

## Out of Specification – Notify Operator via Email

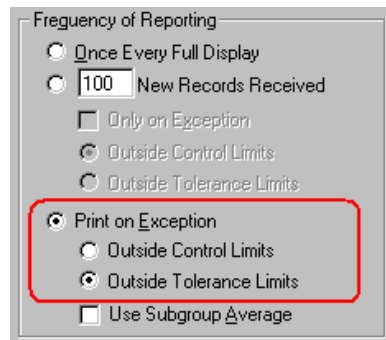
Are you running parts without an operator present and need to have someone notified when a part is Out of Specification? There are two ways to email an operator from QC-CALC Real-Time when a part is Out of Specification; through Automatic Report or through Trend

Analysis. The step-by-step directions for setting up both of these methods are discussed here so you can choose the method that works the best for you.

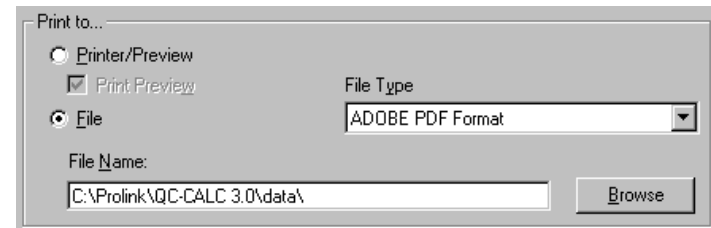
### Automatic Reporting

The Automatic Reporting can be setup to email an operator when an Out of Specification point has been received. This setup will only work if the Automatic Reporting is not already being used. If the Automatic Reporting is already being used, then the Trend Analysis method discussed in the next section will have to be used instead.

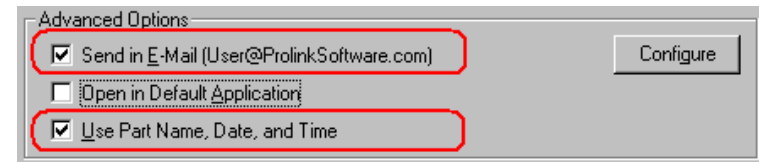
1. First verify that the automatic reporting settings are enabled. Choose **Report – Automatic Reporting** to enable this feature. A checkmark in the front of the menu signifies that it is enabled.
2. Choose **Report – Use Same Settings for All Parts** in order to set up this configuration once and have it work for all parts. If you want a different person emailed depending on the part that is running, you should leave this menu unchecked and setup the Reporting Configuration for each part specifically.
3. Choose **Report – Setup Automatic Reporting**
4. Choose to print any report (First Article is quick and might be helpful to the user to identify the bad part).
5. Set the **Frequency of Reporting** to **Print on Exception** with the **Outside Tolerance Limits** option chosen below.



6. Click the **Advanced** button in the lower left corner.

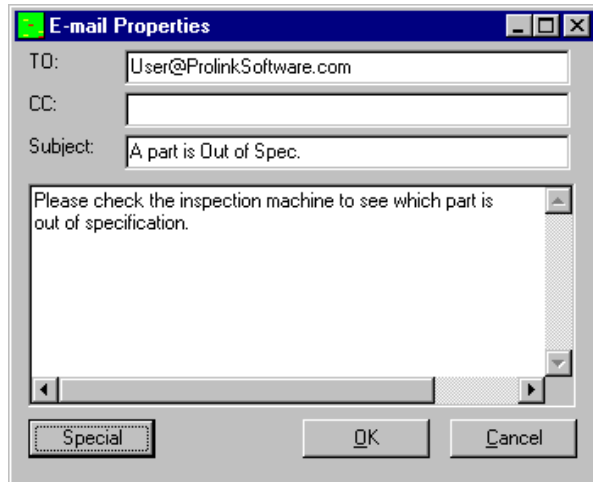


7. In the **Print To...** area on the right side of the screen, choose to **Print to File** along with a **File Type** (.pdf seems to be widely accepted) and a file name.



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- Choose the **Send in E-Mail** option in the **Advanced Options** area and fill in the **E-mail Properties** screen that appears.

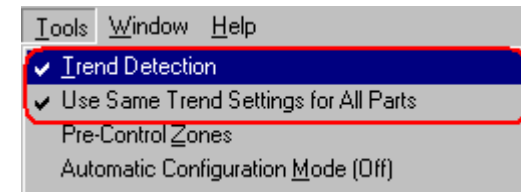


- Using the **Use Part Name, Date, and Time** option in the **Advanced Options** area will make the file name sent to the operator reflect the inspection date and time of the part that was bad. This might help identify the bad part.
- Click **OK** to save these settings and the next time an Out of Specification point is received the user will receive an email notification.

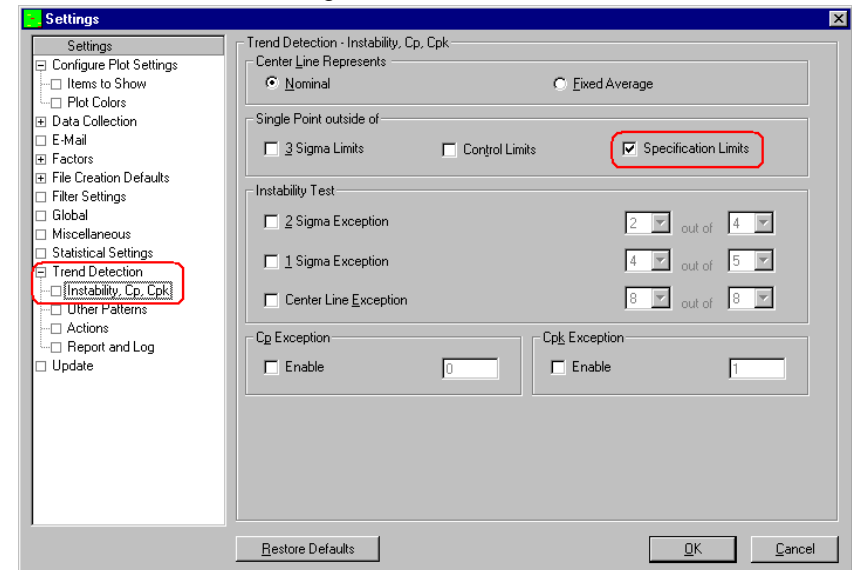
### Trend Analysis

One of the trend tests is for a **Single Point Outside of... – Specification Limits** and this will be the test used to trigger an email to a specified email address. If the Trend Analysis is already being used, this will just be another trend checked. The operator will be notified if a regular trend is detected or if a point is Out of Spec. These are the steps to follow to set this up:

- From the **Tools** menu enable both the **Trend Detection** and **Use Same Trend Settings for All Parts** menus.



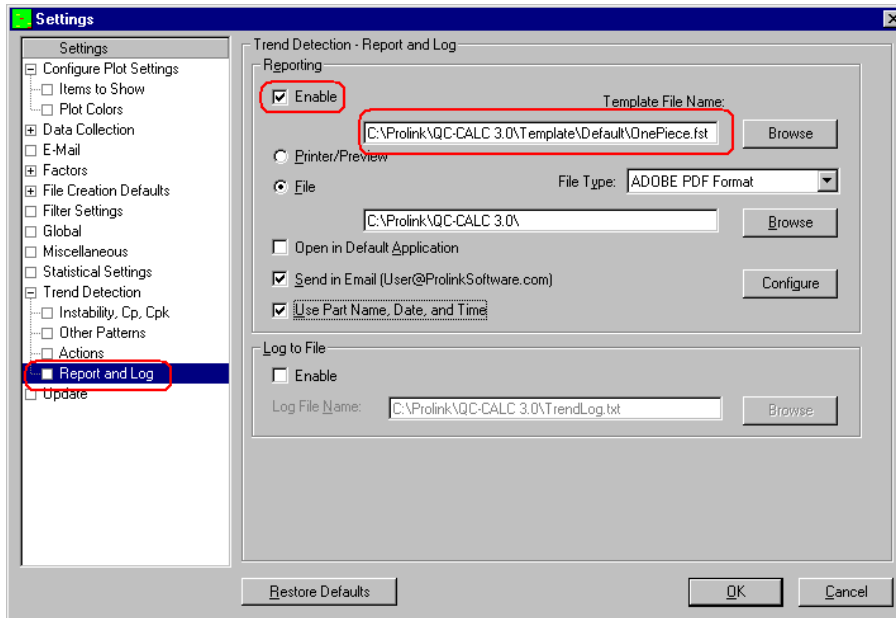
- Now choose **Tools – Options** in order to set the Trend Detection settings to follow.



- From the **Trend Detection – Instability, Cp, Cpk** area choose **Single Point outside of – Specification Limits**.

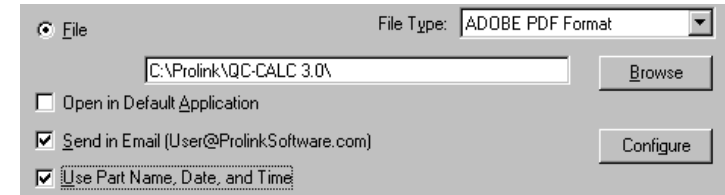
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- Now choose the **Trend Detection – Report and Log** tab.



- In the **Reporting** area, check the **Enable** box.
- Choose a report template to use (OnePiece.fst will give you a First Article report) in the **Template File Name** area.

- Choose the **File** option along with a **File Type** (.pdf seems to be widely accepted) and a file name.



- Choose the **Send in E-Mail** option in the **Advanced Options** area and fill in the **E-mail Properties** screen that appears.
- Using the **Use Part Name, Date, and Time** option in the **Advanced Options** area will make the file name sent to the operator reflect the inspection date and time of the part that was bad. This might help identify the bad part.
- Click **OK** to save these settings and the next time an Out of Specification point is received the user will receive an email notification.