

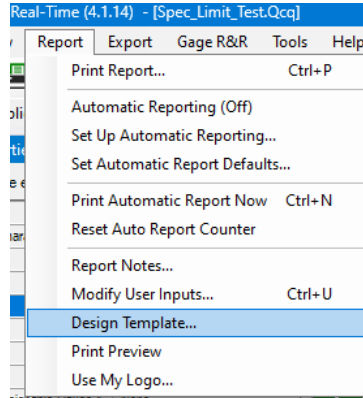
# Reporting – % Out of Spec for Sigma column

The Stat Summary report that comes with QC-CALC only displays columns for some statistical values, but there are other values available to be displayed. This White Paper will give step by step instructions for customizing the default template and changing the “Sigma” column to show the “Percent Out of Spec” instead.

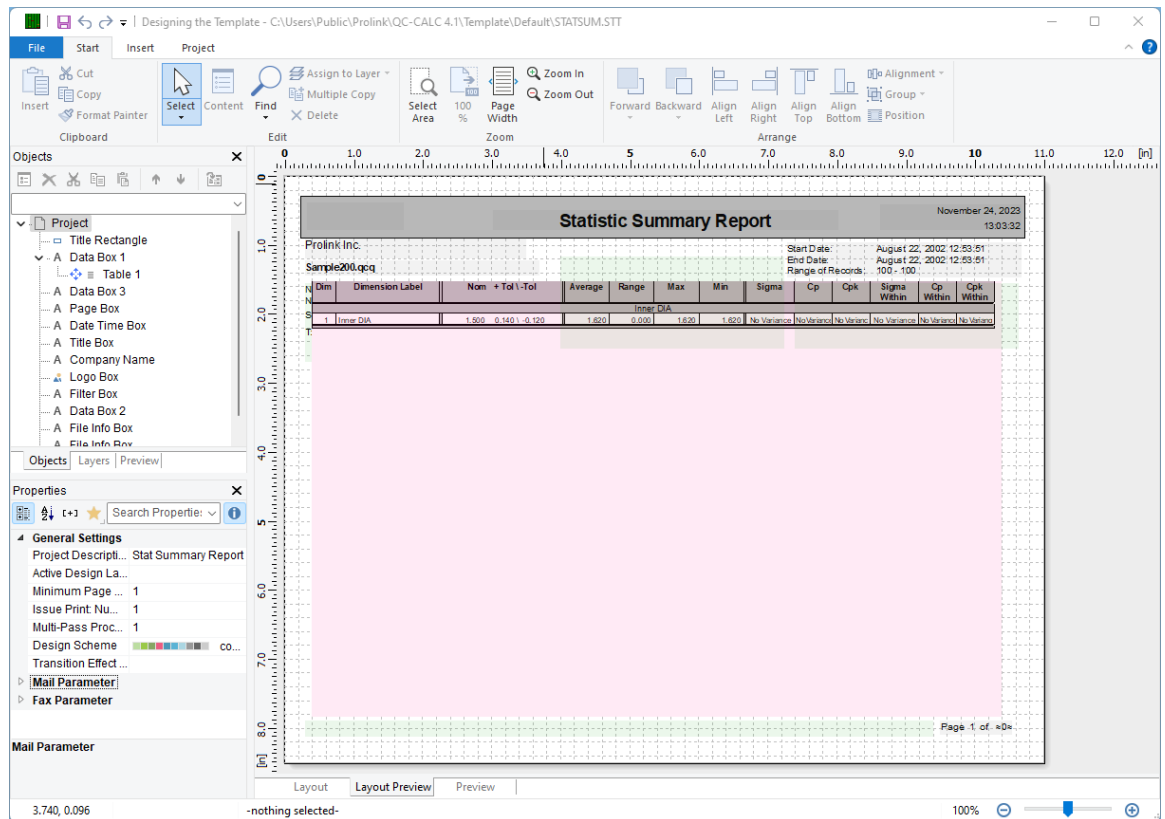
## The Report Designer

The directions shown here will change the “Sigma” column to “Percent OOS” instead. This is a lengthy process, but relatively simple to accomplish.

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



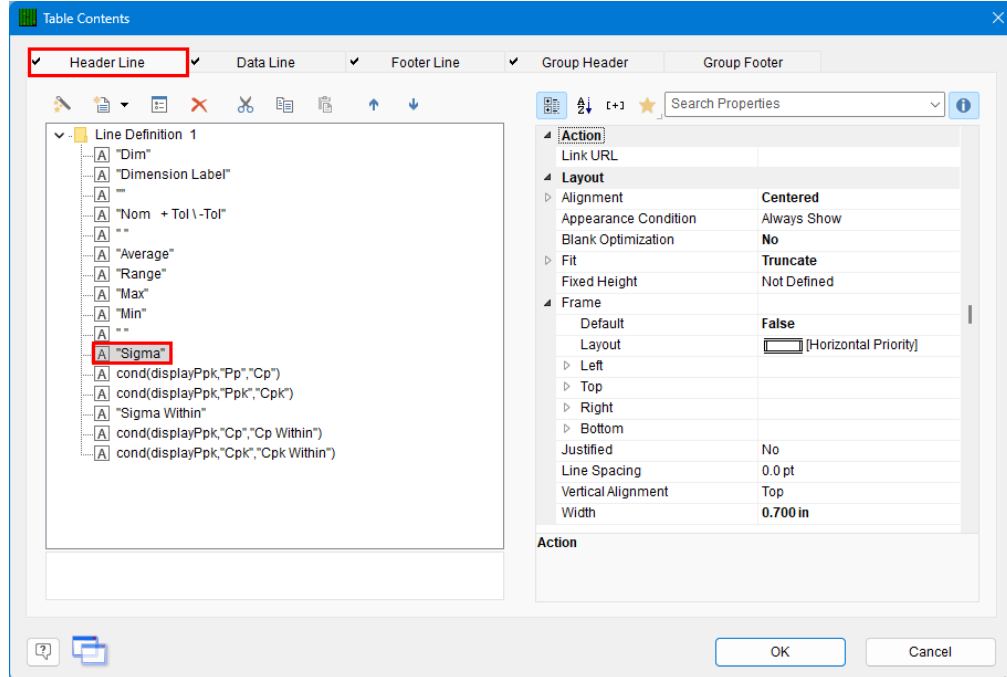
2. Choose the StatSum.STT template from the list of files that appears and click **Open**. The Report Designer now appears on the screen.



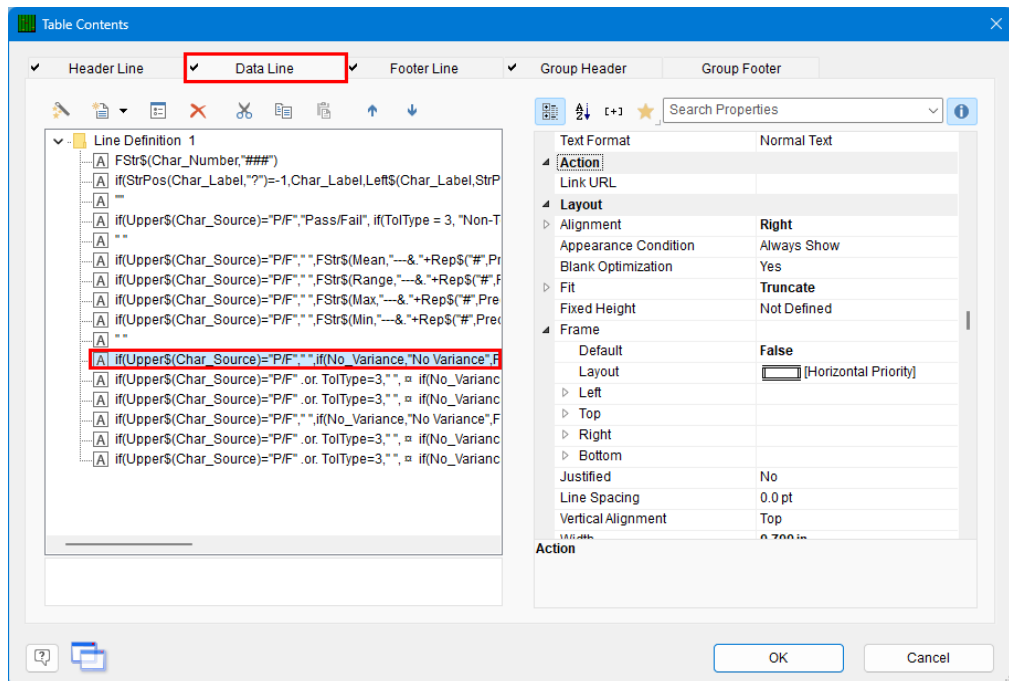
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## Header Lines

1. Double click on the table and the **Table Contents** window will appear.



2. On the **Header Line** tab, choose the “Sigma” line on the left and click the F2 button to edit that value. Enter “Percent OOS” as the new column heading value and click Enter.
3. Now that you’ve fixed the column heading, let’s change the values that will be displayed below the heading. On the **Data Line** tab choose the same line you choose on the **Header Line** tab. It is hard to read the contents of the lines, so counting the number of lines is easier.

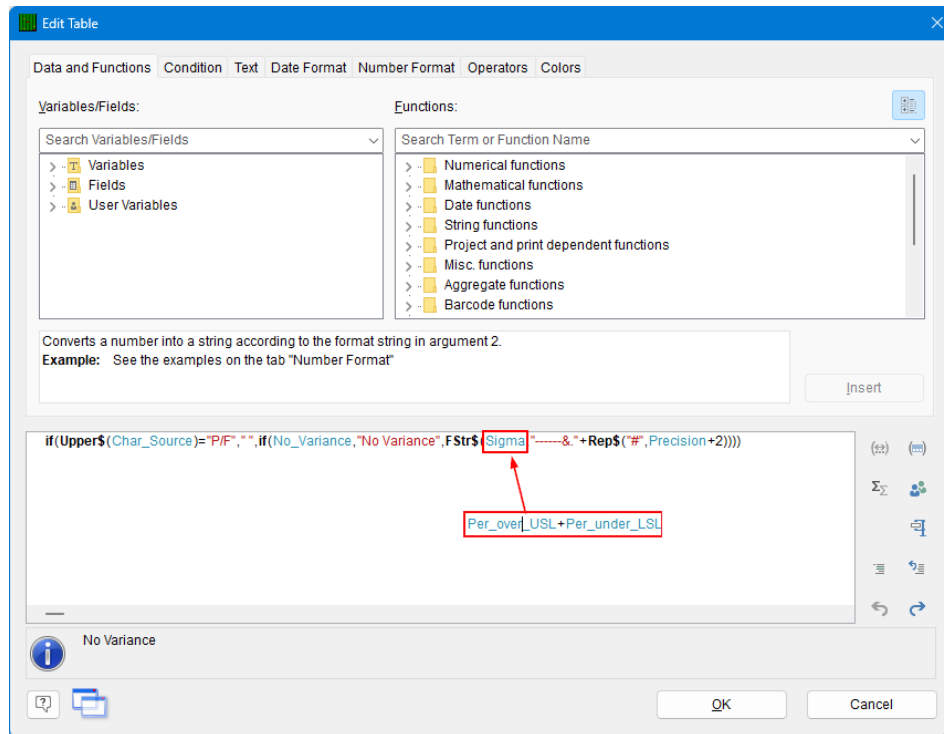


4. Double-click that line and the **Edit Table** screen appears.

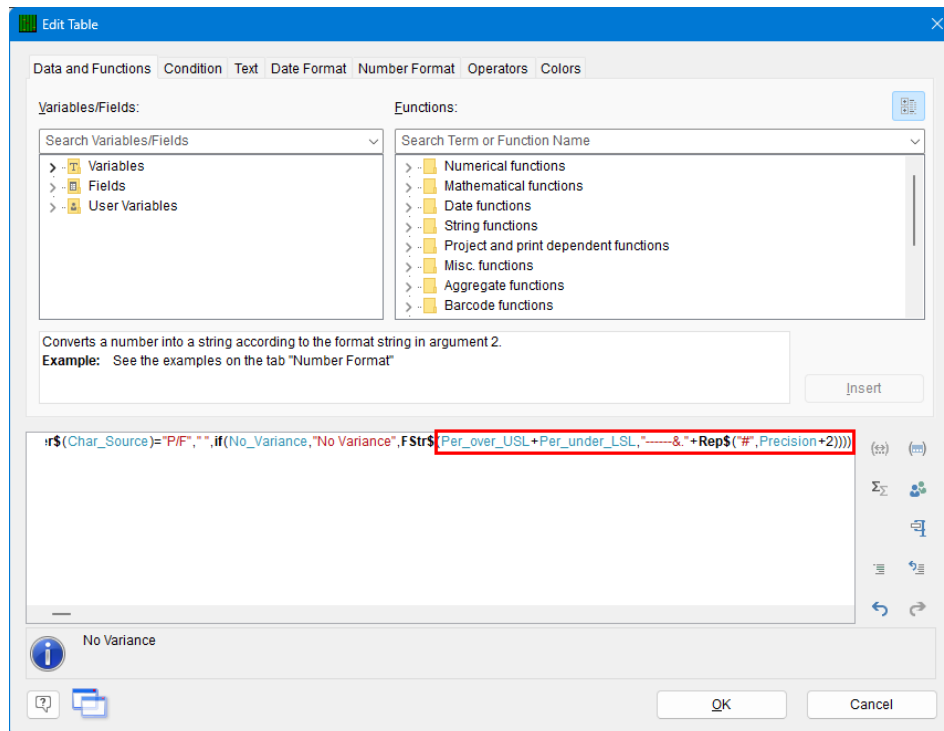
## Reporting – % Out of Spec for Sigma column

5. In the **Edit Table** screen the line showing at the bottom of the screen has a value that needs to be changed. The Sigma shown in the picture below needs to change to:

Per\_over\_USL+Per\_under\_LSL

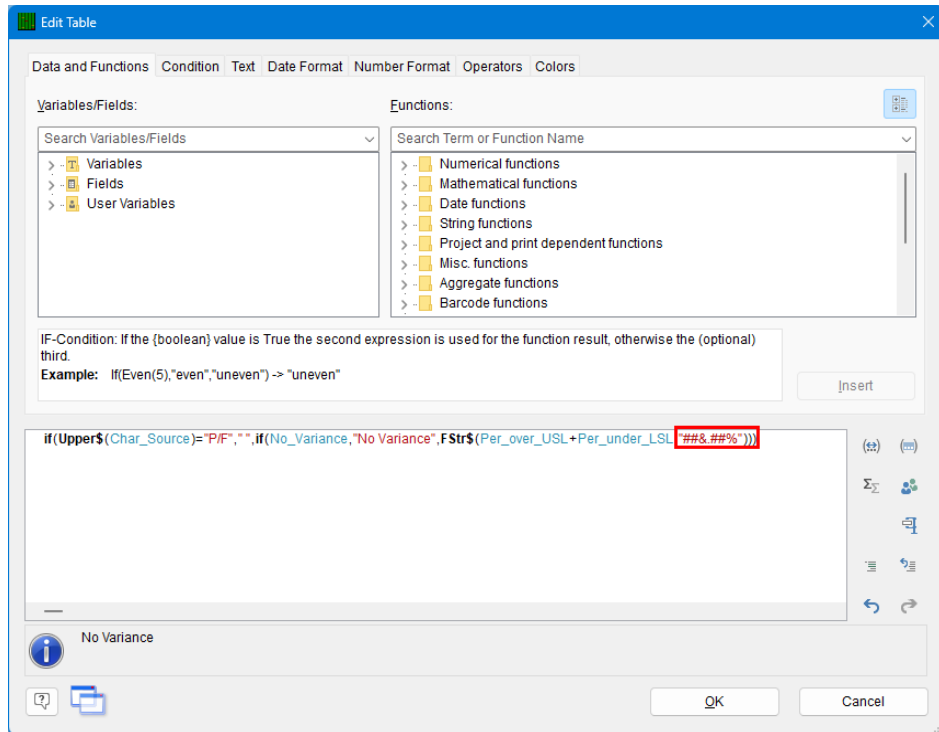


6. Now that the value being used is what you want, you need to fix the formatting (since a percentage is displayed differently than a Sigma value).



## Reporting – % Out of Spec for Sigma column

- To fix the formatting the "-----&."+Rep\$("","#",Precision+2) section of the line needs to be changed. Enter "##&.##%" in place of the text above (make sure you remove the ") at the end too) to allow 3 places to the left of the decimal and 2 to the right followed by a % sign.



- When you've finished the area in the **Edit Table** screen that shows "No Variance" in the picture above should NOT show an error. If it does, make sure you have 3 ")" at the end of the line as that is the most common issue.
- Click the **OK** button on both the **Edit Table** and **Table Contents** windows and save your changes to the template.
- When you run your report you will now have a column called "Percent OOS" that shows the percentage of points that were out of spec for each dimension.