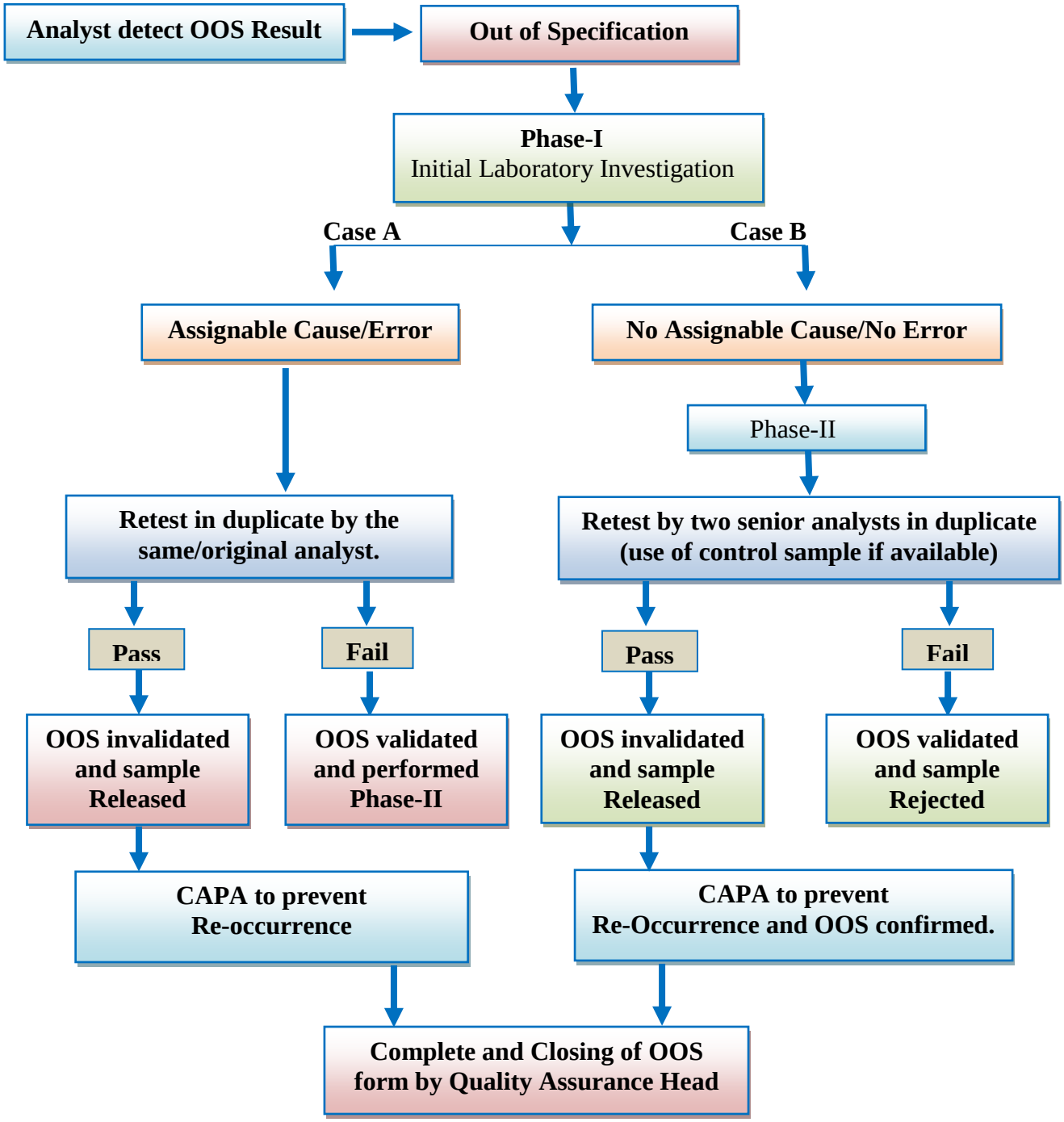Flow Chart for investigation of out of Specification Results