

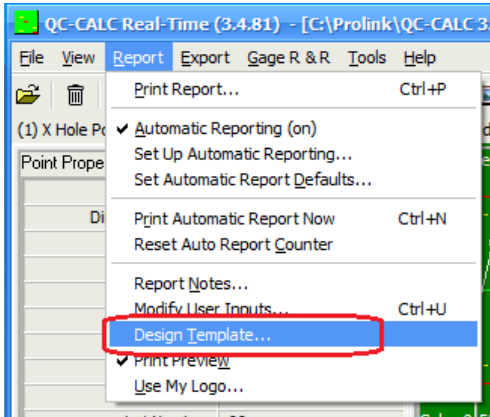
Reporting – Dimension Source to First Article

The default **First Article** report that comes with QC-CALC does not display the Dimension Source value. This White Paper will give step by step instructions for adding a column to the default First Article template to display the Dimension Source.

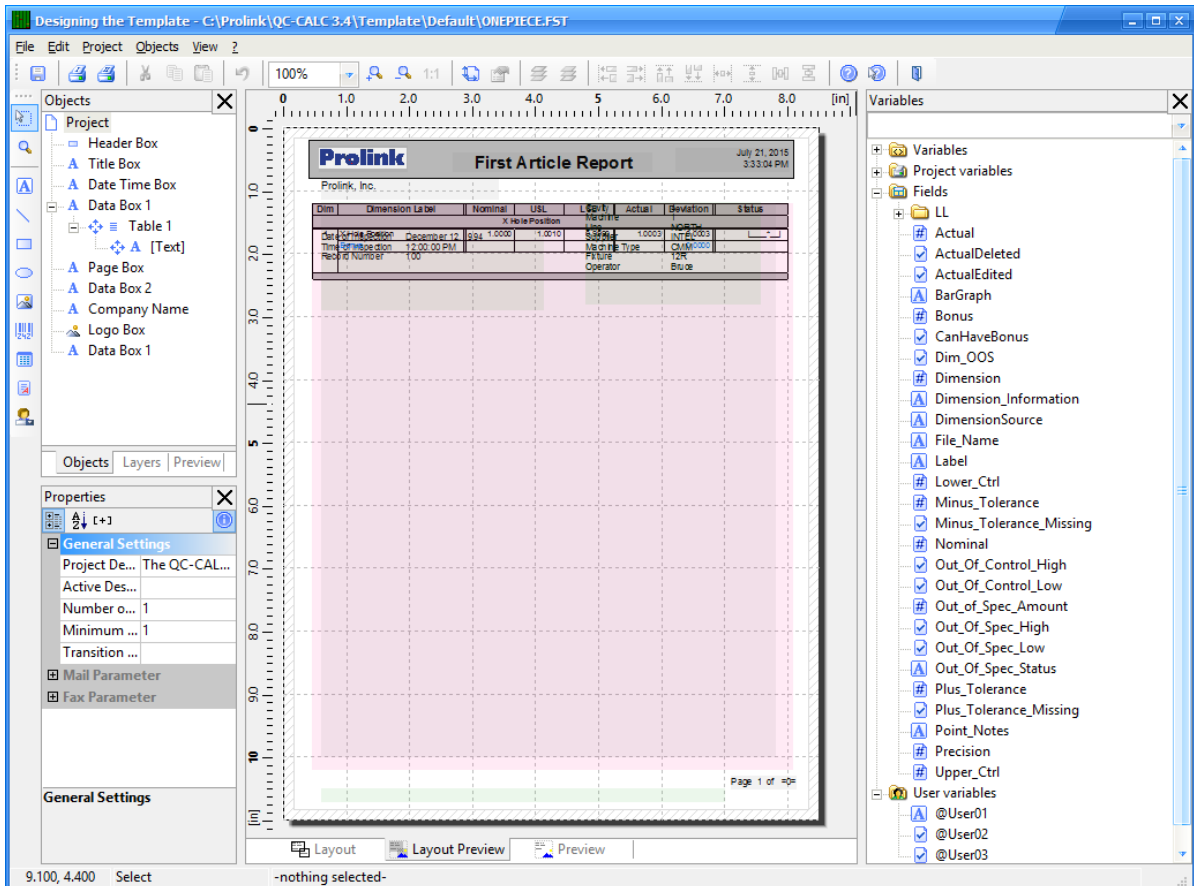
The Report Designer

The directions shown here will walk you through adding a column for Dimension Source 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.

1. From QC-CALC Real-Time choose the **Report – Design Template** menu.



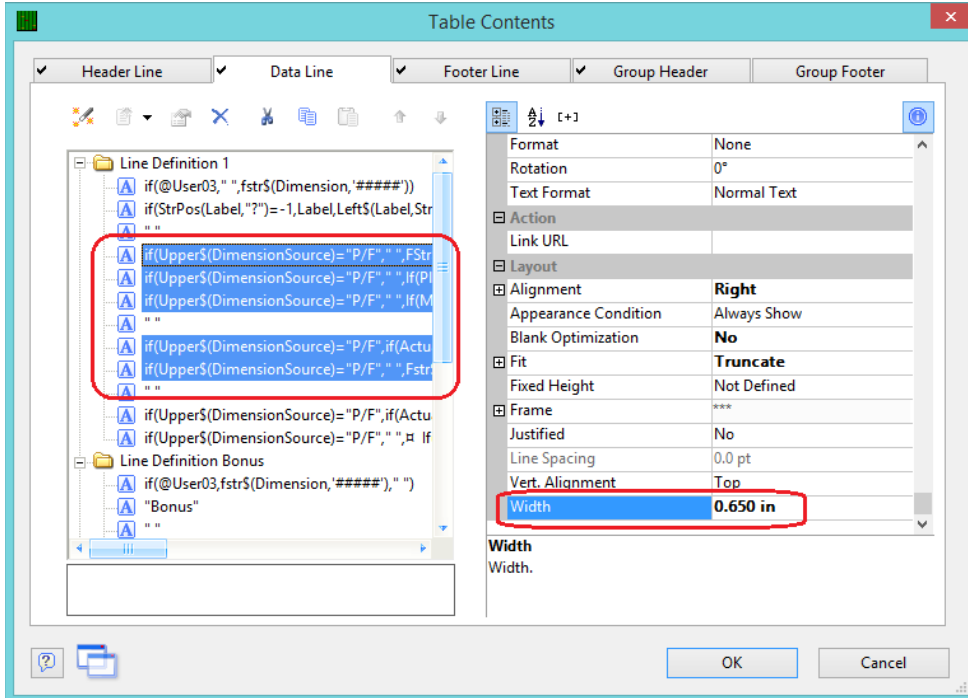
2. Choose the OnePiece.FST template from the list of files that appears and click **Open**.
3. The Report Designer now appears on the screen.



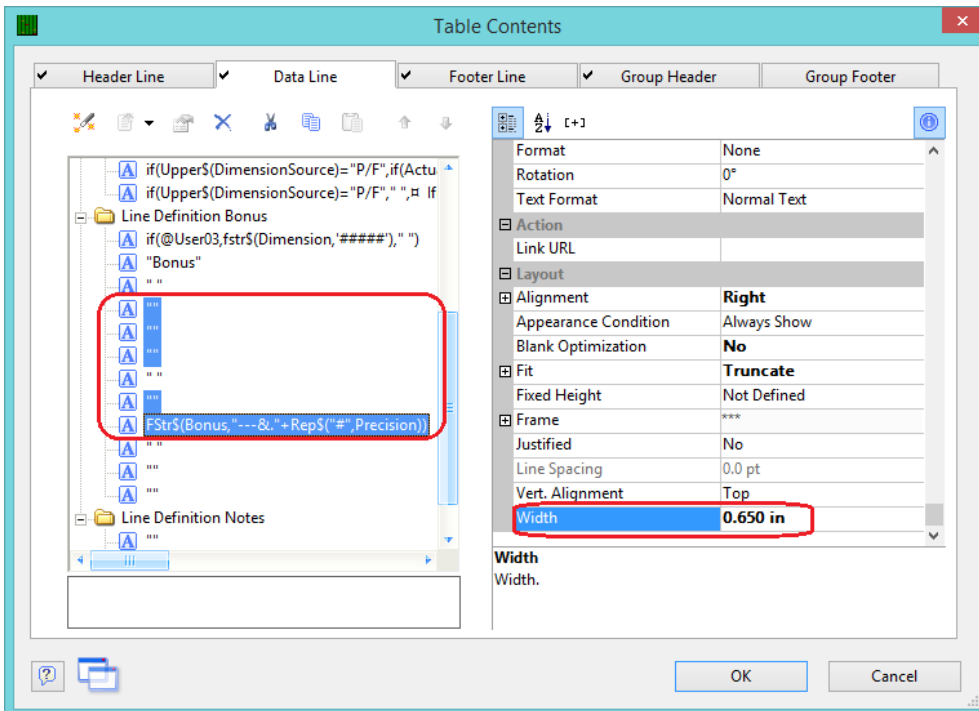
Reporting – Dimension Source to First Article

Making more Space

1. Double click on the table (the large pink rectangle) and the **Table Contents** window will appear.
2. Choose the **Data Line** tab then use the CTRL key to click and highlight the lines for the specification values and the Actual and Deviation values in the **Line Definition 1** area and set the **Width** for all 5 lines to “0.65.” Be sure to skip the blank line in the middle.

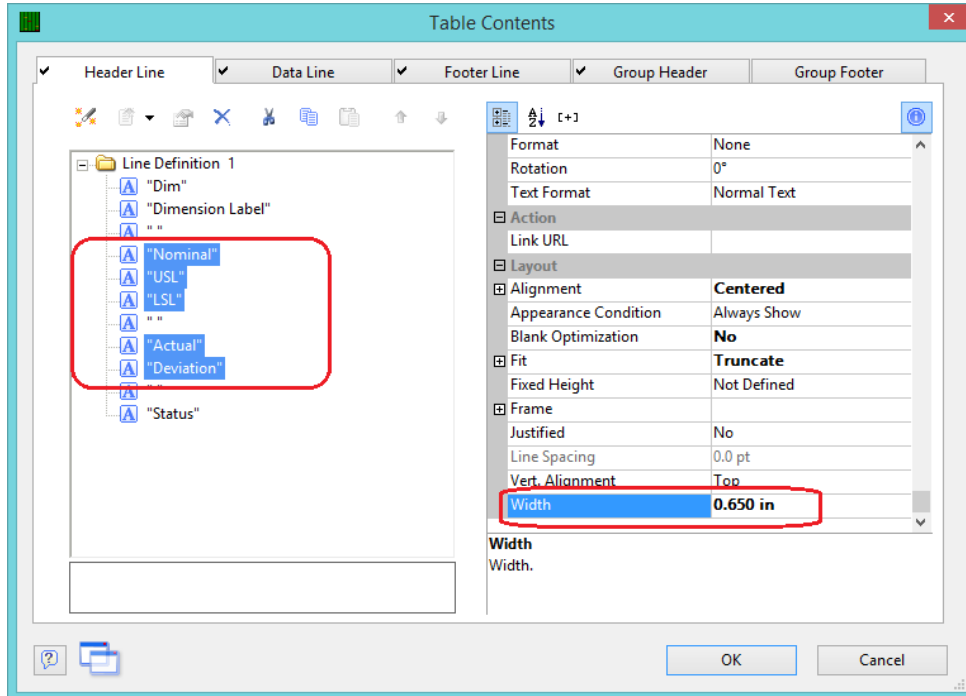


3. Scroll down in to the **Line Definition Bonus** area. Use the CTRL key to highlight the matching lines from the previous step and set the **Width** for all 5 lines to “0.65.” These are mostly blank, so match the pattern below.



Reporting – Dimension Source to First Article

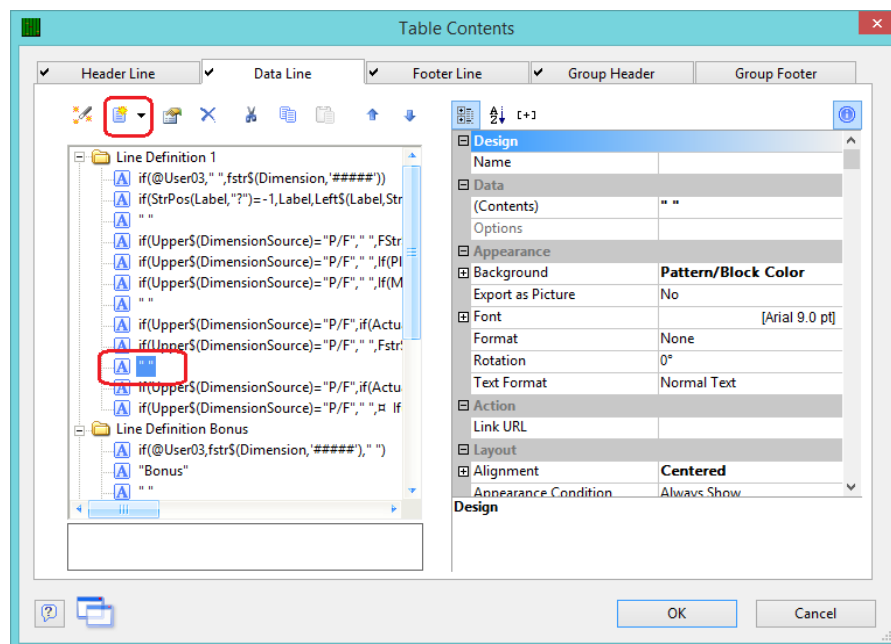
- Now that we have made room in the Data area for the additional column, we need to do the same thing in the Header area.
- Choose the **Header Line** tab then use the CTRL key to click and highlight the specification titles and the Actual and Deviation lines in the **Line Definition 1** area and set the **Width** for all 5 lines to "0.65." Be sure to skip the blank line in the middle.



- Click the **OK** button then choose **File - Save**, to save these changes.

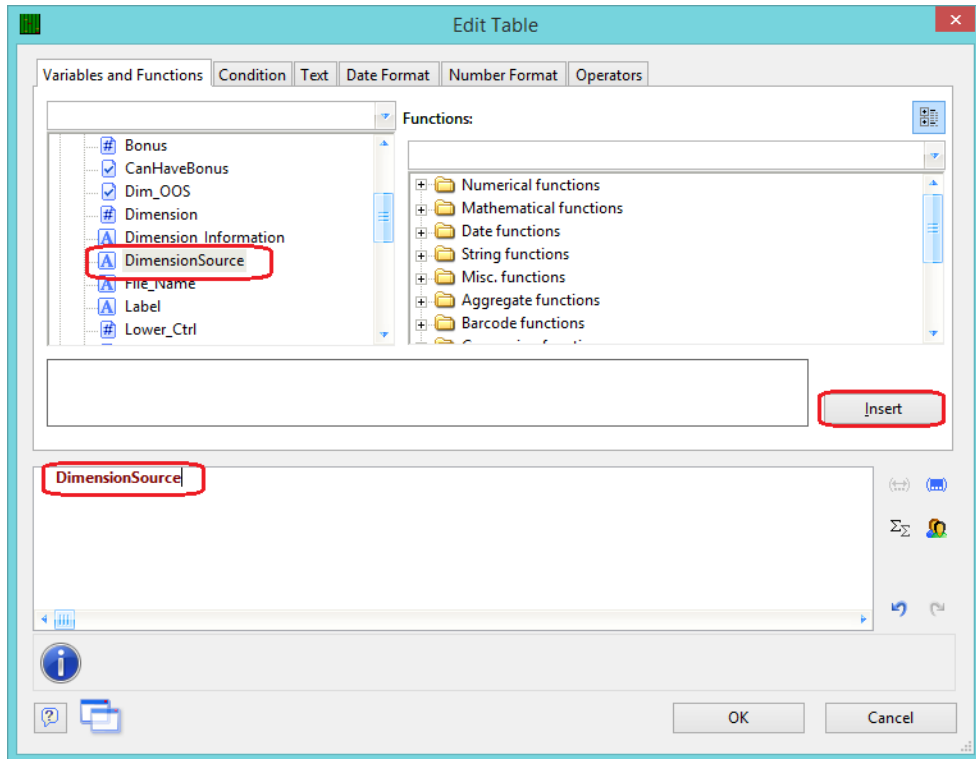
Adding a Column

- Double click on the table and the **Table Contents** window will appear again.
- Choose the **Data Line** tab, highlight the 3rd to last line in the **Line Definition 1** area, then click the **Append column** button.

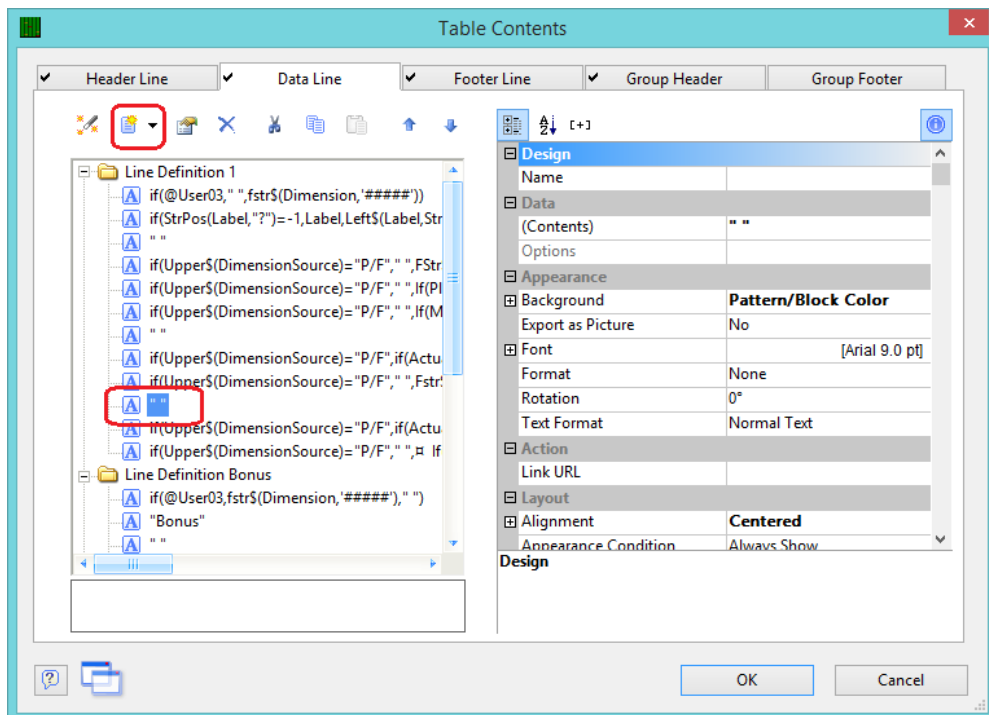


Reporting – Dimension Source to First Article

3. In the **Edit Table** window that appears, choose “DimensionSource” in the **Fields** list, then click the **Insert** button.

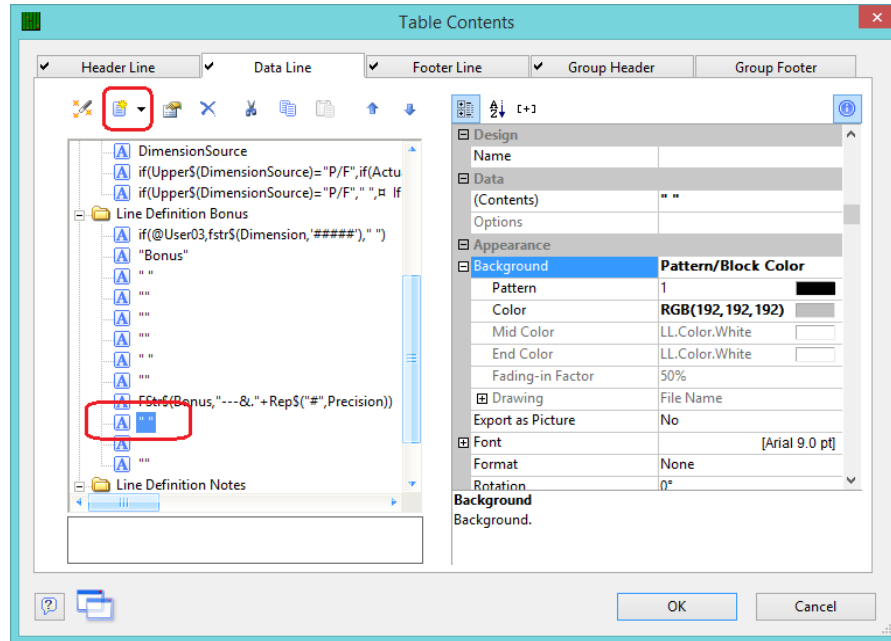


4. Click **OK** on the **Edit Table** window, then, with the “DimensionSource” line highlighted on the left, change the **Width** to “0.650” and the **Background** to “Transparent.”

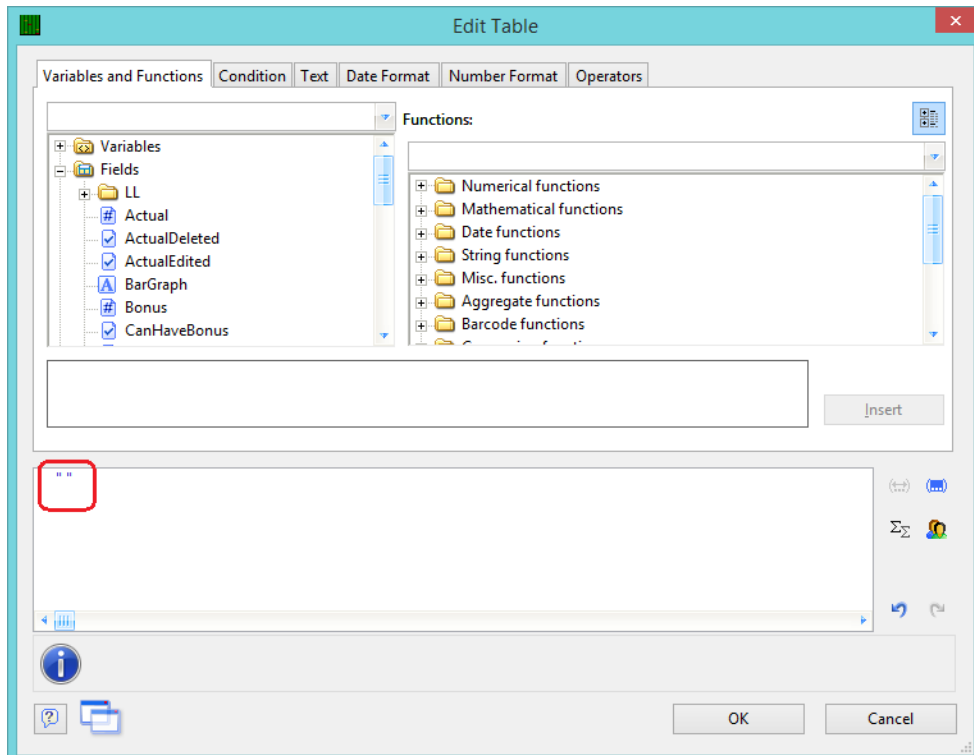


Reporting – Dimension Source to First Article

- Next, the same changes need to be made to the Bonus line. Highlight the 3rd to last line in the **Line Definition Bonus** area and click the **Append column** button.

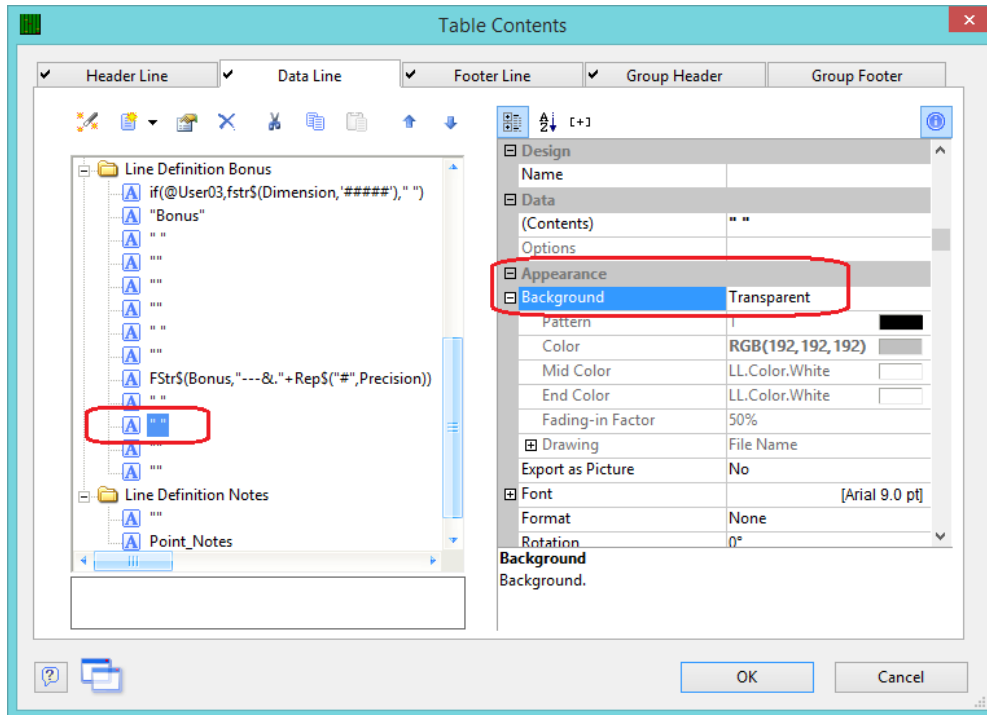


- In the **Edit Table** window that appears, enter “ ” in the box at the bottom.



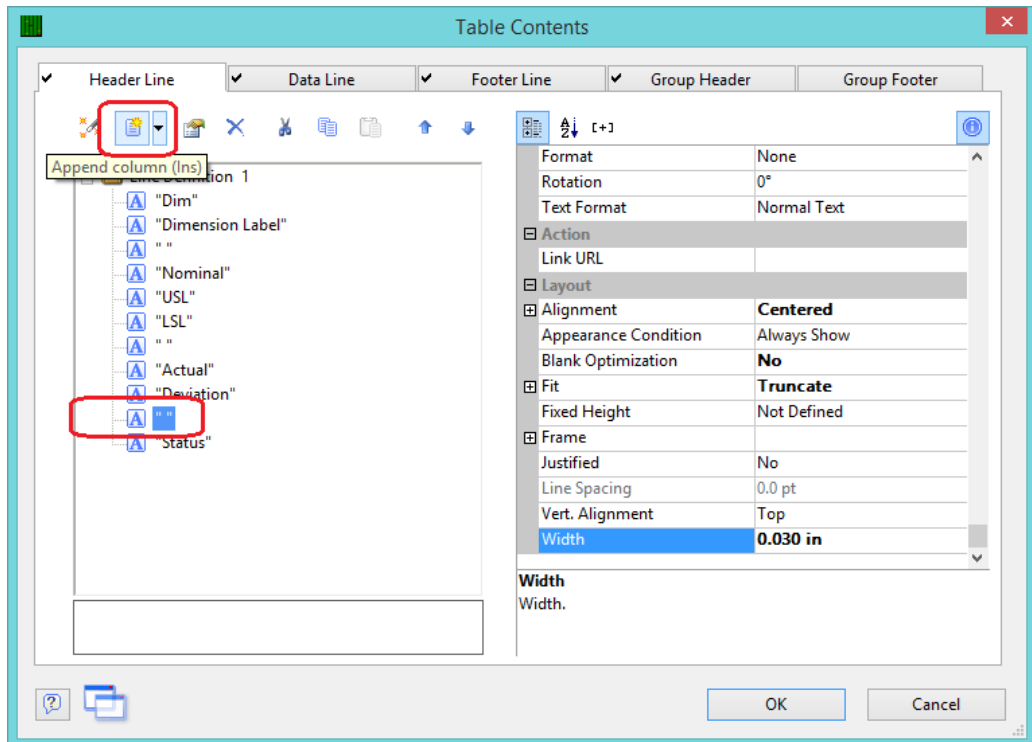
Reporting – Dimension Source to First Article

7. Click **OK** on the **Edit Table** window, then in the **Table Contents** window highlight the “ ” line on the left, change the **Width** to “0.650” and the **Background** to “Transparent.”



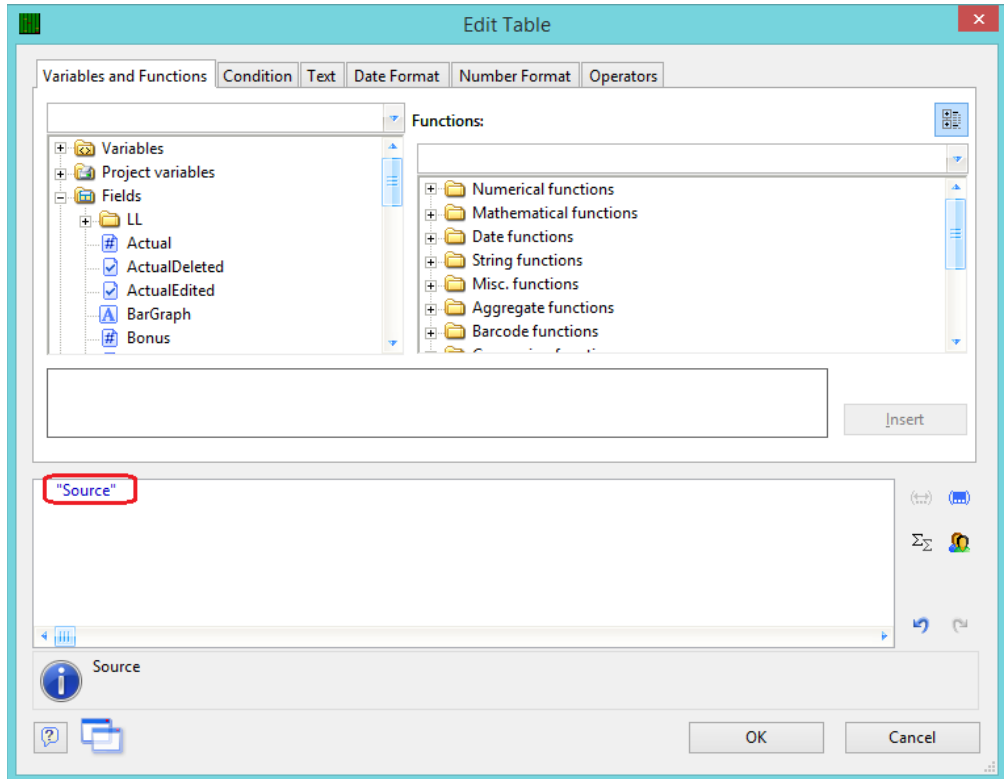
New Column Header

1. In the **Table Contents** window choose the **Header Line** tab.
2. Highlight the “ ” line after “Deviation”, then click the **Append column** button.

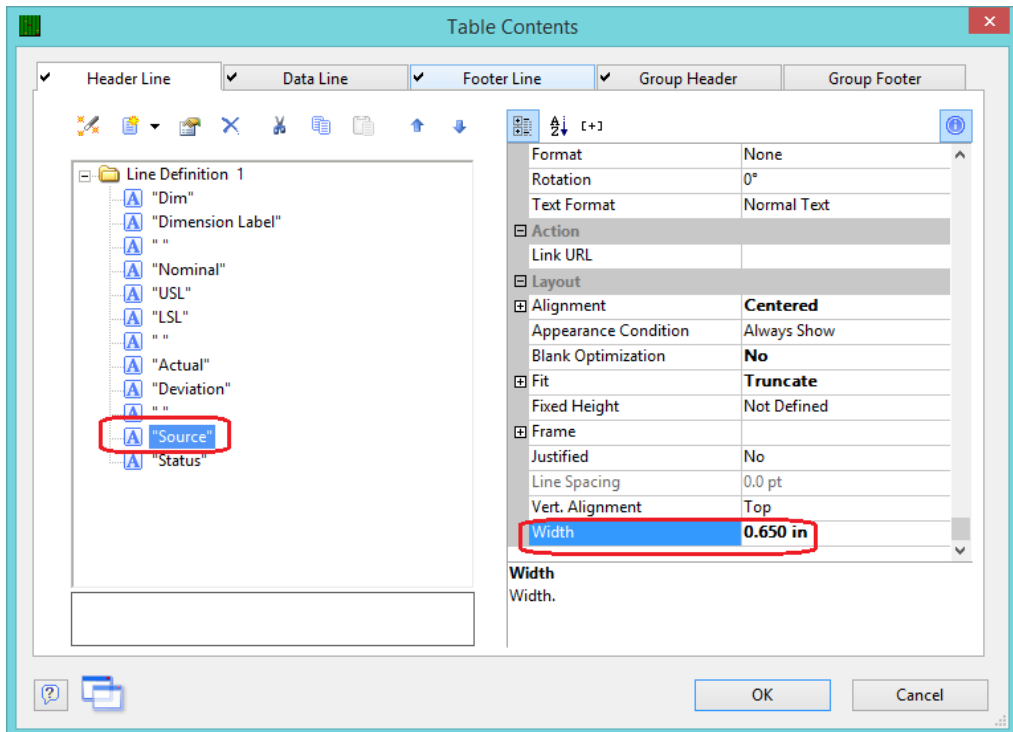


Reporting – Dimension Source to First Article

3. In the **Edit Table** window that appears, enter “Source” in the bottom box and click **OK**.



4. Back in the **Table Contents** window, highlight the “Source” line on the left and change the **Width** to “0.650”.



Reporting – Dimension Source to First Article

Final Steps

1. Click **OK** on the **Table Contents** screen and save your changes (**File – Save**).
2. Exit from the Report Designer and run your report.
3. You should see the contents of the Dimension Source field appearing in your report now.

The screenshot shows a software window titled 'Preview' displaying a 'First Article Report' for Prolink, Inc. The report includes a header with the company name, date (July 21, 2015), and time (5:44:35 PM). Below the header, there are fields for sample information (Sample qcc, Sample), inspection details (Date of Inspection: December 12, 1994; Time of Inspection: 12:00:00 PM; Record Number: 100), and machine/operator information (Cavity: 4; Machine: 1; Line: NORTH; Supplier: INTEL; Machine Type: CMM; Fixture: 12R; Operator: Bruce).

The main part of the report is a table with 20 rows of dimension data. The columns are: Dim, Dimension Label, Nominal, USL, LSL, Actual, Deviation, Source, and Status. A red rectangular box highlights the 'Source' column, which contains values such as 'Gage', 'CMM', 'Vision', and 'Keyboard'.

Dim	Dimension Label	Nominal	USL	LSL	Actual	Deviation	Source	Status
1	X Hole Position	1.0000	1.0010	0.9990	1.0003	0.0003	Gage	*
2	Y Hole Position	2.0000	2.0020	1.9980	1.9988	-0.0014	Gage	*
3	Z Hole Position	3.0000	3.0030	2.9970	2.9989	-0.0011	Gage	*
4	Line Length	4.0000	4.0040	3.9960	4.0013	0.0013	Gage	*
5	Datum 1	5.0000	5.0050	4.9950	5.0004	0.0004	CMM	*
6	Datum 2	6.0000	6.0060	5.9940	5.9960	-0.0040	CMM	*
7	Datum 3	7.0000	7.0070	6.9930	7.0043	0.0043	CMM	*
8	Datum 1 - Datum2	8.0000	8.0080	7.9920	8.0023	0.0023	CMM	*
9	Chamfer Angle	9.0000	9.0090	8.9910	9.0029	0.0029	Vision	*
10	Snap Dia	10.0000	10.0100	9.9900	10.0039	0.0039	Vision	*
11	Overall Length	11.0000	11.0110	10.9890	11.0001	0.0001	Vision	*
12	Ring length	12.0000	12.0120	11.9880	11.9989	-0.0011	Vision	*
13	Thread Pitch	13.0000	13.0130	12.9870	13.0020	0.0020	Gage	*
14	OD Fit	14.0000	14.0140	13.9860	14.0024	0.0024	Gage	*
15	Functional Size	15.0000	15.0150	14.9850	15.0027	0.0027	Gage	*
16	Bond thickness	16.0000	16.0160	15.9840	16.0040	0.0040	Gage	*
17	ManDimension 1	1.5216	2.8147	0.2285	1.6300	0.1084	Keyboard	*
18	ManDimension 2	2.5351	3.5078	1.5624	2.9500	0.4149	Keyboard	*
19	X Hole Position x.2	1.9998	2.0039	1.9957	2.0006	0.0009		*
20	Y Hole Position x.2	4.0000	4.0097	3.9903	3.9971	-0.0029		*