

SOFTWARE QUALITY IN 2010: A SURVEY OF THE STATE OF THE ART

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SOURCES OF QUALITY DATA

Data collected from 1984 through 2010

- **About 675 companies (150 clients in Fortune 500 set)**
- **About 35 government/military groups**
- **About 13,500 total projects**
- **New data = about 50-75 projects per month**
- **Data collected from 24 countries**
- **Observations during more than 15 lawsuits**

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Airlines

Safety hazards

Air traffic control problems

Flight schedule confusion

Navigation equipment failures

Maintenance schedules thrown off

Delay in opening Denver airport

Passengers booked into non-existent seats

Passengers misidentified as terror suspects

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Defense

Security hazards

Base security compromised

Computer security compromised

Strategic weapons malfunction

Command, communication network problems

Aircraft maintenance records thrown off

Logistics and supply systems thrown off

Satellites malfunction

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Finance

Financial transaction

hazards

Interest calculations in error

Account balances thrown off

Credit card charges in error

Funds transfer thrown off

Mortgage/loan interest payments in error

Hacking and identity theft due to software security flaws

Denial of service attacks due to software security flaws

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Health Care

Safety hazards

Patient monitoring devices malfunction

Operating room schedules thrown off

Medical instruments malfunction

Prescription refill problems

Hazardous drug interactions

Billing problems

Medical records stolen or released by accident

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Insurance

Liability, benefit hazards

Policy due dates in error

Policies cancelled in error

Benefits and interest calculation errors

Annuities miscalculated

Errors in actuarial studies

Payment records in error

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

State, Local Governments

Local economic hazards

School taxes miscalculated

Jury records thrown off

Real-estate transactions misfiled

Divorce, marriage records misfiled

Alimony, child support payment records lost

Death records filed for wrong people

Traffic light synchronization thrown off

Errors in property tax assessments

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Manufacturing

Operational hazards

Subcontract parts fail to arrive

Purchases of more or less than economic order quantities

Just-in-time arrivals thrown off

Assembly lines shut down

Aging errors for accounts receivable and cash flow

Aging errors for accounts payable and cash flow

Pension payments miscalculated

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

National Government

Citizen record hazards

Tax records in error

Annuities and entitlements miscalculated

Social Security payments miscalculated or cancelled

Disbursements miscalculated

Retirement benefits miscalculated

Personal data stolen or released by accident

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Public Utilities

Safety hazards

Electric meters malfunction

Gas meters malfunction

Distribution of electric power thrown off

Billing records in error

Nuclear power plants malfunction

SOFTWARE QUALITY HAZARDS IN TEN INDUSTRIES

INDUSTRY

HAZARD

Telecommunications

Service disruption

hazards

Intercontinental switching disrupted

Domestic call switching disrupted

Billing records in error

SOFTWARE QUALITY HAZARDS ALL INDUSTRIES

- 1. Software is blamed for more major business problems than any other man-made product.**
- 2. Poor software quality has become one of the most expensive topics in human history: > \$150 billion per year in U.S.; > \$500 billion per year world wide.**
- 3. Projects cancelled due to poor quality >15% more costly than successful projects of the same size and type.**
- 4. Software executives, managers, and technical personnel are regarded by many CEO's as a painful necessity rather than top professionals.**
- 5. Improving software quality is a key topic for all industries.**

BASIC DEFINITIONS

**SOFTWARE
QUALITY**

Software that combines the characteristics of low defect rates and high user satisfaction

**USER
SATISFACTION**

Clients who are pleased with a vendor's products, quality levels, ease of use, and support

**DEFECT
PREVENTION**

Technologies that minimize the risk of making errors in software deliverables

**DEFECT
REMOVAL**

Activities that find and correct defects in software deliverables

BAD FIXES

Secondary defects injected as a byproduct of defect repairs

FUNDAMENTAL SOFTWARE QUALITY METRICS

- **Defect Potentials**
 - requirements errors, design errors, code errors, document errors, bad fix errors, test plan errors, and test case errors
- **Defects Removed**
 - by origin of defects
 - before testing
 - during testing
 - during deployment
- **Defect Removal Efficiency**
 - ratio of development defects to customer defects
- **Defect Severity Levels (Valid defects)**
 - fatal, serious, minor, cosmetic

FUNDAMENTAL SOFTWARE QUALITY METRICS (cont.)

- **Duplicate Defects**
- **Invalid Defects**
- **Defect Removal Effort and Costs**
 - preparation
 - execution
 - repairs and rework
 - effort on duplicates and invalids
- **Supplemental Quality Metrics**
 - complexity
 - test case volumes
 - test case coverage
 - IBM's orthogonal defect categories

FUNDAMENTAL SOFTWARE QUALITY METRICS (cont.)

- **Standard Cost of Quality**
 - Prevention
 - Appraisal
 - Failures

- **Revised Software Cost of Quality**
 - Defect Prevention
 - Non-Test Defect Removal
 - Testing Defect Removal
 - Post-Release Defect Removal

- **Error-Prone Module Effort**
 - Identification
 - Removal or redevelopment
 - repairs and rework

U.S. AVERAGES FOR SOFTWARE QUALITY

(Data expressed in terms of defects per function point)

<u>Defect Origins</u>	<u>Defect Potential</u>	<u>Removal Efficiency</u>	<u>Delivered Defects</u>
Requirements	1.00	77%	0.23
Design	1.25	85%	0.19
Coding	1.75	95%	0.09
Documents	0.60	80%	0.12
Bad Fixes	<u>0.40</u>	<u>70%</u>	<u>0.12</u>
TOTAL	5.00	85%	0.75

(Function points show all defect sources - not just coding defects)

BEST IN CLASS SOFTWARE QUALITY

(Data expressed in terms of defects per function point)

<u>Defect Origins</u>	<u>Defect Potential</u>	<u>Removal Efficiency</u>	<u>Delivered Defects</u>
Requirements	0.40	85%	0.08
Design	0.60	97%	0.02
Coding	1.00	99%	0.01
Documents	0.40	98%	0.01
Bad Fixes	<u>0.10</u>	<u>95%</u>	<u>0.01</u>
TOTAL	2.50	96%	0.13

OBSERVATIONS

Most often found in systems software > SEI CMM Level 3

POOR SOFTWARE QUALITY - MALPRACTICE

(Data expressed in terms of defects per function point)

<u>Defect Origins</u>	<u>Defect Potential</u>	<u>Removal Efficiency</u>	<u>Delivered Defects</u>
Requirements	1.50	50%	0.75
Design	2.20	50%	1.10
Coding	2.50	80%	0.50
Documents	1.00	70%	0.30
Bad Fixes	<u>0.80</u>	<u>50%</u>	<u>0.40</u>
TOTAL	8.00	62%	3.05

OBSERVATIONS

Most often found in large client-server projects (> 5000 FP).

GOOD QUALITY RESULTS > 90% SUCCESS RATE

- **Formal Inspections (Requirements, Design, and Code)**
- **Static analysis (for about 25 languages out of 2,500 in all)**
- **Joint Application Design (JAD)**
- **Software Six-Sigma methods (tailored for software projects)**
- **Quality Metrics using function points**
- **Quality Metrics using IBM's Orthogonal classification**
- **Defect Removal Efficiency Measurements**
- **Automated Defect tracking tools**
- **Active Quality Assurance (> 5% SQA staff)**
- **Utilization of TSP/PSP approaches**
- **=> Level 3 on the SEI capability maturity model (CMMI)**
- **Virtualization for reuse and debugging**
- **Quality Estimation Tools**
- **Automated Test Support Tools + testing specialists**
- **Root-Cause Analysis**

MIXED QUALITY RESULTS: < 50% SUCCESS RATE

- **Quality Function Deployment (QFD)**
- **Independent Verification & Validation (IV & V)**
- **Total quality management (TQM)**
- **Independent quality audits**
- **Six-Sigma quality programs (without software adjustments)**
- **Baldrige Awards**
- **IEEE Quality Standards**
- **Testing only by Developers**
- **DOD 2167A and DOD 498**
- **Reliability Models**
- **Quality circles in the United States (more success in Japan)**
- **Clean-room methods**
- **Cost of quality without software modifications**

POOR QUALITY RESULTS: < 25% SUCCESS RATE

- **ISO 9000 - 9004 Quality Standards**
- **Informal Testing**
- **Passive Quality Assurance (< 3% QA staff)**
- **Token Quality Assurance (< 1% QA staff)**
- **LOC Metrics for quality (omits non-code defects)**
- **Cost per defect metric (penalizes quality)**
- **Failure to estimate quality or risks early**

A PRACTICAL DEFINITION OF SOFTWARE QUALITY (PREDICTABLE AND MEASURABLE)

- **Low Defect Potentials (< 2.5 per Function Point)**
- **High Defect Removal Efficiency (> 95%)**
- **Unambiguous, Stable Requirements (< 2.5% change)**
- **Explicit Requirements Achieved (> 97.5% achieved)**
- **High User Satisfaction Ratings (> 90% “excellent”)**
 - **Installation**
 - **Ease of learning**
 - **Ease of use**
 - **Functionality**
 - **Compatibility**
 - **Error handling**
 - **User information (screens, manuals, tutorials)**
 - **Customer support**
 - **Defect repairs**

SOFTWARE QUALITY OBSERVATIONS

Quality Measurements Have Found:

- **Individual programmers -- Less than 50% efficient in finding bugs in their own software**
- **Normal test steps -- often less than 75% efficient (1 of 4 bugs remain)**
- **Design Reviews and Code Inspections -- often more than 65% efficient; have topped 90%**
- **Inspections, static analysis, virtualization, plus formal testing – are often more than 95% efficient; have hit 99%**
- **Reviews, Inspections, static analysis, and virtualization -- lower costs and schedules by as much as 30%**

SOFTWARE DEFECT ORIGINS

- 1) Requirements: Hardest to prevent and repair
- 2) Design: Most severe and pervasive
- 3) Code: Most numerous; easiest to fix
- 4) Documentation: Can be serious if ignored
- 5) Bad Fixes: Very difficult to find
- 6) Bad Test Cases: Common and troublesome
- 7) Data quality: Common but hard to measure
- 8) Web content: Unmeasured to date

SOFTWARE DEFECT SEVERITY CATEGORIES

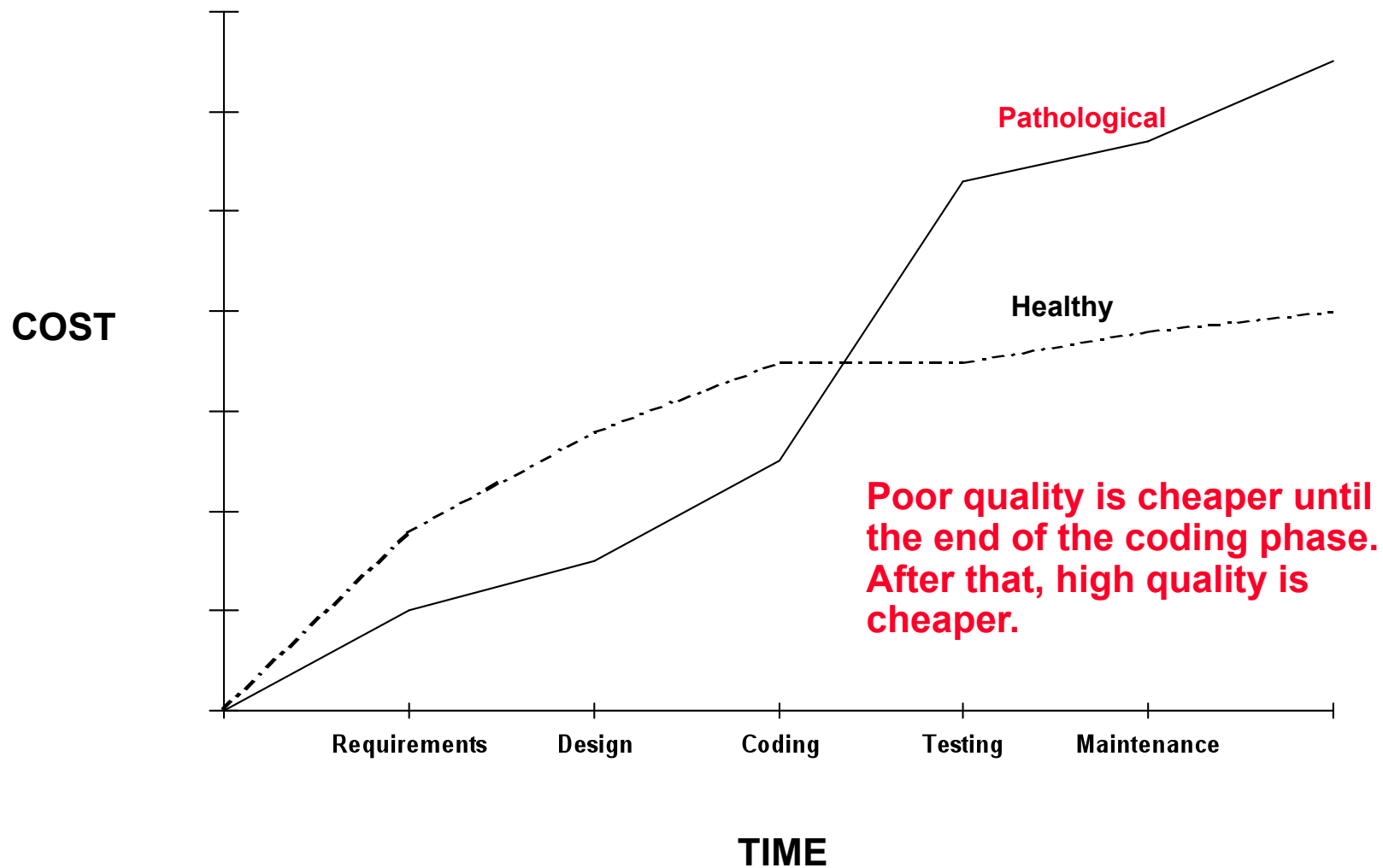
Severity 1:	TOTAL FAILURE S	1% at release
Severity 2:	MAJOR PROBLEMS	20% at release
Severity 3:	MINOR PROBLEMS	35% at release
Severity 4:	COSMETIC ERRORS	44% at release

INVALIDUSER OR SYSTEM ERRORS **15% of reports**

DUPLICATE **MULTIPLE REPORTS** **30% of reports**

ABEYANT **CAN'T RECREATE ERROR** **5% of reports**

HOW QUALITY AFFECTS SOFTWARE COSTS



U. S. SOFTWARE QUALITY AVERAGES CIRCA 2010

(Defects per Function Point)

	System Software	Commercial Software	Information Software	Military Software	Outsource Software
Defect Potentials	6.0	5.0	4.5	7.0	5.2
Defect Removal Efficiency	94%	90%	73%	96%	92%
Delivered Defects	0.4	0.5	1.2	0.3	0.4
First Year Discovery Rate	65%	70%	30%	75%	60%
First Year Reported Defects	0.26	0.35	0.36	0.23	0.30

U. S. SOFTWARE QUALITY AVERAGES CIRCA 2010

(Defects per Function Point)

	Web Software	Embedded Software	SEI-CMM 3 Software	SEI-CMM 1 Software	Overall Average
Defect Potentials	4.0	5.5	3.0	5.5	5.1
Defect Removal Efficiency	72%	95%	95%	73%	86.7%
Delivered Defects	1.1	0.3	0.15	1.5	0.68
First Year Discovery Rate	95%	90%	60%	35%	64.4%
First Year Reported Defects	1.0	0.27	0.09	0.52	0.43

SOFTWARE SIZE VS DEFECT REMOVAL EFFICIENCY

(Data Expressed in terms of Defects per Function Point)

Size	Defect Potential	Defect Removal Efficiency	Delivered Defects	1st Year Discovery Rate	1st Year Reported Defects
1	1.85	95.00%	0.09	90.00%	0.08
10	2.45	92.00%	0.20	80.00%	0.16
100	3.68	90.00%	0.37	70.00%	0.26
1000	5.00	85.00%	0.75	50.00%	0.38
10000	7.60	78.00%	1.67	40.00%	0.67
100000	9.55	75.00%	2.39	30.00%	0.72
AVERAGE	5.02	85.83%	0.91	60.00%	0.38

SOFTWARE DEFECT POTENTIALS AND DEFECT REMOVAL EFFICIENCY FOR EACH LEVEL OF SEI CMM

**(Data Expressed in Terms of Defects per Function Point
For projects nominally 1000 function points in size)**

SEI CMM Levels	Defect Potentials	Removal Efficiency	Delivered Defects
SEI CMMI 1	5.00	80%	1.00
SEI CMMI 2	4.00	90%	0.40
SEI CMMI 3	3.00	95%	0.15
SEI CMMI 4	2.00	97%	0.08
SEI CMMI 5	1.00	99%	0.01
SEI CMMI 6 (TSP/PSP)	1.00	99.5%	<0.01

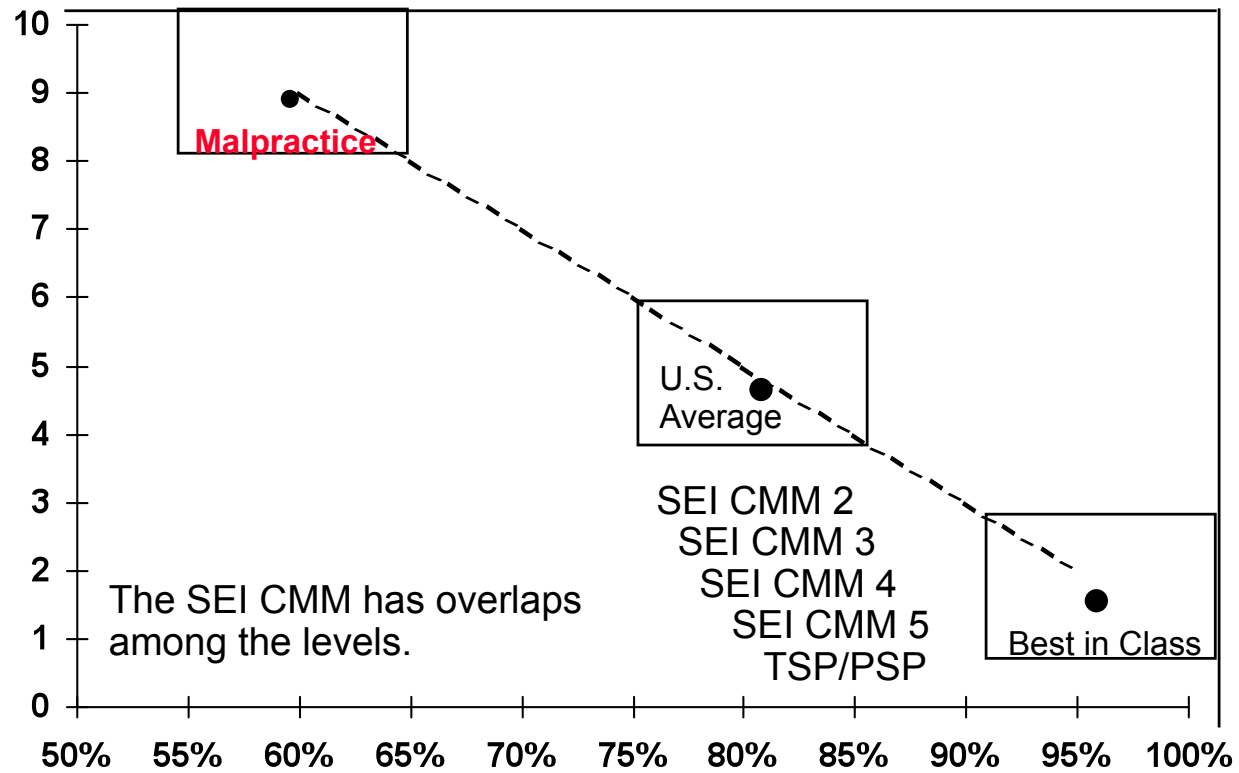
SOFTWARE DEFECT POTENTIALS AND DEFECT REMOVAL EFFICIENCY FOR EACH LEVEL OF SEI CMM

**(Data Expressed in Terms of Defects per Function Point
For projects > 5000 function points in size)**

SEI CMM Levels	Defect Potentials	Removal Efficiency	Delivered Defects
SEI CMMI 1	5.50	73%	1.48
SEI CMMI 2	4.00	90%	0.40
SEI CMMI 3	3.00	95%	0.15
SEI CMMI 4	2.50	97%	0.008
SEI CMMI 5	2.25	98%	0.005
SEI CMMI 6 (TSP/PSP)	2.00	99%	0.004

MAJOR SOFTWARE QUALITY ZONES

Defects
per FP



Defect Removal Efficiency

INDUSTRY-WIDE DEFECT CAUSES

Ranked in order of effort required to fix the defects:

- 1. Requirements problems (omissions; changes, errors)**
- 2. Design problems (omissions; changes; errors)**
- 3. Interface problems between modules**
- 4. Logic, branching, and structural problems**
- 5. Memory allocation problems**
- 6. Testing omissions and poor coverage**
- 7. Test case errors**
- 8. Stress/performance problems**
- 9. Bad fixes/Regressions**
- 10. Documentation errors**

OPTIMIZING QUALITY AND PRODUCTIVITY

Projects that achieve 95% cumulative Defect Removal Efficiency will find:

- 1) Minimum schedules**
- 2) Maximum productivity**
- 3) High levels of user and team satisfaction**
- 4) Low levels of delivered defects**
- 5) Low levels of maintenance costs**
- 6) Low risk of litigation**

INDUSTRY DATA ON DEFECT ORIGINS

Because defect removal is such a major cost element, studying defect origins is a valuable undertaking.

IBM Corporation (MVS)

45%	Design errors
25%	Coding errors
20%	Bad fixes
5%	Documentation errors
5%	Administrative errors
<hr/>	
100%	

SPR Corporation (client studies)

20%	Requirements errors
30%	Design errors
35%	Coding errors
10%	Bad fixes
5%	Documentation errors
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100%	

TRW Corporation

60%	Design errors
40%	Coding errors
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100%	

Mitre Corporation

64%	Design errors
36%	Coding errors
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100%	

Nippon Electric Corp.

60%	Design errors
40%	Coding errors
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100%	

SOFTWARE QUALITY AND PRODUCTIVITY

- **The most effective way of improving software productivity and shortening project schedules is to reduce defect levels.**
- **Defect reduction can occur through:**
 - 1. Defect prevention technologies**
 - Structured design and JAD**
 - Structured code**
 - Use of inspections, static analysis**
 - Reuse of certified components**
 - 2. Defect removal technologies**
 - Design inspections**
 - Code inspections, static analysis**
 - Virtualization**
 - Formal Testing**

DEFECT PREVENTION METHODS

DEFECT PREVENTION

- **Joint Application Design (JAD)**
- **Quality function deployment (QFD)**
- **Software reuse (high-quality components)**
- **Root cause analysis**
- **Six-Sigma quality programs for software**
- **Usage of TSP/PSP methods**
- **Climbing > Level 3 on the SEI CMMI**
- **Virtualization, static analysis, inspections**

DEFECT PREVENTION - Continued

DEFECT PREVENTION

- **Total quality management (TQM)**
- **Quality measurements**
- **Quality Circles**
- **Orthogonal defect analysis**
- **Defect tracking tools**
- **Formal design inspections**
- **Formal code inspections**
- **Embedding users with development team (Agile methods)**

DEFECT REMOVAL METHODS

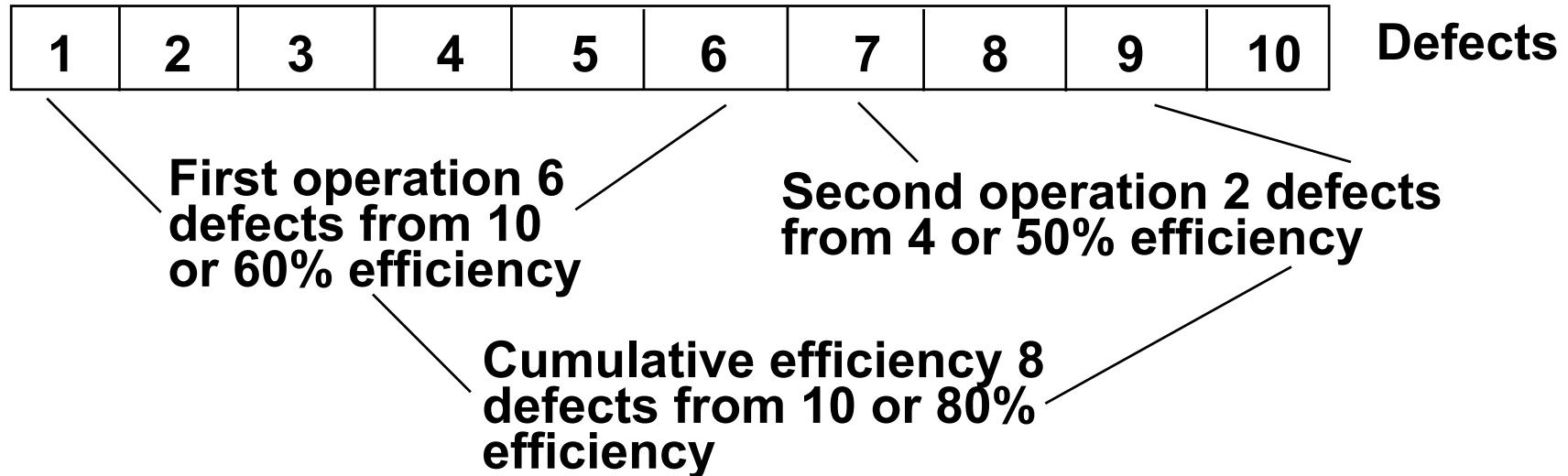
DEFECT REMOVAL

- **Requirements inspections**
- **Design inspections**
- **Test plan inspections**
- **Test case inspections**
- **Static analysis (C, Java, COBOL, SQL etc.)**
- **Code inspections**
- **Automated testing (unit, performance)**
- **All forms of manual testing (more than 17 kinds of test)**

DEFECT REMOVAL EFFICIENCY

- **Defect removal efficiency is a key quality measure**
- **Removal efficiency = $\frac{\text{Defects found}}{\text{Defects present}}$**
- **“Defects present” is the critical parameter**

DEFECT REMOVAL EFFICIENCY - continued



Defect removal efficiency =

Percentage of defects removed by a single level of review, inspection or test

Cumulative defect removal efficiency =

Percentage of defects removed by a series of reviews, inspections or tests

DEFECT REMOVAL EFFICIENCY EXAMPLE

DEVELOPMENT DEFECTS

Inspections	500
Testing	400
Subtotal	900

USER-REPORTED DEFECTS IN FIRST 90 DAYS

Valid unique defects	100
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TOTAL DEFECT VOLUME

Defect totals	1000
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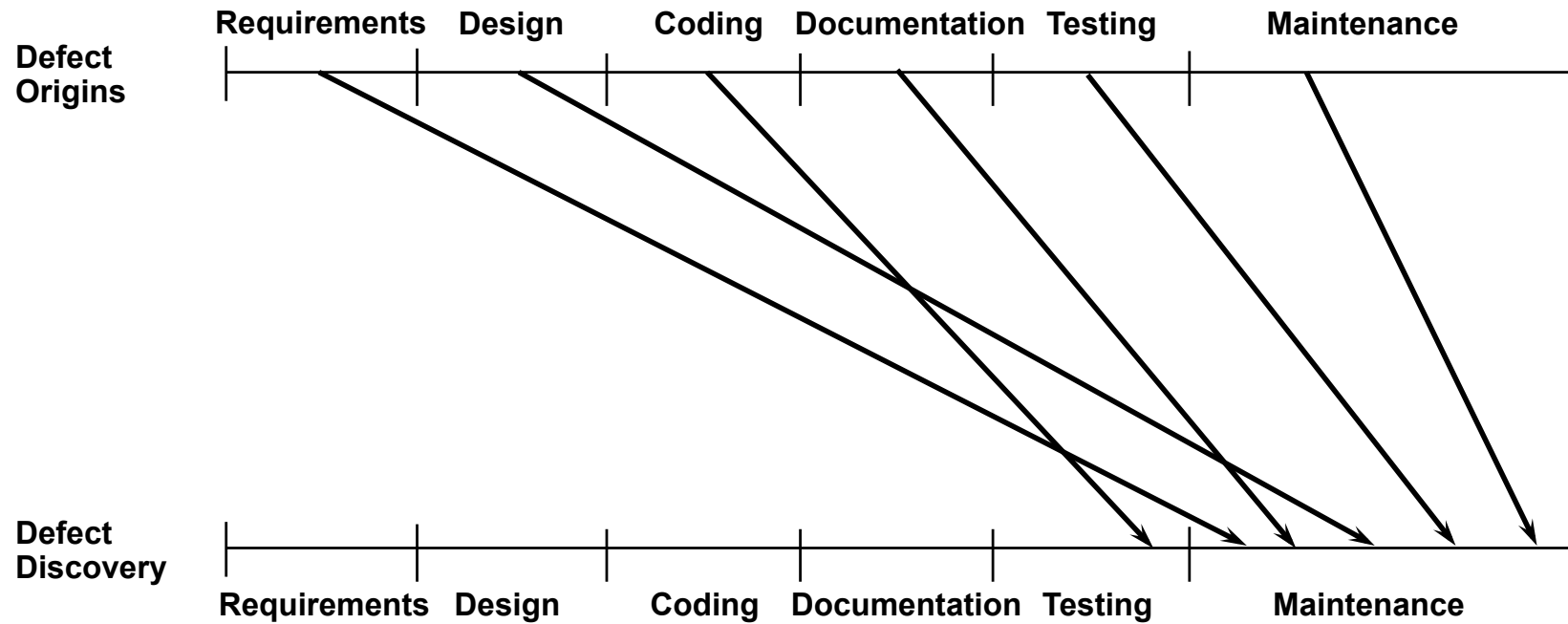
REMOVAL EFFICIENCY

$$\text{Dev. (900) / Total (1000) = 90\%}$$

RANGES OF DEFECT REMOVAL EFFICIENCY

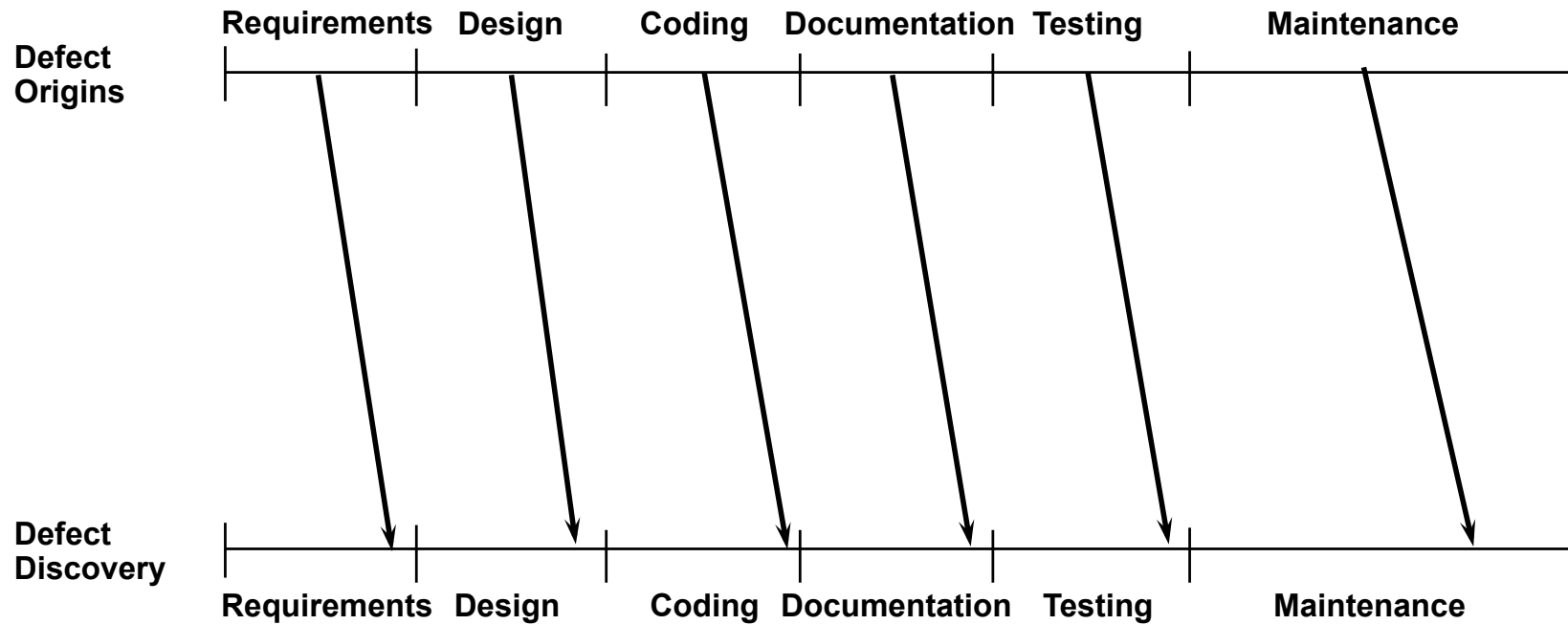
	<u>Lowest</u>	<u>Median</u>	<u>Highest</u>
1 Requirements review	20%	30%	50%
2 Top-level design reviews	30%	40%	60%
3 Detailed functional design reviews	30%	45%	65%
4 Detailed logic design reviews	35%	55%	75%
5 Code inspection or static analysis	35%	60%	85%
6 Unit tests	10%	25%	50%
7 New Function tests	20%	35%	55%
8 Integration tests	25%	45%	60%
9 System test	25%	50%	65%
10 External Beta tests	15%	40%	75%
CUMULATIVE EFFICIENCY	75%	97%	99.99%

NORMAL DEFECT ORIGIN/DISCOVERY GAPS



Zone of Chaos

DEFECT ORIGINS/DISCOVERY WITH INSPECTIONS



SOFTWARE DEFECT REMOVAL RANGES

WORST CASE RANGE

TECHNOLOGY COMBINATIONS

DEFECT REMOVAL EFFICIENCY

	Lowest	Median	Highest
1. No Design Inspections No Code Inspections or static analysis No Quality Assurance No Formal Testing	30%	40%	50%

SOFTWARE DEFECT REMOVAL RANGES (cont.)

TECHNOLOGY COMBINATIONS	SINGLE TECHNOLOGY CHANGES		
	DEFECT REMOVAL EFFICIENCY		
	Lowest	Median	Highest
2. No design inspections No code inspections or static analysis FORMAL QUALITY ASSURANCE No formal testing	32%	45%	55%
3. No design inspections No code inspections or static analysis No quality assurance FORMAL TESTING	37%	53%	60%
4. No design inspections CODE INSPECTIONS/STATIC ANALYSIS No quality assurance No formal testing	43%	57%	65%
5. FORMAL DESIGN INSPECTIONS No code inspections or static analysis No quality assurance No formal testing	45%	60%	68%

SOFTWARE DEFECT REMOVAL RANGES (cont.)

TWO TECHNOLOGY CHANGES

TECHNOLOGY COMBINATIONS	DEFECT REMOVAL EFFICIENCY		
	Lowest	Median	Highest
6. No design inspections No code inspections or static analysis FORMAL QUALITY ASSURANCE FORMAL TESTING	50%	65%	75%
7. No design inspections FORMAL CODE INSPECTIONS/STAT. AN. FORMAL QUALITY ASSURANCE No formal testing	53%	68%	78%
8. No design inspections FORMAL CODE INSPECTIONS/STAT.AN. No quality assurance FORMAL TESTING	55%	70%	80%

SOFTWARE DEFECT REMOVAL RANGES (cont.)

TWO TECHNOLOGY CHANGES - continued

TECHNOLOGY COMBINATIONS	DEFECT REMOVAL EFFICIENCY		
	Lowest	Median	Highest
9. FORMAL DESIGN INSPECTIONS No code inspections or static analysis FORMAL QUALITY ASSURANCE No formal testing	60%	75%	85%
10. FORMAL DESIGN INSPECTIONS No code inspections or static analysis No quality assurance FORMAL TESTING	65%	80%	87%
11. FORMAL DESIGN INSPECTIONS FORMAL CODE INSPECTIONS/STAT.AN. No quality assurance No formal testing	70%	85%	90%

SOFTWARE DEFECT REMOVAL RANGES (cont.)

THREE TECHNOLOGY CHANGES

TECHNOLOGY COMBINATIONS	DEFECT REMOVAL EFFICIENCY		
	Lowest	Median	Highest
12. No design inspections FORMAL CODE INSPECTIONS/STAT.AN. FORMAL QUALITY ASSURANCE FORMAL TESTING	75%	87%	93%
13. FORMAL DESIGN INSPECTIONS No code inspections or static analysis FORMAL QUALITY ASSURANCE FORMAL TESTING	77%	90%	95%
14. FORMAL DESIGN INSPECTIONS FORMAL CODE INSPECTIONS/STAT. AN. FORMAL QUALITY ASSURANCE No formal testing	83%	95%	97%
15. FORMAL DESIGN INSPECTIONS FORMAL CODE INSPECTIONS/STAT.AN. No quality assurance FORMAL TESTING	85%	97%	99%

SOFTWARE DEFECT REMOVAL RANGES (cont.)

BEST CASE RANGE

TECHNOLOGY COMBINATIONS

DEFECT REMOVAL EFFICIENCY

	Lowest	Median	Highest
1. FORMAL DESIGN INSPECTIONS	95%	99%	99.99%
STATIC ANALYSIS			
FORMAL CODE INSPECTIONS			
FORMAL QUALITY ASSURANCE			
FORMAL TESTING			

DISTRIBUTION OF 1500 SOFTWARE PROJECTS BY DEFECT REMOVAL EFFICIENCY LEVEL

Defect Removal Efficiency Level (Percent)	Number of Projects	Percent of Projects
> 99	6	0.40%
95 - 99	104	6.93%
90 - 95	263	17.53%
85 - 90	559	37.26%
80 - 85	408	27.20%
< 80	161	10.73%
Total	1,500	100.00%

SOFTWARE QUALITY UNKNOWNNS IN 2010

SOFTWARE QUALITY TOPICS NEEDING RESEARCH:

Errors in software test plans and test cases

Errors in web content such as graphics and sound

Correlations between security flaws and quality flaws

Supply chain defect removal

Error content of data bases, repositories, warehouses

Causes of bad-fix injection rates

Impact of complexity on quality and defect removal

Impact of creeping requirements

2010 QUALITY RESEARCH TOPICS

Quality levels of Agile projects

Quality levels of Extreme (XP) programming

Quality levels of object-oriented (OO) development

Quality levels of web applications

Quality levels of Microsoft applications

Quality levels of Linux and open source software

Quality levels or ERP applications

Effectiveness of automatic testing methods

CONCLUSIONS ON SOFTWARE QUALITY

- **No single quality method is adequate by itself.**
- **Six-Sigma provides the broadest quality focus**
- **Formal inspections, static analysis are most efficient**
- **Inspections + static analysis + testing > 97% efficient.**
- **Defect prevention + removal best overall**
- **Quality excellence has ROI > \$15 for each \$1 spent**
- **High quality benefits schedules, productivity, users**
- **Virtualization is also a quality tool**

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