

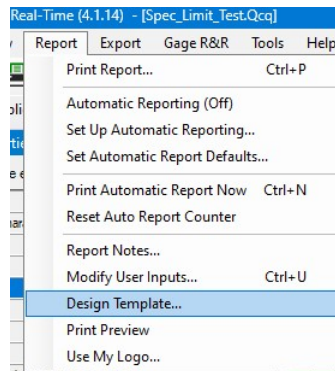
# Reporting – Characteristic Source to First Article

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

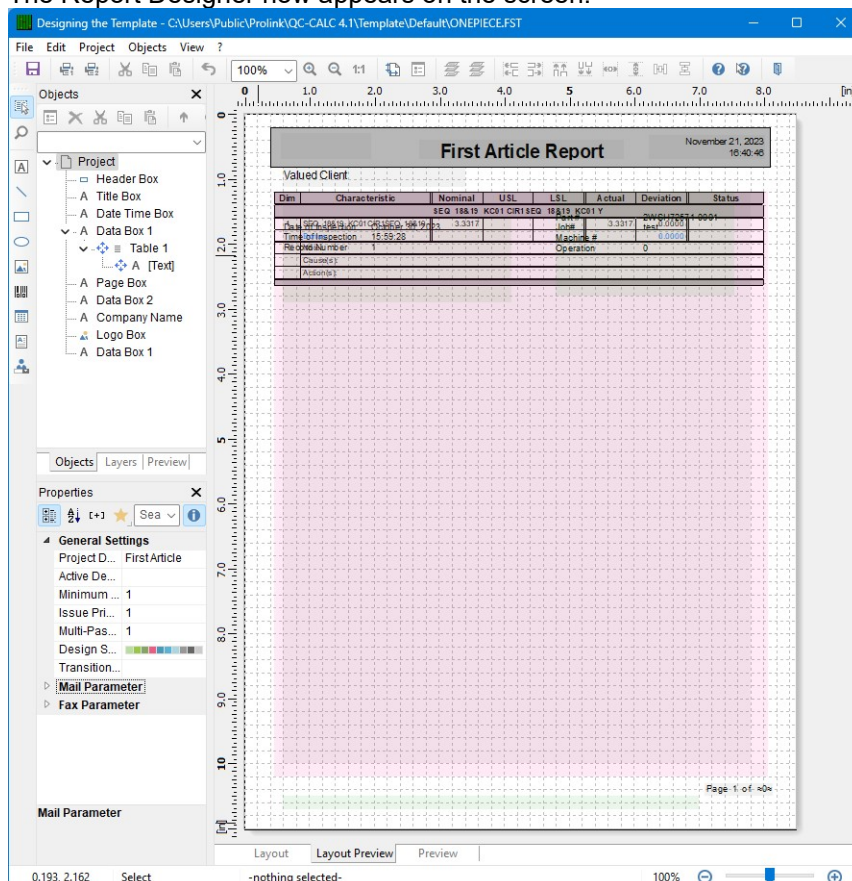
## The Report Designer

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



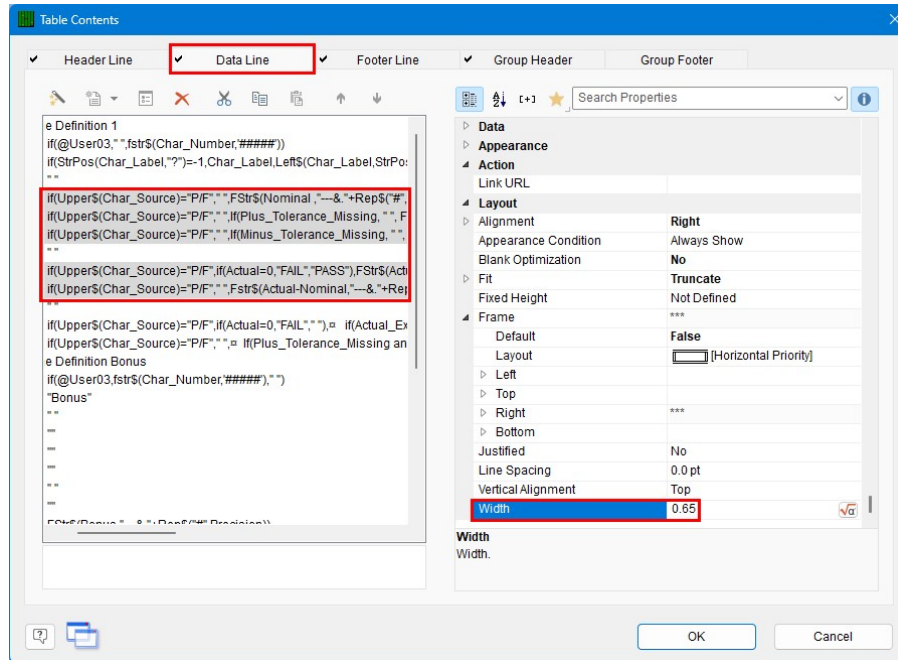
2. Choose the OnePiece.FST template from the list of files that appears and click **Open**.
3. The Report Designer now appears on the screen.



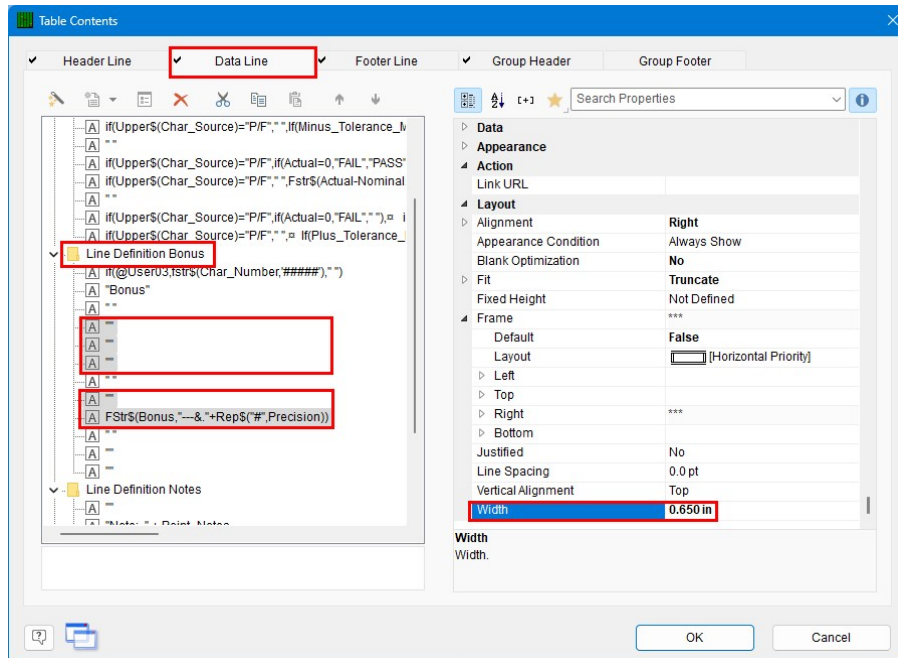
# Reporting – Characteristic Source to First Article

## 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** under **Layout** for all 5 lines to “0.65.” Be sure to skip the blank line in the middle.

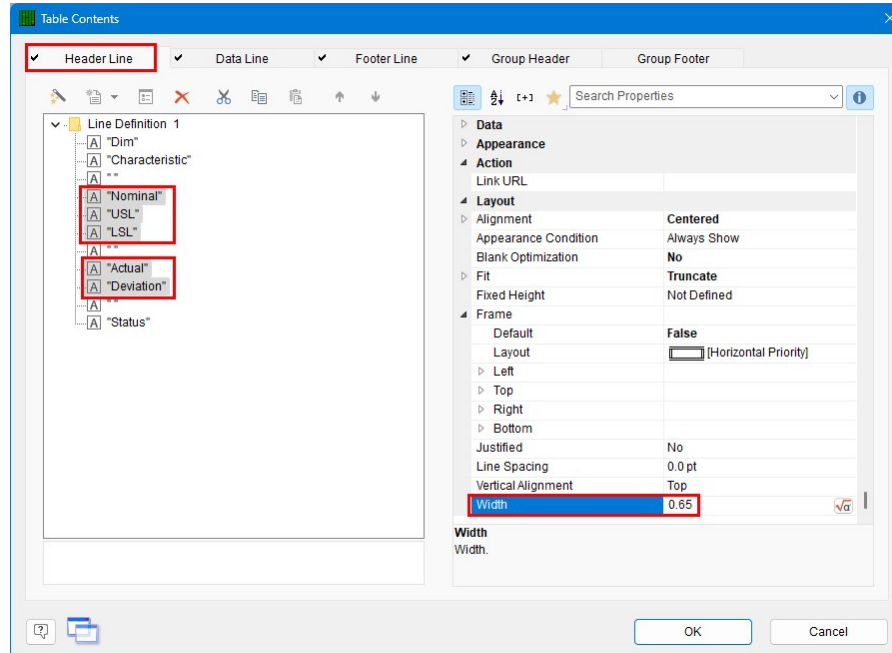


3. Scroll down into the **Line Definition Bonus** area. Use the CTRL key to highlight the matching lines from the previous step and set the **Width** under **Layout** for all 5 lines to “0.65.” These are mostly blank, so match the pattern below.



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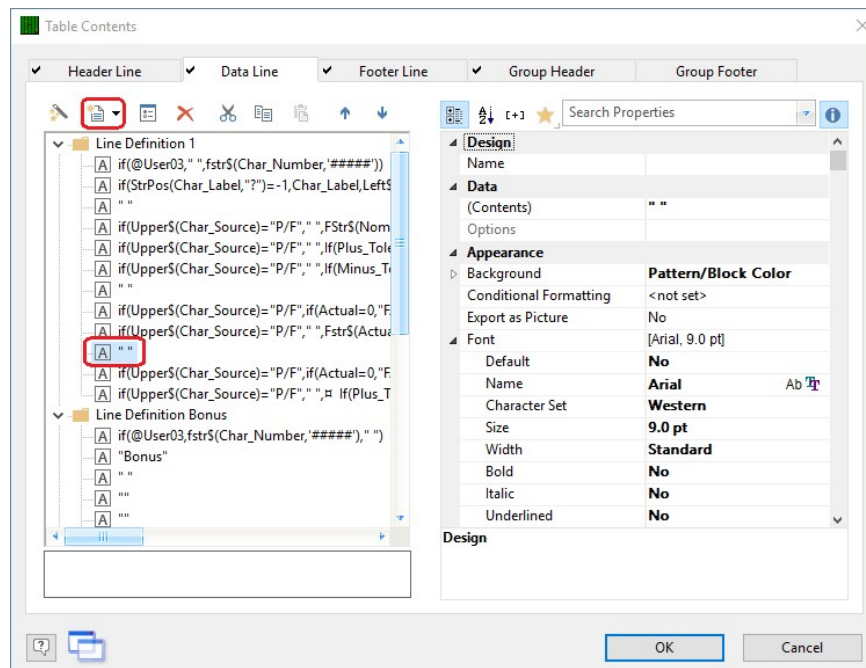
- Now that we have made room in the Data area for the additional column, we need to do the same thing in the Header area.
- Choose the **Header Line** tab then hold the CTRL key and click to highlight the specification titles and the Actual and Deviation lines in the **Line Definition 1** area and set the **Width** under **Layout** 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.

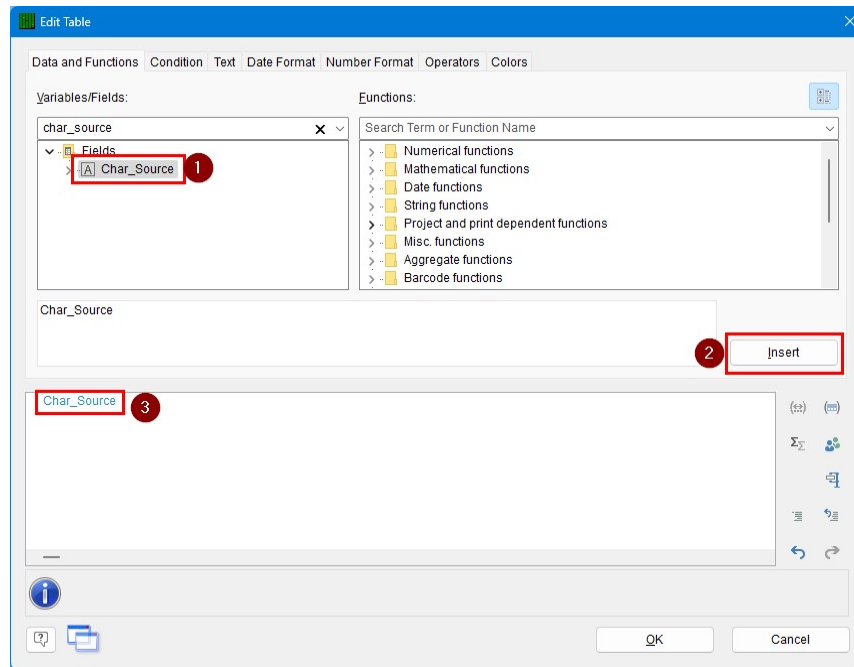
### Adding a Column

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

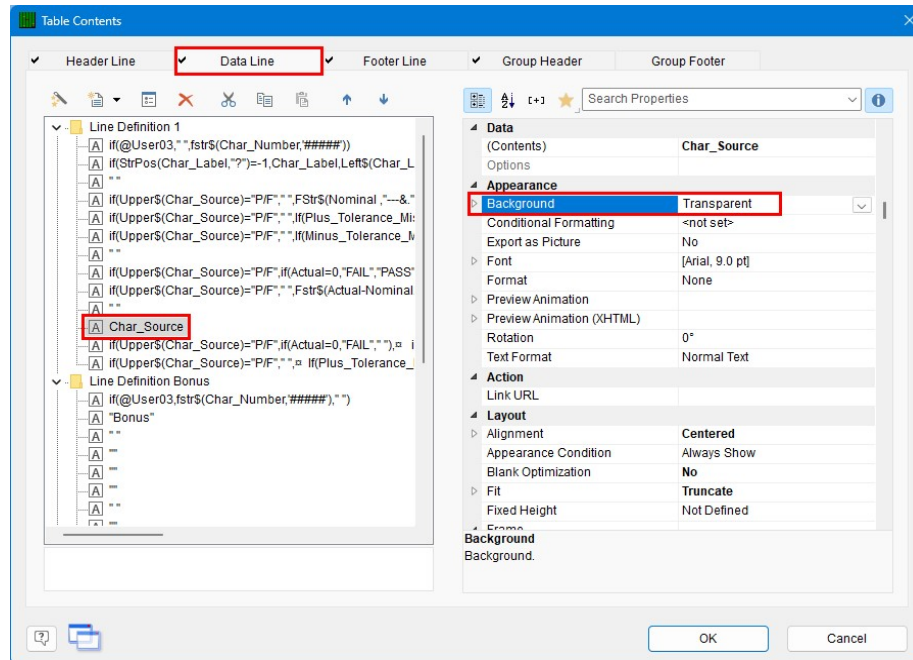


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3. In the **Edit Table** window that appears, choose “Char\_Source” in the **Fields** list, then click the **Insert** button.

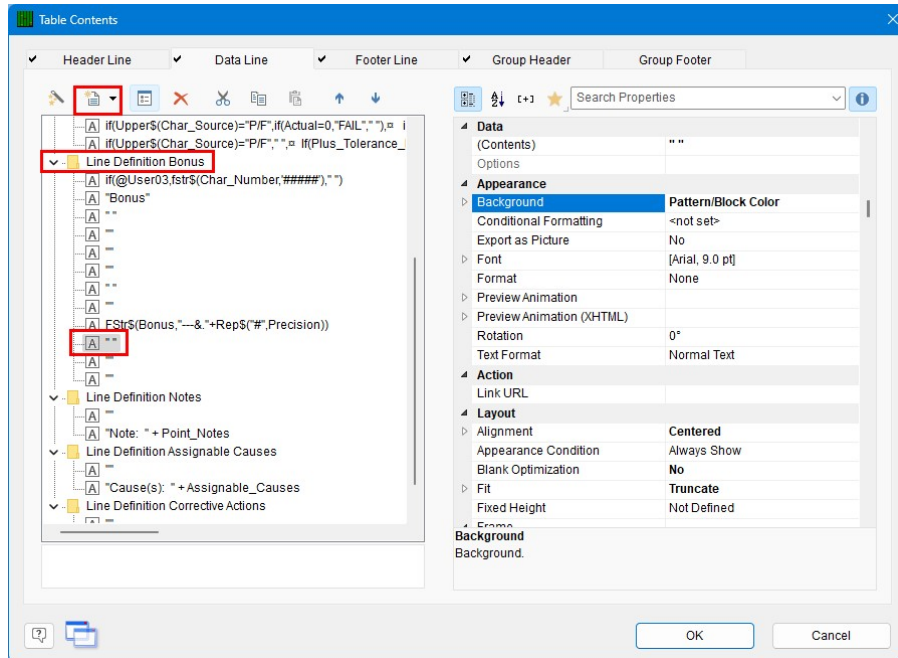


4. Click **OK** on the **Edit Table** window, then, with the “Char\_Source” line highlighted on the left, change the **Width** to “0.650” and the **Background** to “Transparent.”

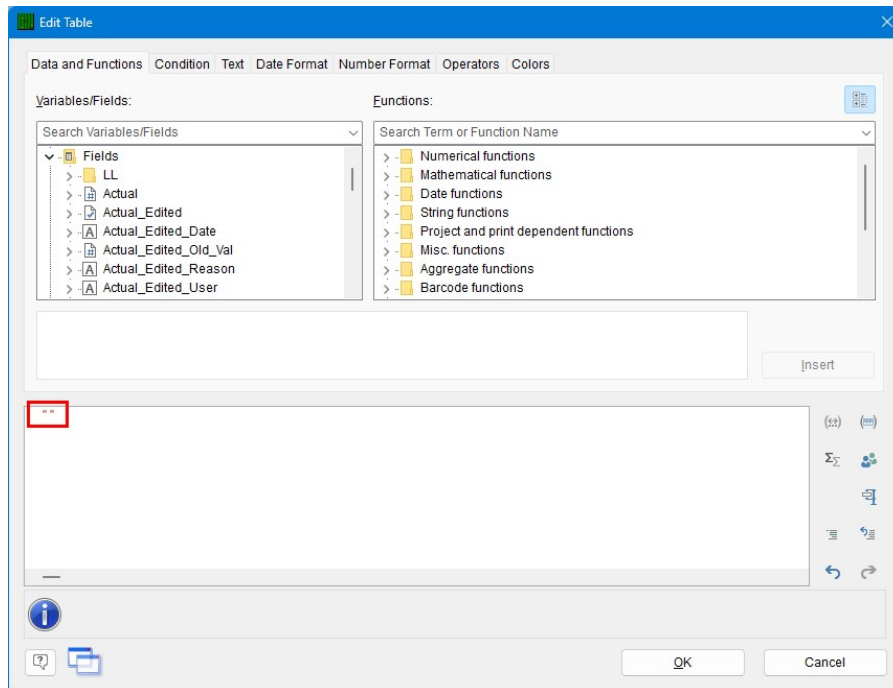


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Next, the same changes need to be made to the Bonus line. Highlight the 3<sup>rd</sup> to last line in the **Line Definition Bonus** area and click the **Append column** button.



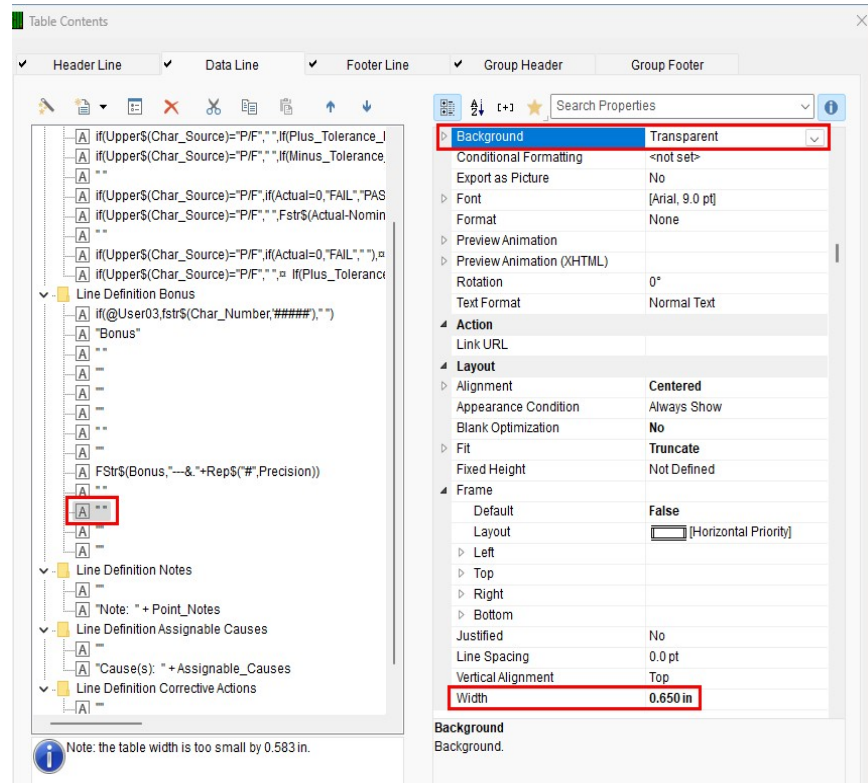
5. In the **Edit Table** window that appears, enter " " (two quotation marks with a space between them) in the box at the bottom.





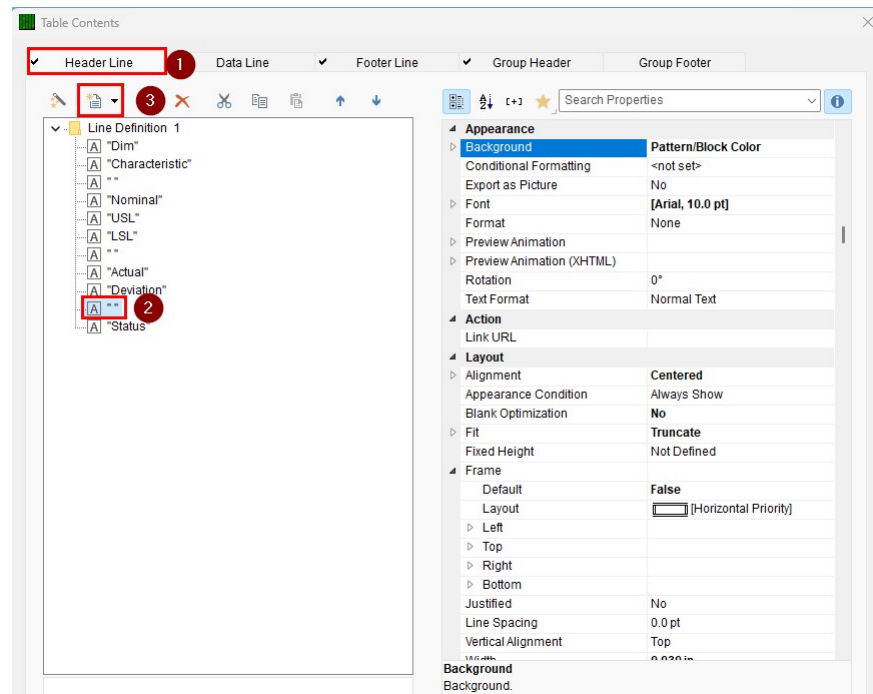
## Reporting – Characteristic Source to First Article

- Click **OK** on the **Edit Table** window, then in the **Table Contents** window highlight the “ ” line on the left, navigate to **Layout** on the right and change the **Width** to “0.650”, then scroll to **Appearance** and change the **Background** to “Transparent.”



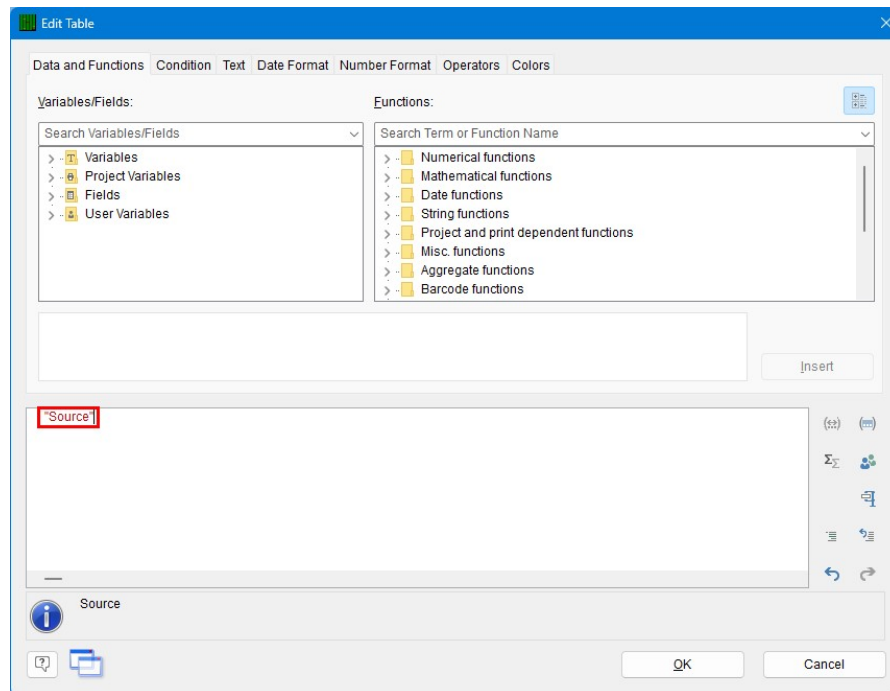
### New Column Header

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

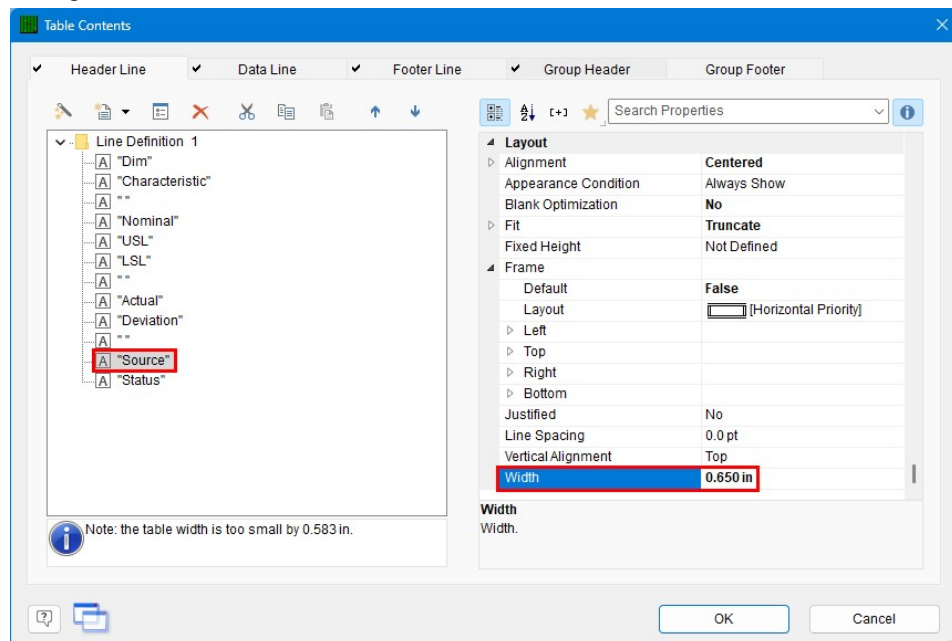


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3. In the **Edit Table** window that appears, enter “Source” (including quotation marks) in the bottom box and click **OK**.



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



## Reporting – Characteristic 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 Characteristic Source field appearing in your report now.

Preview

1 of 100

100%

1:1

First Article Report

November 23, 2023  
14:06:45

Prolink Inc.

Cafe 2 Series - 2001.qcq  
Cafe 2 Series - 2001

Machine 46  
SerialNo 401  
Operator Jerry

Date of Inspection January 24, 2019  
Time of Inspection 02:38:01  
Record Number 401

Dim	Characteristic	Nominal	USL	LSL	Actual	Deviation	Source	Status
1	Handle Top Width	2.0000	2.5000	1.5000	2.1400	0.1400	Calypso	*
2	Handle Bottom Width	2.0000	2.5000	1.5000	1.8117	-0.1883	Calypso	*
3	Door Thickness	2.0000	2.5000	1.5000	2.0413	0.0413	Calypso	*
4	Freezer LH Roller Depth	7.0000	7.5000	6.5000	7.0615	0.0615	Calypso	*
5	Freezer RH Roller Depth	7.0000	7.5000	6.5000	7.1313	0.1313	Calypso	*
6	Freezer LH Track Height	1.5000	2.0000	1.0000	1.3827	-0.1173	Calypso	*
7	Freezer RH Track Height	1.5000	2.0000	1.0000	1.4895	-0.0105	Calypso	*
8	Ice Tube Hole Dia	0.7500	1.0000	0.5000	0.7834	0.0334	VICIVision	*