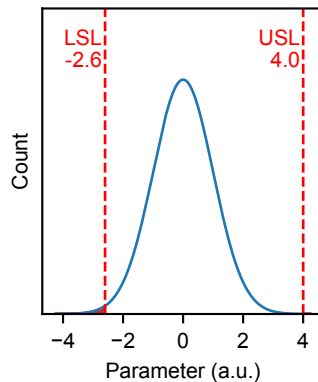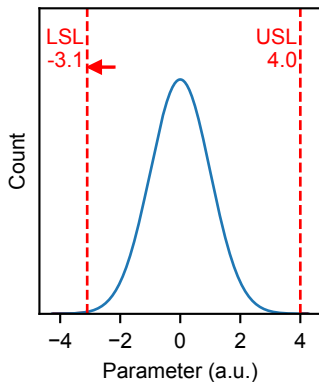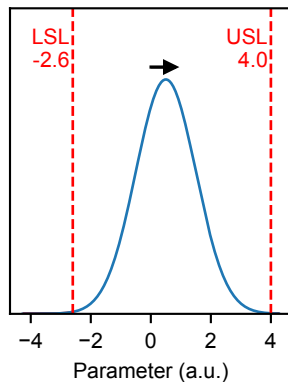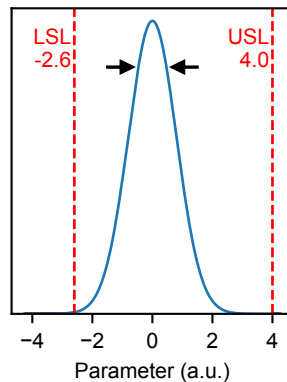**a.** Original
0.5% defective

b. Expand spec limits
0.1% defective

c. Shift mean
0.1% defective

d. Tighten distribution
0.1% defective

4. Improve inspection
0.1% defective*