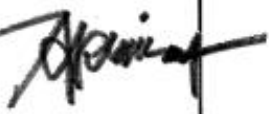




LEMBAR REVISI
LAPORAN KERJA PRAKTEK

Nama : Risda Rusdayani
 NIM : 2017220013
 Pembimbing : Dr. Ir. Budi Sumartono, M.T.
 Penguji : 1. Ir. Atik Kurnianto, M.Eng
 2. Dr. Ade Supriatna, ST, MT
 3. Ir. Jamaluddin Purba, M.T.

NO	DOSEN PENGUJI	REVISI	PARAF
1	Ir Atik Kurnianto, M.Eng	Judul Skripsi	
		Faktor penyebab kecacatan harus dijelaskan lebih spesifik (5W+1H)	
		Dikemukakan proses tahapan taguchinya	
2	Dr. Ade Supriatna, ST, MT	Settingan awal pada Mesinnya	
		Faktor penyebab cacat utama hasil penelitian	
3	Ir. Jamaludin Purba, M.T	Hilangkan kata PT Gelora Aksara Prata dalam Kata Kunci	
		Penjabaran tools pengendalian kualitas yang digunakan.	

LAMPIRAN

Lampiran 1 : Perhitungan Olah Data Analysis of Variance (ANOVA)

1. Menghitung nilai *sum of squares due to factors*.

$$\begin{aligned}
 S_B &= \left(\frac{f_{I^2A1}}{n_{IA1}} + \frac{f_{I^2A2}}{n_{IA2}} - \frac{f_{I^2}}{n_{IA}} \right) W_1 + \left(\frac{f_{II^2A1}}{n_{IIA1}} + \frac{f_{II^2A2}}{n_{IIA2}} - \frac{f_{II^2}}{n_{IIA}} \right) W_1 \\
 &= \left(\frac{741^2}{1000} + \frac{610^2}{1000} - \frac{1351^2}{2000} \right) 4,56 + \left(\frac{259^2}{1000} + \frac{390^2}{1000} - \frac{649^2}{2000} \right) 4,56 \\
 &= 78,2542
 \end{aligned}$$

$$\begin{aligned}
 S_C &= \left(\frac{f_{I^2A1}}{n_{IA1}} + \frac{f_{I^2A2}}{n_{IA2}} - \frac{f_{I^2}}{n_{IA}} \right) W_1 + \left(\frac{f_{II^2A1}}{n_{IIA1}} + \frac{f_{II^2A2}}{n_{IIA2}} - \frac{f_{II^2}}{n_{IIA}} \right) W_1 \\
 &= \left(\frac{657^2}{1000} + \frac{694^2}{1000} - \frac{1351^2}{2000} \right) 4,56 + \left(\frac{343^2}{1000} + \frac{306}{1000} - \frac{649^2}{2000} \right) 4,56 \\
 &= 6,2426
 \end{aligned}$$

2. Menghitung *the degrees of freedom for a factor*.

$$\begin{aligned}
 V_B &= (\text{number of class} - 1) \times (\text{number of levels} - 1) \\
 &= (2 - 1) \times (2 - 1) = 1
 \end{aligned}$$

$$\begin{aligned}
 V_C &= (\text{number of class} - 1) \times (\text{number of levels} - 1) \\
 &= (2 - 1) \times (2 - 1) = 1
 \end{aligned}$$

3. Menghitung nilai *mean of squares*.

$$\begin{aligned}
 MS_B &= \frac{S_B}{V_B} \\
 &= \frac{78,2542}{1} = 78,2542
 \end{aligned}$$

$$MS_C = \frac{S_C}{V_C}$$

$$= \frac{6,2426}{1} = 6,2426$$

4. Menghitung nilai *F-ratio*

$$F\text{-ratio} = \frac{MSB}{MSe} = \frac{78,2542}{0,9512} = 82,2689$$

$$F\text{-ratio} = \frac{MSC}{MSe} = \frac{6,2426}{0,9512} = 6,5629$$

5. Menghitung *pure sum of squares*.

$$S_A' = S_A - V_A \times MSe$$

$$= 16,9678 - 1 \times 0,9512 = 16,0166$$

$$S_B' = S_B - V_B \times MSe$$

$$= 78,2542 - 1 \times 0,9512 = 77,3030$$

$$S_C' = S_C - V_C \times MSe$$

$$= 6,2426 - 1 \times 0,9512 = 5,2915$$

6. Menghitung *percent contribution*.

$$\text{Rho}\% = \frac{S_A'}{ST} = \frac{16,0166}{2000} = 0,0080 = 0,80\%$$

$$\text{Rho}\% = \frac{S_B'}{ST} = \frac{77,3030}{2000} = 0,0387 = 3,87\%$$

$$\text{Rho}\% = \frac{S_C'}{ST} = \frac{5,2915}{2000} = 0,0031 = 0,31\%$$

Lampiran 2 : Perhitungan nilai Signal to-Noise Ratio (SNR)

Nilai SNR dapat dihitung dengan rumus sebagai berikut:

$$\text{SNR} = -10 \text{Log}_{10} \left(\frac{1}{p} - 1 \right)$$

$$1. \text{SNR}_{A1} = -10 \text{Log}_{10} \left(\frac{1}{0,355} - 1 \right) = -2,59$$

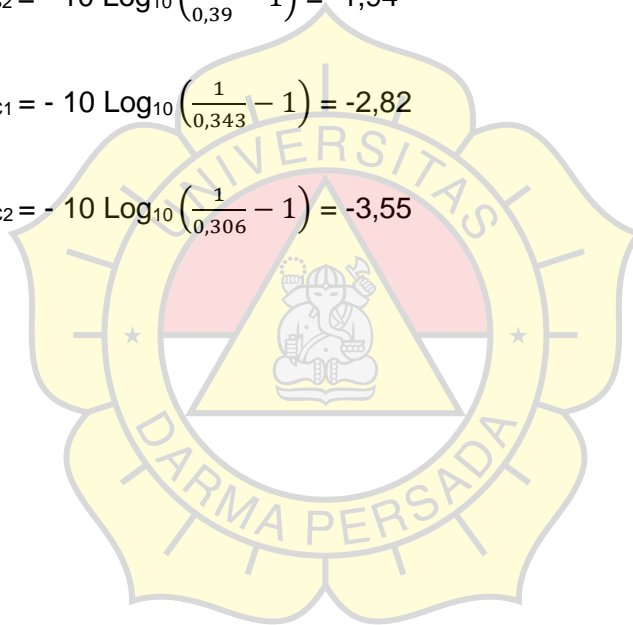
$$2. \text{SNR}_{A2} = -10 \text{Log}_{10} \left(\frac{1}{0,294} - 1 \right) = -3,80$$

$$3. \text{SNR}_{B1} = -10 \text{Log}_{10} \left(\frac{1}{0,259} - 1 \right) = -4,56$$

$$4. \text{SNR}_{B2} = -10 \text{Log}_{10} \left(\frac{1}{0,39} - 1 \right) = -1,94$$

$$5. \text{SNR}_{C1} = -10 \text{Log}_{10} \left(\frac{1}{0,343} - 1 \right) = -2,82$$

$$6. \text{SNR}_{C2} = -10 \text{Log}_{10} \left(\frac{1}{0,306} - 1 \right) = -3,55$$



Lampiran 3 : Perhitungan Level Sigma setelah dilakukan *Improvement*

1. Perhitungan nilai DPU

$$DPU = \frac{Defect}{unit} = \frac{13.547}{741.720} = 0,0183 = 1,83\%$$

2. Perhitungan Total Opportunities

$$\begin{aligned} TOP &= U \times OP \\ &= 741.720 \times 4 \text{ CTQ} \\ &= 2.966.880 \end{aligned}$$

3. Perhitungan nilai DPO

$$\begin{aligned} DPO &= \frac{Defect}{TOP} \\ &= \frac{13.574}{2.966.880} = 0,0046 \end{aligned}$$

4. Perhitungan nilai DPMO

$$\begin{aligned} DPMO &= DPO \times 1.000.000 \\ &= 0,0046 \times 1.000.000 \\ &= 4600 \text{ DPMO} \end{aligned}$$

LAMPIRAN 4

Tabel Konversi Nilai DPMO Ke Level Sigma

LAMPIRAN
Konversi DPMO ke Nilai Sigma Berdasarkan Konsep Motorola

Nilai Sigma	DPMO	Nilai Sigma	DPMO	Nilai Sigma	DPMO	Nilai Sigma	DPMO
0,00	933.193	0,51	838.913	1,02	684.386	1,53	488.033
0,01	931.888	0,52	836.457	1,03	680.822	1,54	484.047
0,02	930.563	0,53	833.977	1,04	677.242	1,55	480.061
0,03	929.219	0,54	831.472	1,05	673.645	1,56	476.078
0,04	927.855	0,55	828.944	1,06	670.031	1,57	472.097
0,05	926.471	0,56	826.391	1,07	666.402	1,58	468.119
0,06	925.066	0,57	823.814	1,08	662.757	1,59	464.144
0,07	923.641	0,58	821.214	1,09	659.097	1,60	460.172
0,08	922.196	0,59	818.589	1,10	655.422	1,61	456.205
0,09	920.730	0,60	815.940	1,11	651.732	1,62	452.242
0,10	919.243	0,61	813.267	1,12	648.027	1,63	448.283
0,11	917.736	0,62	810.570	1,13	644.309	1,64	444.330
0,12	916.207	0,63	807.850	1,14	640.576	1,65	440.382
0,13	914.656	0,64	805.106	1,15	636.831	1,66	436.441
0,14	913.085	0,65	802.338	1,16	633.072	1,67	432.505
0,15	911.492	0,66	799.546	1,17	629.300	1,68	428.576
0,16	909.877	0,67	796.731	1,18	625.516	1,69	424.655
0,17	908.241	0,68	793.892	1,19	621.719	1,70	420.740
0,18	906.582	0,69	791.030	1,20	617.911	1,71	416.834
0,19	904.902	0,70	788.145	1,21	614.092	1,72	412.936
0,20	903.199	0,71	785.236	1,22	610.261	1,73	409.046
0,21	901.475	0,72	782.305	1,23	606.420	1,74	405.165
0,22	899.727	0,73	779.350	1,24	602.568	1,75	401.294
0,23	897.958	0,74	776.373	1,25	598.706	1,76	397.432
0,24	896.165	0,75	773.373	1,26	594.835	1,77	393.580
0,25	894.350	0,76	770.350	1,27	590.954	1,78	389.739
0,26	892.512	0,77	767.305	1,28	587.064	1,79	385.908
0,27	890.651	0,78	764.238	1,29	583.166	1,80	382.089
0,28	888.767	0,79	761.148	1,30	579.260	1,81	378.281
0,29	886.860	0,80	758.036	1,31	575.345	1,82	374.484
0,30	884.930	0,81	754.903	1,32	571.424	1,83	370.700
0,31	882.977	0,82	751.748	1,33	567.495	1,84	366.928
0,32	881.000	0,83	748.571	1,34	563.559	1,85	363.169
0,33	878.999	0,84	745.373	1,35	559.618	1,86	359.424
0,34	876.976	0,85	742.154	1,36	555.670	1,87	355.691
0,35	874.928	0,86	738.914	1,37	551.717	1,88	351.973
0,36	872.857	0,87	735.653	1,38	547.758	1,89	348.268
0,37	870.762	0,88	732.371	1,39	543.795	1,90	344.578
0,38	868.643	0,89	729.069	1,40	539.828	1,91	340.903
0,39	866.500	0,90	725.747	1,41	535.856	1,92	337.243
0,40	864.334	0,91	722.405	1,42	531.881	1,93	333.598
0,41	862.143	0,92	719.043	1,43	527.903	1,94	329.969
0,42	859.929	0,93	715.661	1,44	523.922	1,95	326.355
0,43	857.690	0,94	712.260	1,45	519.939	1,96	322.758
0,44	855.428	0,95	708.840	1,46	515.953	1,97	319.178
0,45	853.141	0,96	705.402	1,47	511.967	1,98	315.614
0,46	850.830	0,97	701.944	1,48	507.978	1,99	312.067
0,47	848.495	0,98	698.468	1,49	503.989	2,00	308.538
0,48	846.136	0,99	694.974	1,50	500.000	2,01	305.026
0,49	843.752	1,00	691.462	1,51	496.011	2,02	301.532
0,50	841.345	1,01	687.933	1,52	492.022	2,03	298.056

Sumber: nilai-nilai dibangkitkan menggunakan program oleh: Vincent Gasperz (2002)

Konversi DPMO ke Nilai Sigma Berdasarkan Konsep Motorola (Lanjutan)

Nilai Sigma	DPMO	Nilai Sigma	DPMO	Nilai Sigma	DPMO	Nilai Sigma	DPMO
2,04	294.598	2,55	146.859	3,06	59.380	3,57	19.226
2,05	291.160	2,56	144.572	3,07	58.208	3,58	18.763
2,06	287.740	2,57	142.310	3,08	57.053	3,59	18.309
2,07	284.339	2,58	140.071	3,09	55.917	3,60	17.864
2,08	280.957	2,59	137.857	3,10	54.799	3,61	17.429
2,09	277.595	2,60	135.666	3,11	53.699	3,62	17.003
2,10	274.253	2,61	133.500	3,12	52.616	3,63	16.586
2,11	270.931	2,62	131.357	3,13	51.551	3,64	16.177
2,12	267.629	2,63	129.238	3,14	50.503	3,65	15.778
2,13	264.347	2,64	127.143	3,15	49.471	3,66	15.386
2,14	261.086	2,65	125.072	3,16	48.457	3,67	15.003
2,15	257.846	2,66	123.024	3,17	47.460	3,68	14.629
2,16	254.627	2,67	121.001	3,18	46.479	3,69	16.262
2,17	251.429	2,68	119.000	3,19	45.514	3,70	13.903
2,18	248.252	2,69	117.023	3,20	44.565	3,71	13.553
2,19	245.097	2,70	115.070	3,21	43.633	3,72	13.209
2,20	241.964	2,71	113.140	3,22	42.716	3,73	12.874
2,21	238.852	2,72	111.233	3,23	41.815	3,74	12.545
2,22	235.762	2,73	109.349	3,24	40.929	3,75	12.224
2,23	232.695	2,74	107.488	3,25	40.059	3,76	11.911
2,24	229.650	2,75	105.650	3,26	39.204	3,77	11.604
2,25	226.627	2,76	103.835	3,27	38.364	3,78	11.304
2,26	223.627	2,77	102.042	3,28	37.538	3,79	11.011
2,27	220.650	2,78	100.273	3,29	36.727	3,80	10.724
2,28	217.695	2,79	98.525	3,30	35.930	3,81	10.444
2,29	214.764	2,80	96.801	3,31	35.148	3,82	10.170
2,30	211.855	2,81	95.098	3,32	34.379	3,83	9.903
2,31	208.970	2,82	93.418	3,33	33.625	3,84	9.642
2,32	206.108	2,83	91.759	3,34	32.884	3,85	9.387
2,33	203.269	2,84	90.123	3,35	32.157	3,86	9.137
2,34	200.454	2,85	88.508	3,36	31.443	3,87	8.894
2,35	197.662	2,86	86.915	3,37	30.742	3,88	8.656
2,36	194.894	2,87	85.344	3,38	30.054	3,89	8.424
2,37	192.150	2,88	83.793	3,39	29.379	3,90	8.198
2,38	189.430	2,89	82.264	3,40	28.716	3,91	7.976
2,39	186.733	2,90	80.757	3,41	28.067	3,92	7.760
2,40	184.060	2,91	79.270	3,42	27.429	3,93	7.549
2,41	181.411	2,92	77.804	3,43	26.803	3,94	7.344
2,42	178.786	2,93	76.359	3,44	26.190	3,95	7.143
2,43	176.186	2,94	74.934	3,45	25.588	3,96	6.947
2,44	173.609	2,95	73.529	3,46	24.998	3,97	6.756
2,45	171.056	2,96	72.145	3,47	24.419	3,98	6.569
2,46	168.528	2,97	70.781	3,48	23.852	3,99	6.387
2,47	166.023	2,98	69.437	3,49	23.295	4,00	6.210
2,48	163.543	2,99	68.112	3,50	22.750	4,01	6.037
2,49	161.087	3,00	66.807	3,51	22.215	4,02	5.868
2,50	158.655	3,01	65.522	3,52	21.692	4,03	5.703
2,51	156.248	3,02	64.256	3,53	21.178	4,04	5.543
2,52	153.864	3,03	63.008	3,54	20.675	4,05	5.386
2,53	151.505	3,04	61.780	3,55	20.182	4,06	5.234
2,54	149.170	3,05	60.571	3,56	19.699	4,07	5.085

Sumber: nilai-nilai dibangkitkan menggunakan program oleh: Vincent Gasparisz (2002)

LAMPIRAN 5
NILAI-NILAI DALAM DISTRIBUSI T

α untuk uji dua pihak (two tail test)						
	0,50	0,20	0,10	0,05	0,02	0,01
α untuk uji satu pihak (one tail test)						
dk	0,25	0,10	0,05	0,025	0,01	0,005
1	1,000	3,078	6,314	12,706	31,821	63,657
2	0,816	1,886	2,920	4,303	6,965	9,925
3	0,765	1,638	2,353	3,182	4,541	5,841
4	0,741	1,533	2,132	2,776	3,747	4,604
5	0,727	1,476	2,015	2,571	3,365	4,032
6	0,718	1,440	1,943	2,447	3,143	3,707
7	0,711	1,415	1,895	2,365	2,998	3,499
8	0,706	1,397	1,860	2,306	2,896	3,355
9	0,703	1,383	1,833	2,262	2,821	3,250
10	0,700	1,372	1,812	2,228	2,764	3,169
11	0,697	1,363	1,796	2,201	2,718	3,106
12	0,695	1,356	1,782	2,179	2,681	3,055
13	0,692	1,350	1,771	2,160	2,650	3,012
14	0,691	1,345	1,761	2,145	2,624	2,977
15	0,690	1,341	1,753	2,131	2,602	2,947
16	0,689	1,337	1,746	2,120	2,583	2,921
17	0,688	1,333	1,740	2,110	2,567	2,898
18	0,688	1,330	1,734	2,101	2,552	2,878
19	0,687	1,328	1,729	2,093	2,539	2,861
20	0,687	1,325	1,725	2,086	2,528	2,845
21	0,686	1,323	1,721	2,080	2,518	2,831
22	0,686	1,321	1,717	2,074	2,508	2,819

23	0,685	1,319	1,714	2,069	2,500	2,807
24	0,685	1,318	1,711	2,064	2,492	2,797
25	0,684	1,316	1,708	2,060	2,485	2,787
26	0,684	1,315	1,706	2,056	2,479	2,779
27	0,684	1,314	1,703	2,052	2,473	2,771
28	0,683	1,313	1,701	2,048	2,467	2,763
29	0,683	1,311	1,699	2,045	2,462	2,756
30	0,683	1,310	1,697	2,042	2,457	2,750
40	0,681	1,303	1,684	2,021	2,423	2,704
60	0,679	1,296	1,671	2,000	2,390	2,660
120	0,677	1,289	1,658	1,980	2,358	2,617
~	0,674	1,282	1,645	1,960	2,326	2,576

(Sugiyono, 2010; 372)

Tabel of F-statistics P=0,05										
df2/df1	1	2	3	4	5	6	7	8	9	10
3	10.13	9.55	9.28	9.12	9.01	8.94	8.89	8.85	8.81	8.79
4	7.71	6.94	6.59	6.39	6.26	6.16	6.09	6.04	6.00	5.96
5	6.61	5.79	5.41	5.19	5.05	4.95	4.88	4.82	4.77	4.74
6	5.99	5.14	4.76	4.53	4.39	4.28	4.21	4.15	4.10	4.06
7	5.59	4.74	4.35	4.12	3.98	3.87	3.79	3.73	3.68	3.64
8	5.32	4.46	4.07	3.84	3.69	3.58	3.50	3.44	3.39	3.35
9	5.12	4.26	3.86	3.63	3.48	3.37	3.29	3.23	3.18	3.14
10	4.96	4.10	3.71	3.48	3.33	3.22	3.14	3.07	3.02	2.98
11	4.84	3.98	3.59	3.36	3.20	3.09	3.01	2.95	2.90	2.85
12	4.75	3.89	3.49	3.26	3.11	3.00	2.91	2.85	2.80	2.75
13	4.67	3.81	3.41	3.18	3.03	2.92	2.83	2.77	2.71	2.67

14	4.60	3.74	3.34	3.11	2.96	2.85	2.76	2.70	2.65	2.60
15	4.54	3.68	3.29	3.06	2.90	2.79	2.71	2.64	2.59	2.54
16	4.49	3.63	3.24	3.01	2.85	2.74	2.66	2.59	2.54	2.49
17	4.45	3.59	3.20	2.96	2.81	2.70	2.61	2.55	2.49	2.45
18	4.41	3.55	3.16	2.93	2.77	2.66	2.58	2.51	2.46	2.41
19	4.38	3.52	3.13	2.90	2.74	2.63	2.54	2.48	2.42	2.38
20	4.35	3.49	3.10	2.87	2.71	2.60	2.51	2.45	2.39	2.35
22	4.30	3.44	3.05	2.82	2.66	2.55	2.46	2.40	2.34	2.30
24	4.26	3.40	3.01	2.78	2.62	2.51	2.42	2.36	2.30	2.25
26	4.23	3.37	2.98	2.74	2.59	2.47	2.39	2.32	2.27	2.22
28	4.20	3.34	2.95	2.71	2.56	2.45	2.36	2.29	2.24	2.19
30	4.17	3.32	2.92	2.69	2.53	2.42	2.33	2.27	2.21	2.16
35	4.12	3.27	2.87	2.64	2.49	2.37	2.29	2.22	2.16	2.11
40	4.08	3.23	2.84	2.61	2.45	2.34	2.25	2.18	2.12	2.08
45	4.06	3.20	2.81	2.58	2.42	2.31	2.22	2.15	2.10	2.05
50	4.03	3.18	2.79	2.56	2.40	2.29	2.20	2.13	2.07	2.03
60	4.00	3.15	2.76	2.53	2.37	2.25	2.17	2.10	2.04	1.99
70	3.98	3.13	2.74	2.50	2.35	2.23	2.14	2.07	2.02	1.97
80	3.96	3.11	2.72	2.49	2.33	2.21	2.13	2.06	2.00	1.95
100	3.94	3.09	2.70	2.46	2.31	2.19	2.10	2.03	1.97	1.93
200	3.89	3.04	2.65	2.42	2.26	2.14	2.06	1.98	1.93	1.88
500	3.86	3.01	2.62	2.39	2.23	2.12	2.03	1.96	1.90	1.85
1000	3.85	3.00	2.61	2.38	2.22	2.11	2.02	1.95	1.89	1.84
>1000	1.04	3.00	2.61	2.37	2.21	2.10	2.01	1.94	1.88	1.83
df2/df1	1	2	3	4	5	6	7	8	9	10