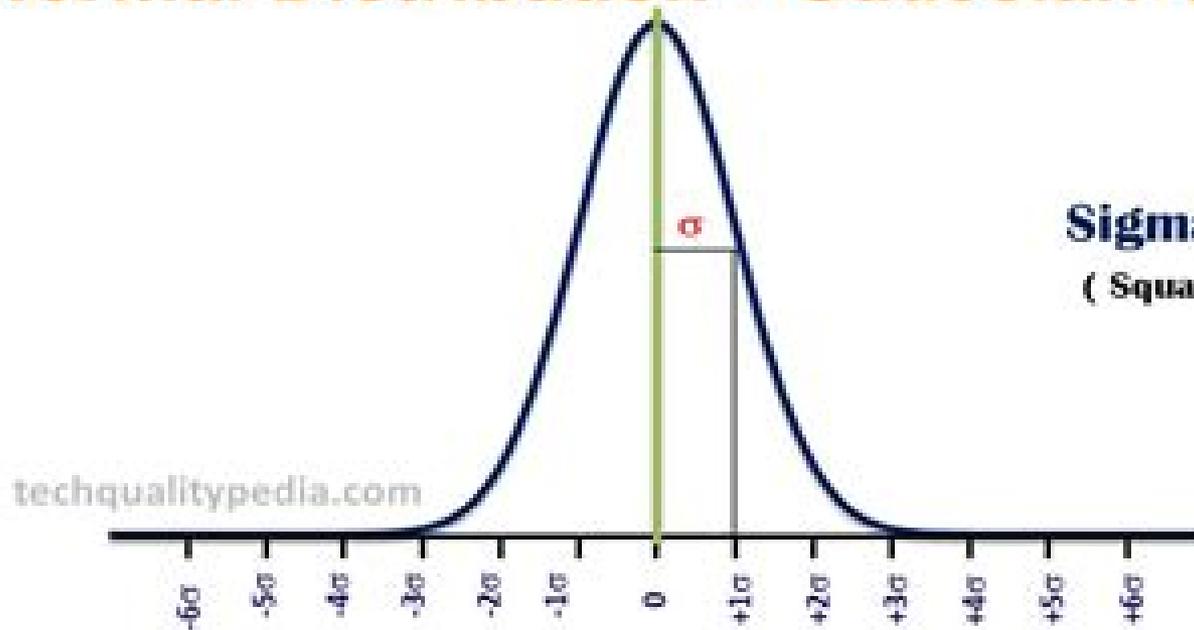


# Six Sigma

## Normal Distribution - Gaussian Curve



**Sigma =  $\sigma$  = Deviation**  
( Square root of variance )

between $+ / - 1\sigma$	68.27 %	Result: 317300 ppm out of Spec.
between $+ / - 2\sigma$	95.45 %	45500 ppm
between $+ / - 3\sigma$	99.73 %	2700 ppm
between $+ / - 4\sigma$	99.9937 %	63 ppm
between $+ / - 5\sigma$	99.999943 %	0.57 ppm
between $+ / - 6\sigma$	99.9999998 %	0.002 ppm

# Tools Six Tech

**Frederic Swing Crispin**



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