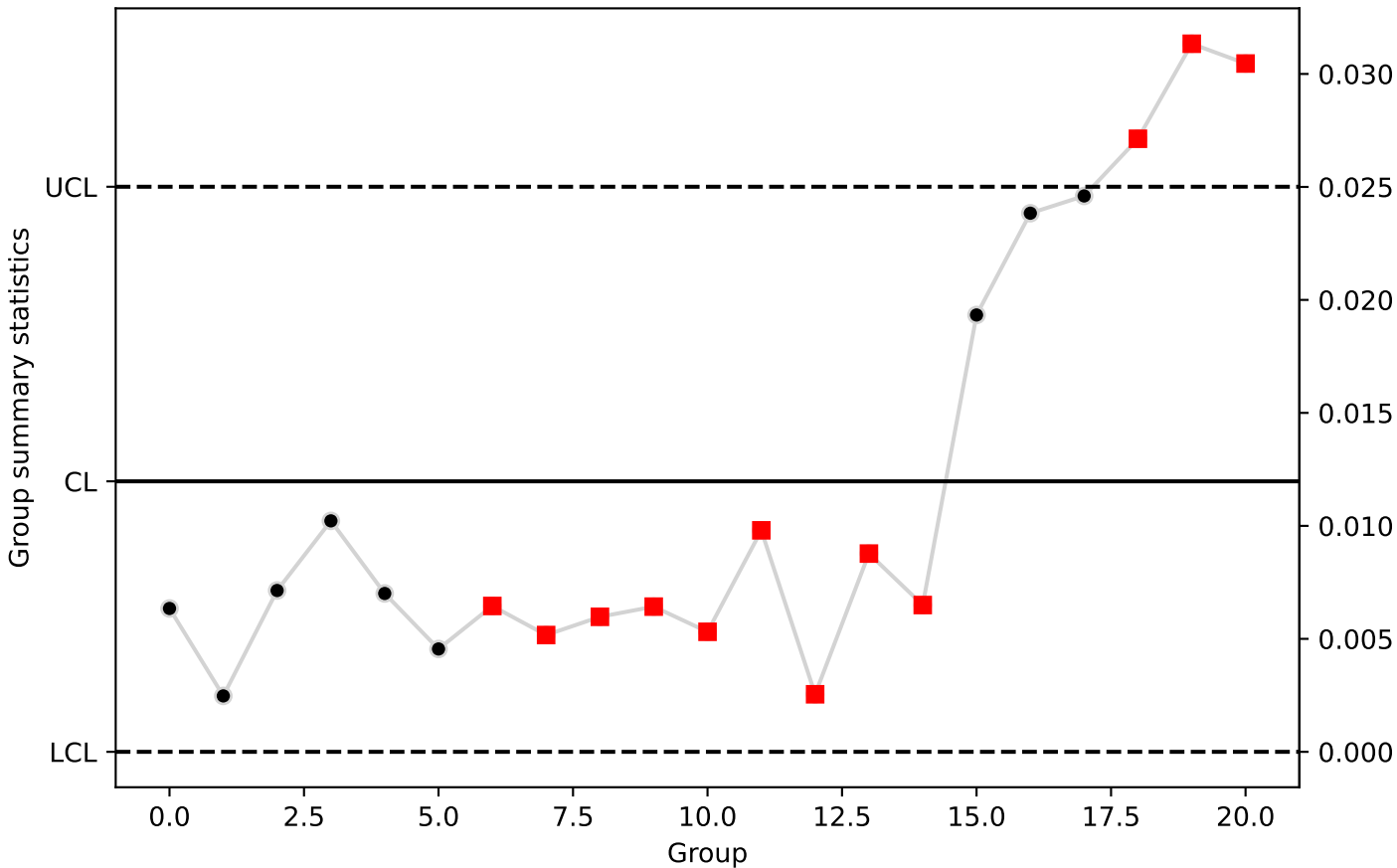


S Chart
for cycleTime



Number of groups = 21

Center = 0.011971

StdDev = 0.012735

LCL = 0

UCL = 0.025008

Number beyond limits = 3

Number violating runs = 9