

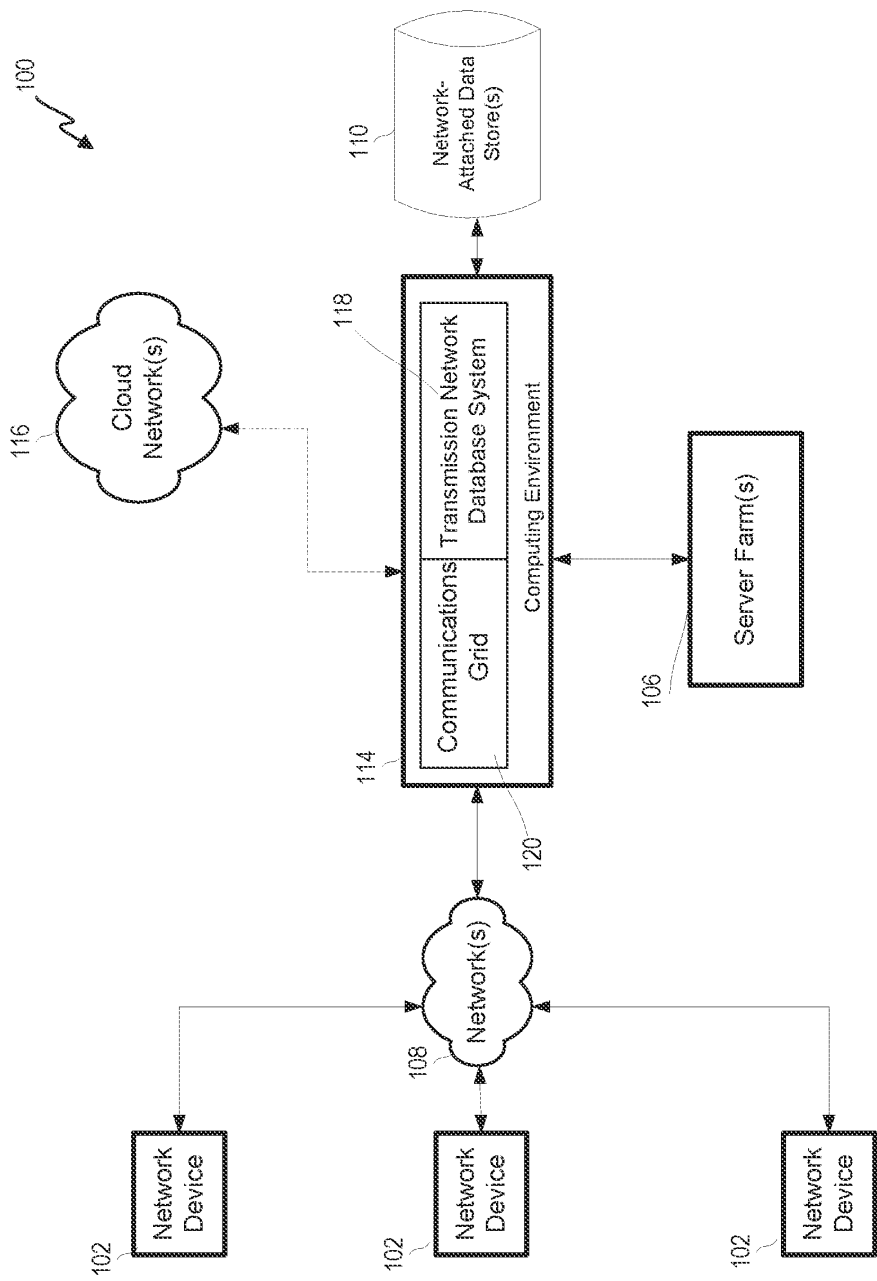


FIG. 1

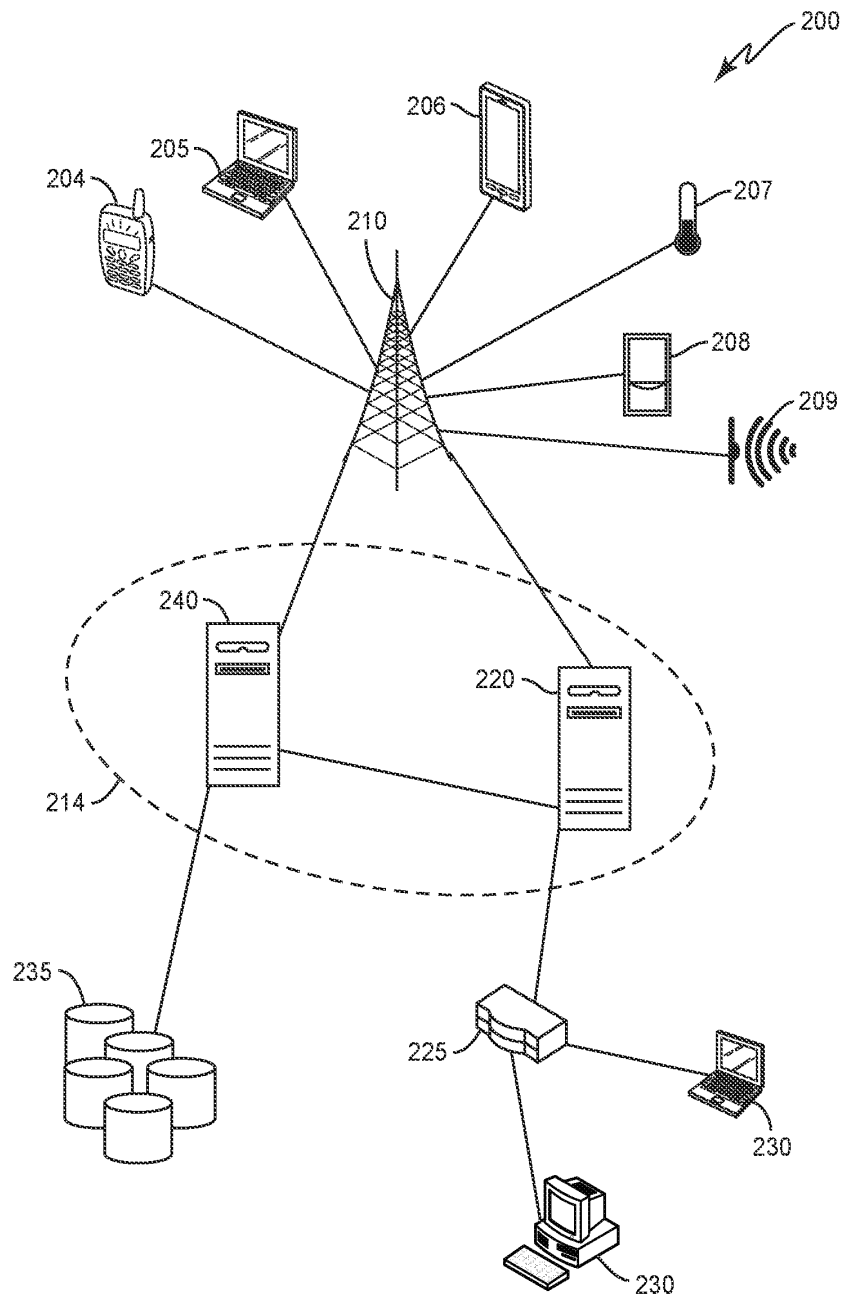


FIG. 2

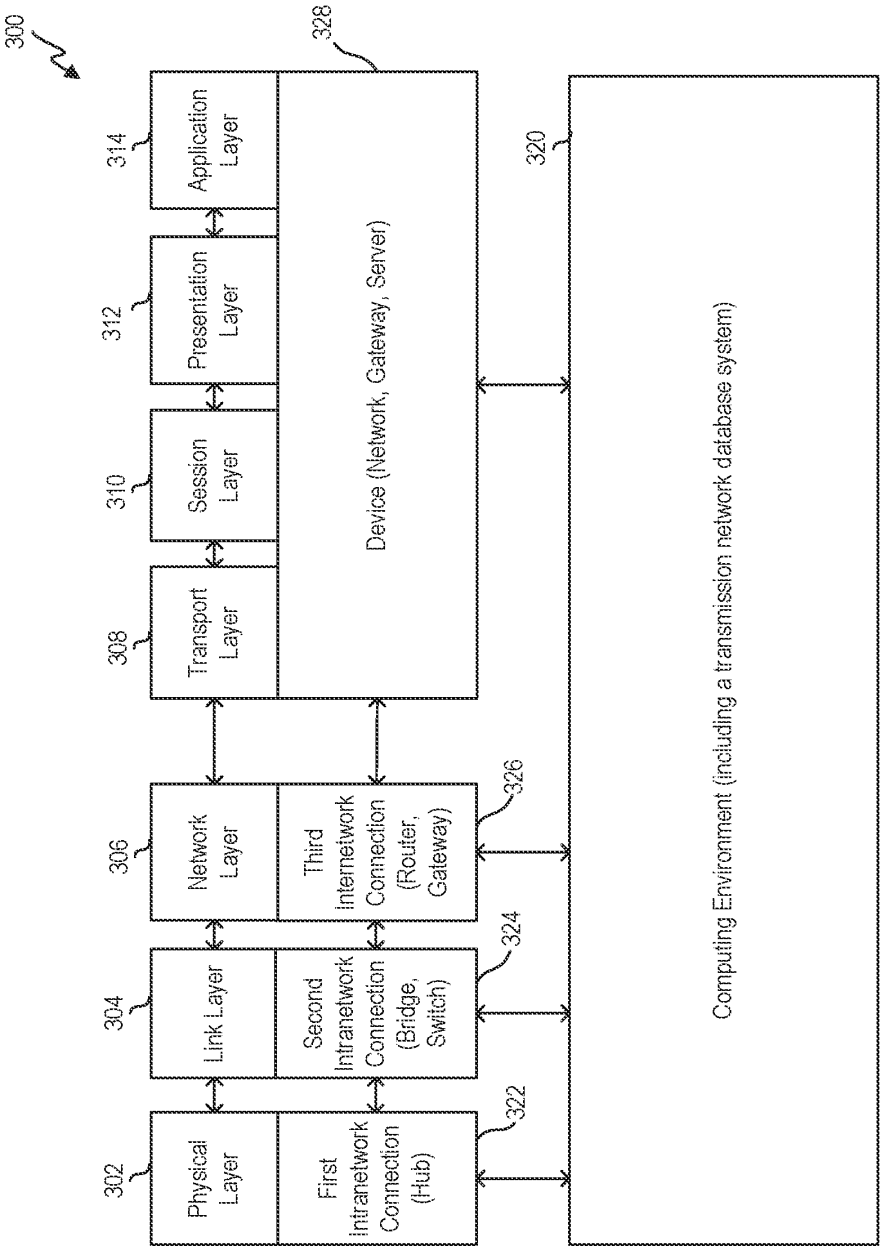


FIG. 3

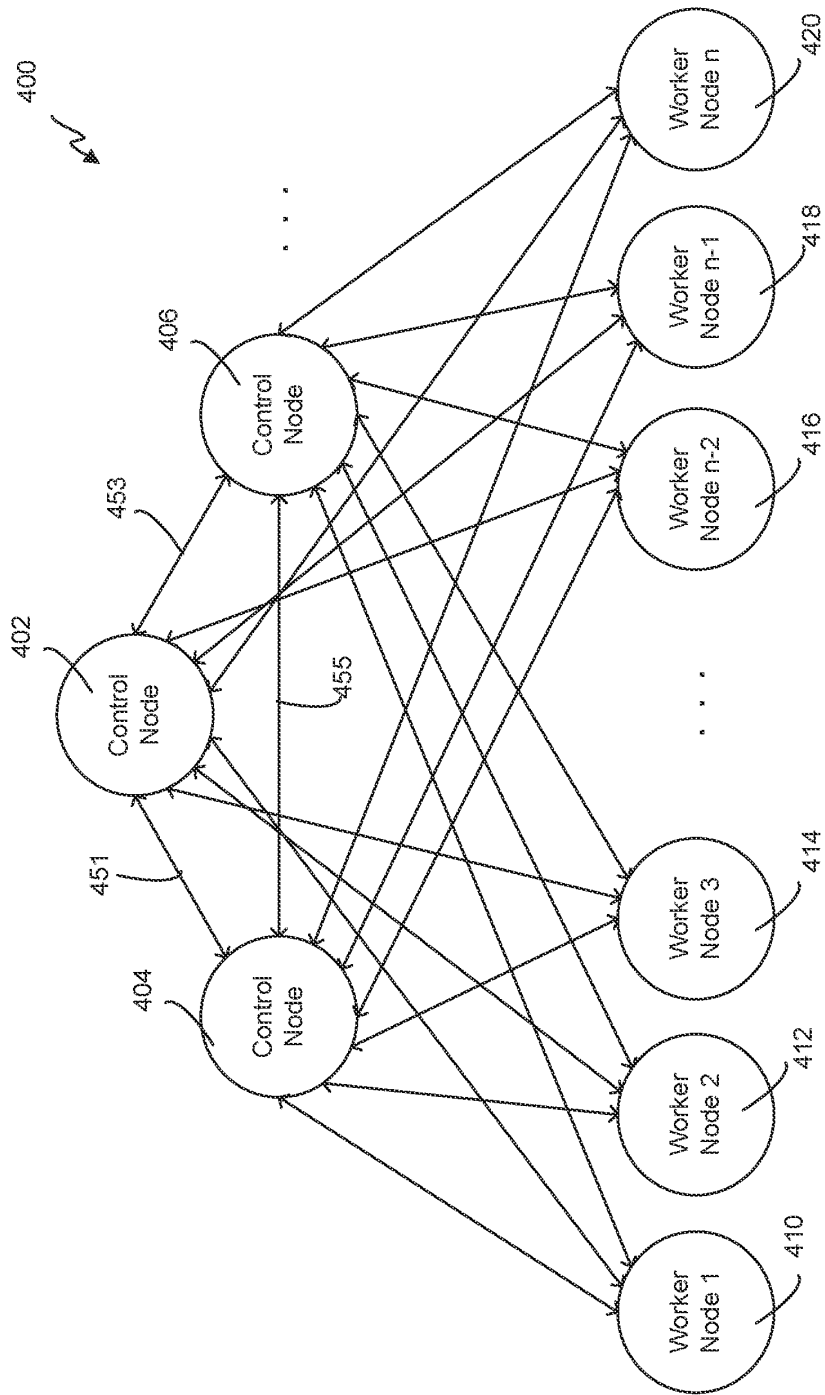
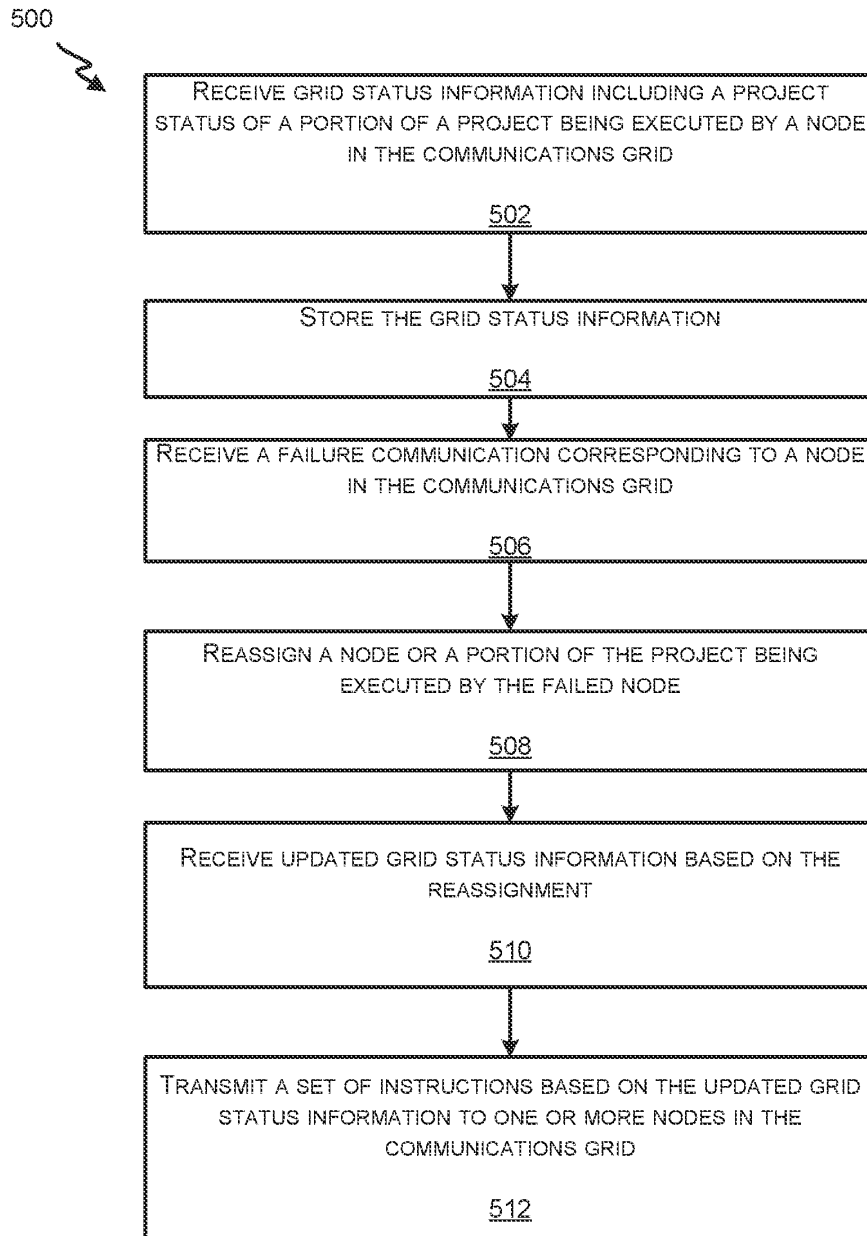


FIG. 4

**FIG. 5**

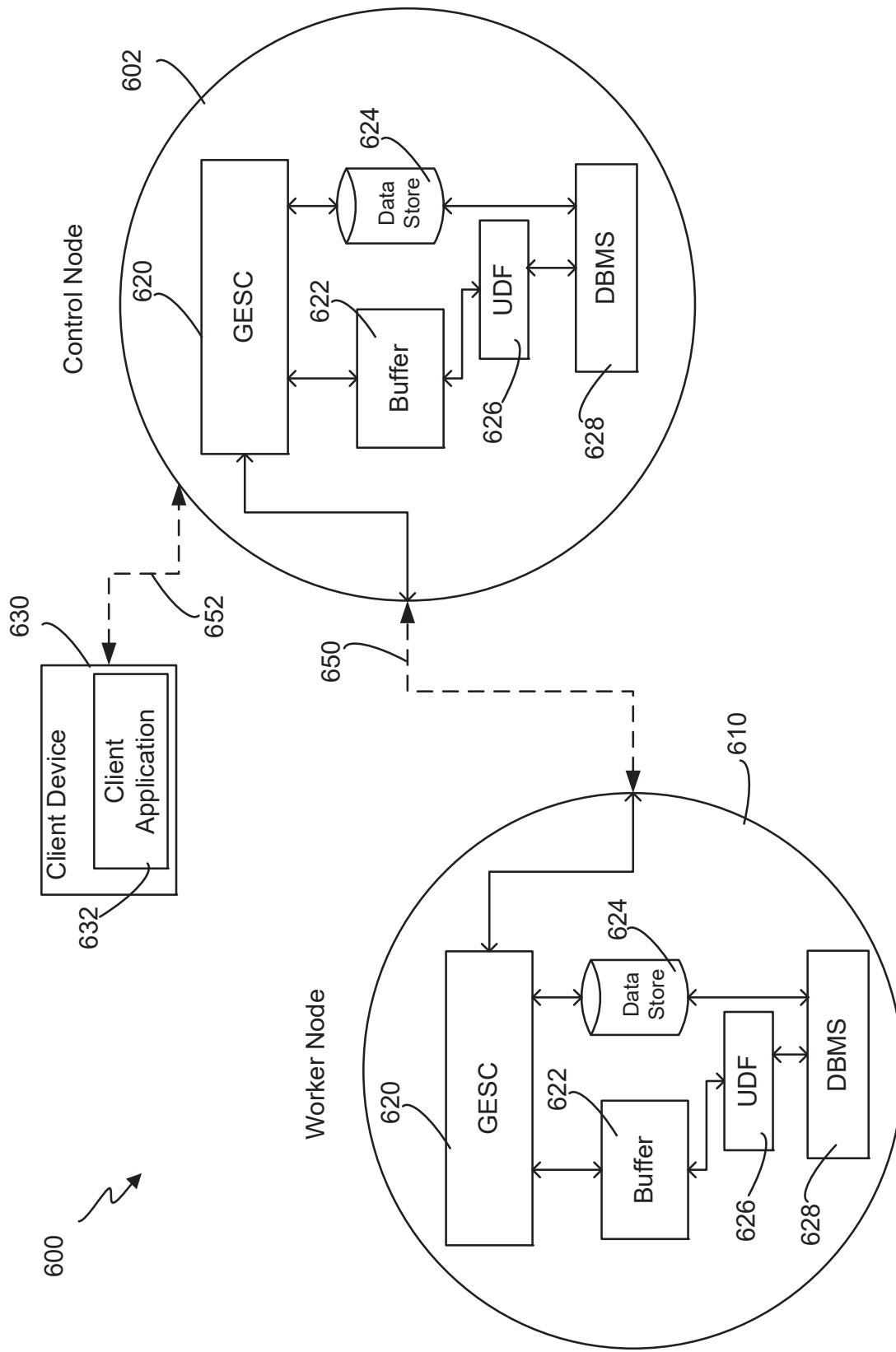


FIG. 6

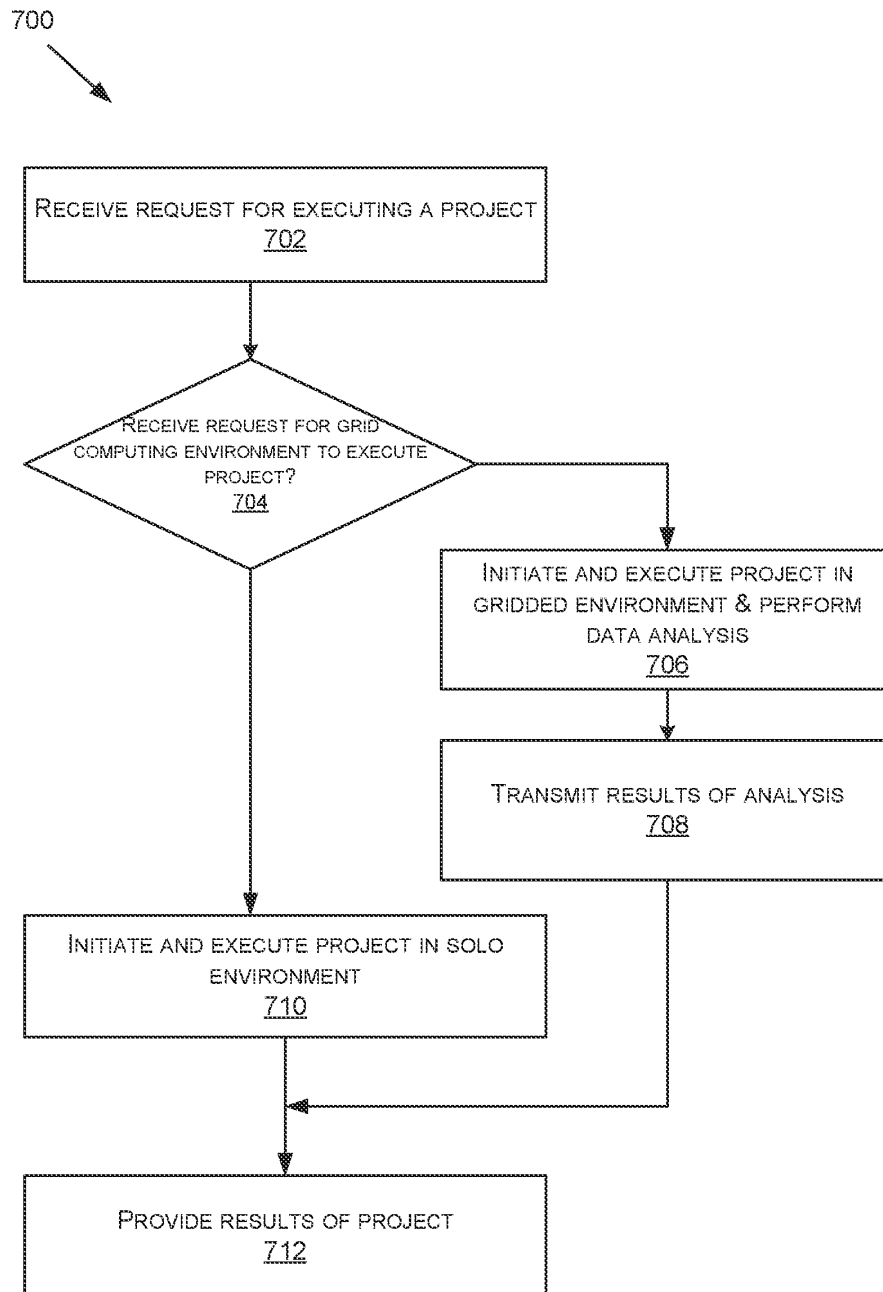


FIG. 7

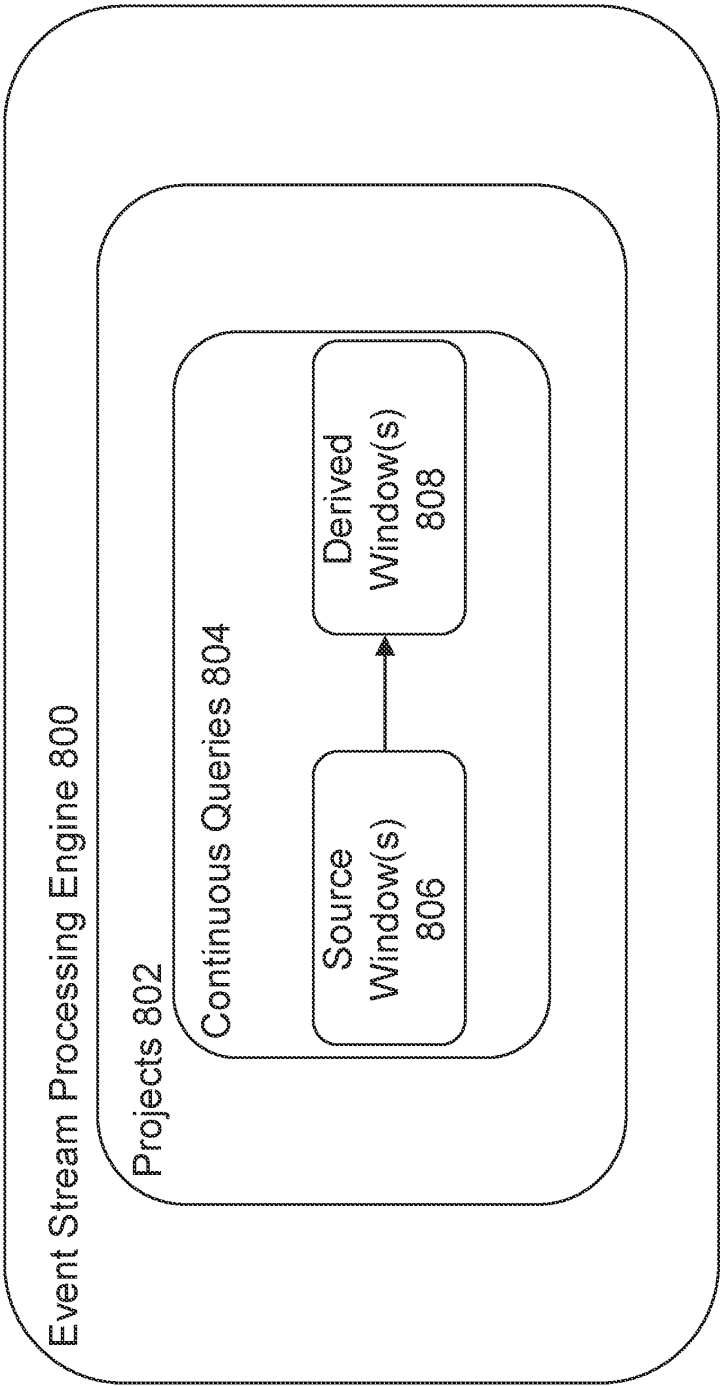


FIG. 8

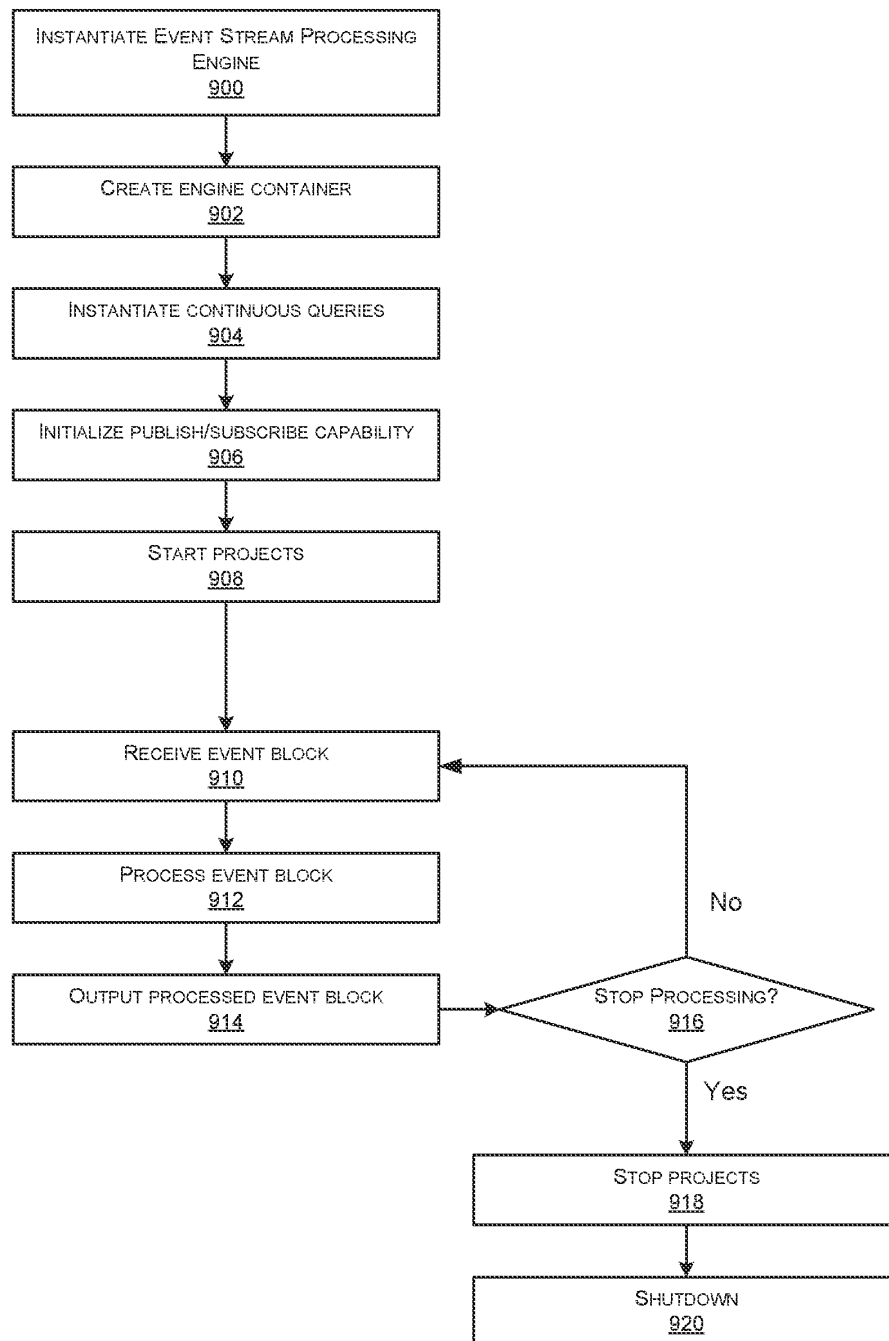


FIG.9

1000 ↗

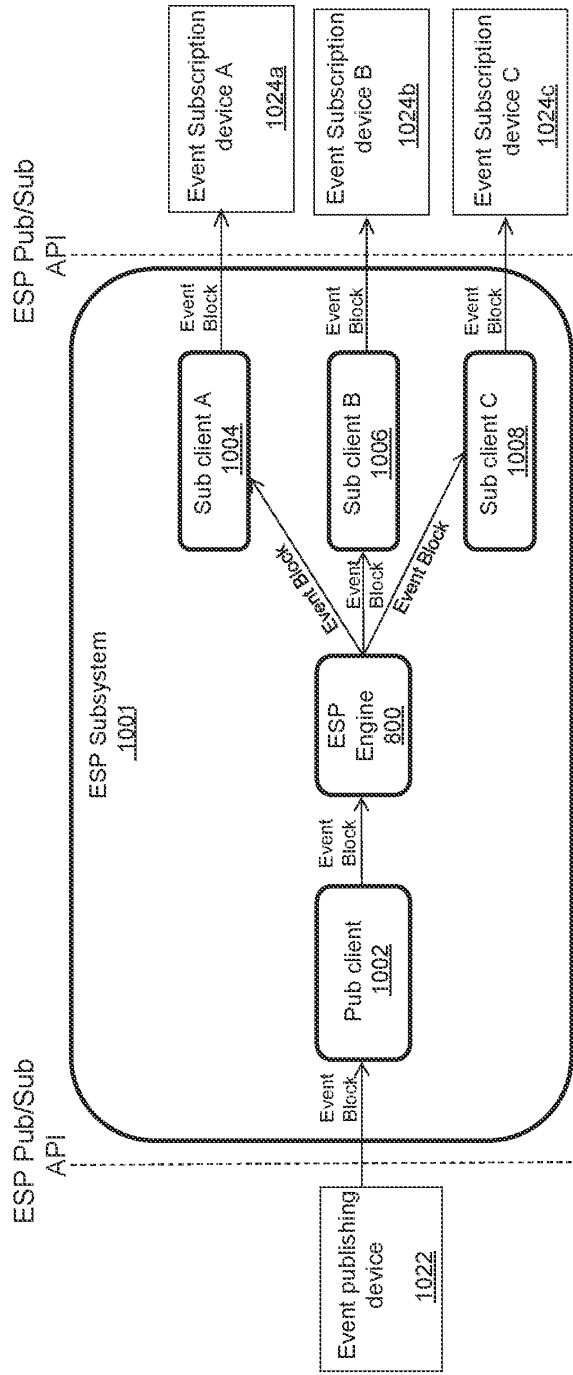


FIG. 10

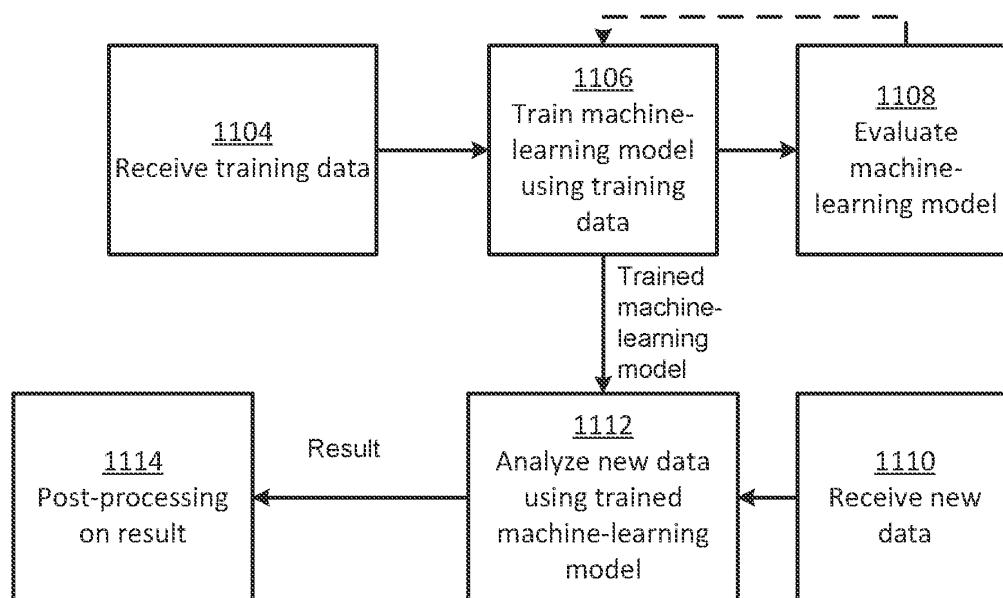


FIG. 11

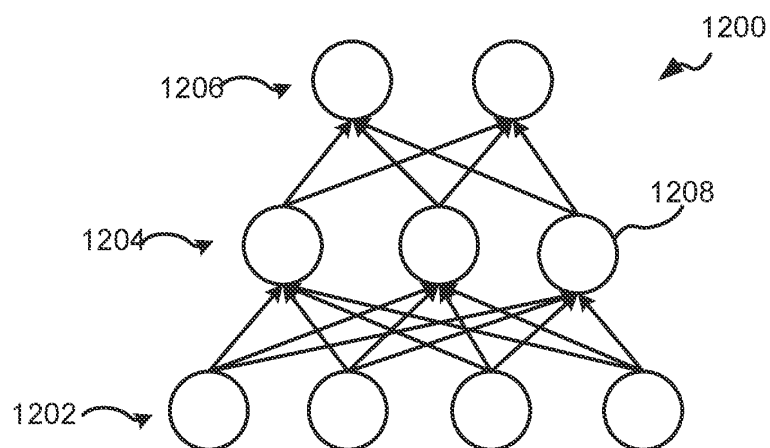
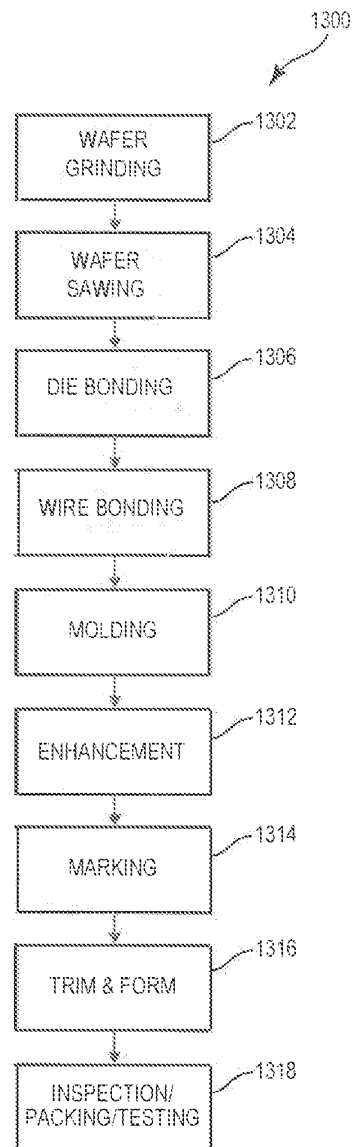


FIG. 12

**FIG. 13**

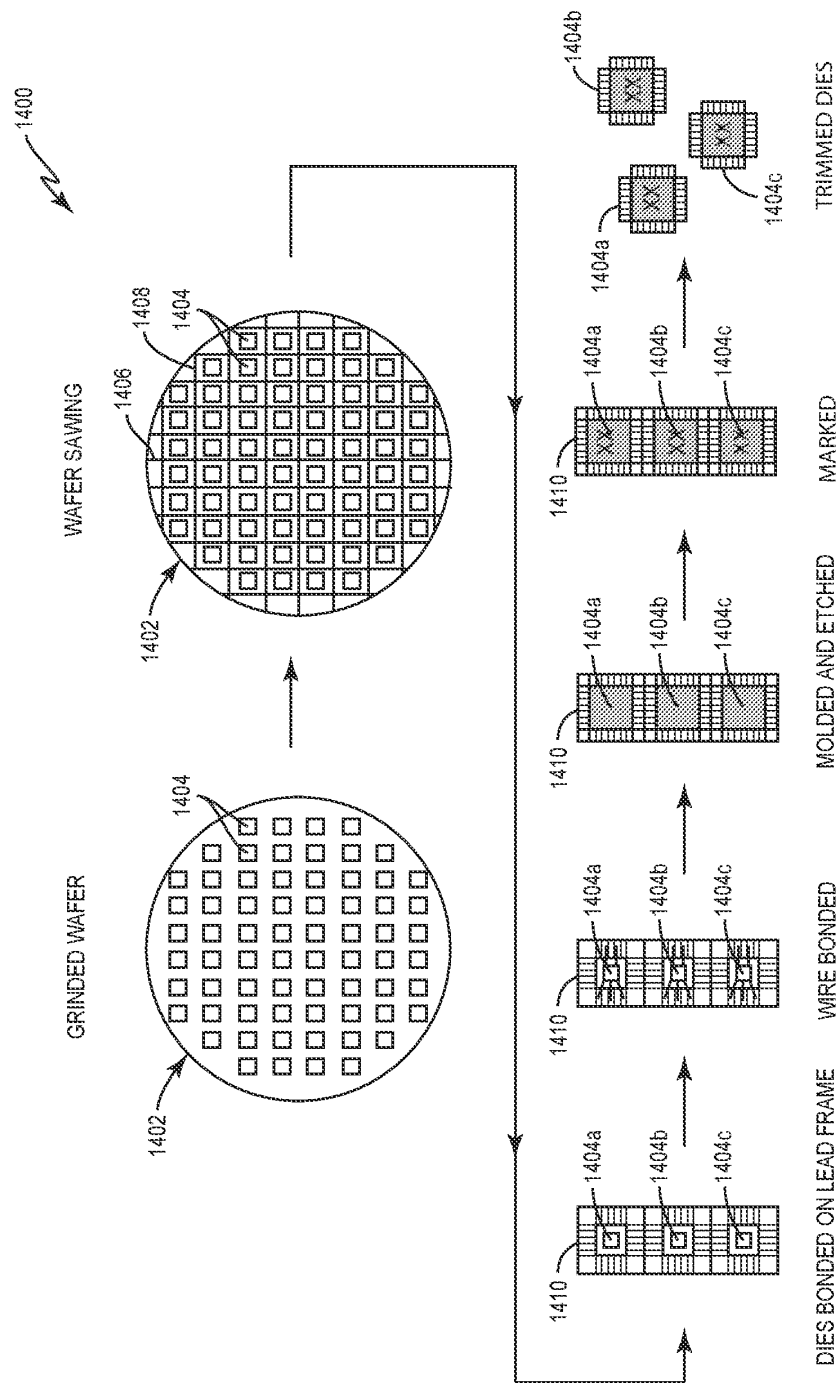


FIG. 14

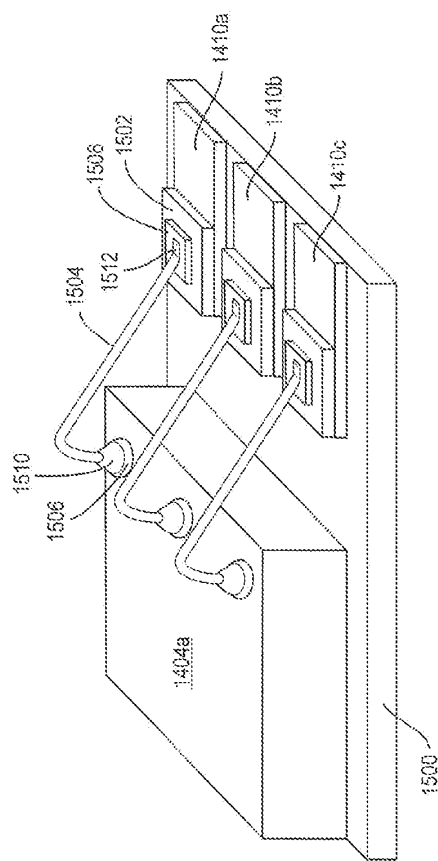


FIG. 15A

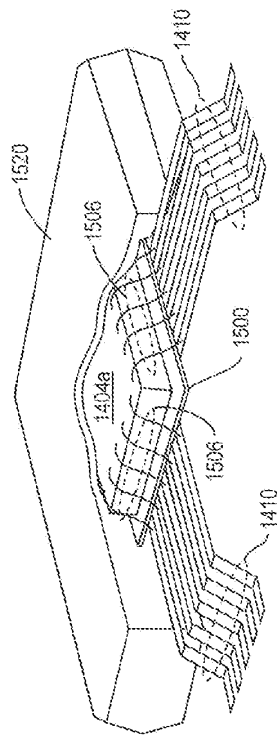
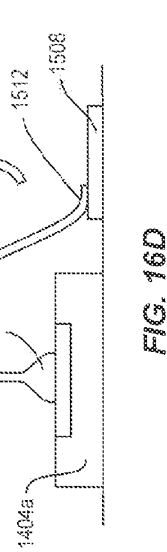
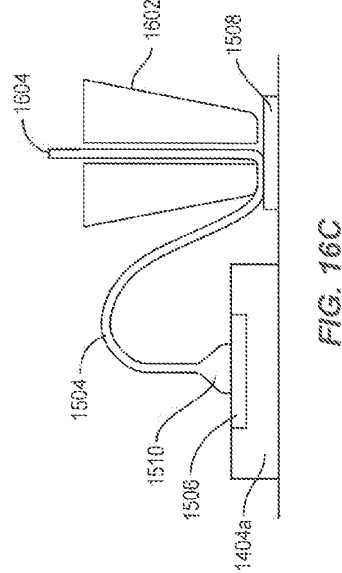
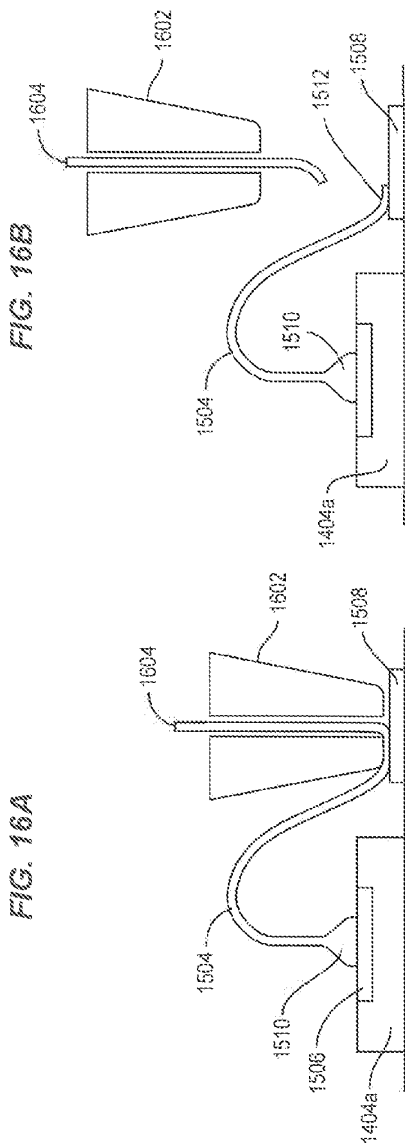
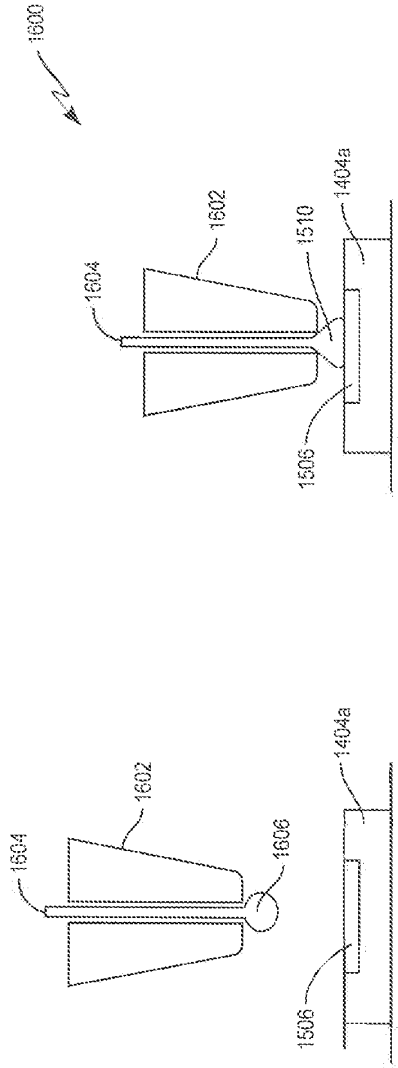


FIG. 15B



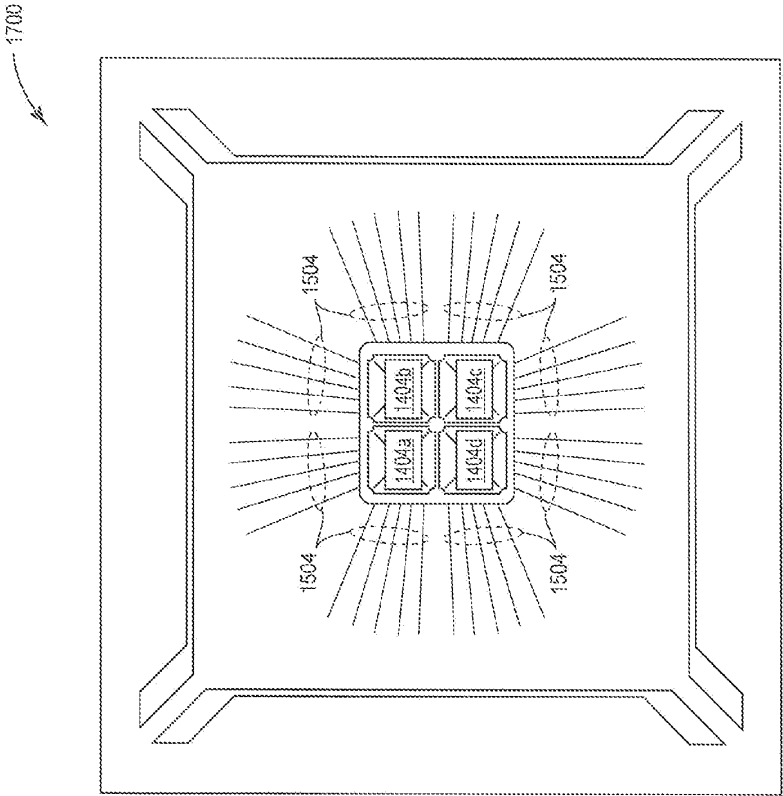


FIG. 17

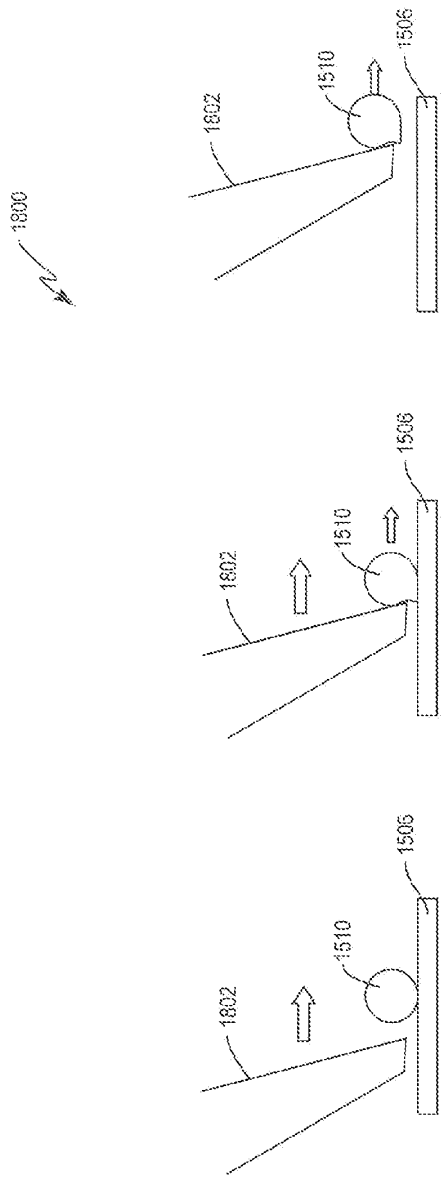
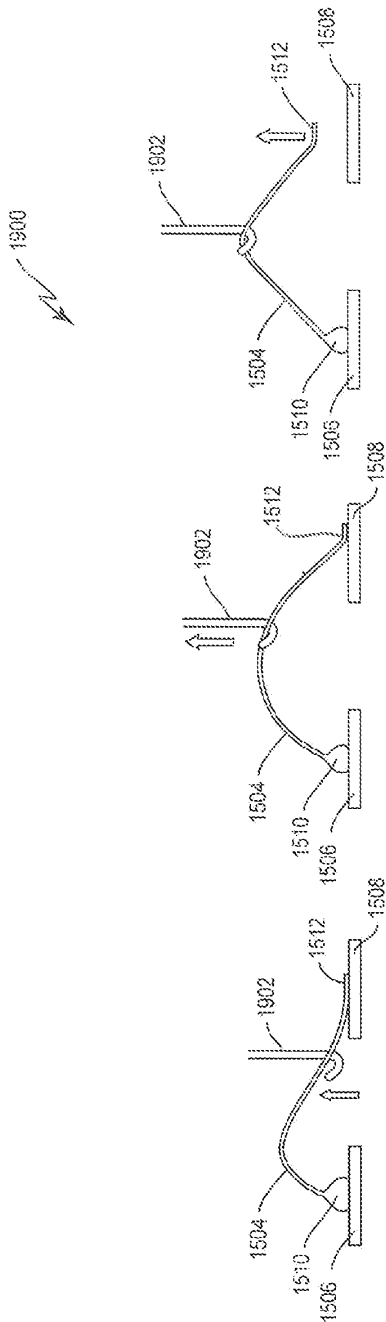


FIG. 18C

FIG. 18B

FIG. 18A



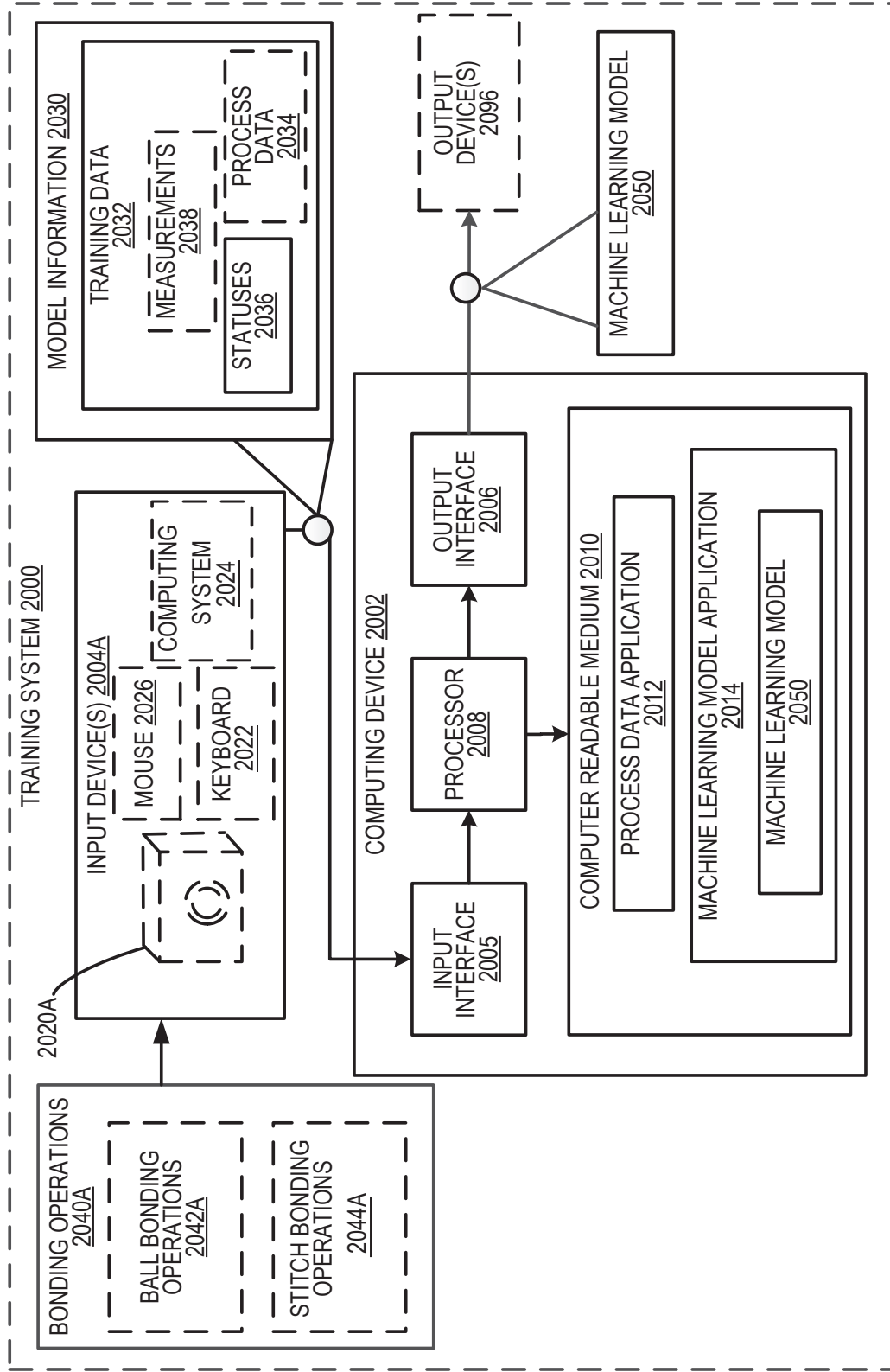


FIG. 20A

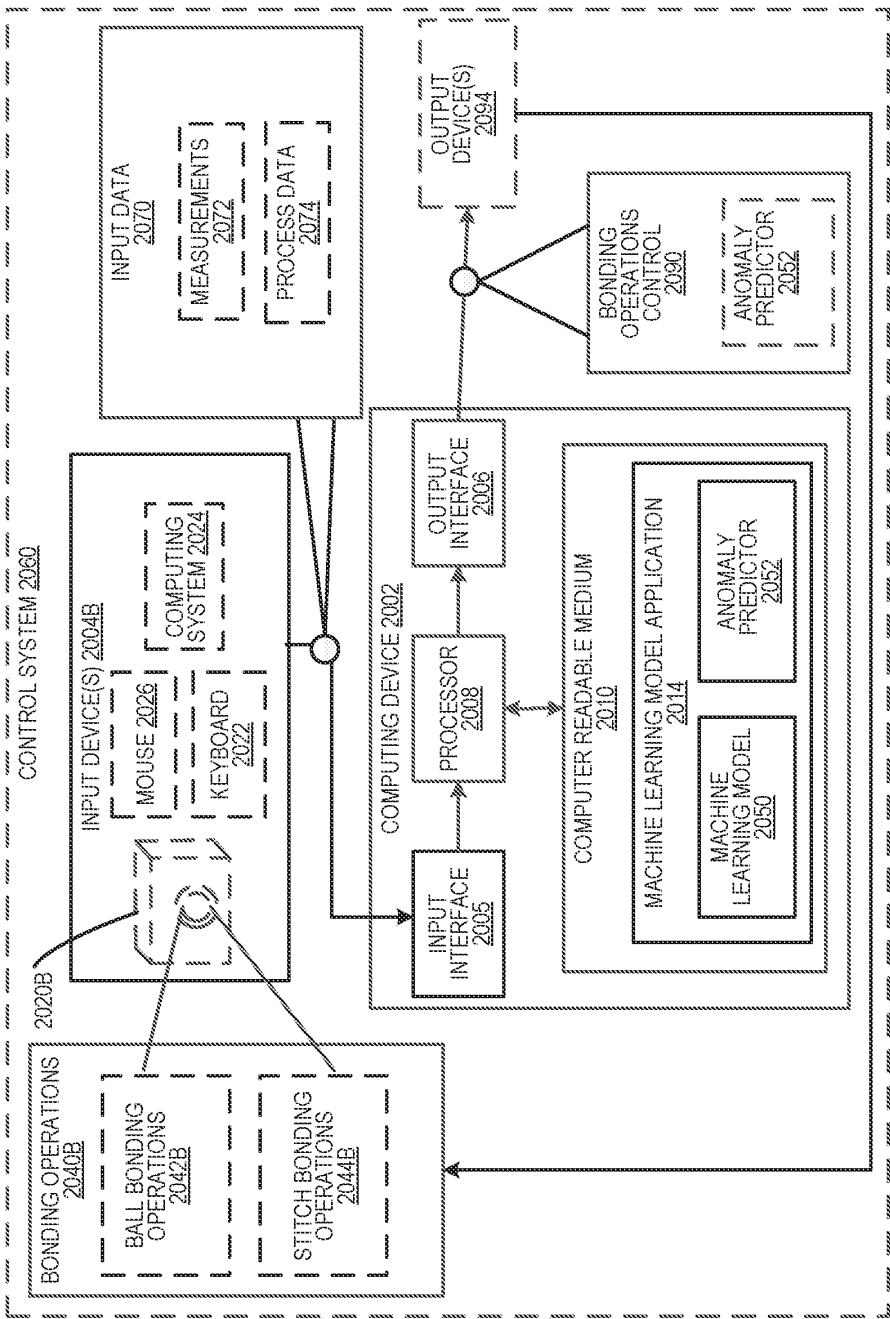
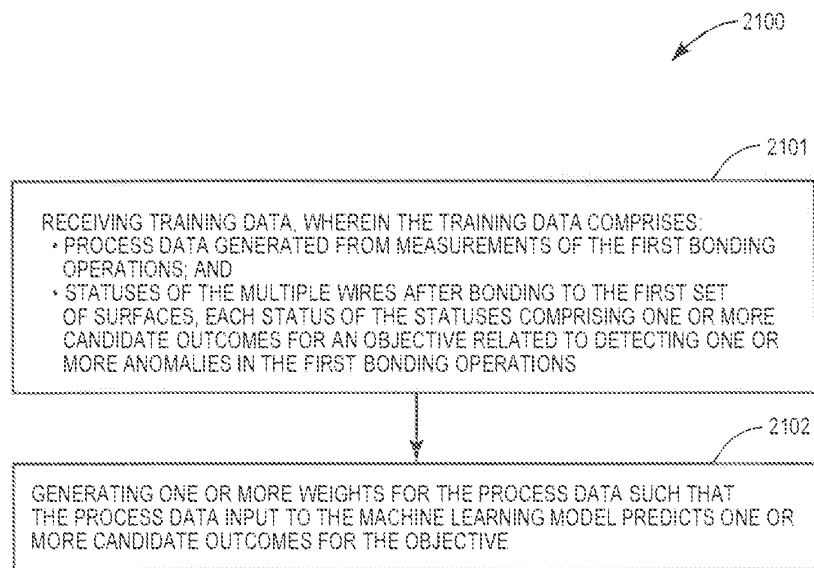


FIG. 20B

**FIG. 21A**

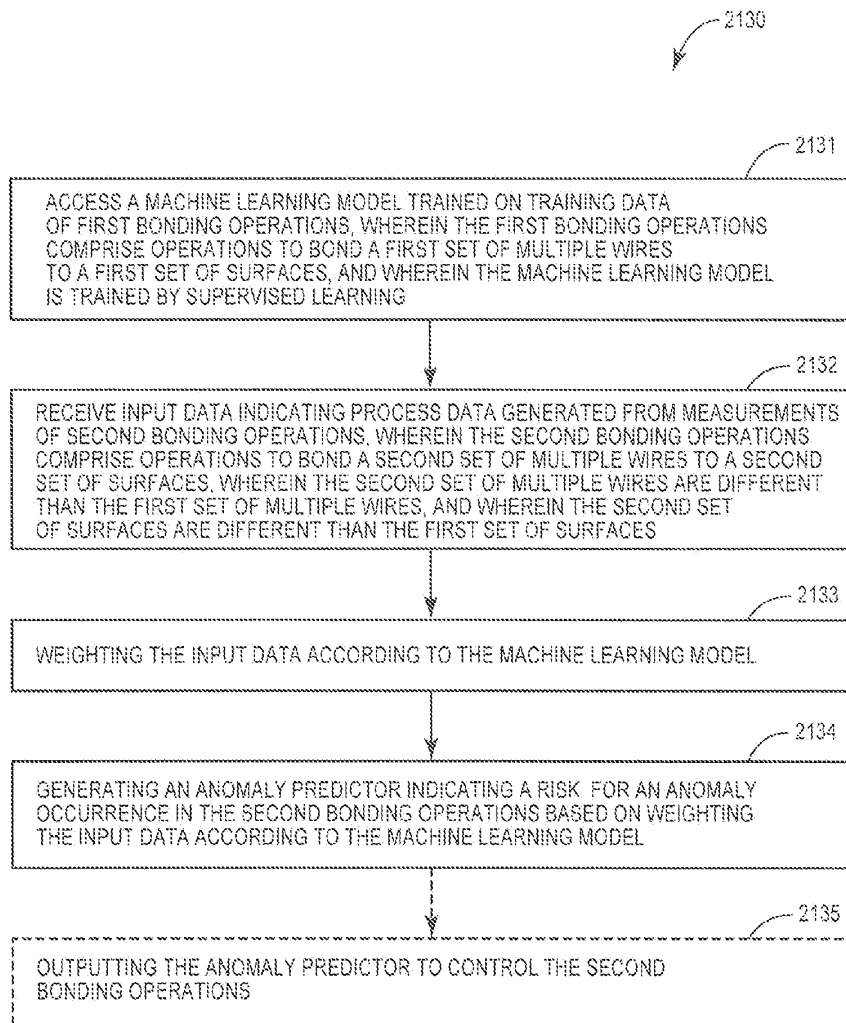
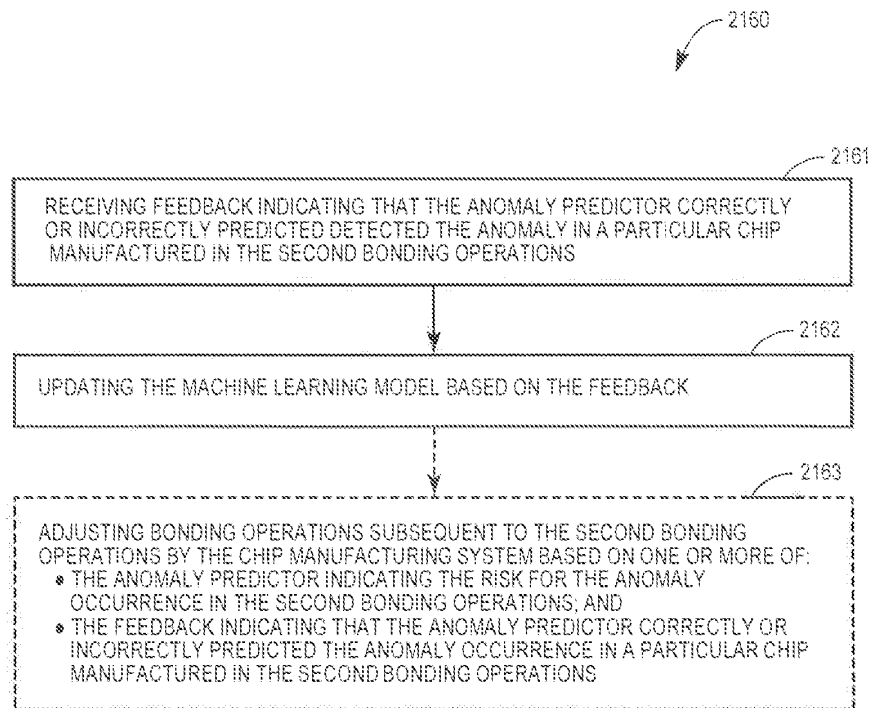


FIG. 21B

**FIG. 21C**

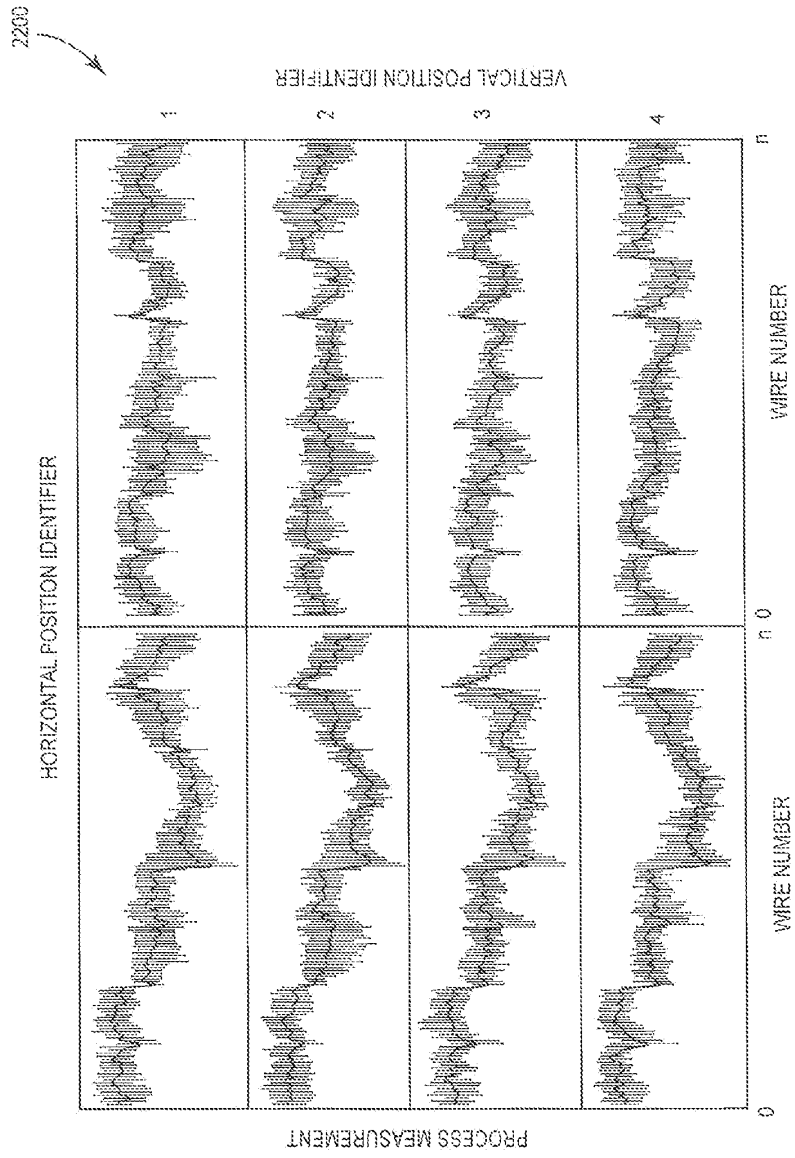


FIG. 22A

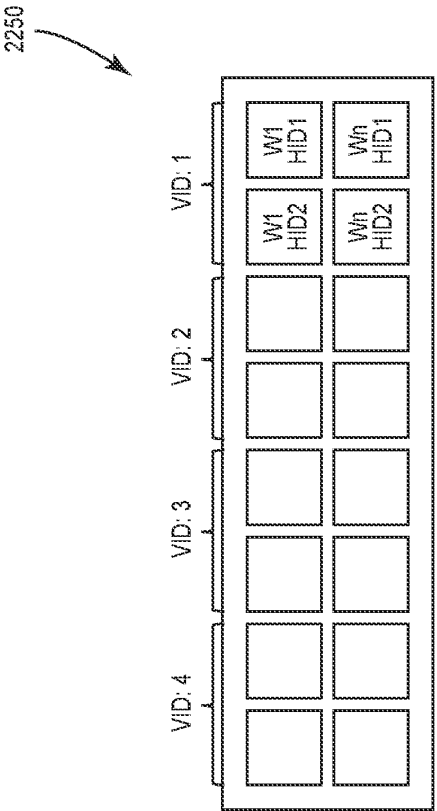


FIG. 22B

2301	2302	2303	2300
MODEL TARGET VARIABLE (QA VALUE)	TRAINING DATA	TEST DATA	
BALL SHEAR	49,114	12,280	
STITCH PULL	48,765	12,193	

FIG. 23A

2351		2352	2353	2354	2355	2350
WIRE NUMBER		HID NUMBER	MEDIAN VALUE (NORMAL)	DELTA VALUE (NORMAL)	DELTA VALUE ABNORMAL	
1		1	11.82	0.08	0.2	
1		2	11.70	-0.09	0.12	
2		1	11.92	-0.05	0.2	
2		2	11.88	0.03	-0.1	
...		...	...			
N		1	12.20	0.20	1.2	
N		2	12.28	-0.16	1.09	

FIG. 23B

2400

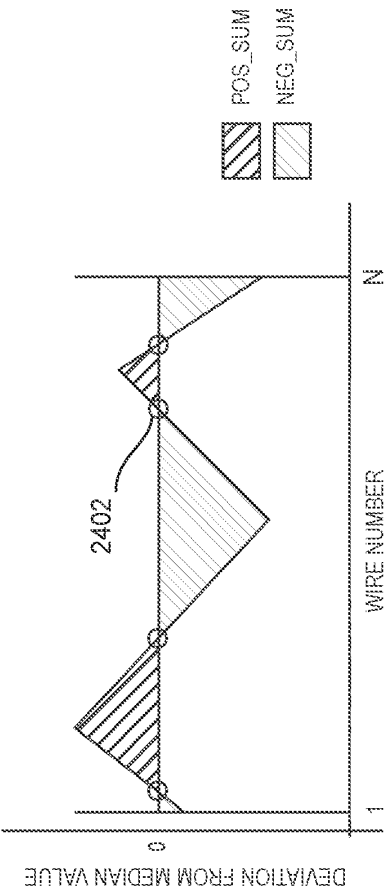
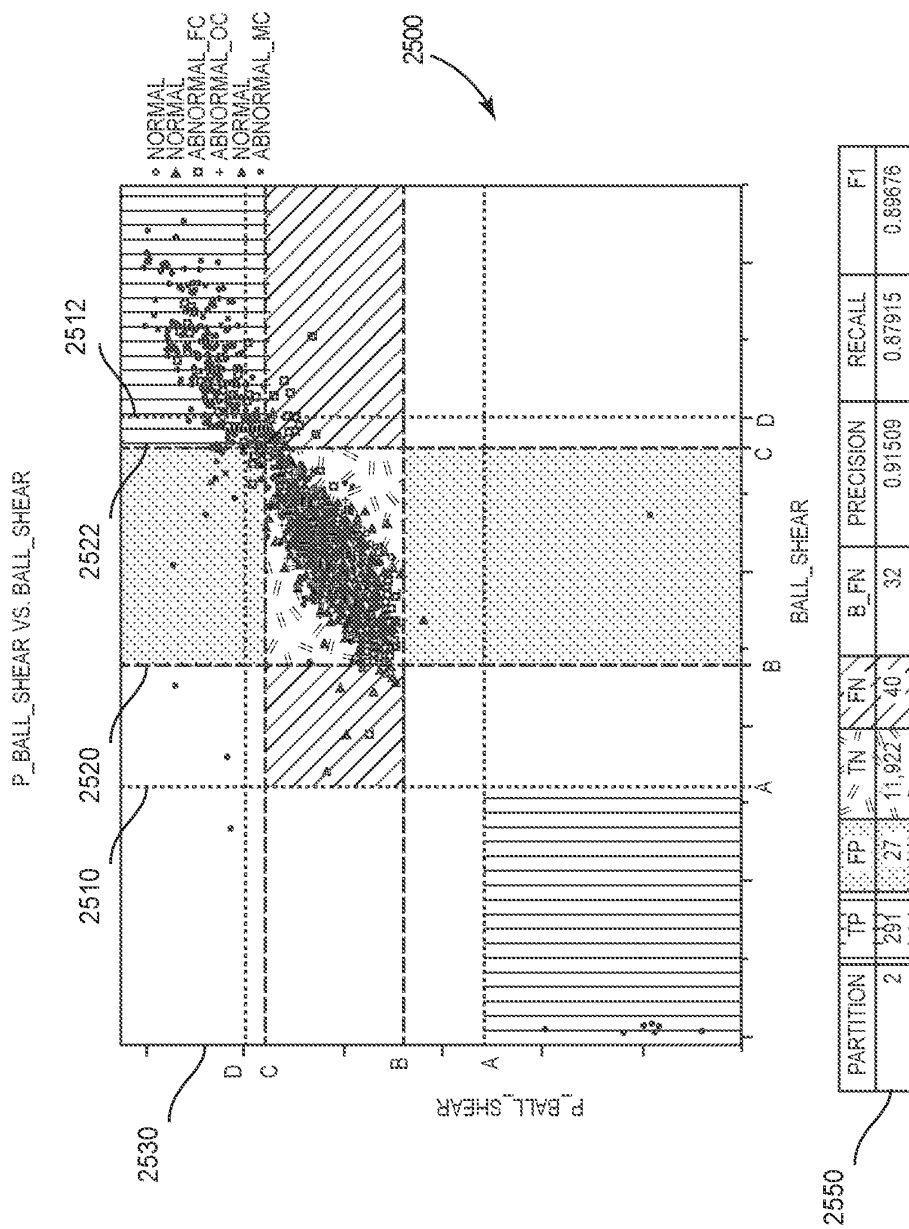


FIG. 24



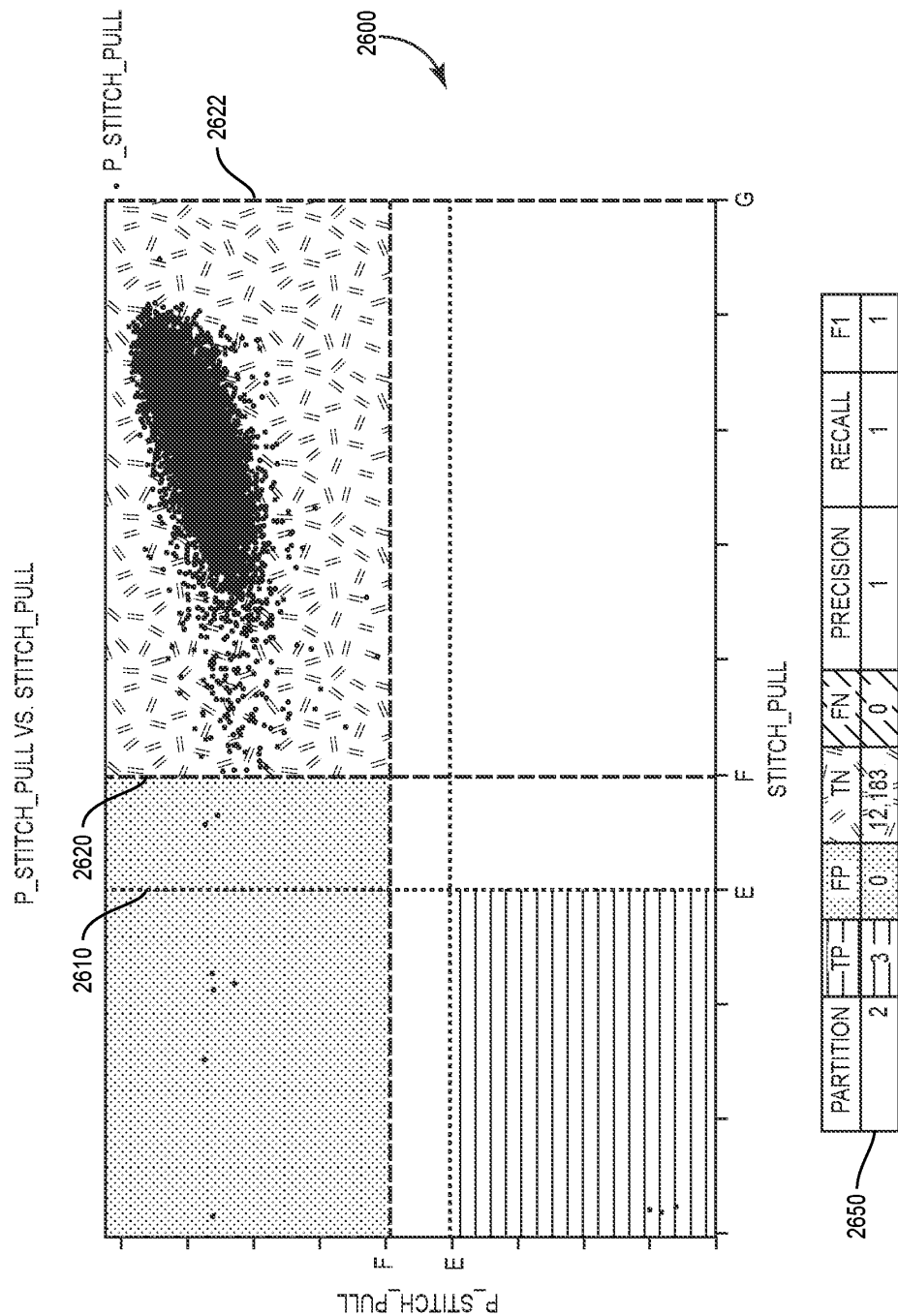


FIG. 26

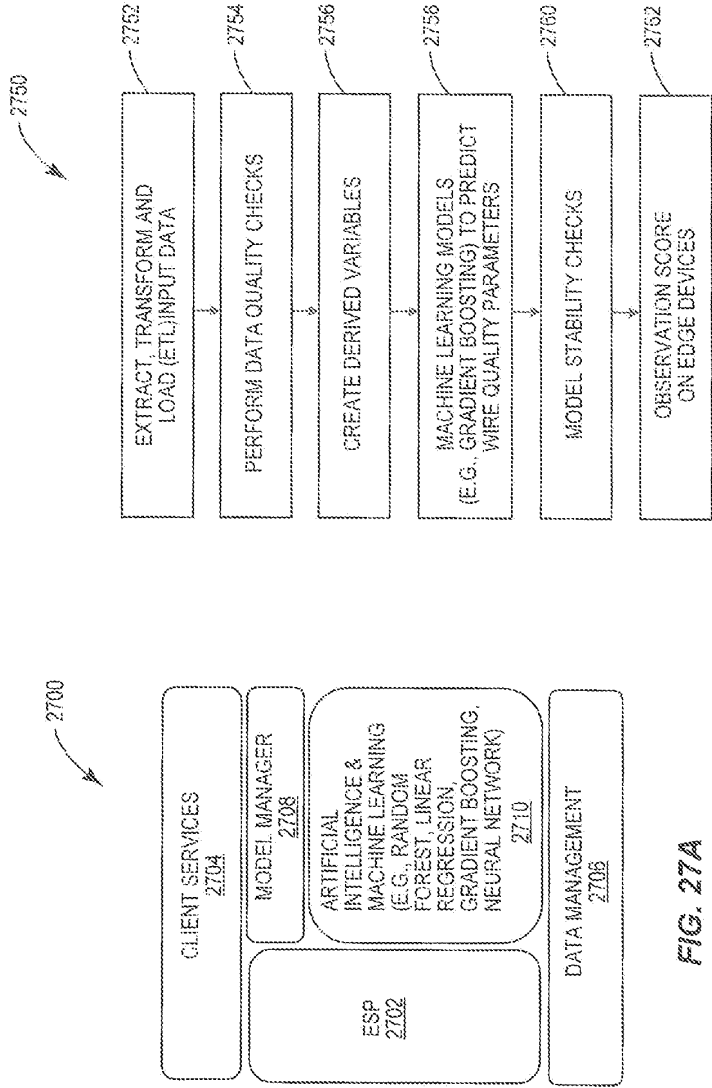
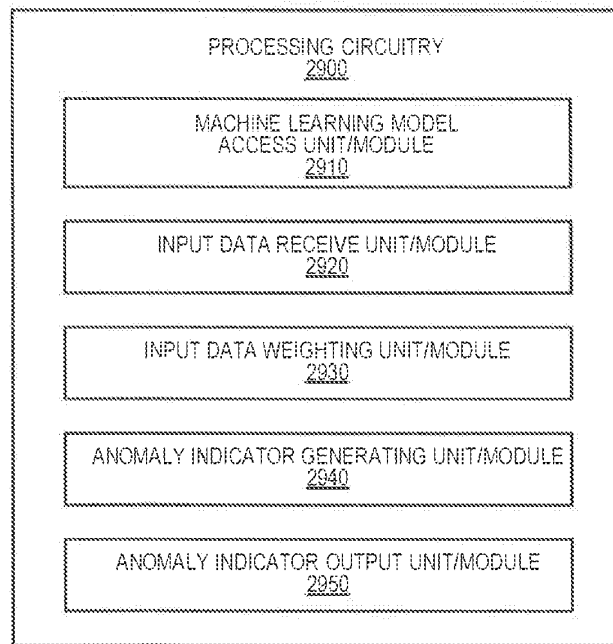


FIG. 27A

FIG. 27B

**FIG. 28**