

How to use qs-STAT freeware



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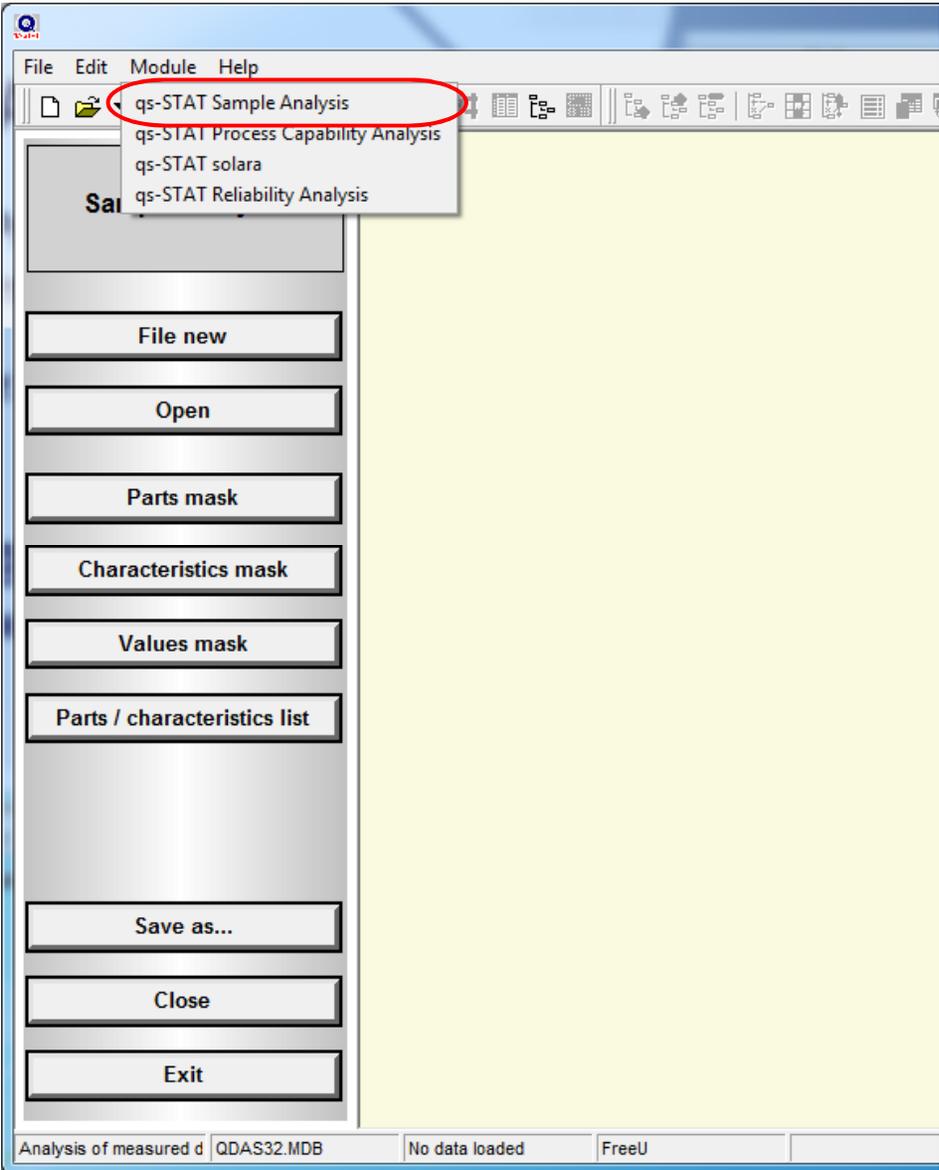


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Start qs-STAT freeware

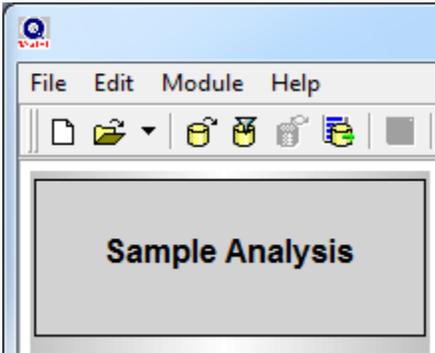


Choose/ change analysis module

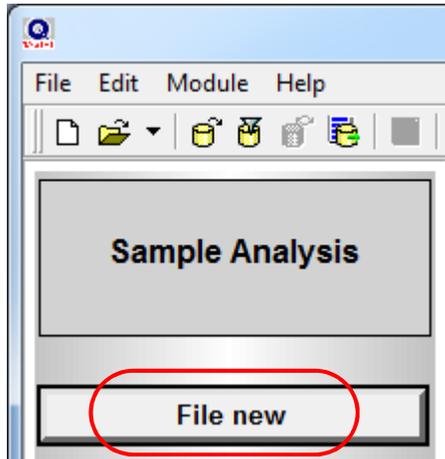


When you start the qs-STAT Freeware to make an analysis, check whether you are in the **Sample Analysis** or **Process Capability Analysis** module.

If not the right one - you can change the module in the top menu Module.



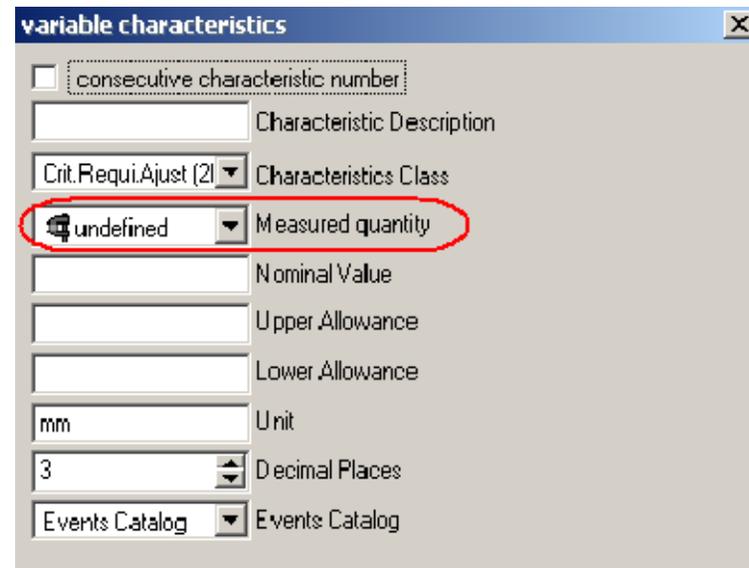
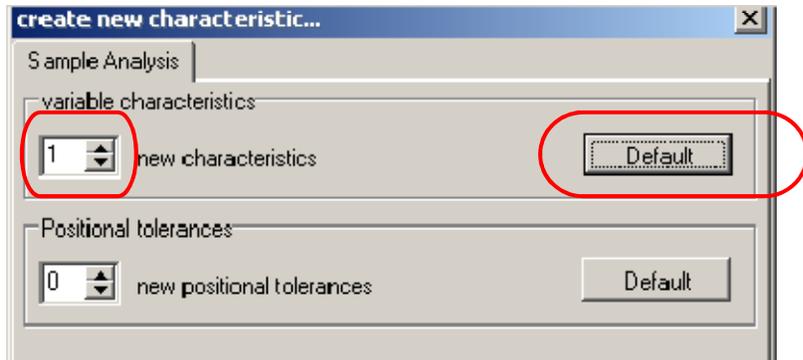
Create a new test plan



To create a new test plan click **File New**, and select number of characteristics.

In the **Default** menu you can select the default settings of the characteristics.

Note: Measured quantity must always be undefined.



When the Default settings is made, continue with **OK**, and when the number of characteristics is set continue again with **OK**.

Fill master data



The test plan is now created and you will now have to fill in data.

Parts mask

1 Plant no.
Only VELUX

2 Supplier Name

3 Supplier Number*

4 Part number*

5 Drawing number

6 Drawing Ed

7 Order number

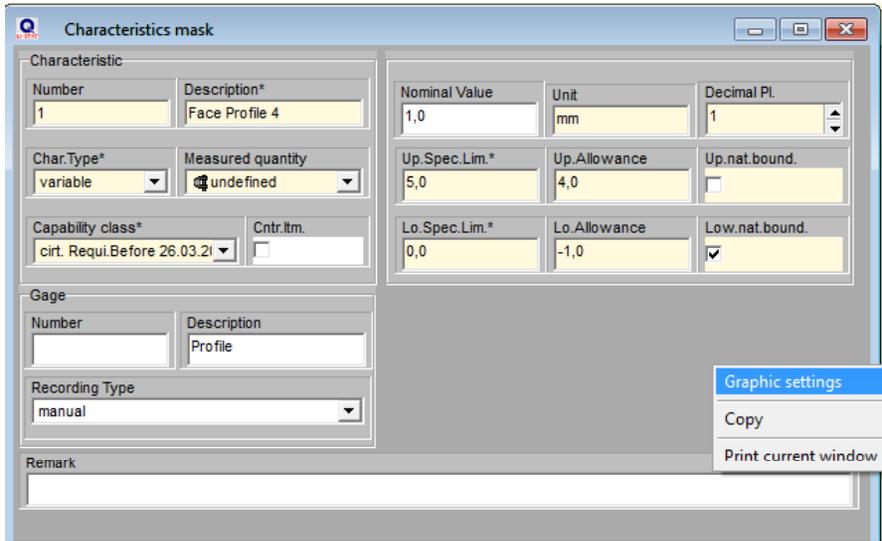
8 Reason for Test

Important to change this number for each set of data:

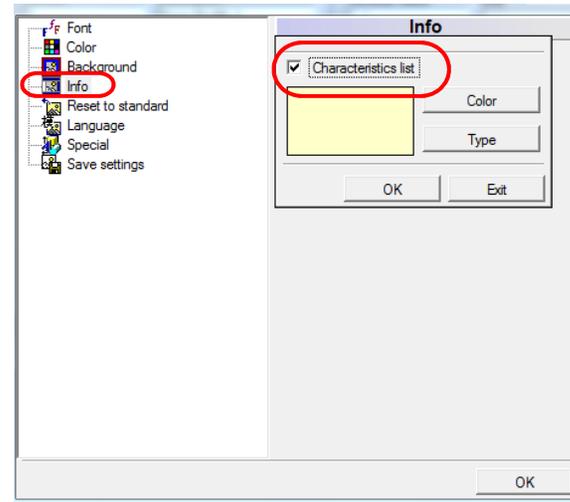
1. VELUX plant number (4- digit number)
2. Supplier Name
3. Supplier number (from VELUX SAP)
4. Part number + operation number (xxxxxx.xx)
5. Drawing number
6. Edition number
7. **Order number, batch number, production number or Test Requisition number. Change this number for each set of new data**
8. Could be AS for sample, PC for process or MSA (optional)

Set characteristic list

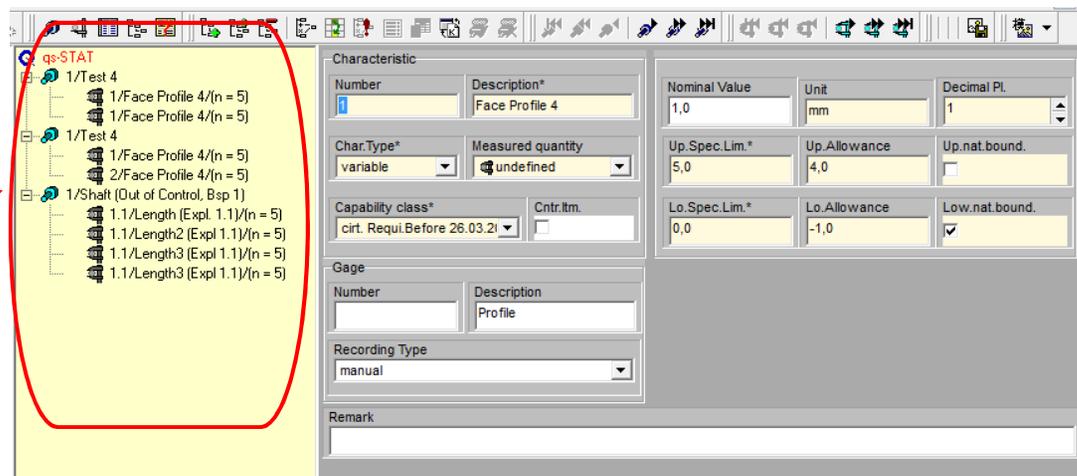
Set Characteristic list (same procedure for all views):



- Right click on the mask
- Choose "Graphic settings"



Now the list is added



Fill characteristic data



Characteristic mask:

The screenshot shows the VELUX software interface for entering characteristic data. The main window has a tree view on the left (9) showing a hierarchy of characteristics. The central 'Characteristic' form contains fields for Number, Description, Nominal Value, Unit, Decimal Pl., Char.Type, Measured quantity, Capability class, and Cntr.ltm. The 'Gage' form below it has fields for Number, Description, and Recording Type. A 'Characteristics mask' dialog is open on the right, showing a list of capability classes (12) and a legend. Red circles and arrows highlight specific fields and the dialog. A toolbar with navigation icons is at the top (14).

Capability class	Designation in VELUX Norm 877200.89.xx
6 sigma requirements	AAA Critical
Crit.Requi.Ajust (2F/2P)	AA Significant
Crit.Requi.Not-ajust (2F/2P)	A Important (use in V22)
Unclassified	B Of secondary importance
cirt. Requi.Before 26.03.2001	C Unimportant

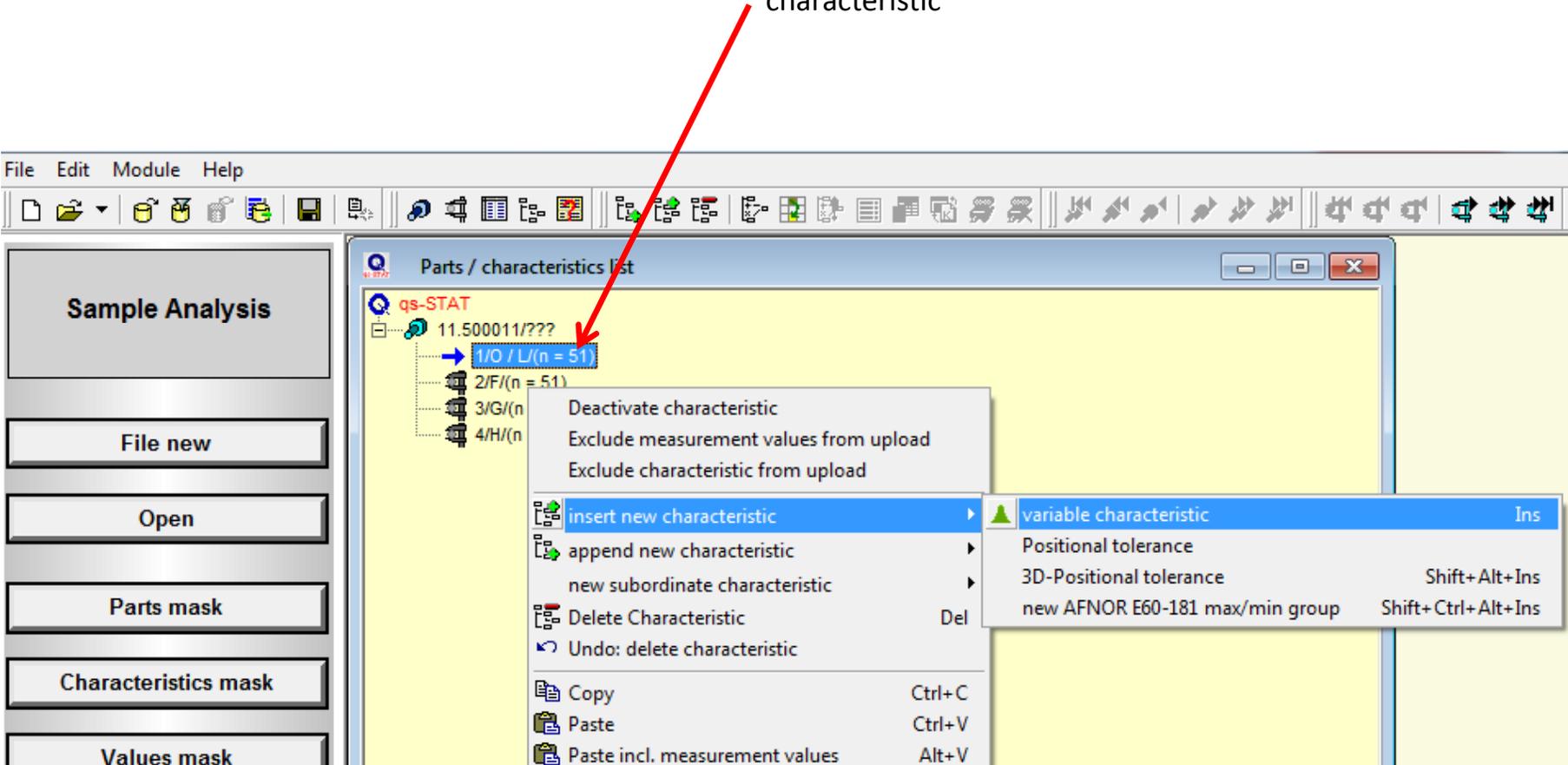
9. The characteristic no. and Description
10. Nominal Value, upper and lower limit
11. Only if the characteristic is Roundness, Concentricity or Parallelism the “low nat bound” must be checked.
12. The Capability requirements are set with the capability class. Please check 23.887200.89.xx for further information. See table for compliance .
13. Normally set to Recording Type “Manual” – other fields empty. If you want to collect data from a gage with a RS232 output, then select the interface type in Recording Type and enter a gage no. and description (eg. 12, caliper)
14. Repeat steps 9-13 for all characteristics. Use these symbols to move forward and backward in the list of characteristics or select in the characteristic list (left)

Add/ delete characteristic



To create an extra characteristic:

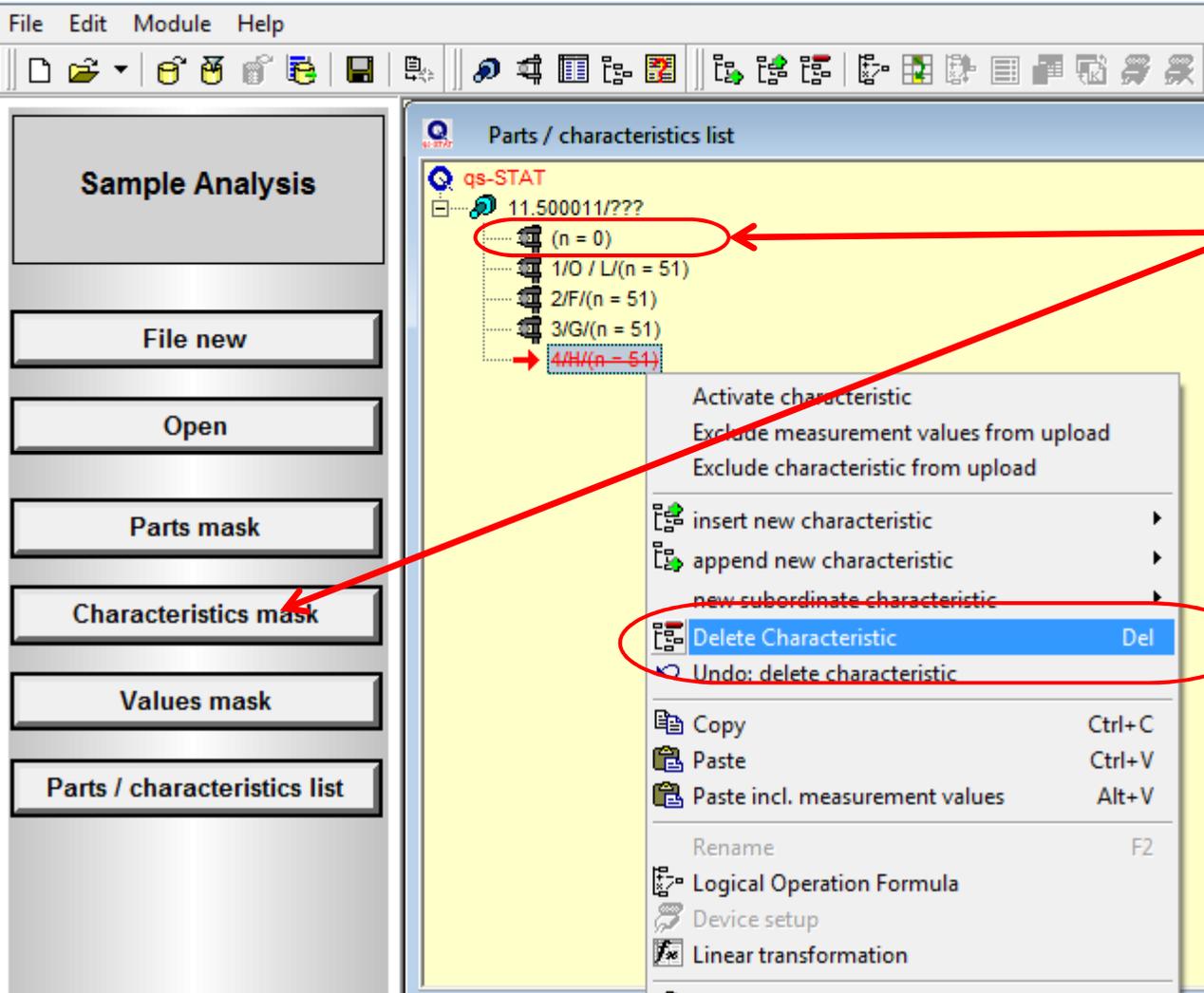
Right click where you want to add an extra characteristic



Add/ delete characteristic



To create or delete characteristic:



Now an extra characteristic has been added.
Remember to define the nominal & tolerances in "Characteristics mask"

You can also delete a Characteristic

Enter values / additional data



When all the characteristics are set, continue to enter the measured values with **Values mask**

Data entry:

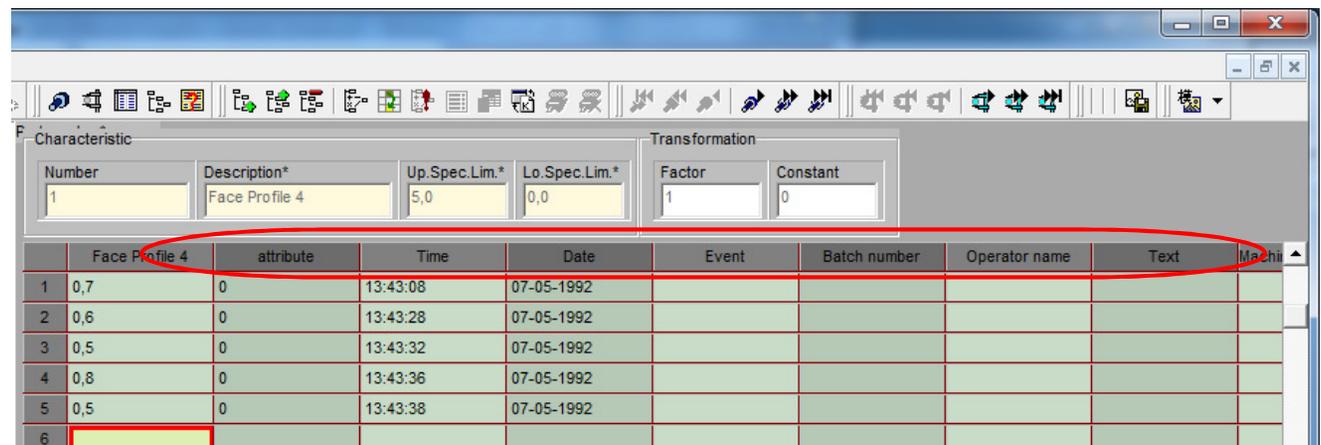
There are two different principles:

- Direct data entry in the values mask
- Copy/ paste data from another source – e.g. excel

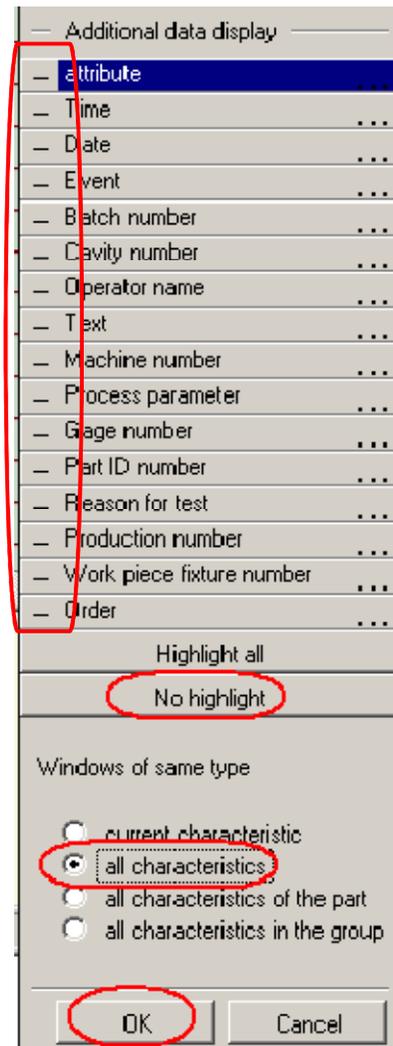
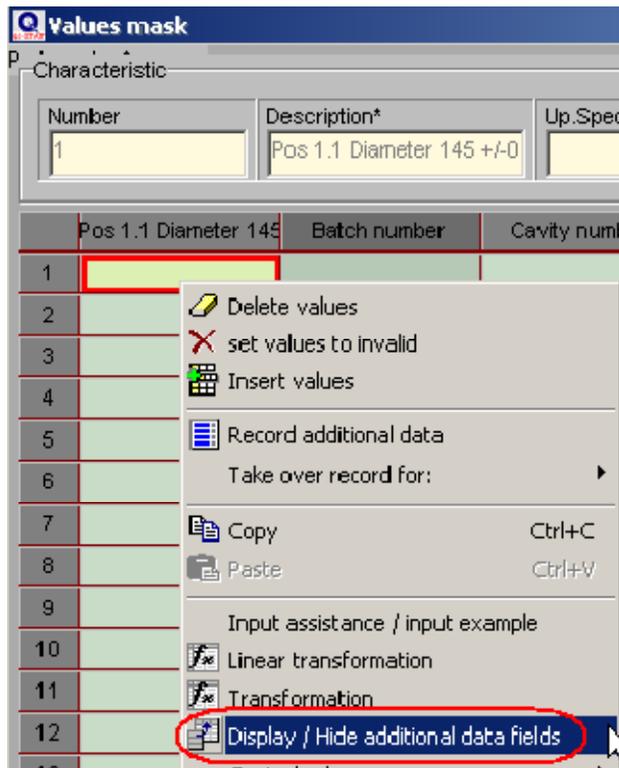
Additional data:

As default the Values mask displays some additional data:

This can be disabled with a right click on the value mask



Additional data



Mark

- No highlights
- all characteristics
- Then OK

OR

Choose the additional data you like to be displayed.

Move additional data to right/ left



Right click on the additional data you like to move

The screenshot shows the 'Values mask' software interface. On the left is a tree view with 'qs-STAT' and several test and shaft entries. The main area displays a table with columns for 'Face Profile 4' and 'Date'. A context menu is open over the 'Date' column, with 'Column to the left' highlighted. A red arrow points from the 'Date' column header to the '0,7' value in the first row. The table data is as follows:

	Face Profile 4	Date	Face Profile 4	Face Profile 4	Face Profile 4	Length
1	0,7	07-05-1992				19,9
2	0,6	07-05-1992				19,9
3	0,5	07-05-1992				19,9
4	0,8	07-05-1992				19,9
5	0,5	07-05-1992				19,9
6						
7						
8						
9						
10						
11						
12						
13						
14						

Input sequence



As default the active cell moves downwards then you input values.

Number	Description*	Up.Spec.Lim.*	Lo.Spec.Lim.*	Factor	Constant	
1	Face Profile 4	5,0	0,0	1	0	
	Face Profile 4	Face Profile 4	Face Profile 4	Face Profile 4	Length (Expl. 1.1)	Length2 (
1	0,7	1,5	2,9	19,980	24,964	
2	0,6	2,6	0,8	19,985	24,980	
3	0,5	2,5	0,5	19,977	24,974	
4	0,8	2,8	1,2	19,985	24,954	
5	0,5	2,5	0,2	19,986	24,966	
6						
7						
8						
9						

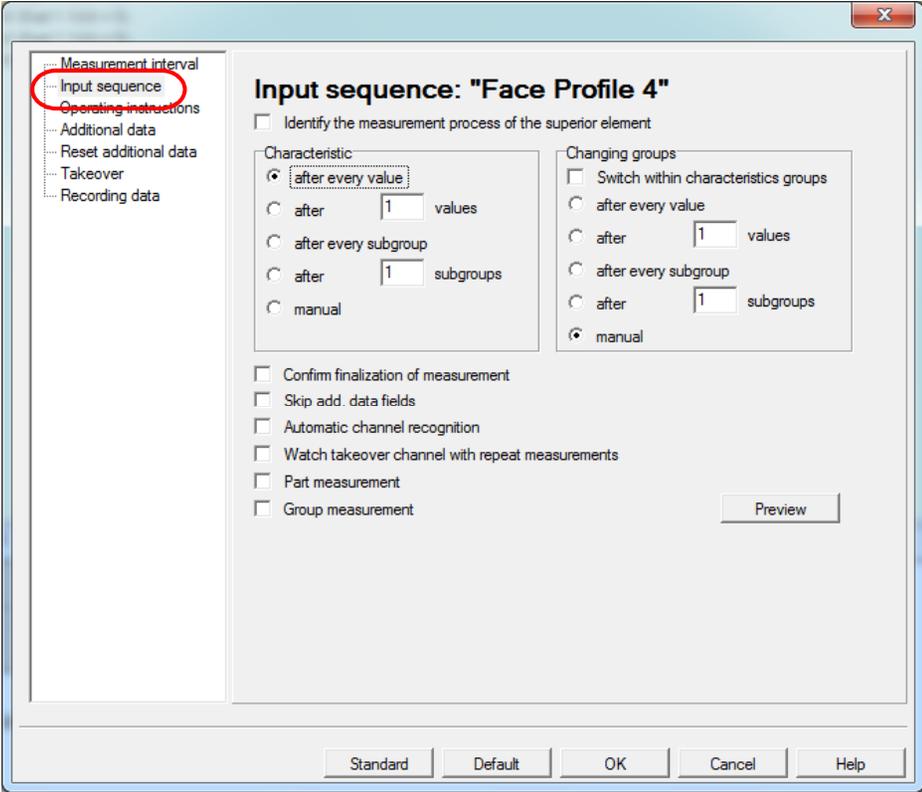
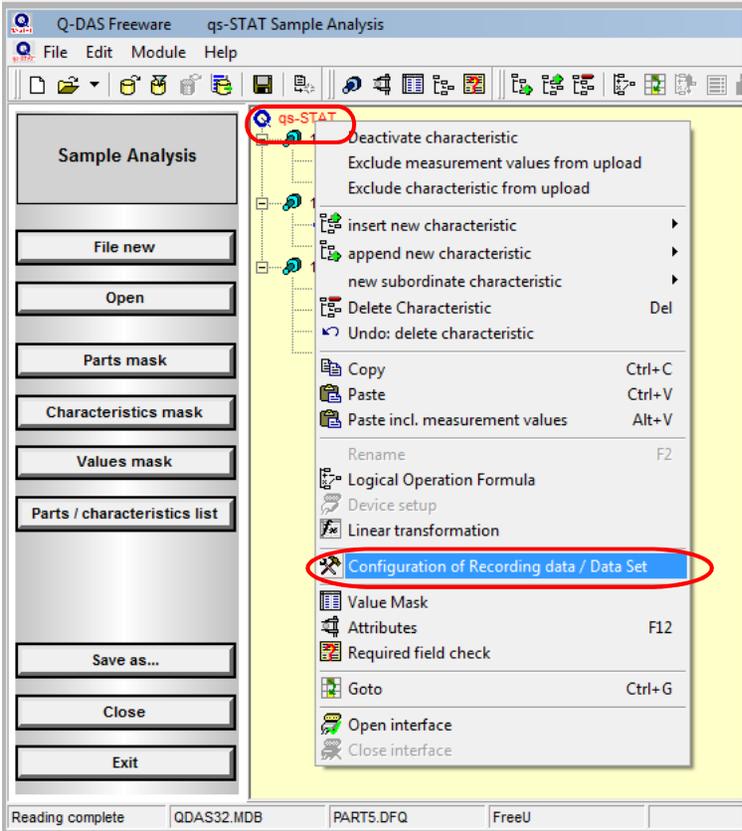
If you want to change this, then click on the Part/Characteristic list bottom



Input sequence



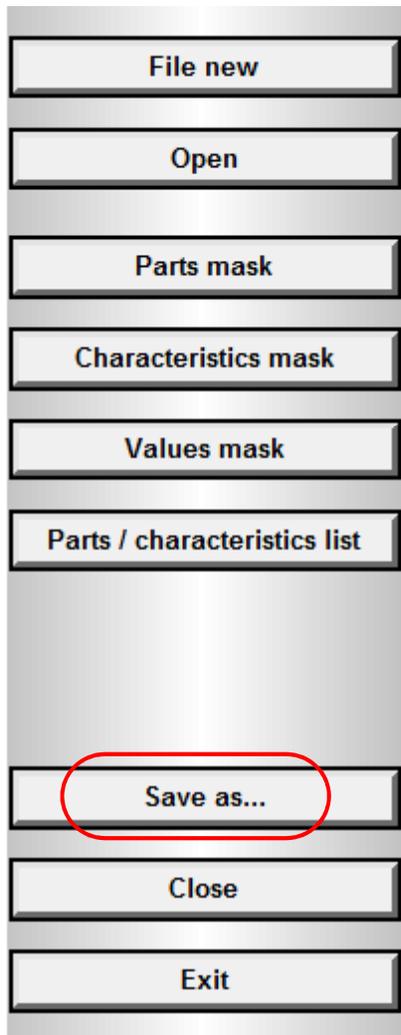
Right click on the Part/Characteristic list:



Select the Input sequence tab and mark "after every value" – Default – OK

Save data

When all the measurements are entered the test plan must be saved as a file.



Then using qs-STAT freeware, all the data and all data templates must be saved on your local computer.

See next slide as an example how this file structure can be.

Then you want to upload data to VELUX database (from the webpage) it's important only to have the data you like to analyze

Therefore you have to create a new file for each set of data (each order, production or batch no.)

To make this easier:

Save a master for each part no, so you don't have to create new characteristics each time

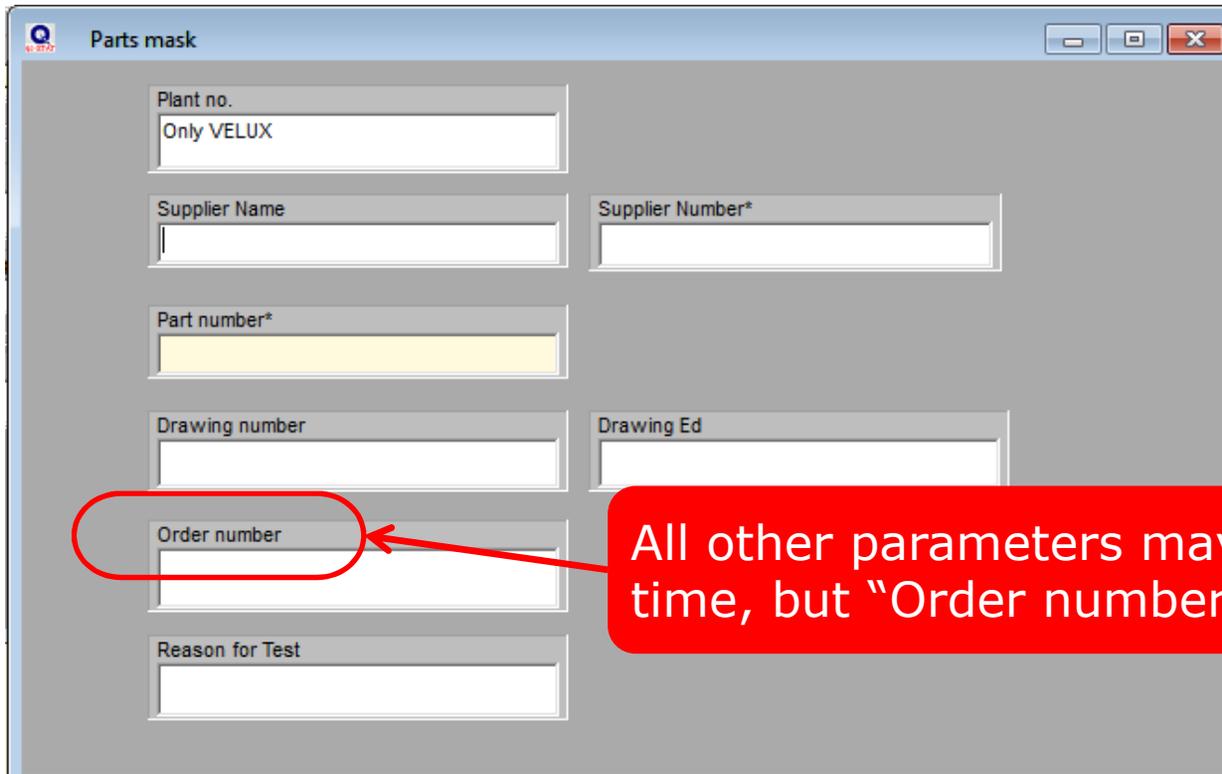
Save data

Example

Name	Date modified	Type
12345.DFQ	06-03-2012 13:52	DFQ File
23456.DFQ	06-03-2012 13:53	DFQ File
34567.DFQ	06-03-2012 13:53	DFQ File
45678.DFQ	06-03-2012 13:53	DFQ File
Template.DFQ	06-03-2012 13:53	DFQ File

Create your own local folder structure.
Just make sure all records are stored under an unique number or text

Save data



The screenshot shows a web form titled "Parts mask" with the following fields:

- Plant no. (text input, containing "Only VELUX")
- Supplier Name (text input)
- Supplier Number* (text input)
- Part number* (text input, highlighted in yellow)
- Drawing number (text input)
- Drawing Ed (text input)
- Order number (text input, circled in red)
- Reason for Test (text input)

A red callout box with a white border and arrow points to the "Order number" field, containing the text: "All other parameters may be the same each time, but "Order number" MUST be changed".

Then data is uploaded to database from webpage, VELUX must be sure to distinguish all the data later.

The most important parameter is "Order number"

This MUST be changed for each new set of data.

Create reports



To make a report, the test plan must be uploaded to VELUX qs-STAT web module (Sample analysis). This is done by entering VELUX.com

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Capability study

Selling to VELUX
Purchasing principles
Quality requirements
Capability study

If you are a preferred VELUX partner you can analyse your own quality data and receive a capability report.

This tool is intended for suppliers who want to make capability studies their own processes. The analysis can be used either to approve or reject own processes or used as finished goods inspection before parts are supplied to the VELUX companies.

Basic analysis and standard reports (freeware)
Upload data via the website to analyse data for batch, tools or machine approval and create a capability report.

1. Download:
Download the zip file, unzip it and install the freeware program.
> [Download qs-STAT freeware](#)

2. Sample analysis:
Get user name and password from the contact persons below.
> [Upload & analyse data](#)

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Manuals
Guides how to install and use qs-STAT (freeware).
> [How to install qs-STAT](#)
> [How to use qs-STAT](#)

Log In

User Name: **Contact VELUX to get username & password**

Password:

Log In

Open Sample analysis

Create reports



Drawing Values		Collected Values		Statistics	
T _{min}	1214.000	X _{min}	1211.000	S	1213.67737
L _{SL}	1209.000	X _{max}	1219.000	T _{-3s}	1208.13709
U _{SL}	1219.000	R	8.000	T _{+3s}	1218.21884
T	10.000	P _{min}	59	S ₂	9.58174
		n _{-USL}	0	P _{min}	99.87521 %
		P _{min}	0	n _{-USL}	0.02190 %
		P _{max}	59	P _{max}	0.29399 %
		P _{max}	59		

1. To upload the file click on the Browse bottom (the top one)
2. Execute to get the file
3. Select the Evaluation strategy
4. Select how to view the values to the right (after selection, tab the icon)
5. Navigate through all the individuals
6. Select which report to see. Tab the icon and it will open in PDF. Save this file local. This report can be attached to a mail to VELUX.
7. Tab Save and the data will be stored in VELUX database.