$DPU_{scrap} = DPU_{pred} * Scrap\ rate$

$DPU_{rework} = DPU_{pred} - DPU_{scrap}$

$Yield_{pred} = e^{-DPUpred} * 100$

$Sigma_{pred} = [(SQRT(LN(1 / (dpmo_{pred} / 1000000)^2))) - (2.515517 + 0.802853 * (SQRT(LN(1 / (dpmo_{pred} / 1000000)^2))) + 0.010328 * (SQRT(LN(1 / (dpmo_{pred} / 1000000)^2)))^2) / (1 + 1.432788 * (SQRT(LN(1 / (dpmo_{pred} / 1000000)^2))) + 0.189269 * (SQRT(LN(1 / (dpmo_{pred} / 1000000)^2)))^2 + 0.001308 * (SQRT(LN(1 / (dpmo_{pred} / 1000000)^2)))^3)] + 1.5$

Mean Dpmo and Feature Factors Method

$DPU_{avg} = (Total\ Opportunities * DPMO\ Mean) / 1,000,000$

K_{dpu} = Product and/or sum of Non-Rated Feature Characteristic DPMO Factors (K_{factor})

$= K_{factor1} * K_{factor2} + K_{factor3} \ldots K_{factorn}$

$DPU_{pred} = K_{dpu} * DPU_{avg}$

$dpmo_{pred} = DPU_{pred} * 1,000,000 / Total\ Opportunities$

$Yield_{pred} = e^{-DPUpred} * 100$

$Sigma_{pred} = [(SQRT(LN(1 / (dpmo_{pred} / 1000000)^2))) - (2.515517 + 0.802853 * (SQRT(LN(1 / (dpmo_{pred} / 1000000)^2))) + 0.010328 * (SQRT(LN(1 /$