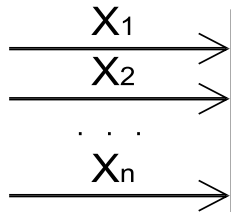


(Controllable Inputs)

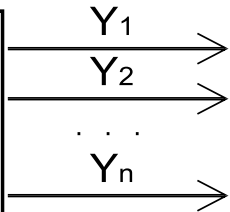
Factors



Noise



Uncontrollable Inputs



Responses

(Quality Characteristics)