

## LAMPIRAN

Tabel Z

Z	0.00	0.01	0.02	0.03	0.04	0.05	0.06	0.07	0.08	0.09
-3.40	0.00034	0.00032	0.00031	0.00030	0.00029	0.00028	0.00027	0.00026	0.00025	0.00024
-3.30	0.00048	0.00047	0.00045	0.00043	0.00042	0.00040	0.00039	0.00038	0.00036	0.00035
-3.20	0.00069	0.00066	0.00064	0.00062	0.00060	0.00058	0.00056	0.00054	0.00052	0.00050
-3.10	0.00097	0.00094	0.00090	0.00087	0.00084	0.00082	0.00079	0.00076	0.00074	0.00071
-3.00	0.00135	0.00131	0.00126	0.00122	0.00118	0.00114	0.00111	0.00107	0.00104	0.00100
-2.90	0.00187	0.00181	0.00175	0.00169	0.00164	0.00159	0.00154	0.00149	0.00144	0.00139
-2.80	0.00256	0.00248	0.00240	0.00233	0.00226	0.00219	0.00212	0.00205	0.00199	0.00193
-2.70	0.00347	0.00336	0.00326	0.00317	0.00307	0.00298	0.00289	0.00280	0.00272	0.00264
-2.60	0.00466	0.00453	0.00440	0.00427	0.00415	0.00402	0.00391	0.00379	0.00368	0.00357
-2.50	0.00621	0.00604	0.00587	0.00570	0.00554	0.00539	0.00523	0.00508	0.00494	0.00480
-2.40	0.00820	0.00798	0.00776	0.00755	0.00734	0.00714	0.00695	0.00676	0.00657	0.00639
-2.30	0.01072	0.01044	0.01017	0.00990	0.00964	0.00939	0.00914	0.00889	0.00866	0.00842
-2.20	0.01390	0.01355	0.01321	0.01287	0.01255	0.01222	0.01191	0.01160	0.01130	0.01101
-2.10	0.01786	0.01743	0.01700	0.01659	0.01618	0.01578	0.01539	0.01500	0.01463	0.01426
-2.00	0.02275	0.02222	0.02169	0.02118	0.02068	0.02018	0.01970	0.01923	0.01876	0.01831
-1.90	0.02872	0.02807	0.02743	0.02680	0.02619	0.02559	0.02500	0.02442	0.02385	0.02330
-1.80	0.03593	0.03515	0.03438	0.03362	0.03288	0.03216	0.03144	0.03074	0.03005	0.02938
-1.70	0.04457	0.04363	0.04272	0.04182	0.04093	0.04006	0.03920	0.03836	0.03754	0.03673
-1.60	0.05480	0.05370	0.05262	0.05155	0.05050	0.04947	0.04846	0.04746	0.04648	0.04551
-1.50	0.06681	0.06552	0.06426	0.06301	0.06178	0.06057	0.05938	0.05821	0.05705	0.05592
-1.40	0.08076	0.07927	0.07780	0.07636	0.07493	0.07353	0.07215	0.07078	0.06944	0.06811
-1.30	0.09680	0.09510	0.09342	0.09176	0.09012	0.08851	0.08691	0.08534	0.08379	0.08226
-1.20	0.11507	0.11314	0.11123	0.10935	0.10749	0.10565	0.10383	0.10204	0.10027	0.09853
-1.10	0.13567	0.13350	0.13136	0.12924	0.12714	0.12507	0.12302	0.12100	0.11900	0.11702
-1.00	0.15866	0.15625	0.15386	0.15151	0.14917	0.14686	0.14457	0.14231	0.14007	0.13786
-0.90	0.18406	0.18141	0.17879	0.17619	0.17361	0.17106	0.16853	0.16602	0.16354	0.16109
-0.80	0.21186	0.20897	0.20611	0.20327	0.20045	0.19766	0.19489	0.19215	0.18943	0.18673
-0.70	0.24196	0.23885	0.23576	0.23270	0.22965	0.22663	0.22363	0.22065	0.21770	0.21476
-0.60	0.27425	0.27093	0.26763	0.26435	0.26109	0.25785	0.25463	0.25143	0.24825	0.24510
-0.50	0.30854	0.30503	0.30153	0.29806	0.29460	0.29116	0.28774	0.28434	0.28096	0.27760
-0.40	0.34458	0.34090	0.33724	0.33360	0.32997	0.32636	0.32276	0.31918	0.31561	0.31207
-0.30	0.38209	0.37828	0.37448	0.37070	0.36693	0.36317	0.35942	0.35569	0.35197	0.34827

-0.20	0.42074	0.41683	0.41294	0.40905	0.40517	0.40129	0.39743	0.39358	0.38974	0.38591
-0.10	0.46017	0.45620	0.45224	0.44828	0.44433	0.44038	0.43644	0.43251	0.42858	0.42465
0.00	0.50000	0.50399	0.50798	0.51197	0.51595	0.51994	0.52392	0.52790	0.53188	0.53586
0.10	0.53983	0.54380	0.54776	0.55172	0.55567	0.55962	0.56356	0.56749	0.57142	0.57535
0.20	0.57926	0.58317	0.58706	0.59095	0.59483	0.59871	0.60257	0.60642	0.61026	0.61409
0.30	0.61791	0.62172	0.62552	0.62930	0.63307	0.63683	0.64058	0.64431	0.64803	0.65173
0.40	0.65542	0.65910	0.66276	0.66640	0.67003	0.67364	0.67724	0.68082	0.68439	0.68793
0.50	0.69146	0.69497	0.69847	0.70194	0.70540	0.70884	0.71226	0.71566	0.71904	0.72240
0.60	0.72575	0.72907	0.73237	0.73565	0.73891	0.74215	0.74537	0.74857	0.75175	0.75490
0.70	0.75804	0.76115	0.76424	0.76730	0.77035	0.77337	0.77637	0.77935	0.78230	0.78524
0.80	0.78814	0.79103	0.79389	0.79673	0.79955	0.80234	0.80511	0.80785	0.81057	0.81327
0.90	0.81594	0.81859	0.82121	0.82381	0.82639	0.82894	0.83147	0.83398	0.83646	0.83891
1.00	0.84134	0.84375	0.84614	0.84849	0.85083	0.85314	0.85543	0.85769	0.85993	0.86214
1.10	0.86433	0.86650	0.86864	0.87076	0.87286	0.87493	0.87698	0.87900	0.88100	0.88298
1.20	0.88493	0.88686	0.88877	0.89065	0.89251	0.89435	0.89617	0.89796	0.89973	0.90147
1.30	0.90320	0.90490	0.90658	0.90824	0.90988	0.91149	0.91309	0.91466	0.91621	0.91774
1.40	0.91924	0.92073	0.92220	0.92364	0.92507	0.92647	0.92785	0.92922	0.93056	0.93189
1.50	0.93319	0.93448	0.93574	0.93699	0.93822	0.93943	0.94062	0.94179	0.94295	0.94408
1.60	0.94520	0.94630	0.94738	0.94845	0.94950	0.95053	0.95154	0.95254	0.95352	0.95449
1.70	0.95543	0.95637	0.95728	0.95818	0.95907	0.95994	0.96080	0.96164	0.96246	0.96327
1.80	0.96407	0.96485	0.96562	0.96638	0.96712	0.96784	0.96856	0.96926	0.96995	0.97062
1.90	0.97128	0.97193	0.97257	0.97320	0.97381	0.97441	0.97500	0.97558	0.97615	0.97670
2.00	0.97725	0.97778	0.97831	0.97882	0.97932	0.97982	0.98030	0.98077	0.98124	0.98169
2.10	0.98214	0.98257	0.98300	0.98341	0.98382	0.98422	0.98461	0.98500	0.98537	0.98574
2.20	0.98610	0.98645	0.98679	0.98713	0.98745	0.98778	0.98809	0.98840	0.98870	0.98899
2.30	0.98928	0.98956	0.98983	0.99010	0.99036	0.99061	0.99086	0.99111	0.99134	0.99158
2.40	0.99180	0.99202	0.99224	0.99245	0.99266	0.99286	0.99305	0.99324	0.99343	0.99361
2.50	0.99379	0.99396	0.99413	0.99430	0.99446	0.99461	0.99477	0.99492	0.99506	0.99520
2.60	0.99534	0.99547	0.99560	0.99573	0.99585	0.99598	0.99609	0.99621	0.99632	0.99643
2.70	0.99653	0.99664	0.99674	0.99683	0.99693	0.99702	0.99711	0.99720	0.99728	0.99736
2.80	0.99744	0.99752	0.99760	0.99767	0.99774	0.99781	0.99788	0.99795	0.99801	0.99807
2.90	0.99813	0.99819	0.99825	0.99831	0.99836	0.99841	0.99846	0.99851	0.99856	0.99861
3.00	0.99865	0.99869	0.99874	0.99878	0.99882	0.99886	0.99889	0.99893	0.99896	0.99900
3.10	0.99903	0.99906	0.99910	0.99913	0.99916	0.99918	0.99921	0.99924	0.99926	0.99929
3.20	0.99931	0.99934	0.99936	0.99938	0.99940	0.99942	0.99944	0.99946	0.99948	0.99950

Tabel t

t-table d.f.	Area in One Tail				
	0.005	0.01	0.025	0.05	0.10
1	63.657	31.821	12.706	6.314	3.078
2	9.925	6.965	4.303	2.92	1.886
3	5.841	4.541	3.182	2.353	1.638
4	4.604	3.747	2.776	2.132	1.533
5	4.032	3.365	2.571	2.015	1.476
6	3.707	3.143	2.447	1.943	1.44
7	3.499	2.998	2.365	1.895	1.415
8	3.355	2.896	2.306	1.86	1.397
9	3.25	2.821	2.262	1.833	1.383
10	3.169	2.764	2.228	1.812	1.372
11	3.106	2.718	2.201	1.796	1.363
12	3.055	2.681	2.179	1.782	1.356
13	3.012	2.65	2.16	1.771	1.35
14	2.977	2.624	2.145	1.761	1.345
15	2.947	2.602	2.131	1.753	1.341
16	2.921	2.583	2.12	1.746	1.337
17	2.898	2.567	2.11	1.74	1.333
18	2.878	2.552	2.101	1.734	1.33
19	2.861	2.539	2.093	1.729	1.328
20	2.845	2.528	2.086	1.725	1.325
21	2.831	2.518	2.08	1.721	1.323
22	2.819	2.508	2.074	1.717	1.321
23	2.807	2.5	2.069	1.714	1.319
24	2.797	2.492	2.064	1.711	1.318
25	2.787	2.485	2.06	1.708	1.316
26	2.779	2.479	2.056	1.706	1.315
27	2.771	2.473	2.052	1.703	1.314
28	2.763	2.467	2.048	1.701	1.313
29	2.756	2.462	2.045	1.699	1.311
30	2.75	2.457	2.042	1.697	1.31
31	2.744	2.453	2.04	1.696	1.309
32	2.738	2.449	2.037	1.694	1.309
34	2.728	2.441	2.032	1.691	1.307
36	2.719	2.434	2.028	1.688	1.306
38	2.712	2.429	2.024	1.686	1.304
40	2.704	2.423	2.021	1.684	1.303
45	2.69	2.412	2.014	1.679	1.301
50	2.678	2.403	2.009	1.676	1.299
55	2.668	2.396	2.004	1.673	1.297
60	2.66	2.39	2	1.671	1.296
65	2.654	2.385	1.997	1.669	1.295
70	2.648	2.381	1.994	1.667	1.294
75	2.643	2.377	1.992	1.665	1.293
80	2.639	2.374	1.99	1.664	1.292
90	2.632	2.368	1.987	1.662	1.291
100	2.626	2.364	1.984	1.66	1.29
200	2.601	2.345	1.972	1.653	1.286
300	2.592	2.339	1.968	1.65	1.284
400	2.588	2.336	1.966	1.649	1.284
500	2.586	2.334	1.965	1.648	1.283
750	2.582	2.331	1.963	1.647	1.283
1000	2.581	2.33	1.962	1.646	1.282
2000	2.578	2.328	1.961	1.646	1.282
(Z) ∞	2.576	2.326	1.96	1.645	1.282
C. Level	99%	98%	95%	90%	80%

Menghitung Batas Kendali Atas (UCL) Dan Batas Kendali Bawah (LCL)\

1. Batas kendali atas (UCL)

Diketahui  $\bar{p} = 0,055263$

$z = 3$

$n =$  pada tanggal 5 april = 420

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{420}}\right)$$

$$UCL_p = 0,088711$$

$n =$  pada tanggal 12 april = 600

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{600}}\right)$$

$$UCL_p = 0,083248$$

$n =$  pada tanggal 19 april = 660

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{660}}\right)$$

$$UCL_p = 0,081945$$

$n =$  pada tanggal 26 april = 335

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{335}}\right)$$

$$UCL_p = 0,091645$$

$n =$  pada tanggal 3 mei = 905

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{905}}\right)$$

$$UCL_p = 0,078049$$

$n =$  pada tanggal 10 mei = 545

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{545}}\right)$$

$$UCL_p = 0,084626$$

$n =$  pada tanggal 17 mei = 550

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{550}}\right)$$

$$UCL_p = 0,084492$$

$n =$  pada tanggal 24 mei = 300

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{300}}\right)$$

$$UCL_p = 0,094839$$

$n =$  pada tanggal 31 mei = 640

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{640}}\right)$$

$$UCL_p = 0,082359$$

$n$  = pada tanggal 7 juni = 370

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{370}}\right)$$

$$UCL_p = 0,090899$$

$n$  = pada tanggal 14 juni = 430

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{430}}\right)$$

$$UCL_p = 0,088320$$

$n$  = pada tanggal 21 juni = 980

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{980}}\right)$$

$$UCL_p = 0,07716$$

$n$  = pada tanggal 28 juni = 845

$$UCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$UCL_p = 0,055263 + 3 \left( \sqrt{\frac{0,055263(1-0,055263)}{845}} \right)$$

$$UCL_p = 0,07884$$

## 2 Batas kendali bawah (LCL)

Diketahui  $\bar{p} = 0,055263$

$$z = 3$$

$n =$  pada tanggal 5 april = 420

$$LCL_p = \bar{p} + 3 \left( \sqrt{\frac{\bar{p}(1-\bar{p})}{n}} \right)$$

$$LCL_p = 0,055263 + 3 \left( \sqrt{\frac{0,055263(1-0,055263)}{420}} \right)$$

$$LCL_p = 0,021815$$

$n =$  pada tanggal 12 april = 600

$$LCL_p = \bar{p} + 3 \left( \sqrt{\frac{\bar{p}(1-\bar{p})}{n}} \right)$$

$$LCL_p = 0,055263 + 3 \left( \sqrt{\frac{0,055263(1-0,055263)}{600}} \right)$$

$$LCL_p = 0,027279$$

$n =$  pada tanggal 19 april = 660

$$LCL_p = \bar{p} + 3 \left( \sqrt{\frac{\bar{p}(1-\bar{p})}{n}} \right)$$

$$LCL_p = 0,055263 + 3 \left( \sqrt{\frac{0,055263(1-0,055263)}{660}} \right)$$

$$LCL_p = 0,028581$$

$n =$  pada tanggal 26 april = 335

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{335}}\right)$$

$$LCL_p = 0,018882$$

$n$  = pada tanggal 3 mei = 905

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{905}}\right)$$

$$LCL_p = 0,032477$$

$n$  = pada tanggal 10 mei = 545

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{545}}\right)$$

$$LCL_p = 0,0259$$

$n$  = pada tanggal 17 mei = 550

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{550}}\right)$$

$$LCL_p = 0,026034$$

$n$  = pada tanggal 24 mei = 300



$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{300}}\right)$$

$$LCL_p = 0,015687$$

$n$  = pada tanggal 31 mei = 640

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{640}}\right)$$

$$LCL_p = 0,028167$$

$n$  = pada tanggal 7 juni = 370

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{370}}\right)$$

$$LCL_p = 0,019627$$

$n$  = pada tanggal 14 juni = 430

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3\left(\sqrt{\frac{0,055263(1-0,055263)}{430}}\right)$$

$$LCL_p = 0,022206$$

$n$  = pada tanggal 21 juni = 980

$$LCL_p = \bar{p} + 3\left(\sqrt{\frac{\bar{p}(1-\bar{p})}{n}}\right)$$

$$LCL_p = 0,055263 + 3 \left( \sqrt{\frac{0,055263(1-0,055263)}{980}} \right)$$

$$LCL_p = 0,033366$$

$n$  = pada tanggal 28 juni = 845

$$LCL_p = \bar{p} + 3 \left( \sqrt{\frac{\bar{p}(1-\bar{p})}{n}} \right)$$

$$LCL_p = 0,055263 + 3 \left( \sqrt{\frac{0,055263(1-0,055263)}{845}} \right)$$

$$LCL_p = 0,031682$$

**GAMBAR JENIS - JENIS CACAT :**  
**Cacat Warna**



**Cacat Mblor**



**Cacat Kotor**



GAMBAR PRODUK JADI :



GAMBAR PROSES PRODUKSI :

**Proses Pemotongan**



**Proses Pengecapan**





**Proses Pewarnaan**





**Proses Pembersihan malam danPencucian**



### Proses Penutupan motif



### Proses Pengeringan



### GAMBAR ALAT CAP :

