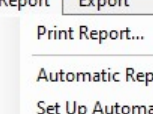


The default **First Article > Multiple Parts** reports that come with QC-CALC only show 5 parts. This White Paper will give step by step instructions for designing your own custom template and adding a 6th part column to one of the First Article – Multiple Parts standard templates.

The directions shown here will walk you through adding a column for Part 6 in the report and shrinking the remaining columns to make enough room on the page for an additional column. This is a lengthy process, but relatively simple to accomplish.

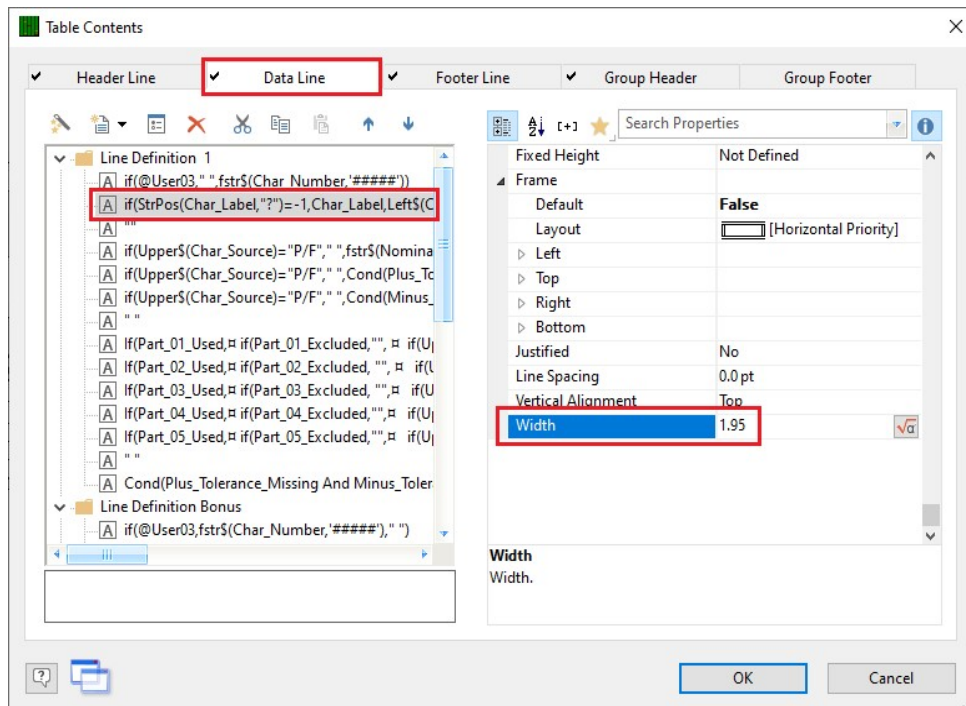
- 
- Real-Time (4.1.14) - [Spec_Limit_Test.Qcq]
- Report Export Gage R&R Tools Help
- Print Report... Ctrl+P
 - Automatic Reporting (Off)
 - Set Up Automatic Reporting...
 - Set Automatic Report Defaults...
 - Print Automatic Report Now Ctrl+N
 - Reset Auto Report Counter
 - Report Notes...
 - Modify User Inputs... Ctrl+U
 - Design Template...**
 - Print Preview
 - Use My Logo...

- [illegible]

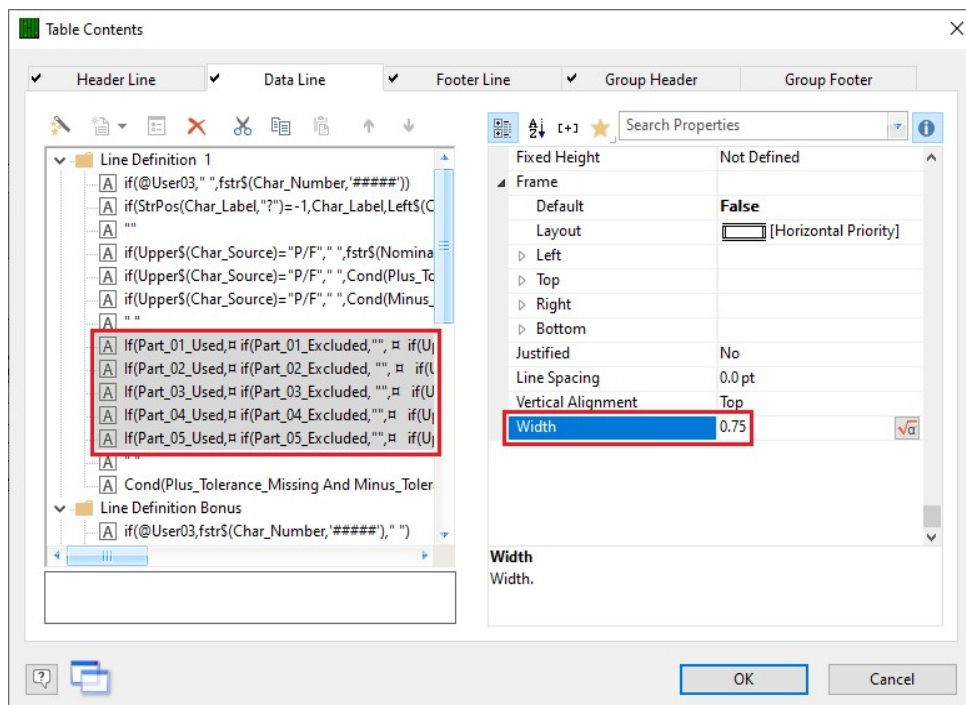
Reporting – First Article for 6 Parts

Making more Space

1. Double click on the table and the **Table Contents** window will appear.
2. Choose the **Data Line** tab, then click on the “Label” line in the **Line** area. On the right side of the screen change the **Width** to “1.95.”

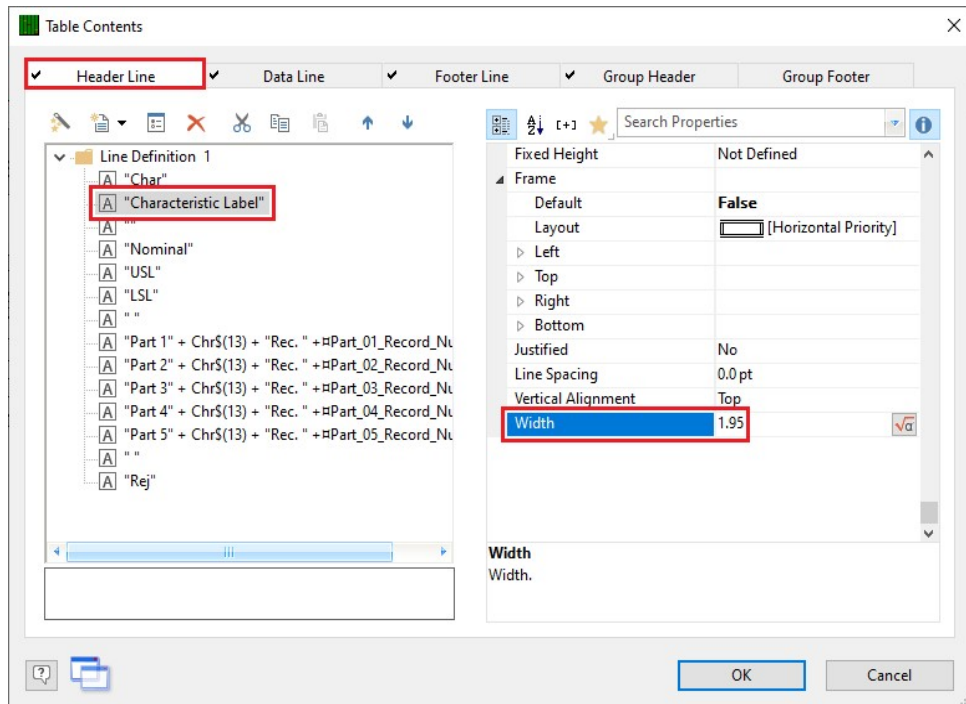


3. Next, use the Ctrl key to click and highlight the “if(Used_Part_01...” through “if(Used_Part_05...” in the **Line** area and set the **Width** for all 5 lines to “0.75.”

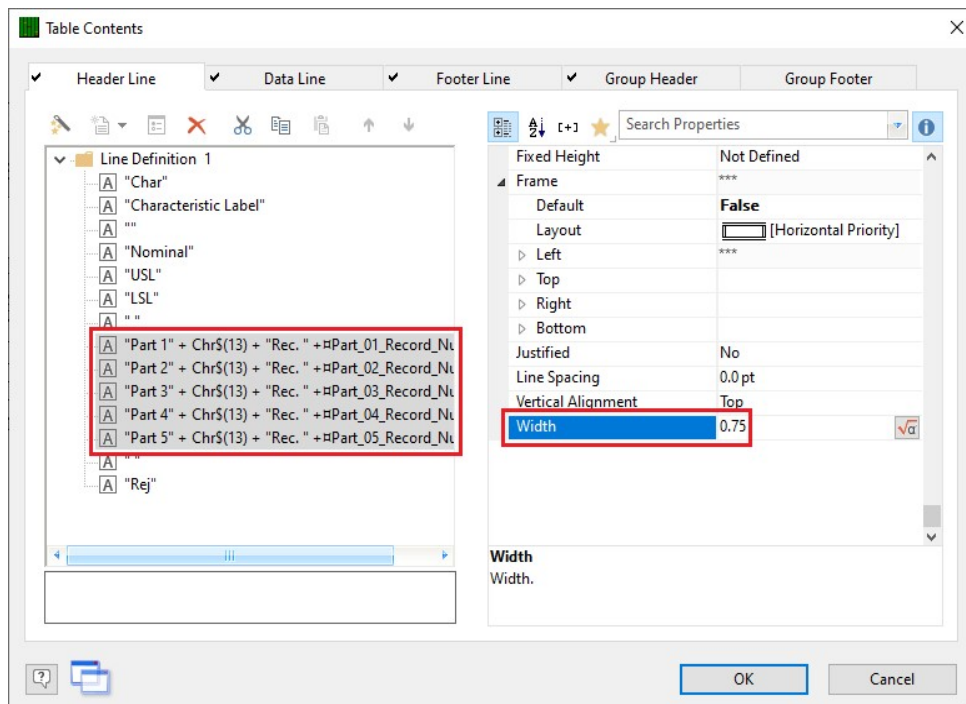


Reporting – First Article for 6 Parts

- Now that we have made room in the Data area for the additional column, we need to do the same thing in the Header area.
- Choose the **Header Line** tab then click on the “Characteristic Label” line in the **Line** area. On the right side of the screen change the **Width** to “1.95.”



- Next, use the Ctrl key to click and highlight the “Part 1” + Chr\$(13)...” through “Part 5” + Chr\$(13)...” in the **Line** area and set the **Width** for all 5 lines to “0.75.”

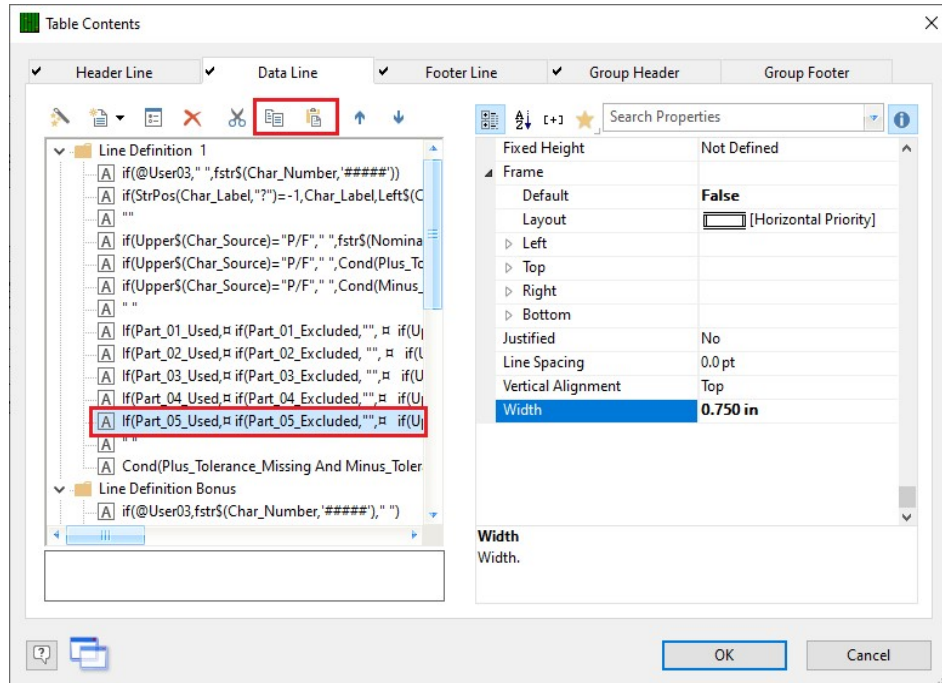


- Click the **OK** button, to save these changes.

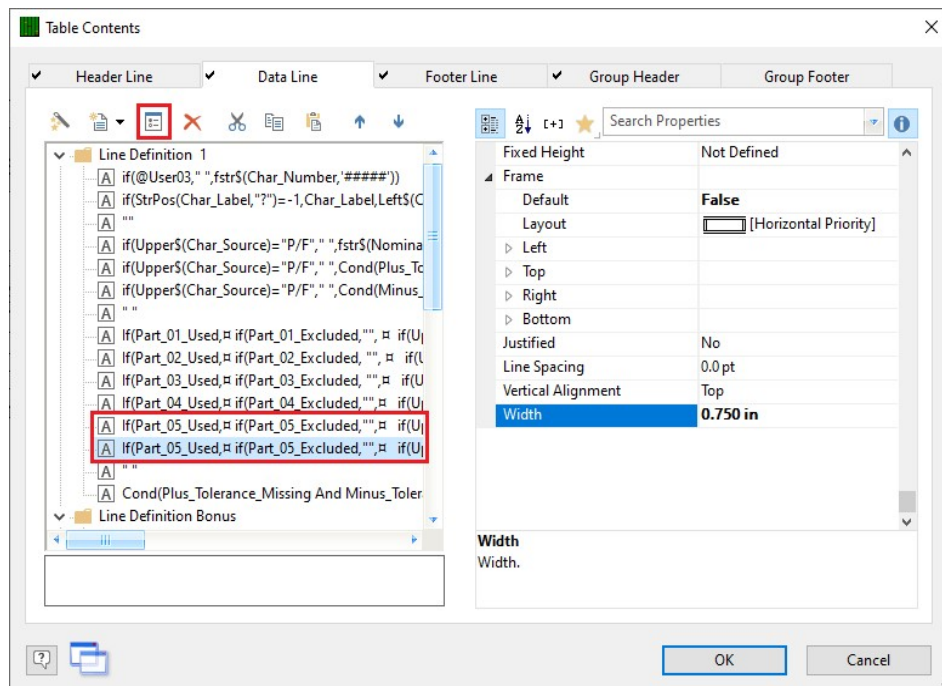
Reporting – First Article for 6 Parts

Adding a Column for Part 6

1. Double click on the table so that the **Table Contents** window will appear again.
2. Choose the **Data Line** tab, highlight the “if(Used_Part_05...” line, then click the **Copy line to Clipboard** button followed by the **Insert line(s) from Clipboard** button. This was done so that you can easily get the same exact information in the Part 6 column without having to type in all of these commands.

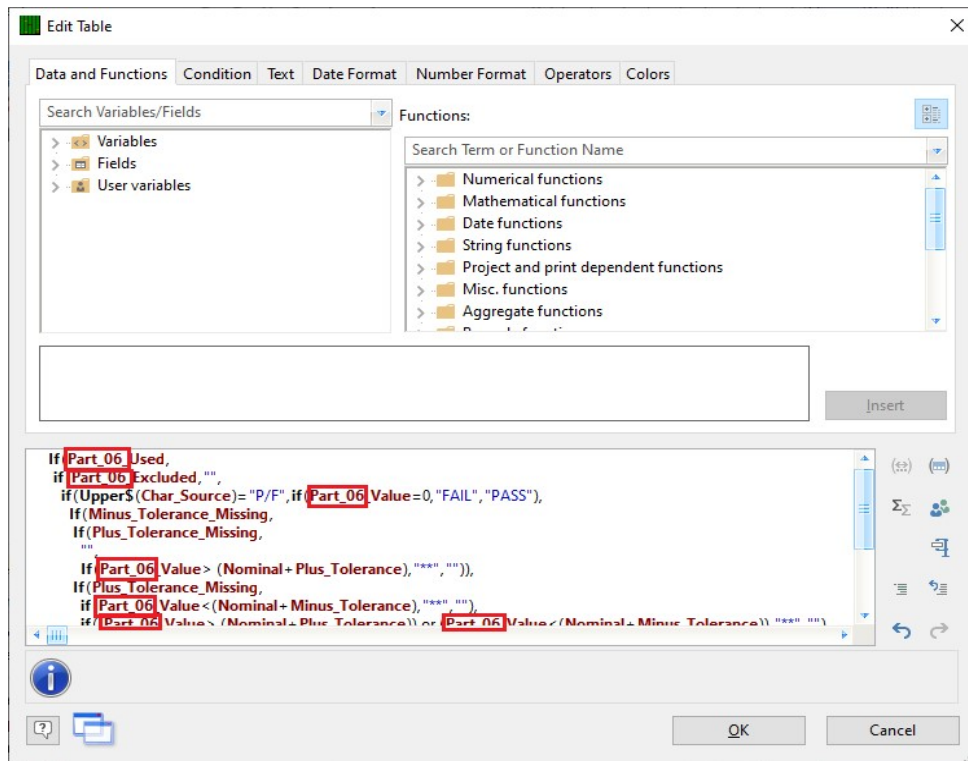


3. You now have 2 “if(Used_Part_05...” lines showing in the **Table Contents** window. Click on the bottom instance of that line and click the **Edit line** button.



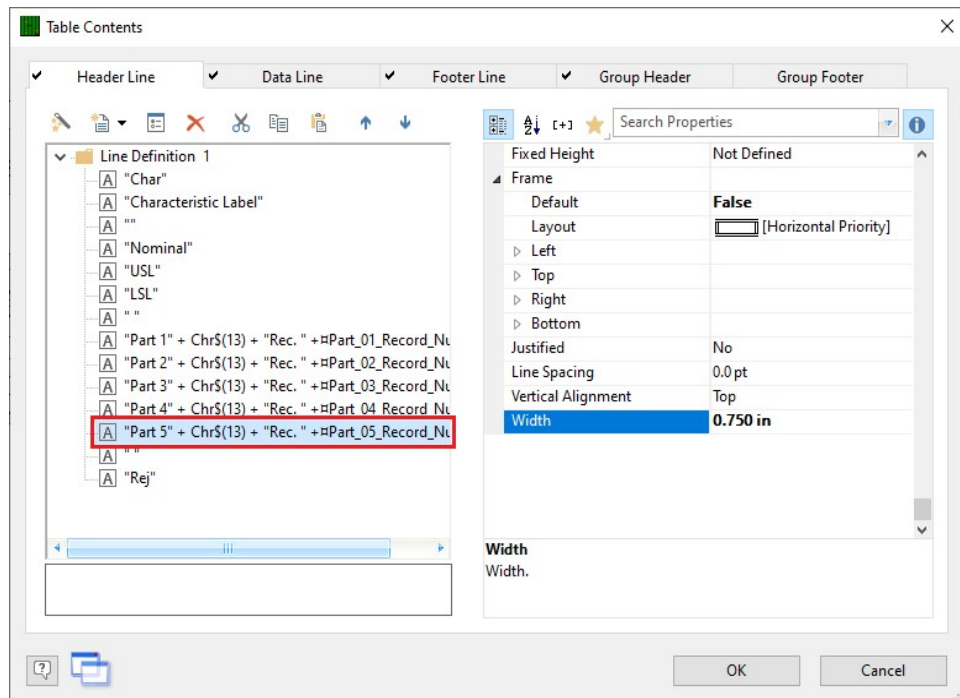
Reporting – First Article for 6 Parts

- Now go through the entire block of commands in the bottom section of the **Edit Table** window, change all instances of “Part_05” to “Part_06”, and click **OK**.



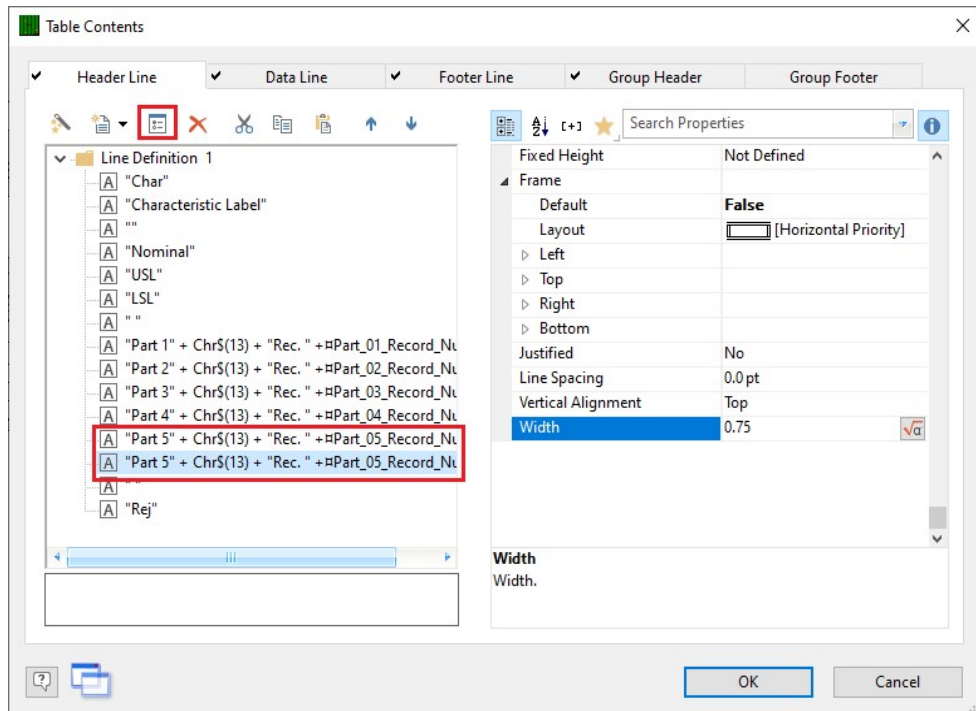
New Column Header

- In the **Table Contents** window, choose the **Header Line** tab.
- Highlight the “Part 5...” line, then click the **Copy line to Clipboard** button followed by the **Insert line(s) from Clipboard** button.

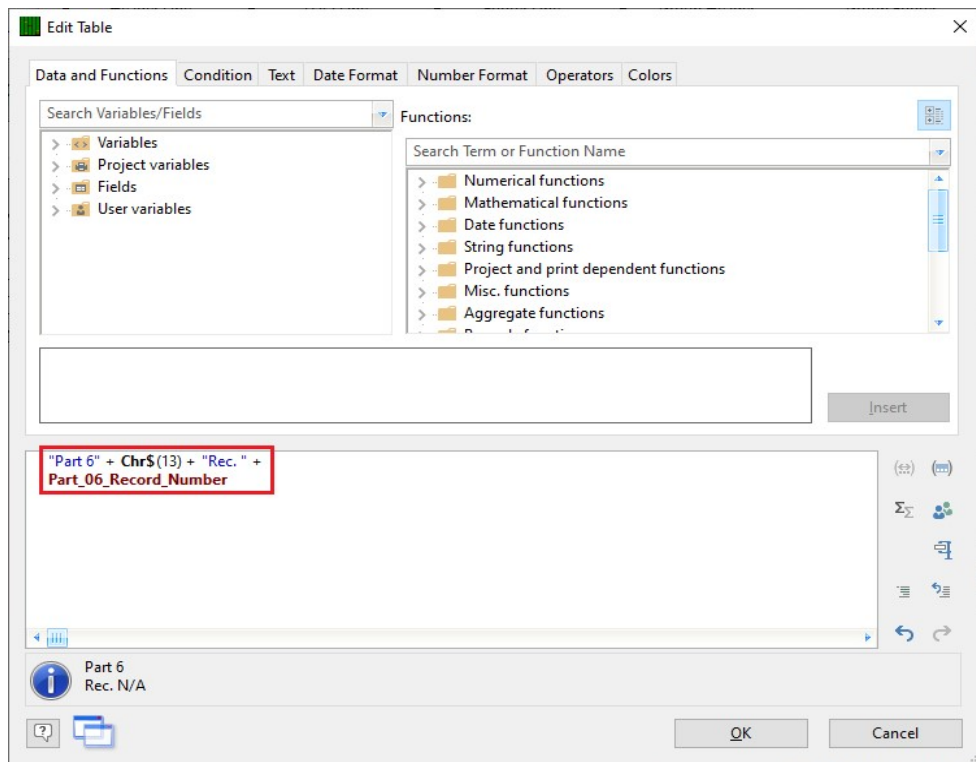


Reporting – First Article for 6 Parts

- You now have 2 “Part 5...” lines showing in the **Table Contents** window. Click on the bottom instance of that line and click the **Edit line** button.



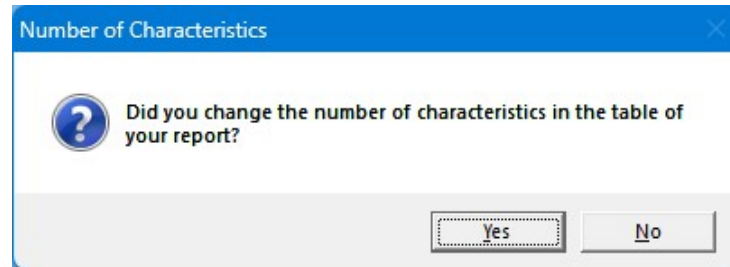
- Now go through the entire block of commands in the bottom section of the **Edit Table** window, change all instances of “Part_05” to “Part_06”, and click **OK**.



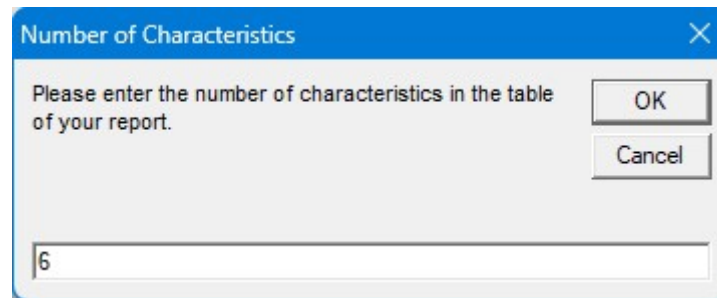
Reporting – First Article for 6 Parts

Final Steps

1. Click **OK** on the **Table Contents** screen and save your changes (**File > Save**).
2. Exit from the Report Designer. You will see a question asking if you changed the number of parts in your report. Choose **Yes** on this message.



3. The next window that appears will be asking for the total number of parts now represented in this report. Answer this question with "6" for your report to run correctly in the future.



4. Now run your report and you should have a 6th column of parts.

Preview

1 of 7

100%

Six Piece (1-6 Piece)

November 23, 2023 15:20:24

Prolink Inc.

Sample200.qcq
Sample200
Date of Inspection August 22, 2002
Time of Inspection 12:53:45
Records 95 - 100

Char	Characteristic Label	Nominal	USL	LSL	Part 1 Rec. 95	Part 2 Rec. 96	Part 3 Rec. 97	Part 4 Rec. 98	Part 5 Rec. 99	Part 6 Rec. 100	Rej
1	1Dimension number 1	1.500	1.640	1.380	1.466	1.402	1.526	1.446	1.519	1.620	
2	2Dimension number 2	2.5000	2.6500	2.3900	2.6360	2.4944	2.4365	2.5481	2.5294	2.4375	
3	3Dimension number 3	3.50	3.63	3.37	3.46	3.44	3.51	3.53	3.50	3.48	
4	4Dimension number 4	4.500	4.640	4.380	4.534	4.625	4.369	4.490	4.448	4.515	1
5	5Dimension number 5	5.5000	5.6500	5.3900	5.4761	5.4784	5.5406	5.4118	5.4545	5.4318	
6	6Dimension number 6	6.50	6.63	6.37	6.57	6.59	6.46	6.53	6.57	6.47	
7	7Dimension number 7	7.500	7.640	7.380	7.569	7.389	7.495	7.444	7.548	7.577	1
8	8Dimension number 8	8.5000	8.6500	8.3900	8.5953	8.4924	8.4940	8.5715	8.4951	8.4903	
9	9Dimension number 9	9.50	9.63	9.37	9.44	9.46	9.46	9.49	9.48	9.56	
10	10Dimension number 10	10.500	10.640	10.380	10.587	10.601	10.550	10.382	10.560	10.364	1
11	11Dimension number 11	11.5000	11.6500	11.3900	11.4841	11.4720	11.5919	11.5348	11.4709	11.5001	
12	12Dimension number 12	12.50	12.63	12.37	12.56	12.40	12.56	12.46	12.46	12.55	
13	13Dimension number 13	13.500	13.640	13.380	13.458	13.531	13.483	13.557	13.418	13.421	
14	14Dimension number 14	14.5000	14.6500	14.3900	14.3851	14.4408	14.5523	14.4195	14.4957	14.5241	1
15	15Dimension number 15	15.50	15.63	15.37	15.43	15.55	15.55	15.57	15.51	15.54	
16	16Dimension number 16	16.500	16.640	16.380	16.491	16.600	16.524	16.582	16.391	16.436	
17	17Dimension number 17	17.5000	17.6500	17.3900	17.4959	17.5058	17.4168	17.4324	17.4228	17.5228	
18	18Dimension number 18	18.50	18.63	18.37	18.51	18.49	18.40	18.63	18.43	18.52	
19	19Dimension number 19	19.500	19.640	19.380	19.374	19.500	19.410	19.540	19.503	19.516	1
20	20Dimension number 20	20.5000	20.6500	20.3900	20.4414	20.5615	20.3854	20.4965	20.5436	20.5626	1
21	21Dimension number 21	21.50	21.63	21.37	21.51	21.60	21.44	21.59	21.47	21.63	
22	22Dimension number 22	22.500	22.640	22.380	22.496	22.509	22.462	22.561	22.561	22.413	1
23	23Dimension number 23	23.5000	23.6500	23.3900	23.5675	23.5345	23.5905	23.5621	23.4961	23.5378	
24	24Dimension number 24	24.50	24.63	24.37	24.63	24.45	24.58	24.58	24.42	24.44	
25	25Dimension number 25	25.500	25.640	25.380	25.632	25.627	25.473	25.480	25.447	25.548	

Page 1 of 7