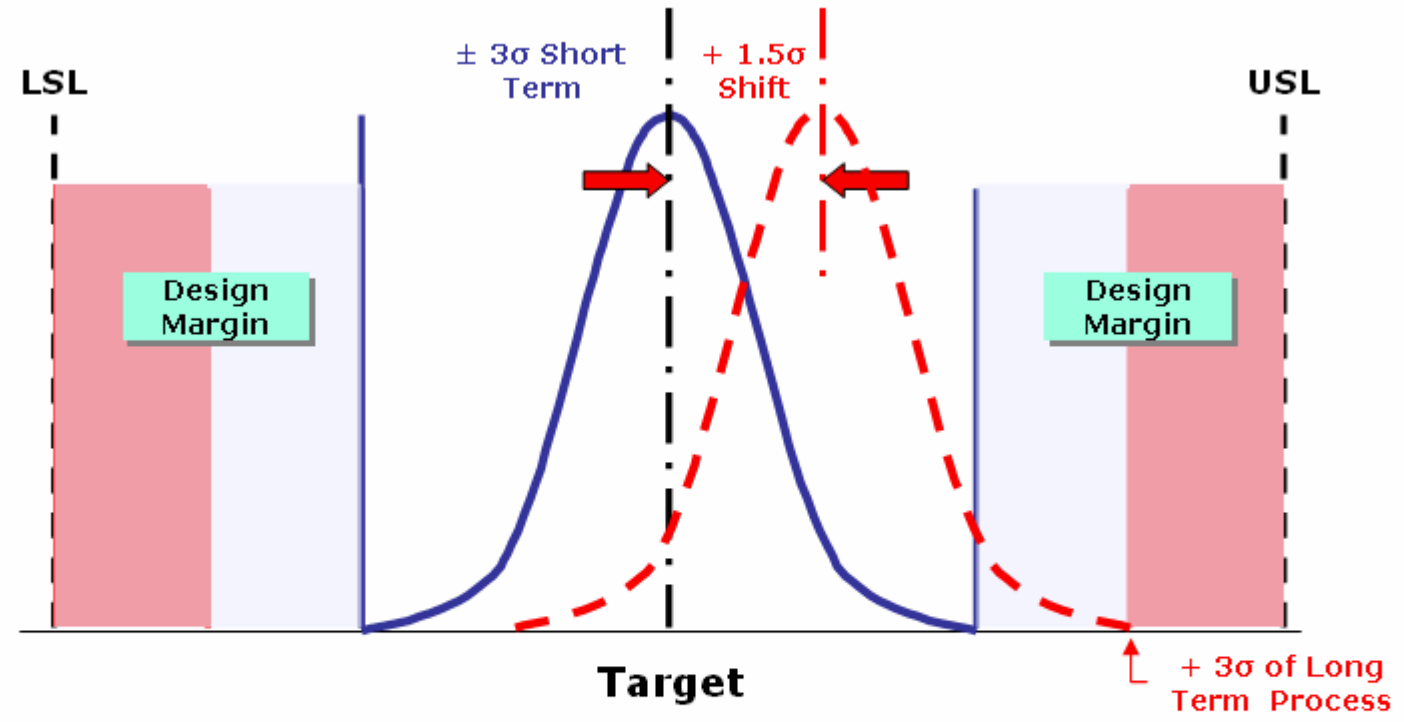
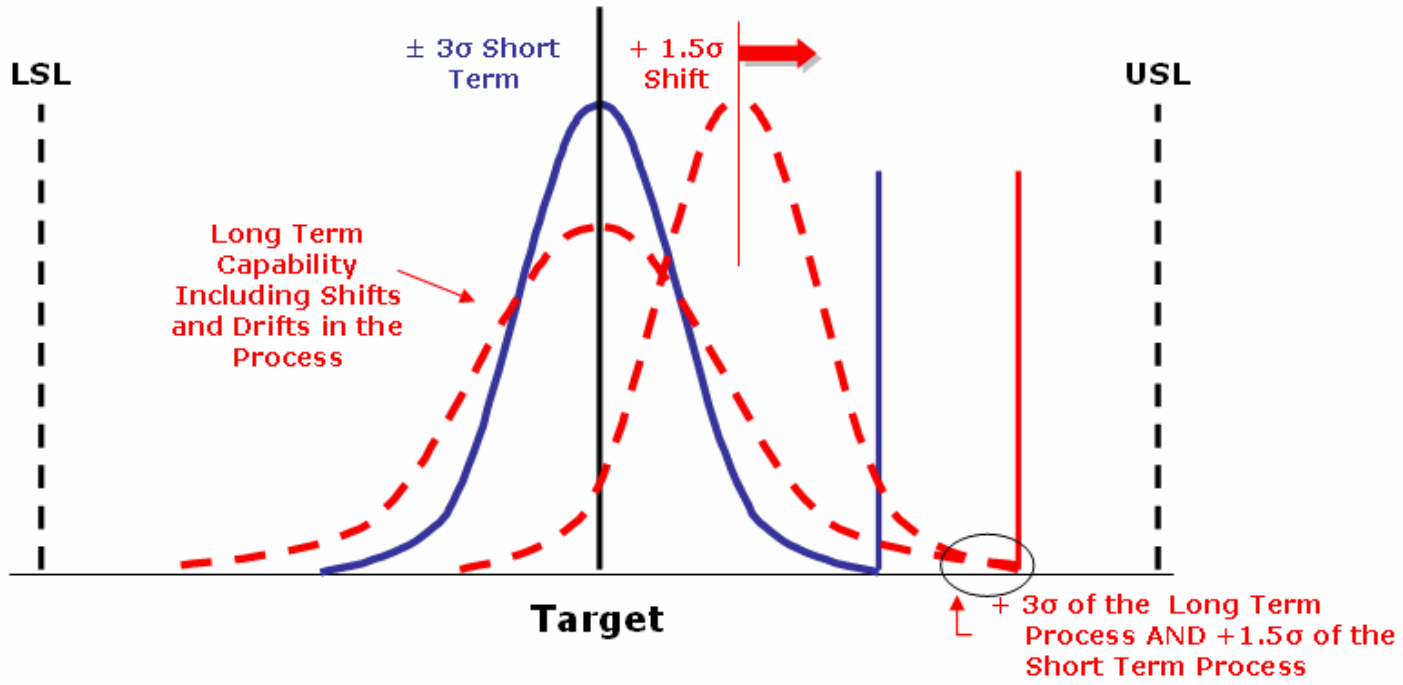


*Long Term Variation, including the shifts and drifts in the process, infringes on design margin*



*The Short Term distribution is "shifted" +1.5σ to simulate the +3σ value of the long term process distribution*



*The +3σ value of the long term distribution has the same tail area probability for a defect as the +1.5σ "shifted" short term distribution.*