

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
1	Create a New QC Plan FROM SCRATCH in DRAFT mode	Part Number, Revision	Ensure Part Number and Revision Combination are Unique	1. Try to create a Plan with a duplicate Part Number and Revision. 2. Create a Plan with a unique Part Number and Revision. Plan should be created in DRAFT mode	1. Plan should not be created if duplicate part number and revision 2. A Blank Quality Control Plan is created. Results in a blank QC Plan in DRAFT mode. Human action and review is required to create and release the plan	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	1. Plan should not be created if duplicate part number and revision 2. A Blank Quality Control Plan is created. Results in a blank QC Plan in DRAFT mode. Human action and review is required to create and release the plan
2	Add Spec of type Nom +/- Tol	Char: diameter (or any other characteristic of size) Char Type: Nom +/- Tol Nom = 1.500 + Tol = 0.010 - Tol = 0.010 Data Type = Num	The Nom field should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an inspection: -- Verify 1.489 is out of spec -- Verify 1.490 is in spec -- Verify 1.510 is in spec -- Verify 1.511 is out of spec	QC Plan: Diameter 1.500 +/- 0.010 Inspection Summary Table: Diameter 1.500 +/- 0.010 Data Entry Screens: Diameter 1.500 +/- 0.010 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	QC Plan: Diameter 1.500 +/- 0.010 Inspection Summary Table: Diameter 1.500 +/- 0.010 Data Entry Screens: Diameter 1.500 +/- 0.010 Pass/Fail is calculated correctly (see Tests)
3	Add Spec of type Nom +/- Tol	Char: diameter (or any other characteristic of size) Char Type: Nom +/- Tol Nom = 1.500 + Tol (Upper) = 0.050 + Tol (Lower) = 0.010 Data Type = Num	The Nom field should be non-null The upper tolerance should be greater than the lower tolerance	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, Upper Tol, and Lower Tol 3. In an inspection: -- Verify 1.509 is out of spec -- Verify 1.510 is in spec -- Verify 1.510 is in spec -- Verify 1.551 is out of spec	QC Plan: Diameter 1.500 +0.050 -0.010 Inspection Summary Table: Diameter 1.500 +0.050 -0.010 Data Entry Screens: Diameter 1.500 +0.050 -0.010 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	QC Plan: Diameter 1.500 +0.050 -0.010 Inspection Summary Table: Diameter 1.500 +0.050 -0.010 Data Entry Screens: Diameter 1.500 +0.050 -0.010 Pass/Fail is calculated correctly (see Tests)
4	Add Spec of type Nom -/- Tol	Char: diameter (or any other characteristic of size) Char Type: Nom -/- Tol Nom = 1.500 - Tol (Upper) = 0.002 - Tol (Lower) = 0.007 Data Type = Num	The Nom field should be non-null The lower tolerance should be greater than the upper tolerance Tolerance fields should be non-negative	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, Upper Tol, and Lower Tol 3. In an inspection: -- Verify 1.492 is out of spec -- Verify 1.493 is in spec -- Verify 1.498 is in spec -- Verify 1.499 is out of spec	QC Plan: Diameter 1.500 -0.002 -0.007 Inspection Summary Table: Diameter 1.500 -0.002 -0.007 Data Entry Screens: Diameter 1.500 -0.002 -0.007 Pass/Fail is calculated correctly (see Tests)	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	QC Plan: Diameter 1.500 -0.002 -0.007 Inspection Summary Table: Diameter 1.500 -0.002 -0.007 Data Entry Screens: Diameter 1.500 -0.002 -0.007 Pass/Fail is calculated correctly (see Tests)
5	Add Spec of type Basic (i.e. Nominal only)	Char: diameter (or any other characteristic of size) Char Type: Basic Nom = 1.500 Data Type = Num	The Nom field should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom 3. In an inspection: -- Any value entered should be indeterminate	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)
6	Add Spec of type Reference	Char: diameter (or any other characteristic of size) Char Type: Reference Nom = 1.500 Data Type = Num	The Nom field should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom 3. In an inspection: -- Any value entered should be indeterminate	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)
7	Add Spec of type Min - Max	Char: diameter (or any other characteristic of size) Char Type: Min - Max Nom = [leave empty] Min = 1.0 Max = 2.0 Data Type = Num	At least one of the three specification fields should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify 0.99 is out of spec -- Verify 1.0 is in spec -- Verify 2.1 is out of spec	QC Plan: Diameter 1.0 - 2.0 Inspection Summary Table: Diameter 1.0 - 2.0 Data Entry Screens: Diameter 1.0 - 2.0 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	QC Plan: Diameter 1.0 - 2.0 Inspection Summary Table: Diameter 1.0 - 2.0 Data Entry Screens: Diameter 1.0 - 2.0 Pass/Fail is calculated correctly (see Tests)
8	Add Spec of type Min Only	Char: diameter (or any other characteristic of size) Char Type: Min - Max Nom = [leave empty] Min = 1.0 Max = [leave empty] Data Type = Num	At least one of the three specification fields should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify 0.99 is out of spec -- Verify 1.0 is in spec -- Verify 2.1 is in spec	QC Plan: Diameter 1.0 MIN Inspection Summary Table: Diameter 1.0 MIN Data Entry Screens: Diameter 1.0 MIN Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/12/2025	QC Plan: Diameter 1.0 MIN Inspection Summary Table: Diameter 1.0 MIN Data Entry Screens: Diameter 1.0 MIN Pass/Fail is calculated correctly (see Tests)
9	Add Spec of type Max Only	Char: diameter (or any other characteristic of size) Char Type: Min - Max Nom = [leave empty] Min = [leave empty] Max = 2.0 Data Type = Num	At least one of the three specification fields should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify 2.1 is out of spec -- Verify 2.0 is in spec -- Verify 0.9 is in spec	QC Plan: Diameter 2.0 MAX Inspection Summary Table: Diameter 2.0 MAX Data Entry Screens: Diameter 2.0 MAX Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 2.0 MAX Inspection Summary Table: Diameter 2.0 MAX Data Entry Screens: Diameter 2.0 MAX Pass/Fail is calculated correctly (see Tests)
10	Add Spec of type GD&T Spec without MMC e.g. position 0.005	Char: position Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.005 Tol (Lower) = [leave empty] Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify .0051 is out of spec -- Verify .0049 is in spec	QC Plan: Position 0.005 Inspection Summary Table: Position 0.005 Data Entry Screens: Position 0.005 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Position 0.005 Inspection Summary Table: Position 0.005 Data Entry Screens: Position 0.005 Pass/Fail is calculated correctly (see Tests)
11	Add Spec of type GD&T Spec with MMC e.g. position 0.005 (RMC)	Char: position Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.005 Tol (Lower) = [leave empty] Bonus = MMC Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify .0051 is out of spec -- Verify 0.0 is in spec 3. Enter a Bonus Tolerance of .0001 -- Verify .0051 should now be in spec	QC Plan: Position 0.005 (MMC) Inspection Summary Table: Position 0.005 (MMC) Data Entry Screens: Position 0.005 (MMC) Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Position 0.005 (MMC) Inspection Summary Table: Position 0.005 (MMC) Data Entry Screens: Position 0.005 (MMC) Pass/Fail is calculated correctly (see Tests)
12	Add Spec of type GD&T Spec special case: Surface Profile Outside Material e.g. profile of surface 0.005	Char: surface profile Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.005 Tol (Lower) = [leave empty] Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify .0051 is out of spec -- Verify .0049 is in spec	QC Plan: Surface Profile (or Profile of Surface) 0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) 0.005 Data Entry Screens: Surface Profile (or Profile of Surface) 0.005 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Surface Profile (or Profile of Surface) 0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) 0.005 Data Entry Screens: Surface Profile (or Profile of Surface) 0.005 Pass/Fail is calculated correctly (see Tests)
13	Add Spec of type GD&T Spec special case: Surface Profile Inside Material e.g. profile of surface -0.005	Char: surface profile Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = [leave empty] Tol (Lower) = -0.005 Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify -.0051 is out of spec -- Verify -.0049 is in spec	QC Plan: Surface Profile (or Profile of Surface) - 0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) - 0.005 Data Entry Screens: Surface Profile (or Profile of Surface) - 0.005 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Surface Profile (or Profile of Surface) - 0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) - 0.005 Data Entry Screens: Surface Profile (or Profile of Surface) - 0.005 Pass/Fail is calculated correctly (see Tests)
14	Add Spec of type GD&T Spec special case: Surface Profile Bilateral e.g. profile of surface -0.0025, +0.0025	Char: surface profile Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.0025 Tol (Lower) = -0.0025 Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify -.0026 is out of spec -- Verify -.0025 is in spec -- Verify 0.0025 is in spec -- Verify 0.0026 is out of spec	QC Plan: Surface Profile -0.0025 + 0.0025 Inspection Summary Table: Surface Profile -0.0025 + 0.0025 Data Entry Screens: Surface Profile -0.0025 + 0.0025 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Surface Profile -0.0025 + 0.0025 Inspection Summary Table: Surface Profile -0.0025 + 0.0025 Data Entry Screens: Surface Profile -0.0025 + 0.0025 Pass/Fail is calculated correctly (see Tests)
15	Add Spec of type Note	Char: Any text (alpha-numeric and special characters) Data Type = P/F	Characteristic cannot be empty	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Enter P or Pass for Pass -- Enter F or Fail for Fail -- Pass or Fail should be reflected correctly	QC Plan: Text is shown exactly as entered Inspection Summary Table: Text is shown exactly as entered Data Entry Screens: Text is shown exactly as entered Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Text is shown exactly as entered Inspection Summary Table: Text is shown exactly as entered Data Entry Screens: Text is shown exactly as entered Pass/Fail is calculated correctly (see Tests)
16	Inch Defaults: Create a spec with a Nominal that is whole number i.e. (no decimal places)	Char: diameter (or any other characteristic of size) Nominal = 10 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num Set default tolerance for X: 0.10	The Nom field should be non-null	1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an inspection: -- Verify 9.99 is out of spec -- Verify 9.90 is in spec -- Verify 10.10 is in spec -- Verify 10.11 is out of spec	QC Plan: Diameter 10 +0.10 -0.10 Inspection Summary Table: Diameter 10 +0.10 -0.10 Data Entry Screens: Diameter 10 +0.10 -0.10 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 10 +0.10 -0.10 Inspection Summary Table: Diameter 10 +0.10 -0.10 Data Entry Screens: Diameter 10 +0.10 -0.10 Pass/Fail is calculated correctly (see Tests)
17	Inch Defaults: Create Spec with a Nominal with whole numbers i.e. X.X	Char: diameter (or any other characteristic of size) Nominal = 10.1 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num Set default tolerance for X.X: 0.05	The Nom field should be non-null	1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an inspection: -- Verify 10.049 is out of spec -- Verify 10.050 is in spec -- Verify 10.150 is in spec -- Verify 10.151 is out of spec	QC Plan: Diameter 10.1 +0.05 -0.05 Inspection Summary Table: Diameter 10.1 +0.05 -0.05 Data Entry Screens: Diameter 10.1 +0.05 -0.05 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 10.1 +0.05 -0.05 Inspection Summary Table: Diameter 10.1 +0.05 -0.05 Data Entry Screens: Diameter 10.1 +0.05 -0.05 Pass/Fail is calculated correctly (see Tests)
18	Inch Defaults: Nominal with whole numbers only (i.e. XXX)	Char: diameter (or any other characteristic of size) Nominal = 10.10 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num Set default tolerance for XXX: 0.01	The Nom field should be non-null	1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an inspection: -- Verify 10.089 is out of spec -- Verify 10.090 is in spec -- Verify 10.110 is in spec -- Verify 10.111 is out of spec	QC Plan: Diameter 10.10 +0.01 -0.01 Inspection Summary Table: Diameter 10.10 +0.01 -0.01 Data Entry Screens: Diameter 10.10 +0.01 -0.01 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 10.10 +0.01 -0.01 Inspection Summary Table: Diameter 10.10 +0.01 -0.01 Data Entry Screens: Diameter 10.10 +0.01 -0.01 Pass/Fail is calculated correctly (see Tests)

PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025
PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025
PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025
PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025
PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025
PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025
PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025
PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025

51	ISO fine mm defaults for Angle: Nominal value = 50.0 deg	Char = ANGLE Nominal = 50.0 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num	The Nom field should be non-null	1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an Inspection: -- Verify 49.49 is out of spec -- Verify 49.5 is in spec -- Verify 50.5 is in spec -- Verify 50.51 is out of spec 1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an Inspection: -- Verify 49.76 is out of spec -- Verify 49.77 is in spec -- Verify 50.43 is in spec -- Verify 50.44 is out of spec 1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an Inspection: -- Verify 119.66 is out of spec -- Verify 119.70 is in spec -- Verify 120.33 is in spec -- Verify 120.34 is out of spec 1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an Inspection: -- Verify 119.93 is out of spec -- Verify 119.94 is in spec -- Verify 120.26 is in spec -- Verify 120.27 is out of spec 1. Verify spec is assembled and displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an Inspection: -- Verify 400.17 is out of spec -- Verify 400.16 is in spec -- Verify 399.84 is in spec -- Verify 399.83 is out of spec	
52	ISO fine mm defaults for Angle: Nominal value = 50.1 deg	Char = ANGLE Nominal = 50.1 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num	The Nom field should be non-null		
53	ISO fine mm defaults for Angle: Nominal value = 120.0 deg	Char = ANGLE Nominal = 120.0 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num	The Nom field should be non-null		
54	ISO fine mm defaults for Angle: Nominal value = 120.1 deg	Char = ANGLE Nominal = 120.1 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num	The Nom field should be non-null		
55	ISO fine mm defaults for Angle: Nominal value = 400.0 deg	Char = ANGLE Nominal = 400.0 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num	The Nom field should be non-null		
56	ISO fine mm defaults for Angle: Nominal value = 400.1 deg	Char = ANGLE Nominal = 400.1 + Tol = [leave empty] - Tol = [leave empty] Data Type = Num	The Nom field should be non-null	Default Tolerances should not be applied	
189	Test Specs with custom tolerances	Setup table of Custom Tolerances under defaults		Add specs without Tolerances	Defaults should be imported correctly
200	Display Feature-Level Work Instructions to Inspector	Add feature-level work instructions to the plan.		Verify work instructions on an inspection.	Work Instructions should be correctly displayed on Part View, Spec View, and Matrix (Spreadsheet view)

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
57	Create a New QC Plan FROM PDF DRAWING in DRAFT mode	Part Number, Revision	Ensure Part Number and Revision Combination are Unique	1. Try to create a Plan with a duplicate Part Number and Revision. 2. Create a Plan with a unique Part Number and Revision. Plan should be created in DRAFT mode	1. Plan should not be created if duplicate part number and revision 2. A Blank Quality Control Plan is created. Results in a blank QC Plan in DRAFT mode. Human action and review is required to create and release the plan	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. Plan should not be created if duplicate part number and revision 2. A Blank Quality Control Plan is created. Results in a blank QC Plan in DRAFT mode. Human action and review is required to create and release the plan
58	Add Balloon of type Nom +/- Tol	Char: diameter (or any other characteristic of size) Char Type: Nom +/- Tol Nom = 1.500 + Tol = 0.010 - Tol = 0.010 Data Type = Num	The Nom field should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, +Tol, and -Tol 3. In an inspection: -- Verify 1.489 is out of spec -- Verify 1.490 is in spec -- Verify 1.510 is in spec -- Verify 1.511 is out of spec	QC Plan: Diameter 1.500 +/- 0.010 Inspection Summary Table: Diameter 1.500 +/- 0.010 Data Entry Screens: Diameter 1.500 +/- 0.010 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.500 +/- 0.010 Inspection Summary Table: Diameter 1.500 +/- 0.010 Data Entry Screens: Diameter 1.500 +/- 0.010 Pass/Fail is calculated correctly (see Tests)
59	Add Balloon of type Nom +/- Tol	Char: diameter (or any other characteristic of size) Char Type: Nom +/- Tol Nom = 1.500 + Tol (Upper) = 0.050 + Tol (Lower) = 0.010 Data Type = Num	The Nom field should be non-null The upper tolerance should be greater than the lower tolerance	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, Upper Tol, and Lower Tol 3. In an inspection: -- Verify 1.509 is out of spec -- Verify 1.510 is in spec -- Verify 1.510 is in spec -- Verify 1.551 is out of spec	QC Plan: Diameter 1.500 +0.050 -0.010 Inspection Summary Table: Diameter 1.500 +0.050 -0.010 Data Entry Screens: Diameter 1.500 +0.050 -0.010 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.500 +0.050 -0.010 Inspection Summary Table: Diameter 1.500 +0.050 -0.010 Data Entry Screens: Diameter 1.500 +0.050 -0.010 Pass/Fail is calculated correctly (see Tests)
60	Add Balloon of type Nom +/- Tol	Char: diameter (or any other characteristic of size) Char Type: Nom +/- Tol Nom = 1.500 - Tol (Upper) = 0.002 - Tol (Lower) = 0.007 Data Type = Num	The Nom field should be non-null The upper tolerance should be greater than the lower tolerance Tolerance fields should be non negative	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom, Upper Tol, and Lower Tol 3. In an inspection: -- Verify 1.492 is out of spec -- Verify 1.493 is in spec -- Verify 1.498 is in spec -- Verify 1.499 is out of spec	QC Plan: Diameter 1.500 -0.002 -0.007 Inspection Summary Table: Diameter 1.500 -0.002 -0.007 Data Entry Screens: Diameter 1.500 -0.002 -0.007 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.500 -0.002 -0.007 Inspection Summary Table: Diameter 1.500 -0.002 -0.007 Data Entry Screens: Diameter 1.500 -0.002 -0.007 Pass/Fail is calculated correctly (see Tests)
61	Add Spec of type Reference	Char: diameter (or any other characteristic of size) Char Type: Reference Nom = 1.500 Data Type = Num	The Nom field should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom 3. In an inspection: -- Any value entered should be indeterminate	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)
62	Add Balloon of type Basic (i.e. Nominal only)	Char: diameter (or any other characteristic of size) Char Type: Basic Nom = 1.500 Data Type = Num	The Nom field should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. Check the number of decimal places for Nom 3. In an inspection: -- Any value entered is accepted without a Pass/Fail determination	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.500 Inspection Summary Table: Diameter 1.500 Data Entry Screens: Diameter 1.500 Pass/Fail is calculated correctly (see Tests)
63	Add Balloon of type Min - Max	Char: diameter (or any other characteristic of size) Char Type: Min - Max Nom = [leave empty] Min = 1.0 Max = 2.0 Data Type = Num	At least one of the three specification fields should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify 0.99 is out of spec -- Verify 1.0 is in spec -- Verify 2.1 is out of spec	QC Plan: Diameter 1.0 - 2.0 Inspection Summary Table: Diameter 1.0 - 2.0 Data Entry Screens: Diameter 1.0 - 2.0 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.0 - 2.0 Inspection Summary Table: Diameter 1.0 - 2.0 Data Entry Screens: Diameter 1.0 - 2.0 Pass/Fail is calculated correctly (see Tests)
64	Add Balloon of type Min Only	Char: diameter (or any other characteristic of size) Char Type: Min - Max Nom = [leave empty] Min = 1.0 Max = [leave empty] Data Type = Num	At least one of the three specification fields should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify 0.99 is out of spec -- Verify 1.0 is in spec -- Verify 2.1 is in spec	QC Plan: Diameter 1.0 MIN Inspection Summary Table: Diameter 1.0 MIN Data Entry Screens: Diameter 1.0 MIN Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 1.0 MIN Inspection Summary Table: Diameter 1.0 MIN Data Entry Screens: Diameter 1.0 MIN Pass/Fail is calculated correctly (see Tests)
65	Add Balloon of type Max Only	Char: diameter (or any other characteristic of size) Char Type: Min - Max Nom = [leave empty] Min = [leave empty] Max = 2.0 Data Type = Num	At least one of the three specification fields should be non-null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify 2.1 is out of spec -- Verify 2.0 is in spec -- Verify 0.9 is in spec	QC Plan: Diameter 2.0 MAX Inspection Summary Table: Diameter 2.0 MAX Data Entry Screens: Diameter 2.0 MAX Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Diameter 2.0 MAX Inspection Summary Table: Diameter 2.0 MAX Data Entry Screens: Diameter 2.0 MAX Pass/Fail is calculated correctly (see Tests)
66	Add Balloon of type GD&T Spec without MMC e.g. position 0.005	Char: position Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.005 Tol (Lower) = [leave empty] Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify .0051 is out of spec -- Verify .0049 is in spec	QC Plan: Position 0.005 Inspection Summary Table: Position 0.005 Data Entry Screens: Position 0.005 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Position 0.005 Inspection Summary Table: Position 0.005 Data Entry Screens: Position 0.005 Pass/Fail is calculated correctly (see Tests)
67	Add Balloon of type GD&T Spec with MMC e.g. position 0.00 (RMC)	Char: position Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.005 Tol (Lower) = [leave empty] Bonus = MMC Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify .0051 is out of spec -- Verify .0049 is in spec 3. Enter a Bonus Tolerance of .0001 -- Verify .0051 should now be in spec	QC Plan: Position 0.005 (MMC) Inspection Summary Table: Position 0.005 (MMC) Data Entry Screens: Position 0.005 (MMC) Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Position 0.005 (MMC) Inspection Summary Table: Position 0.005 (MMC) Data Entry Screens: Position 0.005 (MMC) Pass/Fail is calculated correctly (see Tests)
68	Add Balloon of type GD&T Spec special case: Surface Profile Outside Material e.g. profile of surface 0.005	Char: surface profile Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = 0.005 Tol (Lower) = [leave empty] Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify .0051 is out of spec -- Verify .0049 is in spec	QC Plan: Surface Profile (or Profile of Surface) 0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) 0.005 Data Entry Screens: Surface Profile (or Profile of Surface) 0.005 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Surface Profile (or Profile of Surface) 0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) 0.005 Data Entry Screens: Surface Profile (or Profile of Surface) 0.005 Pass/Fail is calculated correctly (see Tests)
69	Add Balloon of type GD&T Spec special case: Surface Profile Inside Material e.g. profile of surface -0.005	Char: surface profile Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = [leave empty] Tol (Lower) = -0.005 Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify -.0051 is out of spec -- Verify -.0049 is in spec	QC Plan: Surface Profile (or Profile of Surface) -0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) -0.005 Data Entry Screens: Surface Profile (or Profile of Surface) -0.005 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Surface Profile (or Profile of Surface) -0.005 Inspection Summary Table: Surface Profile (or Profile of Surface) -0.005 Data Entry Screens: Surface Profile (or Profile of Surface) -0.005 Pass/Fail is calculated correctly (see Tests)
70	Add Balloon of type GD&T Spec special case: Surface Profile Bilateral e.g. profile of surface -0.0025, +0.0025	Char: surface profile Char Type: GD&T Nom = [assumed to be 0] Tol (Upper) = +0.0025 Tol (Lower) = -0.0025 Bonus = RFS Data Type = Num	Both + Tol and -Tol cannot be null	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Verify -.0026 is out of spec -- Verify -.0025 is in spec -- Verify 0.0025 is in spec -- Verify 0.0026 is out of spec	QC Plan: Surface Profile -0.0025 + 0.0025 Inspection Summary Table: Surface Profile -0.0025 + 0.0025 Data Entry Screens: Surface Profile -0.0025 + 0.0025 Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Surface Profile -0.0025 + 0.0025 Inspection Summary Table: Surface Profile -0.0025 + 0.0025 Data Entry Screens: Surface Profile -0.0025 + 0.0025 Pass/Fail is calculated correctly (see Tests)
71	Add Balloon of type Note	Char: Any text (alpha-numeric and special characters) Data Type = Y/N	Characteristic cannot be empty	1. Verify spec is displayed correctly on Plan and Inspection screens. 2. In an inspection: -- Enter P or Pass for Pass -- Enter F or Fail for Fail -- Pass or Fail should be reflected correctly Add specs without Tolerances	QC Plan: Text is shown exactly as entered Inspection Summary Table: Text is shown exactly as entered Data Entry Screens: Text is shown exactly as entered Pass/Fail is calculated correctly (see Tests)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	QC Plan: Text is shown exactly as entered Inspection Summary Table: Text is shown exactly as entered Data Entry Screens: Text is shown exactly as entered Pass/Fail is calculated correctly (see Tests)
190	Test Specs with custom tolerances	Setup table of Custom Tolerances under defaults			Defaults should be imported correctly	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Defaults should be imported correctly
196	Add Ops Sheets	Open the Drawing tab on a plan. Click on "sheets" to add one or more drawings (Typically Ops Sheets). Add balloons on the Ops Sheets. Release Plan. Create an Inspection.		Verify that all balloons from Ops Sheets are correctly included in the Plan and in the Inspection.	All balloons from Ops Sheets should be correctly included in Plan and Inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All balloons from Ops Sheets should be correctly included in Plan and Inspection.
199	Create a Tabulated Family Plan where the Child Parts have revisions independent of the Family Plan	On the Part Masters Tile: Create a Tabulated (Family) Part Master Add child part masters and revisions under the TOS tab (P101 D, P202 A, P303 B).		Family Part Number and Revision (P123, E) Add child part masters and revisions under the TOS tab (P101 D, P202 A, P303 B).	Table of Sizes tab should appear on the Plan with the child Part Masters and Revisions. Inspection should reflect the Child Part Master and Revision (not the parent Revision)	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Table of Sizes tab should appear on the Plan with the child Part Masters and Revisions. Inspection should reflect the Child Part Master and Revision (not the parent Revision)

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
72	New Plan from "New Revision"	Existing Part Number & Revision, New Part Number (prefilled), New Revision	Ensure Part Number and Revision Combination are Unique	1. Create a New Plan for "New Revision". Plan should be created in DRAFT mode	1. x. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1. b. Balloons and Specs are copied from the Drawing associated with the Existing Part Number and Revision 1.a. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. x. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1. b. Balloons and Specs are copied from the Drawing associated with the Existing Part Number and Revision 1.a. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision.
73	Create a New Plan from "New Revision" for a Tabulated Plan	Existing Part Number & Revision, New Part Number (prefilled), New Revision.	Ensure Part Number and Revision Combination are Unique	1. Create a New Plan for "New Revision". Plan should be created in DRAFT mode	1. x. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1. b. Balloons are copied from the Drawing associated with the Existing Part Number and Revision 1.c. An empty table of sizes is created	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. x. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1. b. Balloons are copied from the Drawing associated with the Existing Part Number and Revision 1.c. An empty table of sizes is created

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
75	Create a New QC Plan from XLSX in DRAFT mode	Part Number, Revision	Ensure Part Number and Revision Combination are Unique. Ensure file type is XLSX.	1. Create a Plan with a unique Part Number and Revision. Plan should be created in DRAFT mode	1. A Quality Control Plan is created that matches the excel file being imported	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. A Quality Control Plan is created that matches the excel file being imported

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
76	Create a New QC Plan: CLONE a Plan	Part Number, Revision	Ensure Part Number and Revision Combination are Unique	1. Try to create a Plan with a duplicate Part Number and Revision. 2. Create a Plan with a unique Part Number and Revision	1. A plan cannot be created. 2. A Quality Control Plan is created that matches the Plan associated with the Existing Part Number and Revision. Plan should be created in DRAFT mode 1.a. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1.b. Balloons are copied from the Drawing associated with the Existing Part Number and Revision 1.c. An empty table of sizes is created 2. A plan cannot be created.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. A plan cannot be created. 2. A Quality Control Plan is created that matches the Plan associated with the Existing Part Number and Revision. Plan should be created in DRAFT mode 1.a. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1.b. Balloons are copied from the Drawing associated with the Existing Part Number and Revision 1.c. An empty table of sizes is created 2. A plan cannot be created.
77	Create a New QC Plan by "Clone" for a Tabulated Plan	Part Number, Revision	Ensure Part Number and Revision Combination are Unique	1. Try to create a Plan with a duplicate Part Number and Revision. 2. Create a Plan with a unique Part Number and Revision. Plan should be created in DRAFT mode	1. A plan cannot be created. 2. A Quality Control Plan is created that matches the Plan associated with the Existing Part Number and Revision. Plan should be created in DRAFT mode 1.a. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1.b. Balloons are copied from the Drawing associated with the Existing Part Number and Revision 1.c. An empty table of sizes is created 2. A plan cannot be created.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. A plan cannot be created. 2. A Quality Control Plan is created that matches the Plan associated with the Existing Part Number and Revision. Plan should be created in DRAFT mode 1.a. A Quality Control Plan is created that matches exactly the Plan associated with the Existing Part Number and Revision. 1.b. Balloons are copied from the Drawing associated with the Existing Part Number and Revision 1.c. An empty table of sizes is created 2. A plan cannot be created.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
79	Create a Tabulated Plan where each Child Part Master has same Revision as the Family Part Master	On the Part Masters Tile: Create a Tabulated (Family) Part Master. Load Tabulated Child Part Masters (TOS Entries) the Navigate to Plans. Create a New QC Plan by selecting Part Number and Revision. Set Plan Defaults: X.XX = 0.01 X.XXX = 0.005 Char Type = Nom +/- Tabulated = No Char = linear dimension Nom = 3.00 +Tol = [blank] -Tol = [blank] Data Type = Num Char Type = Nom +/- Tabulated = Yes Char = Diameter D1 Nom = [blank] +Tol = [blank] -Tol = [blank] Data Type = Num	Part Number and Revision (P123, A) Add child part masters under the TOS tab (P101, P202, P303)	Table of Sizes tab should appear on the Plan with the child Part Masters	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Table of Sizes tab should appear on the Plan with the child Part Masters	
80	Add a Non-Tabulated Spec of Data Type = Num	Plan Default Tol = 0.005 Char Type = Nom +/- Tabulated = Yes Char = Diameter D2 Nom = [blank] +Tol = 0.002 -Tol = 0.002 Data Type = Num	Add spec to plan	1. Should show up as a non-tabulated spec in QC Plan: linear dim 3.00 +0.01 -0.01.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Should show up as a non-tabulated spec in QC Plan: linear dim 3.00 +0.01 -0.01.	
81	Add a Tabulated "Nom +/-" Spec of Data Type = Num with tolerance defaults set at the PLAN level	Plan Default Tol = 0.005 Char Type = Nom +/- Tabulated = Yes Char = Diameter D2 Nom = [blank] +Tol = 0.002 -Tol = 0.002 Data Type = Num	Add spec to plan. Add at least one variant and a nominal with three places after the decimal (e.g. P101, 1.500)	1. Should show up as a tabulated spec in QC Plan: Diameter D1 TAB +0.005 -0.005, Data Type: T:NUM 2. Diameter D1 should show up as a column on Table of Sizes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Should show up as a tabulated spec in QC Plan: Diameter D1 TAB +0.005 -0.005, Data Type: T:NUM 2. Diameter D1 should show up as a column on Table of Sizes	
82	Add a Tabulated "Nom +/-" Spec of Data Type = Num with tolerance defaults set at the SPEC level	Plan Default Tol = 0.005 Char Type = Nom +/- Tabulated = Yes Char = Diameter D2 Nom = [blank] +Tol = 0.002 -Tol = 0.002 Data Type = Num	Add spec to plan	1. Should show up as a tabulated spec in QC Plan: Diameter D2 TAB +0.002 -0.002, Data Type: T:NUM 2. Diameter D2 should show up as a column on Table of Sizes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Should show up as a tabulated spec in QC Plan: Diameter D2 TAB +0.002 -0.002, Data Type: T:NUM 2. Diameter D2 should show up as a column on Table of Sizes	
83	Add a Tabulated "Nom +/-" Spec of Data Type = Num with tolerance defaults set at the SPEC level	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	1. Should show up as a tabulated spec in QC Plan: Diameter D3 BASIC TAB, Data Type: T:NUM 2. Diameter D3 should show up as a column on Table of Sizes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Should show up as a tabulated spec in QC Plan: Diameter D3 BASIC TAB, Data Type: T:NUM 2. Diameter D3 should show up as a column on Table of Sizes	
84	Add a Tabulated "Min/Max" Spec of Data Type = Num with tolerance defaults set at the SPEC level	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	1. Should show up as a tabulated spec in QC Plan: Color, Data Type: T:P/F 2. Color should show up as a column on Table of Sizes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Should show up as a tabulated spec in QC Plan: Color, Data Type: T:P/F 2. Color should show up as a column on Table of Sizes	
85	Add a Tabulated "Min/Max" Spec of Data Type = Num with tolerance defaults set at the SPEC level	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	1. Should show up as a tabulated spec in QC Plan: Coating Yes/No, Data Type: T:P/F 2. Coating Yes/No? should show up as a column on Table of Sizes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Should show up as a tabulated spec in QC Plan: Coating Yes/No, Data Type: T:P/F 2. Coating Yes/No? should show up as a column on Table of Sizes	
86	Add a Tabulated "Min Only" Spec of Data Type = Num with tolerance defaults set at the SPEC level	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	Inspection for part P202 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.650 + 0.005 -0.005 3. D2 2.100 +.002 -.002 4. D3 2.000 BASIC 5. Color= Red 6. Coating= Yes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Inspection for part P202 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.650 + 0.005 -0.005 3. D2 2.100 +.002 -.002 4. D3 2.000 BASIC 5. Color= Red 6. Coating= Yes	
87	Add a Tabulated "Max Only" Spec of Data Type = Num with tolerance defaults set at the SPEC level	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	Inspection for part P303 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.750 + 0.005 -0.005 3. D2 2.500 +.001 -.001 4. D3 3.000 BASIC 5. Color= Blue Important: Since Coating was set to "" (i.e. empty) the spec should not show up on the inspection	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Inspection for part P303 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.750 + 0.005 -0.005 3. D2 2.500 +.001 -.001 4. D3 3.000 BASIC 5. Color= Blue Important: Since Coating was set to "" (i.e. empty) the spec should not show up on the inspection	
88	Add a Tabulated BASIC Spec of Data Type = Num with tolerances set in the Table of Sizes	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	
89	Add a Tabulated "Note" Spec of Data Type = P/F	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	
90	Add a Tabulated "Note" Spec of Data Type = P/F THAT APPLIES TO ONLY CERTAIN VARIANTS	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add spec to plan	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	
91	Load Table of Sizes	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add data to Table of Sizes for Group Number P123 Rev A with Variant Part Numbers: P101, P202, P303: Use Test Data for Table of Sizes	Inspection for part P202 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.650 + 0.005 -0.005 3. D2 2.100 +.002 -.002 4. D3 2.000 BASIC 5. Color= Red 6. Coating= Yes	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Inspection for part P202 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.650 + 0.005 -0.005 3. D2 2.100 +.002 -.002 4. D3 2.000 BASIC 5. Color= Red 6. Coating= Yes	
92	Load Table of Sizes	Char Type = BASIC Tabulated = Yes Char = Diameter D3 Nom = [blank] Data Type = Num Char Type = Note Tabulated = Yes Char = Color Data Type = P/F Char Type = Note Tabulated = Yes Char = Coating Yes/No Data Type = P/F	Add data to Table of Sizes for Group Number P123 Rev A with Variant Part Numbers: P101, P202, P303: Use Test Data for Table of Sizes	Inspection for part P303 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.750 + 0.005 -0.005 3. D2 2.500 +.001 -.001 4. D3 3.000 BASIC 5. Color= Blue Important: Since Coating was set to "" (i.e. empty) the spec should not show up on the inspection	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Inspection for part P303 should include: 1. linear dimension 3.00 +0.005 -0.005 (from the non-tabulated spec) 2. D1 1.750 + 0.005 -0.005 3. D2 2.500 +.001 -.001 4. D3 3.000 BASIC 5. Color= Blue Important: Since Coating was set to "" (i.e. empty) the spec should not show up on the inspection	
229	Updating the Parent Tabulated Part Master's revision also updates the Tabulated Child (TOS Entry).	A user with "Manage Part Master" permission creates a tabulated part master with associated Tos entries.	Ensure that no duplicate part masters exist following the changes made in the input.	A user with "Manage Part Master" permission updates the revision of one of the parent tabulated part masters and hits Save.	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Tos entry revisions should automatically update to reflect the Parent Tabulated part master's revision.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
94	User receives a drawing in metric (mm) from a customer, but must convert the drawing to inches for measurement on the shop floor, and then must convert the inch measurements back to mm to report to the customer	Create a plan with two parameters: 1. A parameter with Unit = mm (2.54 +/- .254 mm) 2. A parameter with Unit = inch (1.500 +/- .005 inch)	On the Properties Tab, set Unit Conversion: mm to inch. In an Inspection created from this plan: 1. Parameter 2.54 +/- .254 mm must be converted to 0.10000 ± 0.00999* inch 2. Parameter 1.500 +/- .005 inch must not be converted	In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to inches. 2. Any dimensions with units inch must not be converted 0.089 should be out of spec 0.090 should be in spec 0.110 should be in spec 0.111 should be out of spec In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to mm. 2. Any dimensions with units inch must not be converted 37.9729 should be out of spec 37.9730 should be in spec 38.2270 should be in spec 38.2271 should be out of spec	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to inches. 2. Any dimensions with units inch must not be converted 0.089 should be out of spec 0.090 should be in spec 0.110 should be in spec 0.111 should be out of spec In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to mm. 2. Any dimensions with units inch must not be converted 37.9729 should be out of spec 37.9730 should be in spec 38.2270 should be in spec 38.2271 should be out of spec	
95	User receives a drawing in inch from a customer, but must convert the drawing to mm (metric) for measurement on the shop floor, and then must convert the mm measurements back to inch to report to the customer	Create a plan with two parameters: 1. A parameter with Unit = inch (1.500 +/- .005 inch) 2. A parameter with Unit = mm (2.50 +/- .02 mm)	On the Properties Tab, set Unit Conversion: inch to mm. In an Inspection created from this plan: 1. Parameter 1.500 +/- .005 inch must be converted to 38.100 ± 0.126* mm 2. Parameter 2.50 +/- .02 mm must not be converted	In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to inches. 2. Any dimensions with units inch must not be converted 0.090 should be out of spec 0.090 should be in spec 0.110 should be in spec 0.111 should be out of spec In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to mm. 2. Any dimensions with units inch must not be converted 37.9729 should be out of spec 37.9730 should be in spec 38.2270 should be in spec 38.2271 should be out of spec	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to inches. 2. Any dimensions with units inch must not be converted 0.090 should be out of spec 0.090 should be in spec 0.110 should be in spec 0.111 should be out of spec In an Inspection created from this Plan: 1. Any dimensions with units mm must be converted to mm. 2. Any dimensions with units inch must not be converted 37.9729 should be out of spec 37.9730 should be in spec 38.2270 should be in spec 38.2271 should be out of spec	

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
96	Assign specs to different Inspection Types (i.e. create sub-groups)	Create Inspection Types: 1. Setup 2. In Process 3. Final (Note: Inspection Type names will be different for each organization) For a spec assigned to all three inspection types, set inspection method and sampling to: 1. Setup: Caliper, 3 2. In Process: Caliper, 1 in 10 3. Final: CMM, C=0 1.0 or ORG C=0 1.0		Create a QC Plan. Assign specs: 1. To only one Inspection Type each (S, IP, F) 2. To two inspection Types each (S+IP, S+F, IP+F) 3. To all three Inspection Types (S+IP+F)	When an inspection is created, only the assigned specs should show up.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	When an inspection is created, only the assigned specs should show up.
97	Assign inspection method and sampling rules by Inspection Type			Create Inspections of type: 1. Setup 2. In Process 3. Final	1. The correct inspection method and sampling rule should show up for each spec based on Inspection Type.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. The correct inspection method and sampling rule should show up for each spec based on Inspection Type.
98	Create a First Article Inspection (Special Built-In Inspection type)	Create a Plan 1. Add specs of type Standard, Deviation, and Manufacturing		Create a First Article 1.a. Set FAI to "Exclude Manufacturing", then create an FAI 1.b. Set FAI to "Include All", then create an FAI	1.a. FAI should exclude MFG specs 1.b. FAI should include STD, DVN, and MFG specs	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1.a. FAI should exclude MFG specs 1.b. FAI should include STD, DVN, and MFG specs

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
99	Create a new Manufacturing Inspection from a Released Plan	[Assuming a Released Plan exists] Select Plan: Part Number + Rev 1. Enter Inspection Identifier 1 (required) 2. Enter Inspection Identifier 2 (optional) 3. Enter Lot Size 4. Select Switching 5. Select Inspection Type	System checks for duplicated Inspection Identifier 1	Create New Inspection	New Inspection is Created with the correct Meta Data. All Meta Data is logged in History.	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	New Inspection is Created with the correct Meta Data. All Meta Data is logged in History.
100	Create a new Mfg FAI from a Released Plan	[Assuming a Released Plan exists] 1. Select Plan: Part Number + Rev 2. Enter Inspection Identifier 1 (required) 3. Enter Inspection Identifier 2 (optional) 4. Select FAI Type 5. Select Number of Parts		Create New FAI	New FAI is Created with the correct Meta Data. All Meta Data is logged in History.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	New FAI is Created with the correct Meta Data. All Meta Data is logged in History.
101	Create a new Receiving Inspection from a Released Plan	[Assuming a Released Plan exists] 1. Select Plan: Part Number + Rev 2. Enter Inspection Identifier 1 (required) 3. Enter Inspection Identifier 2 (optional) 4. Enter Lot Size 5. Select Switching 6. Select Inspection Type	For a Receiving Inspection, Suppliers can be selected from: 1. A list of suppliers defined on a Plan 2. The complete list of suppliers if suppliers were not listed on the Plan	Create New Inspection	New Inspection is Created with the correct Meta Data. All Meta Data is logged in History. [BUG] Supplier Name not logged in History	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	New Inspection is Created with the correct Meta Data. All Meta Data is logged in History. [BUG] Supplier Name not logged in History
102	Create a new Receiving FAI from a Released Plan	After the inspection is created: 1. Set Supplier Name [Assuming a Released Plan exists] 1. Select Plan: Part Number + Rev 2. Enter Inspection Identifier 1 (required) 3. Enter Inspection Identifier 2 (optional) 4. Select FAI Type 5. Select Number of Parts	For a Receiving Inspection, Suppliers can be selected from: 1. A list of suppliers defined on a Plan 2. The complete list of suppliers if suppliers were not listed on the Plan	Create New FAI	New FAI is Created with the correct Meta Data. All Meta Data is logged in History. [BUG] Supplier Name not logged in History	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	New FAI is Created with the correct Meta Data. All Meta Data is logged in History. [BUG] Supplier Name not logged in History
103	Create an FAI from any row marked as "First Piece" in an Inspection	[Assuming a Released Plan exists, AND an Inspection has been created AND measurements entered] 1. In the "Measurements" (spreadsheet) view, select a row that needs to be reported as First Articles (this process can be repeated for up to 10 rows) 2. Click on mark N/C and mark selected row as First Piece 3. From the Inspection Summary page, click on "New FAI" to generate an FAI and transfer data from inspection to FAI		Click on New FAI	New FAI is Created with the correct Meta Data. All Meta Data is logged in History. Measurement data is copied from existing inspection to FAI.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	New FAI is Created with the correct Meta Data. All Meta Data is logged in History. Measurement data is copied from existing inspection to FAI.
104	Accept data as entered	Enter numeric data in an inspection (up to a total of 8 places after the decimal)		Enter numeric data. Close Inspection. Then reopen the inspection. Verify that the data has not changed.	Factory should save data as entered without any rounding.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Factory should save data as entered without any rounding.
105	Accept Attachments	Attach one or more files to an inspection		Attach files. Close inspection. Then reopen the inspection. Verify that attached files are listed correctly, and can be downloaded to desktop / opened in browser.	Attachments should be listed. Attachments can be downloaded / opened. Attachments should be logged in History	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Attachments should be listed. Attachments can be downloaded / opened. Attachments should be logged in History
184	User wants to sort by Inspection Method on the FAI measurement entry screen (Both Standard and AS9102)	User creates an FAI and then sorts by inspection Method.		Sort by Inspection Method. Unsort by clicking on Balloon Number.	Data should be captured against the correct feature. Work Instructions and Drawing Zones should be displayed for the correct feature.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Data should be captured against the correct feature. Work Instructions and Drawing Zones should be displayed for the correct feature.
185	User wants to sort by Inspection Method on Part View page	User creates a regular inspection, then navigates to the Part view, and then sorts by inspection Method.		Sort by Inspection Method. Unsort by clicking on Balloon Number.	Data should be captured against the correct feature. Work Instructions and Drawing Zones should be displayed for the correct feature.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Data should be captured against the correct feature. Work Instructions and Drawing Zones should be displayed for the correct feature.
193	Upload work orders to create inspections.	Load an excel file that has Standard Parts and Tabulated Parts (ToS Entries)		Create and release a plan with Three Inspection Types. Load excel file with list of Work Orders and Lot Sizes.	Inspections should be created for any Parts that have associated Released Plans. For each part, the system should create all required inspection types.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Inspections should be created for any Parts that have associated Released Plans. For each part, the system should create all required inspection types.
212	Ability to export a Partial AS9102 FAI	User creates an new AS9102 FAI and choses clicks on the "partial" FAI option on Form 1.	System requires a "reason" for Partial FAI to be able to make a disposition on the FAI.	Once Partial FAI is chosen, the user should now check the boxes of which features they wish to report when the FAI exported from the system on Form 3	Exported report only includes the features which were checked on Form 3.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Exported report only includes the features which were checked on Form 3.
216	Cannot create an inspection without a supplier identified.	Create an receiving inspection and fill out all the data except for the supplier.	System does not allow the inspection to be created until a supplier has been selected. System flags user.	Click Go to create inspection.	Unable to create inspection—user is prompted to select a supplier. Note: A supplier must be identified on the plan for it to appear as an option when creating the inspection. Samples size should reflect as per the following when rules applied.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Unable to create inspection—user is prompted to select a supplier. Note: A supplier must be identified on the plan for it to appear as an option when creating the inspection. Samples size should reflect as per the following when rules applied.
217	Lot switching (Normal, Reduced & Tightened)	Create a Receiving Plan with sampling rules of C=0 1.0 & Z1.4 II 0.	N/A	Create a Receiving Inspection with a lot size of 615. Within the "Lot & Switching" Tab toggle the rules between Normal, Reduced & Tightened.	Normal: C=0 1.0, Sample size 34 / Z1.4 II 10, Sample size 80 Reduced: C=0 1.5, Sample size 27 / Z1.4 II 10, Sample size 32 Tightened: C=0 0.65, Sample size 47 / Z1.4 II 10, Sample size 80	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Normal: C=0 1.0, Sample size 34 / Z1.4 II 10, Sample size 80 Reduced: C=0 1.5, Sample size 27 / Z1.4 II 10, Sample size 32 Tightened: C=0 0.65, Sample size 47 / Z1.4 II 10, Sample size 80
233	Ability to copy & paste data from one cell to another.	1. User creates an inspection against a released plan.	n/a	1. User enters data in the measurements view. 2. User then copies the cell via "CTRL+C" and then paste it in another cell via "CTRL+V".	Data is pasted and saved in the new cell. All Audit history is recorded.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Data is pasted and saved in the new cell. All Audit history is recorded.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
106	Move Plan from DRAFT to RELEASE	On Manage slideout, change status from DRAFT to RELEASE		On Manage slideout, change status from DRAFT to RELEASE. Enter signature	System should ask user for Signature before change plan status from DRAFT to RELEASE. Password must be valid.	PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	System should ask user for Signature before change plan status from DRAFT to RELEASE. Password must be valid.
107	Each Inspector signs for his/her own work.	User enters some or all required measurement data		Enter new data and verify whether Signature Box appears in header for the user that entered data	System recognizes that new data has been entered (since last signing if applicable) and offers user the header prompt to sign. 1. Inspector is asked to sign document by entering his/her password. 2. Inspection status changes to Accepted, Rejected or Pending depending on selection. Also displayed on List of Inspections page. 3. Changes are logged in Inspection History 4. User Name, Date and Time are displayed on the Manage tab after signing.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	System recognizes that new data has been entered (since last signing if applicable) and offers user the header prompt to sign. 1. Inspector is asked to sign document by entering his/her password. 2. Inspection status changes to Accepted, Rejected or Pending depending on selection. Also displayed on List of Inspections page. 3. Changes are logged in Inspection History 4. User Name, Date and Time are displayed on the Manage tab after signing.
108	An (any) Inspector Accepts or Rejects an Inspection or FAI	Click on Accept or Reject on the Manage tab	Check for missing attachments (if attachments were set to required on Properties)	1. Set Accept 2. Set Reject 3. Return to Pending	1. Reviewer is asked to sign document by entering his/her password. 2. Review status changes to Reviewed (check mark) on List of Inspections page 3. Changes are logged in Inspection History 4. Reviewer Name, Date and Time are displayed on the Manage tab after signing.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. Reviewer is asked to sign document by entering his/her password. 2. Review status changes to Reviewed (check mark) on List of Inspections page 3. Changes are logged in Inspection History 4. Reviewer Name, Date and Time are displayed on the Manage tab after signing.
109	A separate user or a manager Reviews an Inspection or FAI	Create an inspection for a plan with "attachments required" turned on within the plans properties. Click on the Reviewed button on the Manage tab. For E-signature accounts, the user must enter their password and click Save.	Check for missing attachments, if turned on in the plan. Assure ONLY user with the "Manage Inspections" Permissions can "Review the inspection"	1. Set Reviewed 2. Return to Pending	1. Reviewer is asked to sign document by entering his/her password. 2. Review status changes to Reviewed (check mark) on List of Inspections page 3. Changes are logged in Inspection History 4. Reviewer Name, Date and Time are displayed on the Manage tab after signing.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Reviewer is asked to sign document by entering his/her password. 2. Review status changes to Reviewed (check mark) on List of Inspections page 3. Changes are logged in Inspection History 4. Reviewer Name, Date and Time are displayed on the Manage tab after signing.
110	Entering or changing (or deleting) gage ID requires signature from Inspector	Enter a Gage ID in an Inspection Change a Gage ID in an Inspection Delete a Gage ID in an Inspection	Is the gage valid? Is it in Cal?	Enter / change /delete a gage ID	Gage ID should be captured in history. Initial entry or change or delete should require an e-signature	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Gage ID should be captured in history. Initial entry or change or delete should require an e-signature
111	1. Manual CMM upload should require signature.	User selects a Part or selects the Serial Number column. Then the user clicks on CMM Upload, and uploads a file. Run CMM Auto-Upload. Any data added via CMM auto-upload should not trigger an electronic signature requirement in the header.		Upload data from a CMM file	Once data is loaded, an option to sign must appear in the header.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Once data is loaded, an option to sign must appear in the header.
112	2. CMM auto-upload should not require signature.	User changes Inspection Status from Pending to Accept or Reject		Change Inspection Status from Pending to Accept or Reject		PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
113	A signature is required to Accept or Reject	User logs into IFactory, and is presented with a message and only option to Accept (and continue) or Reject (and leave). User should not be able to bypass initial signature by requesting "reset password" link		User logs into IFactory (with and without SSO)	System displays an initial signing message	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	System displays an initial signing message
114	An initial signature is required from every user (non read-only users)	User uploads data from an excel file		User uploads data from an excel file	Signature Box should appear in the header for the user that uploaded the data.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Signature Box should appear in the header for the user that uploaded the data.
115	Excel upload of data should require an e-signature	Create 6 inspections. Leave one Pending with data un-signed for. Set status of at least one inspection to Accepted. Set status of at least one inspection to Rejected. Change Reviewer status from Pending to Reviewed.	n/a	Of the 6 inspections, leave one Pending with data un-signed for. Set status of at least one inspection to Accepted. Set status of at least one inspection to Rejected. Change Reviewer status from Pending to Reviewed.	The updated status should be correctly reflected in the List of Inspections.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	The updated status should be correctly reflected in the List of Inspections.
116	Verify that % In-Spec is correctly calculated	Create a Plan and Inspection with two features. Record 9 measurements that pass, and one that fails for each measurement.		Verify that IFactory shows the correct % of parts in-spec		PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	
117	User with Manage Inspection Permissions needs to be able to sign off inspections for employees who have not returned to work to finish an inspection.	Manage Inspection user opens the "manage" tab in an inspection and signs off on or work still pending signatures.			After the Manage Inspection User signs, completed signature is visible to all users, and inspection is locked and cannot be edited.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	After the Manage Inspection User signs, completed signature is visible to all users, and inspection is locked and cannot be edited.
118	Inspection with signature left Pending have an Unsigned Status on the list of inspections.	User creates an inspection with at least one feature required to be measured.	System defaults to unsigned status until it verify all inspection has a signature for them in which the status is then changed to Pending.	Enter data into the inspection and leave your signature pending.	The inspection should have a "unsigned" status on the list of inspections.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	The inspection should have a "unsigned" status on the list of inspections.
119	Enforce rules when completing an inspection	1. User changes their inspection settings for enforce rules to Warn/Block for one or all of the enforcing rules (Sampling Rules, Gages Entered, Required Attachments, Receiving Inspection Identifiers).	Assures the user has permission to make inspection settings changes.	1. Users create an inspection that is incomplete for the measurements required to be recorded. 2. Users create an inspection that is missing a Gage ID that is required to be entered. 3. Users create an inspection that has a non valid Gage ID (expired, inactive, reference). 4. Users create an inspection that that has not had a file attached to it yet. 5. Users create a receiving inspection that is missing an Inspection Identifier.	For each of the test cases should Warn have been the setting chosen, then the user shall prompted with a Yes or No option to continue with closing out the inspection. For each of the test cases should Block have been the setting chosen, then the user shall prompted with a red flag stating to correct the issue before the inspection can be completed.	PASS	Nick Kelly	4/23/2025	PASS	Matthew Stanley	4/23/2025	For each of the test cases should Warn have been the setting chosen, then the user shall prompted with a Yes or No option to continue with closing out the inspection. For each of the test cases should Block have been the setting chosen, then the user shall prompted with a red flag stating to correct the issue before the inspection can be completed.
120	Ability to close an inspection with a Accepted with Deviation Status	1. User shall not have the Manage Inspection Permissions. 2. User creates an Inspection.	Assures the user has proper permissions to change the status to Accepted with Deviation.	1. User changes the inspection status to Accepted with Deviation.	The status cannot be changed unless the user has Manage Inspections permissions.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	The status cannot be changed unless the user has Manage Inspections permissions.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
118	Import data for ONE part from CMM file(s) MANUALLY	Output CMM file(s) from desired CMM Type (e.g. Zeiss/Calypro, PCDMIS, etc). Select part (row) in Spreadsheet view, then upload CMM file(s)		Select a part, and upload 1. One file per part 2. Multiple files per part	1. Data is written to the correct spec 2. Multiple Places parsed correctly 3. Features of size parsed correctly (e.g. diameter, linear dimension etc) 4. GD&T features parsed correctly 5. Bonus parsed correctly	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Data is written to the correct spec 2. Multiple Places parsed correctly 3. Features of size parsed correctly (e.g. diameter, linear dimension etc) 4. GD&T features parsed correctly 5. Bonus parsed correctly
119	Import data for MULTIPLE parts from CMM files MANUALLY	Output multiple CMM file from desired CMM Type (e.g. Zeiss/Calypro, PCDMIS, etc). Select part (row) in Spreadsheet view, then upload CMM file(s)		Select the Serial Number (Row Identifier) column, and upload: 1. CMM files for multiple parts; ONE file per part 2. CMM files for multiple parts; MULTIPLE files per part	1. Data is writtent to the correct row in the Inspection. Where two or more files are uploaded per part, make sure that the data is uploaded to the correct serial number 2. Data is written to the correct spec 3. Multiple Places parsed correctly 4. Features of size parsed correctly (e.g. diameter, linear dimension etc) 5. GD&T features parsed correctly 6. Bonus parsed correctly	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Data is writtent to the correct row in the Inspection. Where two or more files are uploaded per part, make sure that the data is uploaded to the correct serial number 2. Data is written to the correct spec 3. Multiple Places parsed correctly 4. Features of size parsed correctly (e.g. diameter, linear dimension etc) 5. GD&T features parsed correctly 6. Bonus parsed correctly
120	Import data from CMM files AUTOMATICALLY	Output a CMM file from desired CMM Type (e.g. Zeiss/Calypro, PCDMIS, etc) to the upload/n folder.			1. File is moved from "in" to "out". 2. Data is sent to the correct Inspection (Plan, Inspection Identifier, Inspection Type) 3. Data is written to the correct row in the Inspection 4. Data is written to the correct spec 5. Multiple Places parsed correctly 6. Features of size parsed correctly (e.g. diameter, linear dimension etc) 7. GD&T features parsed correctly 8. Bonus parsed correctly	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. File is moved from "in" to "out". 2. Data is sent to the correct Inspection (Plan, Inspection Identifier, Inspection Type) 3. Data is written to the correct row in the Inspection 4. Data is written to the correct spec 5. Multiple Places parsed correctly 6. Features of size parsed correctly (e.g. diameter, linear dimension etc) 7. GD&T features parsed correctly 8. Bonus parsed correctly
215	User has ability to add configurable Start & End delimiters for CMM uploads.	Set Start & End delimiter within the CMM section of the organizational settings. Le Start = "a" End = " " _	System checks for matching balloon number within plan once based on Start & End Delimiter.	Upload A CMM File that includes feature identified with the Start & End delimiter and ones that do not.	Only data for the features identified with the Start & Delimiter are imported.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Only data for the features identified with the Start & Delimiter are imported.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
121	Identify incomplete and complete inspections	Create an inspection		1. Enter lot size. 2. Enter measurement data for multiple parts and features. 3. On the Inspection Summary page, filter the Progress bar to identify Complete and Incomplete features.	User should be able to filter the Progress bar to identify Incomplete and Complete features.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	User should be able to filter the Progress bar to identify Incomplete and Complete features.
122	Calculate Percentage Parts In-Spec	Create an inspection		Enter measurement data	1. User should be able to see the Parts in Spec % from the List of Inspections page.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. User should be able to see the Parts in Spec % from the List of Inspections page.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
123	Add a new Gage Manually (i.e. one-at-a-time)	1. Set-up List of Values for Gage type, Make, Model etc. 2. Set-up List of Values for Storage Locations and Usage Locations 3. Add a Single Gage		Add a single Gage	A new gage is created without a Calibration status	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	A new gage is created without a Calibration status
124	Add multiple Gages via Upload	1. Set-up List of Values for Gage type, Make, Model etc. 2. Set-up List of Values for Storage Locations and Usage Locations 3. Upload a List of Gages (including Standard, Master, Reference gages, fixtures)	Column headers must match 1factory's standard column names	Upload a List of Gages	1. Gages should be imported correctly 2. Calibration due-dates should be set correctly 3. Standard, Master, Reference Only gages should be classified correctly	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	1. Gages should be imported correctly 2. Calibration due-dates should be set correctly 3. Standard, Master, Reference Only gages should be classified correctly
125	Calibrate a Variable / Numeric Gage In-House	Setup an In-House Calibration: Nominal = 0.250 * Tol = 0.0003 ^ Tol = 0.0001	1. The default "After Calibration" setting should be "Out of Calibration" unless cal data is entered, and complete (i.e. values for actuals are entered for all rows). 2. Master gage should be highlighted in red if it is invalid	1. Enter Measurements for Condition Before and Condition After (if required) Actual Before = 0.2502 Actual After = 0.2499	1. Condition Before should be out-of-cal 2. Condition After should be in-cal 3. New calibration due-date should be set correctly 4. Calibration status should be set correctly	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	1. Condition Before should be out-of-cal 2. Condition After should be in-cal 3. New calibration due-date should be set correctly 4. Calibration status should be set correctly
126	Update calibration record for a Gage after calibration at vendor	1. Create a New Calibration		1. Set calibration status After to In-Calibration (default) 2. Optionally upload a calibration cert from a vendor	1. Calibration Date and Calibration Due-Date should be set correctly. 2. Calibration status should be set correctly 1. If Gage is in-calibration, system shows green-check-mark 2. If Gage is out-of-calibration, system shows red circle 3. If Gage ID is not recognized, system shows a "?" 4. If Gage ID corresponds to a Reference Only gage, system shows red circle 5. If Gage ID corresponds to a Fixture, system shows grey circle (no calibration required)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. Calibration Date and Calibration Due-Date should be set correctly. 2. Calibration status should be set correctly 1. If Gage is in-calibration, system shows green-check-mark 2. If Gage is out-of-calibration, system shows red circle 3. If Gage ID is not recognized, system shows a "?" 4. If Gage ID corresponds to a Reference Only gage, system shows red circle 5. If Gage ID corresponds to a Fixture, system shows grey circle (no calibration required)
127	Log Gage IDs on the Gage Tab in Inspections to ensure Gages are in calibrations and are traceable	1. Log gage ID for a single gage (standard, reference only, fixture, master) 2. Log gage IDs for compound gages 3. Log gage IDs for multiple gages	System verifies gage calibration as of the date the Gage ID is recorded.	Calibration date and status should match data under the Gage tab.		PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	
128	Perform a Gage Recall	Enter the suspect gage ID in the search box on the List of Inspections page. Alternatively, see all the Gage Transactions under Gage			System returns a List of Inspections that used that Gage ID	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	System returns a List of Inspections that used that Gage ID
129	Find a list of calibrations that used a specific Master Gage	Enter the suspect master gage ID in the search box on the List of Gages page			System returns a List of Gages that used that Master Gage ID for calibrations (as well as the Master Gage listing itself)	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	System returns a List of Gages that used that Master Gage ID for calibrations (as well as the Master Gage listing itself)
130	Anytime calibration record changes state between "before" and "after", the user MUST select action taken and add a note.		Out-of-Cal until passing calibration data is entered. All rows with a check must be filled completely before Out-of-Cal status changes.			PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	
177	Verify Reference Gage Functionality	User adds a gage and sets it to Reference Gage.			The calibration tab should be disabled. gage should show special calibration status of "Reference Only".	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	The calibration tab should be disabled. gage should show special calibration status of "Reference Only".
178	Cloning a Gage should copy over Calibration Template	User creates a new Gage ID in the system by cloning from an existing gage.			System should copy over the calibration template from the first calibration.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	System should copy over the calibration template from the first calibration.
179	Recalibration should inherit template from the Facts page	User calibrates a gage for a second time (or any time after the first calibration)		Calibrate a Gage for the first time. Calibrate the gage for a second time.	System should pull in the calibration template from the facts page	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	System should pull in the calibration template from the facts page
180	Calibrate an Attribute / Pass/Fail Gage In-House	Setup an In-House Calibration: Nominal = 0.250 * Tol = 0.0001 ^ Tol = 0.0001	1. The default "After Calibration" setting should be "Out of Calibration" unless cal data is entered, and complete (i.e. values for actuals are entered for all rows). 3. Master gage should be highlighted in red if it is invalid	1. Enter Measurements for Condition Before and Condition After (if required) Actual Before = FALSE Actual After = TRUE	1. Condition Before should be out-of-cal 2. Condition After should be in-cal 3. New calibration due-date should be set correctly 4. Calibration status should be set correctly	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	1. Condition Before should be out-of-cal 2. Condition After should be in-cal 3. New calibration due-date should be set correctly 4. Calibration status should be set correctly
182	Prevent updates to historical calibration records	User attempts to modify a historical calibration record.	Don't allow updates to previous calibration records - only the current (most recent) record can be updated.	Open an older calibration record (not the most recent calibration record) for a gage. Attempt to modify the data entered in the calibration record.	Fields should be read-only. System should not allow modification of historical calibration record.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	Fields should be read-only. System should not allow modification of historical calibration record.
188	Print Gage Label per account settings	1. User sets the gage barcode setting to one of the options in the gage setting (Code-39, Code-128, Data Matrix or QR code). Upload a spreadsheet of Gages.	n/A	1. User hits the Barcode button.	1. A label shall be exported with the Gage ID, Last Cal, Cal due date and Calibrations Labels (if any).	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	1. A label shall be exported with the Gage ID, Last Cal, Cal due date and Calibrations Labels (if any).
204	Import a List of Gages	1. User creates Active & Inactive reasons in their accounts List of Values.		Verify last Cal Date and Cal Due Date	2. Scanning the barcode shall return the Gage ID. Gage Calibration Dates must be imported in the User's Time Zone.	PASS	Nick Kelly	4/23/2025	PASS	Matthew Stanley	4/23/2025	2. Scanning the barcode shall return the Gage ID. Gage Calibration Dates must be imported in the User's Time Zone.
238	A reason is required to make a gage active or inactive.	1. User sets their account setting for CAL BEFORE USE to require a validity date for when the gage will be marked Expired to 90 days.	Assure users has proper to permissions to add to the List of Values.	1. User changes a gage from active to inactive. 2. User changes a gage from inactive to active.	In both scenarios, the user shall not be able to save the change to the gages status without choosing a reason from he dropdown.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	In both scenarios, the user shall not be able to save the change to the gages status without choosing a reason from he dropdown.
239	User sets Cal Before Use Validity		Assure the user has permissions to make changes to the gage settings.	1. Create or use a gage marked as CAL BEFORE USE with a Last Cal date or more than 90 days ago	The gages outside of the 90 day window shall be marked EXPIRED.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	The gages outside of the 90 day window shall be marked EXPIRED.
240	A Valid Master Gage shall be required for in-house calibration	1. One gage that is marked as Master with an OK TO USE status. 2. One gage that is marked as Master with an EXPIRED status. 3. One gage that is marked as Standard.	Assure the gage ID has not been used already.	1. Perform an In-house calibration using a Master Gage with an OK TO USE status. 2. Perform an In-house calibration using a Master Gage with an EXPIRED status. 3. Perform an In-house calibration using a Standard Gage	1. Calibration can be Saved. 2. Calibration cannot be saved and a red warning shall be displayed. 3. Calibration cannot be saved and a red warning shall be displayed.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	1. Calibration can be Saved. 2. Calibration cannot be saved and a red warning shall be displayed. 3. Calibration cannot be saved and a red warning shall be displayed.
241	User is required to signoff on a calibration (E-signature)	1. User completes a calibration on a gage.	Assures the user has permissions to conduct a calibration.	1. User hits save without typing in their password on the calibration slide out.	The user will not be able to save the calibration until a valid password for the user signed in is entered. Once saved, any changes shall require a new signature.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	The user will not be able to save the calibration until a valid password for the user signed in is entered. Once saved, any changes shall require a new signature.
244	Calibration is Template required for in-house calibrations	1. User creates a gage template, with function that require 1, 2 & 3 Master gages.	Assures a templates with the same name does not already exist.	1. User conducts a calibration for a gage where the template created is chosen for the gage.	1. The values entered are properly evaluated against the functional tolerances. 2. All fields requiring master gages must be completed for the calibration to be saved. 3. The template is recorded in the History, and previously conducted calibrations become read-only if a new template is used at a later date.	PASS	Nick Kelly	3/12/2025	PASS	Matthew Stanley	3/24/2025	1. The values entered are properly evaluated against the functional tolerances. 2. All fields requiring master gages must be completed for the calibration to be saved. 3. The template is recorded in the History, and previously conducted calibrations become read-only if a new template is used at a later date.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
	Settings: Set Company-wide Time Zone and/or User Time Zone. Ensure all Time Stamps display data in local Time Zone. (Note: Time stamps are always saved in UTC)	Set Time Zone under Settings		Enter measurement data	Verify that data date and time stamp is accurate	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Verify that data date and time stamp is accurate
132	Verify measurement data is saved / stored correctly	Enter measurement data		Restart server	Data should be saved to database and not lost after restart. 1- Data from both users should be recorded and the audit history show the correct user. 2- If a user overwrites another's data, they should receive an alert indicating that data has already been entered in that cell by another user and refresh to display the updated data. 3- The data shall be overwritten and the changes to the data logged in the audit history.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Data should be saved to database and not lost after restart. 1- Data from both users should be recorded and the audit history show the correct user. 2- If a user overwrites another's data, they should receive an alert indicating that data has already been entered in that cell by another user and refresh to display the updated data. 3- The data shall be overwritten and the changes to the data logged in the audit history.
133	Test two users entering data in the same inspection.	Create an inspection that allows two users to work on it simultaneously from separate computers.		1- Both users input data for the same inspection lot, but in different sections of the inspection. 2- One user unknowingly overwrites the other user's data within the refresh window (5 minutes). 3- One user overwrites the other user's data.		PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
134	Test Plan Change History	Take an existing QC Plan, and make the following changes: 1. Add a spec. 2. Change an Inspection Method 3. Change a Sampling Rule 4. Change Inspection Type Assignments 5. Add or change a Default tolerance 6. Delete a Spec. User enters data in multiple specs. Then overwrites some measurements. User enters Serial Number (Row Identifier), and/or Group Identifier information. "Admin" user attempts to delete an Object (Plan, Inspection etc.)		Verify that all changes are recorded in Plan history	All changes to QC Plan should be recorded	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All changes to QC Plan should be recorded
135	Test Measurement Audit			1. Verify that initial, overwritten and deleted measurements are recorded in Measurement audit. 2. Verify that initial, overwritten and deleted row and group identifiers are recorded in Measurement audit.		PASS	Matthew Stanley	3/10/2025	PASS	Nick Kelly	3/13/2025	
136	Test Object Delete History Log		Only "Admin" can delete an object.	Verify that object is deleted from List, and added to Delete History	Object is deleted and added to delete history	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Object is deleted and added to delete history
137	Ensure that all Exec Output Reports have a Unique Identifier that matches the Object (e.g. Inspection) the report was created from.	Search for an inspection record by entering the Unique ID.		On the List of Inspections page, enter the Inspection Unique ID.	1. System should return the Inspection that matches that Unique ID 2. Note: For Composite Inspections, user can only search by Parent Inspection Unique ID.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. System should return the Inspection that matches that Unique ID 2. Note: For Composite Inspections, user can only search by Parent Inspection Unique ID.
138	Test Inspection History Tab	For changes to Inspection Record (other than measurements): 1. Record gage IDs in Inspection History 2. Record inspection identifier 1 and 2 in inspection history 3. Record Comments: Part Level, Feature Level, Measurement Level in History 4. Lot Size and Switching Rules 5. Record Comments from the Manage tab in History				PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	
139	Balloon renumbering (from either Add Spec or Add Balloon) must be captured in Plan History	User balloons some features, then deletes a feature from: 1. The table 2. The drawing Then the user clicks on Renumber. As Admin: 1. Change a User's First Name, Last Name, Email Address, Role. 2. Change a User's password		User balloons 10 features, then deletes a feature from: 1. The table 2. The drawing Then the user clicks on Renumber.	The old and new balloon numbers should be logged in History	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	The old and new balloon numbers should be logged in History
140	User History should record all changes to users				All changes to User record are displayed in History accessed by clicking on the "three-dots" menu at the end of each row.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All changes to User record are displayed in History accessed by clicking on the "three-dots" menu at the end of each row.
141	Note: Ifactory provides a number of controls for user authentication. These include: 1. Minimum password length and complexity (enforced by Ifactory) 2. Limit number of unsuccessful logins (company setting) 3. Prevent password reuse for 3 generations (enforced by Ifactory) 4. Auto-log-out after period of inactivity (company settings) 5. Password reset intervals (company settings)					PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
142	Passwords should meet minimum length and complexity requirements (these requirements are defined by Ifactory)	Create or change a password.	An error message should displayed if password entered is fewer than 8 characters or if minimum complexity is not met	1. Create a password with fewer than 8 characters. 2. Create a password that does not meet minimum requirements as displayed on screen	An error message is displayed.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	An error message is displayed.
181	Gage Calibration History	Add Actual before, Actual After to history - need to map record back to cal data (record function and nominal as labels changed to recording row number instead, as function may not be entered, and function/nominal could change) Add Notes to History Add deletion of calibration records to history			Gage History should record the following from every calibration: 1. Actual Before 2. Actual After 3. Notes 4. Deletion of Calibration records	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Gage History should record the following from every calibration: 1. Actual Before 2. Actual After 3. Notes 4. Deletion of Calibration records
209	IP restrictions prevent login from non-approved IP's					PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
223	Delete notes required to delete inspections for users with Manage Inspections permissions.	Users creates an inspection.	Verify a text is placed into the delete notes to be able to complete deleting an inspection.	1- Delete an inspection and leave a note "test" and hit save. 2- Delete an inspection and hit save.	1- Inspection is deleted and note of "test" is recorded in the delete history with the date, time and who deleted the inspection. 2- Inspection is not deleted and system flags user they must leave a note to delete an inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- Inspection is deleted and note of "test" is recorded in the delete history with the date, time and who deleted the inspection. 2- Inspection is not deleted and system flags user they must leave a note to delete an inspection.
228	User Activity log should record all sign in & sign out activity (E- accept the "Initial Signature" accounts ONLY). 2. User log offs via the Logout feature found by clicking on their name in the top right corner and clicking "Logout"	1. User signs in and clicks on "Accept" upon the initial login to accept the "Initial Signature". 2. User log offs via the Logout feature found by clicking on their name in the top right corner and clicking "Logout"	Should the user "Decline" upon the "Initial Signature", the user is logged out automatically.	Go to the User Activity log found under the Master Data tab > Users Tile and selecting the users name that performed the inputs of the test.	When viewing the "Activity log" of the user, it should reflect the users name and time of log-in's and logoff's.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	When viewing the "Activity log" of the user, it should reflect the users name and time of log-in's and logoff's.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
169	Add a Part Master manually					PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	
170	Add a Part Master from an Import					PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
171	Create a BoM manually					PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
172	Add a BoM from an Import					PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
234	Clone an Active Part Master	1. User creates a Part Master with a BOM i.e. BOM_A 2. User creates a Part Master that is Tabulated i.e. TAB_A 3. User create Part Master that is a spec library i.e. SPEC_S	Verifies a duplicate Part Master does not exist before creating the Part Master.	1. Users create a new Part Master by cloning a previously created Part Master and updating either the Part Number or Part Revision. 2. This step is repeated for each input scenario.	All information from the cloned Part Master SHALL be present in the cloned Part Master	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All information from the cloned Part Master SHALL be present in the cloned Part Master

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
143	Change or correct a default tolerance	Change default tolerance for .XXX from .015 to .0015	N/A	Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The corrected tolerance should be shown in the Inspection 3. Pass/Fail should be recalculated if data was previously entered	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The corrected tolerance should be shown in the Inspection 3. Pass/Fail should be recalculated if data was previously entered
144	Add a specification	Add a Spec		Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The spec that was added should be shown in the Inspection	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The spec that was added should be shown in the Inspection
145	Delete a specification	Delete a spec		Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The spec that was deleted should no longer be shown in the Inspection	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The spec that was deleted should no longer be shown in the Inspection
146	Change an Inspection Method	Change an Inspection Method		Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The inspection method that was updated should be displayed correctly.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The inspection method that was updated should be displayed correctly.
147	Change a Sampling Rule	Change a Sampling Rule		Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The sampling rule that was updated should be displayed correctly. Sample size should be recalculated (if possible)	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The sampling rule that was updated should be displayed correctly. Sample size should be recalculated (if possible)
148	Remove a feature from an Inspection Type	Remove a feature from an inspection Type		Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The features that were removed from the inspection Type should no longer be included in the Inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The features that were removed from the inspection Type should no longer be included in the Inspection.
149	Add a feature to an Inspection Type	1. Create an inspection of any inspection type 2. Return to the Plan, create a new draft version, and assign one or more features to the above inspection Type		Release Plan. Up-version button should appear on the Inspection page indicating that Factory has detected that the Version of the Inspection does not match with the Version of the Plan. In the Inspection, click on Up Version.	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The features that were assigned to the inspection Type should now be included in the Inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. The inspection should be up-versioned to match the latest Plan (The Version shown on the Inspection should match with the Version on the Plan) 2. The features that were assigned to the inspection Type should now be included in the Inspection.
186	Only users with "Manage Plans" can Up-Version (Users cannot up-version)	An inspection should be created against a Plan. After creating the inspection, create a new version and release the Plan the inspection was made against.		A "Inspection user" attempts to up-version the plan.	Note: All user without the "Manage Plans" permissions shall not be able up-version an inspection. "Inspection" is not permitted to Up-Version the Plan.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Note: All user without the "Manage Plans" permissions shall not be able up-version an inspection. "Inspection" is not permitted to Up-Version the Plan.
235	Up-version all Pending Inspections from the Plan.	1. The user creates a plan and releases it for inspection. 2. The user creates two inspections against the plan, leaving one Pending and marking the other as Complete (Accepted, Rejected, or Accepted with Deviation). 3. The user moves the plan back to draft, then re-releases it for inspection.	1. The previous version plan is not available for inspection.	1. Once the plan is released, navigate to the "Usage" tab on the plan and hit the "UPVER Inspections" button.	1. Only Pending inspections linked to the previous version of the plan will be displayed in the Usage tab. 2. When the UPVER button is clicked, all Pending inspections are updated to the latest version of the plan. Previously completed inspections (Accepted, Rejected, or Accepted with Deviation) will not be upversioned. 3. The History tab of the upversioned inspection will record who performed the upversion and when it was done.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Only Pending inspections linked to the previous version of the plan will be displayed in the Usage tab. 2. When the UPVER button is clicked, all Pending inspections are updated to the latest version of the plan. Previously completed inspections (Accepted, Rejected, or Accepted with Deviation) will not be upversioned. 3. The History tab of the upversioned inspection will record who performed the upversion and when it was done.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
150	Set sampling rule to 100%	Define sampling rule in the plan	Enter a lot size of 365		Sample size should be 365	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Sample size should be 365
151	Set sampling rule to 1 in 5	Define sampling rule in the plan	Enter a lot size of 365		Sample size should be 365/5 = 73. Inspection data entry screens should have every 5th row in white starting with the first row	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Sample size should be 365/5 = 73. Inspection data entry screens should have every 5th row in white starting with the first row
152	Set sampling rule to a fixed quantity (e.g. 13)	Define sampling rule in the plan	Enter a lot size of 365		Sample size should be 13	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Sample size should be 13
153	Set sampling rule C=0 1.0	Define sampling rule in the plan	Enter a lot size of 365		Lot size = 500; Sample Size = 29	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Lot size = 500; Sample Size = 29
154	Set sampling rule to ORIG C=0 1.0 (i.e. old revision)	Define sampling rule in the plan using the "Original C=0" plan	Enter a lot size of 150		Lot size = 150; Sample Size = 13	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Lot size = 150; Sample Size = 13
155	Set sampling to C=0 1.0 (i.e. new revision)	Define sampling rule in the plan using the "C=0" plan	Enter a lot size of 150		Lot size = 150; Sample Size = 19	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Lot size = 150; Sample Size = 19

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
173	Common Permissions "User" needs to add a New user to an account that has SSO enabled	On boarding page should prompt user to enter password if SSO AND Esignatures enabled.	Should include explanatory text on both pages that password is used for signing only (not for login)	Add a New User in the Identity Provider (e.g. Okta, Azure AD, Cisco Duo etc.). [This test will need to be run by the end customer]	User receives an email to complete the sign-up process. Clicking on the link takes user to a page where he/she sets up their signing password.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	User receives an email to complete the sign-up process. Clicking on the link takes user to a page where he/she sets up their signing password.
174	Common Permissions "User" needs to reset the password for an account that has SSO enabled	Common Permissions "User" should be able to reset forgotten password, via 'reset password' button on User slide-out.		Add New User with the same user email in 3Factory.	User receives an email with a link to reset password.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	User receives an email with a link to reset password.
175	User resets his/her own password for an account that has SSO enabled	User should be able to reset forgotten password, via 'Forgot password' on login page.		Common Permissions "User" navigates to the Users menu, selects a User, and clicks on Reset Password Link.	User receives an email with a link to reset password.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	User receives an email with a link to reset password.
176	User changes her/her own password for an account that has SSO enabled	User should be able to change password, via change password page		Click on "forgot password"	User enters current password and new password to change password.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	User enters current password and new password to change password.
227	User Permissions & Modules are function as designed.	Update user permissions based on the "1Factory Permissions Test Matrix" within the attachments.	N/A	See Matrix	User permissions function Per Matrix.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	User permissions function Per Matrix.
242	User can create a new user by cloning a current users permissions & QMS Roles	1. Create or choose a user with known set of Permission and QMS Roles.	Assures no users in the database with the email for the user already.	1. User create a new user and choosing the clone the permission from the user defined in the inputs.	All permissions and QMS Roles Shall be identified on the new users facts page.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All permissions and QMS Roles Shall be identified on the new users facts page.
246	Restrict Access to CAPA & Complaints (Issues)	1. User change account setting for restricting access to CAPA's & Complaints to YES.	Assures the user has permissions to make the setting change.	3. User creates an Issue and makes themselves the owner and cc'ed one other user.	Only the Owner and the user cc'ed in the Manage tab of the Issue can view the Issue.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Only the Owner and the user cc'ed in the Manage tab of the Issue can view the Issue.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
161	Output an Inspection Summary Report	Setting: Precision: Data as entered. Rounding: No rounding 1. Enter measurement data in an inspection 2. Use Mark Row/Column to add Part-level and Feature-level comments 3. Use Manage tab to add Inspection-level comments 4. Filter Inspection Summary Table by Inspection Method or Spec Type 5. Use Manage tab to set Accept/Reject and Reviewed by		1. Verify inspection headers 2. Verify measurement data 3. Verify Feature-level comments (Part-level will not show up) 4. Repeat test by Filtering by Inspection Method or Spec Type and then running the report	1. Inspection headers must match exactly 2. Min and Max of measurement data should be calculated correctly Note: -- Min and Max of features with multiple places e.g. 3x is calculated across all the places -- Min and Max values are shown with a fixed number of decimal places (4) 3. Feature-level and inspection level comments show up on the report 4. Inspector names should show up on the report (shows all inspectors that entered data) 5. Status Accepted / Rejected should show up on report 6. Report should be filtered to match list of features on the Inspection Summary page	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Inspection headers must match exactly 2. Min and Max of measurement data should be calculated correctly Note: -- Min and Max of features with multiple places e.g. 3x is calculated across all the places -- Min and Max values are shown with a fixed number of decimal places (4) 3. Feature-level and inspection level comments show up on the report 4. Inspector names should show up on the report (shows all inspectors that entered data) 5. Status Accepted / Rejected should show up on report 6. Report should be filtered to match list of features on the Inspection Summary page
162	Output a Specifications as Columns Reports	Setting: Precision: Data as entered. Rounding: No rounding 1. Enter measurement data in an inspection 2. Use Mark Row/Column to add Part-level and Feature-level comments 3. Use Manage tab to add Inspection-level comments 4. Optionally Filter Inspection Summary Table by Inspection Method or Spec Type 5. Use Manage tab to set Accept/Reject and Reviewed by		1. Verify inspection headers 2. Verify measurement data 3. Verify Feature-level comments (Part-level will not show up) 4. Repeat test by Filtering by Inspection Method or Spec Type and then running the report	1. Inspection headers must match exactly 2. All measurement data must match what was entered in the system 3. Feature-level and inspection level comments show up on the report 4. Inspector names should show up on the report (shows all inspectors that entered data) 5. Status Accepted / Rejected should show up on report 6. Report should be filtered to match list of features on the Inspection Summary page	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Inspection headers must match exactly 2. All measurement data must match what was entered in the system 3. Feature-level and inspection level comments show up on the report 4. Inspector names should show up on the report (shows all inspectors that entered data) 5. Status Accepted / Rejected should show up on report 6. Report should be filtered to match list of features on the Inspection Summary page
163	Output a Specifications as Rows Reports	Setting: Precision: Data as entered. Rounding: No rounding 1. Enter measurement data in an inspection 2. Use Mark Row/Column to add Part-level and Feature-level comments 3. Use Manage tab to add Inspection-level comments 4. Optionally Filter Inspection Summary Table by Inspection Method or Spec Type 5. Use Manage tab to set Accept/Reject and Reviewed by		1. Verify inspection headers 2. Verify measurement data 3. Verify Feature-level comments (Part-level will not show up) 4. Repeat test by Filtering by Inspection Method or Spec Type and then running the report	1. Inspection headers must match exactly 2. All measurement data must match what was entered in the system 3. Feature-level and inspection level comments show up on the report 4. Inspector names should show up on the report (shows all inspectors that entered data) 5. Status Accepted / Rejected should show up on report 6. Report should be filtered to match list of features on the Inspection Summary page	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Inspection headers must match exactly 2. All measurement data must match what was entered in the system 3. Feature-level and inspection level comments show up on the report 4. Inspector names should show up on the report (shows all inspectors that entered data) 5. Status Accepted / Rejected should show up on report 6. Report should be filtered to match list of features on the Inspection Summary page
164	From a First Article Inspection, output a FAI report	Setting: Precision: Data as entered. Rounding: No rounding Change Settings for Reports output (gage/calibration) from No to Yes FAI Type: AS9102 or Standard 1. AS9102 - Form 1,2,3 Standard output				PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	
165	Output gage ID and calibration to reports	Settings: Precision: Data as entered. Rounding: No rounding Change Settings for Reports output (gage/calibration) from No to Yes	Run		Inspection reports must include the Gage ID and Calibration Due Date	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Inspection reports must include the Gage ID and Calibration Due Date
167	Output a Data Entry Form for an inspector to fill off-line	Open an Inspection that does not have any data in it. In the inspection, click on Reports tab. Then click on Data Entry Form.		Clicking on Data Entry Form should output a report that can be printed for data entry	Content of Data Entry Form should match data entry screens in 1factory	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Content of Data Entry Form should match data entry screens in 1factory
168	Output a human-readable QC Plan form	Open a Plan. On the Manage tab, click on QC Plan Summary			QC Plan Summary in excel must match QC Plan in the system.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	QC Plan Summary in excel must match QC Plan in the system.
207	User name and date of disposition in the Accepted/Rejected & Reviewed cells					PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
194	Spec Library	Create and release a Spec Library with one or more specs. Import Spec Library into a Plan. Release Plan. Create an Inspection.		Verify that all Spec Library features are correctly imported into Plan and associated Inspection.	All Spec Library features should be correctly displayed in the Inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All Spec Library features should be correctly displayed in the Inspection.
195	Spec Library	Up Version the Spec Library. Reimport the Spec Library into the Plan. Release the Plan.		Verify that all updated Spec Library features are correctly imported into Plan and associated Inspection.	All Spec Library features should be correctly displayed in the Inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	All Spec Library features should be correctly displayed in the Inspection.
211	Ability to import a Spec. Library multiple times (Up to 10x)	When in draft mode of a Plan, choose a previously released Spec. Library to be imported into the draft plan.	Checks if the imported Spec Library has already been imported for this plan. If so, the plan is updated with the latest imported version.	On the Import slide out, choose to import the Spec Library more than once.	1- The Spec Library should be added to the end of the plan, with the sequence of balloon numbers repeated based on the import time. 2- If a PDF is attached within the Spec Library, that file should be imported along with the selected number of imports.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- The Spec Library should be added to the end of the plan, with the sequence of balloon numbers repeated based on the import time. 2- If a PDF is attached within the Spec Library, that file should be imported along with the selected number of imports.
236	Ability to create a Spec Library that is tabulated.	1. The user creates a Spec Library, which is tabulated from the Part Masters file. 2. The user creates at least two variants within the TOS of the Part Master. 3. The user creates a Plan against the tabulated Spec Library, ensuring at least one feature is tabulated.	Verifies a duplicate Part Master does not exist before creating the Part Master.	1. The user imports the Tabulated Spec Library into a Plan that is in the Draft state. 2. This step is repeated for each variant of the Spec Library.	The features imported into the Plan reflect the features identified in each variant of the Spec Library.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	The features imported into the Plan reflect the features identified in each variant of the Spec Library.
237	Up-version all associated Plans Automatically	1. User creates a Spec Library and imports it to one or more plans.	n/a	1. User creates a new version of the Spec Library. 2. User hits the UPVER Plans Button on the Usage Tab of the Spec Library.	1. All associated Plans are automatically up-versioned and left in draft state.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. All associated Plans are automatically up-versioned and left in draft state.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
183	Bug: Gage Calibration for fourth place decimal (rounding issue) is incorrect	Setup an In-House Calibration: Nominal = 0.0250 + Tol = 0.0002 - Tol = 0.0001 User creates and releases a Plan. User creates an FAI and adds Remarks.		1. Enter Measurements for Condition Before and Condition After (if required) Nominal = 0.02489 Actual Before = 0.02489 Actual After = 0.02489 or 0.02491 User modifies the Plan and releases the new Version. User Up-Versions FAI.	1. Condition Before should be out-of-cal 2. Condition After should be in-cal 3. New calibration due-date should be set correctly 4. Calibration status should be set correctly When the FAI is up-versioned, the Remarks are not erased.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1. Condition Before should be out-of-cal 2. Condition After should be in-cal 3. New calibration due-date should be set correctly 4. Calibration status should be set correctly
187	Bug: When FAI is Up-Versioned, the data in the Remarks column (#14) gets erased	BUG: Auto upload timestamp does not reflect the time zone settings		Start auto-upload	Auto-Upload attempt should reflect time in User's Time Zone.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	When the FAI is up-versioned, the Remarks are not erased.
191	BUG: When an Inspection is moved from Reviewed back to Pending, we are not updating the Status on the List of Inspections page.	Set an Inspection to Approved (or rejected), and then to Reviewed. Save Inspection.		Move Inspection from Reviewed to Pending.	New status should be recorded in History and must be reflected on the List of Inspections page.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Auto-Upload attempt should reflect time in User's Time Zone.
197	BUG: When clicking save to Release a New Version and adding Release Notes at the same time - the release notes will not save. (They only save if you type the release notes first then hit save, go back to manage and then release the plan and hit save.)	User creates a new version of a Plan, adds Release Notes, and clicks Save.		Verify Plan Status and Release Notes.	Plan status changes to Released, and Release Notes are saved.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	New status should be recorded in History and must be reflected on the List of Inspections page.
203	Unable to save more than 12 rows of in house calibration data.	Load calibration data with more than 12 rows		Verify that calibration record with more than 12 rows is saved correctly.		PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Plan status changes to Released, and Release Notes are saved.
208	Create a Spec with "Spec. attributes (e.g. "Insp. method")" Plan setting set to "From List of Values"	Within an plan define an inspection method as the default inspection method.	Check LOV assure inspection method is defined		If the method is not in the "Inspection methods" List of Values, then 1factory shall throw an error.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Plan status changes to Released, and Release Notes are saved.
213	1factory user is able to download the "Version Changes" file from with the Manage Tab of a Plan	Users creates a plan with 3 or more features and then releases the plan.	Assures version changes report is generated correctly when features are removed from the plan	Users bring the plan to draft and deletes more than one feature within the plan without renumbering.	The "Version Changes" file shall be exported in .xlsx format.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	Plan status changes to Released, and Release Notes are saved.
224	Bug: E-signature is cleared on FAIs without entering data on certain browsers (chrome, edges).	User creates a FAI.		User enters data and signs for their data.	Signature remains valid until more data is entered.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Signature remains valid until more data is entered.
225	BUG: Email is required when importing users via the Excel import.	User downloads user list.	System verified required cells (name, email) for each row (user) within the import.	1- Import list with a row missing an email.	1- User is flagged that the import was not complete due to email being required.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	Signature remains valid until more data is entered.
226	BUG: Fixture not properly being reflected within inspections (Red)	User creates a gage ID and chooses "Fixture" on the gages facts page & creates an inspection.	N/A	Enter the Gage ID into the gages tab of the inspection.	The gage should not highlight the gage tab & the gage ID should have a gray circle next to it.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- User is flagged that the import was not complete due to email being required.
231	Spec Libraries are only reflected on the Spec Library list.	1- The user creates a Spec Library and leave the Spec Library in Draft.	N/A	1- Use Release the Spec Library through the Manage Tab.	1- The Spec Library functions as intended and DOES not show up on the Plans list.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	The gage should not highlight the gage tab & the gage ID should have a gray circle next to it.
232	Change history for the M8B dispositions within the Manage tab shall be visible on the History tab of the inspection.	1. Create an Inspection Receiving or Manufacturing.	N/A	1. Leave a disposition in the M8B cell within the Manage tab of the inspection and hit Save.	1. Any data entered int he M8B cell shall be seen in the History tab of the inspection (Data, name, date).	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- The Spec Library functions as intended and DOES not show up on the Plans list.
247	If a CMM auto-upload fails due to a mismatch where the Plan does not specify GD&T but the file does, the system shall display an error message and skip the file. All subsequent files other than "GD&T" i.e. "Nom +/-". shall continue to upload without interruption.	1. User creates a Plan with a featured identified as something n/a	n/a	1. User run a file via the auto upload method with the featured set up as a GD&T spec in the file that is to be uploaded i.e. "True Position"	1. PowerShell stays open with error message displayed within the PowerShell and inside the 1factory app under the "CMM Machines" tile.	PASS	Nick Kelly	4/23/2025	PASS	Matthew Stanley	4/23/2025	1. Any data entered int he M8B cell shall be seen in the History tab of the inspection (Data, name, date).
248	User can import create a Plan via the .xlsx import method that includes Tabulated features that are "MIN/MAX"	1. User creates a plan that has a feature that is tabulated and that a characteristic type of "Min/Max". 2. User exports that plan via the excel download on the left had side bar.	n/a	1. User imports the exported file to create a new plan with a NEW part number.	1. The feature should be identified as a tabulated spec that is Min/Max.	PASS	Nick Kelly	4/23/2025	PASS	Matthew Stanley	4/23/2025	1. User is flagged that the import was not complete due to email being required.

Test #	User Requirement	User Inputs	System Validation (Error Checks)	Test	Expected Behavior	Verified	Verified By	Verified On	Reviewed	Reviewed By	Reviewed On	Test Data (for convenience)
210	Dual Data Type: Capability to support both Pass/Fail (P/F) and Numeric (NUM) data types for the same Balloon Number.	1- Create a balloon within a Plan and set the default data type to either P/F or NUM. 2- In the Inspection Type table, select the data type not set as the default for one of the Inspection Types in the table.	Ensure that the selected default data type is correctly applied as the default in the inspection	Create an inspection for all inspection types specified in the plan using balloons that support dual data types.	1- The inspection using the Pass/Fail (P/F) inspection type should only display and accept Pass/Fail entries, with no numerical values allowed. 2- The inspection using the Numeric (NUM) inspection type should only display and accept numerical value entries.	PASS	Matthew Stanley	3/12/2025	PASS	Nick Kelly	3/13/2025	1- The inspection using the Pass/Fail (P/F) inspection type should only display and accept Pass/Fail entries, with no numerical values allowed. 2- The inspection using the Numeric (NUM) inspection type should only display and accept numerical value entries.
218	Plan Approval required for plan to be released.	1- User sets number of required approvals (3) for a plan to be released in the company settings. 2- Create a new plan and select a user for Approver #1, #2 & #3. 3- Send plan for pending approval.	System validates that the author of the plan is not an options in the Approver Drops downs.	1- Send plan for pending approval. 2- Approver #1 & #2 approve plan, Approver #3 rejects. 3- Approver #1, #2 & #3 approve plan.	1- All Approvers receive email. 2- Emails have been sent. The plan will be moved back to draft and resubmitted for approval, clearing the approvals from Approver #1 and Approver #2. 3- Plan should not be able to be Released.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- All Approvers receive email. 2- Emails have been sent. The plan will be moved back to draft and resubmitted for approval, clearing the approvals from Approver #1 and Approver #2. 3- Plan should not be able to be Released.
219	Enforce Sampling Rules on frequency based sample rules.	User creates a plan with a sample rule of 100% for... 1- Pass/Fail (P/F) check 2- Numerical (NUM) check	System alters user if sample requirements have not been met upon inspection completion.	1- Create an inspection against the plan with a sample size of 10. 2- Enter data in all 10 rows for the P/F check and 9 out of the 10 in NUM check. Disposition inspection. 3- Enter data in all 10 rows for the NUM check and 9 out of the 10 in P/F check. Disposition inspection.	1- n/a 2- System alerts user if they want to disposition an incomplete inspection. 3- System alerts user if they want to disposition an incomplete inspection.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- n/a 2- System alerts user if they want to disposition an incomplete inspection. 3- System alerts user if they want to disposition an incomplete inspection.
220	Enforce a valid Gage ID for all features within an inspection.	1- Turn on "Enforce Gages" within the organization settings. 2- Create an inspection with at least one feature required to be measured.	System verify that all features have a Valid gage ID entered against them when inspection disposition is made. If not system flags user. Note: A "Valid" Gage ID is a gage in "OK to use" within the 1factory gage module.	1- Enter a Valid Gage ID for all features within an inspection. 2- Leave at least one feature without a Gage ID entered against 3- Enter an expired Gage ID into at least one feature within the inspection. 4- Enter a Gage ID that is specified as a "Fixture" within the Gage Facts. 5- Enter a Gage ID that is specified as a "Reference" within the Gage Facts. Make a disposition in all cases (Accept/Reject).	1- Gage Tab is NOT Highlighted (Orange) & user receives no flag when disposition is made. 2- Gage Tab is Highlighted (Orange) & user receives a flag when disposition is made. 3- Gage Tab is Highlighted (Orange) & user receives a flag when disposition is made. 4- Gage Tab is NOT Highlighted (Orange) & user receives no flag when disposition is made. 5- Gage Tab is Highlighted (Orange) & user receives a flag when disposition is made.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- Gage Tab is NOT Highlighted (Orange) & user receives no flag when disposition is made. 2- Gage Tab is Highlighted (Orange) & user receives a flag when disposition is made. 3- Gage Tab is Highlighted (Orange) & user receives a flag when disposition is made. 4- Gage Tab is NOT Highlighted (Orange) & user receives no flag when disposition is made. 5- Gage Tab is Highlighted (Orange) & user receives a flag when disposition is made.
221	Ability to enter more than one Gage ID for an inspection feature.	User has the "Multiple Gages" configuration turned for their account and created an inspection with at least one feature required to be inspected.	Verifies Gage status and present visual cues to user based on status.	1- Enter Gage ID into Gage 1 column and Gage 2 column and hit Save.	1- In each column the gage status should be reflected properly & date, time & user who entered the Gage ID is recorded in the inspection history tab.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- In each column the gage status should be reflected properly & date, time & user who entered the Gage ID is recorded in the inspection history tab.
230	User is able to utilize the API configuration to GET & PULL data from 1factory.	1- Your user account must have the API configuration enabled. 2- Once enabled, the "Organization ID" and "API Key" found in your account settings will be used to authorize the API Page at https://val.1factory.co/api-doc/index.html .	Verifies API Key is correct for the organization ID entered.	1- Utilize the "try out" button on to run the API call for each offering.	1- The data submitted to 1factory matches the data displayed on the API Page. 2- The data retrieved from 1factory reflects the information available within the 1factory system.	PASS	Nick Kelly	3/17/2025	PASS	Matthew Stanley	3/24/2025	1- The data submitted to 1factory matches the data displayed on the API Page. 2- The data retrieved from 1factory reflects the information available within the 1factory system.