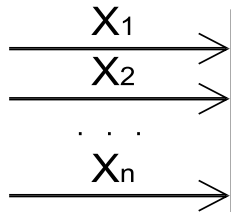


(Controllable Inputs)

Factors



Noise

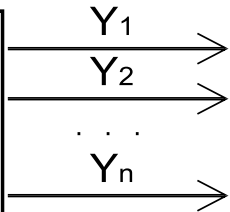


\vdots



Uncontrollable Inputs

Process



Responses

(Quality Characteristics)