WORK CENTER	A					B					C					D					E				
%C&A	100%					100%					100%					100%					100%				
TURN	1	2	3	4	5	1	2	3	4	5	1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
ROLL	3	1	4	4	2	5	4	5	4	5	4	4	2	6	1	1	3	2	3	4	2	4	4	1	6
MOVED	3	1	4	4	2	3	1	4	4	2	3	1	2	6	1	1	3	2	3	4	1	3	2	1	6
WIP	0	0	0	0	0	0	0	0	0	0	0	0	2	0	1	2	0	0	3	0	0	0	0	2	0
DEVIATION	-0.5	-3.0	-2.5	-2.0	-3.5	-0.5	-3.0	-2.5	-2.0	-3.5	-0.5	-3.0	-4.5	-2.0	-4.5	-2.5	-3.0	-4.5	-5.0	-4.5	-2.5	-3.0	-4.5	-7.0	-4.5

Total deviation from average. Calculate the deviation for each turn by subtracting 3.5 from each die roll to get the current turn's deviation. Add that deviation to the prior turn's deviation to get the total cumulative deviation and place an 'X' in the appropriate row and column. All work centers begin with 0 deviation at the start.

Example: Suppose work center 'A's first roll is a 4. Its total deviation for its first turn would be (4 - 3.5) + 0 = +0.5. If it next rolls a 1, then the total deviation for its second turn would (1 - 3.5) + 0.5 = -2.0.