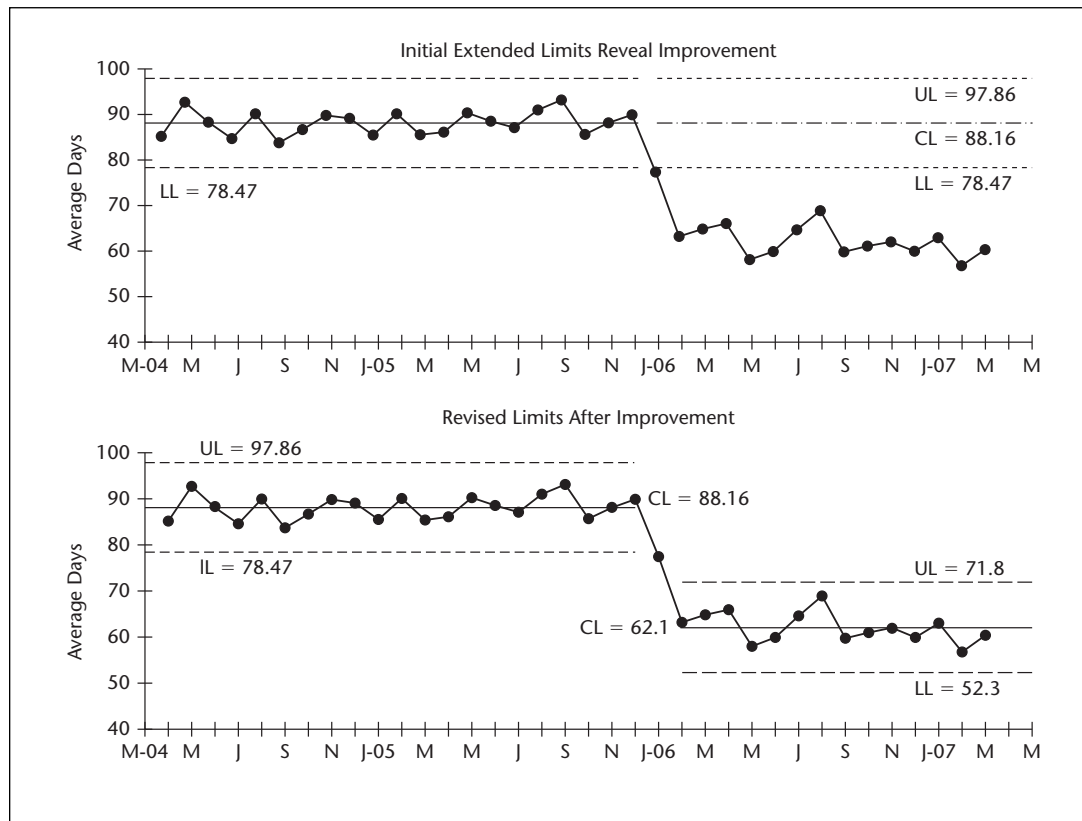


FIGURE 4.16 Recalculating Limits After Special Cause Improvement**FIGURE 4.17 Recalculating Limits After Exhausting Efforts to Remove Special Cause**