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 **LAMPIRAN**

**Lampiran 1 Data Produksi dan Reject Kain Elastis**

| BULAN | Minggu ke - | jumlah produksi (meter) | Jenis Defect | Total Defect |
| --- | --- | --- | --- | --- |
| stop mark | lubang | minyak | sambungan | kotor |
| Januari | 1 | 118.005 | 3.786 | 2.188 | 2.089 | 1.243 | 2.059 | 11.365 |
|  | 2 | 114.351 | 3.903 | 2.015 | 2.120 | 1.134 | 1.964 | 11.136 |
|  | 3 | 107.538 | 3.213 | 2.068 | 2.099 | 1.194 | 1.913 | 10.487 |
|  | 4 | 109.688 | 3.452 | 2.056 | 2.069 | 1.135 | 1.875 | 10.587 |
| Februari | 1 | 113.012 | 3.716 | 2.216 | 2.117 | 1.215 | 2.024 | 11.288 |
|  | 2 | 114.069 | 3.833 | 2.043 | 2.148 | 1.106 | 1.929 | 11.059 |
|  | 3 | 103.908 | 3.143 | 2.096 | 2.127 | 1.166 | 1.878 | 10.410 |
|  | 4 | 106.790 | 3.382 | 2.084 | 2.097 | 1.107 | 1.840 | 10.510 |
| Maret | 1 | 114.865 | 3.702 | 2.237 | 2.145 | 1.250 | 2.052 | 11.386 |
|  | 2 | 115.449 | 3.819 | 2.064 | 2.176 | 1.141 | 1.957 | 11.157 |
|  | 3 | 108.896 | 3.129 | 2.117 | 2.155 | 1.201 | 1.906 | 10.508 |
|  | 4 | 106.245 | 3.368 | 2.105 | 2.125 | 1.142 | 1.868 | 10.608 |
| April | 1 | 117.457 | 3.723 | 2.258 | 2.166 | 1.271 | 2.073 | 11.491 |
|  | 2 | 115.496 | 3.840 | 2.085 | 2.197 | 1.162 | 1.978 | 11.262 |
|  | 3 | 107.496 | 3.150 | 2.138 | 2.176 | 1.222 | 1.927 | 10.613 |
|  | 4 | 107.435 | 3.389 | 2.126 | 2.146 | 1.163 | 1.889 | 10.713 |
| Mei | 1 | 118.676 | 3.737 | 2.244 | 2.152 | 1.299 | 2.052 | 11.484 |
|  | 2 | 113.492 | 3.854 | 2.071 | 2.183 | 1.190 | 1.957 | 11.255 |
|  | 3 | 105.776 | 3.164 | 2.124 | 2.162 | 1.250 | 1.906 | 10.606 |
|  | 4 | 109.877 | 3.403 | 2.112 | 2.132 | 1.191 | 1.868 | 10.706 |
| Juni | 1 | 116.945 | 3.709 | 2.216 | 2.124 | 1.327 | 2.038 | 11.414 |
|  | 2 | 115.821 | 3.826 | 2.043 | 2.155 | 1.218 | 1.943 | 11.185 |
|  | 3 | 108.675 | 3.136 | 2.096 | 2.134 | 1.278 | 1.892 | 10.536 |
|  | 4 | 109.493 | 3.375 | 2.084 | 2.104 | 1.219 | 1.854 | 10.636 |
| Jumlah | 2.679.455 | 84.752 | 50.886 | 51.298 | 28.824 | 46.642 | 262.402 |
| Rata - Rata | 111.644 | 3.531 | 2.120 | 2.137 | 1.201 | 1.943 | 10.933 |

(Sumber: PT. Fujian Honggang Textile Technology Co. Ltd)

**Lampiran 2 Laporan Produksi Kain Elastis Bulan Januari - Juni 2024**

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| BULAN | Minggu ke - | jumlah produksi (meter) | Jenis Defect | Total Defect | Prosentase % |
| stop mark | lubang | minyak | sambungan | kotor |
| Januari | 1 | 118.005 | 3.786 | 2.188 | 2.089 | 1.243 | 2.059 | 11.365 | 9,63 |
|  | 2 | 114.351 | 3.903 | 2.015 | 2.120 | 1.134 | 1.964 | 11.136 | 9,74 |
|  | 3 | 107.538 | 3.213 | 2.068 | 2.099 | 1.194 | 1.913 | 10.487 | 9,75 |
|  | 4 | 109.688 | 3.452 | 2.056 | 2.069 | 1.135 | 1.875 | 10.587 | 9,65 |
| Februari | 1 | 113.012 | 3.716 | 2.216 | 2.117 | 1.215 | 2.024 | 11.288 | 9,99 |
|  | 2 | 114.069 | 3.833 | 2.043 | 2.148 | 1.106 | 1.929 | 11.059 | 9,70 |
|  | 3 | 103.908 | 3.143 | 2.096 | 2.127 | 1.166 | 1.878 | 10.410 | 10,22 |
|  | 4 | 106.790 | 3.382 | 2.084 | 2.097 | 1.107 | 1.840 | 10.510 | 9,84 |
| Maret | 1 | 114.865 | 3.702 | 2.237 | 2.145 | 1.250 | 2.052 | 11.386 | 9,91 |
|  | 2 | 115.449 | 3.819 | 2.064 | 2.176 | 1.141 | 1.957 | 11.157 | 9,66 |
|  | 3 | 108.896 | 3.129 | 2.117 | 2.155 | 1.201 | 1.906 | 10.508 | 9,65 |
|  | 4 | 106.245 | 3.368 | 2.105 | 2.125 | 1.142 | 1.868 | 10.608 | 9,98 |
| April | 1 | 117.457 | 3.723 | 2.258 | 2.166 | 1.271 | 2.073 | 11.491 | 9,78 |
|  | 2 | 115.496 | 3.840 | 2.085 | 2.197 | 1.162 | 1.978 | 11.262 | 9,75 |
|  | 3 | 107.496 | 3.150 | 2.138 | 2.176 | 1.222 | 1.927 | 10.613 | 9,87 |
|  | 4 | 107.435 | 3.389 | 2.126 | 2.146 | 1.163 | 1.889 | 10.713 | 9,97 |
| Mei | 1 | 118.676 | 3.737 | 2.244 | 2.152 | 1.299 | 2.052 | 11.484 | 9,68 |
|  | 2 | 113.492 | 3.854 | 2.071 | 2.183 | 1.190 | 1.957 | 11.255 | 9,92 |
|  | 3 | 105.776 | 3.164 | 2.124 | 2.162 | 1.250 | 1.906 | 10.606 | 10,03 |
|  | 4 | 109.877 | 3.403 | 2.112 | 2.132 | 1.191 | 1.868 | 10.706 | 9,74 |
| Juni | 1 | 116.945 | 3.709 | 2.216 | 2.124 | 1.327 | 2.038 | 11.414 | 9,76 |
|  | 2 | 115.821 | 3.826 | 2.043 | 2.155 | 1.218 | 1.943 | 11.185 | 9,66 |
|  | 3 | 108.675 | 3.136 | 2.096 | 2.134 | 1.278 | 1.892 | 10.536 | 9,69 |
|  | 4 | 109.493 | 3.375 | 2.084 | 2.104 | 1.219 | 1.854 | 10.636 | 9,71 |
| Jumlah | 2.679.455 | 84.752 | 50.886 | 51.298 | 28.824 | 46.642 | 262.402 | 9,81 |
| Rata - Rata | 111.644 | 3.531 | 2.120 | 2.137 | 1.201 | 1.943 | 10.933 | 9,80 |

(Sumber: PT. Fujian Honggang Textile Technology Co. Ltd)

**Lampiran 3 Perhitungan Tahap Kendali Bulan Januari - Juni 2024**

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| Bulan | Minggu ke - | jumlah produksi (meter) | Total Defect | Proporsi reject (%) | CL | UCL | LCL |
|
| Januari | 1 | 118.005 | 11.365 | 0,096 | 0,098 | 0,101 | 0,095 |
|  | 2 | 114.351 | 11.136 | 0,097 | 0,098 | 0,101 | 0,095 |
|  | 3 | 107.538 | 10.487 | 0,098 | 0,098 | 0,101 | 0,095 |
|  | 4 | 109.688 | 10.587 | 0,097 | 0,098 | 0,101 | 0,095 |
| Februari | 1 | 113.012 | 11.288 | 0,100 | 0,098 | 0,101 | 0,095 |
|  | 2 | 114.069 | 11.059 | 0,097 | 0,098 | 0,101 | 0,095 |
|  | 3 | 103.908 | 10.410 | 0,102 | 0,098 | 0,101 | 0,095 |
|  | 4 | 106.790 | 10.510 | 0,098 | 0,098 | 0,101 | 0,095 |
| Maret | 1 | 114.865 | 11.386 | 0,099 | 0,098 | 0,101 | 0,095 |
|  | 2 | 115.449 | 11.157 | 0,097 | 0,098 | 0,101 | 0,095 |
|  | 3 | 108.896 | 10.508 | 0,096 | 0,098 | 0,101 | 0,095 |
|  | 4 | 106.245 | 10.608 | 0,100 | 0,098 | 0,101 | 0,095 |
| April | 1 | 117.457 | 11.491 | 0,098 | 0,098 | 0,101 | 0,095 |
|  | 2 | 115.496 | 11.262 | 0,098 | 0,098 | 0,101 | 0,095 |
|  | 3 | 107.496 | 10.613 | 0,099 | 0,098 | 0,101 | 0,095 |
|  | 4 | 107.435 | 10.713 | 0,100 | 0,098 | 0,101 | 0,095 |
| Mei | 1 | 118.676 | 11.484 | 0,097 | 0,098 | 0,101 | 0,095 |
|  | 2 | 113.492 | 11.255 | 0,099 | 0,098 | 0,101 | 0,095 |
|  | 3 | 105.776 | 10.606 | 0,100 | 0,098 | 0,101 | 0,095 |
|  | 4 | 109.877 | 10.706 | 0,097 | 0,098 | 0,101 | 0,095 |
| Juni | 1 | 116.945 | 11.414 | 0,098 | 0,098 | 0,101 | 0,095 |
|  | 2 | 115.821 | 11.185 | 0,097 | 0,098 | 0,101 | 0,095 |
|  | 3 | 108.675 | 10.536 | 0,097 | 0,098 | 0,101 | 0,095 |
|  | 4 | 109.493 | 10.636 | 0,097 | 0,098 | 0,101 | 0,095 |

(Sumber: pengolahan data exel oleh penulis)

**Lampiran 4 Pengukuran Tingkat Sigma dan DPMO Bulan Januari - Juni 2024**

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| Bulan | Minggu ke - | jumlah produksi (meter) | produk cacat | banyaknya CTQ | DPU | DPMO | Nilai Sigma |
|
| Januari | 1 | 118.005 | 11.365 | 5 | 0,096 | 19.262 | 3,57 |
|  | 2 | 114.351 | 11.136 | 5 | 0,097 | 19.477 | 3,56 |
|  | 3 | 107.538 | 10.487 | 5 | 0,098 | 19.504 | 3,56 |
|  | 4 | 109.688 | 10.587 | 5 | 0,097 | 19.304 | 3,57 |
| Februari | 1 | 113.012 | 11.288 | 5 | 0,100 | 19.977 | 3,55 |
|  | 2 | 114.069 | 11.059 | 5 | 0,097 | 19.390 | 3,57 |
|  | 3 | 103.908 | 10.410 | 5 | 0,102 | 20.430 | 3,54 |
|  | 4 | 106.790 | 10.510 | 5 | 0,098 | 19.683 | 3,56 |
| Maret | 1 | 114.865 | 11.386 | 5 | 0,099 | 19.825 | 3,56 |
|  | 2 | 115.449 | 11.157 | 5 | 0,097 | 19.328 | 3,57 |
|  | 3 | 108.896 | 10.508 | 5 | 0,096 | 19.299 | 3,57 |
|  | 4 | 106.245 | 10.608 | 5 | 0,100 | 19.969 | 3,55 |
| April | 1 | 117.457 | 11.491 | 5 | 0,098 | 19.566 | 3,56 |
|  | 2 | 115.496 | 11.262 | 5 | 0,098 | 19.502 | 3,56 |
|  | 3 | 107.496 | 10.613 | 5 | 0,099 | 19.746 | 3,56 |
|  | 4 | 107.435 | 10.713 | 5 | 0,100 | 19.943 | 3,55 |
| Mei | 1 | 118.676 | 11.484 | 5 | 0,097 | 19.354 | 3,57 |
|  | 2 | 113.492 | 11.255 | 5 | 0,099 | 19.834 | 3,56 |
|  | 3 | 105.776 | 10.606 | 5 | 0,100 | 20.054 | 3,55 |
|  | 4 | 109.877 | 10.706 | 5 | 0,097 | 19.487 | 3,56 |
| Juni | 1 | 116.945 | 11.414 | 5 | 0,098 | 19.520 | 3,56 |
|  | 2 | 115.821 | 11.185 | 5 | 0,097 | 19.314 | 3,57 |
|  | 3 | 108.675 | 10.536 | 5 | 0,097 | 19.390 | 3,57 |
|  | 4 | 109.493 | 10.636 | 5 | 0,097 | 19.428 | 3,57 |
| jumlah | 2.679.455 | 262.402 |  |  |  |  |
| rata - rata | 111.644 | 3.531 |  | 0,098 | 19.608 | 3,56 |

(Sumber: PT. Fujian Honggang Textile Technology Co. Ltd)

**Lampiran 5 Karakteristik Produk Reject**

|  |  |  |  |
| --- | --- | --- | --- |
| jenis reject | jumlah reject | presentase reject (%) | presentase reject kumulatif (%) |
| stop mark | 84.752 | 32% | 32% |
| lubang | 50.886 | 19% | 52% |
| minyak | 51.298 | 20% | 71% |
| sambungan | 28.824 | 11% | 82% |
| kotor | 46.642 | 18% | 100% |
| jumlah | 262.402 | 100% |  |

(sumber: pengelolaan data exel penulis)