

Universitas
Esa Unggul

LAMPIRAN

Universitas
Esa Unggul

Lampiran 1. Foto Produk Energen Champion Twinpack

Foto produk Energen Champion Twinpack



Lampiran 1. Foto produk Energen Champion Twinpack

Lampiran 2. Check Sheet Rekap Reject Kemasan

Check sheet yang digunakan untuk merekap reject kemasan

| | | PT. TORABIKA EKA SEMESTA DIVISI HEALTHY FOOD BALARAJA PLANT Data Waste Cello dan Sgmsan | | | | | | | | | | | | | | | | | |
|----------------------|------------------|---|------|------|----------------------|---------------------------|-------------|-------------|----------------|------|-------|------|----------------|-------|------|------|------|------|--|
| Tanggal : 08.08.2019 | | | | | | | | | | | | | | | | | | | |
| No | Coba | Reject Main | | | Sisa mesin (kg/berg) | BP Complet SIP (kg sakti) | Change Over | Total Waste | Waste Material | | | | Waste Operator | | | | | | |
| | | Roll | Roll | Roll | | | | | Roll | Roll | Roll | Roll | Roll | Roll | Roll | Roll | Roll | Roll | |
| | En Chocolate lok | 0.31 | 0.03 | 0.01 | | | | 0.35 | | | | | | | | | | | |
| | En Vanilla lok | 0.17 | 0.01 | 0.00 | | | | 0.18 | | | | | | | | | | | |
| | En k Hlsau lok | 0.83 | 0.02 | 0.01 | | | | 0.86 | | | | | | | | | | | |
| | En Jambu lok | 0.05 | 0.01 | 0.00 | | | | 0.06 | | | | | | | | | | | |
| | En chocolate Exp | 0.19 | 0.00 | 0.40 | | | | 0.59 | | | 8.63 | | | | | | | | |
| | En Vanilla Exp | 0.40 | 0.11 | 0.01 | | | | 0.52 | | | 12.37 | | | | | | | | |
| | En kumpa lok | - | - | - | | | | - | | | - | | | | | | | | |
| | Bembesan | 0.03 | 0.08 | 0.07 | | | | 0.18 | | | 3.94 | | | | | | | | |
| | DBB | 0.00 | - | - | | | | 0.00 | | | 0.26 | | | | | | | | |
| | En champ sp | 0.16 | 0.00 | 0.03 | | | | 0.22 | | | 5.29 | | | | | | | | |
| | En champ Exp | 0.15 | 0.05 | 0.09 | | | | 0.29 | | | 1.97 | | | | | | | | |
| | En champ lok Mba | 0.15 | 0.06 | 0.29 | | | | 0.50 | | | 3.84 | | | | | | | | |
| | En champ lok | 0.02 | 0.01 | 0.01 | | | | 0.04 | | | 0.46 | | | | | | | | |
| | | | | | | | | | | | 83.43 | | | 14.00 | | | | | |
| Dibuat oleh | | Unit Head | | | | | | | | | | | | | | | | | |
| [Signature] | | [Signature] | | | | | | | | | | | | | | | | | |

Lampiran 2. Check sheet rekap reject kemasan

Lampiran 3. Check Sheet Data Hasil Produksi

Check sheet Data Hasil Produksi

PT. TORABIKA EKA SEMESTA

| No | | ITEM PRODUK | Plan | | Act | | Spd | Efisiensi | | | Berkas |
|-------|--|-------------|-------|-------|-------|-------|-----|----------------|-------------|---|--------|
| | | | Mt | JK | Mt | JK | | Hasil Produksi | | % | |
| | | | (UMH) | (JAM) | (UMH) | (JAM) | | Teori (Ct) | Aktual (Ct) | | |
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| Total | | | | | | | | | | | |

Group : _____

| No | | ITEM PRODUK | Plan | | Act | | Spd | Efisiensi | | | Berkas |
|-------|--|-------------|-------|-------|-------|-------|-----|----------------|-------------|---|--------|
| | | | Mt | JK | Mt | JK | | Hasil Produksi | | % | |
| | | | (UMH) | (JAM) | (UMH) | (JAM) | | Teori (Ct) | Aktual (Ct) | | |
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| Total | | | | | | | | | | | |

Group : _____

| No | | ITEM PRODUK | Plan | | Act | | Spd | Efisiensi | | | Berkas |
|-------|--|-------------|-------|-------|-------|-------|-----|----------------|-------------|---|--------|
| | | | Mt | JK | Mt | JK | | Hasil Produksi | | % | |
| | | | (UMH) | (JAM) | (UMH) | (JAM) | | Teori (Ct) | Aktual (Ct) | | |
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Diklat sisk.
Mngkrakul

Lampiran 3. Check sheet Data Hasil Produksi

Lampiran 4. *Check Sheet* Pengecekan Kualitas Produk

Check sheet Pengecekan Kualitas Produk

PT. TORABIKA EKA SEMESTA
DIVISI HEALTH FOOD BALARAJA PLANT
Pengecekan Produk Mesin Low Speed

Tanggal Pengukuran: 05-08-2023
No. Urut: 106
Nama Produk: EN. CEMENDIUM BAKAR BAKEL

| No. Mesin | Mesin Per Batching | Pemeriksaan Berat Mekanis | | | | AVG | Simpul | Pemeriksaan Berat Baku | | | | WBJ | Waktu | Kelembaban | Kelembaban (g) | Kelembaban (%) | Kelembaban (g) | Kelembaban (%) | Kondisi Kemasan | | |
|---------------|--------------------|---------------------------|-------|-------|-------|-------|--------|------------------------|---|---|---|-----|-------|------------|----------------|----------------|----------------|----------------|-----------------|--|--|
| | | 1 | 2 | 3 | 4 | | | 1 | 2 | 3 | 4 | | | | | | | | Pengisian I | Pengisian II | |
| 001 | 178-70 | 28.40 | 28.41 | 28.42 | 28.43 | 28.41 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0001 | |
| 002 | 178-71 | 28.39 | 28.40 | 28.41 | 28.42 | 28.40 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0002 | |
| 003 | 178-72 | 28.38 | 28.39 | 28.40 | 28.41 | 28.39 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0003 | |
| 004 | 178-73 | 28.37 | 28.38 | 28.39 | 28.40 | 28.38 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0004 | |
| 005 | 178-74 | 28.36 | 28.37 | 28.38 | 28.39 | 28.37 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0005 | |
| 006 | 178-75 | 28.35 | 28.36 | 28.37 | 28.38 | 28.36 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0006 | |
| 007 | 178-76 | 28.34 | 28.35 | 28.36 | 28.37 | 28.35 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0007 | |
| 008 | 178-77 | 28.33 | 28.34 | 28.35 | 28.36 | 28.34 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0008 | |
| 009 | 178-78 | 28.32 | 28.33 | 28.34 | 28.35 | 28.33 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0009 | |
| 010 | 178-79 | 28.31 | 28.32 | 28.33 | 28.34 | 28.32 | | 1 | 2 | 3 | 4 | | | | | | | | | PROD: 05 AUG 2023 EXP: 05 AUG 2024 STAFPAK 000003 0010 | |
| Rata-rata | | | | | | 28.38 | | | | | | | | | | | | | | | |
| AVG Per shift | | | | | | 28.38 | | | | | | | | | | | | | | | |

| No. Mesin | Mesin Per Batching | Pemeriksaan Berat Produk | | | | AVG | Simpul | WBJ | Waktu | Kelembaban | Kelembaban (g) | Kelembaban (%) | Kelembaban (g) | Kelembaban (%) | Kelembaban (g) | Kelembaban (%) | Kelembaban (g) | Kelembaban (%) | Kelembaban (g) | Kelembaban (%) | Kelembaban (g) | Kelembaban (%) |
|---------------|--------------------|--------------------------|-------|-------|-------|-------|--------|-----|-------|------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|
| | | 1 | 2 | 3 | 4 | | | | | | | | | | | | | | | | | |
| 001 | 178-70 | 28.40 | 28.41 | 28.42 | 28.43 | 28.41 | | | | | | | | | | | | | | | | |
| 002 | 178-71 | 28.39 | 28.40 | 28.41 | 28.42 | 28.40 | | | | | | | | | | | | | | | | |
| 003 | 178-72 | 28.38 | 28.39 | 28.40 | 28.41 | 28.39 | | | | | | | | | | | | | | | | |
| 004 | 178-73 | 28.37 | 28.38 | 28.39 | 28.40 | 28.38 | | | | | | | | | | | | | | | | |
| 005 | 178-74 | 28.36 | 28.37 | 28.38 | 28.39 | 28.37 | | | | | | | | | | | | | | | | |
| 006 | 178-75 | 28.35 | 28.36 | 28.37 | 28.38 | 28.36 | | | | | | | | | | | | | | | | |
| 007 | 178-76 | 28.34 | 28.35 | 28.36 | 28.37 | 28.35 | | | | | | | | | | | | | | | | |
| 008 | 178-77 | 28.33 | 28.34 | 28.35 | 28.36 | 28.34 | | | | | | | | | | | | | | | | |
| 009 | 178-78 | 28.32 | 28.33 | 28.34 | 28.35 | 28.33 | | | | | | | | | | | | | | | | |
| 010 | 178-79 | 28.31 | 28.32 | 28.33 | 28.34 | 28.32 | | | | | | | | | | | | | | | | |
| Rata-rata | | | | | | 28.38 | | | | | | | | | | | | | | | | |
| AVG Per shift | | | | | | 28.38 | | | | | | | | | | | | | | | | |

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| <p>1. Produk ini adalah produk makanan yang siap saji</p> <p>2. Produk ini harus disimpan dalam kemasan yang tertutup rapat</p> <p>3. Produk ini harus disimpan dalam suhu ruang</p> <p>4. Produk ini harus disimpan dalam suhu dingin</p> <p>5. Produk ini harus disimpan dalam suhu beku</p> <p>6. Produk ini harus disimpan dalam suhu kamar</p> <p>7. Produk ini harus disimpan dalam suhu lembab</p> <p>8. Produk ini harus disimpan dalam suhu kering</p> <p>9. Produk ini harus disimpan dalam suhu lembab dan kering</p> <p>10. Produk ini harus disimpan dalam suhu lembab dan kering</p> | <p>1. Produk ini adalah produk makanan yang siap saji</p> <p>2. Produk ini harus disimpan dalam kemasan yang tertutup rapat</p> <p>3. Produk ini harus disimpan dalam suhu ruang</p> <p>4. Produk ini harus disimpan dalam suhu dingin</p> <p>5. Produk ini harus disimpan dalam suhu beku</p> <p>6. Produk ini harus disimpan dalam suhu kamar</p> <p>7. Produk ini harus disimpan dalam suhu lembab</p> <p>8. Produk ini harus disimpan dalam suhu kering</p> <p>9. Produk ini harus disimpan dalam suhu lembab dan kering</p> <p>10. Produk ini harus disimpan dalam suhu lembab dan kering</p> |
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Lampiran 4. *Check sheet* Pengecekan Kualitas Produk

Lampiran 5. *Check Sheet* Pengecekan Kebocoran Kemasan

Check sheet Pengecekan Kebocoran Kemasan

FBS/C/C/01/04/01/15

| PT. TORABIKA EKA SEMESTA DIVISI HEALTH FOOD BALARAJA PLANT Pengecekan Kebocoran Kemasan Produk Mesin Low Speed | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|--------------|---------------|--------------|----|---|---|-------------|---|---|---|--------------|---|---|---|----------|------------------|---------------|----|---|---|-------------|---|---|---|--------------|---|---|---|----------|------------------|----------------|----|---|---|-------------|---|----|-------|--------------|-------|---|---|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|
| Tanggal: <u>04.11.2022</u> Shift / Group: <u>01 / 0200000</u> Nama Produk: <u>01 / 0200000 / 01 / 0200000</u> | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| No. | Jenis Produk | Jenis Kemasan | Pengecekan I | | | | | | | | | | | | Kategori | Jenis Pengecekan | Pengecekan II | | | | | | | | | | | | Kategori | Jenis Pengecekan | Pengecekan III | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | Faktor awal | | | | Faktor saat | | | | Faktor akhir | | | | | | Faktor awal | | | | Faktor saat | | | | Faktor akhir | | | | | | Faktor awal | | | | Faktor saat | | | | Faktor akhir | | | | | | | | | | | | | | | | | | |
| | | | A | Ta | M | S | V | W | S | L | R | R | R | R | | | A | Ta | M | S | V | W | S | L | R | R | R | R | | | A | Ta | M | S | V | W | S | L | R | R | R | R | | | | | | | | | | | | | | | |
| 1 | 001 | 01-20 | ✓ | | | | | | | | | | | | Dt | 01-22 | ✓ | | | | | | | | | | | | | | | | | | | | Dt | 01-22 | ✓ | | | | | | | | | | | | | | | | | | |
| 2 | 002 | 01-22 | ✓ | | | | | | | | | | | | Dt | 01-22 | ✓ | | | | | | | | | | | | | | | | | | | | | Dt | 01-22 | ✓ | | | | | | | | | | | | | | | | | |
| 3 | 003 | 01-23 | ✓ | | | | | | | | | | | | Dt | 01-23 | ✓ | | | | | | | | | | | | | | | | | | | | | Dt | 01-23 | ✓ | | | | | | | | | | | | | | | | | |
| 4 | 004 | 01-18 | ✓ | | | | | | | | | | | | Dt | 01-18 | ✓ | | | | | | | | | | | | | | | | | | | | | Dt | 01-18 | ✓ | | | | | | | | | | | | | | | | | |
| 5 | 005 | 01-19 | ✓ | | | | | | | | | | | | Dt | 01-19 | ✓ | | | | | | | | | | | | | | | | | | | | | | Dt | 01-19 | ✓ | | | | | | | | | | | | | | | | |
| 6 | 006 | 01-15 | ✓ | | | | | | | | | | | | Dt | 01-15 | ✓ | | | | | | | | | | | | | | | | | | | | | | Dt | 01-15 | ✓ | | | | | | | | | | | | | | | | |
| Total month % Kebocoran = 0% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Total month % Kebocoran = 0% | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Keterangan:

 * Pengecekan dilakukan secara otomatis 1 kali per shift

 * Pengecekan dilakukan secara manual 1 kali per shift

 * Pengecekan dilakukan secara manual 1 kali per shift

 * Pengecekan dilakukan secara manual 1 kali per shift

 * Pengecekan dilakukan secara manual 1 kali per shift

 * Pengecekan dilakukan secara manual 1 kali per shift

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|---|--|
| Pengecekan I: <ul style="list-style-type: none"> A. Baik Ta. Tidak Baik M. Baik S. Tidak Baik V. Baik W. Tidak Baik S. Baik L. Tidak Baik R. Baik R. Tidak Baik R. Baik R. Tidak Baik | Pengecekan II: <ul style="list-style-type: none"> A. Baik Ta. Tidak Baik M. Baik S. Tidak Baik V. Baik W. Tidak Baik S. Baik L. Tidak Baik R. Baik R. Tidak Baik R. Baik R. Tidak Baik |
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| Pengecekan I tjr. Sidiq | Pengecekan II Lili |
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Lampiran 5. *Check sheet* Pengecekan Kebocoran Kemasan

Lampiran 6. Tabel Perhitungan Peta Kendali

Berikut adalah hasil perhitungan nilai Proporsi reject, CL, dan UCL periode November 2022 sampai dengan Mei 2023. Untuk nilai LCL = 0, karena merupakan proporsi reject.

Tabel Perhitungan Batas Kendali Bulan November 2022

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 1 | 1.078.395 | 7.038 | 0,00653 | 0,01033 | 0,01062 | 0,00000 |
| 2 | 2 | 1.124.726 | 7.694 | 0,00684 | 0,01033 | 0,01062 | 0,00000 |
| 3 | 3 | 1.075.778 | 7.694 | 0,00715 | 0,01033 | 0,01062 | 0,00000 |
| 4 | 4 | 1.030.986 | 6.728 | 0,00653 | 0,01033 | 0,01063 | 0,00000 |
| 5 | 5 | 690.044 | 5.624 | 0,00815 | 0,01033 | 0,01070 | 0,00000 |
| 6 | 7 | 675.420 | 8.108 | 0,01200 | 0,01033 | 0,01070 | 0,00000 |
| 7 | 8 | 1.129.344 | 14.629 | 0,01295 | 0,01033 | 0,01062 | 0,00000 |
| 8 | 9 | 1.176.137 | 13.559 | 0,01153 | 0,01033 | 0,01061 | 0,00000 |
| 9 | 10 | 1.146.122 | 11.455 | 0,00999 | 0,01033 | 0,01061 | 0,00000 |
| 10 | 11 | 1.194.762 | 10.385 | 0,00869 | 0,01033 | 0,01061 | 0,00000 |
| 11 | 12 | 700.049 | 3.105 | 0,00444 | 0,01033 | 0,01069 | 0,00000 |
| 12 | 14 | 640.788 | 15.940 | 0,02488 | 0,01033 | 0,01071 | 0,00000 |
| 13 | 15 | 981.115 | 7.625 | 0,00777 | 0,01033 | 0,01064 | 0,00000 |
| 13 | 16 | 1.060.078 | 8.694 | 0,00820 | 0,01033 | 0,01062 | 0,00000 |
| 15 | 17 | 1.179.985 | 6.830 | 0,00579 | 0,01033 | 0,01061 | 0,00000 |
| 16 | 18 | 1.148.277 | 6.141 | 0,00535 | 0,01033 | 0,01061 | 0,00000 |
| 17 | 19 | 767.160 | 6.452 | 0,00841 | 0,01033 | 0,01068 | 0,00000 |
| 18 | 21 | 326.166 | 6.935 | 0,02126 | 0,01033 | 0,01086 | 0,00000 |
| 19 | 22 | 684.964 | 14.560 | 0,02126 | 0,01033 | 0,01070 | 0,00000 |
| 20 | 23 | 650.177 | 13.490 | 0,02075 | 0,01033 | 0,01071 | 0,00000 |
| 21 | 24 | 650.485 | 8.177 | 0,01257 | 0,01033 | 0,01071 | 0,00000 |
| 22 | 25 | 616.006 | 7.142 | 0,01159 | 0,01033 | 0,01072 | 0,00000 |
| 23 | 26 | 296.151 | 8.349 | 0,02819 | 0,01033 | 0,01089 | 0,00000 |
| 24 | 28 | 626.319 | 13.352 | 0,02132 | 0,01033 | 0,01071 | 0,00000 |
| 25 | 29 | 1.086.399 | 9.419 | 0,00867 | 0,01033 | 0,01062 | 0,00000 |
| 26 | 30 | 1.129.344 | 7.073 | 0,00626 | 0,01033 | 0,01062 | 0,00000 |
| Total | | 22.865.177 | 236.198 | | | | |
| CL | | | 0,01033 | | | | |

Tabel Perhitungan Batas Kendali Bulan Desember 2022

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 1 | 1.171.967 | 4.774 | 0,00407 | 0,00680 | 0,00703 | 0,00000 |
| 2 | 2 | 1.110.523 | 4.655 | 0,00419 | 0,00680 | 0,00704 | 0,00000 |
| 3 | 3 | 760.326 | 5.130 | 0,00675 | 0,00680 | 0,00708 | 0,00000 |
| 4 | 5 | 607.171 | 9.524 | 0,01569 | 0,00680 | 0,00712 | 0,00000 |
| 5 | 6 | 1.034.249 | 9.263 | 0,00896 | 0,00680 | 0,00704 | 0,00000 |
| 6 | 7 | 1.056.344 | 6.413 | 0,00607 | 0,00680 | 0,00704 | 0,00000 |
| 7 | 8 | 875.797 | 5.770 | 0,00659 | 0,00680 | 0,00706 | 0,00000 |
| 8 | 9 | 624.423 | 3.943 | 0,00631 | 0,00680 | 0,00711 | 0,00000 |
| 9 | 10 | 216.112 | 1.710 | 0,00791 | 0,00680 | 0,00733 | 0,00000 |
| 10 | 12 | 790.442 | 4.750 | 0,00601 | 0,00680 | 0,00708 | 0,00000 |
| 11 | 13 | 1.094.179 | 6.175 | 0,00564 | 0,00680 | 0,00704 | 0,00000 |
| 12 | 14 | 1.164.249 | 6.626 | 0,00569 | 0,00680 | 0,00703 | 0,00000 |
| 13 | 15 | 1.380.209 | 6.246 | 0,00453 | 0,00680 | 0,00701 | 0,00000 |
| 14 | 16 | 1.082.374 | 5.106 | 0,00472 | 0,00680 | 0,00704 | 0,00000 |
| 15 | 17 | 650.302 | 3.966 | 0,00610 | 0,00680 | 0,00711 | 0,00000 |
| 16 | 18 | 1.099.627 | 7.410 | 0,00674 | 0,00680 | 0,00704 | 0,00000 |
| 17 | 19 | 869.895 | 8.859 | 0,01018 | 0,00680 | 0,00707 | 0,00000 |
| 18 | 20 | 893.958 | 4.774 | 0,00534 | 0,00680 | 0,00706 | 0,00000 |
| 19 | 21 | 661.955 | 2.660 | 0,00402 | 0,00680 | 0,00710 | 0,00000 |
| 20 | 22 | 496.240 | 2.850 | 0,00574 | 0,00680 | 0,00715 | 0,00000 |
| 21 | 23 | 386.822 | 4.228 | 0,01093 | 0,00680 | 0,00720 | 0,00000 |
| 22 | 24 | 217.474 | 3.325 | 0,01529 | 0,00680 | 0,00733 | 0,00000 |
| 23 | 25 | 600.966 | 4.703 | 0,00783 | 0,00680 | 0,00712 | 0,00000 |
| 24 | 26 | 622.456 | 8.716 | 0,01400 | 0,00680 | 0,00711 | 0,00000 |
| 25 | 27 | 620.940 | 5.059 | 0,00815 | 0,00680 | 0,00711 | 0,00000 |
| Total | | 20.089.000 | 136.635 | | | | |
| CL | | 0,00680 | | | | | |

Tabel Perhitungan Batas Kendali Bulan Januari 2023

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 2 | 413.344 | 5.001 | 0,01210 | 0,00709 | 0,00749 | 0,00000 |
| 2 | 3 | 664.665 | 5.934 | 0,00893 | 0,00709 | 0,00740 | 0,00000 |
| 3 | 4 | 685.378 | 4.244 | 0,00619 | 0,00709 | 0,00740 | 0,00000 |
| 4 | 5 | 683.230 | 4.772 | 0,00698 | 0,00709 | 0,00740 | 0,00000 |
| 5 | 6 | 216.952 | 4.785 | 0,02206 | 0,00709 | 0,00763 | 0,00000 |
| 6 | 7 | 429.148 | 1.649 | 0,00384 | 0,00709 | 0,00748 | 0,00000 |
| 7 | 9 | 396.007 | 5.475 | 0,01383 | 0,00709 | 0,00749 | 0,00000 |
| 8 | 10 | 635.973 | 4.582 | 0,00720 | 0,00709 | 0,00741 | 0,00000 |
| 9 | 11 | 615.107 | 4.826 | 0,00785 | 0,00709 | 0,00741 | 0,00000 |
| 10 | 12 | 633.365 | 5.907 | 0,00933 | 0,00709 | 0,00741 | 0,00000 |
| 11 | 13 | 574.601 | 5.204 | 0,00906 | 0,00709 | 0,00743 | 0,00000 |
| 12 | 14 | 404.599 | 1.419 | 0,00351 | 0,00709 | 0,00749 | 0,00000 |
| 13 | 16 | 463.977 | 1.825 | 0,00393 | 0,00709 | 0,00746 | 0,00000 |
| 14 | 17 | 649.629 | 2.366 | 0,00364 | 0,00709 | 0,00741 | 0,00000 |
| 15 | 18 | 665.586 | 4.285 | 0,00644 | 0,00709 | 0,00740 | 0,00000 |
| 16 | 19 | 665.432 | 2.595 | 0,00390 | 0,00709 | 0,00740 | 0,00000 |
| 17 | 20 | 668.040 | 3.812 | 0,00571 | 0,00709 | 0,00740 | 0,00000 |
| 18 | 21 | 435.745 | 1.947 | 0,00447 | 0,00709 | 0,00748 | 0,00000 |
| 19 | 23 | 459.527 | 3.460 | 0,00753 | 0,00709 | 0,00747 | 0,00000 |
| 20 | 24 | 644.105 | 3.109 | 0,00483 | 0,00709 | 0,00741 | 0,00000 |
| 21 | 25 | 481.161 | 4.582 | 0,00952 | 0,00709 | 0,00746 | 0,00000 |
| 22 | 26 | 671.723 | 3.920 | 0,00584 | 0,00709 | 0,00740 | 0,00000 |
| 23 | 27 | 575.520 | 5.137 | 0,00893 | 0,00709 | 0,00743 | 0,00000 |
| 24 | 28 | 447.713 | 2.812 | 0,00628 | 0,00709 | 0,00747 | 0,00000 |
| 25 | 30 | 481.468 | 4.177 | 0,00868 | 0,00709 | 0,00746 | 0,00000 |
| 26 | 31 | 907.547 | 5.529 | 0,00609 | 0,00709 | 0,00736 | 0,00000 |
| Total | | 14.569.542 | 103.354 | | | | |
| CL | | 0,00709 | | | | | |

Tabel Perhitungan Batas Kendali Bulan Februari 2023

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 1 | 524.915 | 7.944 | 0,01513 | 0,00608 | 0,00640 | 0,00000 |
| 2 | 2 | 888.946 | 9.293 | 0,01045 | 0,00608 | 0,00633 | 0,00000 |
| 3 | 3 | 620.808 | 6.439 | 0,01037 | 0,00608 | 0,00637 | 0,00000 |
| 4 | 4 | 447.352 | 4.116 | 0,00920 | 0,00608 | 0,00643 | 0,00000 |
| 5 | 6 | 730.790 | 3.784 | 0,00518 | 0,00608 | 0,00635 | 0,00000 |
| 6 | 7 | 1.064.069 | 4.116 | 0,00387 | 0,00608 | 0,00630 | 0,00000 |
| 7 | 8 | 1.229.497 | 4.160 | 0,00338 | 0,00608 | 0,00629 | 0,00000 |
| 8 | 9 | 1.365.232 | 3.718 | 0,00272 | 0,00608 | 0,00628 | 0,00000 |
| 9 | 10 | 1.482.789 | 4.846 | 0,00327 | 0,00608 | 0,00627 | 0,00000 |
| 10 | 11 | 852.437 | 3.098 | 0,00363 | 0,00608 | 0,00633 | 0,00000 |
| 11 | 13 | 1.261.007 | 5.200 | 0,00412 | 0,00608 | 0,00629 | 0,00000 |
| 12 | 14 | 1.601.557 | 4.779 | 0,00298 | 0,00608 | 0,00626 | 0,00000 |
| 13 | 15 | 1.297.213 | 3.363 | 0,00259 | 0,00608 | 0,00628 | 0,00000 |
| 14 | 16 | 1.267.975 | 3.607 | 0,00284 | 0,00608 | 0,00629 | 0,00000 |
| 15 | 17 | 1.054.374 | 4.204 | 0,00399 | 0,00608 | 0,00631 | 0,00000 |
| 16 | 20 | 461.743 | 3.540 | 0,00767 | 0,00608 | 0,00642 | 0,00000 |
| 17 | 21 | 657.317 | 5.311 | 0,00808 | 0,00608 | 0,00637 | 0,00000 |
| 18 | 22 | 340.854 | 4.226 | 0,01240 | 0,00608 | 0,00648 | 0,00000 |
| 19 | 23 | 328.886 | 3.850 | 0,01171 | 0,00608 | 0,00649 | 0,00000 |
| 20 | 24 | 332.976 | 3.031 | 0,00910 | 0,00608 | 0,00648 | 0,00000 |
| 21 | 25 | 233.295 | 2.788 | 0,01195 | 0,00608 | 0,00656 | 0,00000 |
| 22 | 28 | 845.165 | 13.630 | 0,01613 | 0,00608 | 0,00633 | 0,00000 |
| Total | | 19.402.750 | 117.938 | | | | |
| CL | | 0,00608 | | | | | |

Tabel Perhitungan Batas Kendali Bulan Maret 2023

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 1 | 871.261 | 3.432 | 0,00394 | 0,00317 | 0,00335 | 0,00000 |
| 2 | 2 | 496.646 | 2.038 | 0,00410 | 0,00317 | 0,00341 | 0,00000 |
| 3 | 3 | 332.467 | 2.190 | 0,00659 | 0,00317 | 0,00346 | 0,00000 |
| 4 | 4 | 230.673 | 3.356 | 0,01455 | 0,00317 | 0,00352 | 0,00000 |
| 5 | 6 | 562.379 | 2.953 | 0,00525 | 0,00317 | 0,00339 | 0,00000 |
| 6 | 7 | 940.037 | 3.340 | 0,00355 | 0,00317 | 0,00334 | 0,00000 |
| 7 | 8 | 807.050 | 3.340 | 0,00414 | 0,00317 | 0,00336 | 0,00000 |
| 8 | 9 | 913.409 | 3.160 | 0,00346 | 0,00317 | 0,00334 | 0,00000 |
| 9 | 10 | 911.583 | 3.149 | 0,00345 | 0,00317 | 0,00334 | 0,00000 |
| 10 | 11 | 739.644 | 1.019 | 0,00138 | 0,00317 | 0,00336 | 0,00000 |
| 11 | 13 | 902.606 | 1.722 | 0,00191 | 0,00317 | 0,00334 | 0,00000 |
| 12 | 14 | 911.127 | 2.680 | 0,00294 | 0,00317 | 0,00334 | 0,00000 |
| 13 | 15 | 924.669 | 2.403 | 0,00260 | 0,00317 | 0,00334 | 0,00000 |
| 14 | 16 | 943.080 | 1.934 | 0,00205 | 0,00317 | 0,00334 | 0,00000 |
| 15 | 17 | 654.891 | 1.591 | 0,00243 | 0,00317 | 0,00338 | 0,00000 |
| 16 | 18 | 270.082 | 1.590 | 0,00589 | 0,00317 | 0,00349 | 0,00000 |
| 17 | 20 | 743.144 | 1.890 | 0,00254 | 0,00317 | 0,00336 | 0,00000 |
| 18 | 21 | 1.236.290 | 1.847 | 0,00149 | 0,00317 | 0,00332 | 0,00000 |
| 19 | 22 | 1.262.766 | 2.146 | 0,00170 | 0,00317 | 0,00332 | 0,00000 |
| 20 | 23 | 1.263.374 | 2.228 | 0,00176 | 0,00317 | 0,00332 | 0,00000 |
| 21 | 24 | 709.669 | 2.364 | 0,00333 | 0,00317 | 0,00337 | 0,00000 |
| 22 | 25 | 366.855 | 1.650 | 0,00450 | 0,00317 | 0,00345 | 0,00000 |
| 23 | 27 | 669.955 | 3.078 | 0,00459 | 0,00317 | 0,00337 | 0,00000 |
| 24 | 28 | 977.772 | 2.810 | 0,00287 | 0,00317 | 0,00334 | 0,00000 |
| 25 | 29 | 995.879 | 2.975 | 0,00299 | 0,00317 | 0,00334 | 0,00000 |
| 26 | 30 | 1.006.685 | 2.746 | 0,00273 | 0,00317 | 0,00334 | 0,00000 |
| 27 | 31 | 333.684 | 2.817 | 0,00844 | 0,00317 | 0,00346 | 0,00000 |
| Total | | 20.977.677 | 66.448 | | | | |
| CL | | 0,00317 | | | | | |

Tabel Perhitungan Batas Kendali Bulan April 2023

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 4 | 116.832 | 1.884 | 0,01613 | 0,00615 | 0,00684 | 0,00000 |
| 2 | 5 | 128.302 | 1.829 | 0,01426 | 0,00615 | 0,00680 | 0,00000 |
| 3 | 6 | 82.585 | 1.677 | 0,02031 | 0,00615 | 0,00697 | 0,00000 |
| 4 | 10 | 280.363 | 1.800 | 0,00642 | 0,00615 | 0,00659 | 0,00000 |
| 5 | 11 | 380.645 | 2.062 | 0,00542 | 0,00615 | 0,00653 | 0,00000 |
| 6 | 12 | 396.212 | 1.783 | 0,00450 | 0,00615 | 0,00652 | 0,00000 |
| 7 | 27 | 98.643 | 1.787 | 0,01812 | 0,00615 | 0,00690 | 0,00000 |
| 8 | 28 | 491.086 | 1.287 | 0,00262 | 0,00615 | 0,00648 | 0,00000 |
| 9 | 29 | 488.301 | 1.037 | 0,00212 | 0,00615 | 0,00649 | 0,00000 |
| Total | | 2.462.969 | 15.146 | | | | |
| CL | | 0,00615 | | | | | |

Tabel Perhitungan Batas Kendali Bulan Mei 2023

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|---------|----------------------|--------------|----------|---------|---------|---------|
| 1 | 2 | 557.026 | 2.285 | 0,00410 | 0,00599 | 0,00630 | 0,00000 |
| 2 | 3 | 851.734 | 2.287 | 0,00269 | 0,00599 | 0,00624 | 0,00000 |
| 3 | 4 | 1.013.382 | 2.442 | 0,00241 | 0,00599 | 0,00622 | 0,00000 |
| 4 | 5 | 1.052.616 | 7.012 | 0,00666 | 0,00599 | 0,00621 | 0,00000 |
| 5 | 6 | 725.365 | 2.786 | 0,00384 | 0,00599 | 0,00626 | 0,00000 |
| 6 | 8 | 647.963 | 2.223 | 0,00343 | 0,00599 | 0,00628 | 0,00000 |
| 7 | 9 | 743.766 | 2.285 | 0,00307 | 0,00599 | 0,00626 | 0,00000 |
| 8 | 10 | 763.839 | 2.567 | 0,00336 | 0,00599 | 0,00625 | 0,00000 |
| 9 | 11 | 759.885 | 2.442 | 0,00321 | 0,00599 | 0,00625 | 0,00000 |
| 10 | 12 | 372.871 | 2.410 | 0,00646 | 0,00599 | 0,00637 | 0,00000 |
| 11 | 13 | 223.388 | 2.786 | 0,01247 | 0,00599 | 0,00648 | 0,00000 |
| 12 | 15 | 262.013 | 2.317 | 0,00884 | 0,00599 | 0,00644 | 0,00000 |
| 13 | 16 | 387.318 | 2.473 | 0,00638 | 0,00599 | 0,00636 | 0,00000 |
| 14 | 17 | 387.774 | 2.786 | 0,00718 | 0,00599 | 0,00636 | 0,00000 |
| 15 | 18 | 378.194 | 2.849 | 0,00753 | 0,00599 | 0,00636 | 0,00000 |
| 16 | 19 | 235.706 | 5.228 | 0,02218 | 0,00599 | 0,00647 | 0,00000 |
| 17 | 22 | 588.352 | 1.722 | 0,00293 | 0,00599 | 0,00629 | 0,00000 |
| 18 | 23 | 777.829 | 6.981 | 0,00897 | 0,00599 | 0,00625 | 0,00000 |
| 19 | 24 | 770.834 | 2.410 | 0,00313 | 0,00599 | 0,00625 | 0,00000 |
| 20 | 25 | 788.778 | 2.786 | 0,00353 | 0,00599 | 0,00625 | 0,00000 |
| 21 | 26 | 364.964 | 2.035 | 0,00558 | 0,00599 | 0,00637 | 0,00000 |
| 22 | 29 | 331.810 | 6.699 | 0,02019 | 0,00599 | 0,00639 | 0,00000 |
| 23 | 30 | 391.728 | 6.198 | 0,01582 | 0,00599 | 0,00636 | 0,00000 |
| 24 | 31 | 412.865 | 6.574 | 0,01592 | 0,00599 | 0,00635 | 0,00000 |
| Total | | 13.790.000 | 82.583 | | | | |
| CL | | 0,00599 | | | | | |

Tabel Perhitungan Batas Kendali Secara total bulanan
Periode November 2022 sampai Mei 2023

| No | Tanggal | Hasil Produksi (pcs) | Reject (pcs) | Proporsi | CL | UCL | LCL |
|-------|----------|----------------------|--------------|----------|---------|---------|---------|
| 1 | Nov 2022 | 22.865.177 | 236.198 | 0,01033 | 0,00664 | 0,00669 | 0,00000 |
| 2 | Dec-22 | 20.089.000 | 136.635 | 0,00680 | 0,00664 | 0,00670 | 0,00000 |
| 3 | Jan-23 | 14.569.542 | 103.354 | 0,00709 | 0,00664 | 0,00671 | 0,00000 |
| 4 | Feb-23 | 19.402.750 | 117.938 | 0,00608 | 0,00664 | 0,00670 | 0,00000 |
| 5 | Mar-23 | 20.977.677 | 66.448 | 0,00317 | 0,00664 | 0,00670 | 0,00000 |
| 6 | Apr-23 | 2.462.969 | 15.146 | 0,00615 | 0,00664 | 0,00680 | 0,00000 |
| 7 | May-23 | 13.790.000 | 82.583 | 0,00599 | 0,00664 | 0,00671 | 0,00000 |
| Total | | 114.157.115 | 758.302 | | | | |
| CL | | 0,00664 | | | | | |