

Specification for the KLIPPEL ANALYZER SYSTEM (QC Ver. 6, dB-Lab Ver. 210)  
 Document Revision 6.9

**FEATURES**

- Ultra-fast testing at physical limit
- Highly sensitive rub & buzz testing
- Ambient noise detection – no false re-jects
- Easy limit calculation, grading, limit import
- Dedicated for use with *KLIPPEL Analyzer (KA3, PA)* hardware
- ASIO, WDM Support: use 3rd party audio interfaces (sound cards) or stream directly from/to digital DUT
- Automatic detection of golden reference units
- Impedance, frequency response
- Polarity, mean level
- THD, 2nd – 5th order distortion,
- T/S parameter ( $R_e$ ,  $f_s$ ,  $Q_{ts}$ , ...)
- Enclosure parameters  $f_b$ ,  $Q_b$
- Customizable test sequences
- Easy test management and synchronization
- Multi-language user interface
- Automatic detection of “golden reference units”
- Extraction tool for data export
- Production indices ( $C_{pk}$ ,  $P_{pk}$ )
- Process control rules (Nelson/Weco)
- Yield and single value statistics
- Operator and engineer access level
- Simple integration into assembling line
- Auto-detection of amplifier gain

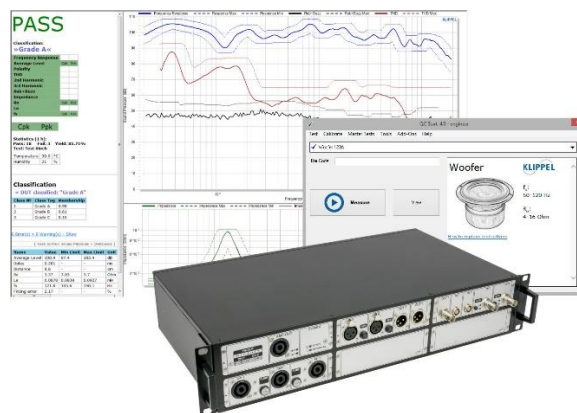
*Certain system configurations may not include all features listed above*

**BENEFITS**

- 100% production testing
- Ensure consistency of production
- Process control
- More reliable than human ear testing
- Comprehensive defect detection
- Simple and intuitive operation
- Seamless integration in production process
- Compatible to Klippel R&D
- Flexible, modular solution to match your company needs
- Simple customization with dedicated infrastructure

**APPLICATIONS**

- Transducers (woofer, tweeter, micro-speaker ...)
- Headphones, headsets, earphones
- Active, passive, wireless, digital speakers and audio systems
- Multi-channel systems
- Amplifier, crossover
- Microphones
- Incoming goods inspection
- Noise and vibration testing



Item numbers

4004-001; 4004-200; 4004-250

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1 Overview

1.1 Concept

The KLIPPEL QC software in combination with KLIPPEL analyzer hardware is a comprehensive solution dedicated to the quality control of

- electro-acoustic transducers (e.g. micro-speakers, woofers, tweeters),
- passive audio systems (speaker box, headphones) and
- active and digital audio systems (smart speakers, Bluetooth enabled headsets, tablets, smart phones, cars, multimedia, ...).

The robust *KLIPPEL Analyzer* hardware is designed for operation in production environments. It can be integrated in a fully automated line as well as operated manually. 3<sup>rd</sup> party audio devices and interfaces can be tested or used for testing, alternatively.

The software has two basic access levels (operator and engineer). An intuitive user interface (available in different languages) and smart limit setting algorithms are implemented to shorten training and setup periods for operators and engineers.

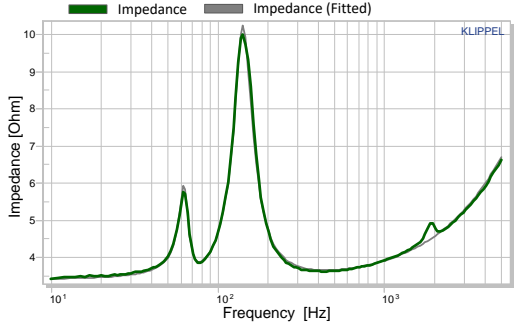
A dedicated project management software (*QC Start*) simplifies test setup generation, selection, execution and connected to housekeeping tasks (statistics, calibration, networking).

The KLIPPEL QC software framework is highly flexible. Test sequences comprise measurement steps (tasks) with individual stimuli. This allows shortest test cycles using most critical signals for testing at the physical limits.

Using KLIPPEL QC, defective units are detected reliably, even if the symptoms are not audible in a noisy production environment while focusing on the ultimate goal to increase the yield rate in manufacturing. End-of-line testing provides valuable diagnostic information for detecting the root cause of the problem and allows solving problems as soon as possible.

1.2 Results

<p>Frequency Response</p>	<ul style="list-style-type: none"> <li>• Frequency response – magnitude and phase</li> <li>• Windowed impulse response</li> <li>• Average level</li> <li>• Multi-point or band average levels</li> <li>• Sound pressure level (opt. A-weighting)</li> <li>• Acoustic phase</li> <li>• Polarity</li> <li>• Spectrum</li> </ul>	
<p>Distortion</p>	<ul style="list-style-type: none"> <li>• THD (absolute, relative)</li> <li>• 2<sup>nd</sup> – 5<sup>th</sup> harmonic</li> <li>• Rub &amp; Buzz – transient defect</li> </ul>	

	<ul style="list-style-type: none"> <li>distortion                     <ul style="list-style-type: none"> <li>HOHD</li> <li>HI-2 distortion (add-on)</li> <li>Incoherence</li> </ul> </li> </ul>																																																																					
<p>Impedance and T/S Parameters</p>	<ul style="list-style-type: none"> <li>Impedance – Magnitude and Phase</li> <li>Points/bands extracted from impedance magnitude</li> <li>Thiele/Small parameters: <math>R_e, f_s, Q_{ts}, Q_{es}, Q_{ms}</math>,</li> <li>Other linear parameters: <math>L_e, C_{mes}, L_{ces}, R_{es}, Q_b, f_b</math> (box)</li> <li>Additional T/S parameters (added mass method or laser measurement with <i>TSX</i> add-on): <math>Bl, M_{ms}, V_{as}, K_{ms}, C_{ms}, R_{ms}</math></li> </ul>																																																																					
<p>Test Verdict</p>	<ul style="list-style-type: none"> <li>Individual Pass/Fail decision for selected measures</li> <li>Overall PASS/FAIL verdict</li> <li>Individual quality grades</li> <li>Overall grade</li> <li>Process control verdicts</li> </ul>	<p><b>PASS</b></p> <p>New Golden DUT found</p> <table border="1"> <thead> <tr> <th>Grade 1</th> <th>Cpk</th> <th>Ppk</th> <th>Rules</th> </tr> </thead> <tbody> <tr><td>left - Impedance</td><td></td><td></td><td>Rules Grade 1 100%</td></tr> <tr><td>right - Impedance</td><td></td><td></td><td>Rules Grade 1 100%</td></tr> <tr><td>left - MODulation</td><td></td><td></td><td>100%</td></tr> <tr><td>right - MODulation</td><td></td><td></td><td>100%</td></tr> <tr><td>left - Frequency Response</td><td></td><td></td><td>Grade 1 100%</td></tr> <tr><td>left - Average Level</td><td></td><td></td><td>Rules Cpk Ppk 100%</td></tr> <tr><td>left - Polarity</td><td></td><td></td><td>100%</td></tr> <tr><td>left - THD</td><td></td><td></td><td>Grade 1 100%</td></tr> <tr><td>left - Rub+Buzz</td><td></td><td></td><td>Grade 1 100%</td></tr> <tr><td>right - Frequency Response</td><td></td><td></td><td>Grade 1 89%</td></tr> <tr><td>right - Average Level</td><td></td><td></td><td>Rules Cpk Ppk 100%</td></tr> <tr><td>right - Polarity</td><td></td><td></td><td>100%</td></tr> <tr><td>right - THD</td><td></td><td></td><td>Grade 1 100%</td></tr> <tr><td>right - Rub+Buzz</td><td></td><td></td><td>Grade 1 100%</td></tr> <tr><td>FreqResp - Difference Curve</td><td></td><td></td><td>100%</td></tr> <tr><td>FreqResp - Maximum Deviation</td><td></td><td></td><td>100%</td></tr> </tbody> </table> <p>Statistics (1 h):                  Pass: 16 Fail: 2 Yield: 88.89%                  SN: USB-54322 Test: By-4728</p>	Grade 1	Cpk	Ppk	Rules	left - Impedance			Rules Grade 1 100%	right - Impedance			Rules Grade 1 100%	left - MODulation			100%	right - MODulation			100%	left - Frequency Response			Grade 1 100%	left - Average Level			Rules Cpk Ppk 100%	left - Polarity			100%	left - THD			Grade 1 100%	left - Rub+Buzz			Grade 1 100%	right - Frequency Response			Grade 1 89%	right - Average Level			Rules Cpk Ppk 100%	right - Polarity			100%	right - THD			Grade 1 100%	right - Rub+Buzz			Grade 1 100%	FreqResp - Difference Curve			100%	FreqResp - Maximum Deviation			100%
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### 1.3 Demo Video

For a quick demo video (English or Chinese), please refer to the resources found on the KLIPPEL website:

<http://www.klippel.de/our-products/qc-system/demo-videos.html>

### 1.4 Versions of the QC Software

<p>QC Standard Software</p> <p>ART. NR. 4004-001</p>	<p>The <i>QC Standard</i> is the most common version of KLIPPEL QC, setting new standards in speaker and audio system testing. This software package contains the QC software framework and various test <i>Tasks</i> and it is dedicated for operation with <i>KLIPPEL Analyzer</i> hardware (PA, KA3). This comprehensive solution provides optimal flexibility and performance for various testing scenarios. For special requirements, functionality may be extended by a variety of add-on modules</p> <p>Most parts of this document refer to the <i>QC Standard Software</i>. Specifics or restrictions which apply to other versions of the QC software are highlighted explicitly. For a detailed comparison and feature list, also refer to the overview table in the appendix.</p>
<p>QC Basic Software</p> <p>ART. NR. 4004-200</p>	<p>The <i>QC Basic Software</i> is available in two version. The default version fulfils common demands of modern end-of-line testing while keeping an eye on the budget.</p> <p>The following restrictions apply compared to the <i>Standard</i> version:</p> <ul style="list-style-type: none"> <li>Only one measurement task type: combined <i>Sound Pressure and Impedance</i> task.</li> <li>Task sequences limited to max. 3 tasks (steps).</li> <li>Sweep Profiles (level and speed) are not available</li> <li>No multiple reference DUTs for statistical limit calculation (restricted to one)</li> <li>No ambient noise detection</li> <li>Most additional modules (<i>Motor &amp; Suspension Check, Air Leak Detection..</i>) cannot be</li> </ul>

	<p>operated</p> <p>The <i>Basic</i> software can be upgraded to the <i>Standard</i> version at any time, no separate installation is required. See section <a href="#">Software Features</a> for further restrictions.</p>
<p>QC Basic Software (special application)</p> <p>ART. NR. 4004-250</p>	<p>In contrast to the default version of the <i>QC Basic Software</i> which is dedicated to meet the requirements of common electro-acoustic tests, the <i>special application</i> version is focusing on general spectrum-based transfer function, noise and vibration testing. Instead of combined <i>Sound Pressure and Impedance</i> task, this version comes with <i>Spectrum Analysis (SAN)</i> task. Find more information in section <a href="#">Available Tasks</a>.</p> <p>Apart from the different main application, the same restrictions apply as stated for <i>QC Basic Software</i>.</p>
<p>QC Programmable Software</p>	<p>The programmable version of the QC software is based on <i>QC Standard</i>. It allows editing the actual measurement <i>Tasks</i> in order to modify signal processing, result and limit calculation, the user interface and much more. The programming is based on a high-level language (Scilab®), which is comparable to MatLab®.</p> <p><b>Note:</b> For most custom requirements, the <i>Programming</i> version is too powerful. There are alternative tools available to customize the standard functionality while keeping the benefit of regular updates by Klippel. Using custom <i>Feature Libraries</i>, many features can be added in encapsulated containers. Please see separate specification <i>S36 QC Feature Libraries</i>.</p>
<p>QC Stand-alone Software</p>	<p>This version of the <i>QC Software</i> is based on <i>QC Standard</i> version with certain restrictions. It is dedicated to testing applications which do not require the particular features of the <i>KLIPPEL Analyzer</i> hardware (e.g. voltage/current sensors for impedance testing, Digital IO interface). Any 3rd party audio interface (sound card) may be used as measurement device instead.</p> <p>The <i>QC Stand-alone</i> software version is very suitable for testing active and digital systems (e.g. Bluetooth or powered speaker), mobile testing applications (e.g. installed speaker diagnostics, rental companies, car audio system ...) or electronics testing. Only acoustical or line level tests are supported. All impedance-based test tasks and add-on modules are not functional.</p> <p>The following restrictions apply compared to the <i>QC Standard</i>:</p> <ul style="list-style-type: none"> <li>• Impedance measurement (terminal voltage and current) is not available</li> <li>• No power amplifier handling (gain check not supported)</li> <li>• Some add-on modules are not supported (e.g. <i>Motor+Suspension Check</i>)</li> <li>• <i>Klippel Analyzer</i> cannot be operated</li> </ul> <p>The customer is responsible for selection, installation, configuration and robustness of 3<sup>rd</sup> party audio interfaces. A list of recommended audio interfaces is available separately. Klippel provides limited support for recommended audio interfaces only.</p>
<p>QC Remote Configuration</p> <p>ART. NR. 4004-200</p>	<p>The <i>QC Remote Configuration</i> is a software-only distribution which cannot be used for measurement. It allows modifying QC test settings and limits on any PC without having any measurement hardware connected.</p> <p>See specification <i>S14 QC Remote Setup</i> for more information.</p>
<p>QC KCS Configuration</p> <p>ART. NR. TBD</p>	<p>A tailored version of the QC software exists for Klippel Controlled Sound (KCS) application. Basically, the QC-Standard functionality is available with the following exceptions:</p> <ul style="list-style-type: none"> <li>• Reference DUTs are used to compare several KCS setup versions. Therefore, after Logout the reference DUTs are shown in the result charts instead of the last measurement.</li> <li>• No standard temperature / humidity measurement available</li> <li>• No Operator level available (only engineer level), no user management (User property page)</li> <li>• Avoids access of speaker relays when KCS is running.</li> </ul> <p>A separate documentation is available for this product.</p>
<p>QC Tasks in R&amp;D Software version</p>	<p>From dB-Lab version 210, <i>QC Tasks</i> can also be used within the <i>Klippel R&amp;D</i> software framework (dB-Lab 210 and higher). Therefore, QC test functions can be used in R&amp;D setups in parallel to the <i>R&amp;D</i> software modules. Test sequences may contain both, <i>R&amp;D</i> and <i>QC</i> opera-</p>

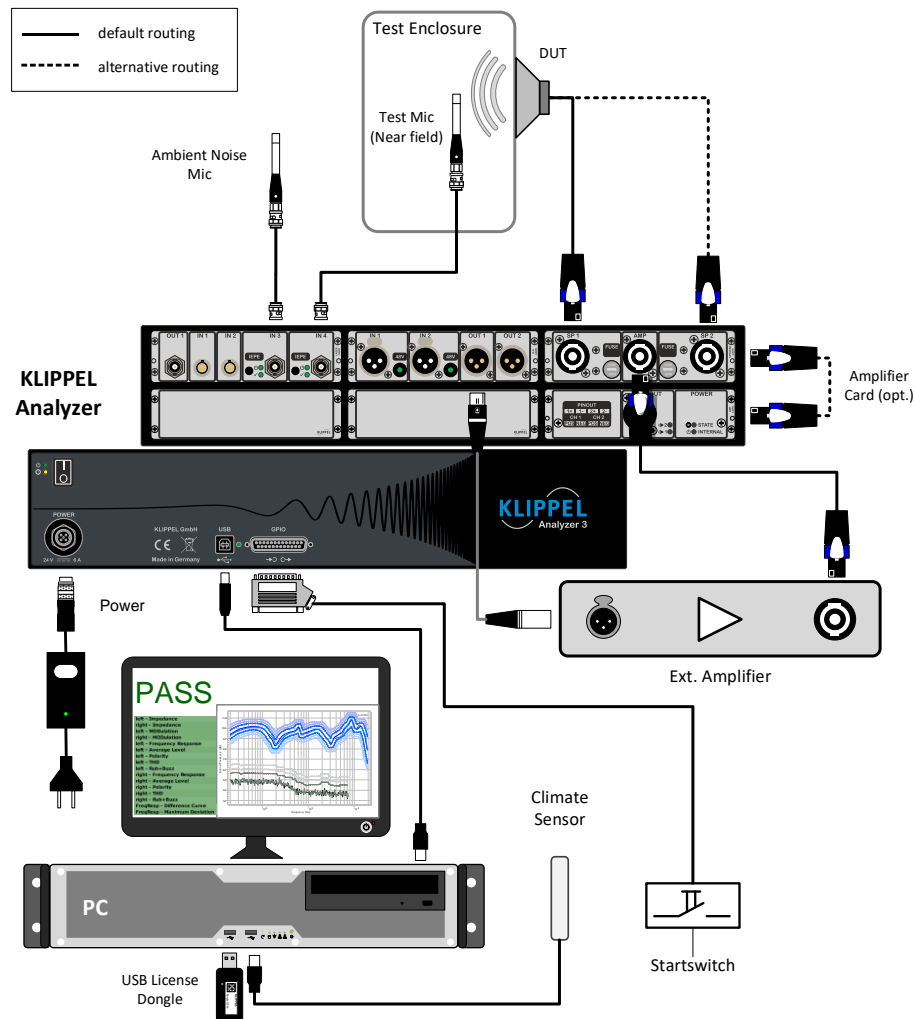
	<p>tions.</p> <p>The QC framework module is provided for free. However, each test <i>Task</i> to be used requires a dedicated license. This includes <i>Tasks</i> that are included in <i>QC Standard</i> software package (<i>SPL</i>, <i>IMP</i>, <i>SPL-IMP</i> task) require a license.</p> <p>The following restrictions apply in this version:</p> <ul style="list-style-type: none"> <li>• The dedicated user modes for operators is not available. The user has Engineer Rights implicitly.</li> <li>• Limits can be calculated and applied based on one reference unit. Statistical limit generation is not available.</li> <li>• Up to three measurement tasks in a QC test sequence are available.</li> <li>• Any add-on modules can be used with a valid license. Check the R&amp;D price list for available tasks and options. Available features are specified in the appendix.</li> <li>• QC Start tool is not available. All data management can be done using dB-Lab.</li> </ul>
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**1.5 Scope of Delivery**

Software	Any QC Software packages comprises:	Item No
	<ul style="list-style-type: none"> <li>• dB-Lab</li> <li>• QC Framework Module</li> <li>• QC Start Tool</li> <li>• QC Tasks:                             <ul style="list-style-type: none"> <li>○ Sound Pressure (SPL)*</li> <li>○ Impedance (IMP)*</li> <li>○ Sound Pressure + Impedance (SPL+IMP)</li> <li>○ Control</li> <li>○ Preconditioning</li> <li>○ IO</li> <li>○ Post-processing (PP)*</li> <li>○ Added Mass</li> <li>○ Spectrum Analysis (SAN)**</li> </ul> </li> <li>• Feature Libraries</li> <li>• Yield Statistics (YST)</li> <li>• db extract</li> <li>• KLIPPEL Software Protection Dongle (USB)</li> </ul>	<p>-</p> <p>-</p> <p>-</p> <p>4000-263</p> <p>4000-262</p> <p>-</p> <p>-</p> <p>-</p> <p>-</p> <p>-</p> <p>-</p> <p>4000-267</p> <p>-</p> <p>-</p> <p>-</p> <p>2000-500</p>
	<p><i>*not included in QC Basic software</i></p> <p><i>**only included in QC Standard and QC Basic (special application)</i></p>	
Hardware	In case the <i>QC Software</i> is purchased together with a <i>KLIPPEL Analyzer</i> , the following components are included:	
	<ul style="list-style-type: none"> <li>• <i>Klippel Analyzer</i> hardware:                             <ul style="list-style-type: none"> <li>○ <i>PA - Production Analyzer</i> (Spec. <i>H3</i>) or</li> <li>○ <i>KA3 - KLIPPEL Analyzer 3</i> (Spec. <i>H4</i>) - various card configurations available</li> </ul> </li> <li>• 1 Power supply with country specific power cable</li> <li>• Cable set                             <ul style="list-style-type: none"> <li>○ 1 USB cable: 3 m</li> <li>○ 1 Signal cable: XLR cable (male-female) 1 m</li> <li>○ 1 Amplifier cable (<i>speakON</i> - crimped ferrule): 4 x 2.5 mm<sup>2</sup>, 1.5 m</li> <li>○ <i>speakON</i> connector</li> <li>○ 1 High precision speaker cable: (<i>speakON</i>-banana plug) 4 x 2.5 mm<sup>2</sup>, 2.2 m</li> <li>○ 2 Alligator clips</li> </ul> </li> </ul>	<p>4000-100</p> <p>4000-3xx</p> <p></p> <p>2920-001</p> <p>2300-103</p> <p>2300-010</p> <p></p> <p>2300-023</p> <p>2300-020</p>

## 2 Applications

## 2.1 Transducer Testing with QC Standard and KLIPPEL Analyzer



This is a typical setup for transducer end-of-line testing using QC Standard setup.

The setup includes:

- Klippel Analyzer hardware (KA3 or PA)
- Test and ambient noise microphones
- Power amplifier (opt.)
- Optional accessories and IO (footswitches, climate sensor, assembly line control)
- Windows PC
- USB License Dongle
- Test enclosure (optional)

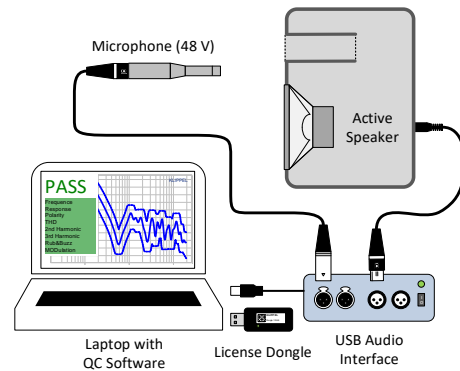
An external power amplifier or the integrated amplifier of the QC Card or Amplifier Card of the KA3 is used to drive the speaker under test which is mounted on a test enclosure. The sound pressure response is picked up by a near field microphone. External noise corruption is identified using a dedicated ambient noise microphone placed outside of the test box. The setup includes an additional sensor to monitor temperature and humidity variation and a foot switch for hands-free test start.

**2.2 Active System Test with Audio Interface (QC Stand-alone Software)**

The *QC Stand-alone software* can be used for testing the acoustical response of active speaker systems with just a laptop and a microphone connected to a USB audio interface.

This portable test setup can be applied for on-site testing of installed speakers and many other scenarios which require high mobility or a cost-efficient quality test solution.

*Note: Impedance and T/S parameter measurement is not available using 3rd party audio interfaces.*



**More Applications:**

<http://www.klippel.de/our-products/qc-system/qc-applications.html>

**3 Requirements**

**3.1 Hardware**

Additional Hardware Required	<ul style="list-style-type: none"> <li>• 1 test microphone (see requirements below)</li> <li>• Power amplifier for passive DUTs (see document <i>Amplifier Requirements</i>) or <i>Amplifier Card</i> or <i>QC Card</i> for KA3</li> <li>• 1 PC (see requirements below)</li> <li>• Fixture for DUT and microphone (not provided by KLIPPEL)</li> <li>• for <i>QC Stand-alone Software</i> version: audio interface (external sound card)</li> </ul>
PC Requirements	<ul style="list-style-type: none"> <li>• Operating systems: Microsoft Windows 7, 8 or 10</li> </ul> <p>See <i>KLIPPEL QC PC Requirements</i> or <i>dB-Lab Manual</i> for more information</p>
Amplifier Requirements	<p>An amplifier is required for testing passive devices such as transducers. For KA3 a dedicated <i>Amplifier Card</i> is available (see spec). The <i>QC Card</i> also provides an internal amplifier.</p> <p>Any professional audio amplifier meeting the power and bandwidth requirements of the particular tests may be used.</p> <p>Find more information in <i>KLIPPEL Amplifier Requirements</i> or <i>Hardware Manual</i>.</p>
Microphone Requirements	<p>All <i>IEPE</i> powered microphones can be directly connected to the microphone inputs of the <i>KA3-Laser Card</i>, <i>QC Card</i> or the <i>Production Analyzer</i> without an additional power supply. Also, other <i>IEPE</i> powered sensors such as accelerometers may be used as well.</p> <p>Phantom-powered microphones (48 V) can be directly connected to the <i>KA3-XLR Card</i>.</p> <p>Microphones with 48 V phantom power supply or 200 V polarization may be connected to the line inputs of <i>KA3-XLR Card</i>, <i>PA</i> or 3<sup>rd</sup> party audio interfaces using external power supply.</p>

**3.2 Test Environment**

Fixture	<p>A suitable test jig is required to ensure consistent and reproducible test conditions (e.g. distance between DUT and microphone). The test fixture should not cause any parasitic vibration induced by the device under test.</p> <p>The test fixture is highly specific for particular applications. Therefore, it is not provided by KLIPPEL. For 3<sup>rd</sup> party vendors of fixtures and test enclosures see <i>AN 46 Test Enclosure for QC</i>.</p>
Test Enclosure	<p>In order to ensure optimal sensitivity for acoustical tests in a noisy production environ-</p>

	ment, it is highly recommended to provide acoustical shielding (test enclosure). This may be omitted when testing in low background noise environment (labs). A box enclosure must have a sufficient size depending on the device to be tested and the sound pressure limit of the microphone (see <i>AN 46 Test Enclosure for QC</i> ).
Ambient / Production Noise	<p>The background noise level in a production environment can easily mask the symptoms generated by a defective DUT (Device under Test). Typically, impulsive noise in production is so high that even the box enclosure and an additional isolated test cabin / enclosure do not provide sufficient attenuation.</p> <p>KLIPPEL QC Tasks like <i>SPL</i>, <i>SPL+IMP</i> or <i>ALD</i> can be configured to detect corrupted measurements. A second microphone is required to measure the ambient sound pressure. The operator is warned in case of excessive ambient noise.</p> <p>This feature is included in any QC version except <i>QC Basic</i>.</p>

## 4 Supported KLIPPEL Analyzer Hardware

### 4.1 Klippel Analyzer 3

The *Klippel Analyzer 3* is the recommended analyzer platform for the *QC Software* replacing the *Production Analyzer* (from QC6).

The device provides the following features superior to the *PA* hardware:

- Modular, flexible architecture
- Multichannel 15 in/outputs
- Better noise floor
- Optional *Amplifier Card*
- Direct laser connection
- Compatible to KLIPPEL R&D
- Electronic speaker relays, no wear
- More GPIO in / outputs



Please refer to *H3-KA3* for detailed specification.

*The QC Stand-alone Software version does not support this device.*

### 4.2 Production Analyzer

The *Production Analyzer* has been the dedicated measurement for use with the *QC Software*. It is still available on request and supported by the latest software.



The device provides the following features:

- AD/DA conversion:
  - 48 / 96 / 192 kHz / 24 Bit
  - SNR > 100 dB
- Analog sensor hardware:
  - Two channel speaker monitoring
  - Voltage and current sensors (up to 200 V peak / 50 A peak)
  - Different sensitivities available
  - Fuses in speaker channels for overload protection
  - Two channel microphone Input
  - Built in IEPE microphone power supply
  - Symmetrical line input and output



	<ul style="list-style-type: none"> <li>• PC-controlled operation via USB</li> <li>• GPIO connector for integration, accessories and remote control</li> </ul> <p>Please refer to <i>H4 – Production Analyzer Hardware</i> for detailed specification.  <i>The QC Stand-alone Software version does not support this device.</i></p>
<h3>4.3 Optional Hardware &amp; Accessories</h3>	
	<p>KLIPPEL offers a variety of optional hardware and accessories:</p> <ul style="list-style-type: none"> <li>• Power amplifier for passive DUTs (see document <i>Amplifier Requirements</i>)</li> <li>• Additional microphone for ambient noise detection</li> <li>• Multiplexer (BNC-Mic, XLR or Speakon)</li> <li>• Accessories <ul style="list-style-type: none"> <li>○ Temperature and humidity sensor</li> <li>○ Bar code reader</li> <li>○ Manual sweep controller</li> <li>○ Bluetooth interface</li> </ul> </li> <li>• Microphone calibrator</li> <li>• Microphone power supply</li> <li>• Laser displacement sensors</li> <li>• Ear &amp; mouth simulators (G.R.A.S.)</li> <li>• Head- and earphone test stands (G.R.A.S.)</li> <li>• Professional sound sources (Genelec)</li> <li>• Additional speaker cable</li> <li>• Speaker cable extension</li> </ul> <p>A complete hardware set for your testing application can be supplied by KLIPPEL on request.</p>

## 5 Software Features

<h3>5.1 Task Philosophy</h3>	
	<p>There are 3 basic steps in a QC measurement:</p> <ul style="list-style-type: none"> <li>• Measurement</li> <li>• Limit check</li> <li>• Setting test verdict and classification or quality grade</li> </ul> <p>Since in most cases several test steps are required (e.g. low-level impedance, high-level sound pressure), multiple <b>Measurement Tasks</b> may be applied in test a particular sequence. Each measurement task has its own:</p> <ul style="list-style-type: none"> <li>• Test signal,</li> <li>• Data acquisition and analysis,</li> <li>• Limit check,</li> <li>• Limit calculation,</li> <li>• Setup parameters,</li> <li>• Signal processing and</li> <li>• Graphical output.</li> </ul> <p>The tasks-specific test results and verdicts are forwarded to the <b>Control Task</b>. This special framework task</p> <ul style="list-style-type: none"> <li>• collects all PASS/FAIL and grading results,</li> <li>• generates the overall PASS/FAIL and grading result</li> <li>• performs result classification</li> <li>• leads online statistics and checks control rules</li> <li>• performs data logging</li> </ul> <p>Therefore, each measurement sequence consists of multiple measurement and auxiliary tasks as well as one <i>Control Task</i>.</p>

**Stimulus**

- Multi-Tone 1 V
- User Interaction
- Multi-Tone 10 V
- Log Sweep 8 V
- Sine-Tone 5 V
- Wave File 2.8 V

**Sequence of Test Steps**

PASS

- Low Level - Impedance
- Low Level - Re
- Low Level - fs
- Low Level - Qts
- Low Level - fb
- Low Level - Qb
- Low Level - Min Impedance
- Coil Offset
- Stiffness Asymmetry
- Front - Frequency Response
- Front - Average Level
- Front - Polarity
- Front - THD
- Front - 2nd Harmonic
- Front - 3rd Harmonic
- Front - Hi-2
- Front - Rub+Buzz
- Front - MODulation
- Rear Left - MODulation
- Rear Right - MODulation
- Music - Spectrum
- Music - Incoherence

There is no restriction in the number of tasks to be used for one measurement sequence in QC-Standard version.

The QC software comes with a selection of predefined tasks covering most standard applications. A variety of add-on modules is available for specific testing applications.

An intuitive user interface provides access to the setup of the test signal, data analysis, limit setup and the result output.

## 5.2 Available Tasks

Sound Pressure (SPL)*	<p>Using log. sine sweep excitation, the following measures can be tested:</p> <ul style="list-style-type: none"> <li>• Fundamental (Frequency Response)</li> <li>• Windowing of Impulse Response (not available in <i>QC Basic</i>)</li> <li>• Average Level</li> <li>• Multi-point/band levels</li> <li>• Phase</li> <li>• Polarity</li> <li>• THD</li> <li>• 2<sup>nd</sup> – 5<sup>th</sup> harmonic</li> <li>• HOHD</li> <li>• Rub &amp; Buzz</li> <li>• Production Noise Detection</li> <li>• Step sine excitation available on request</li> </ul>
Impedance (IMP)*	<p>Using log. sine sweep or multitone excitation, the following measures can be tested:</p> <ul style="list-style-type: none"> <li>• Impedance - Magnitude</li> <li>• Impedance - Phase</li> <li>• Points/bands extracted from impedance curve</li> <li>• T/S Parameters</li> <li>• Voltage Magnitude, Phase, THD+N</li> <li>• Current THD+N</li> </ul>
SPL+IMP	<p>Using log. sine sweep excitation, the following measures can be tested:</p> <ul style="list-style-type: none"> <li>• Fundamental (Frequency Response)</li> <li>• Windowing of Impulse Response (not available in <i>QC Basic</i>)</li> <li>• Average Level</li> <li>• Multi-point/band levels</li> <li>• Phase</li> <li>• Polarity</li> <li>• THD</li> <li>• 2<sup>nd</sup> – 5<sup>th</sup> harmonic</li> </ul>

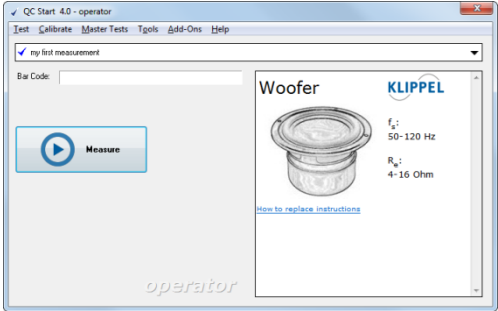
	<ul style="list-style-type: none"> <li>• Rub &amp; Buzz</li> <li>• Production Noise Detection (not available in <i>QC Basic</i>)</li> <li>• Impedance – Magnitude</li> <li>• Impedance - Phase</li> <li>• Points/bands extracted from impedance curve</li> <li>• T/S Parameters (limited set in <i>QC Basic</i>)</li> </ul>
Spectrum Analysis (SAN)**	<p>The SAN is a universal task for testing any noise and vibration source or audio systems with noise or custom test signals</p> <ul style="list-style-type: none"> <li>• FFT Spectrum</li> <li>• Frequency Response &amp; Transfer Function</li> <li>• Polarity</li> <li>• Level (opt. A-weighted)</li> <li>• Incoherence</li> <li>• Pink/white noise generator</li> <li>• Custom stimulus (WAVE)</li> </ul>
IO Task	<p>The <i>IO &amp; Prompt</i> is an auxiliary task providing multiple ways of interaction with the operator or the hard- and software environment.</p> <p>The following actions are available</p> <ul style="list-style-type: none"> <li>• User Message</li> <li>• Cancel test</li> <li>• Wait for digital input</li> <li>• Run batch file</li> <li>• Set digital output</li> <li>• Wait for specified time</li> </ul> <p>Those actions can be triggered by different conditions:</p> <ul style="list-style-type: none"> <li>• Digital input state</li> <li>• Verdict of preceding tests (Pass / Fail / Noise)</li> </ul> <p>Additionally, the IO Task provides ambient temperature and humidity check against user-defined limits (requires optional sensor).</p> <p>See separate specification <i>S34 – IO &amp; Prompt Task</i> for more information.</p>
Preconditioning	<p>For pre-excitation of the device under test, the following stimuli are available:</p> <ul style="list-style-type: none"> <li>• Log. sine sweep</li> <li>• Sine tone</li> <li>• Custom (wave file)</li> </ul>
Post-Processing	<p>The Post Processing (PP) can access and combine test results of any preceding measurement task in the test sequence and check the processed data against limits</p> <ul style="list-style-type: none"> <li>• Difference curve</li> <li>• Difference value</li> <li>• Maximum deviation</li> </ul>
Control	<p>General settings for the complete test sequence can be defined in the <i>Control</i> task:</p> <ul style="list-style-type: none"> <li>• Execution mode (Synchronization to external sources, wave file mode)</li> <li>• Routing</li> <li>• Configuration of the Control Panel (operator interface)</li> <li>• Serial number handling</li> <li>• Data logging (text file, database, wave files)</li> </ul>
<b>5.3 Limit Handling</b>	
Limit Check	<p>The limit check compares the measured values with limits. Each measurement task offers own limits for all provided measures. The results of this check are provided to the <i>Control</i> task to derive an overall verdict (see below).</p>
PASS/FAIL Verdict	<p>All task-specific pass/fail verdicts (individual measures) and quality grades are forwarded to the <i>Control Task</i>, which derives the overall test verdict and grade classification.</p>

Grades	Additionally, warnings may be generated, e.g. in case ambient noise corruption has been detected.
Limit Calculation	<p>The limit calculation is performed in a special mode, which is accessible via <i>QC Engineer</i> mode only. It is not accessible for the Operator (see access modes below).</p> <p>Limits and quality grades can be defined using</p> <ul style="list-style-type: none"> <li>• absolute limits</li> <li>• tolerances related to reference measurements (average or max)</li> <li>• statistics based on variation of reference DUTs</li> <li>• external file (imported limits)</li> </ul> <p>or a combination of these methods.</p> <p>An arbitrary number of reference measurements may be recorded to define limits statistically. All reference measurements are displayed in the result windows and may be (de)selected or deleted from the reference pool.</p>
Golden DUTs and Limit Calibration	<p>One or more “Golden Units” may be selected from the reference DUT pool in <i>Limit Calculation Mode</i> automatically. These units best represent the statistical average of the reference pool and may be used for on-line limit calibration to account for systematic drifts (e.g. due to climate variation).</p> <p>Additionally, new <i>Golden DUTs</i> can be detected automatically during testing using <i>Online Golden DUT Detection</i>.</p>

**5.4 Access Levels**

	<p>Different user access levels are provided by any QC Software. By default, two levels are provided:</p> <p>The <b>QC Engineer Mode</b> provides full access to test and limit settings.</p> <p>In the <b>Operator Mode</b> all settings are hidden and protected. It provides a simple interface and only necessary information to perform testing.</p> <p>In the optional 3<sup>rd</sup> level <b>Programmer Mode</b> all setups and also algorithms can be modified using a scripting language</p>	
Operator Mode (Level 1)	<p>The <i>Operator Mode</i> provides an intuitive and simple interface for the following functionality:</p> <ul style="list-style-type: none"> <li>• Test selection</li> <li>• Test start/repeat (using keyboard, barcode reader or switch)</li> <li>• Serial number definition</li> <li>• Report generation</li> <li>• Limit calibration (opt.)</li> </ul> <p>This functionality may be extended or restricted depending on the access rights granted due to the settings defined by the <i>QC Engineer</i>. Basically, the rights of the operators can be restricted to a minimum (e.g. start only) or enhanced for well-trained persons.</p> <p>The operator interface supports multiple languages. No special knowledge about the software and / or hardware is needed. This reduces the training time for new operators.</p> <p><b>Note:</b> This access level is not available when tasks are used in a R&amp;D installation.</p>	

Engineer Mode (Level 2)	<p>The <i>QC Engineer Mode</i> allows setting up test sequences and modifying setup parameters of measurement tasks. This includes the setup of test signals, signal analysis, limit calculation, <i>Golden DUT</i> calculation, statistical post processing, or even result representation.</p> <p>Also, the communication with the production line or operator can be set up in the Engineer Mode. Typical scenarios are setting and reading digital pins or showing instructions for the operator.</p> <p>This access level is the only available one in a R&amp;D installation.</p>
Programmer Mode (Level 3)	<p>The <i>Programmer Mode</i> is only available in <i>QC Programming Version</i>. This mode is required to operate tasks, created or customized by the user. Additional tools and internal information are provided for the programmer. Please check with Klippel support in case you need programming features.</p>
<h2>5.5 Further Features</h2>	
Multi-Language Support	<p>The user interface of the QC software is available in different languages:</p> <ul style="list-style-type: none"> <li>• English</li> <li>• Chinese (simplified)</li> <li>• Spanish</li> <li>• Portuguese</li> <li>• German</li> <li>• More languages are available on request</li> </ul>
Statistics	<p>Basic online-statistics such as individual and overall yield with defined time window are provided by the QC test.</p> <p>For offline analysis, the dedicated <i>Yield Statistics</i> (see <i>S35 QC Yield Statistics</i>) provides simple and comprehensive statistical data (yield analysis, single value result analysis) as well as histogram and time course plots. <i>Yield Statistics</i> is included in QC version.</p>
Serial Numbers	<p>Serial numbers for the identification can be assigned to each test. Various schemes to define serial numbers are available:</p> <ul style="list-style-type: none"> <li>• Keyboard or barcode scanner input</li> <li>• Automatic increase of serial numbers</li> <li>• Import from file</li> </ul>
Process Control	<p>For online process control, process capability indexes (Cpk, Ppk) and control rules (aka. <i>Nelson/Weco</i> rules) are provided.</p>
Data Logging	<p>Measurement data can be stored in multiple forms:</p> <ul style="list-style-type: none"> <li>• <i>Summary log file</i>: One line per test with results, verdicts, grades as well as meta information like time stamp, serial number and operator.</li> <li>• <i>Full Results</i>: All results, settings and meta-information are stored in a database (*.kdbx). This database can be opened at any time to visualize the particular test using <i>dB-Lab</i>. Reports can be generated or data can be exported using <i>db extract</i>.</li> <li>• <i>Wave file</i>: the recorded measurement signals may be stored as wave files</li> </ul>
dB-Lab Framework Software	<p>The dB-Lab framework software (which is also used for the <i>KLIPPEL R&amp;D System</i>) provides the</p> <ul style="list-style-type: none"> <li>• Database handling,</li> <li>• User interface and</li> <li>• Report generator.</li> </ul> <p>Using the same environment as for R&amp;D applications, a seamless integration is provided.</p>
QC Start Tool	<p>The QC Start is the central test management framework software providing the following functionality:</p> <ul style="list-style-type: none"> <li>• Test selection (simple and fast access for operators)</li> <li>• Different access levels for engineer and operator - configurable access rights for operators</li> </ul>

	<ul style="list-style-type: none"> <li>• Template handling: new tests can be based on default or company specific templates for fast test setup</li> <li>• Synchronization of multiple lines – refer to section <i>Master Tests</i></li> <li>• Calibration of peripheral hardware (microphones, amplifier) and 3rd party sound cards</li> <li>• Access to additional tools             <ul style="list-style-type: none"> <li>○ <i>db extract</i></li> <li>○ Statistics</li> <li>○ <i>Performance test</i></li> <li>○ Remote support</li> <li>○ Setup check</li> <li>○ Backup</li> <li>○ Customization and custom tools</li> </ul> </li> </ul>  <p>May be used as exclusive windows application (started automatically after booting Windows, Windows shuts down after exiting) to restrict access to other software.</p> <p><b>Note:</b> The QC start tool is not available when tasks are used in a R&amp;D installation.</p>
db extract Tool (data export)	<p>This tool allows extracting any curve data from stored measurement data. The export format may be specified freely. This allows interfacing with 3<sup>rd</sup> party tools for data processing such as <i>Microsoft Excel</i>.</p>
Master Tests / Synchronizing multiple production lines	<p>For synchronizing multiple test stations with identical test setups, <i>Master Tests</i> may be defined in a central network location. The local tests are updated by the <i>Master Test</i> automatically (settings, limits) at the beginning of each test session (login).</p> <p>It is also possible to adjust settings and limits from remote computers. For this option no measurement hardware is required, only a <i>QC Remote Configuration</i> license must be available.</p>
User Administration	<p>The access to the QC framework can be controlled via user login names and passwords</p> <ul style="list-style-type: none"> <li>• Based on <i>Windows</i> user management or</li> <li>• Using separate user management (including access level and passwords)</li> </ul> <p>The operator rights can be restricted by the QC engineer who may set up the tests and the <i>QC Start</i> test management software accordingly.</p>
Remote Monitoring/ Control	<p>Using standard remote desktop tools (e.g. <i>Windows Remote Desktop</i> or <i>Teamviewer</i>) it is possible to monitor and the operator screen or control the <i>QC Software</i> from a remote PC.</p> <p>A remote support module based on <i>TeamViewer</i> is delivered with the QC software for KLIPPEL support.</p>
Customization – Feature Libraries	<p>Feature libraries are the easiest and recommended solution for customized extensions. They are part of the custom library infrastructure that is provided by the <i>QC Software</i>. This infrastructure allows customizing standard measurement tasks without actually modifying the source code of the tasks. Thus, updating by regular software maintenance does not interfere with customized extensions.</p> <p>Specific features are implemented in individual feature libraries that can be linked into standard task scripts easily.</p> <p>See separate manual for more information.</p>
Software interfaces	<p>A dedicated software interface (<i>IOMonitor</i>) allows slave operation of the <i>QC Software</i> controlled by a master software.</p> <p>An automation interface allows the access of test results by external software.</p>

\*not available in QC Basic

\*\*only available in QC Standard and QC Basic (special application) version

## 6 References

Specifications	<ul style="list-style-type: none"> <li>• QC 6 Software - Feature Overview</li> <li>• A4 – Microphones</li> <li>• A6 – Accessories</li> <li>• A8 – Multiplexer</li> <li>• A14 – Artificial Ears &amp; Mouths</li> <li>• H3 – Klippel Analyzer 3 (KA3)</li> <li>• H6-H11 – Cards for KA3</li> <li>• H4 – QC Production Analyzer</li> <li>• S14 – Remote QC Configuration Tool</li> <li>• S34 – QC IO &amp; Prompt</li> <li>• S35 – QC Yield Statistics</li> <li>• S36 – QC Feature Libraries</li> <li>• S40 – db extract</li> <li>• S55 – QC Post Processing Task</li> <li>• S65 – QC Spectrum Analysis</li> <li>• F1 – dB-Lab</li> </ul> <p>The documents can be downloaded here:  <a href="http://www.klippel.de/go/46">http://www.klippel.de/go/46</a></p>
Manuals	<ul style="list-style-type: none"> <li>• Manual QC</li> <li>• Manual IO Task</li> <li>• Manual dB-Lab</li> <li>• Manual db extract</li> <li>• Manual Hardware</li> <li>• Manual SAN</li> <li>• Manual Feature Libraries</li> <li>• Manual QC Verdict Collector</li> <li>• Manual PP</li> </ul>
Add-on Modules (Specifications)	<ul style="list-style-type: none"> <li>• C6 – QC Linear Suspension Test</li> <li>• S13 – QC MSC - Motor + Suspension Check</li> <li>• S15 – QC Match Speaker Tool</li> <li>• S18 – QC Air Leak Detection</li> <li>• S20 – QC Meta Hearing</li> <li>• S21 – QC Production Noise Immunity</li> <li>• S18 – QC ALS - Air Leak Stethoscope</li> <li>• S31 – QC External Devices</li> <li>• S32 – SYN – External Synchronization</li> <li>• S33 – QC EQA - Equalization &amp; Alignment</li> <li>• S37 – QC DCX – Dynamic Excursion Check and Control</li> <li>• S39 – QC BAC - Balanced Armature Check</li> <li>• S48 – STAT Statistics</li> <li>• S63 – QC 3DL – Spectrogram 3D Limits</li> </ul> <p>Newest information can be found here: <a href="http://www.klippel.de/go/46">http://www.klippel.de/go/46</a></p>
Application Notes	<ul style="list-style-type: none"> <li>• AN42 Tolerances of Resonance Frequency</li> <li>• AN43 Data extraction and post processing</li> <li>• AN44 Creating automated reports</li> <li>• AN45 Optimal Setup for Fixed Time</li> <li>• AN46 Test Enclosure for QC</li> <li>• AN48 Yield Statistics</li> <li>• AN52 Result Export to VACS</li> <li>• AN53 Fast Quality Control of Suspension Charts</li> <li>• AN62 Online Input Equalization</li> <li>• AN64 Housing Ground Check</li> <li>• AN65 Linking Large Signal Testing between QC and R&amp;D</li> <li>• AN73 QC Headphone Testing</li> </ul>

	Application Notes may be downloaded here: <a href="http://www.klippel.de/go/47">http://www.klippel.de/go/47</a>
Applications	Application examples: <a href="http://www.klippel.de/go/48">http://www.klippel.de/go/48</a> Demo Videos: <a href="http://www.klippel.de/go/49">http://www.klippel.de/go/49</a>
Publications	W. Klippel, S. Irrgang, U. Seidel, " <a href="#">Loudspeaker Testing at the Production Line</a> ," presented at the 120th Convention of the Audio Eng. Soc., Paris, France, 2006 May 20-23. W. Klippel, U. Seidel, " <a href="#">Measurement of Impulsive Distortion, Rub and Buzz and other Disturbances</a> ," presented at the 114th Convention of the Audio Eng. Soc., 2003 March 22–25, Amsterdam, The Netherlands, Preprint 5734. Wolfgang Klippel (2011). End-Of-Line Testing, Assembly Line - Theory and Practice, Waldemar Grzechca (Ed.), ISBN: 978-953-307-995-0, InTech, : <a href="http://www.intechopen.com/articles/show/title/end-of-line-testing">http://www.intechopen.com/articles/show/title/end-of-line-testing</a> Find more scientific contributions here: <a href="http://www.klippel.de/go/5">http://www.klippel.de/go/5</a>

## 7 Patents

<b>Germany</b>	P10214407; 102009033614
<b>USA</b>	7,221,167; 12/819,455
<b>China</b>	03108708.6; 201010228820.8

Find explanations for symbols at:

<http://www.klippel.de/know-how/literature.html>

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