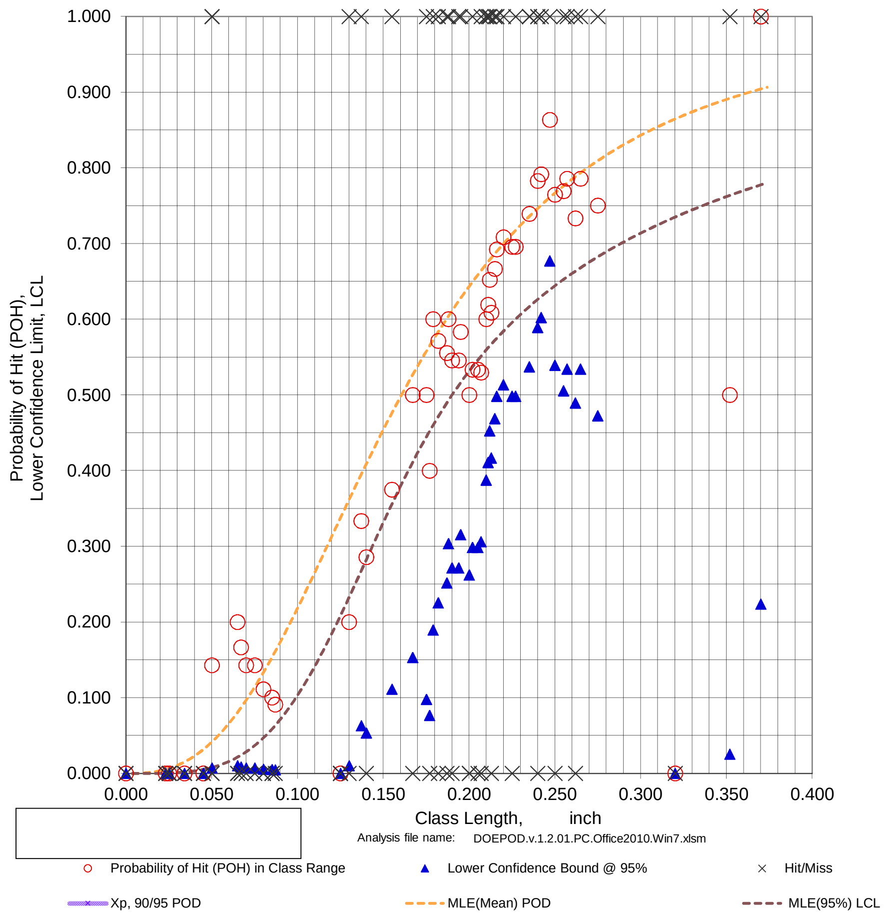
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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 #)

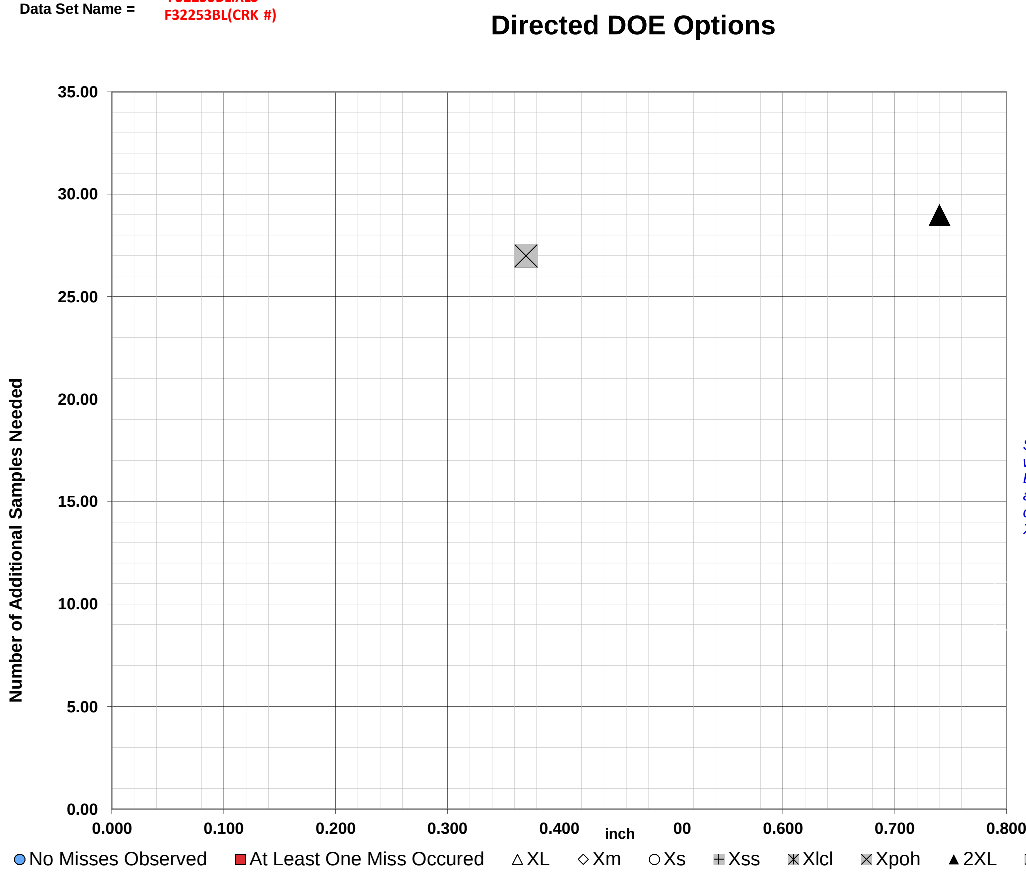


TABLE C

	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*

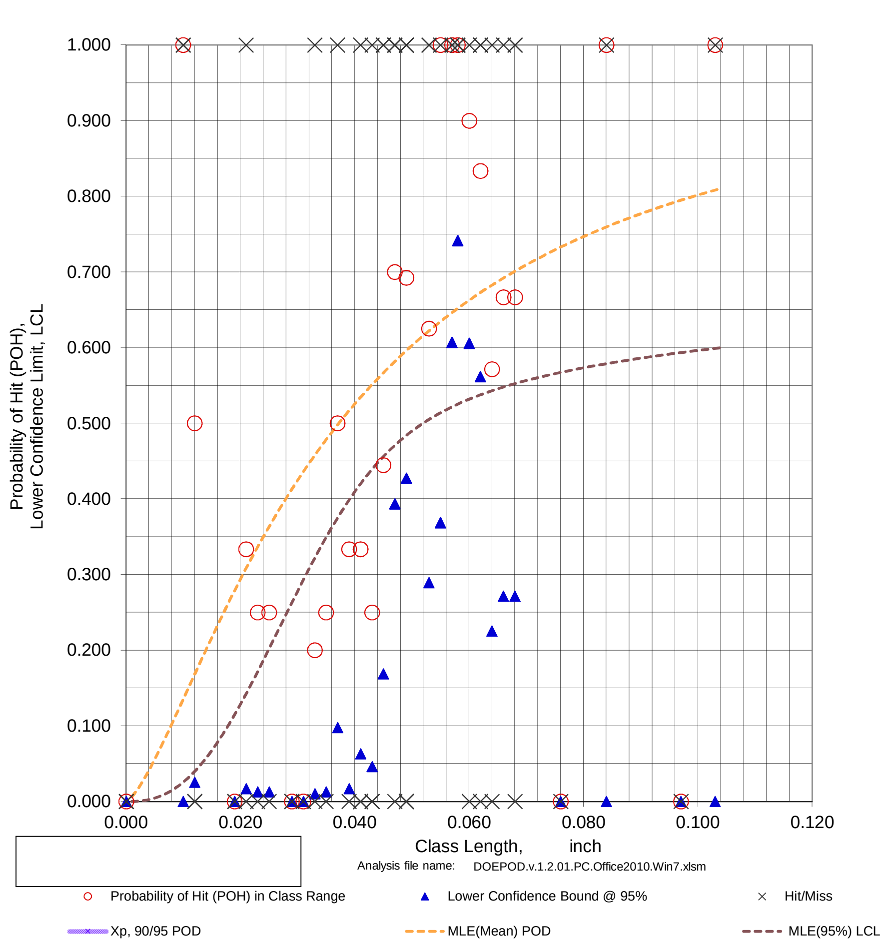
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

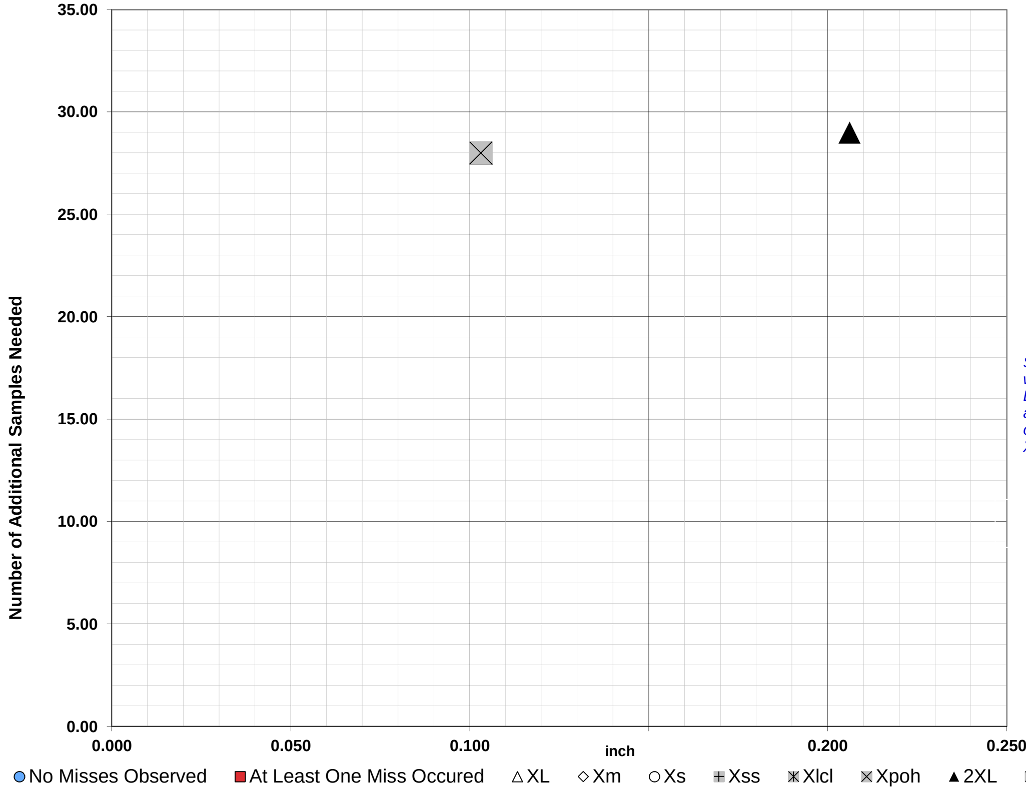


TABLE C

	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.

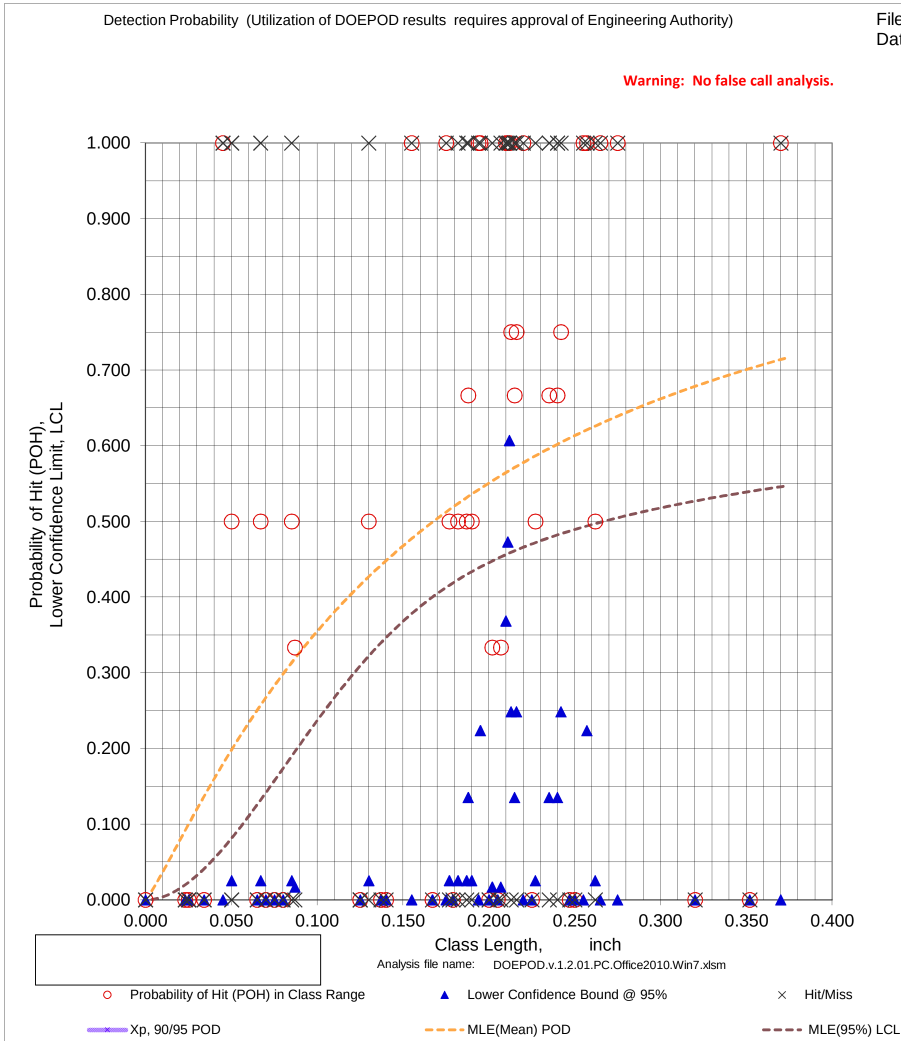
Xpod,Class Length	No. Need

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



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

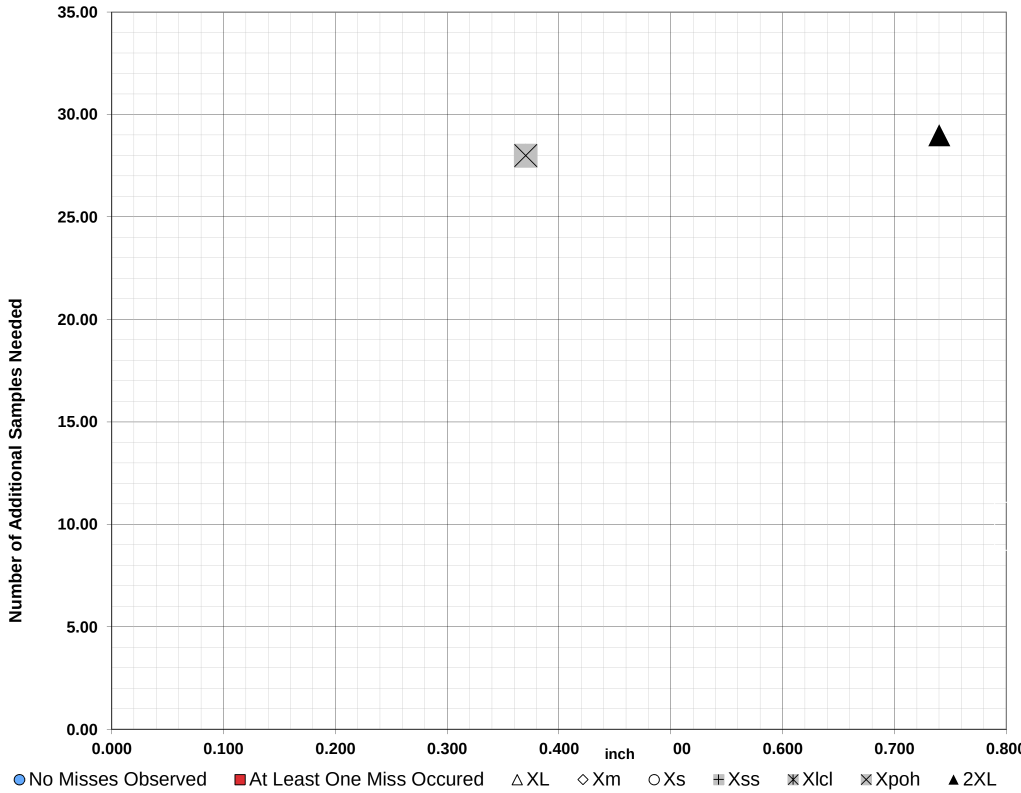


TABLE C

	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

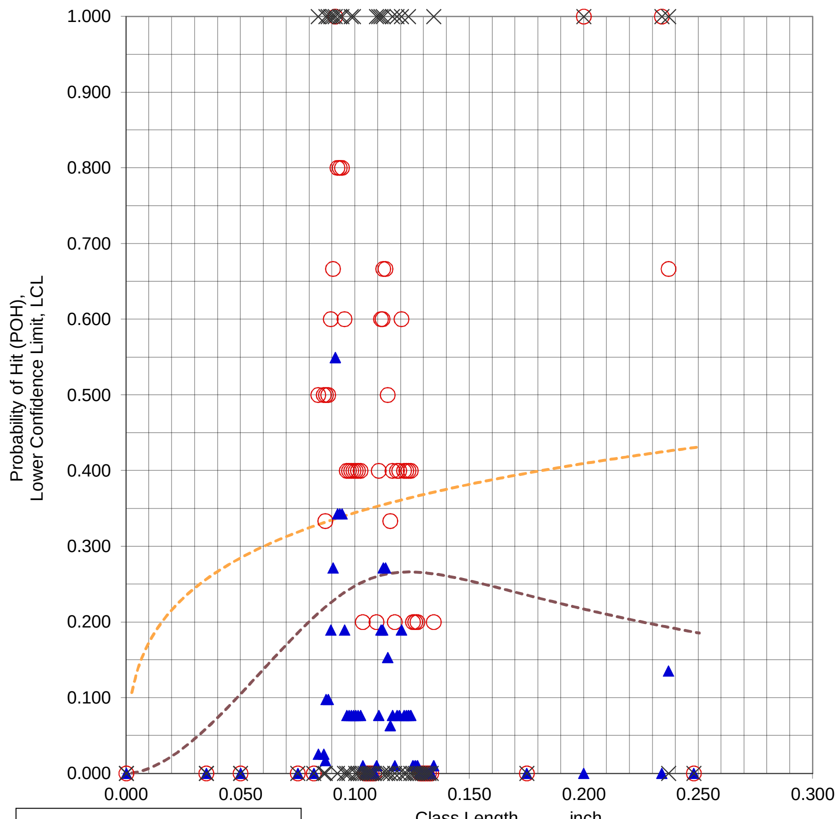
TABLE B*
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

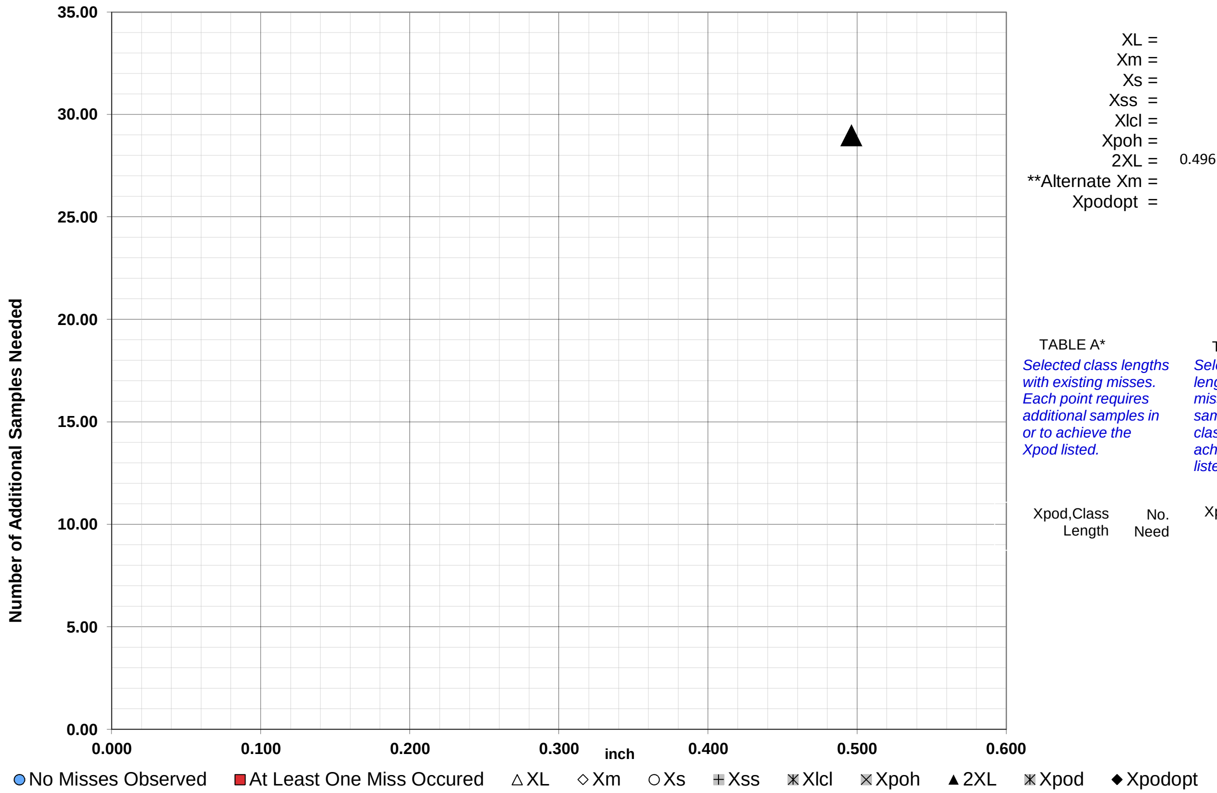


TABLE C

	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*

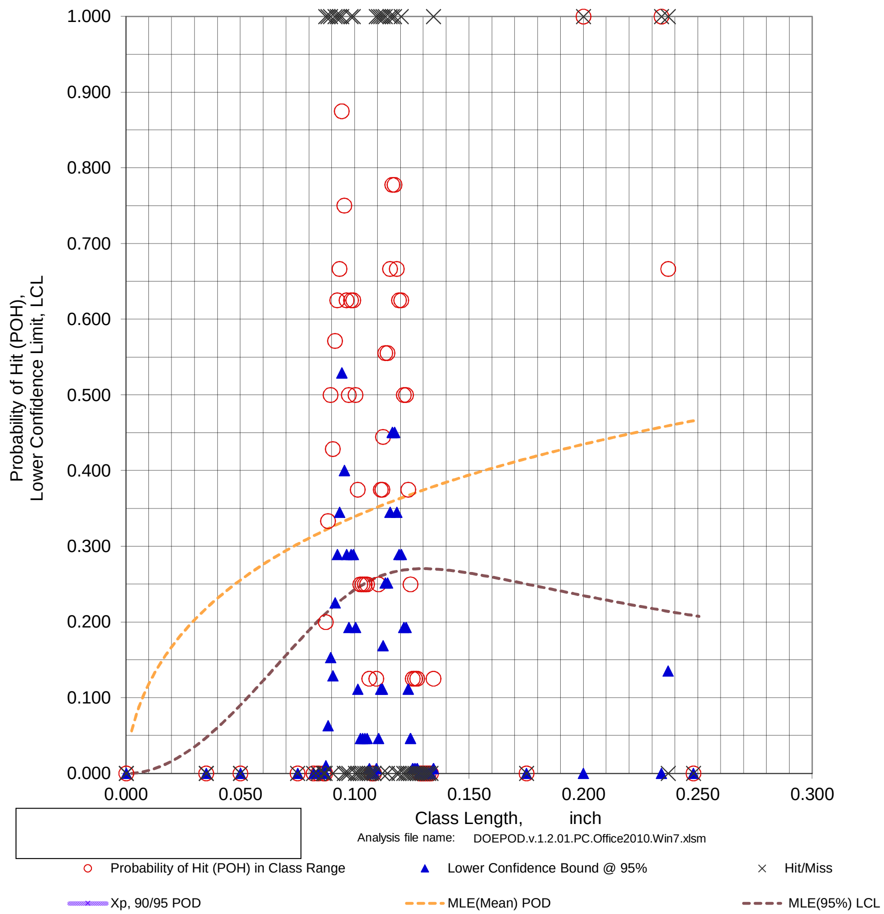
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

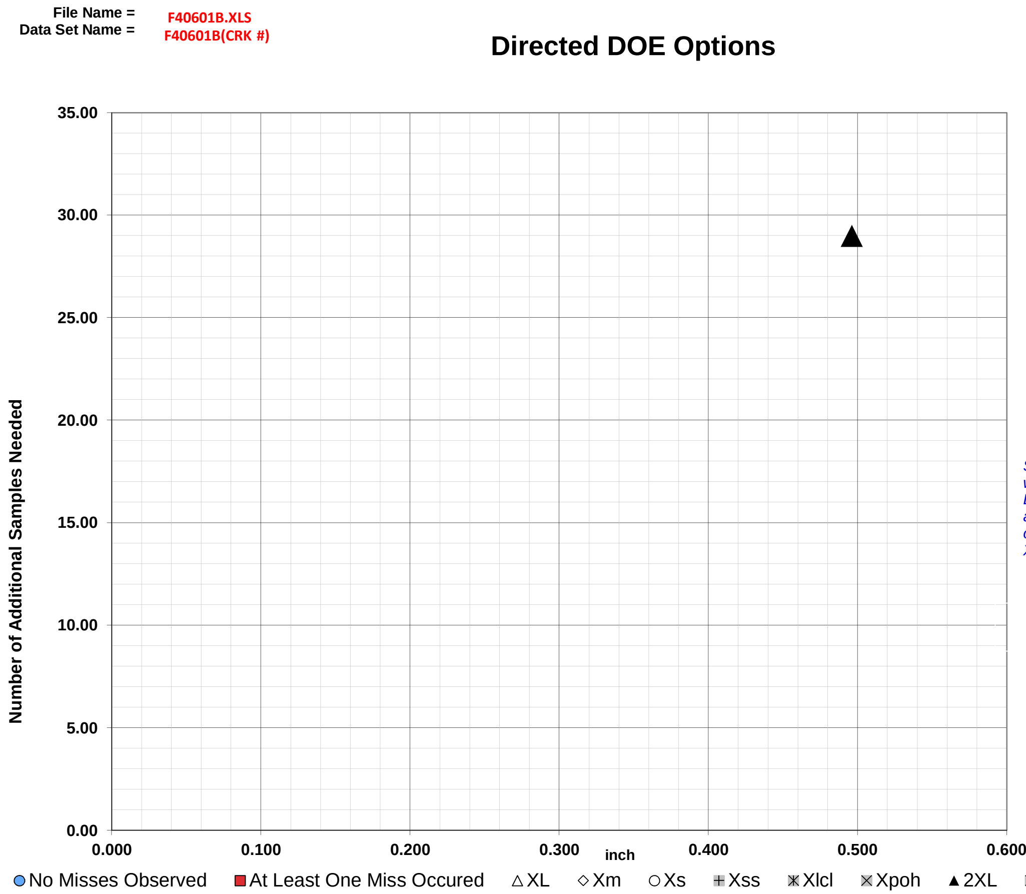


TABLE C

	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*

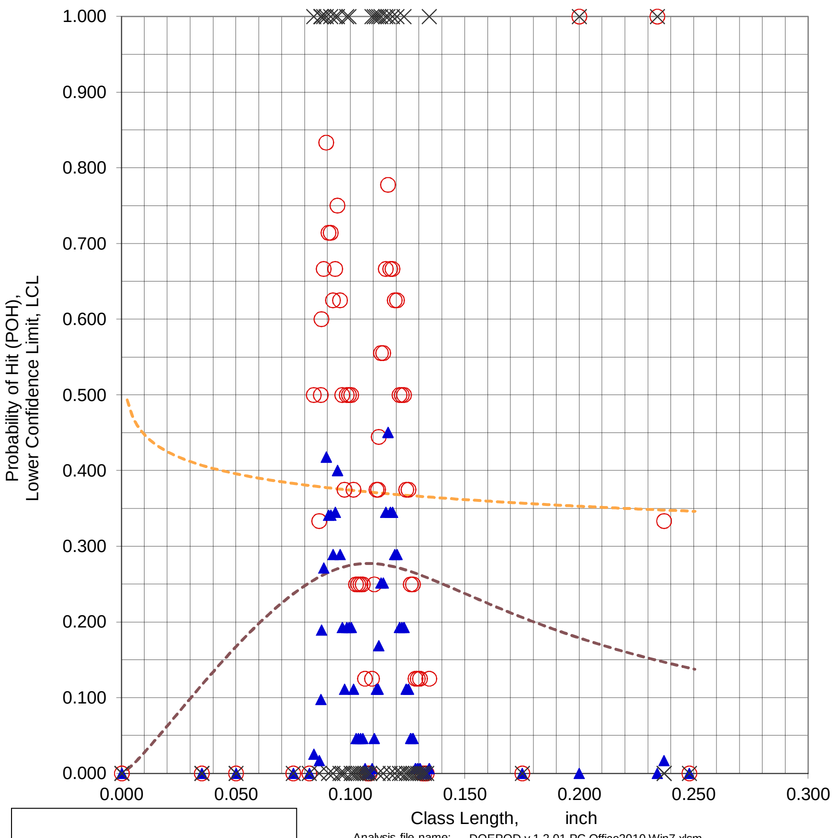
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

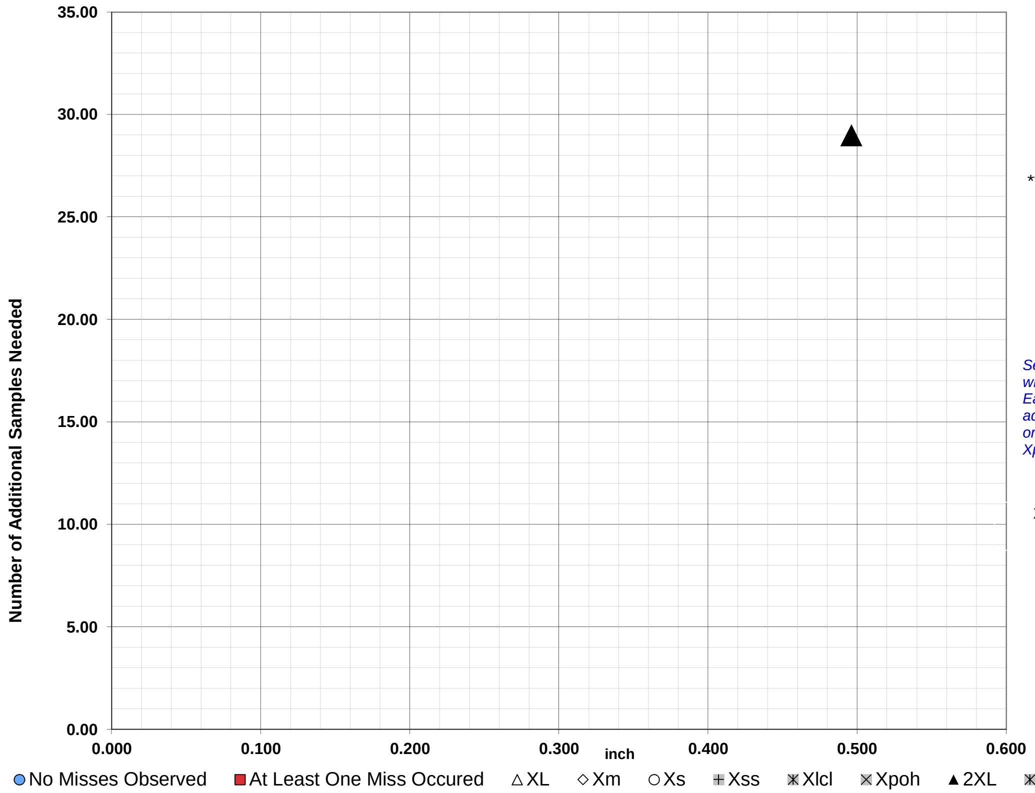


TABLE C

	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.

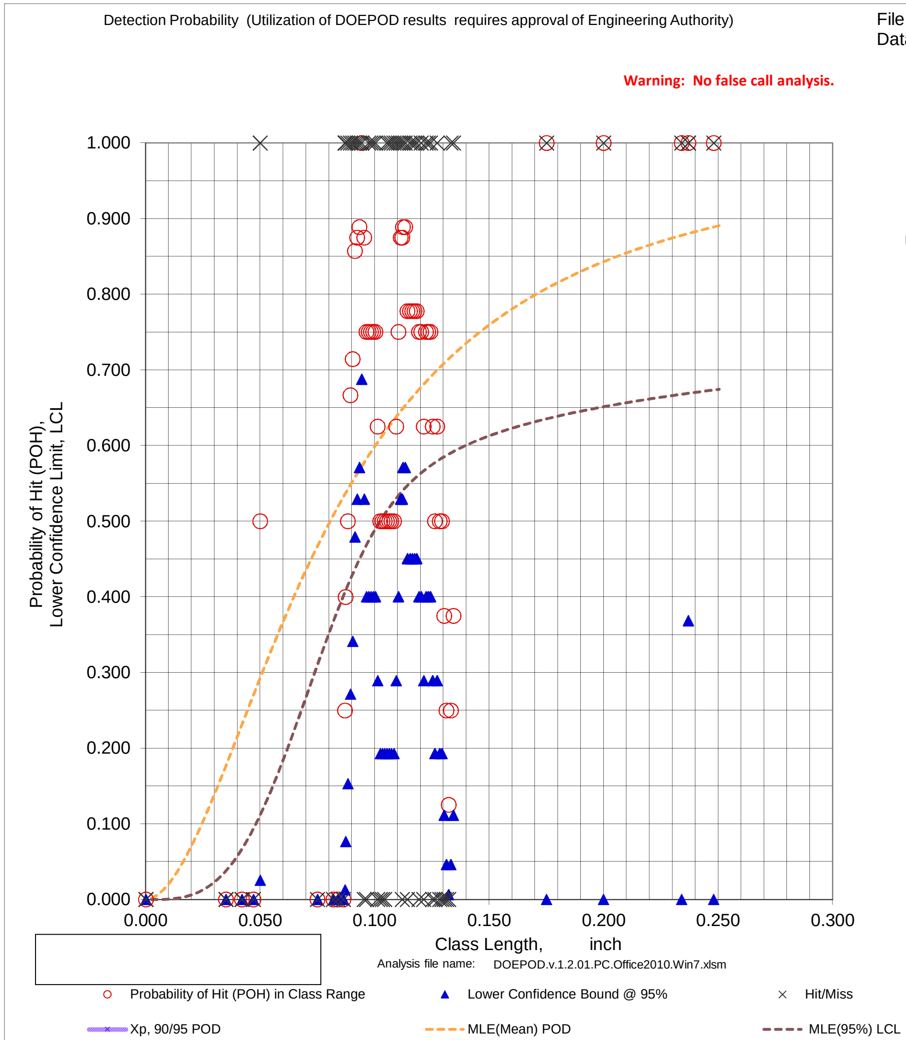
Xpod,Class Length	No. Need

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



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

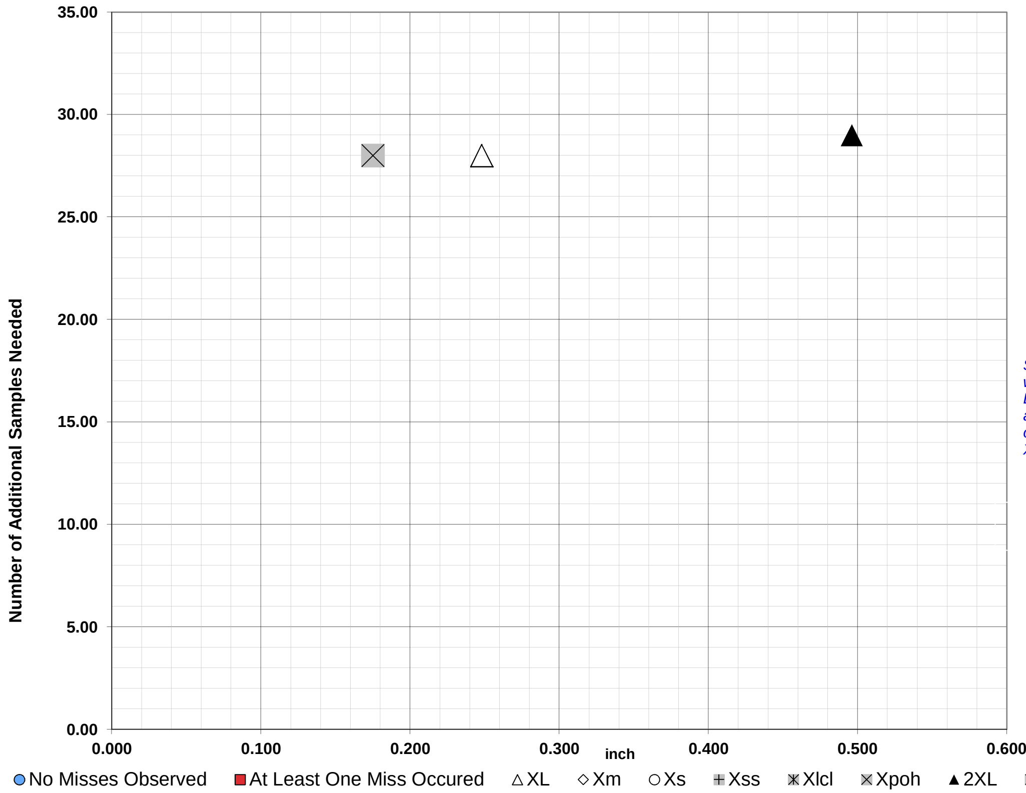


TABLE C

	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*

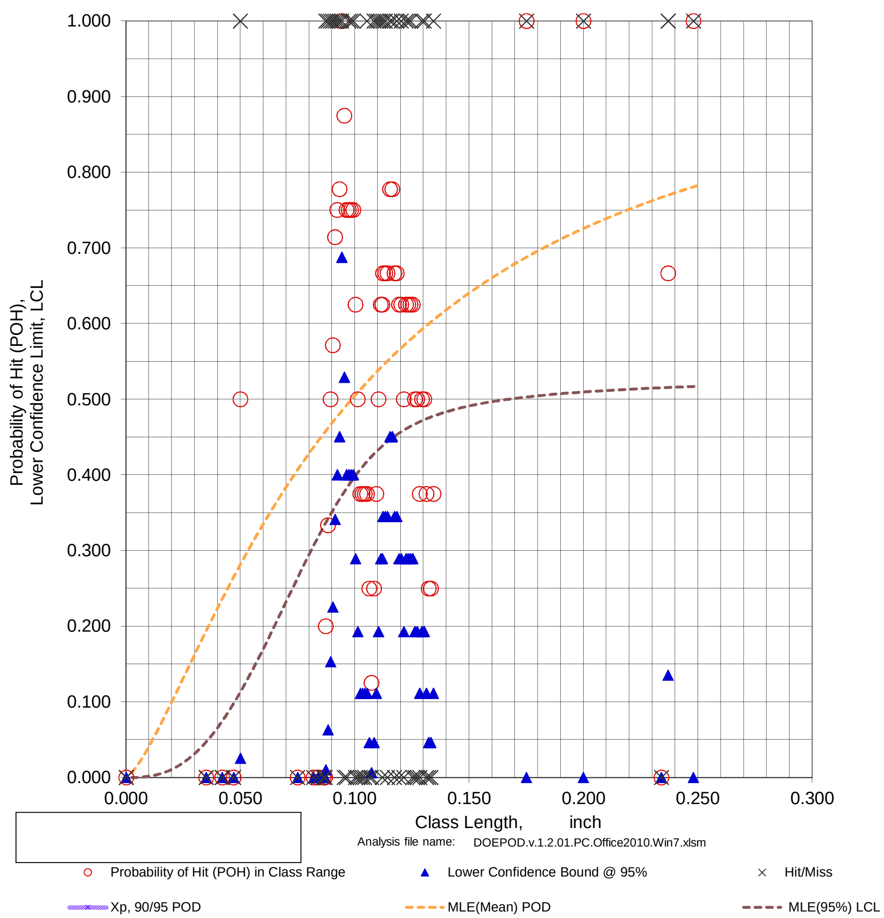
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

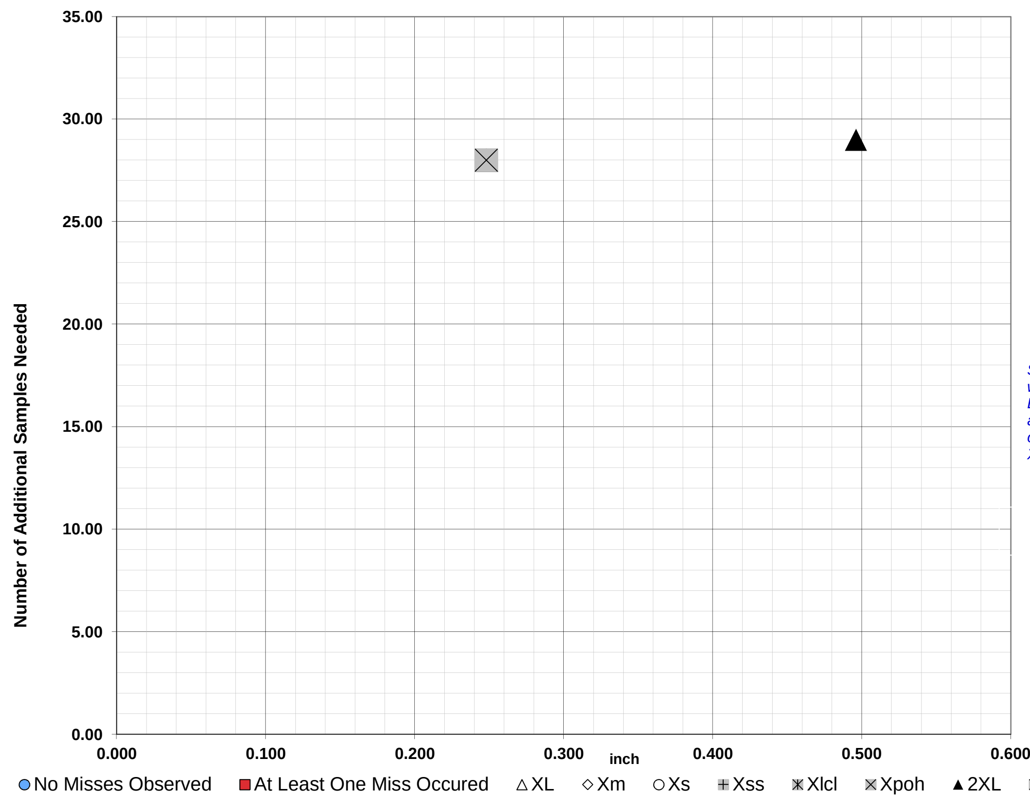


TABLE C

	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.

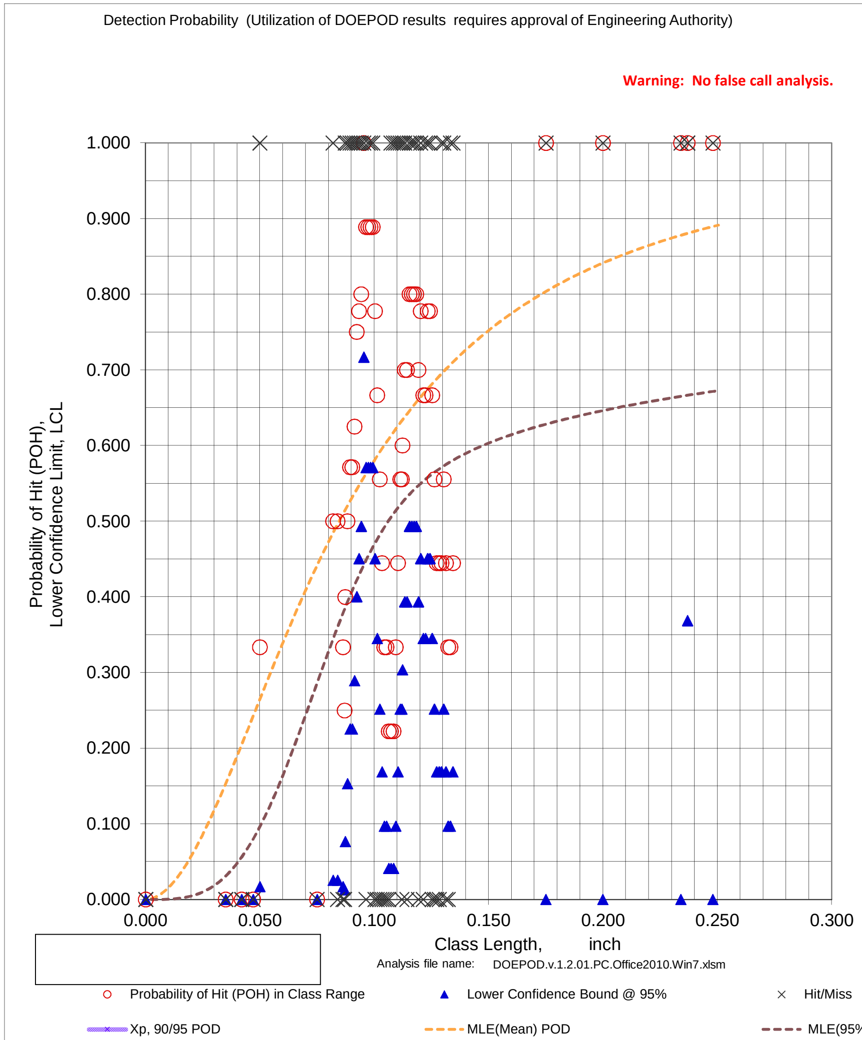
Xpod,Class Length	No. Need

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



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

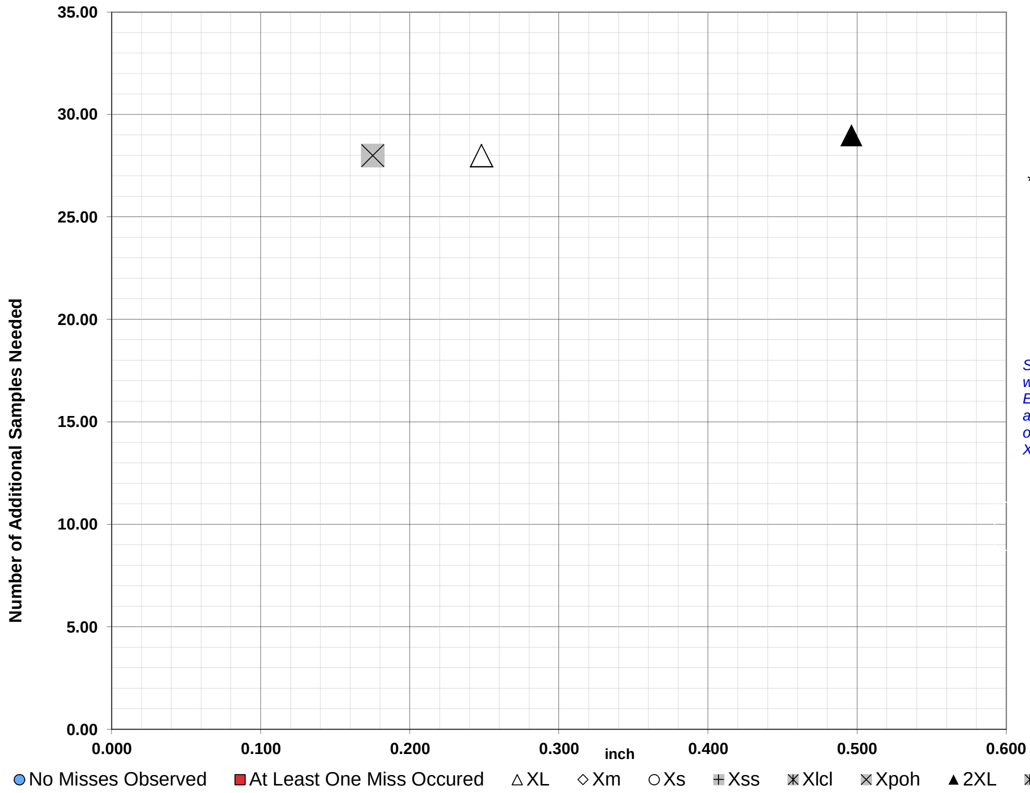


TABLE C

	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*

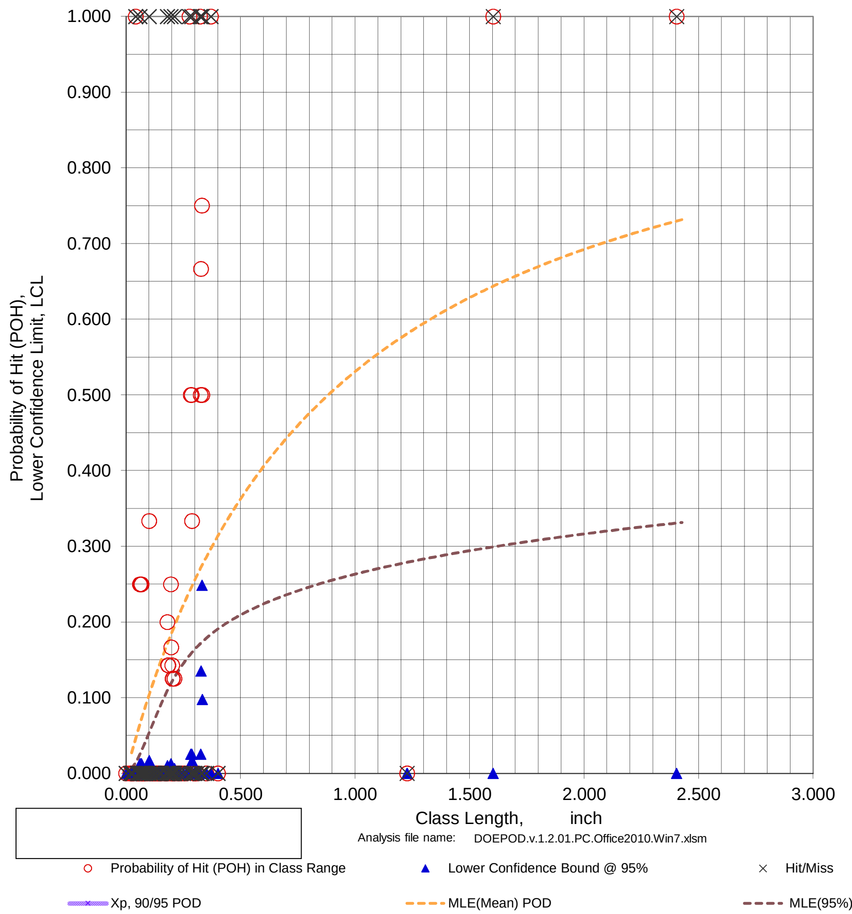
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

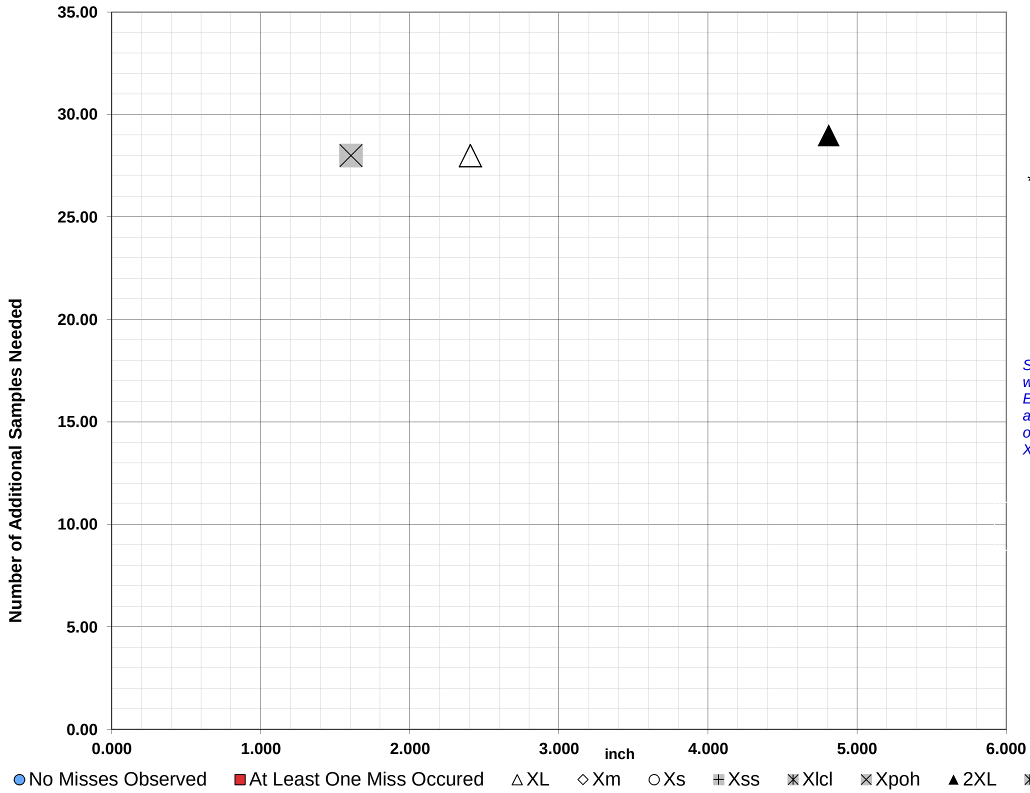


TABLE C

	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.
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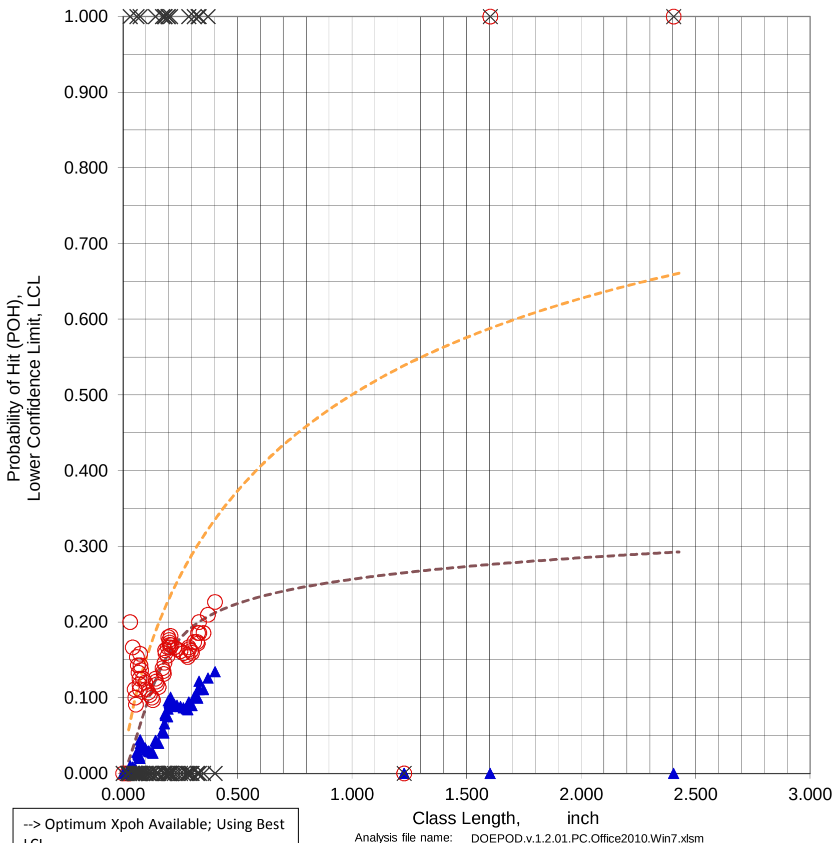
The class lengths listed in Table B exhibited no misses, and these class lengths provide alternate target Xpod points. Only largest 4 class lengths are shown
Follow sample selection priority in the DOEPOD Manual.
Before adding flawed samples to satisfy elements of Table A or Table B, it is recommended that the cause of the Misses be determined (human factors, unexpected flaw type, etc) and resloved first.
**Satisfying the Alternate Xm requirement removes the need to meet the adjacent Xm requirement.
***The added class lengths are to be at the class length 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.



--> 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 = 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 #)

Directed DOE Options

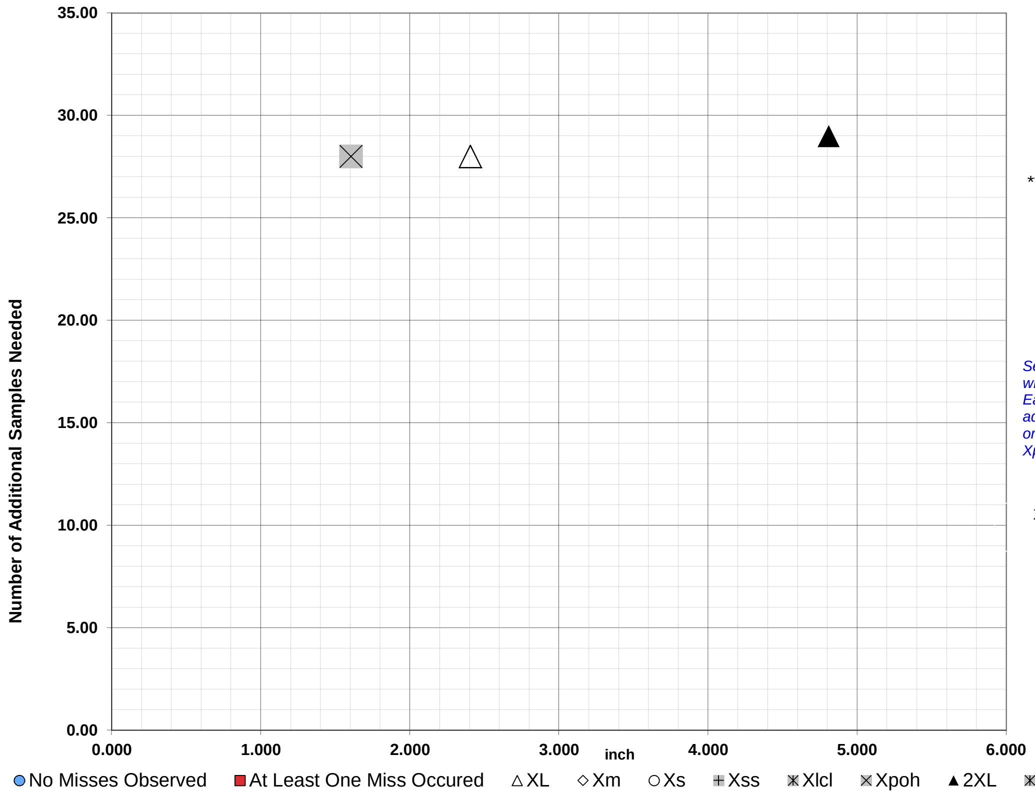


TABLE C

	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*

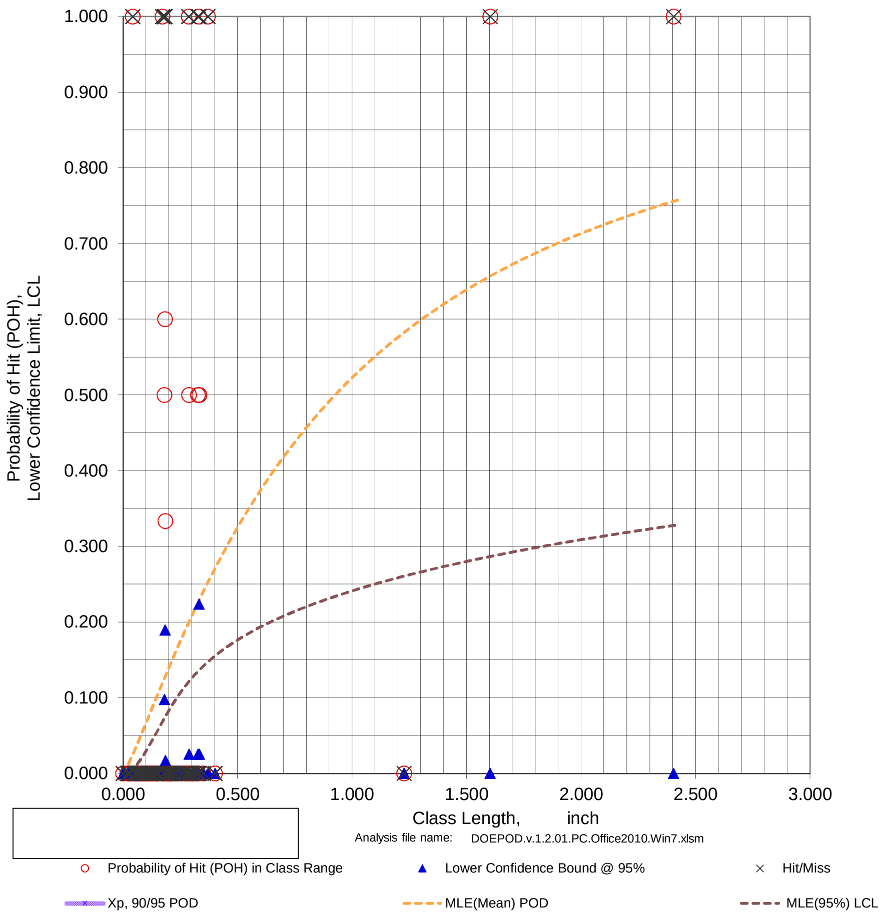
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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 = 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

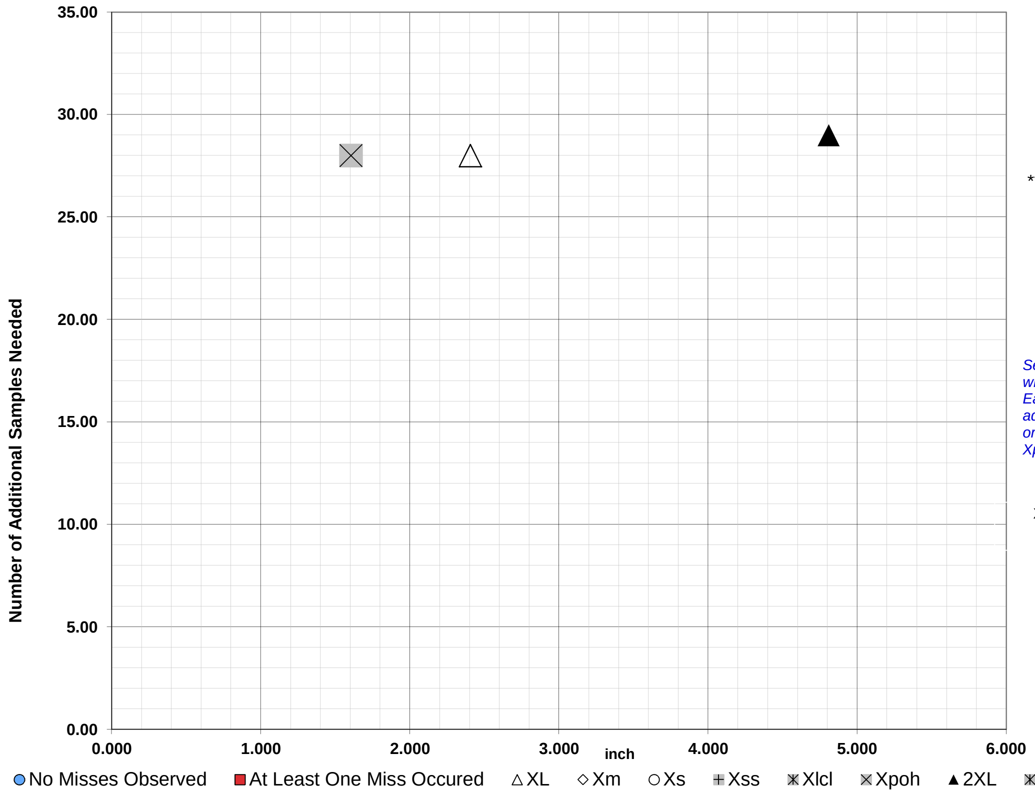


TABLE C

	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*

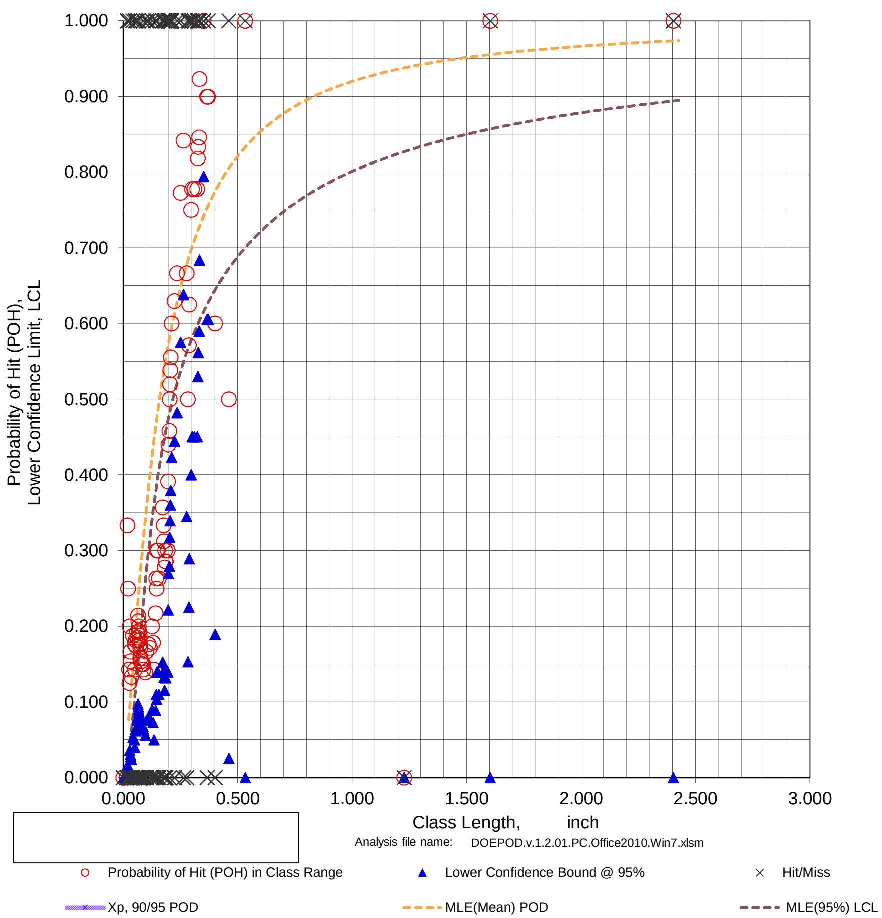
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

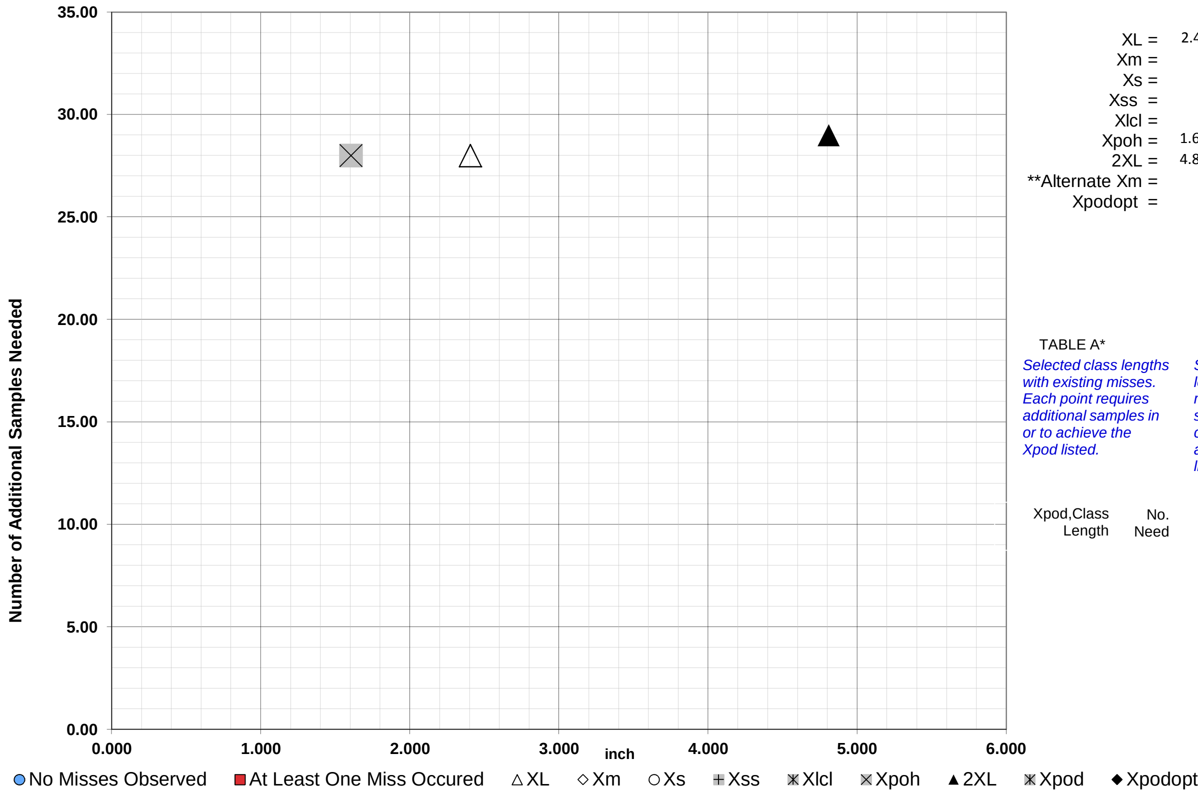


TABLE C

	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*

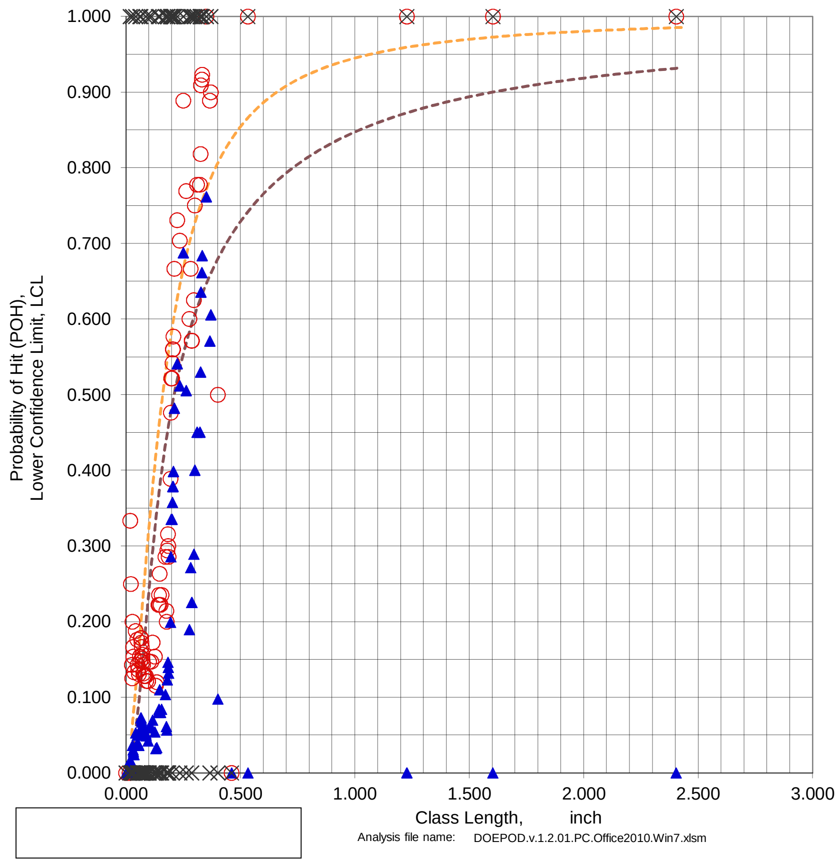
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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 #)

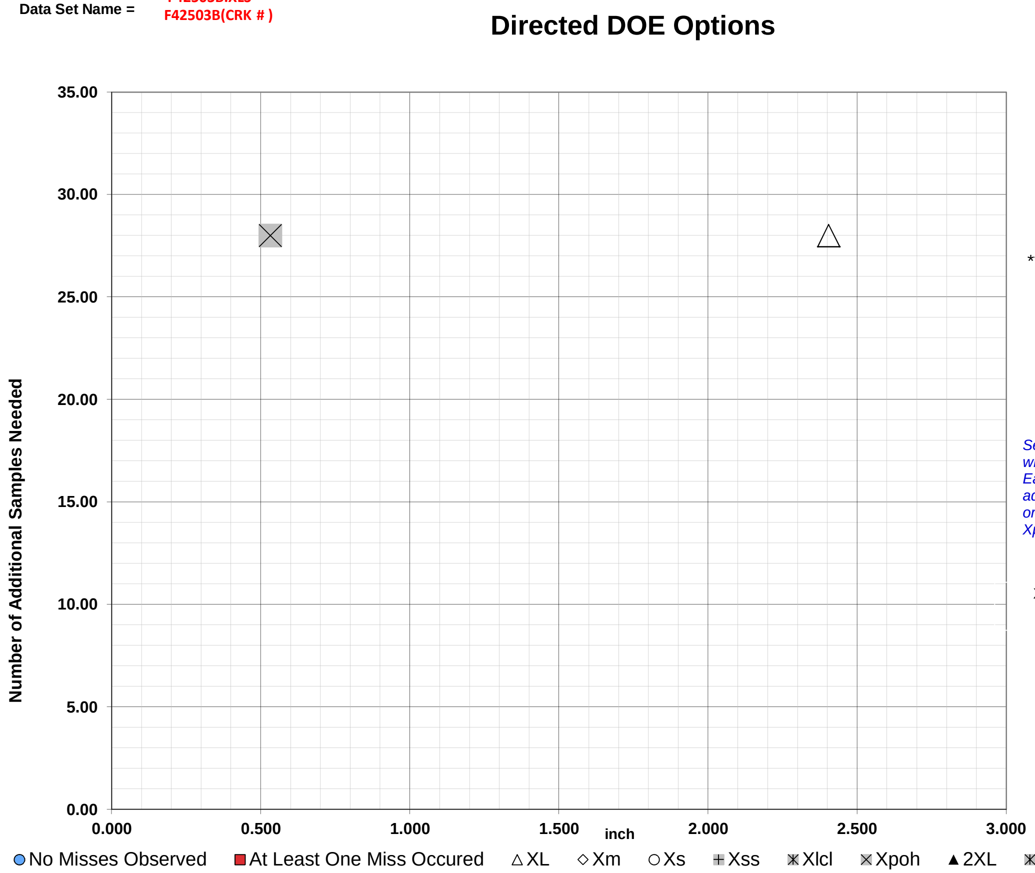


TABLE C

	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*

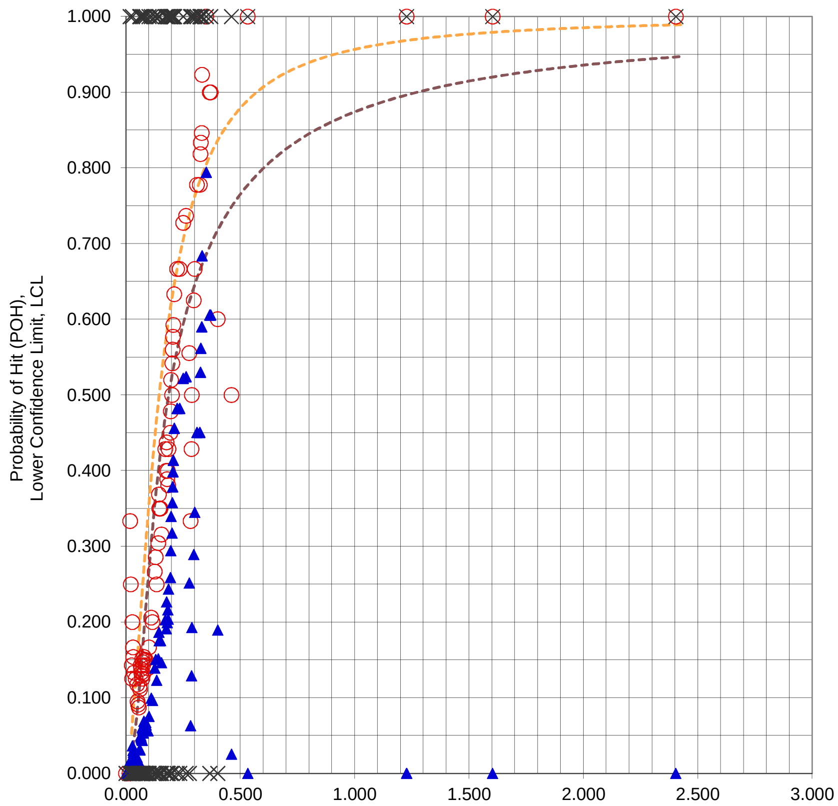
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

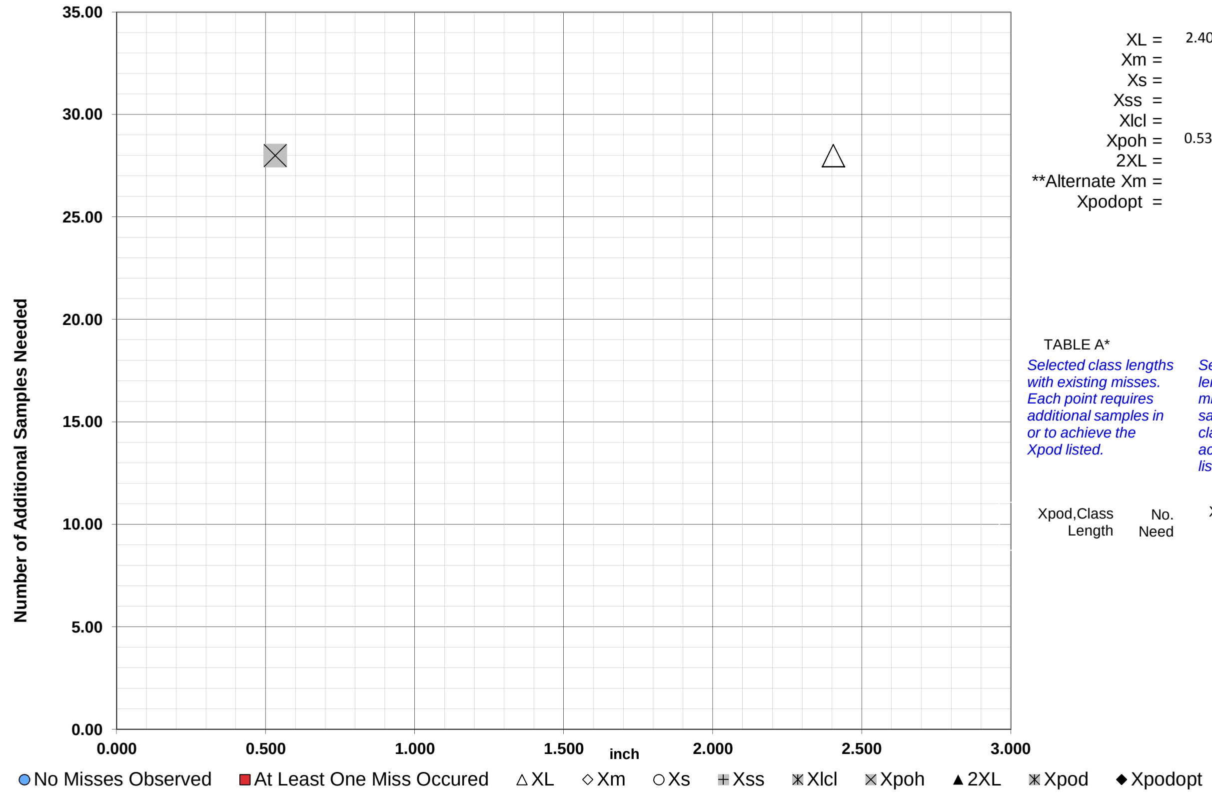


TABLE C

	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

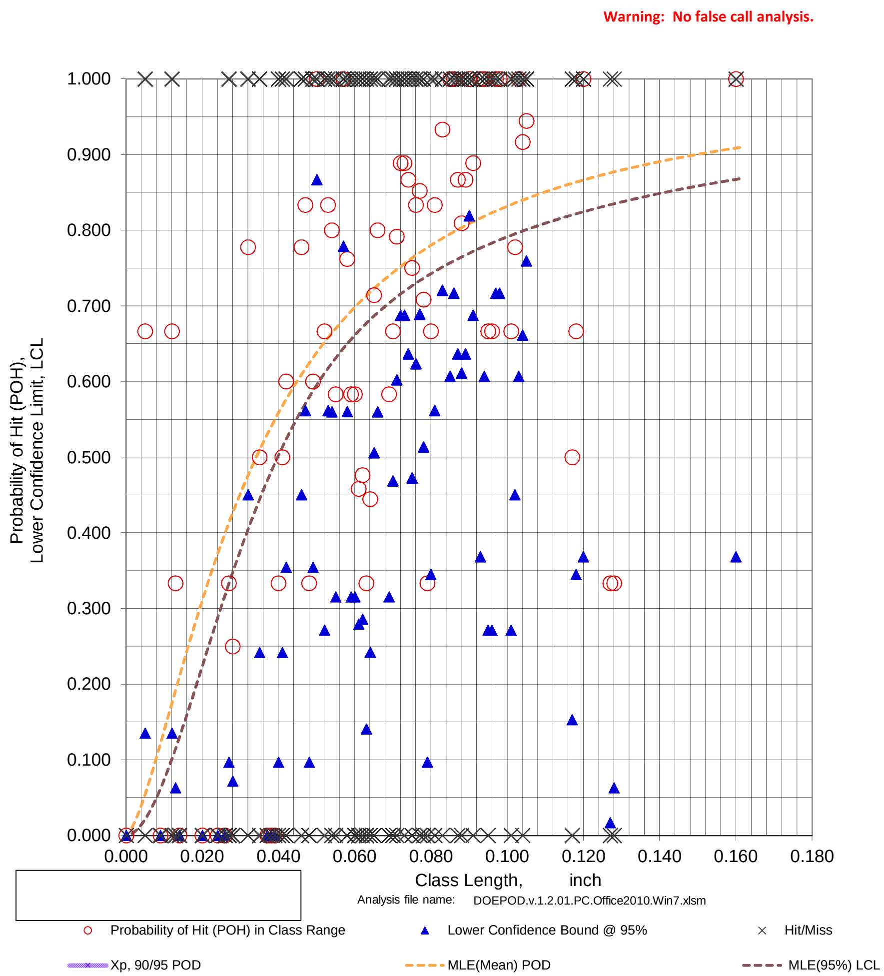
TABLE B*

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)



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

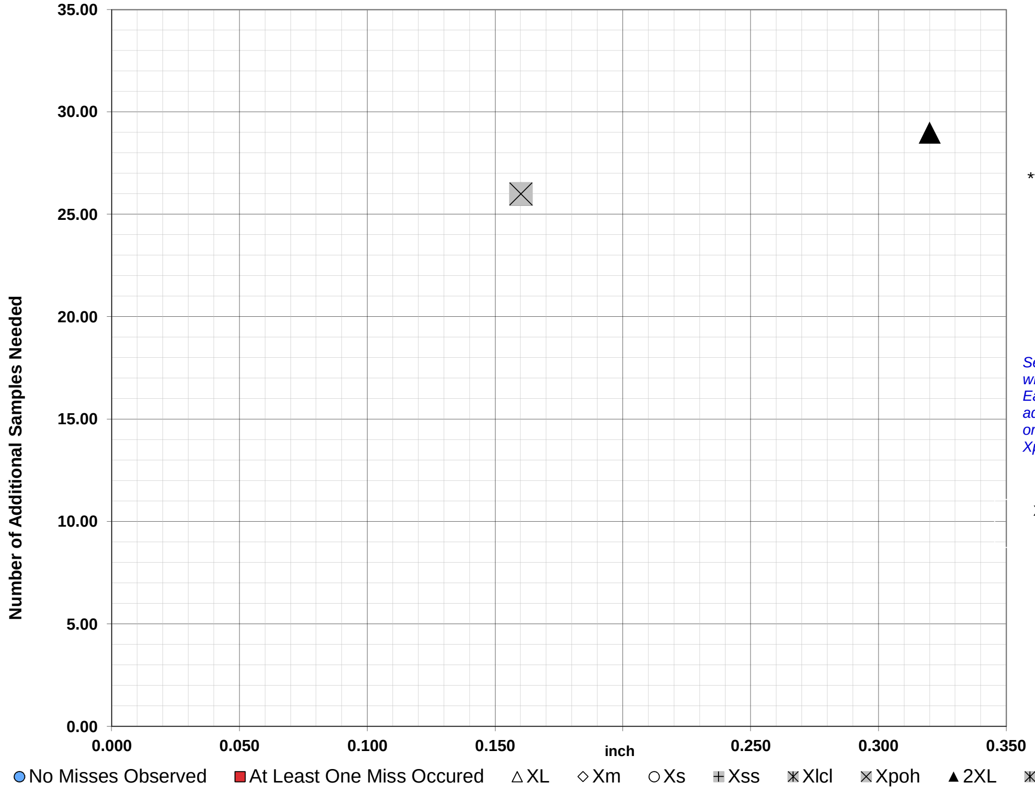


TABLE C

	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

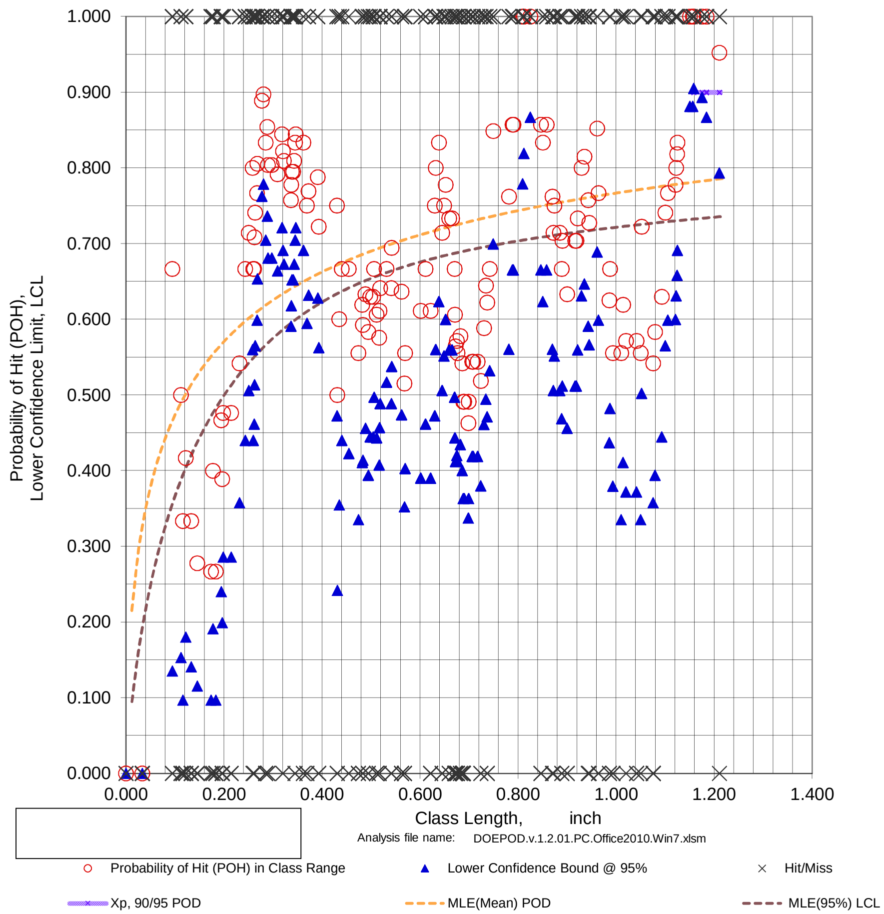
TABLE B*

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

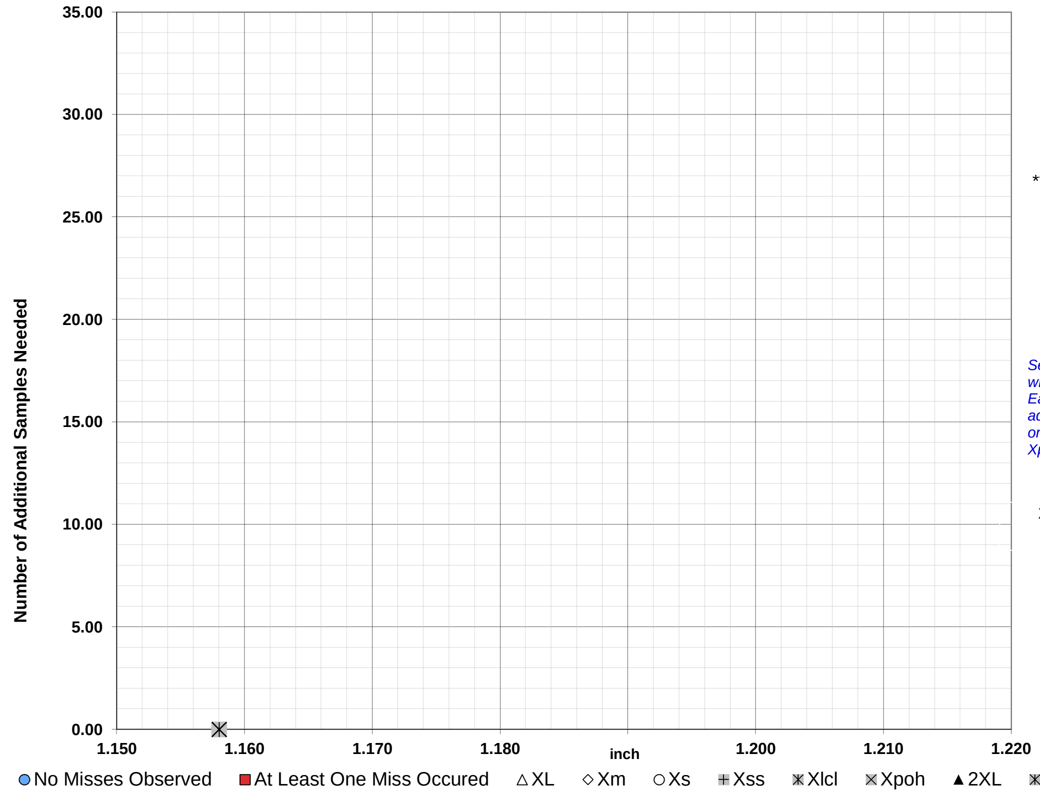


TABLE C

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*

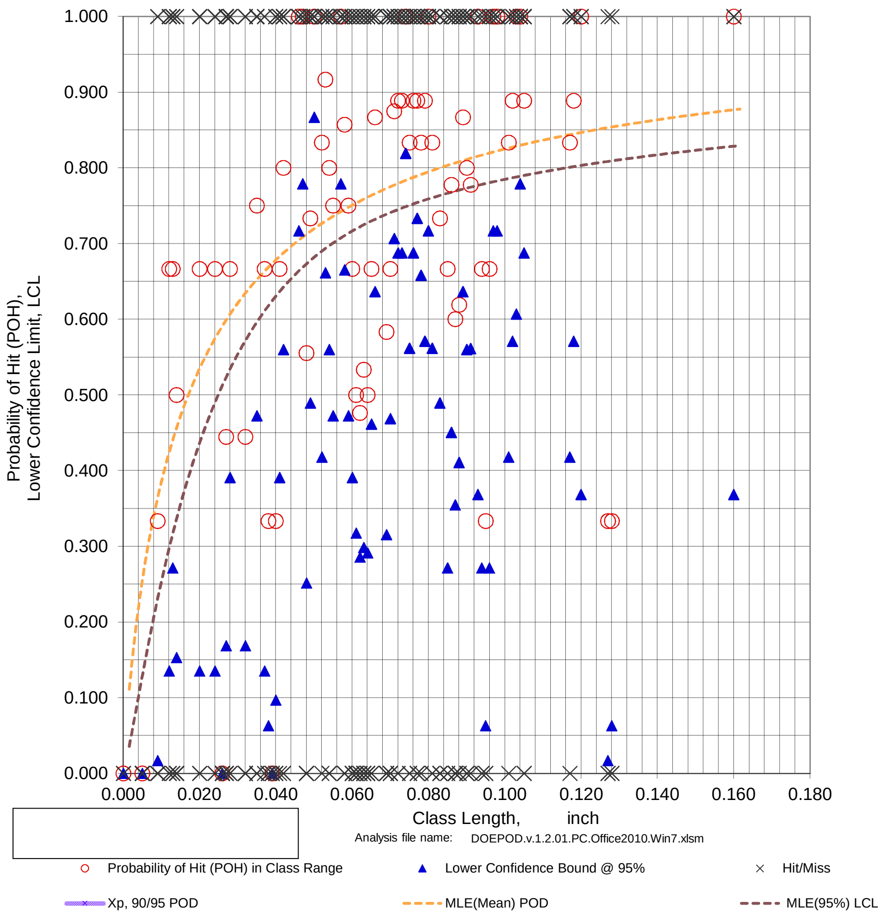
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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.)

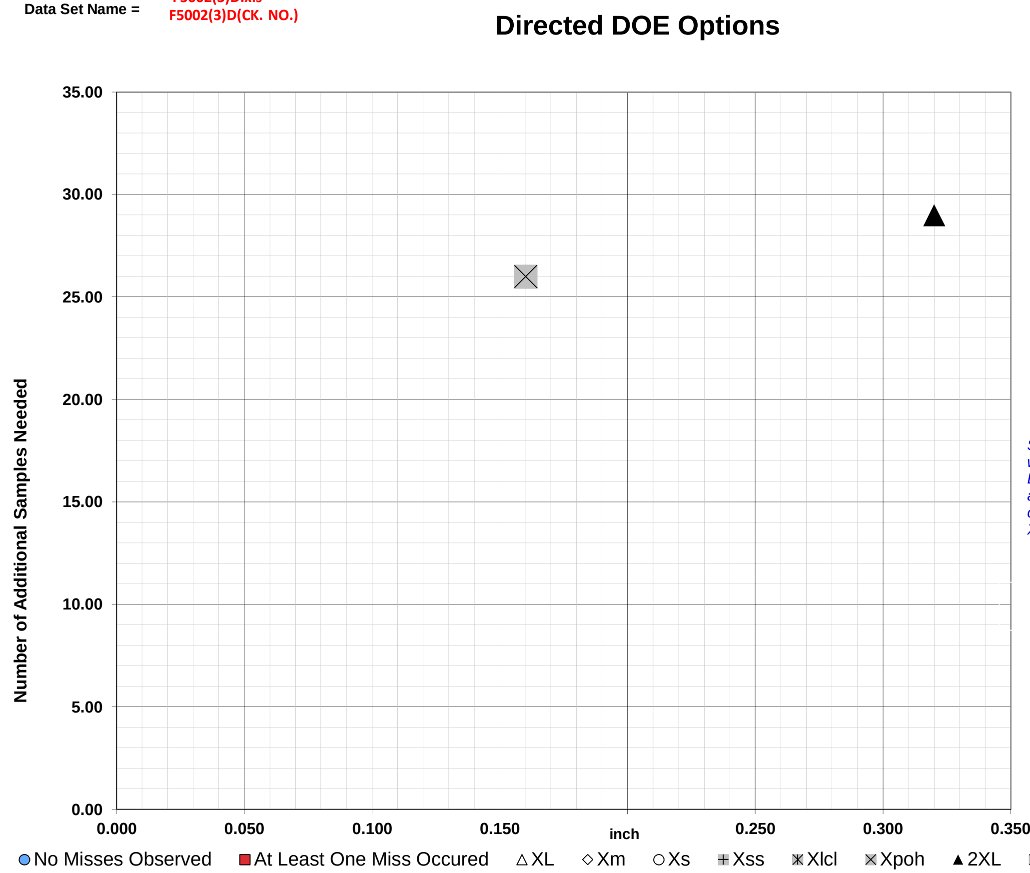


TABLE C

	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

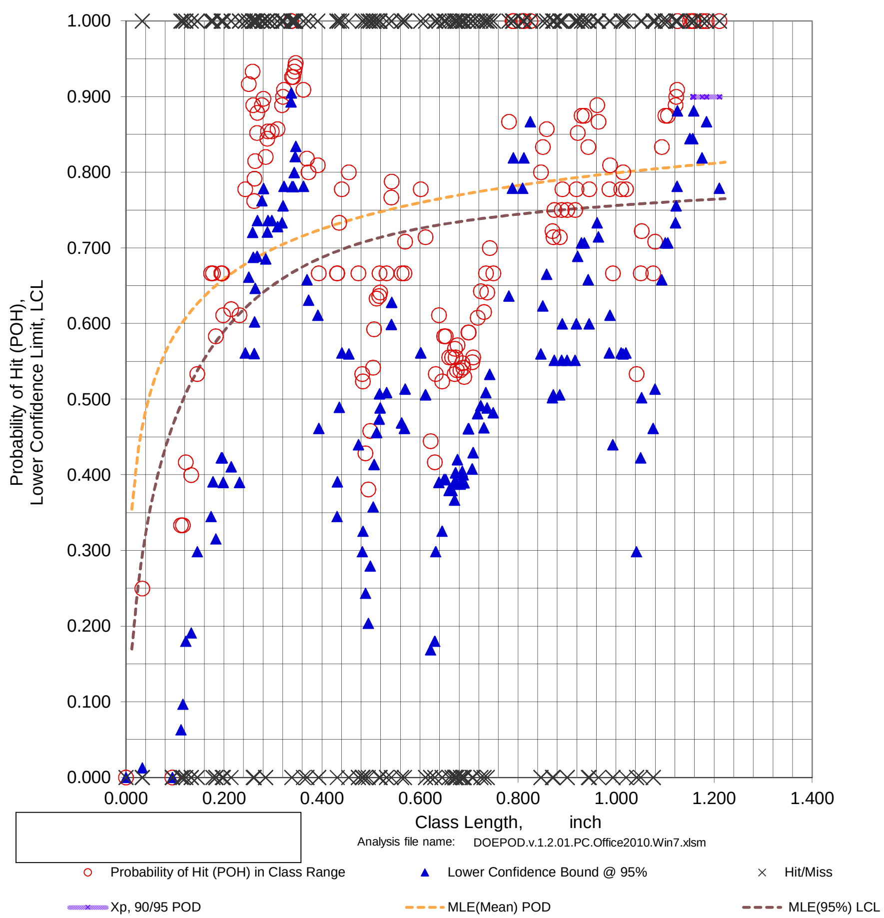
TABLE B*

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

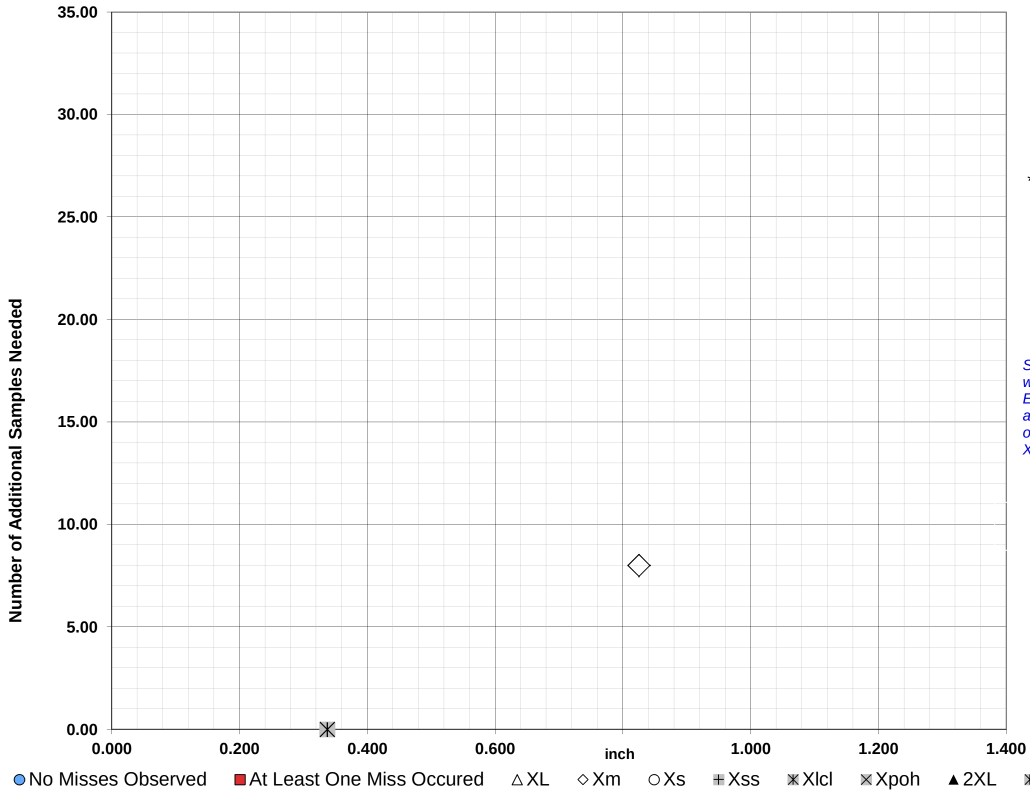


TABLE C

	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.

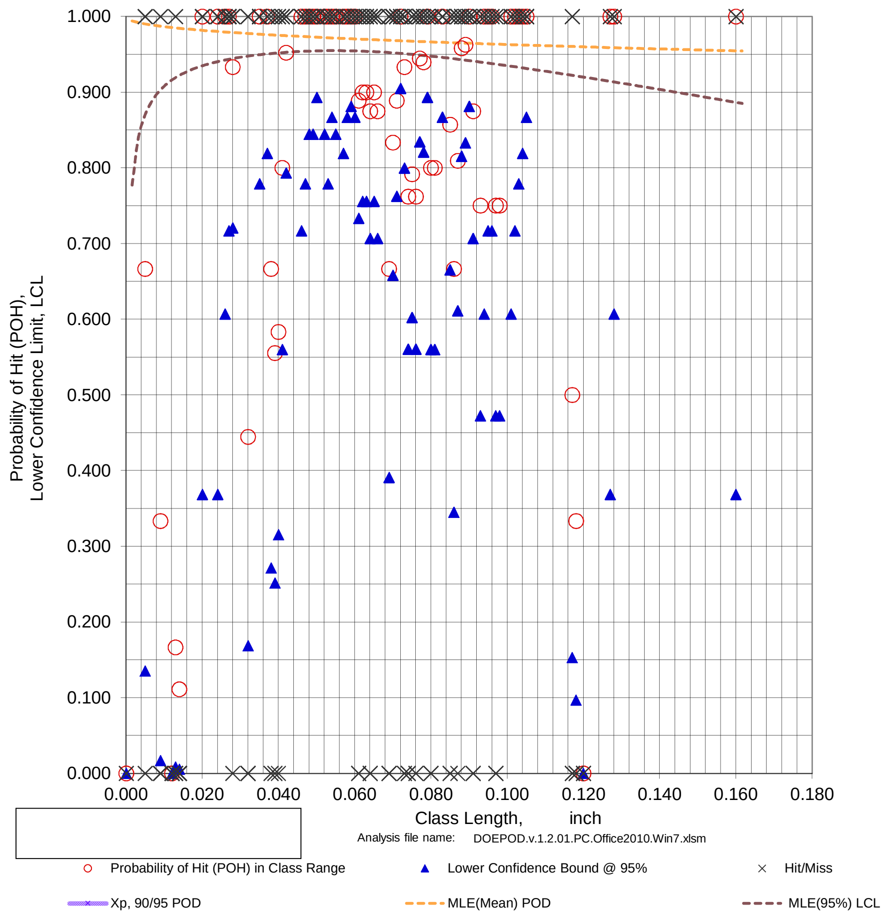
MLE Divergence Warning: Initial results listed.

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

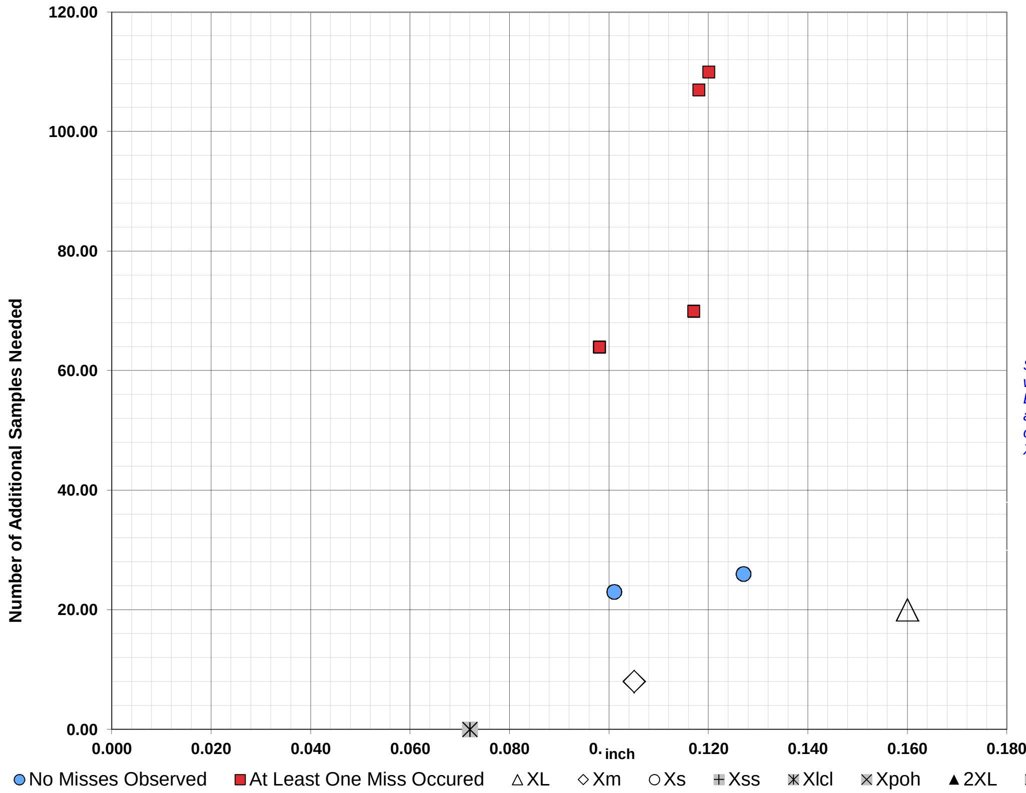


TABLE C

	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

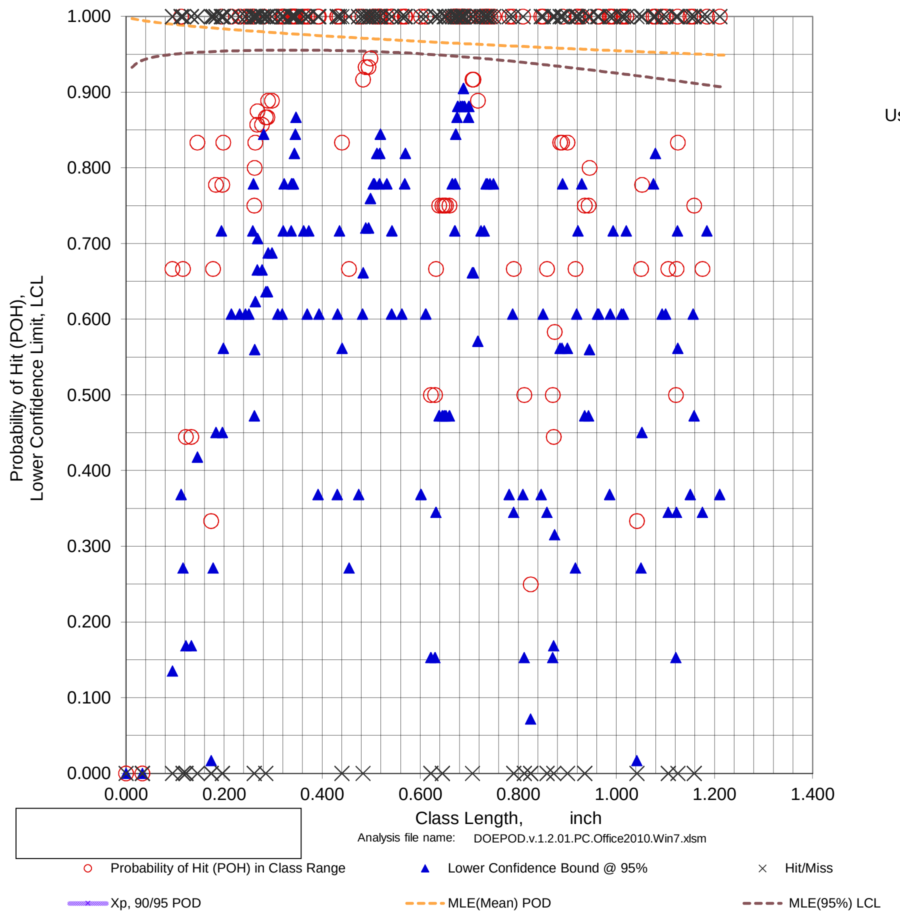
Classlength @ Best LCL = inch

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

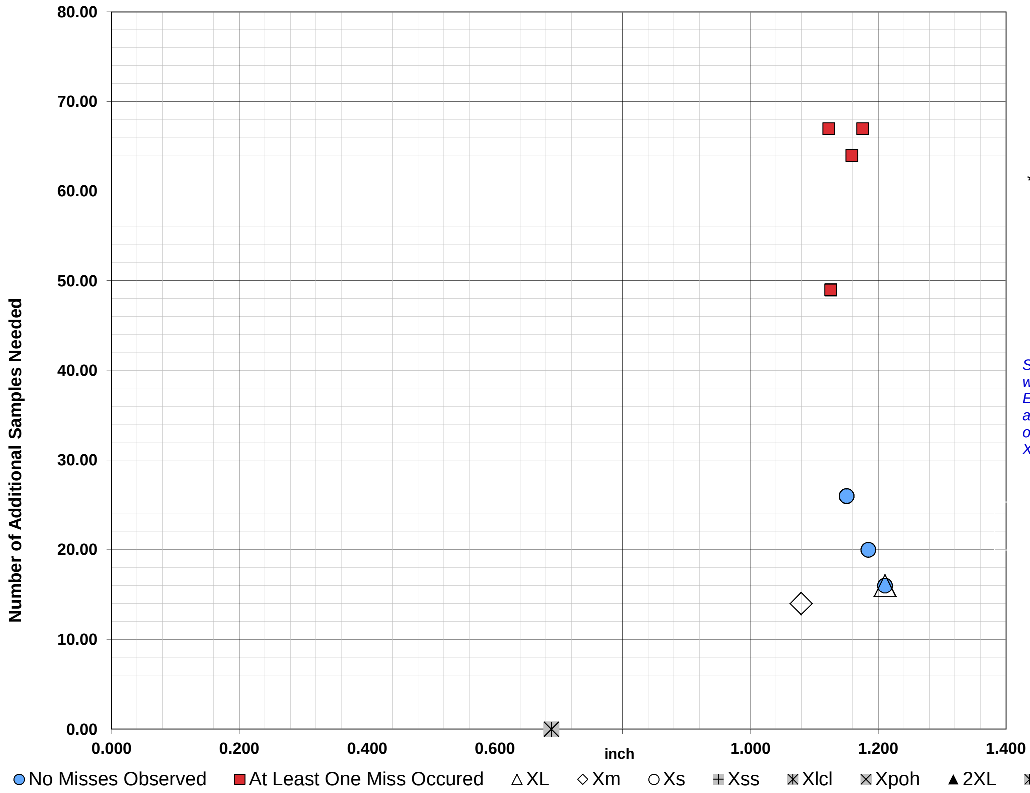


TABLE C

	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*

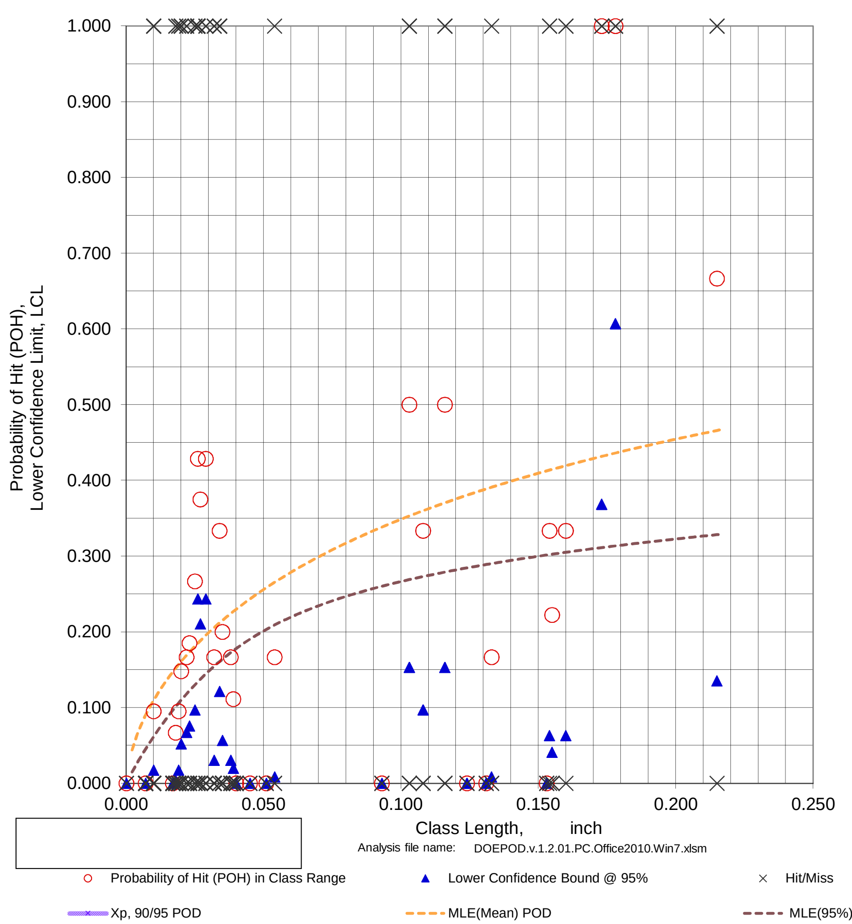
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

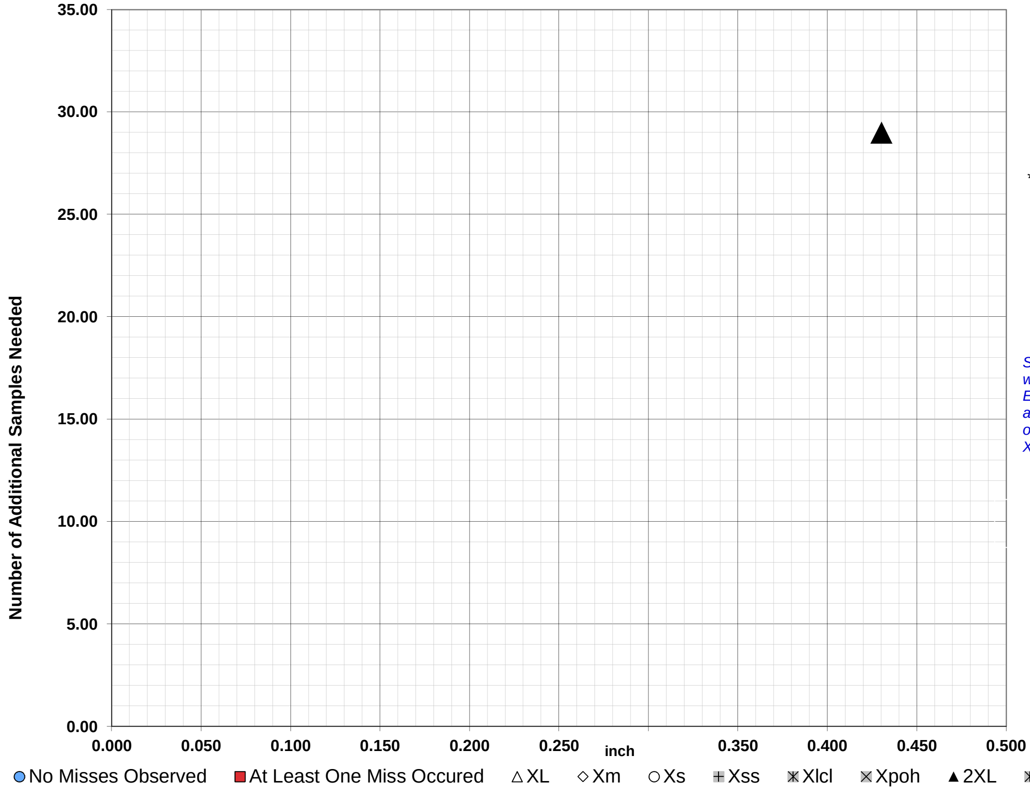


TABLE C

	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*

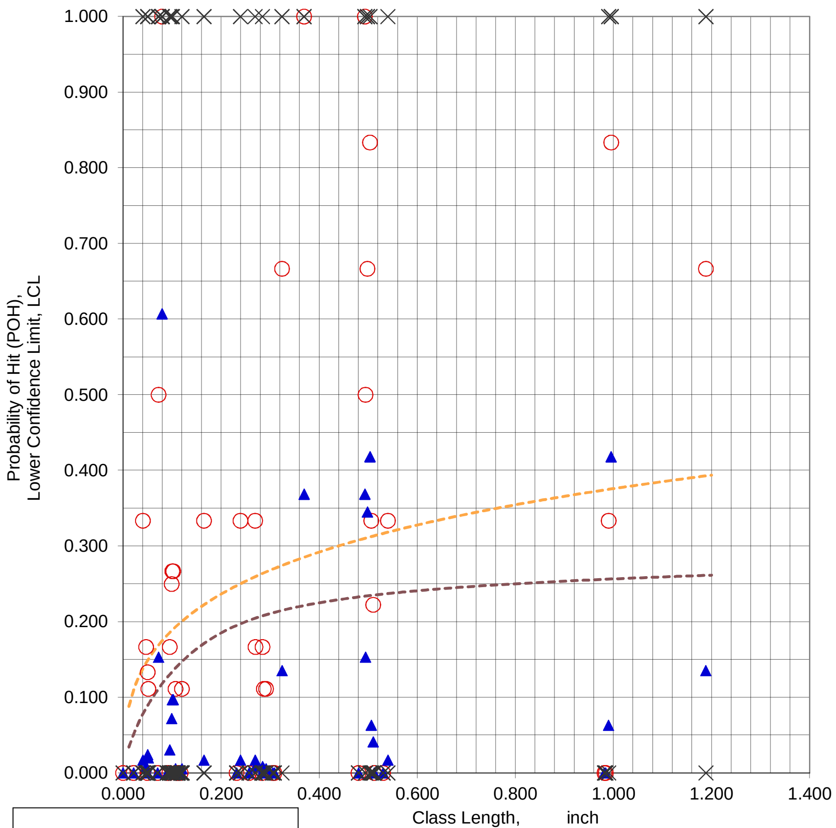
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

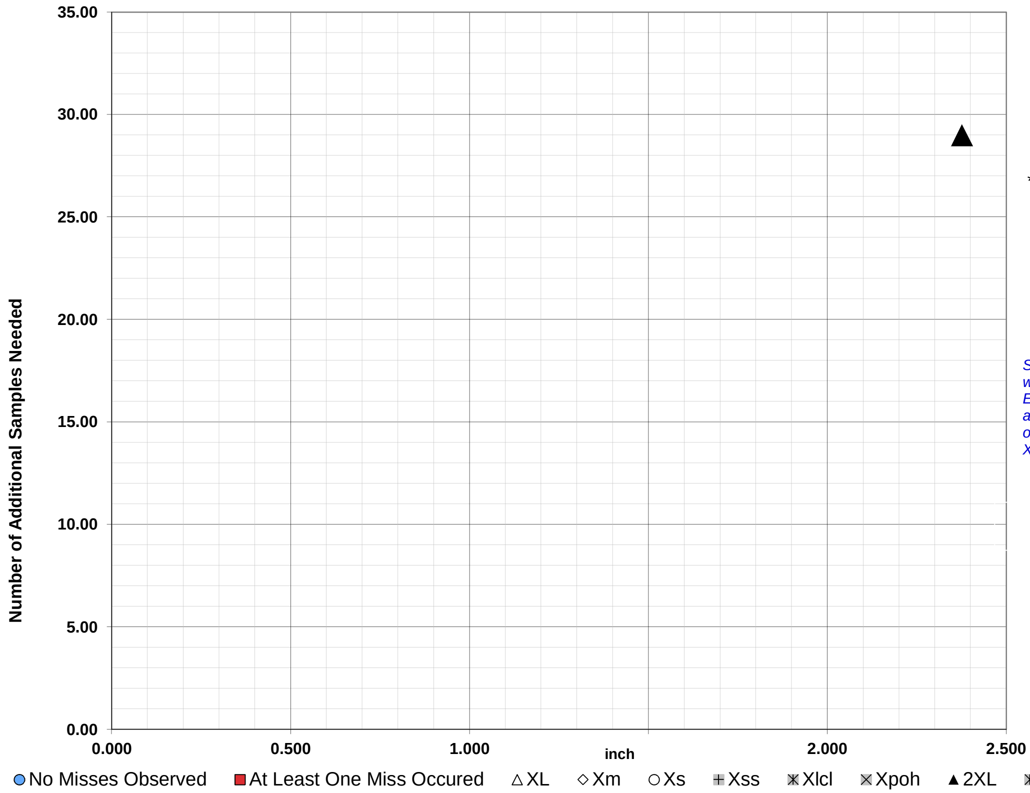


TABLE C

	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*

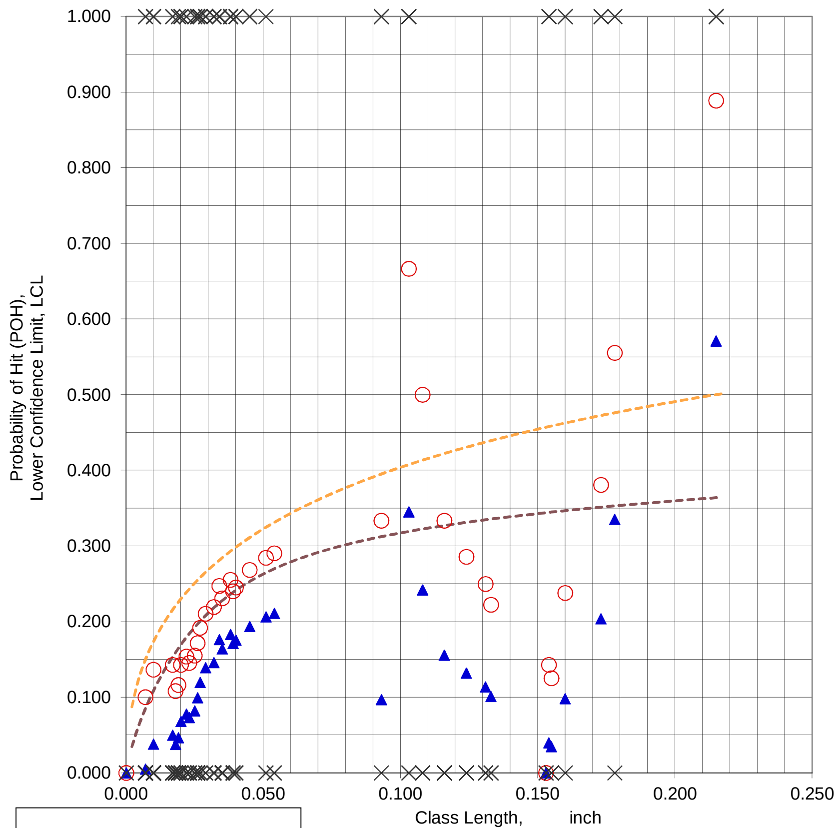
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

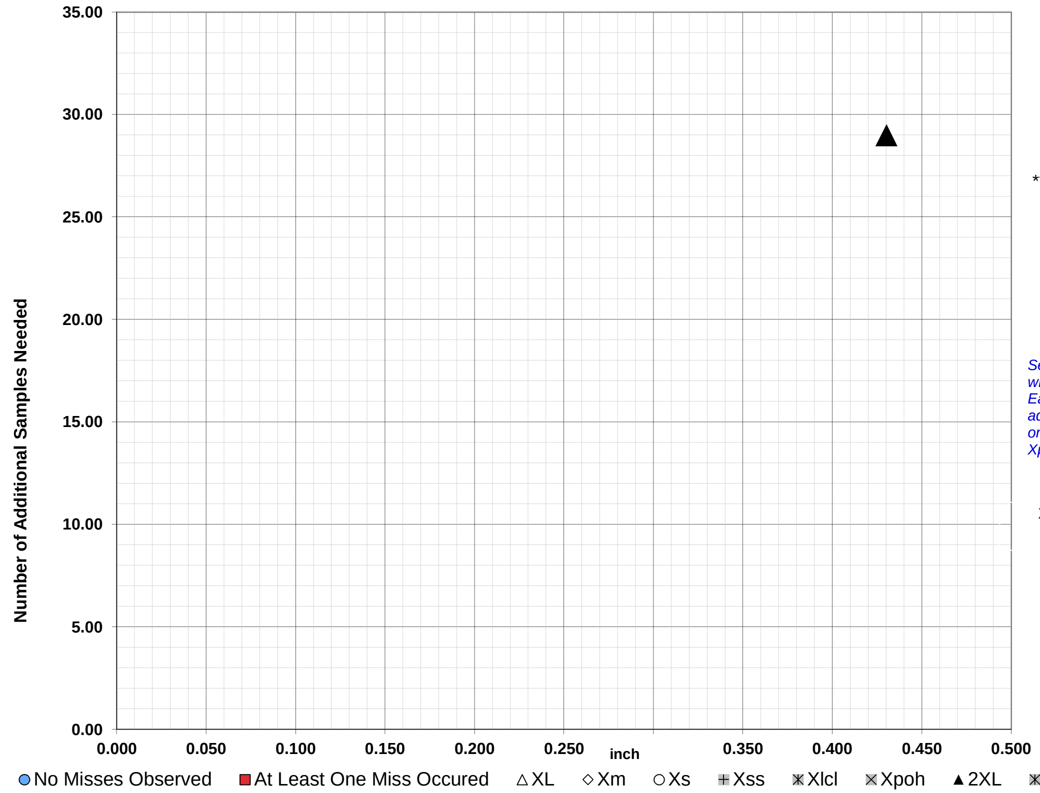


TABLE C

	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*

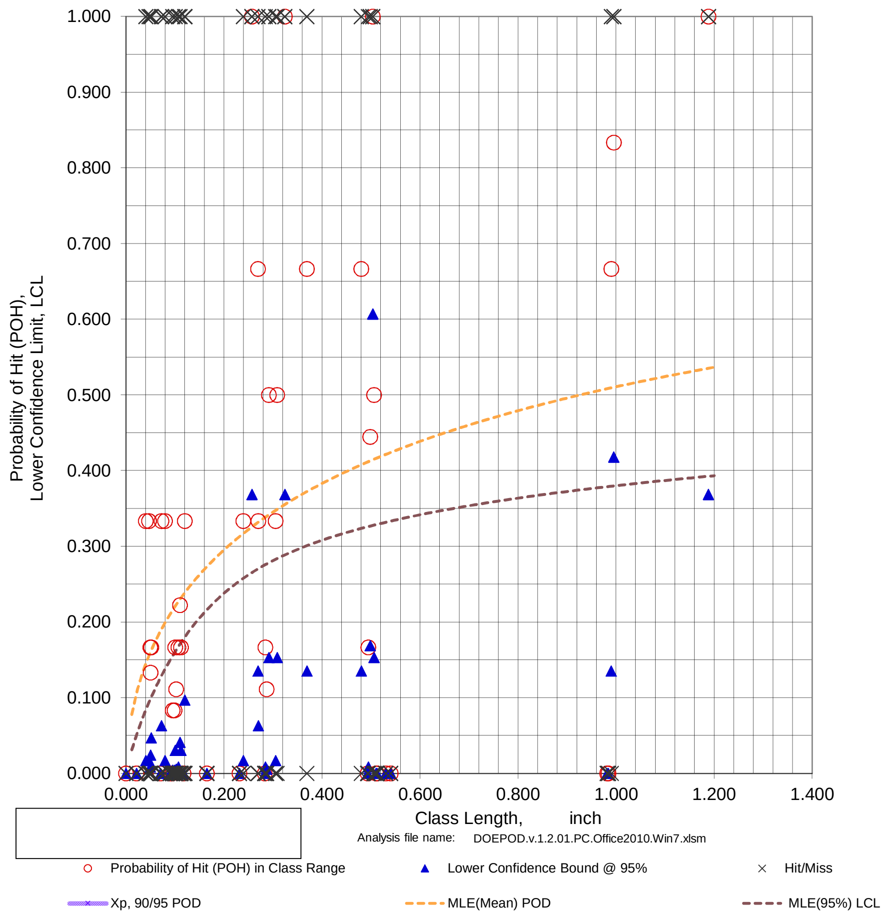
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

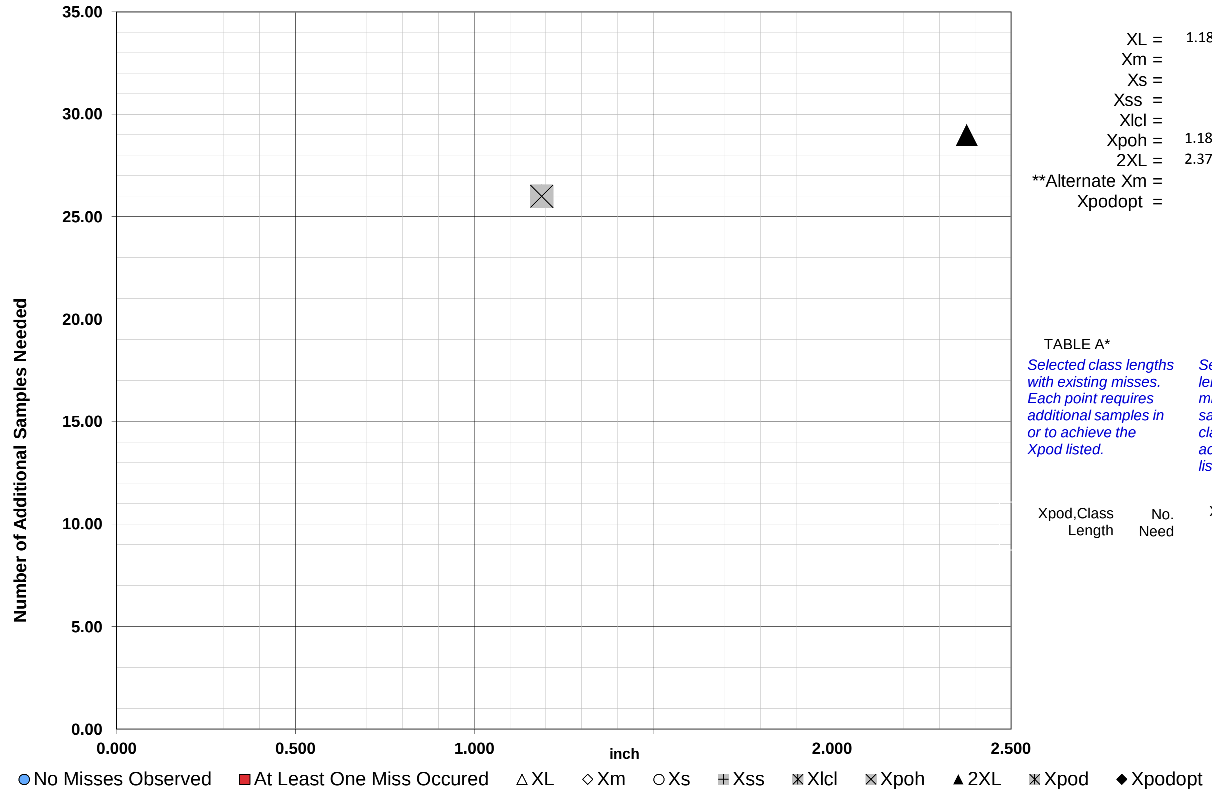


TABLE C

	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*

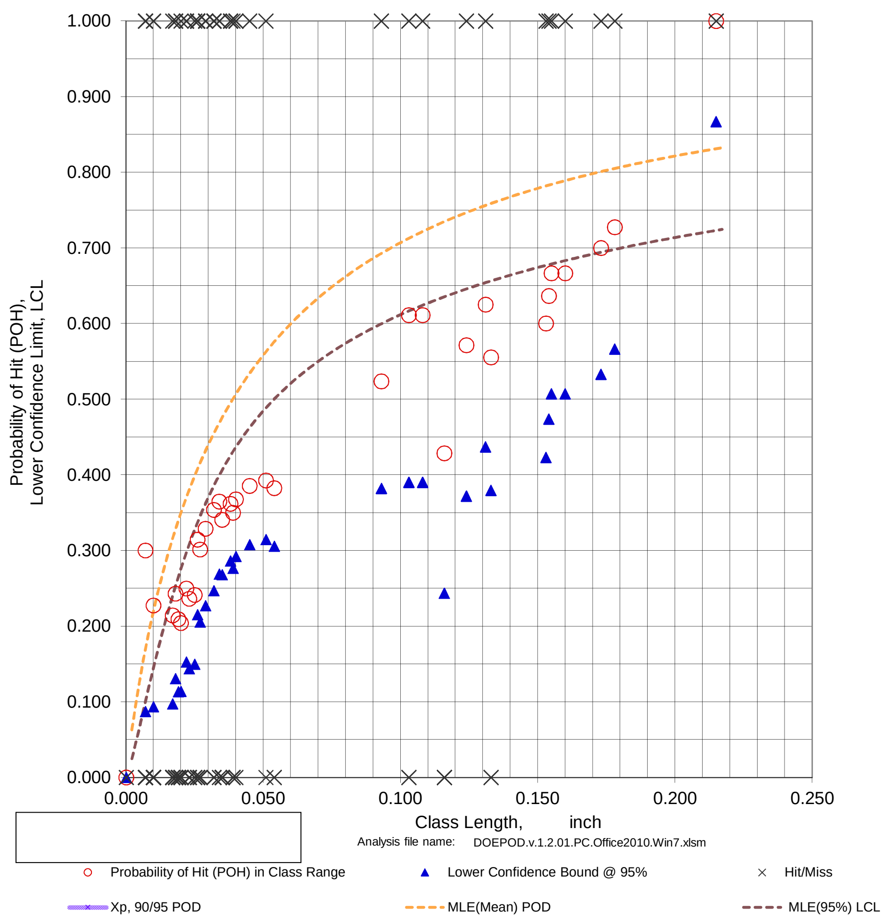
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

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

Warning: No false call analysis.



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 = 0.215 inch
Samples Needed @ XL = 8
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 = 8
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

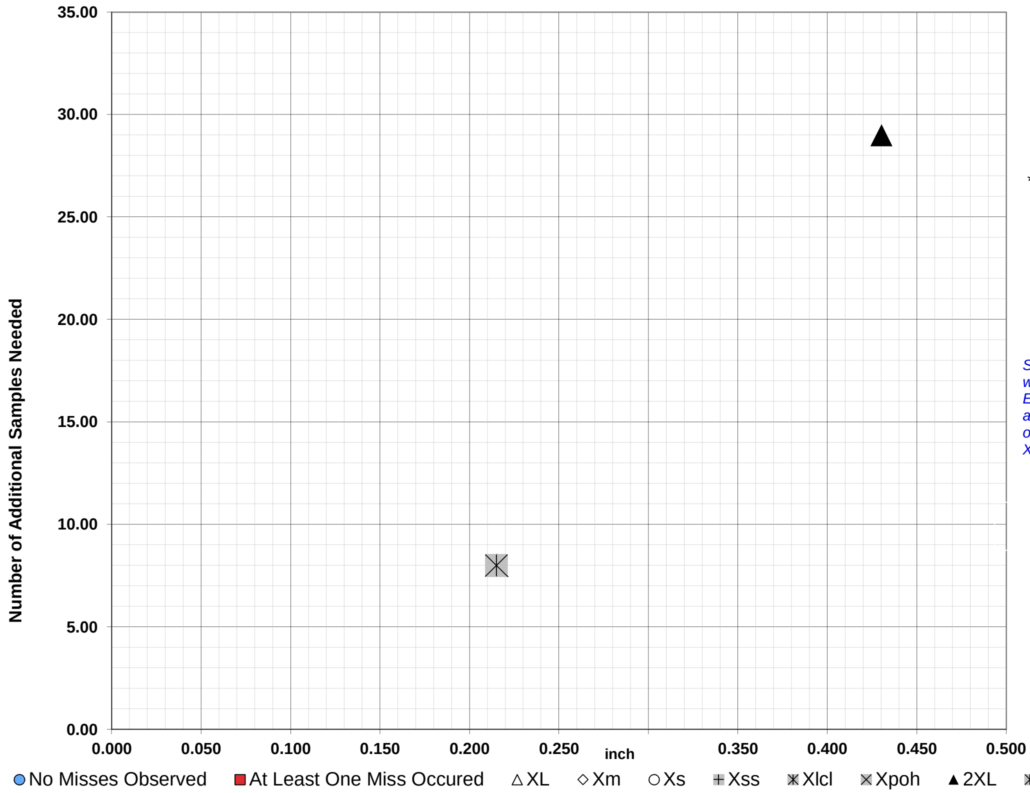


TABLE C

	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*

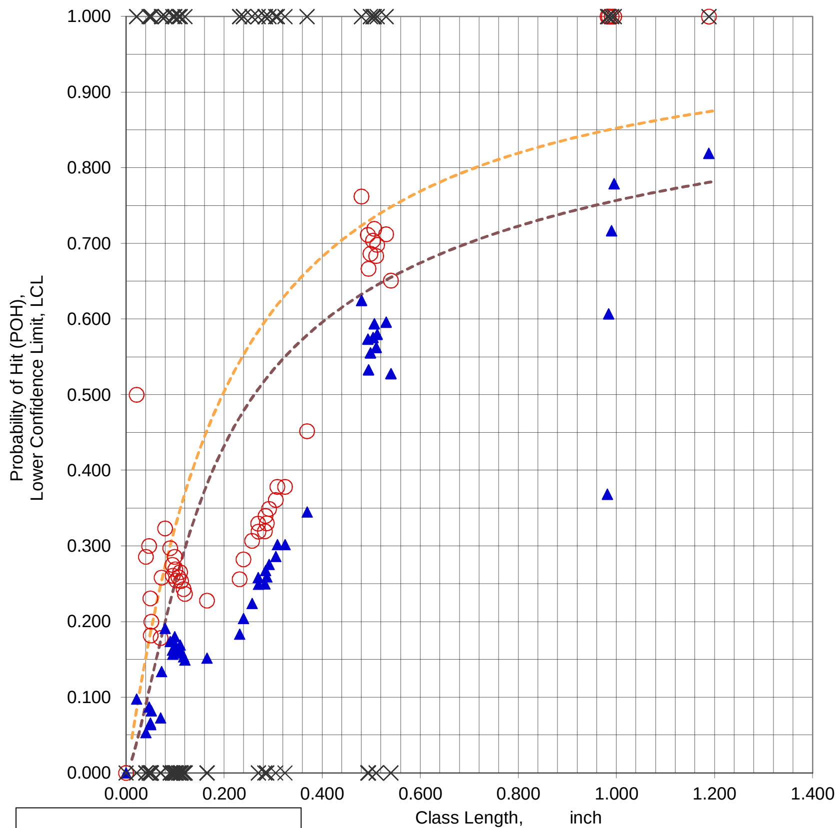
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

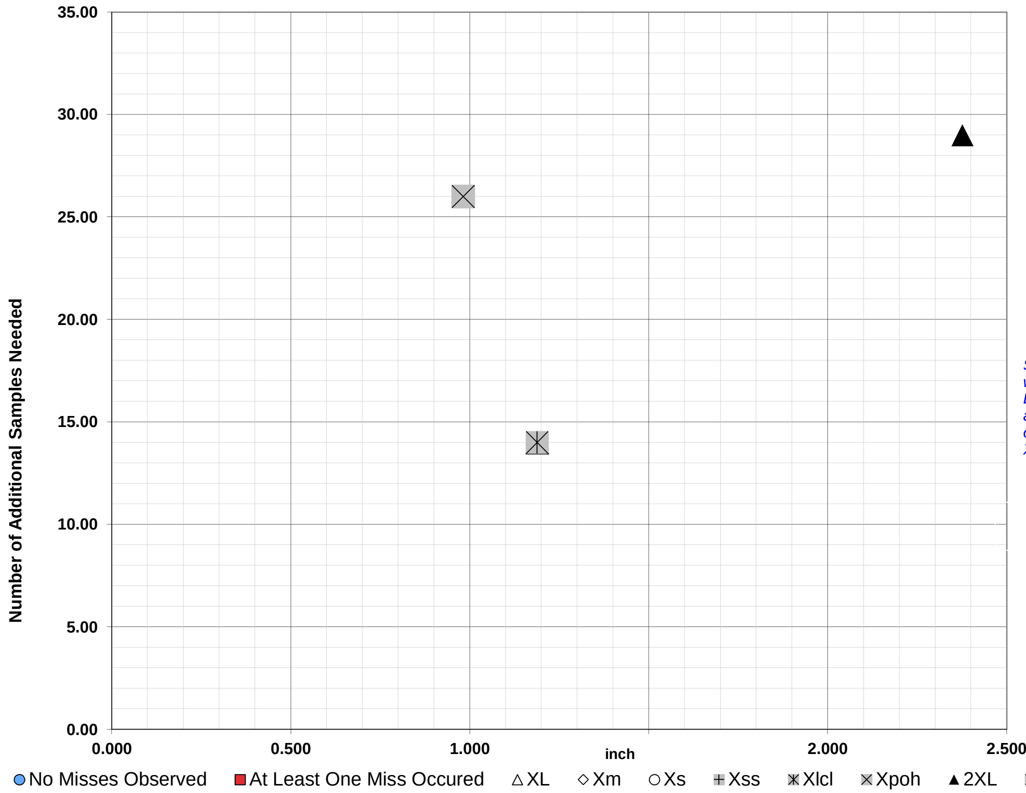


TABLE C

	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*

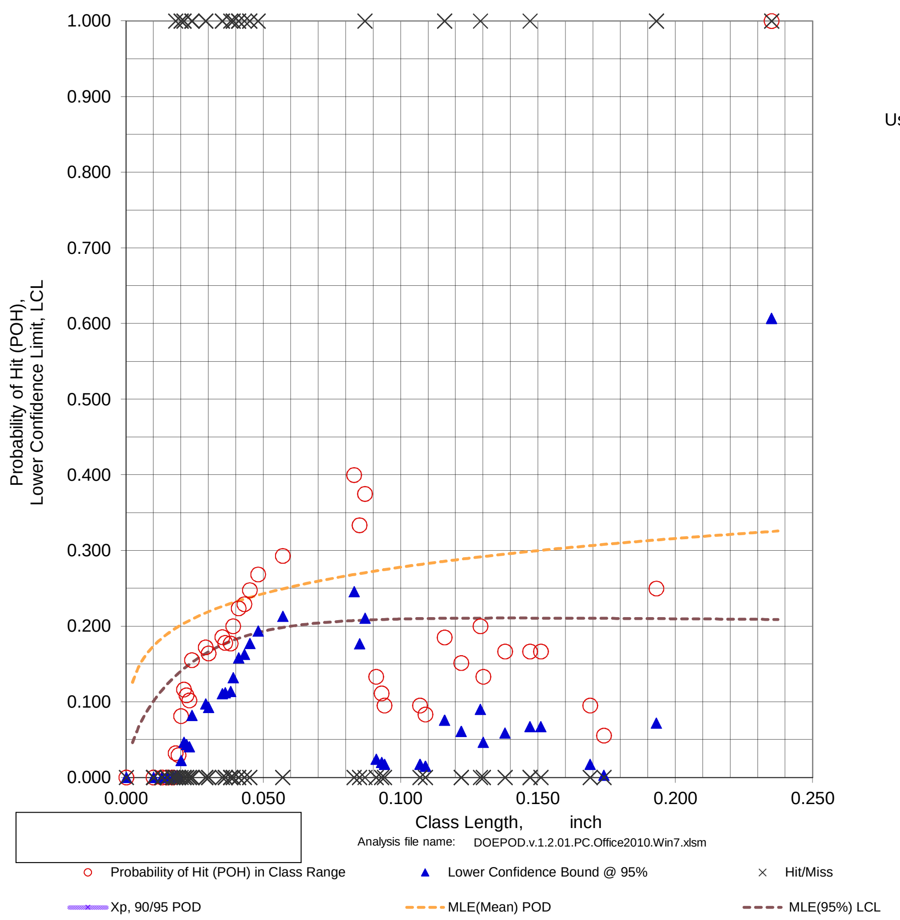
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

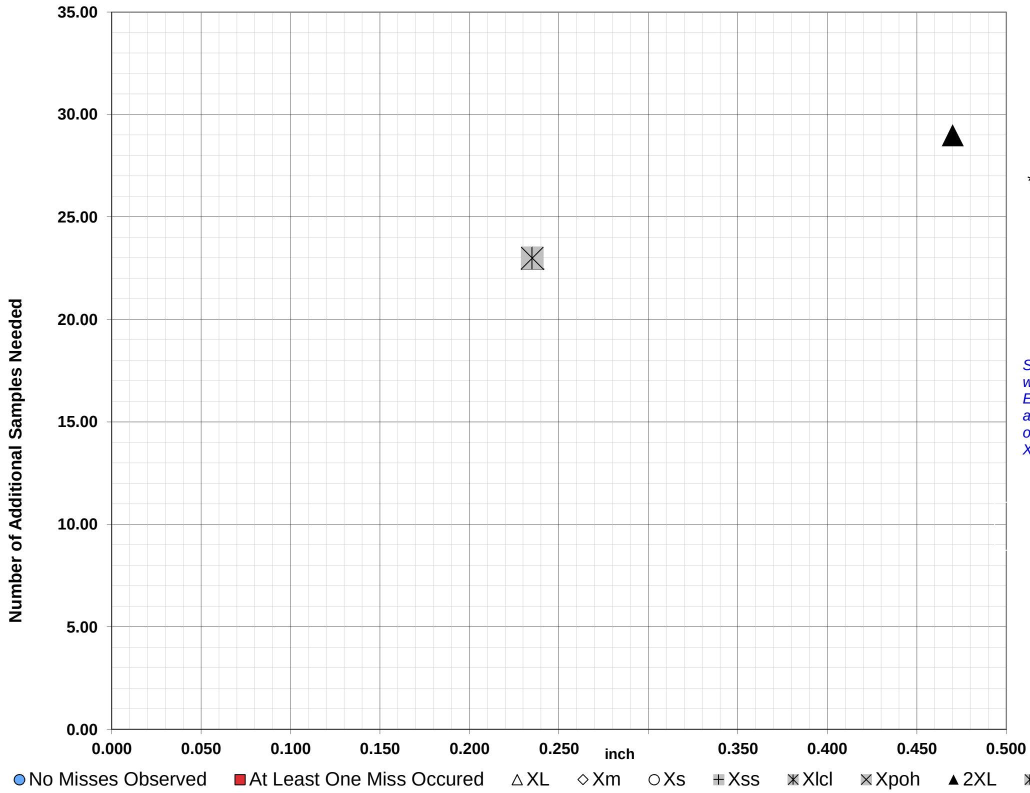


TABLE C

	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*

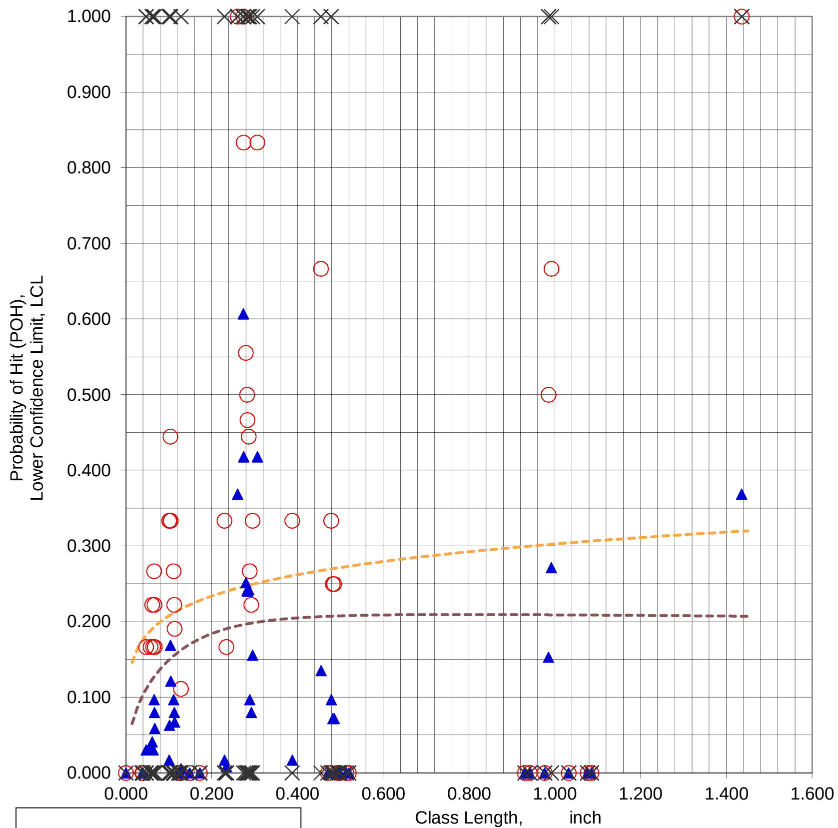
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

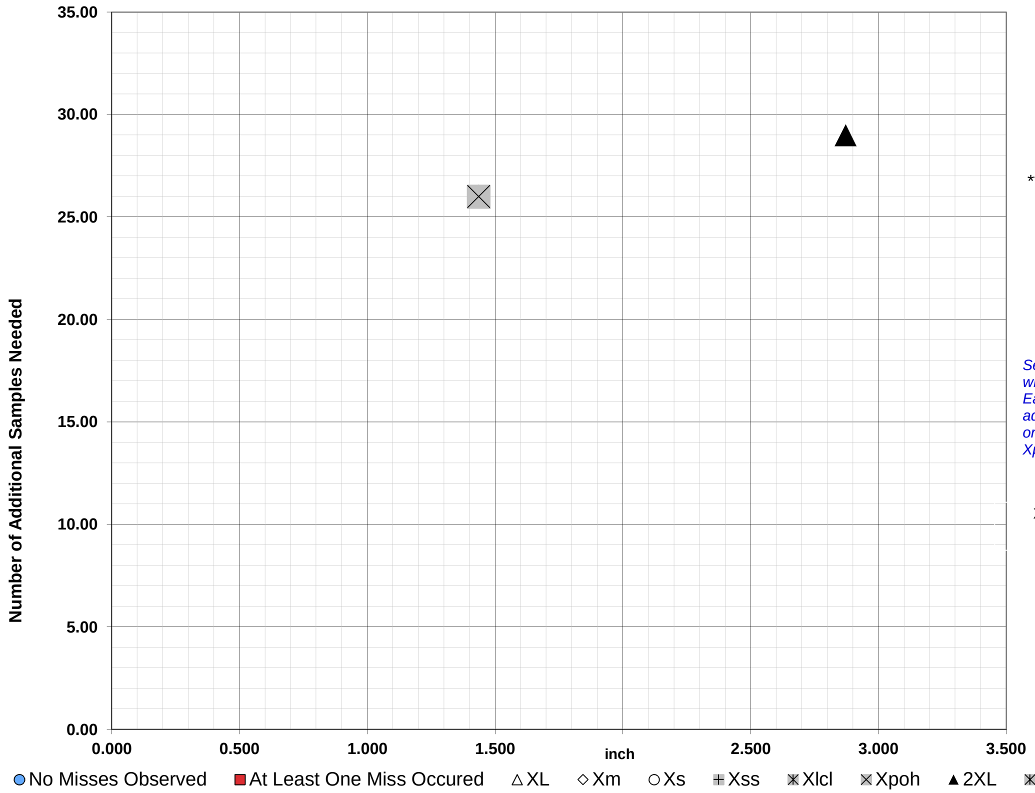


TABLE C

	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*

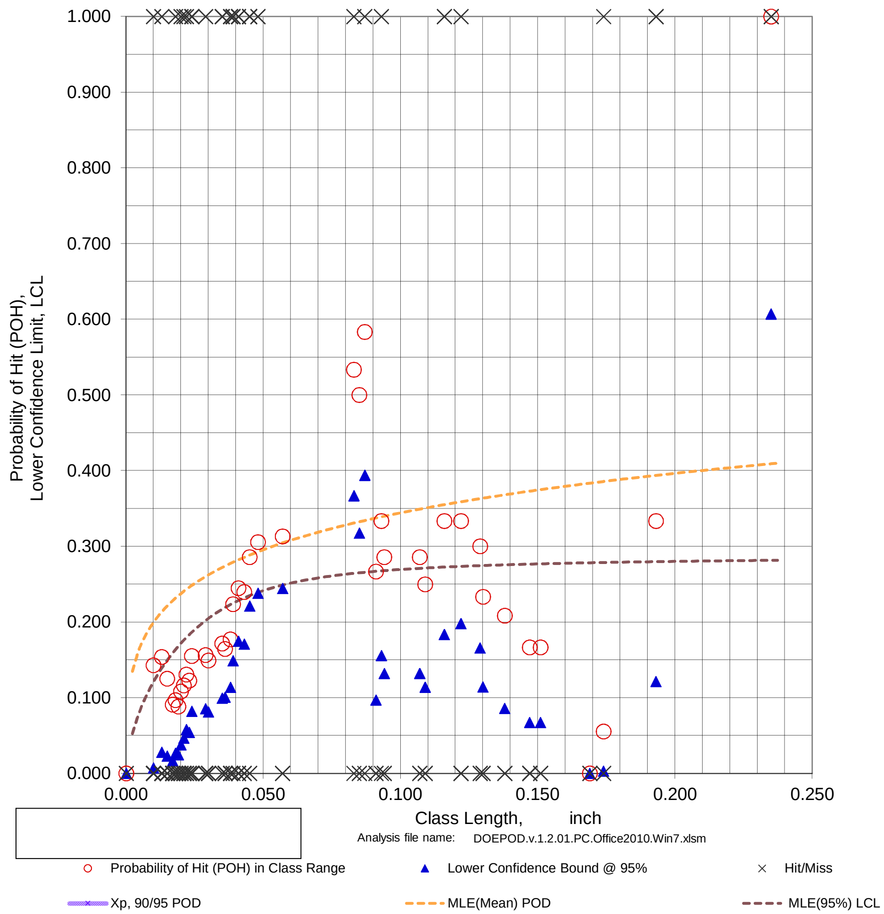
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

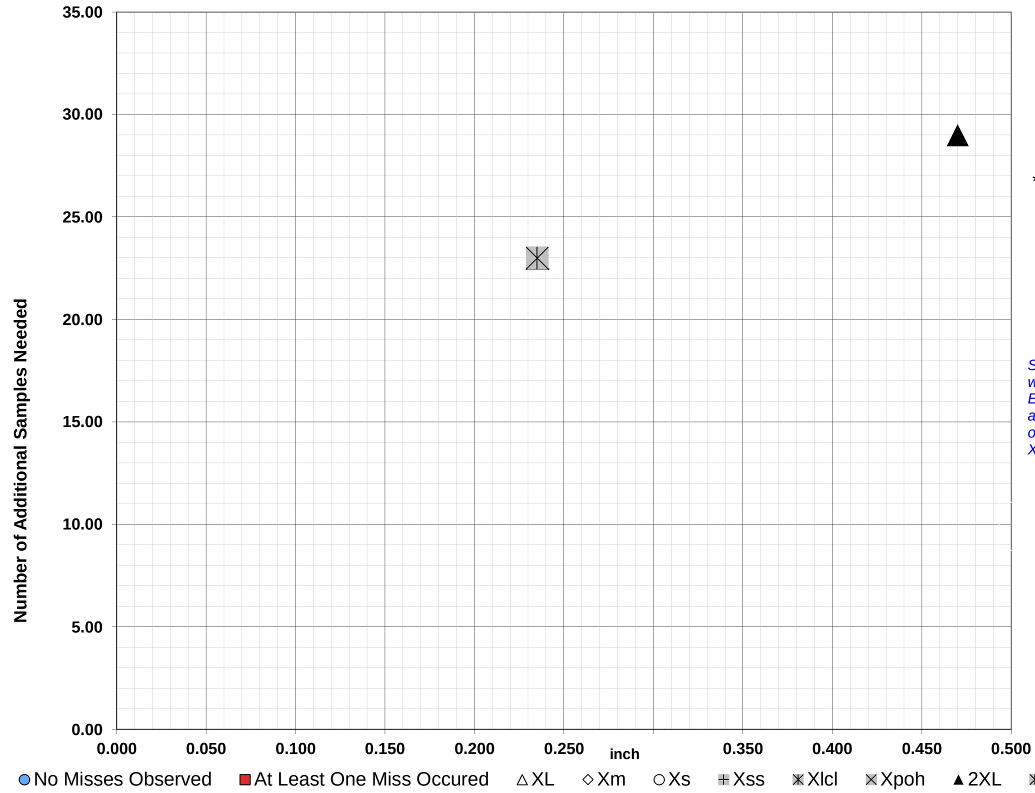


TABLE C

	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*

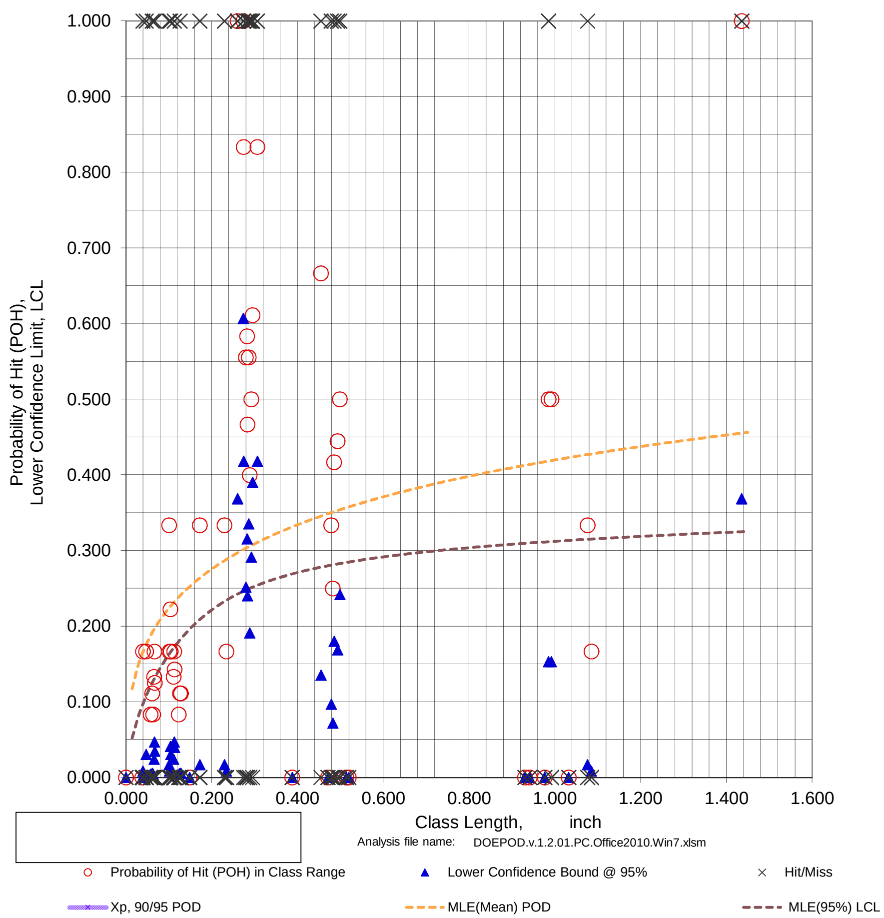
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

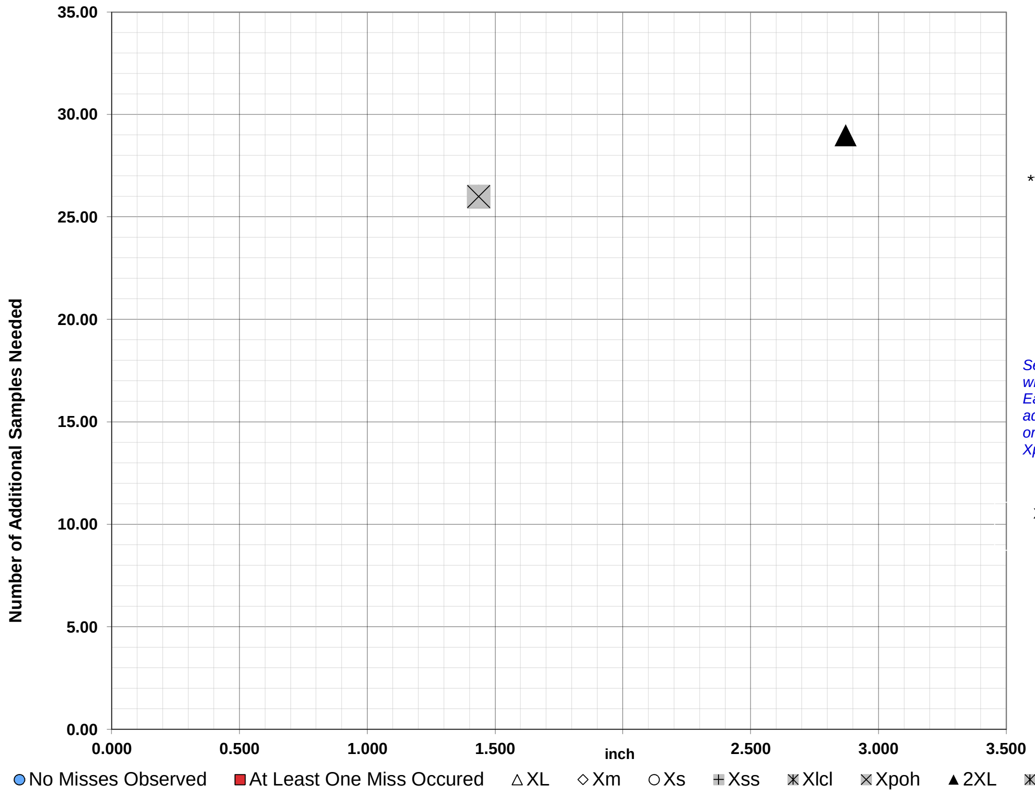


TABLE C

	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*

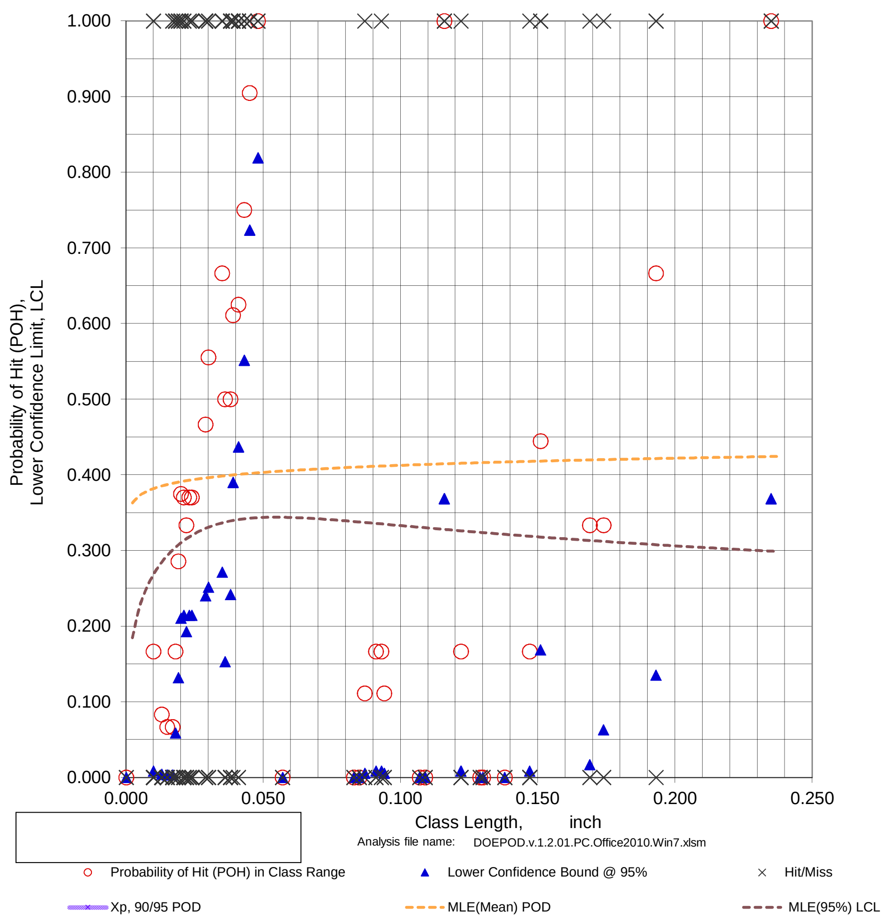
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

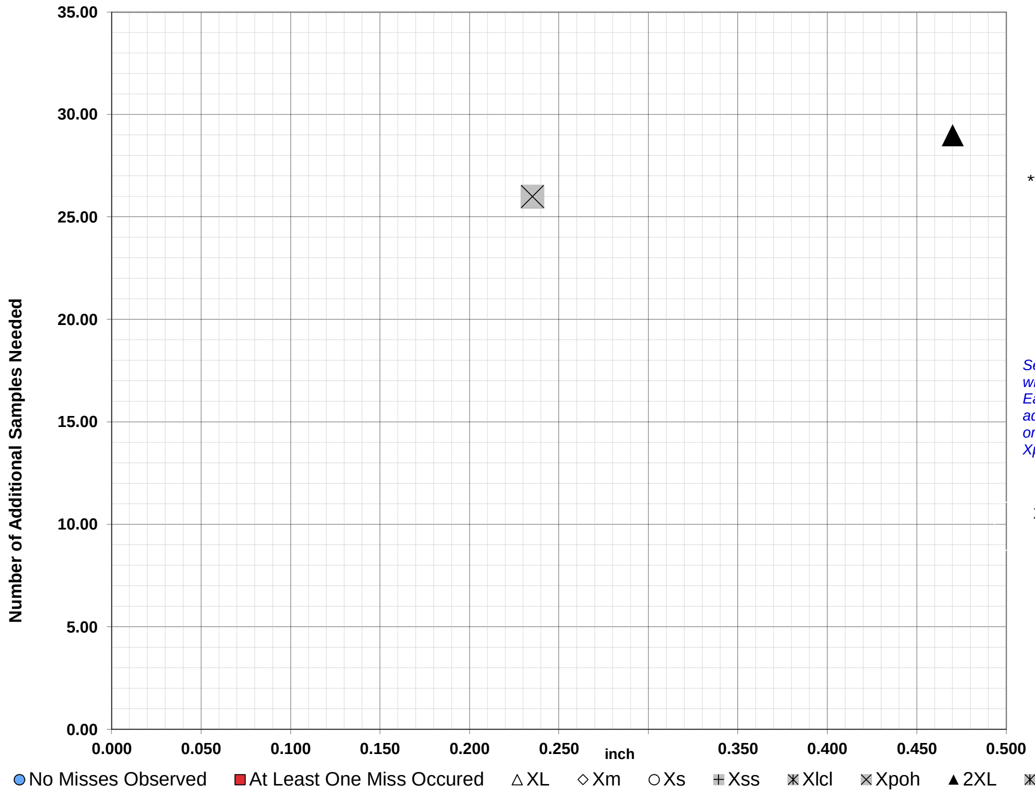


TABLE C

	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*

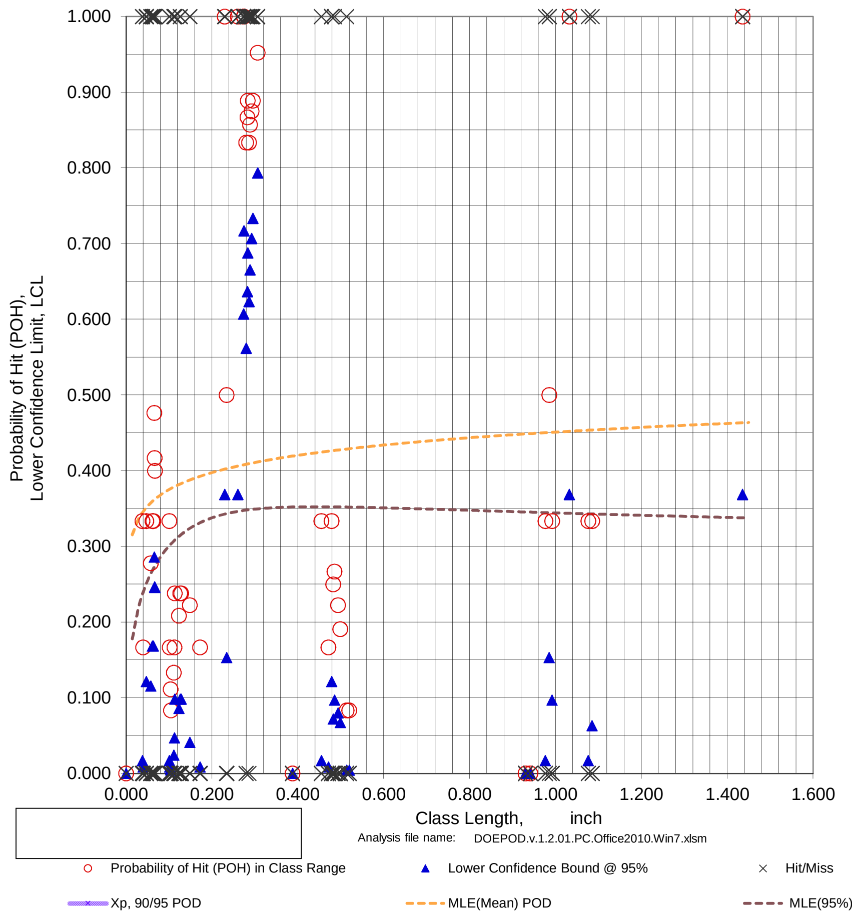
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

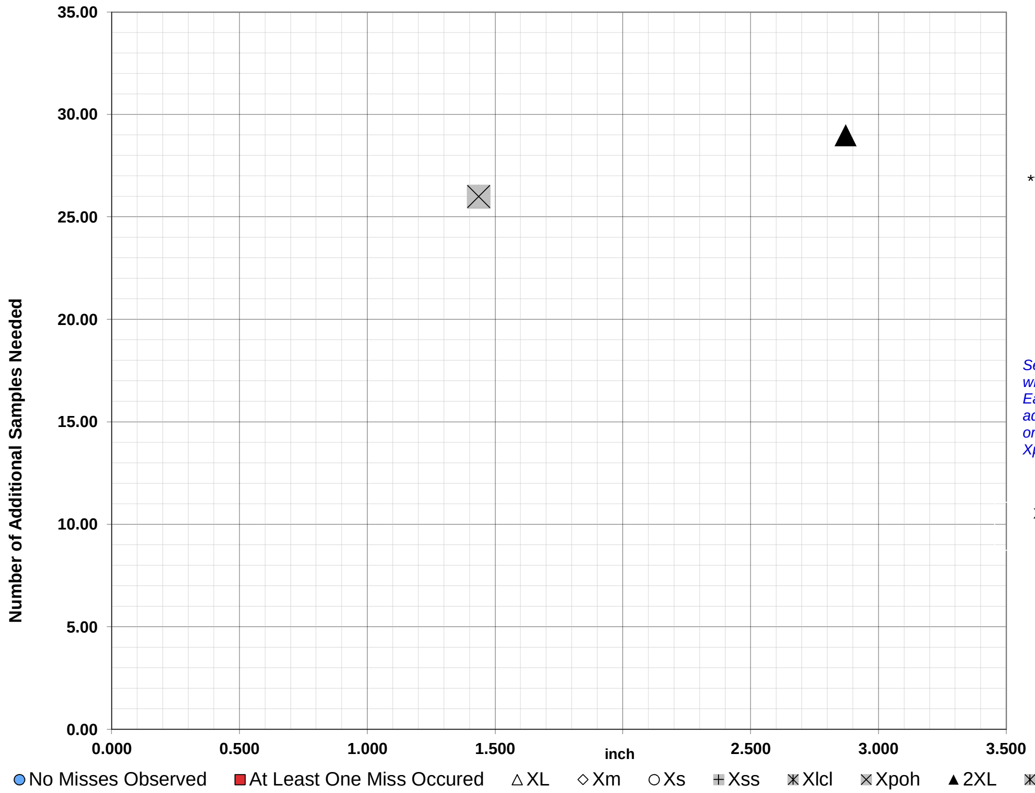


TABLE C

	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*

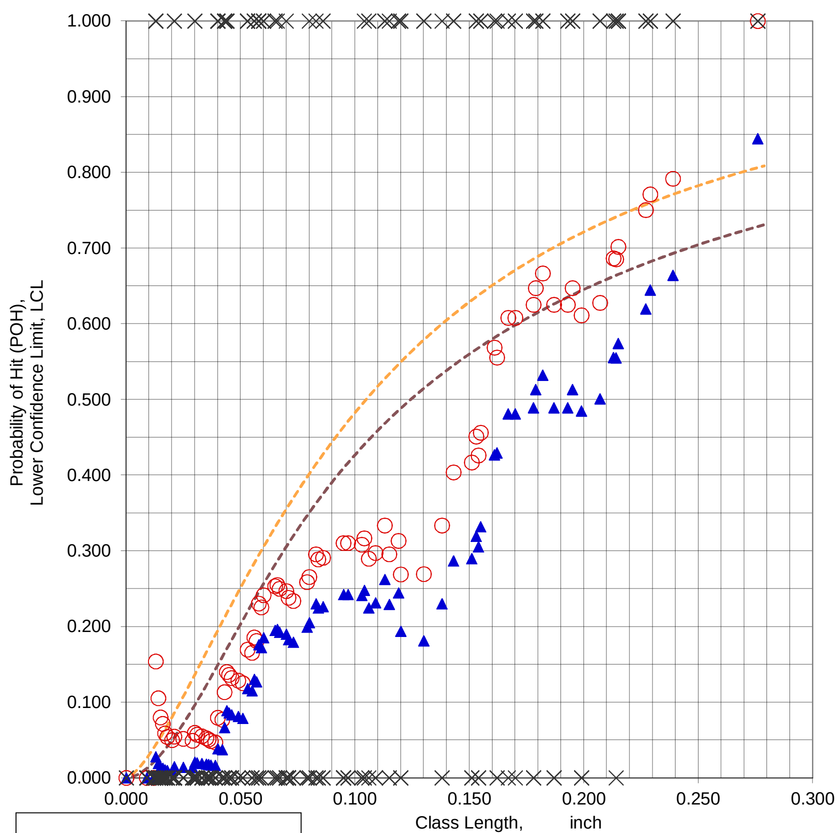
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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)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

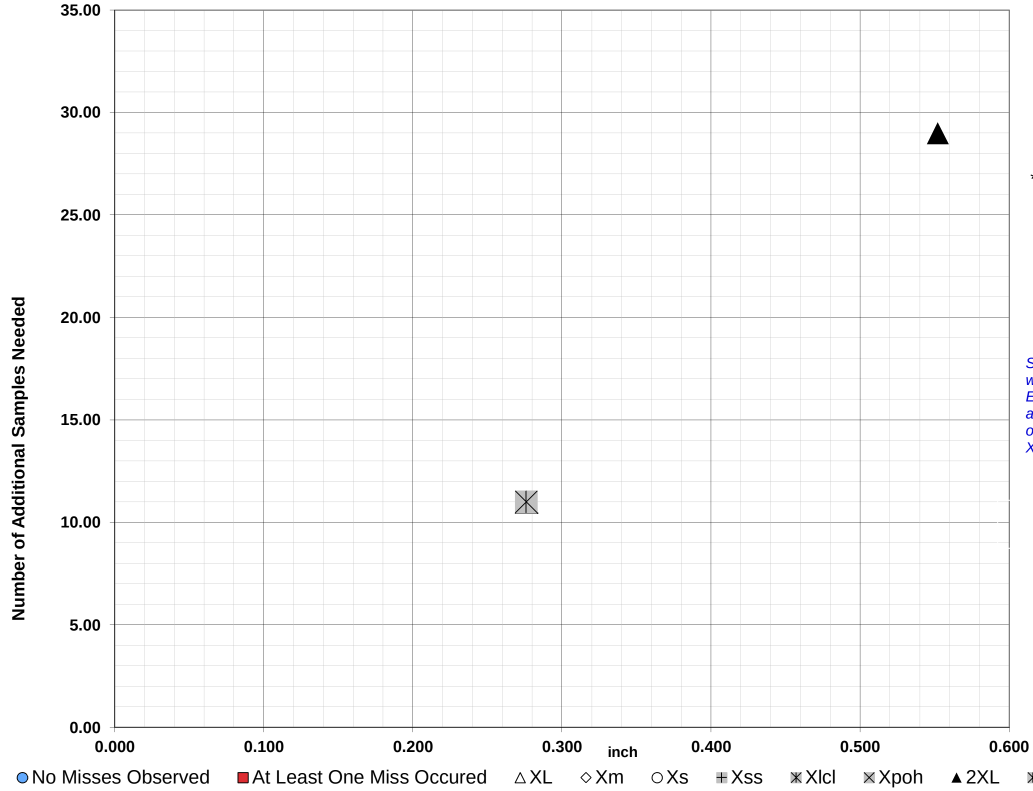


TABLE C

	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

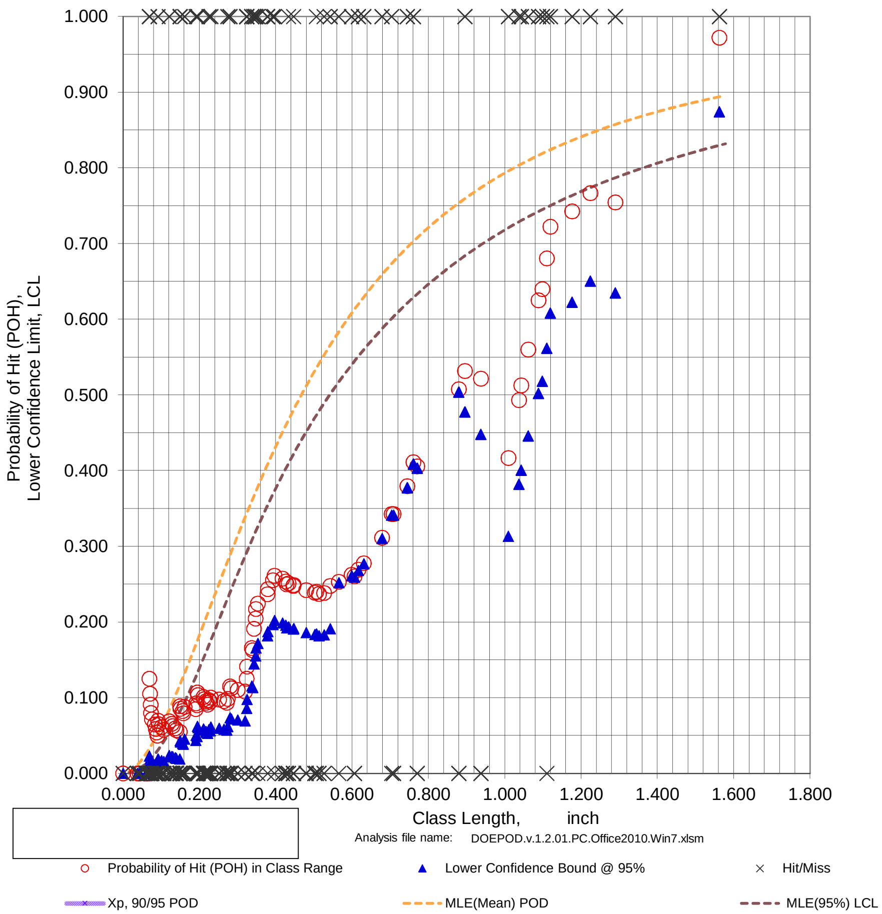
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

File Name = F8001(3)L.xls
Data Set Name = F8001(3)L(CK. NO.)

Directed DOE Options

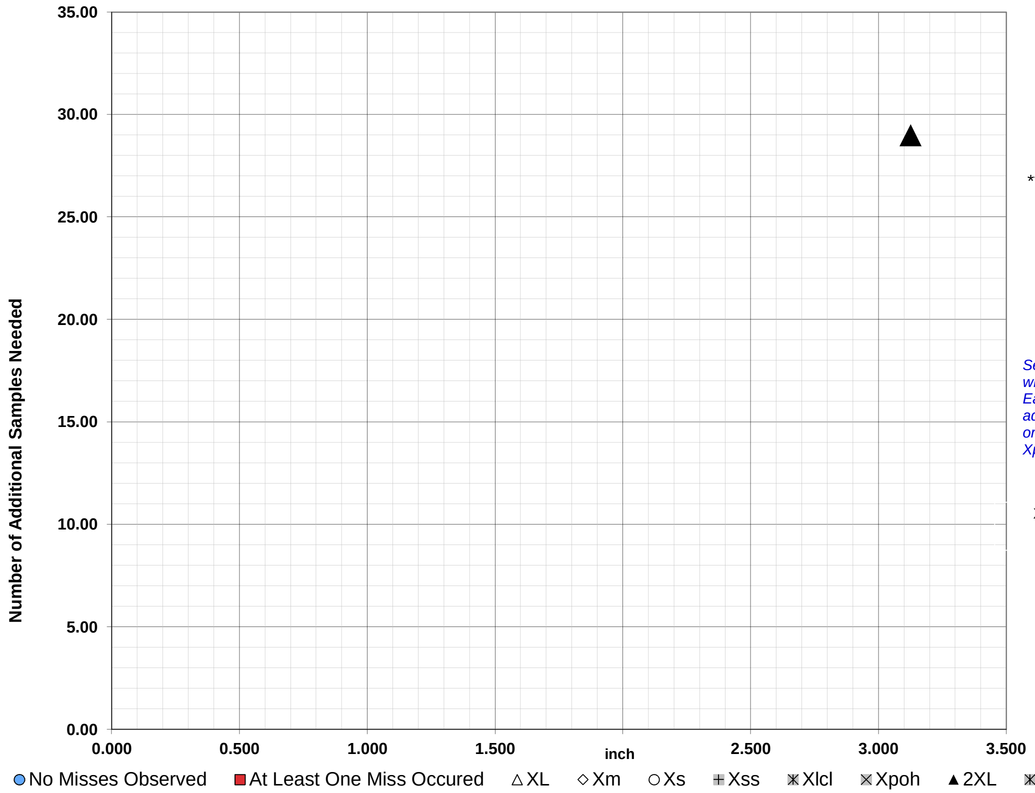


TABLE C

	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

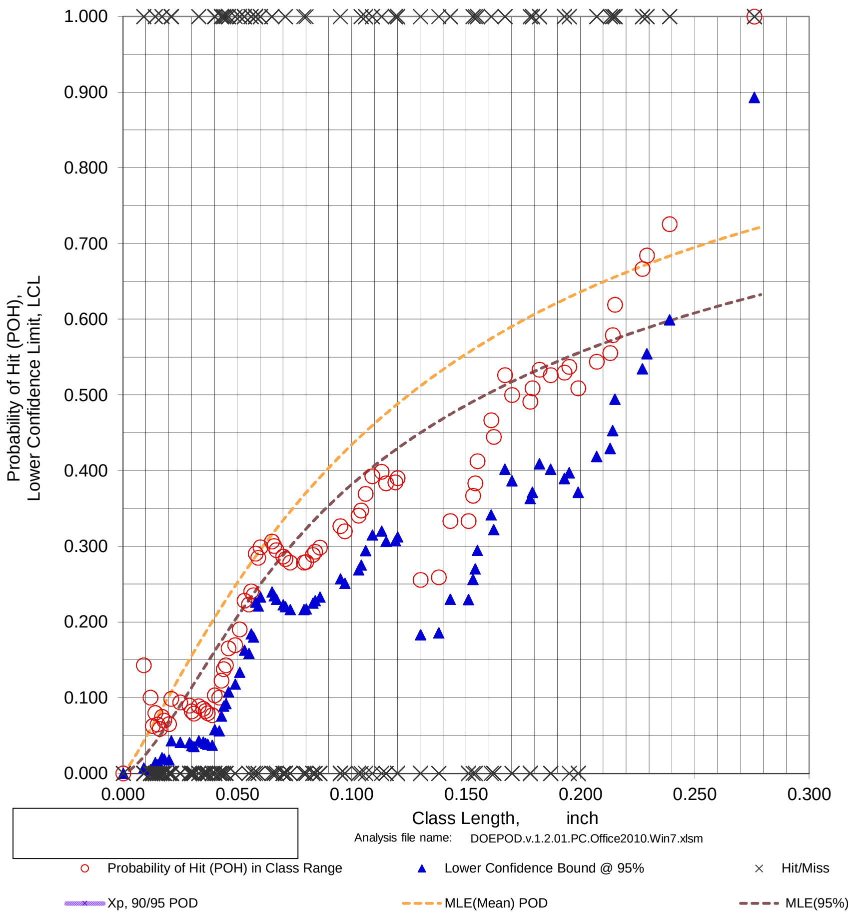
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.

File Name = F8002(3)D.xls
Data Set Name = F8002(3)D(CK. NO.)
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

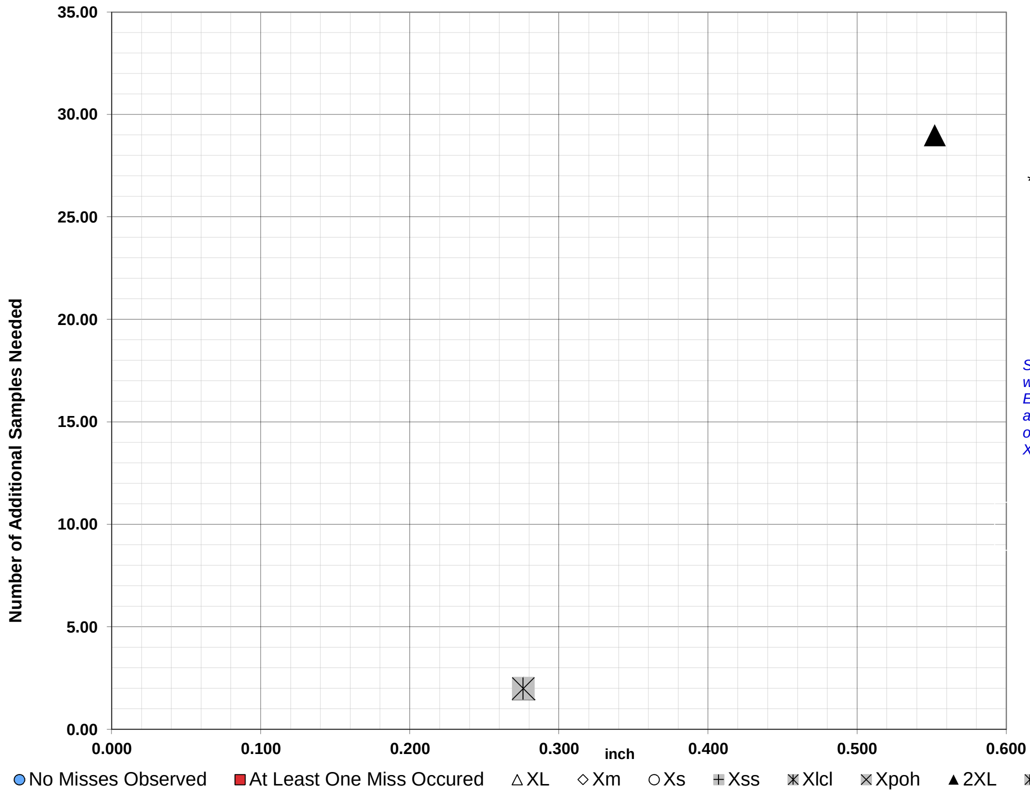


TABLE C

	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.

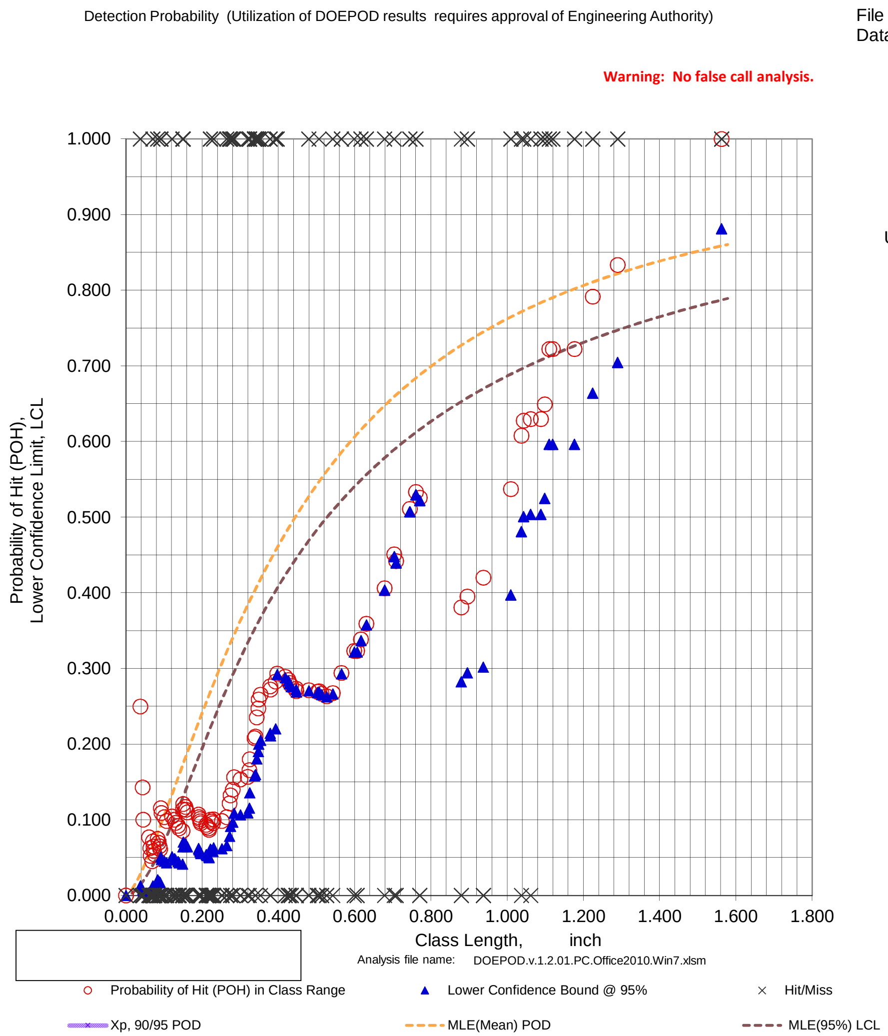
Xpod,Class Length	No. Need

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



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

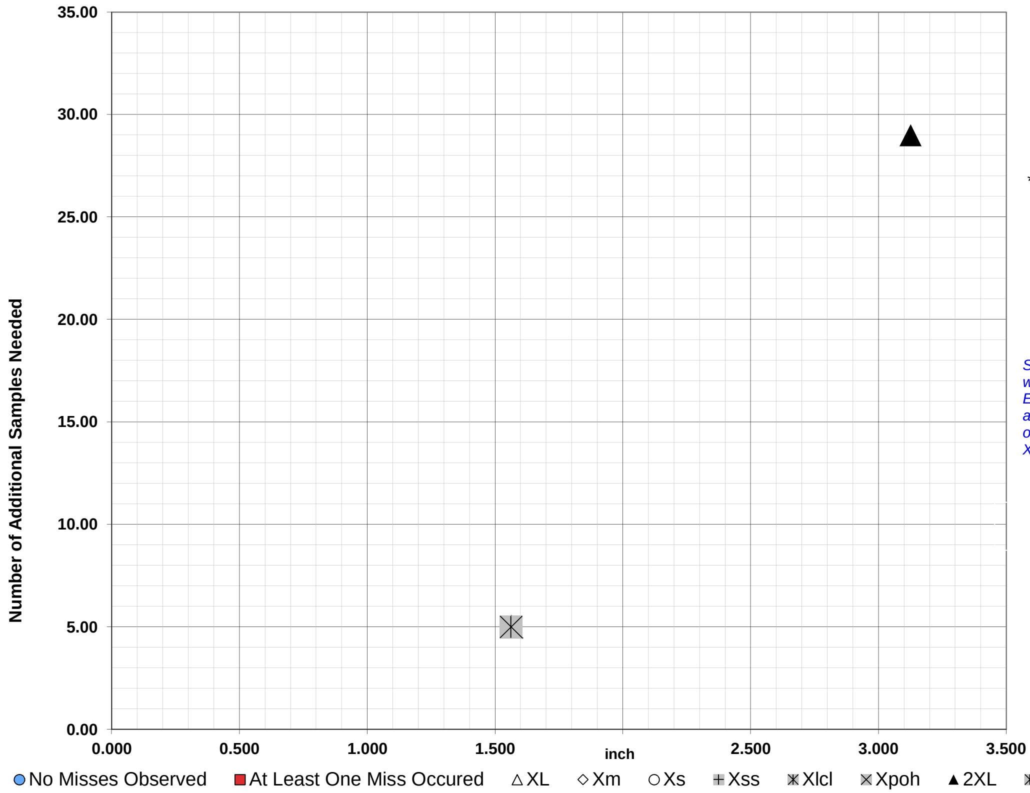


TABLE C

	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*

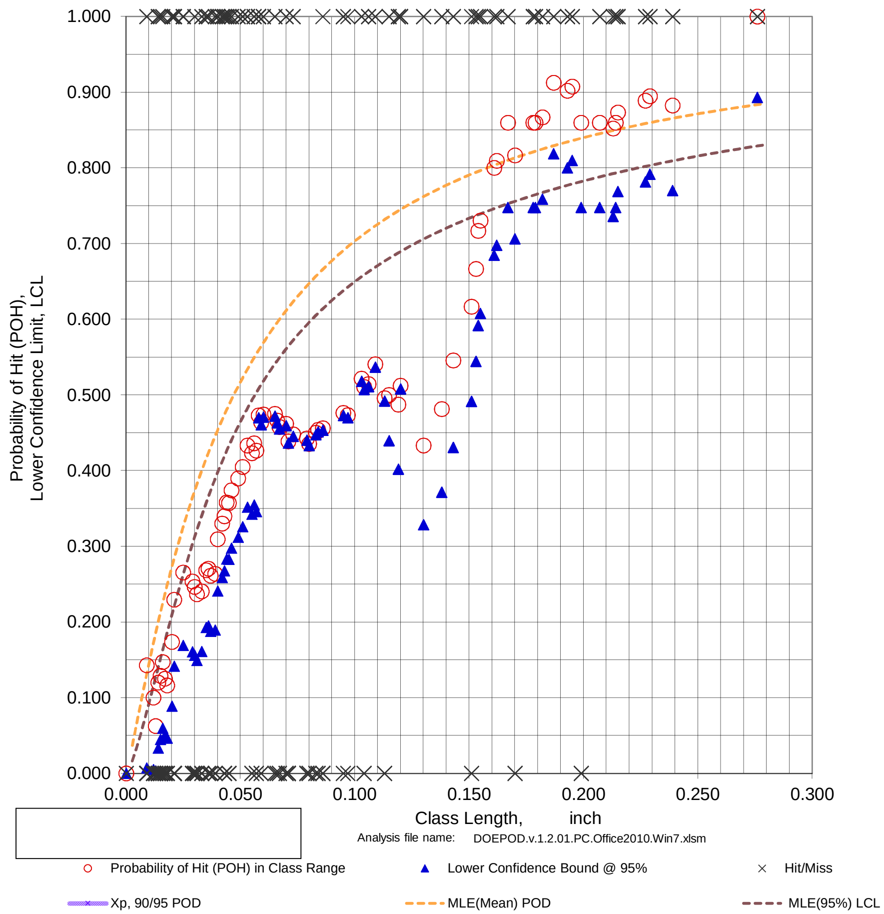
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

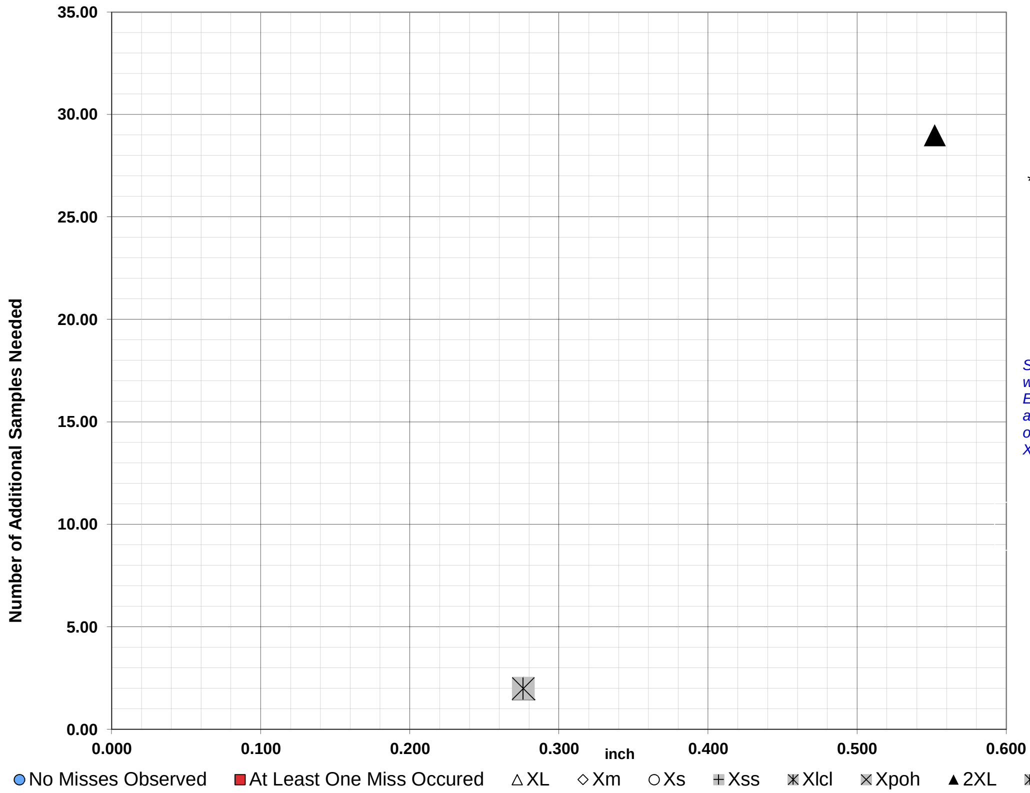


TABLE C

	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

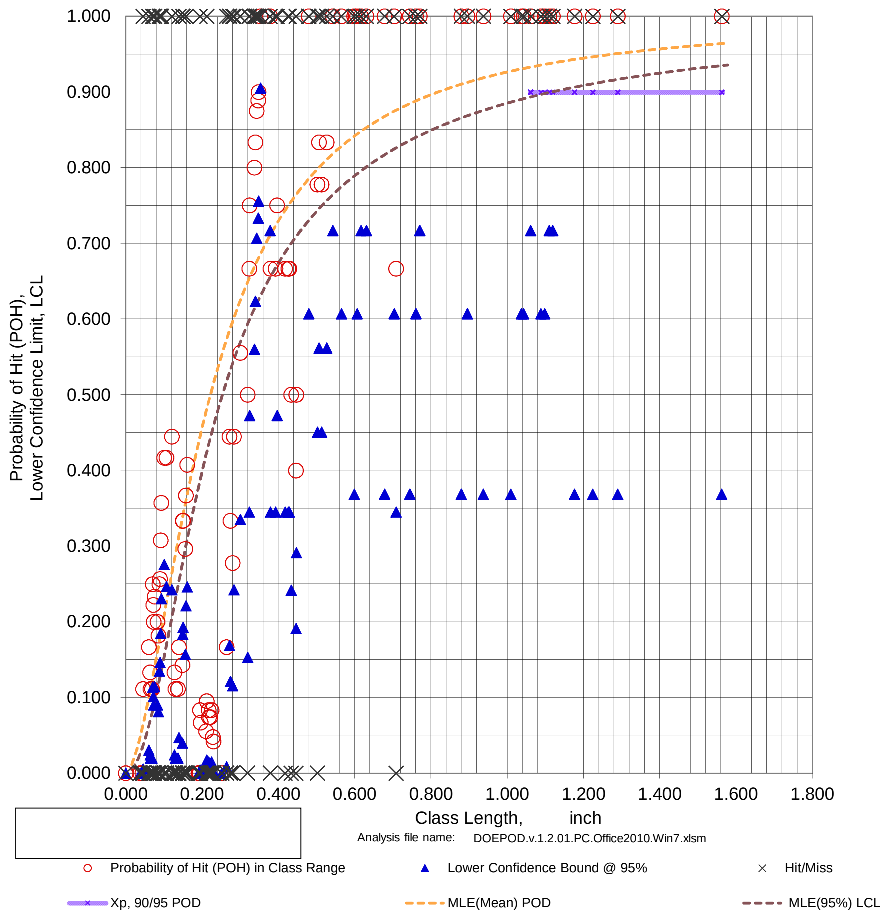
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

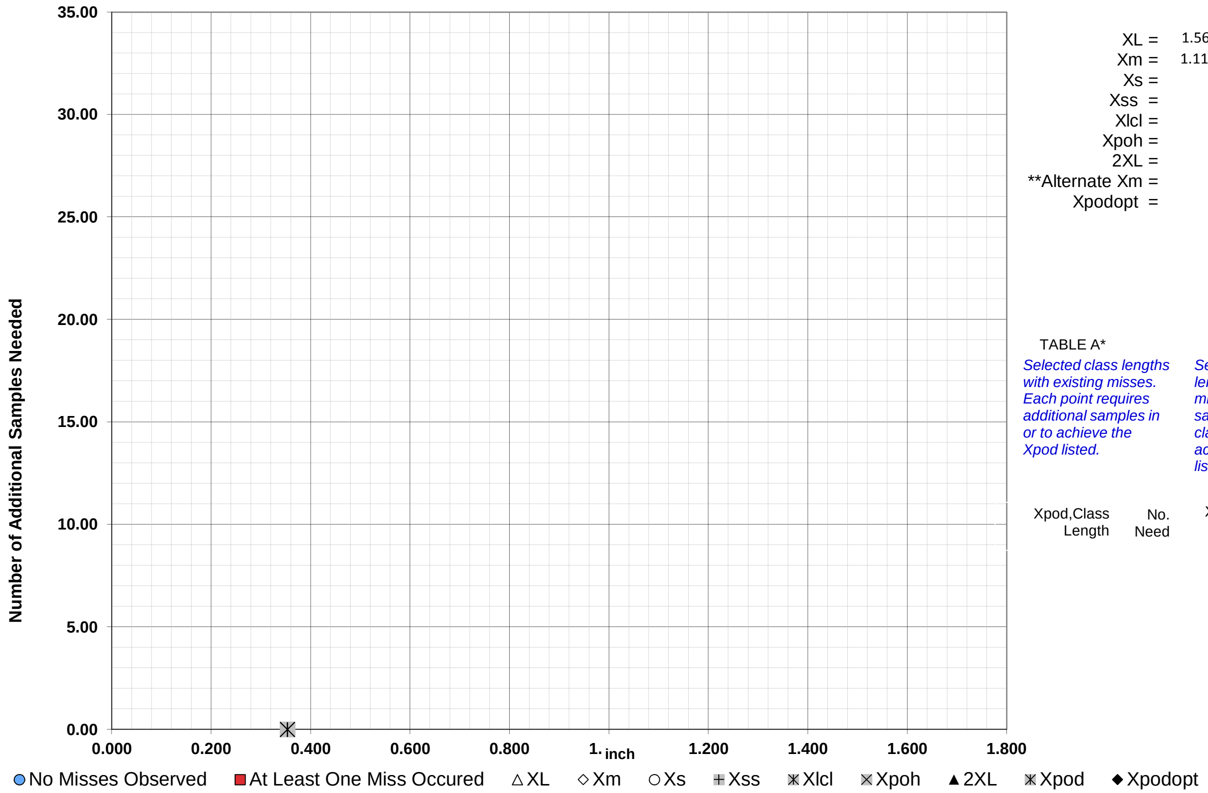


TABLE C

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*

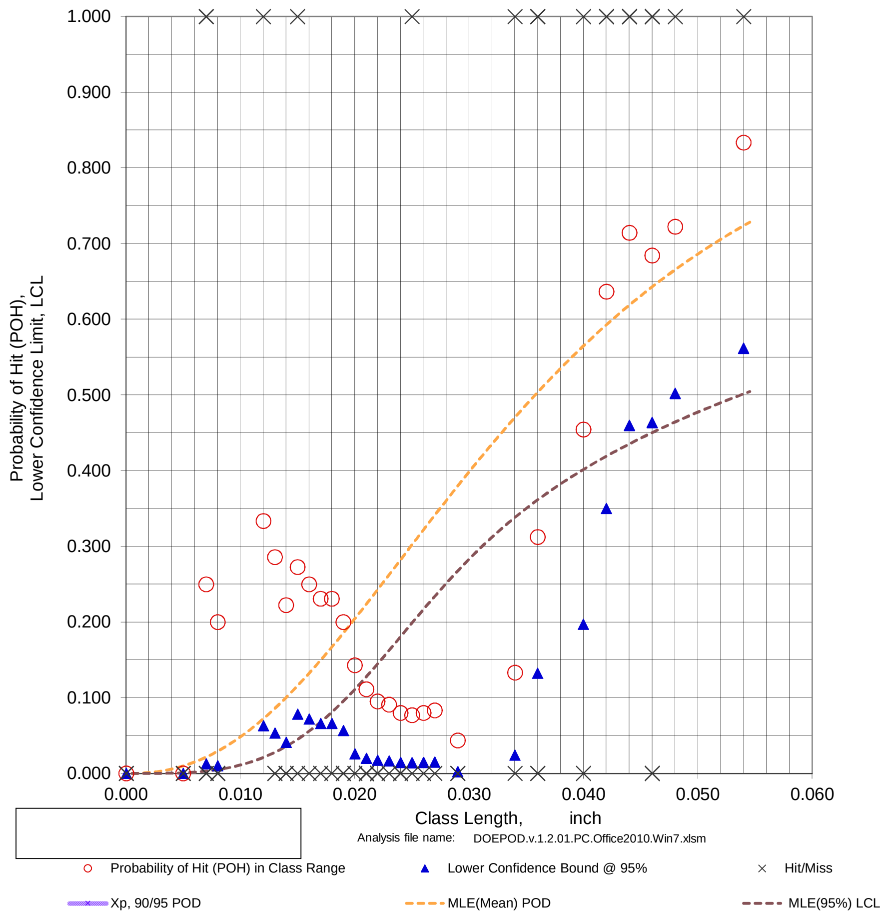
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

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

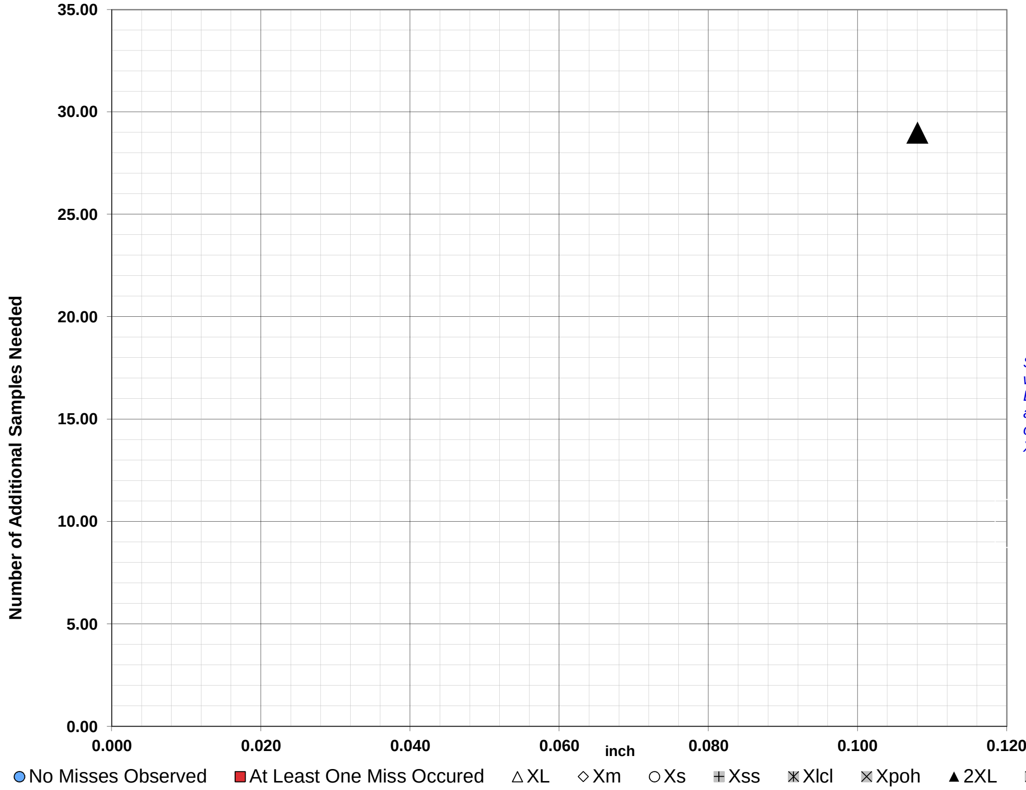


TABLE C

	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*

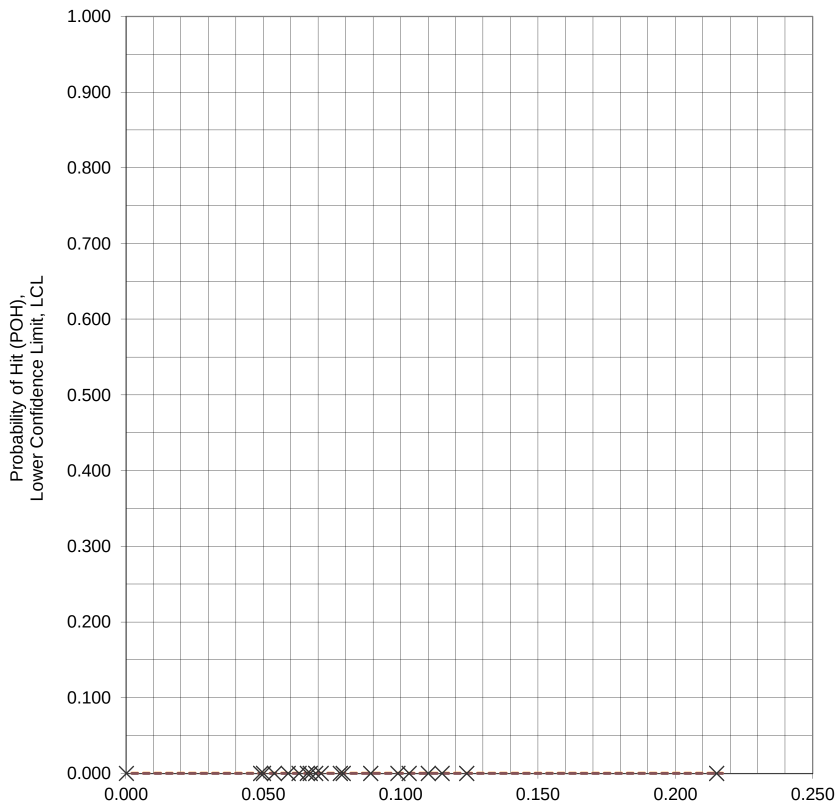
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

MLE Divergence Warning: Initial results listed.



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 = F9001(3)D.xls
Data Set Name = F9001(3)D(CK. NO.)
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

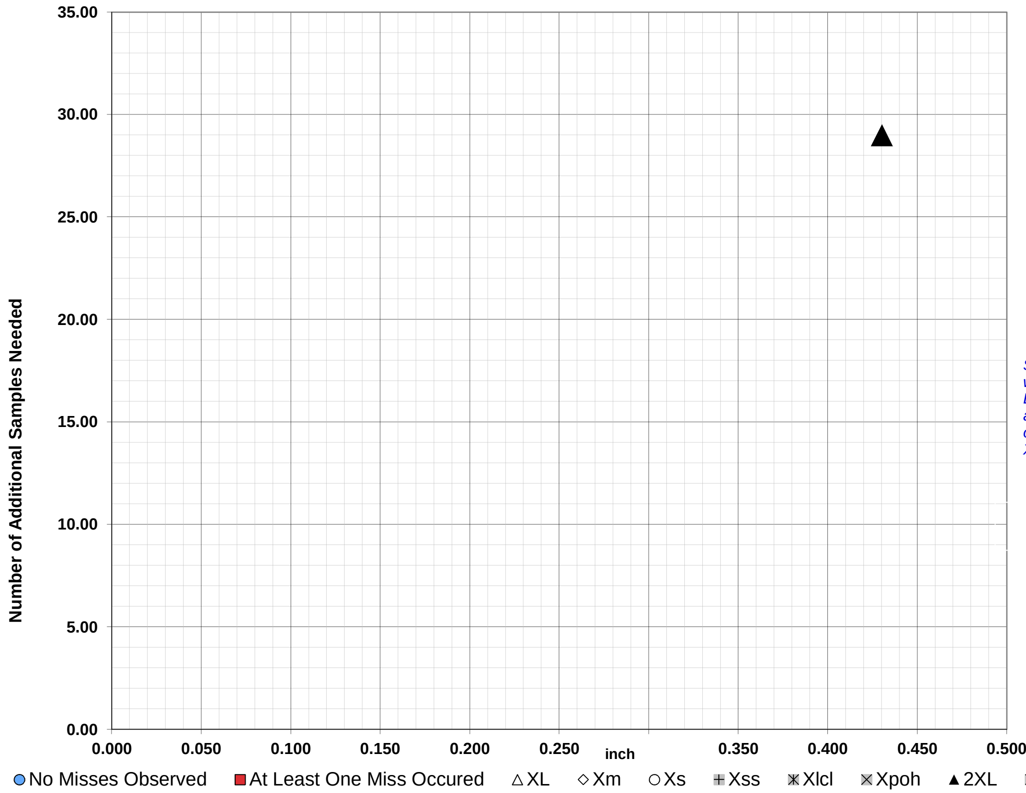


TABLE C

	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

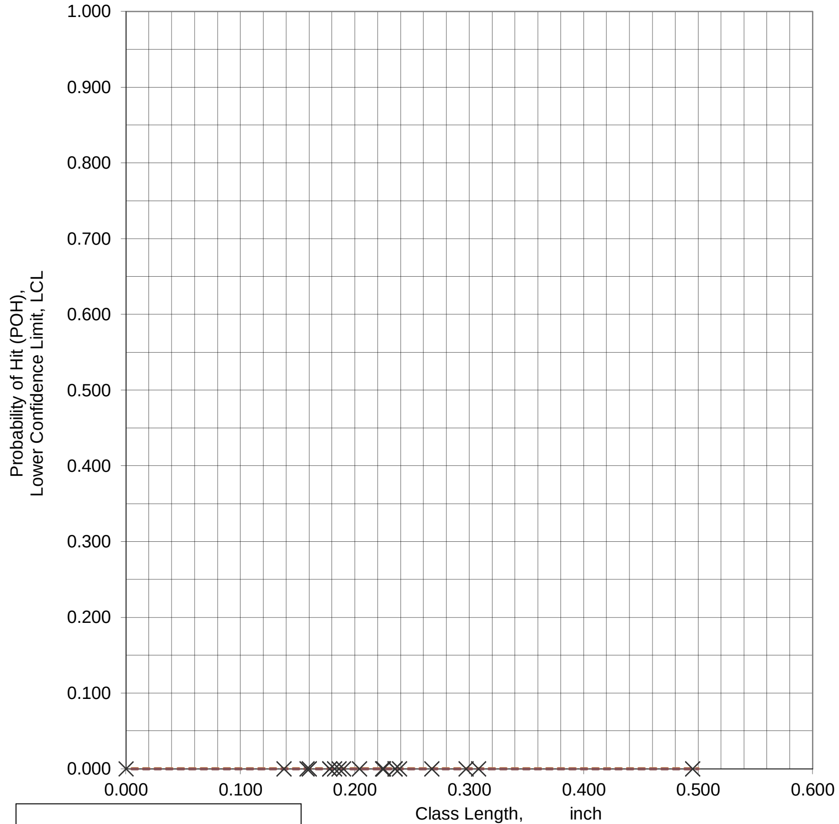
Classlength @ Best LCL = inch

User Provided a 90/95 POD @ = inch

User's Maximum Allowed Classlength = inch

Inspector Classwidth @ Xp = inch

POD @ Xpod =



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

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

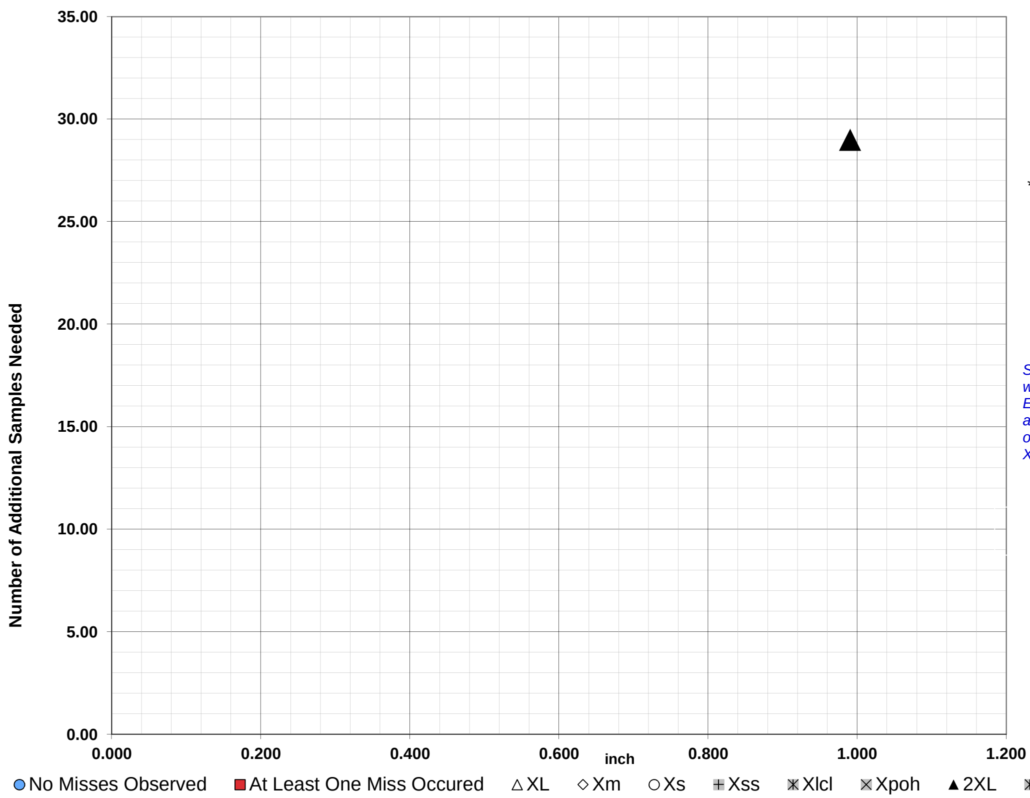


TABLE C

	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

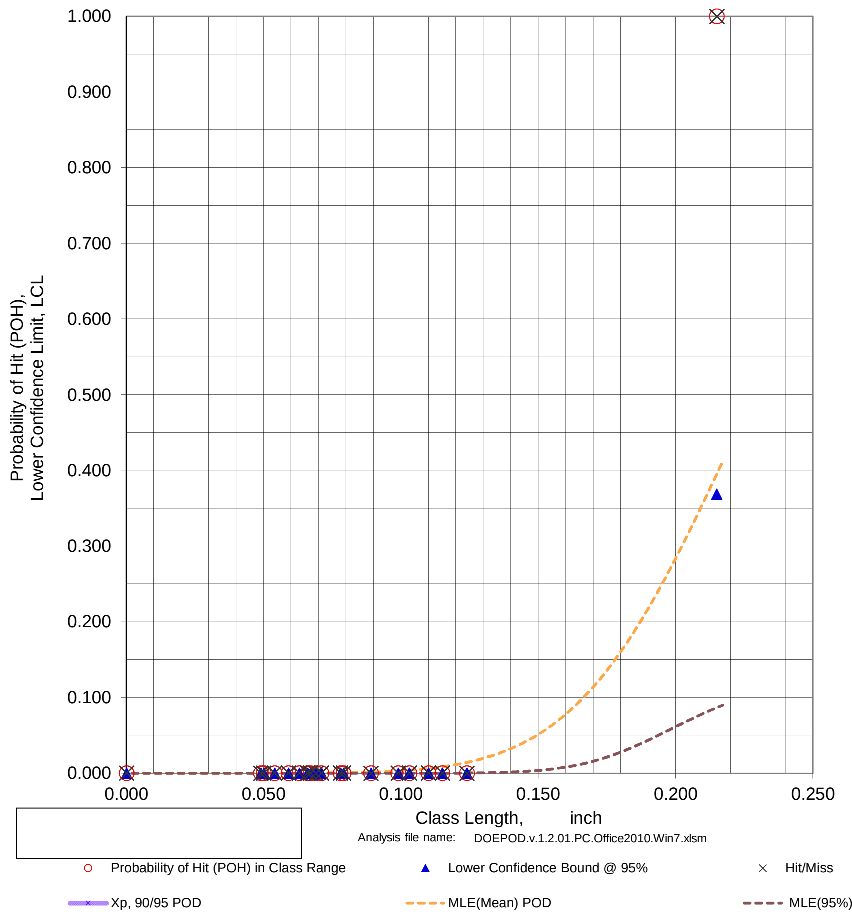
Detection Probability (Utilization of DOEPOD results requires approval of Engineering Authority)

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

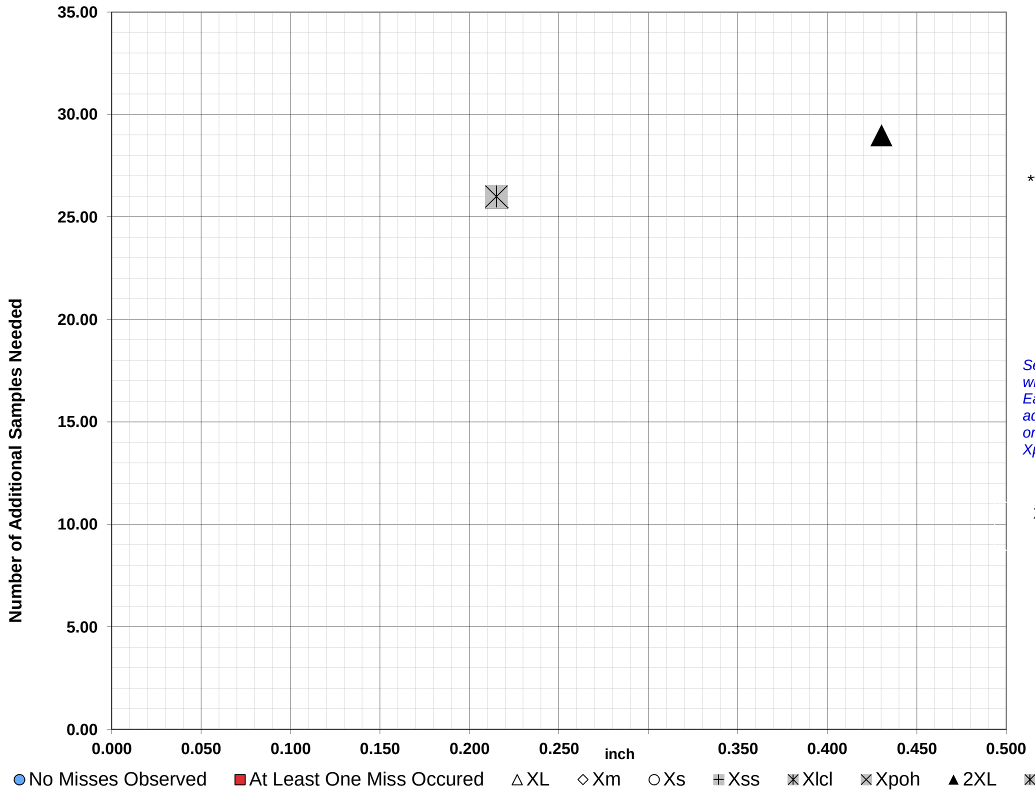


TABLE C

	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

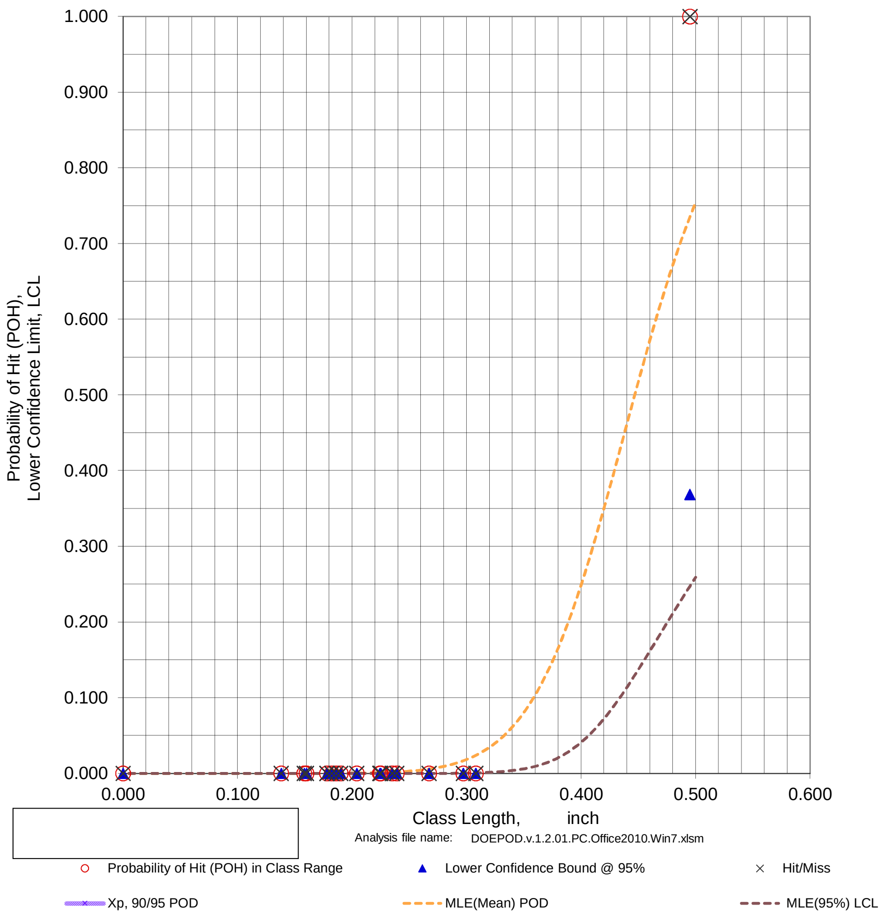
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

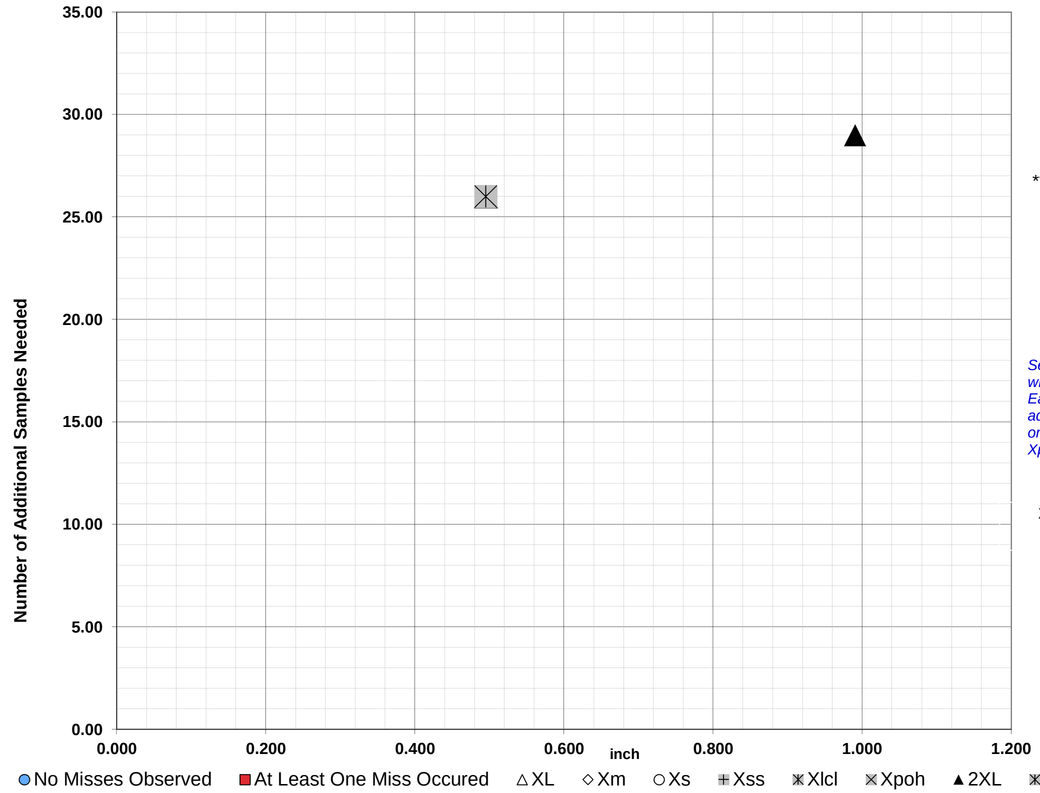


TABLE C

	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

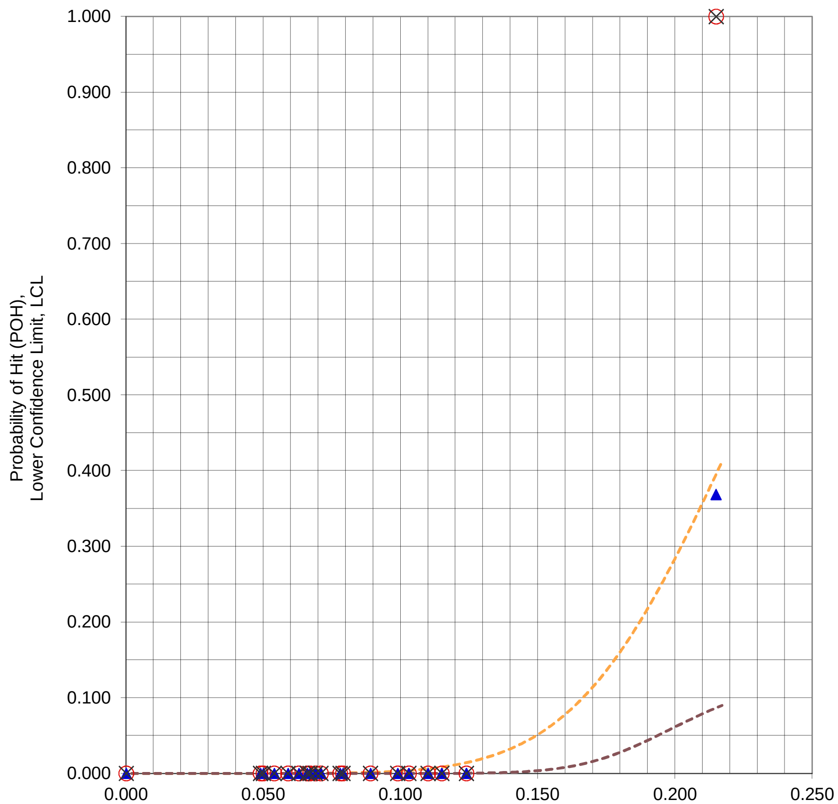
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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.



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

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

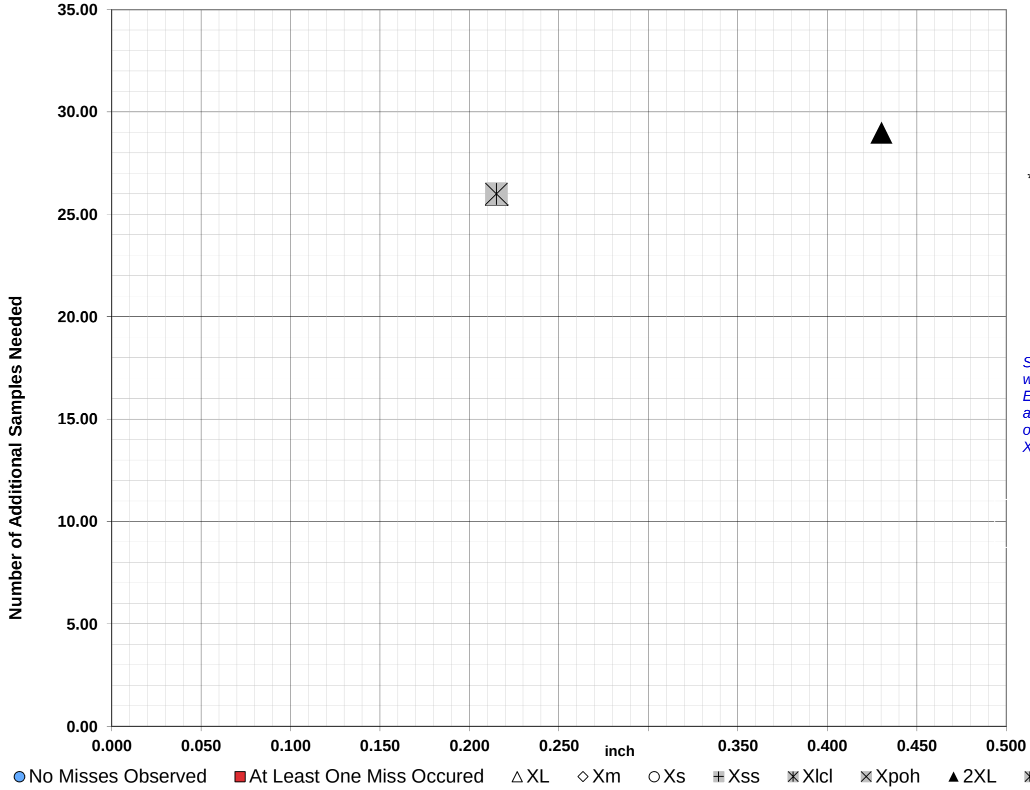


TABLE C

	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.

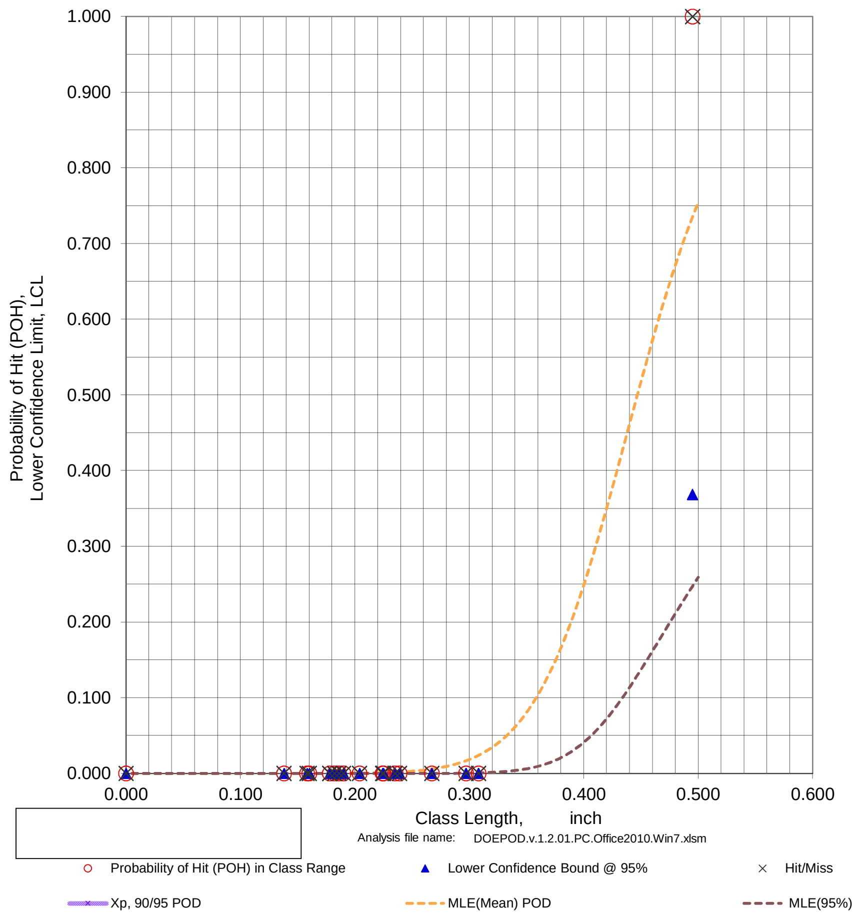
Xpod,Class Length	No. Need

* 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)

MLE Divergence Warning: Initial results listed.

Warning: No false call analysis.



Analysis file name: DOEPOD.v.1.2.01.PC.Office2010.Win7.xlsm

File Name = F9003(3)L.xls
Data Set Name = F9003(3)L(CK. NO.)
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

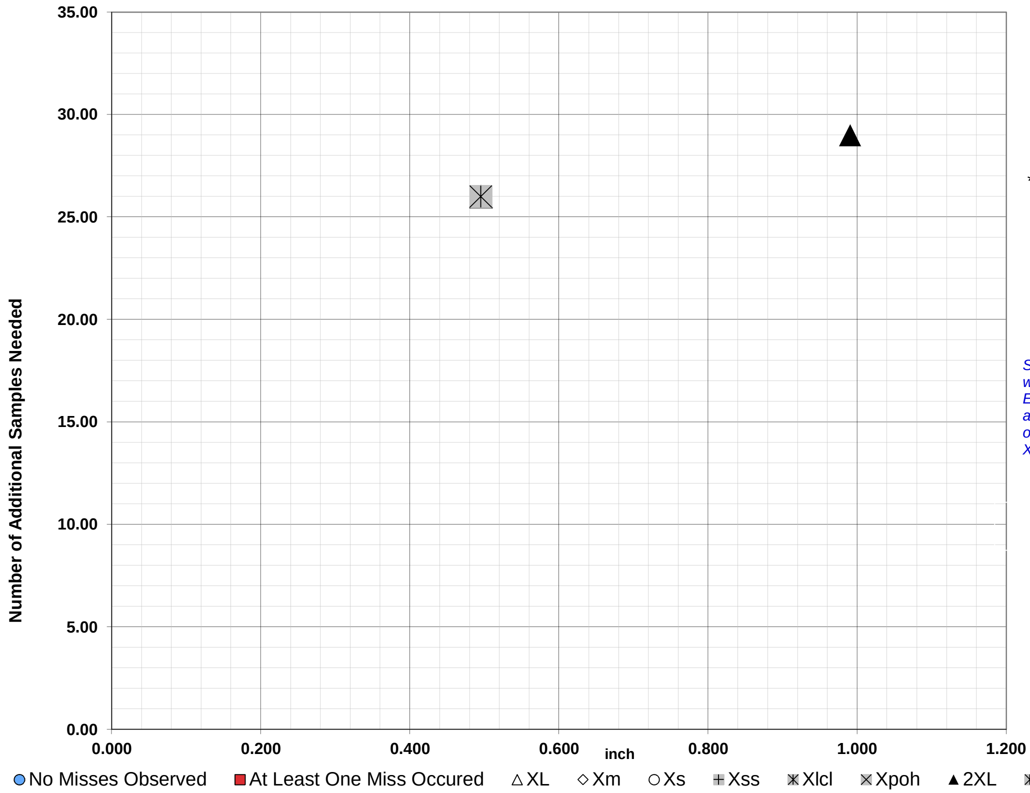


TABLE C

	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*

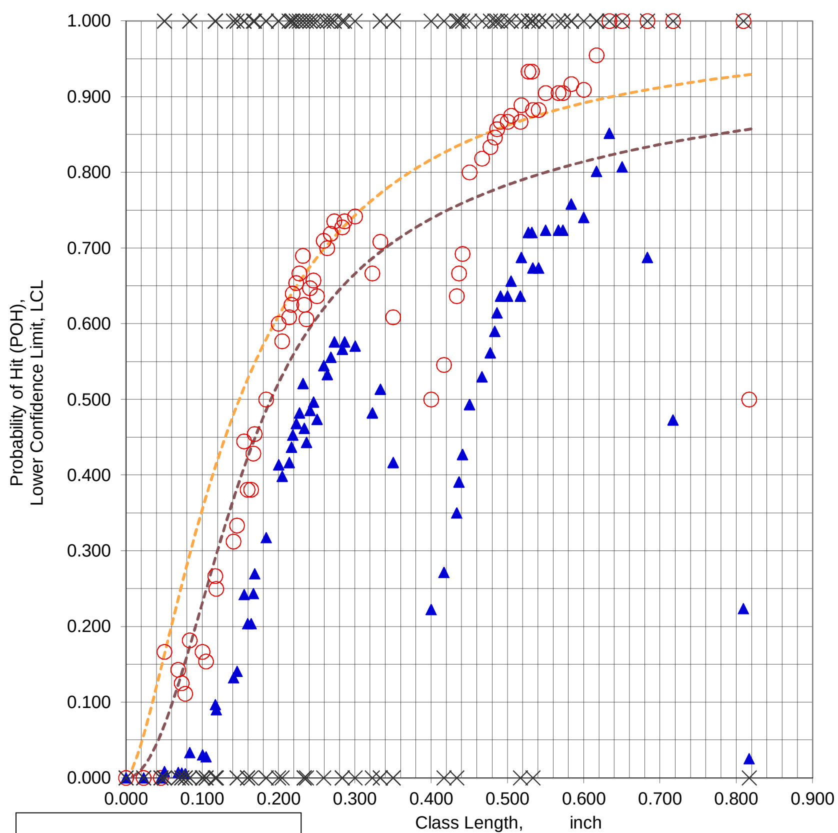
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

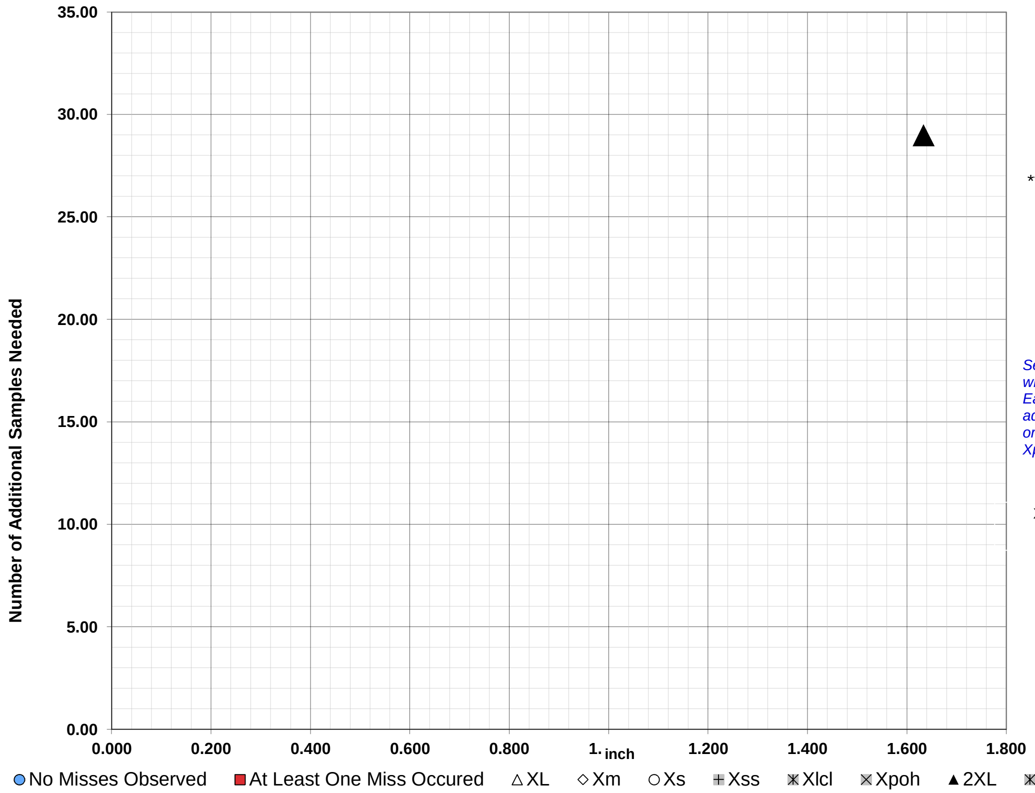


TABLE C

	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*

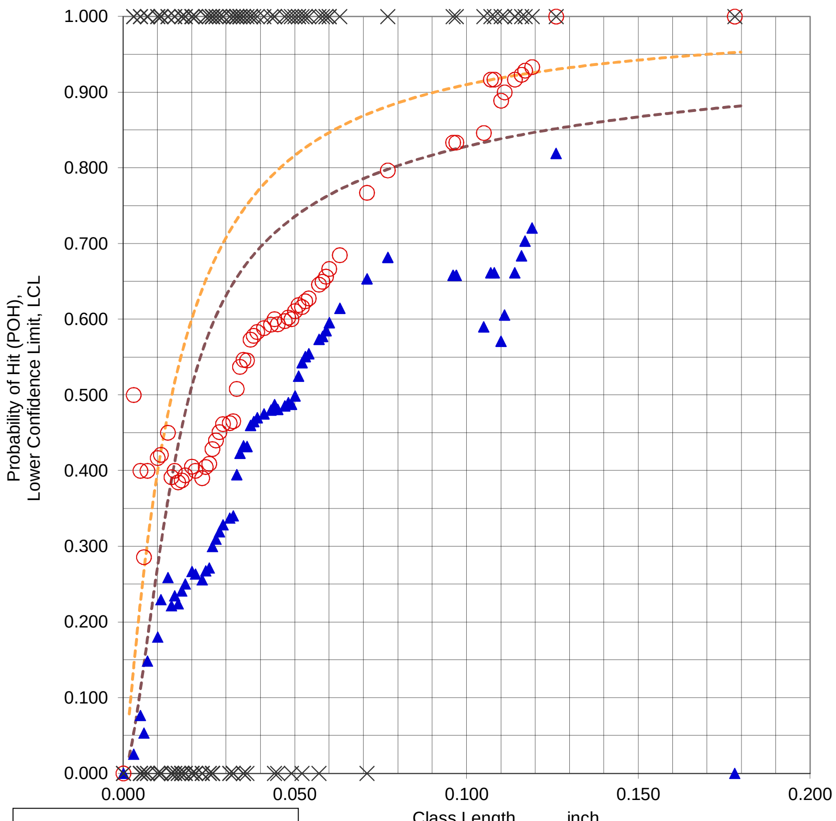
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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

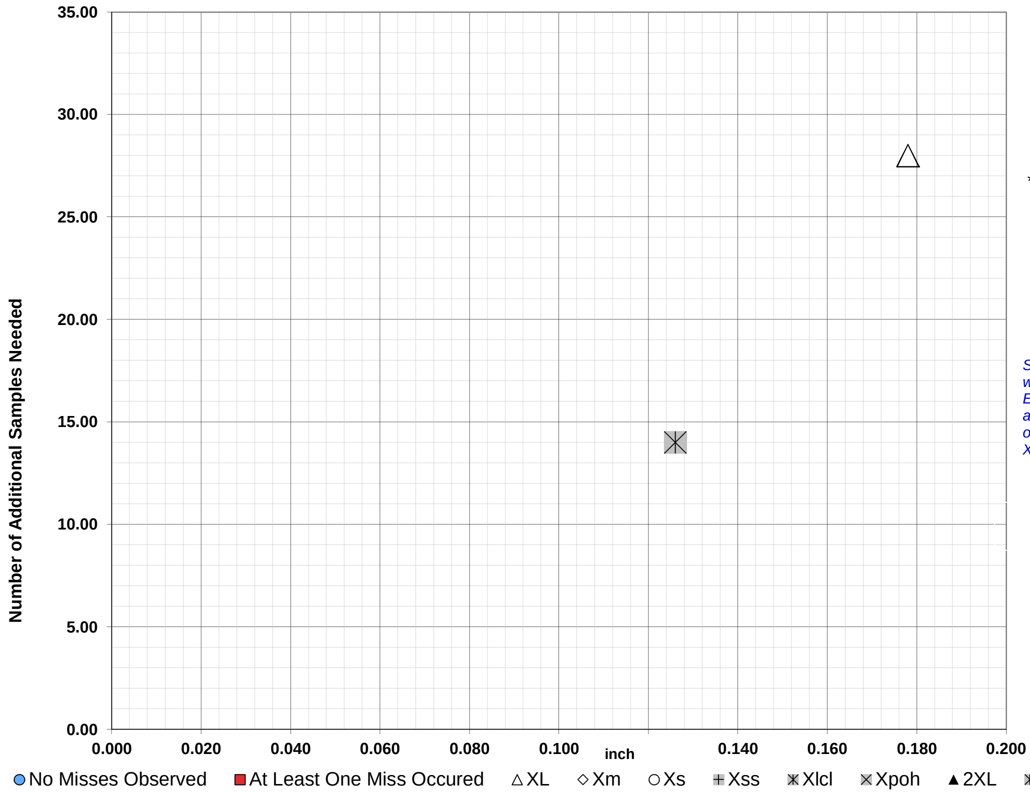


TABLE C

	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

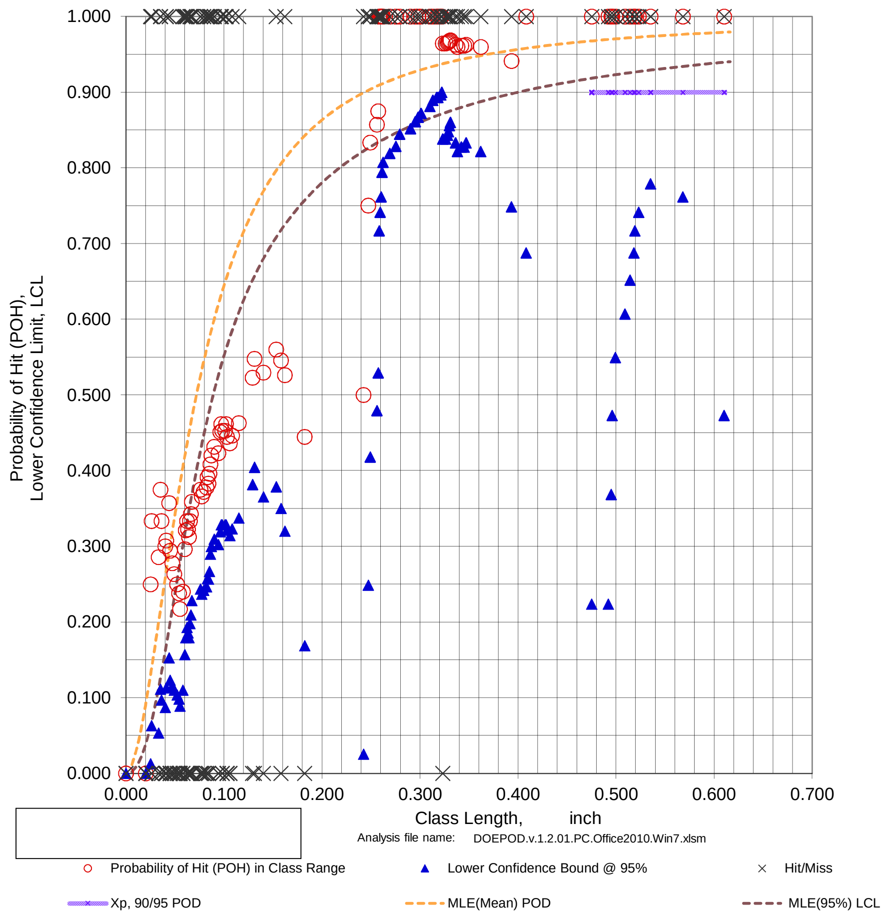
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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

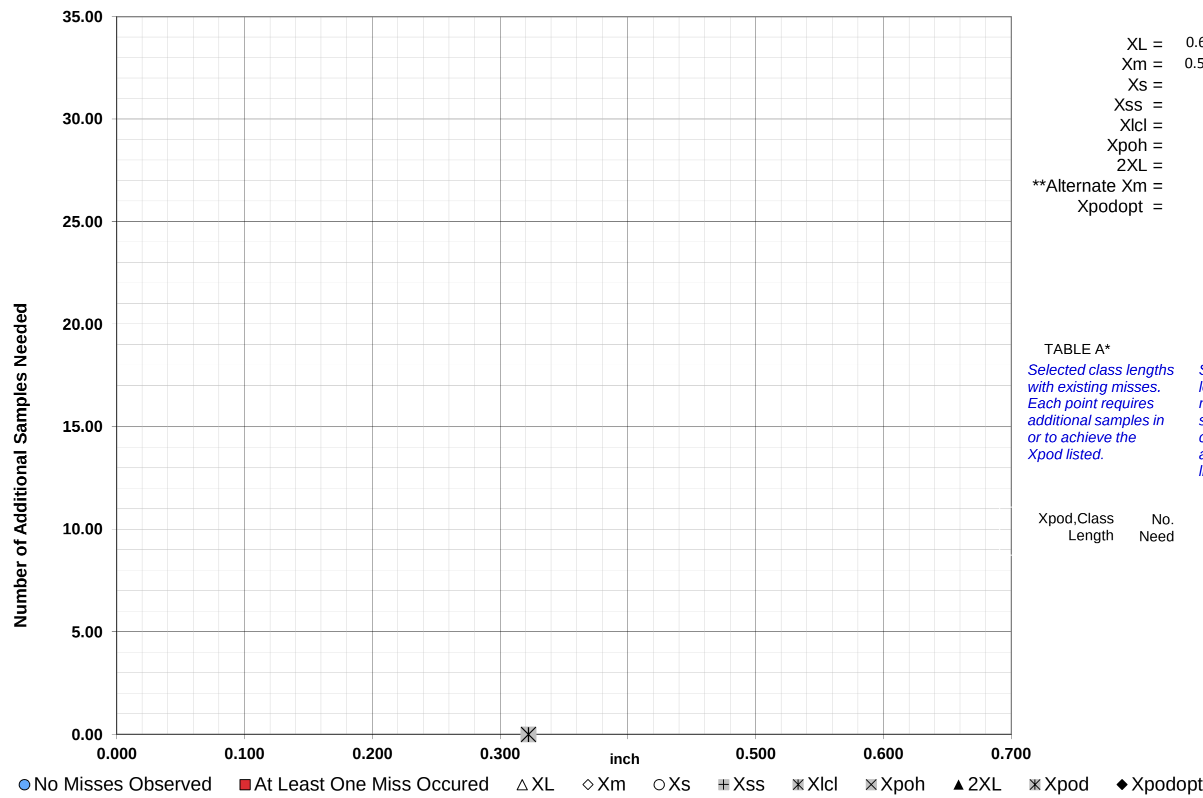


TABLE C

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*

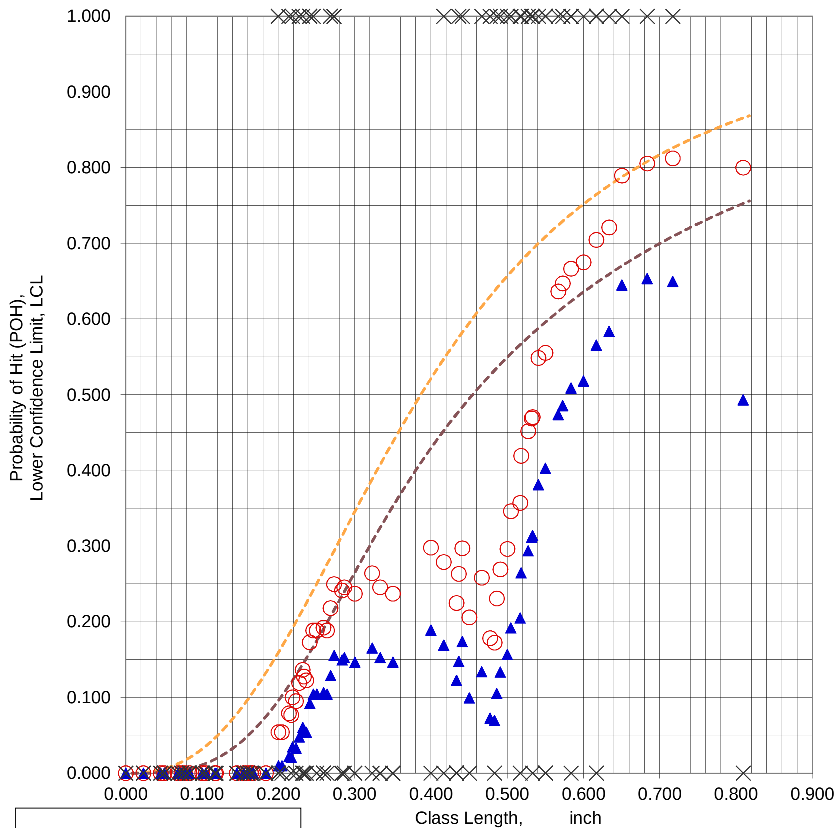
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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.



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 = 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 #)

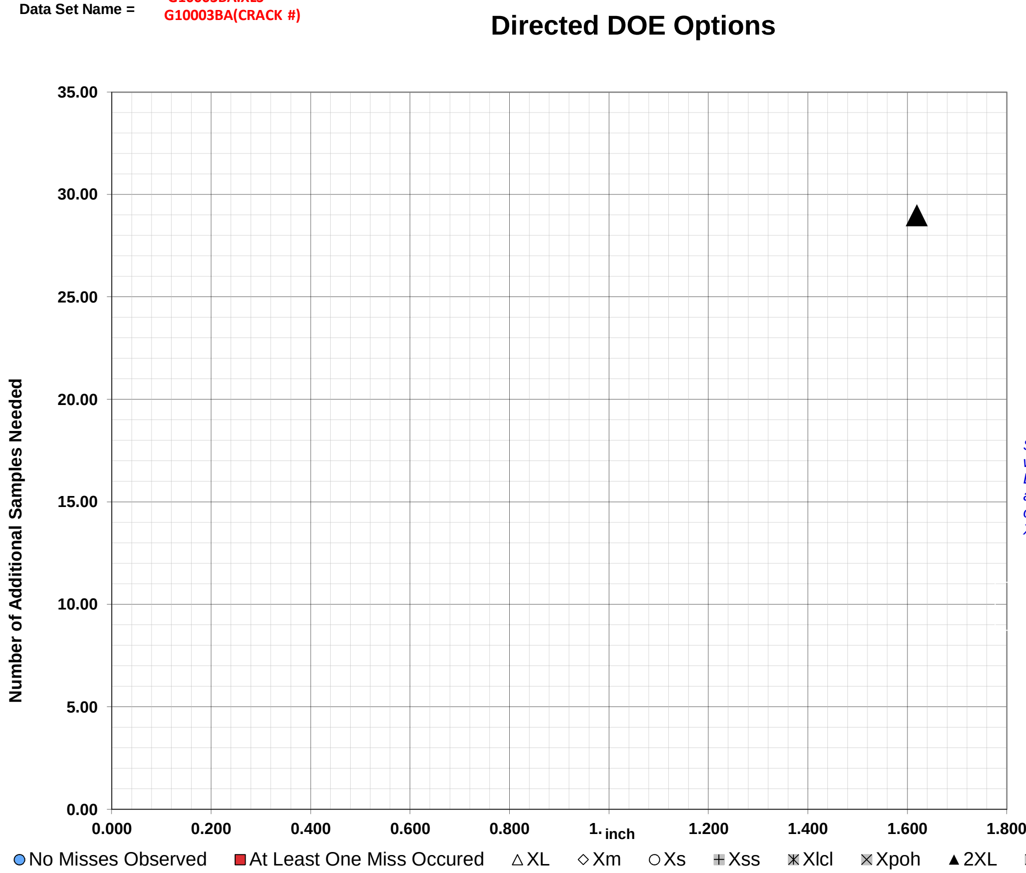


TABLE C

	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*

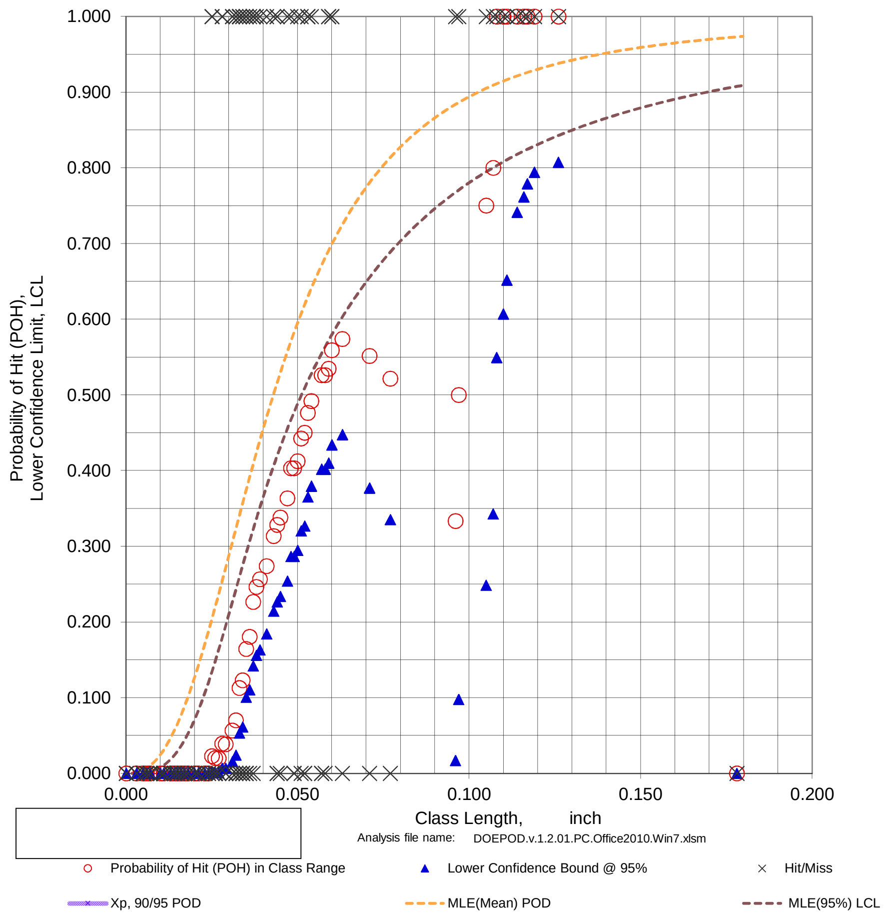
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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

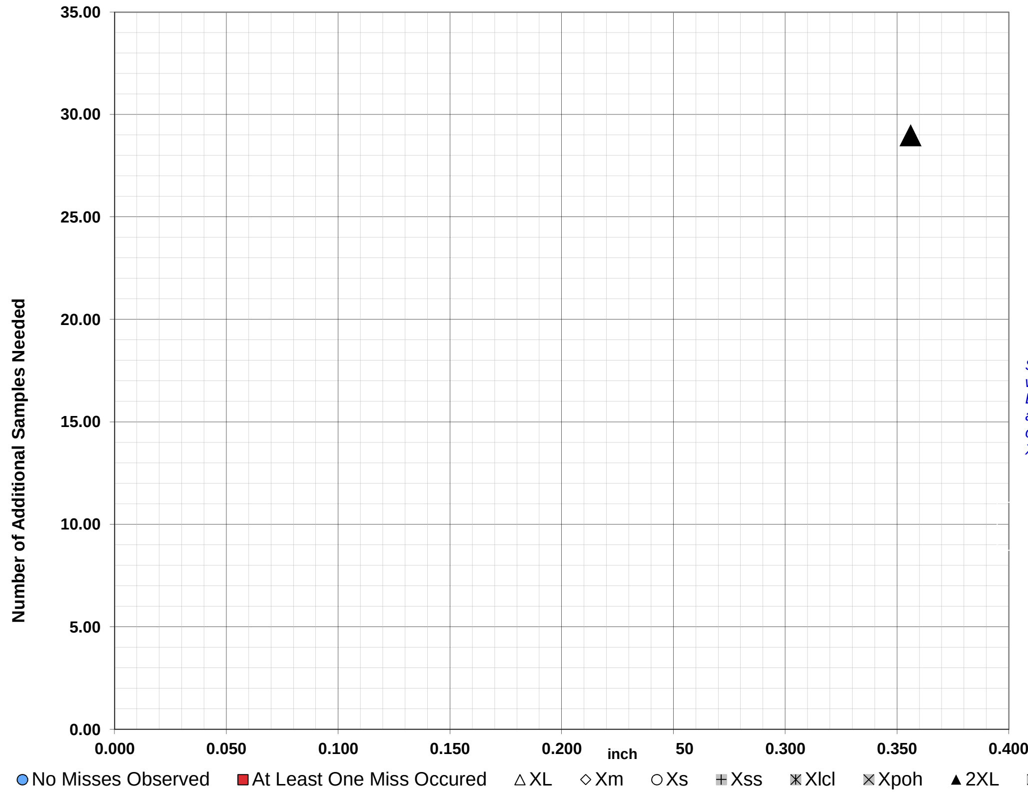


TABLE C

	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*

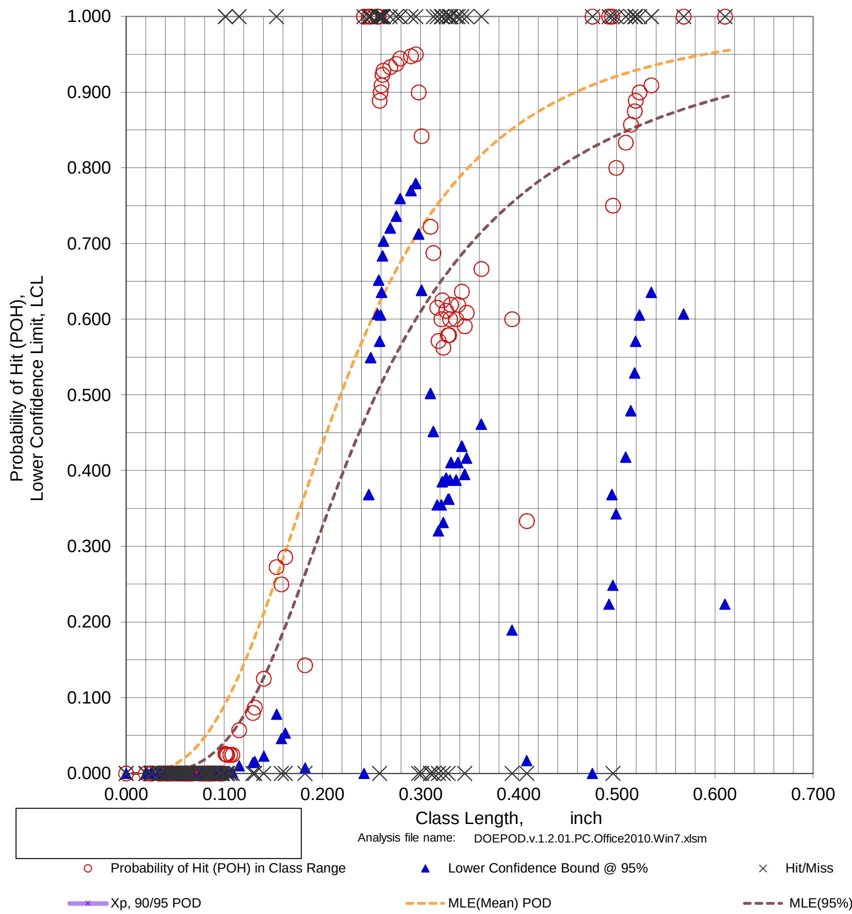
Selected class lengths with no misses. Additional samples at these class lengths will achieve the Xpod listed.

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)

Warning: No false call analysis.



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

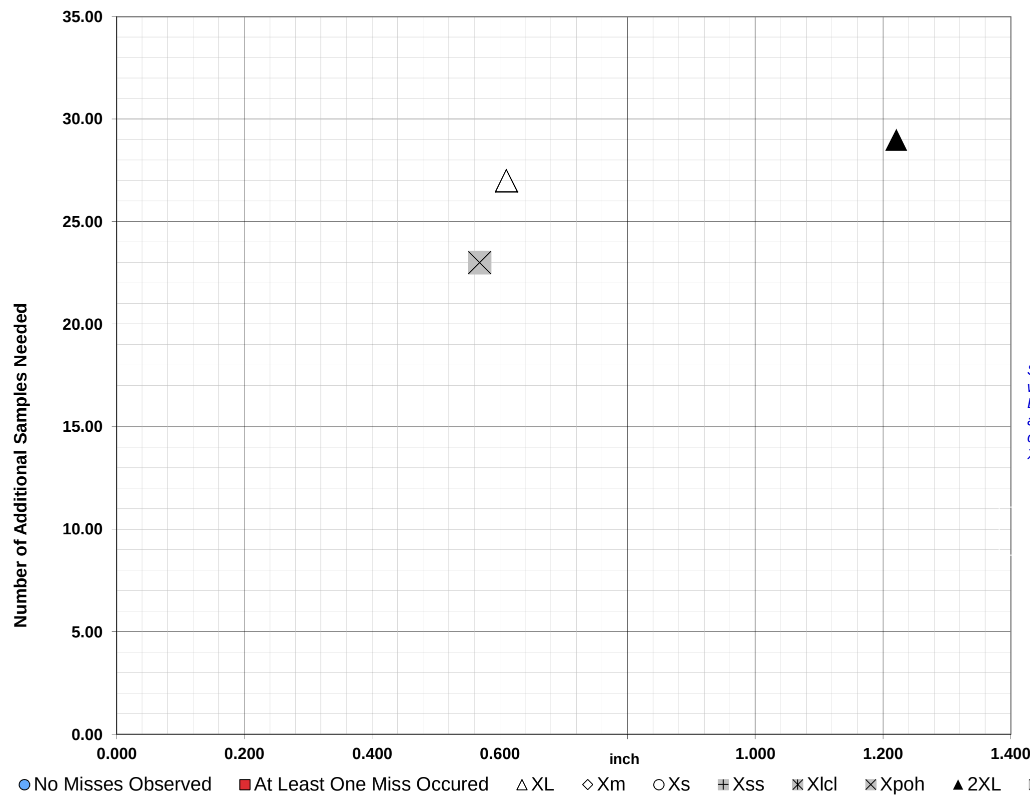


TABLE C

	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

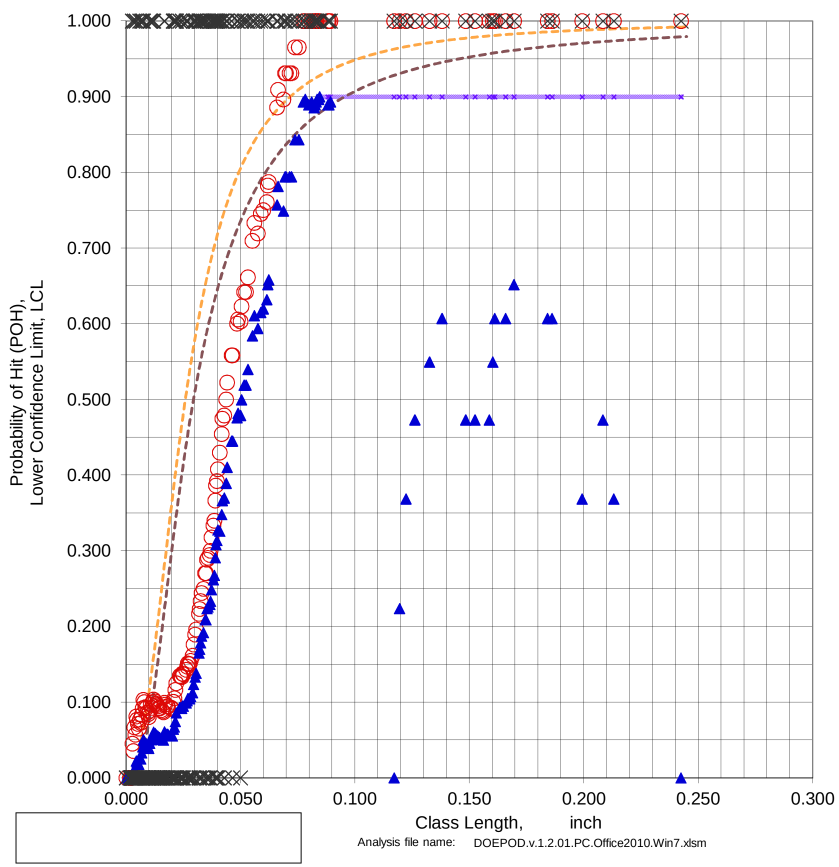
* Although Xpod appears to have been reached at a point, there are Misses at larger class lengths this indicates that the POH function may be oscillatory. This needs to be checked.
The class lengths listed in Table A exhibited misses and resulted in LCL below 0.90. Only largest 4 class lengths are shown.
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(Eol-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

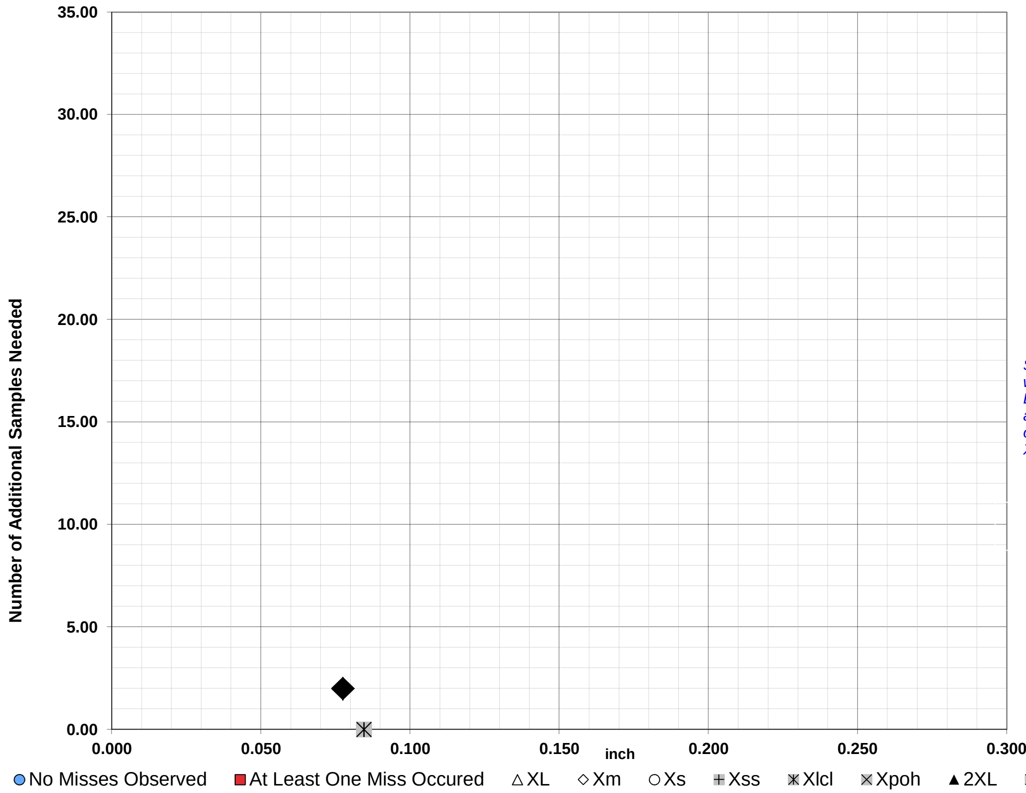


TABLE C

	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.

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13. SUPPLEMENTARY NOTES

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.

15. SUBJECT TERMS

Defects; Flaws; Maximum destructive likelihood; Nondestructive evaluation; Probability of detection

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