

## **LAMPIRAN**

**LAMPIRAN 1**  
**TABEL PERHITUNGAN BKA BKB**

tabel Kualitas

TABLE B Factors for Computing Central Lines and  $3\sigma$  Control Limits for  $\bar{X}$ ,  $s$  and  $R$  Charts.

OBSERVATIONS IN SAMPLE, $n$	AVERAGES				CHART FOR STANDARD DEVIATIONS						CHART FOR RANGES					
	FACTORS FOR CONTROL LIMITS		CENTRAL LINE		FACTORS FOR CONTROL LIMITS		CENTRAL LINE		FACTORS FOR CONTROL LIMITS		CENTRAL LINE		FACTORS FOR CONTROL LIMITS		CENTRAL LINE	
	$A_1$	$A_2$	$A_3$	$A_4$	$B_1$	$B_2$	$B_3$	$B_4$	$B_5$	$B_6$	$d_1$	$d_2$	$d_3$	$D_1$	$D_2$	$D_3$
2	2.121	1.880	2.659	0.7979	0	3.267	0	2.606	1.128	0.853	0	3.686	0	3.267		
3	1.732	1.023	1.954	0.8862	0	2.568	0	2.276	1.693	0.888	0	4.358	0	2.574		
4	1.500	0.729	1.628	0.9213	0	2.266	0	2.088	2.052	0.880	0	4.698	0	2.282		
5	1.342	0.577	1.427	0.9400	0	2.089	0	1.964	2.326	0.864	0	4.918	0	2.114		
6	1.225	0.483	1.287	0.9515	0.030	1.970	0.029	1.874	2.534	0.848	0	5.078	0	2.004		
7	1.134	0.419	1.182	0.9594	0.118	1.882	0.113	1.806	2.704	0.833	0.204	5.204	0.076	1.924		
8	1.061	0.373	1.099	0.9650	0.185	1.815	0.179	1.751	2.847	0.820	0.388	5.306	0.136	1.864		
9	1.000	0.337	1.032	0.9693	0.239	1.761	0.232	1.707	2.970	0.808	0.547	5.393	0.184	1.816		
10	0.949	0.308	0.975	0.9727	0.284	1.716	0.276	1.669	3.078	0.797	0.687	5.469	0.223	1.777		
11	0.905	0.285	0.927	0.9754	0.321	1.679	0.313	1.637	3.173	0.787	0.811	5.535	0.256	1.744		
12	0.866	0.266	0.886	0.9776	0.354	1.646	0.346	1.610	3.258	0.778	0.922	5.594	0.283	1.717		
13	0.832	0.249	0.850	0.9794	0.382	1.618	0.374	1.585	3.336	0.770	1.025	5.647	0.307	1.693		
14	0.802	0.235	0.817	0.9810	0.406	1.594	0.399	1.563	3.407	0.763	1.118	5.696	0.328	1.672		
15	0.775	0.223	0.789	0.9823	0.428	1.572	0.421	1.544	3.472	0.756	1.203	5.741	0.347	1.653		
16	0.750	0.212	0.763	0.9835	0.448	1.552	0.440	1.526	3.532	0.750	1.282	5.782	0.363	1.637		
17	0.728	0.203	0.739	0.9845	0.466	1.534	0.458	1.511	3.588	0.744	1.356	5.820	0.378	1.622		
18	0.707	0.194	0.718	0.9854	0.482	1.518	0.475	1.496	3.640	0.739	1.424	5.856	0.391	1.608		
19	0.688	0.187	0.698	0.9862	0.497	1.503	0.490	1.483	3.689	0.734	1.487	5.891	0.403	1.597		
20	0.671	0.180	0.680	0.9869	0.510	1.490	0.504	1.470	3.735	0.729	1.549	5.921	0.415	1.585		

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**LAMPIRAN 2**  
**DATA OBSERVASI**  
**DIAMETER HASIL BUBUT BAGIAN KEPALA**

**Lampiran 2.1**  
**Diameter Bagian Kepala Mesin Bubut 1**

Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter
1/11/2008	1	12.02	6/11/2008	34	11.96	11/11/2008	68	11.92
1/11/2008	2	11.92	6/11/2008	35	12.00	11/11/2008	69	12.03
1/11/2008	3	12.09	6/11/2008	36	12.06	11/11/2008	70	11.98
1/11/2008	4	12.05	6/11/2008	37	12.04	11/11/2008	71	11.98
1/11/2008	5	12.08	7/11/2008	38	11.96	11/11/2008	72	12.10
3/11/2008	6	11.99	7/11/2008	39	12.04	11/11/2008	73	12.04
3/11/2008	7	11.99	7/11/2008	40	11.92	12/11/2008	74	12.04
3/11/2008	8	12.08	7/11/2008	41	12.01	12/11/2008	75	12.08
3/11/2008	9	12.03	7/11/2008	42	12.08	12/11/2008	76	12.08
3/11/2008	10	11.99	7/11/2008	43	12.07	12/11/2008	77	11.92
3/11/2008	11	12.08	7/11/2008	44	11.99	12/11/2008	78	11.93
3/11/2008	12	12.09	7/11/2008	45	11.93	12/11/2008	79	11.92
3/11/2008	13	12.02	7/11/2008	46	11.92	12/11/2008	80	12.02
3/11/2008	14	12.06	7/11/2008	47	11.90	13/11/2008	81	12.06
3/11/2008	15	11.98	7/11/2008	48	12.07	13/11/2008	82	11.94
4/11/2008	16	11.98	8/11/2008	49	11.98	13/11/2008	83	12.04
4/11/2008	17	11.99	8/11/2008	50	12.01	13/11/2008	84	12.09
4/11/2008	18	12.01	8/11/2008	51	12.03	13/11/2008	85	12.03
4/11/2008	19	11.92	8/11/2008	52	12.01	13/11/2008	86	12.07
4/11/2008	20	12.02	8/11/2008	53	11.99	13/11/2008	87	12.06
4/11/2008	21	12.09	8/11/2008	54	11.94	13/11/2008	88	11.96
4/11/2008	22	12.00	10/11/2008	55	11.98	13/11/2008	89	12.09
5/11/2008	23	12.01	10/11/2008	56	11.93	13/11/2008	90	12.09
5/11/2008	24	12.08	10/11/2008	57	11.99	13/11/2008	91	12.07
5/11/2008	25	12.03	10/11/2008	58	11.97	13/11/2008	92	11.93
5/11/2008	26	11.92	10/11/2008	59	11.92	14/11/2008	93	12.06
5/11/2008	27	12.01	10/11/2008	60	12.01	14/11/2008	94	12.07
5/11/2008	28	12.03	10/11/2008	61	11.98	14/11/2008	95	12.02
6/11/2008	29	12.08	10/11/2008	62	12.09	14/11/2008	96	12.03
6/11/2008	30	11.98	10/11/2008	63	11.90	14/11/2008	97	12.09
6/11/2008	31	12.05	10/11/2008	64	11.98	14/11/2008	98	12.08
6/11/2008	32	12.04	10/11/2008	65	11.93	14/11/2008	99	12.07
6/11/2008	33	12.07	11/11/2008	66	12.07	14/11/2008	100	12.09
6/11/2008	34	11.96	11/11/2008	67	12.03			

Sumber: Observasi, 2008

**Lampiran 2.2**  
**Diameter Bagian Kepala Mesin Bubut 2**

Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter
1/11/2008	1	12.06	6/11/2008	34	11.92	11/11/2008	68	11.94
1/11/2008	2	12.08	6/11/2008	35	12.04	11/11/2008	69	12.07
1/11/2008	3	12.03	6/11/2008	36	11.95	11/11/2008	70	11.92
1/11/2008	4	12.07	6/11/2008	37	11.98	11/11/2008	71	11.97
1/11/2008	5	12.09	7/11/2008	38	12.08	11/11/2008	72	11.90
3/11/2008	6	12.06	7/11/2008	39	11.96	11/11/2008	73	12.02
3/11/2008	7	11.92	7/11/2008	40	11.92	12/11/2008	74	12.02
3/11/2008	8	12.07	7/11/2008	41	11.92	12/11/2008	75	12.03
3/11/2008	9	12.04	7/11/2008	42	11.92	12/11/2008	76	12.06
3/11/2008	10	11.95	7/11/2008	43	11.92	12/11/2008	77	12.05
3/11/2008	11	12.03	7/11/2008	44	12.08	12/11/2008	78	12.02
3/11/2008	12	12.08	7/11/2008	45	12.09	12/11/2008	79	11.94
3/11/2008	13	12.03	7/11/2008	46	12.01	12/11/2008	80	11.92
3/11/2008	14	12.10	7/11/2008	47	11.98	13/11/2008	81	11.99
3/11/2008	15	11.96	7/11/2008	48	12.09	13/11/2008	82	11.96
4/11/2008	16	11.92	8/11/2008	49	11.92	13/11/2008	83	12.03
4/11/2008	17	12.00	8/11/2008	50	11.90	13/11/2008	84	12.07
4/11/2008	18	12.04	8/11/2008	51	12.09	13/11/2008	85	12.04
4/11/2008	19	11.96	8/11/2008	52	12.09	13/11/2008	86	12.02
4/11/2008	20	12.08	8/11/2008	53	12.03	13/11/2008	87	12.06
4/11/2008	21	11.90	8/11/2008	54	12.02	13/11/2008	88	12.02
4/11/2008	22	12.07	10/11/2008	55	11.94	13/11/2008	89	12.04
5/11/2008	23	12.03	10/11/2008	56	11.97	13/11/2008	90	12.00
5/11/2008	24	12.06	10/11/2008	57	12.02	13/11/2008	91	11.98
5/11/2008	25	11.95	10/11/2008	58	12.03	13/11/2008	92	11.98
5/11/2008	26	11.95	10/11/2008	59	11.92	14/11/2008	93	11.98
5/11/2008	27	11.98	10/11/2008	60	11.97	14/11/2008	94	12.07
5/11/2008	28	12.06	10/11/2008	61	11.98	14/11/2008	95	12.06
6/11/2008	29	11.92	10/11/2008	62	11.95	14/11/2008	96	11.94
6/11/2008	30	11.98	10/11/2008	63	11.96	14/11/2008	97	11.92
6/11/2008	31	11.97	10/11/2008	64	12.03	14/11/2008	98	11.96
6/11/2008	32	12.02	10/11/2008	65	11.98	14/11/2008	99	12.05
6/11/2008	33	11.99	11/11/2008	66	12.01	14/11/2008	100	12.04
6/11/2008	34	11.96	11/11/2008	67	12.03			

Sumber: Observasi, 2008

**LAMPIRAN 3**  
**DATA OBSERVASI**  
**DIAMETER HASIL BUBUT BAGIAN TENGAH**

**Lampiran 3.1**  
**Diameter Bagian Tengah Mesin Bubut 1**

Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter
1/11/2008	1	15.09	6/11/2008	34	15.04	11/11/2008	68	14.93
1/11/2008	2	14.99	6/11/2008	35	15.08	11/11/2008	69	14.97
1/11/2008	3	14.90	6/11/2008	36	15.08	11/11/2008	70	14.98
1/11/2008	4	14.90	6/11/2008	37	14.92	11/11/2008	71	15.09
1/11/2008	5	15.09	7/11/2008	38	15.02	11/11/2008	72	14.90
3/11/2008	6	15.03	7/11/2008	39	14.98	11/11/2008	73	14.94
3/11/2008	7	15.01	7/11/2008	40	15.09	12/11/2008	74	14.98
3/11/2008	8	15.00	7/11/2008	41	14.95	12/11/2008	75	14.98
3/11/2008	9	15.02	7/11/2008	42	14.95	12/11/2008	76	14.92
3/11/2008	10	14.92	7/11/2008	43	14.92	12/11/2008	77	15.02
3/11/2008	11	14.92	7/11/2008	44	14.92	12/11/2008	78	15.01
3/11/2008	12	15.07	7/11/2008	45	15.01	12/11/2008	79	14.98
3/11/2008	13	15.02	7/11/2008	46	15.03	12/11/2008	80	15.02
3/11/2008	14	15.01	7/11/2008	47	15.01	13/11/2008	81	15.06
3/11/2008	15	15.01	7/11/2008	48	14.98	13/11/2008	82	14.96
4/11/2008	16	14.98	8/11/2008	49	15.09	13/11/2008	83	14.95
4/11/2008	17	15.01	8/11/2008	50	14.90	13/11/2008	84	15.05
4/11/2008	18	15.06	8/11/2008	51	15.05	13/11/2008	85	14.98
4/11/2008	19	14.95	8/11/2008	52	15.09	13/11/2008	86	14.91
4/11/2008	20	15.03	8/11/2008	53	15.00	13/11/2008	87	14.92
4/11/2008	21	15.08	8/11/2008	54	15.08	13/11/2008	88	14.97
4/11/2008	22	15.09	10/11/2008	55	15.06	13/11/2008	89	15.02
5/11/2008	23	15.01	10/11/2008	56	15.09	13/11/2008	90	15.03
5/11/2008	24	15.02	10/11/2008	57	14.91	13/11/2008	91	15.02
5/11/2008	25	14.96	10/11/2008	58	15.08	13/11/2008	92	14.98
5/11/2008	26	15.06	10/11/2008	59	14.98	14/11/2008	93	14.99
5/11/2008	27	15.02	10/11/2008	60	15.06	14/11/2008	94	14.92
5/11/2008	28	15.06	10/11/2008	61	15.08	14/11/2008	95	15.08
6/11/2008	29	15.09	10/11/2008	62	15.09	14/11/2008	96	15.02
6/11/2008	30	14.98	10/11/2008	63	15.08	14/11/2008	97	14.93
6/11/2008	31	15.03	10/11/2008	64	14.99	14/11/2008	98	15.03
6/11/2008	32	15.09	10/11/2008	65	14.92	14/11/2008	99	15.09
6/11/2008	33	15.05	11/11/2008	66	14.92	14/11/2008	100	14.99
6/11/2008	34	15.09	11/11/2008	67	12.03			

Sumber: Observasi, 2008



**Lampiran 3.2**  
**Diameter Bagian Tengah Mesin Bubut 2**

Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter
1/11/2008	1	15.09	6/11/2008	34	15.04	11/11/2008	68	14.93
1/11/2008	2	14.99	6/11/2008	35	15.08	11/11/2008	69	14.97
1/11/2008	3	14.90	6/11/2008	36	15.08	11/11/2008	70	14.98
1/11/2008	4	14.90	6/11/2008	37	14.92	11/11/2008	71	15.09
1/11/2008	5	15.09	7/11/2008	38	15.02	11/11/2008	72	14.90
3/11/2008	6	15.03	7/11/2008	39	14.98	11/11/2008	73	14.94
3/11/2008	7	15.01	7/11/2008	40	15.09	12/11/2008	74	14.98
3/11/2008	8	15.00	7/11/2008	41	14.95	12/11/2008	75	14.98
3/11/2008	9	15.02	7/11/2008	42	14.95	12/11/2008	76	14.92
3/11/2008	10	14.92	7/11/2008	43	14.92	12/11/2008	77	15.02
3/11/2008	11	14.92	7/11/2008	44	14.92	12/11/2008	78	15.01
3/11/2008	12	15.07	7/11/2008	45	15.01	12/11/2008	79	14.98
3/11/2008	13	15.02	7/11/2008	46	15.03	12/11/2008	80	15.02
3/11/2008	14	15.01	7/11/2008	47	15.01	13/11/2008	81	15.06
3/11/2008	15	15.01	7/11/2008	48	14.98	13/11/2008	82	14.96
4/11/2008	16	14.98	8/11/2008	49	15.09	13/11/2008	83	14.95
4/11/2008	17	15.01	8/11/2008	50	14.90	13/11/2008	84	15.05
4/11/2008	18	15.06	8/11/2008	51	15.05	13/11/2008	85	14.98
4/11/2008	19	14.95	8/11/2008	52	15.09	13/11/2008	86	14.91
4/11/2008	20	15.03	8/11/2008	53	15.00	13/11/2008	87	14.92
4/11/2008	21	15.08	8/11/2008	54	15.08	13/11/2008	88	14.97
4/11/2008	22	15.09	10/11/2008	55	15.06	13/11/2008	89	15.02
5/11/2008	23	15.01	10/11/2008	56	15.09	13/11/2008	90	15.03
5/11/2008	24	15.02	10/11/2008	57	14.91	13/11/2008	91	15.02
5/11/2008	25	14.96	10/11/2008	58	15.08	13/11/2008	92	14.98
5/11/2008	26	15.06	10/11/2008	59	14.98	14/11/2008	93	14.99
5/11/2008	27	15.02	10/11/2008	60	15.06	14/11/2008	94	14.92
5/11/2008	28	15.06	10/11/2008	61	15.08	14/11/2008	95	15.08
6/11/2008	29	15.09	10/11/2008	62	15.09	14/11/2008	96	15.02
6/11/2008	30	14.98	10/11/2008	63	15.08	14/11/2008	97	14.93
6/11/2008	31	15.03	10/11/2008	64	14.99	14/11/2008	98	15.03
6/11/2008	32	15.09	10/11/2008	65	14.92	14/11/2008	99	15.09
6/11/2008	33	15.05	11/11/2008	66	14.92	14/11/2008	100	14.99
6/11/2008	34	15.09	11/11/2008	67	12.03			

Sumber: Observasi, 2008

**LAMPIRAN 4**  
**DATA OBSERVASI**  
**DIAMETER HASIL BUBUT BAGIAN BELAKANG**

**Lampiran 4.1**  
**Diameter Bagian Belakang Mesin Bubut 1**

Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter
1/11/2008	1	9.79	6/11/2008	34	9.85	11/11/2008	68	9.82
1/11/2008	2	9.89	6/11/2008	35	9.82	11/11/2008	69	9.87
1/11/2008	3	9.90	6/11/2008	36	9.83	11/11/2008	70	9.82
1/11/2008	4	9.76	6/11/2008	37	9.90	11/11/2008	71	9.86
1/11/2008	5	9.78	7/11/2008	38	9.88	11/11/2008	72	9.77
3/11/2008	6	9.89	7/11/2008	39	9.76	11/11/2008	73	9.80
3/11/2008	7	9.78	7/11/2008	40	9.90	12/11/2008	74	9.90
3/11/2008	8	9.86	7/11/2008	41	9.82	12/11/2008	75	9.76
3/11/2008	9	9.78	7/11/2008	42	9.86	12/11/2008	76	9.83
3/11/2008	10	9.88	7/11/2008	43	9.82	12/11/2008	77	9.74
3/11/2008	11	9.81	7/11/2008	44	9.76	12/11/2008	78	9.78
3/11/2008	12	9.76	7/11/2008	45	9.88	12/11/2008	79	9.82
3/11/2008	13	9.79	7/11/2008	46	9.80	12/11/2008	80	9.74
3/11/2008	14	9.86	7/11/2008	47	9.78	13/11/2008	81	9.76
3/11/2008	15	9.87	7/11/2008	48	9.82	13/11/2008	82	9.77
4/11/2008	16	9.77	8/11/2008	49	9.81	13/11/2008	83	9.86
4/11/2008	17	9.78	8/11/2008	50	9.79	13/11/2008	84	9.75
4/11/2008	18	9.82	8/11/2008	51	9.85	13/11/2008	85	9.80
4/11/2008	19	9.81	8/11/2008	52	9.72	13/11/2008	86	9.88
4/11/2008	20	9.82	8/11/2008	53	9.83	13/11/2008	87	9.82
4/11/2008	21	9.73	8/11/2008	54	9.86	13/11/2008	88	9.85
4/11/2008	22	9.86	10/11/2008	55	9.78	13/11/2008	89	9.86
5/11/2008	23	9.76	10/11/2008	56	9.90	13/11/2008	90	9.83
5/11/2008	24	9.89	10/11/2008	57	9.84	13/11/2008	91	9.86
5/11/2008	25	9.86	10/11/2008	58	9.76	13/11/2008	92	9.82
5/11/2008	26	9.78	10/11/2008	59	9.78	14/11/2008	93	9.84
5/11/2008	27	9.78	10/11/2008	60	9.75	14/11/2008	94	9.87
5/11/2008	28	9.78	10/11/2008	61	9.76	14/11/2008	95	9.79
6/11/2008	29	9.72	10/11/2008	62	9.87	14/11/2008	96	9.82
6/11/2008	30	9.81	10/11/2008	63	9.83	14/11/2008	97	9.88
6/11/2008	31	9.86	10/11/2008	64	9.88	14/11/2008	98	9.74
6/11/2008	32	9.76	10/11/2008	65	9.83	14/11/2008	99	9.74
6/11/2008	33	9.76	11/11/2008	66	9.86	14/11/2008	100	9.80
6/11/2008	34	9.87	11/11/2008	67	12.03			

Sumber: Observasi, 2008

**Lampiran 4.2**  
**Diameter Bagian Belakang Mesin Bubut 2**

Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter	Tgl Observasi	No	Diameter
1/11/2008	1	9.77	6/11/2008	34	9.86	11/11/2008	68	9.86
1/11/2008	2	9.80	6/11/2008	35	9.72	11/11/2008	69	9.88
1/11/2008	3	9.87	6/11/2008	36	9.81	11/11/2008	70	9.76
1/11/2008	4	9.78	6/11/2008	37	9.81	11/11/2008	71	9.86
1/11/2008	5	9.76	7/11/2008	38	9.86	11/11/2008	72	9.81
3/11/2008	6	9.86	7/11/2008	39	9.81	11/11/2008	73	9.85
3/11/2008	7	9.77	7/11/2008	40	9.78	12/11/2008	74	9.90
3/11/2008	8	9.72	7/11/2008	41	9.78	12/11/2008	75	9.82
3/11/2008	9	9.86	7/11/2008	42	9.88	12/11/2008	76	9.72
3/11/2008	10	9.81	7/11/2008	43	9.82	12/11/2008	77	9.81
3/11/2008	11	9.82	7/11/2008	44	9.86	12/11/2008	78	9.81
3/11/2008	12	9.79	7/11/2008	45	9.81	12/11/2008	79	9.89
3/11/2008	13	9.86	7/11/2008	46	9.88	12/11/2008	80	9.82
3/11/2008	14	9.72	7/11/2008	47	9.90	13/11/2008	81	9.80
3/11/2008	15	9.83	7/11/2008	48	9.78	13/11/2008	82	9.86
4/11/2008	16	9.88	8/11/2008	49	9.82	13/11/2008	83	9.86
4/11/2008	17	9.72	8/11/2008	50	9.80	13/11/2008	84	9.88
4/11/2008	18	9.89	8/11/2008	51	9.88	13/11/2008	85	9.89
4/11/2008	19	9.83	8/11/2008	52	9.81	13/11/2008	86	9.82
4/11/2008	20	9.80	8/11/2008	53	9.76	13/11/2008	87	9.85
4/11/2008	21	9.88	8/11/2008	54	9.78	13/11/2008	88	9.86
4/11/2008	22	9.84	10/11/2008	55	9.81	13/11/2008	89	9.78
5/11/2008	23	9.88	10/11/2008	56	9.72	13/11/2008	90	9.81
5/11/2008	24	9.87	10/11/2008	57	9.72	13/11/2008	91	9.80
5/11/2008	25	9.78	10/11/2008	58	9.76	13/11/2008	92	9.80
5/11/2008	26	9.79	10/11/2008	59	9.87	14/11/2008	93	9.86
5/11/2008	27	9.72	10/11/2008	60	9.82	14/11/2008	94	9.88
5/11/2008	28	9.75	10/11/2008	61	9.86	14/11/2008	95	9.78
6/11/2008	29	9.82	10/11/2008	62	9.82	14/11/2008	96	9.88
6/11/2008	30	9.82	10/11/2008	63	9.81	14/11/2008	97	9.74
6/11/2008	31	9.78	10/11/2008	64	9.78	14/11/2008	98	9.83
6/11/2008	32	9.80	10/11/2008	65	9.84	14/11/2008	99	9.86
6/11/2008	33	9.76	11/11/2008	66	9.80	14/11/2008	100	9.85
6/11/2008	34	9.81	11/11/2008	67	12.03			

Sumber: Observasi, 2008

**LAMPIRAN 5**  
**PETA KENDALI X DAN MR**

**Lampiran 5.1**  
**Peta X Diameter Bagian Kepala Mesin Bubut 1**

No Data	Data	No Data	Data	Peta X		
				CL(x)	BKA(x)	BKB(x)
1	12.02	51	12.03	12.014	12.175	11.854
2	11.92	52	12.01	12.014	12.175	11.854
3	12.09	53	11.99	12.014	12.175	11.854
4	12.05	54	11.94	12.014	12.175	11.854
5	12.08	55	11.98	12.014	12.175	11.854
6	11.99	56	11.93	12.014	12.175	11.854
7	11.99	57	11.99	12.014	12.175	11.854
8	12.08	58	11.97	12.014	12.175	11.854
9	12.03	59	11.92	12.014	12.175	11.854
10	11.99	60	12.01	12.014	12.175	11.854
11	12.08	61	11.98	12.014	12.175	11.854
12	12.09	62	12.09	12.014	12.175	11.854
13	12.02	63	11.9	12.014	12.175	11.854
14	12.06	64	11.98	12.014	12.175	11.854
15	11.98	65	11.93	12.014	12.175	11.854
16	11.98	66	12.07	12.014	12.175	11.854
17	11.99	67	12.03	12.014	12.175	11.854
18	12.01	68	11.92	12.014	12.175	11.854
19	11.92	69	12.03	12.014	12.175	11.854
20	12.02	70	11.98	12.014	12.175	11.854
21	12.09	71	11.98	12.014	12.175	11.854
22	12	72	12.1	12.014	12.175	11.854
23	12.01	73	12.04	12.014	12.175	11.854
24	12.08	74	12.04	12.014	12.175	11.854
25	12.03	75	12.08	12.014	12.175	11.854
26	11.92	76	12.08	12.014	12.175	11.854
27	12.01	77	11.92	12.014	12.175	11.854
28	12.03	78	11.93	12.014	12.175	11.854
29	12.08	79	11.92	12.014	12.175	11.854
30	11.98	80	12.02	12.014	12.175	11.854
31	12.05	81	12.06	12.014	12.175	11.854
32	12.04	82	11.94	12.014	12.175	11.854
33	12.07	83	12.04	12.014	12.175	11.854
34	11.96	84	12.09	12.014	12.175	11.854
35	12	85	12.03	12.014	12.175	11.854
36	12.06	86	12.07	12.014	12.175	11.854
37	12.04	87	12.06	12.014	12.175	11.854
38	11.96	88	11.96	12.014	12.175	11.854
39	12.04	89	12.09	12.014	12.175	11.854
40	11.92	90	12.09	12.014	12.175	11.854
41	12.01	91	12.07	12.014	12.175	11.854
42	12.08	92	11.93	12.014	12.175	11.854
43	12.07	93	12.06	12.014	12.175	11.854
44	11.99	94	12.07	12.014	12.175	11.854
45	11.93	95	12.02	12.014	12.175	11.854
46	11.92	96	12.03	12.014	12.175	11.854
47	11.9	97	12.09	12.014	12.175	11.854
48	12.07	98	12.08	12.014	12.175	11.854
49	11.98	99	12.07	12.014	12.175	11.854
50	12.01	100	12.09	12.014	12.175	11.854

Sumber: Pengolahan Data, 2008

**Lampiran 5.2**  
**Peta MR Diameter Bagian Kepala Mesin Bubut 1**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1	0.000	51	0.020	0.060	0.197	0
2	0.100	52	0.020	0.060	0.197	0
3	0.170	53	0.020	0.060	0.197	0
4	0.040	54	0.050	0.060	0.197	0
5	0.030	55	0.040	0.060	0.197	0
6	0.090	56	0.050	0.060	0.197	0
7	0.000	57	0.060	0.060	0.197	0
8	0.090	58	0.020	0.060	0.197	0
9	0.050	59	0.050	0.060	0.197	0
10	0.040	60	0.090	0.060	0.197	0
11	0.090	61	0.030	0.060	0.197	0
12	0.010	62	0.110	0.060	0.197	0
13	0.070	63	0.190	0.060	0.197	0
14	0.040	64	0.080	0.060	0.197	0
15	0.080	65	0.050	0.060	0.197	0
16	0.000	66	0.140	0.060	0.197	0
17	0.010	67	0.040	0.060	0.197	0
18	0.020	68	0.110	0.060	0.197	0
19	0.090	69	0.110	0.060	0.197	0
20	0.100	70	0.050	0.060	0.197	0
21	0.070	71	0.000	0.060	0.197	0
22	0.090	72	0.120	0.060	0.197	0
23	0.010	73	0.060	0.060	0.197	0
24	0.070	74	0.000	0.060	0.197	0
25	0.050	75	0.040	0.060	0.197	0
26	0.110	76	0.000	0.060	0.197	0
27	0.090	77	0.160	0.060	0.197	0
28	0.020	78	0.010	0.060	0.197	0
29	0.050	79	0.010	0.060	0.197	0
30	0.100	80	0.100	0.060	0.197	0
31	0.070	81	0.040	0.060	0.197	0
32	0.010	82	0.120	0.060	0.197	0
33	0.030	83	0.100	0.060	0.197	0
34	0.110	84	0.050	0.060	0.197	0
35	0.040	85	0.060	0.060	0.197	0
36	0.060	86	0.040	0.060	0.197	0
37	0.020	87	0.010	0.060	0.197	0
38	0.080	88	0.100	0.060	0.197	0
39	0.080	89	0.130	0.060	0.197	0
40	0.120	90	0.000	0.060	0.197	0
41	0.090	91	0.020	0.060	0.197	0
42	0.070	92	0.140	0.060	0.197	0
43	0.010	93	0.130	0.060	0.197	0
44	0.080	94	0.010	0.060	0.197	0
45	0.060	95	0.050	0.060	0.197	0
46	0.010	96	0.010	0.060	0.197	0
47	0.020	97	0.060	0.060	0.197	0
48	0.170	98	0.010	0.060	0.197	0
49	0.090	99	0.010	0.060	0.197	0
50	0.030	100	0.020	0.060	0.197	0

Sumber: Pengolahan Data, 2008

**Lampiran 5.3**  
**Peta X Diameter Bagian Kepala Mesin Bubut 2**

No Data	Data	No Data	Data	Peta X		
				CL(x)	BKA(x)	BKB(x)
1	12.06	51	11.9	12.001	12.156	11.846
2	12.08	52	12.09	12.001	12.156	11.846
3	12.03	53	12.09	12.001	12.156	11.846
4	12.07	54	12.03	12.001	12.156	11.846
5	12.09	55	12.02	12.001	12.156	11.846
6	12.06	56	11.94	12.001	12.156	11.846
7	11.92	57	11.97	12.001	12.156	11.846
8	12.07	58	12.02	12.001	12.156	11.846
9	12.04	59	12.03	12.001	12.156	11.846
10	11.95	60	11.92	12.001	12.156	11.846
11	12.03	61	11.97	12.001	12.156	11.846
12	12.08	62	11.98	12.001	12.156	11.846
13	12.03	63	11.95	12.001	12.156	11.846
14	12.1	64	11.96	12.001	12.156	11.846
15	11.96	65	12.03	12.001	12.156	11.846
16	11.92	66	11.98	12.001	12.156	11.846
17	12	67	12.01	12.001	12.156	11.846
18	12.04	68	11.94	12.001	12.156	11.846
19	11.96	69	12.07	12.001	12.156	11.846
20	12.08	70	11.92	12.001	12.156	11.846
21	11.9	71	11.97	12.001	12.156	11.846
22	12.07	72	11.9	12.001	12.156	11.846
23	12.03	73	12.02	12.001	12.156	11.846
24	12.06	74	12.02	12.001	12.156	11.846
25	11.95	75	12.03	12.001	12.156	11.846
26	11.95	76	12.06	12.001	12.156	11.846
27	11.98	77	12.05	12.001	12.156	11.846
28	12.06	78	12.02	12.001	12.156	11.846
29	11.92	79	11.94	12.001	12.156	11.846
30	11.98	80	11.92	12.001	12.156	11.846
31	11.97	81	11.99	12.001	12.156	11.846
32	12.02	82	11.96	12.001	12.156	11.846
33	11.99	83	12.03	12.001	12.156	11.846
34	11.96	84	12.07	12.001	12.156	11.846
35	11.92	85	12.04	12.001	12.156	11.846
36	12.04	86	12.02	12.001	12.156	11.846
37	11.95	87	12.06	12.001	12.156	11.846
38	11.98	88	12.02	12.001	12.156	11.846
39	12.08	89	12.04	12.001	12.156	11.846
40	11.96	90	12	12.001	12.156	11.846
41	11.92	91	11.98	12.001	12.156	11.846
42	11.92	92	11.98	12.001	12.156	11.846
43	11.92	93	11.98	12.001	12.156	11.846
44	11.92	94	12.07	12.001	12.156	11.846
45	12.08	95	12.06	12.001	12.156	11.846
46	12.09	96	11.94	12.001	12.156	11.846
47	12.01	97	11.92	12.001	12.156	11.846
48	11.98	98	11.96	12.001	12.156	11.846
49	12.09	99	12.05	12.001	12.156	11.846
50	11.92	100	12.04	12.001	12.156	11.846

Sumber: Pengolahan Data, 2008



**Lampiran 5.4**  
**Peta MR Diameter Bagian Kepala Mesin Bubut 2**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1	0.000	51	0.020	0.058	0.190	0
2	0.020	52	0.190	0.058	0.190	0
3	0.050	53	0.000	0.058	0.190	0
4	0.040	54	0.060	0.058	0.190	0
5	0.020	55	0.010	0.058	0.190	0
6	0.030	56	0.080	0.058	0.190	0
7	0.140	57	0.030	0.058	0.190	0
8	0.150	58	0.050	0.058	0.190	0
9	0.030	59	0.010	0.058	0.190	0
10	0.090	60	0.110	0.058	0.190	0
11	0.080	61	0.050	0.058	0.190	0
12	0.050	62	0.010	0.058	0.190	0
13	0.050	63	0.030	0.058	0.190	0
14	0.070	64	0.010	0.058	0.190	0
15	0.140	65	0.070	0.058	0.190	0
16	0.040	66	0.050	0.058	0.190	0
17	0.080	67	0.030	0.058	0.190	0
18	0.040	68	0.070	0.058	0.190	0
19	0.080	69	0.130	0.058	0.190	0
20	0.120	70	0.150	0.058	0.190	0
21	0.180	71	0.050	0.058	0.190	0
22	0.170	72	0.070	0.058	0.190	0
23	0.040	73	0.120	0.058	0.190	0
24	0.030	74	0.000	0.058	0.190	0
25	0.110	75	0.010	0.058	0.190	0
26	0.000	76	0.030	0.058	0.190	0
27	0.030	77	0.010	0.058	0.190	0
28	0.080	78	0.030	0.058	0.190	0
29	0.140	79	0.080	0.058	0.190	0
30	0.060	80	0.020	0.058	0.190	0
31	0.010	81	0.070	0.058	0.190	0
32	0.050	82	0.030	0.058	0.190	0
33	0.030	83	0.070	0.058	0.190	0
34	0.030	84	0.040	0.058	0.190	0
35	0.040	85	0.030	0.058	0.190	0
36	0.120	86	0.020	0.058	0.190	0
37	0.090	87	0.040	0.058	0.190	0
38	0.030	88	0.040	0.058	0.190	0
39	0.100	89	0.020	0.058	0.190	0
40	0.120	90	0.040	0.058	0.190	0
41	0.040	91	0.020	0.058	0.190	0
42	0.000	92	0.000	0.058	0.190	0
43	0.000	93	0.000	0.058	0.190	0
44	0.000	94	0.090	0.058	0.190	0
45	0.160	95	0.010	0.058	0.190	0
46	0.010	96	0.120	0.058	0.190	0
47	0.080	97	0.020	0.058	0.190	0
48	0.030	98	0.040	0.058	0.190	0
49	0.110	99	0.090	0.058	0.190	0
50	0.170	100	0.010	0.058	0.190	0

Sumber: Pengolahan Data, 2008

No Data	Data	No Data	Data	Peta X		
				CL(x)	BKA(x)	BKB(x)
1	15.090	51	14.900	15.0063	15.1669	14.8456
2	14.990	52	15.050	15.0063	15.1669	14.8456
3	14.900	53	15.090	15.0063	15.1669	14.8456
4	14.900	54	15.000	15.0063	15.1669	14.8456
5	15.090	55	15.080	15.0063	15.1669	14.8456
6	15.030	56	15.060	15.0063	15.1669	14.8456
7	15.010	57	15.090	15.0063	15.1669	14.8456
8	15.000	58	14.910	15.0063	15.1669	14.8456
9	15.020	59	15.080	15.0063	15.1669	14.8456
10	14.920	60	14.980	15.0063	15.1669	14.8456
11	14.920	61	15.060	15.0063	15.1669	14.8456
12	15.070	62	15.080	15.0063	15.1669	14.8456
13	15.020	63	15.090	15.0063	15.1669	14.8456
14	15.010	64	15.080	15.0063	15.1669	14.8456
15	15.010	65	14.990	15.0063	15.1669	14.8456
16	14.980	66	14.920	15.0063	15.1669	14.8456
17	15.010	67	14.920	15.0063	15.1669	14.8456
18	15.060	68	14.930	15.0063	15.1669	14.8456
19	14.950	69	14.970	15.0063	15.1669	14.8456
20	15.030	70	14.980	15.0063	15.1669	14.8456
21	15.080	71	15.090	15.0063	15.1669	14.8456
22	15.090	72	14.900	15.0063	15.1669	14.8456
23	15.010	73	14.940	15.0063	15.1669	14.8456
24	15.020	74	14.980	15.0063	15.1669	14.8456
25	14.960	75	14.980	15.0063	15.1669	14.8456
26	15.060	76	14.920	15.0063	15.1669	14.8456
27	15.020	77	15.020	15.0063	15.1669	14.8456
28	15.060	78	15.010	15.0063	15.1669	14.8456
29	15.090	79	14.980	15.0063	15.1669	14.8456
30	14.980	80	15.020	15.0063	15.1669	14.8456
31	15.030	81	15.060	15.0063	15.1669	14.8456
32	15.090	82	14.960	15.0063	15.1669	14.8456
33	15.050	83	14.950	15.0063	15.1669	14.8456
34	15.090	84	15.050	15.0063	15.1669	14.8456
35	15.040	85	14.980	15.0063	15.1669	14.8456
36	15.080	86	14.910	15.0063	15.1669	14.8456
37	15.080	87	14.920	15.0063	15.1669	14.8456
38	14.920	88	14.970	15.0063	15.1669	14.8456
39	15.020	89	15.020	15.0063	15.1669	14.8456
40	14.980	90	15.030	15.0063	15.1669	14.8456
41	15.090	91	15.020	15.0063	15.1669	14.8456
42	14.950	92	14.980	15.0063	15.1669	14.8456
43	14.950	93	14.990	15.0063	15.1669	14.8456
44	14.920	94	14.920	15.0063	15.1669	14.8456
45	14.920	95	15.080	15.0063	15.1669	14.8456
46	15.010	96	15.020	15.0063	15.1669	14.8456
47	15.030	97	14.930	15.0063	15.1669	14.8456
48	15.010	98	15.030	15.0063	15.1669	14.8456
49	14.980	99	15.090	15.0063	15.1669	14.8456
50	15.090	100	14.990	15.0063	15.1669	14.8456

Sumber: Pengolahan Data, 2008

**Lampiran 5.5**  
**Peta X Diameter Bagian Tengah Mesin Bubut 1**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1		51	0.19	0.0604	0.1973	0.0000
2	0.1	52	0.15	0.0604	0.1973	0.0000
3	0.09	53	0.04	0.0604	0.1973	0.0000
4	0	54	0.09	0.0604	0.1973	0.0000
5	0.19	55	0.08	0.0604	0.1973	0.0000
6	0.06	56	0.02	0.0604	0.1973	0.0000
7	0.02	57	0.03	0.0604	0.1973	0.0000
8	0.01	58	0.18	0.0604	0.1973	0.0000
9	0.02	59	0.17	0.0604	0.1973	0.0000
10	0.1	60	0.1	0.0604	0.1973	0.0000
11	0	61	0.08	0.0604	0.1973	0.0000
12	0.15	62	0.02	0.0604	0.1973	0.0000
13	0.05	63	0.01	0.0604	0.1973	0.0000
14	0.01	64	0.01	0.0604	0.1973	0.0000
15	0	65	0.09	0.0604	0.1973	0.0000
16	0.03	66	0.07	0.0604	0.1973	0.0000
17	0.03	67	0	0.0604	0.1973	0.0000
18	0.05	68	0.01	0.0604	0.1973	0.0000
19	0.11	69	0.04	0.0604	0.1973	0.0000
20	0.08	70	0.01	0.0604	0.1973	0.0000
21	0.05	71	0.11	0.0604	0.1973	0.0000
22	0.01	72	0.19	0.0604	0.1973	0.0000
23	0.08	73	0.04	0.0604	0.1973	0.0000
24	0.01	74	0.04	0.0604	0.1973	0.0000
25	0.06	75	0	0.0604	0.1973	0.0000
26	0.1	76	0.06	0.0604	0.1973	0.0000
27	0.04	77	0.1	0.0604	0.1973	0.0000
28	0.04	78	0.01	0.0604	0.1973	0.0000
29	0.03	79	0.03	0.0604	0.1973	0.0000
30	0.11	80	0.04	0.0604	0.1973	0.0000
31	0.05	81	0.04	0.0604	0.1973	0.0000
32	0.06	82	0.1	0.0604	0.1973	0.0000
33	0.04	83	0.01	0.0604	0.1973	0.0000
34	0.04	84	0.1	0.0604	0.1973	0.0000
35	0.05	85	0.07	0.0604	0.1973	0.0000
36	0.04	86	0.07	0.0604	0.1973	0.0000
37	0	87	0.01	0.0604	0.1973	0.0000
38	0.16	88	0.05	0.0604	0.1973	0.0000
39	0.1	89	0.05	0.0604	0.1973	0.0000
40	0.04	90	0.01	0.0604	0.1973	0.0000
41	0.11	91	0.01	0.0604	0.1973	0.0000
42	0.14	92	0.04	0.0604	0.1973	0.0000
43	0	93	0.01	0.0604	0.1973	0.0000
44	0.03	94	0.07	0.0604	0.1973	0.0000
45	0	95	0.16	0.0604	0.1973	0.0000
46	0.09	96	0.06	0.0604	0.1973	0.0000
47	0.02	97	0.09	0.0604	0.1973	0.0000
48	0.02	98	0.1	0.0604	0.1973	0.0000
49	0.03	99	0.06	0.0604	0.1973	0.0000
50	0.11	100	0.1	0.0604	0.1973	0.0000

Sumber: Pengolahan Data, 2008

**Lampiran 5.6**  
**Peta MR Diameter Bagian Tengah Mesin Bubut 1**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1		51	0.19	0.0604	0.1973	0.0000
2	0.1	52	0.15	0.0604	0.1973	0.0000
3	0.09	53	0.04	0.0604	0.1973	0.0000
4	0	54	0.09	0.0604	0.1973	0.0000
5	0.19	55	0.08	0.0604	0.1973	0.0000
6	0.06	56	0.02	0.0604	0.1973	0.0000
7	0.02	57	0.03	0.0604	0.1973	0.0000
8	0.01	58	0.18	0.0604	0.1973	0.0000
9	0.02	59	0.17	0.0604	0.1973	0.0000
10	0.1	60	0.1	0.0604	0.1973	0.0000
11	0	61	0.08	0.0604	0.1973	0.0000
12	0.15	62	0.02	0.0604	0.1973	0.0000
13	0.05	63	0.01	0.0604	0.1973	0.0000
14	0.01	64	0.01	0.0604	0.1973	0.0000
15	0	65	0.09	0.0604	0.1973	0.0000
16	0.03	66	0.07	0.0604	0.1973	0.0000
17	0.03	67	0	0.0604	0.1973	0.0000
18	0.05	68	0.01	0.0604	0.1973	0.0000
19	0.11	69	0.04	0.0604	0.1973	0.0000
20	0.08	70	0.01	0.0604	0.1973	0.0000
21	0.05	71	0.11	0.0604	0.1973	0.0000
22	0.01	72	0.19	0.0604	0.1973	0.0000
23	0.08	73	0.04	0.0604	0.1973	0.0000
24	0.01	74	0.04	0.0604	0.1973	0.0000
25	0.06	75	0	0.0604	0.1973	0.0000
26	0.1	76	0.06	0.0604	0.1973	0.0000
27	0.04	77	0.1	0.0604	0.1973	0.0000
28	0.04	78	0.01	0.0604	0.1973	0.0000
29	0.03	79	0.03	0.0604	0.1973	0.0000
30	0.11	80	0.04	0.0604	0.1973	0.0000
31	0.05	81	0.04	0.0604	0.1973	0.0000
32	0.06	82	0.1	0.0604	0.1973	0.0000
33	0.04	83	0.01	0.0604	0.1973	0.0000
34	0.04	84	0.1	0.0604	0.1973	0.0000
35	0.05	85	0.07	0.0604	0.1973	0.0000
36	0.04	86	0.07	0.0604	0.1973	0.0000
37	0	87	0.01	0.0604	0.1973	0.0000
38	0.16	88	0.05	0.0604	0.1973	0.0000
39	0.1	89	0.05	0.0604	0.1973	0.0000
40	0.04	90	0.01	0.0604	0.1973	0.0000
41	0.11	91	0.01	0.0604	0.1973	0.0000
42	0.14	92	0.04	0.0604	0.1973	0.0000
43	0	93	0.01	0.0604	0.1973	0.0000
44	0.03	94	0.07	0.0604	0.1973	0.0000
45	0	95	0.16	0.0604	0.1973	0.0000
46	0.09	96	0.06	0.0604	0.1973	0.0000
47	0.02	97	0.09	0.0604	0.1973	0.0000
48	0.02	98	0.1	0.0604	0.1973	0.0000
49	0.03	99	0.06	0.0604	0.1973	0.0000
50	0.11	100	0.1	0.0604	0.1973	0.0000

Sumber: Pengolahan Data,2008

**Lampiran 5.7**  
**Peta X Diameter Bagian Tengah Mesin Bubut 2**

No Data	Data	No Data	Data	Peta X		
				CL(x)	BKA(x)	BKB(x)
1	15.04	51	15	14.996	15.143	14.850
2	15.01	52	14.92	14.996	15.143	14.850
3	14.97	53	14.98	14.996	15.143	14.850
4	15.01	54	14.98	14.996	15.143	14.850
5	14.98	55	14.9	14.996	15.143	14.850
6	15.09	56	14.93	14.996	15.143	14.850
7	15.04	57	15.04	14.996	15.143	14.850
8	15.03	58	14.96	14.996	15.143	14.850
9	15.03	59	14.92	14.996	15.143	14.850
10	14.9	60	15.08	14.996	15.143	14.850
11	15.01	61	15.03	14.996	15.143	14.850
12	15.09	62	15.06	14.996	15.143	14.850
13	15.03	63	15.01	14.996	15.143	14.850
14	15.03	64	15.09	14.996	15.143	14.850
15	15.02	65	14.98	14.996	15.143	14.850
16	14.96	66	15.03	14.996	15.143	14.850
17	15.04	67	15.02	14.996	15.143	14.850
18	15.04	68	14.92	14.996	15.143	14.850
19	15	69	14.93	14.996	15.143	14.850
20	14.92	70	14.99	14.996	15.143	14.850
21	14.9	71	15.06	14.996	15.143	14.850
22	14.95	72	14.97	14.996	15.143	14.850
23	15	73	14.92	14.996	15.143	14.850
24	15.02	74	14.91	14.996	15.143	14.850
25	14.99	75	14.92	14.996	15.143	14.850
26	15.03	76	14.99	14.996	15.143	14.850
27	15.09	77	14.92	14.996	15.143	14.850
28	15.09	78	15	14.996	15.143	14.850
29	15.03	79	14.99	14.996	15.143	14.850
30	15.03	80	15.04	14.996	15.143	14.850
31	15.05	81	15.1	14.996	15.143	14.850
32	15.01	82	15.02	14.996	15.143	14.850
33	15.05	83	14.92	14.996	15.143	14.850
34	15.02	84	15.06	14.996	15.143	14.850
35	15.06	85	14.9	14.996	15.143	14.850
36	15.04	86	14.92	14.996	15.143	14.850
37	14.92	87	14.98	14.996	15.143	14.850
38	14.92	88	15.09	14.996	15.143	14.850
39	15.04	89	15.02	14.996	15.143	14.850
40	15.06	90	15.02	14.996	15.143	14.850
41	15.02	91	15.03	14.996	15.143	14.850
42	15	92	14.96	14.996	15.143	14.850
43	15.03	93	14.92	14.996	15.143	14.850
44	15	94	14.98	14.996	15.143	14.850
45	14.92	95	15.02	14.996	15.143	14.850
46	14.99	96	15.06	14.996	15.143	14.850
47	14.9	97	14.96	14.996	15.143	14.850
48	14.98	98	15.08	14.996	15.143	14.850
49	14.9	99	15.02	14.996	15.143	14.850
50	14.9	100	14.96	14.996	15.143	14.850

Sumber: Pengolahan Data, 2008

**Lampiran 5.8**  
**Peta MR Diameter Bagian Tengah Mesin Bubut 2**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1	0.000	51	0.100	0.055	0.180	0
2	0.030	52	0.080	0.055	0.180	0
3	0.040	53	0.060	0.055	0.180	0
4	0.040	54	0.000	0.055	0.180	0
5	0.030	55	0.080	0.055	0.180	0
6	0.110	56	0.030	0.055	0.180	0
7	0.050	57	0.110	0.055	0.180	0
8	0.010	58	0.080	0.055	0.180	0
9	0.000	59	0.040	0.055	0.180	0
10	0.130	60	0.160	0.055	0.180	0
11	0.110	61	0.050	0.055	0.180	0
12	0.080	62	0.030	0.055	0.180	0
13	0.060	63	0.050	0.055	0.180	0
14	0.000	64	0.080	0.055	0.180	0
15	0.010	65	0.110	0.055	0.180	0
16	0.060	66	0.050	0.055	0.180	0
17	0.080	67	0.010	0.055	0.180	0
18	0.000	68	0.100	0.055	0.180	0
19	0.040	69	0.010	0.055	0.180	0
20	0.080	70	0.060	0.055	0.180	0
21	0.020	71	0.070	0.055	0.180	0
22	0.050	72	0.090	0.055	0.180	0
23	0.050	73	0.050	0.055	0.180	0
24	0.020	74	0.010	0.055	0.180	0
25	0.030	75	0.010	0.055	0.180	0
26	0.040	76	0.070	0.055	0.180	0
27	0.060	77	0.070	0.055	0.180	0
28	0.000	78	0.080	0.055	0.180	0
29	0.060	79	0.010	0.055	0.180	0
30	0.000	80	0.050	0.055	0.180	0
31	0.020	81	0.060	0.055	0.180	0
32	0.040	82	0.080	0.055	0.180	0
33	0.040	83	0.100	0.055	0.180	0
34	0.030	84	0.140	0.055	0.180	0
35	0.040	85	0.160	0.055	0.180	0
36	0.020	86	0.020	0.055	0.180	0
37	0.120	87	0.060	0.055	0.180	0
38	0.000	88	0.110	0.055	0.180	0
39	0.120	89	0.070	0.055	0.180	0
40	0.020	90	0.000	0.055	0.180	0
41	0.040	91	0.010	0.055	0.180	0
42	0.020	92	0.070	0.055	0.180	0
43	0.030	93	0.040	0.055	0.180	0
44	0.030	94	0.060	0.055	0.180	0
45	0.080	95	0.040	0.055	0.180	0
46	0.070	96	0.040	0.055	0.180	0
47	0.090	97	0.100	0.055	0.180	0
48	0.080	98	0.120	0.055	0.180	0
49	0.080	99	0.060	0.055	0.180	0
50	0.000	100	0.060	0.055	0.180	0

Sumber: Pengolahan Data, 2008

**Lampiran 5.9**  
**Peta X Diameter Bagian Belakang Mesin Bubut 1**

No Data	Data	No Data	Data	Peta X		
				CL(x)	BKA(x)	BKB(x)
1	9.79	51	9.79	9.817	9.975	9.659
2	9.89	52	9.85	9.817	9.975	9.659
3	9.9	53	9.72	9.817	9.975	9.659
4	9.76	54	9.83	9.817	9.975	9.659
5	9.78	55	9.86	9.817	9.975	9.659
6	9.89	56	9.78	9.817	9.975	9.659
7	9.78	57	9.9	9.817	9.975	9.659
8	9.86	58	9.84	9.817	9.975	9.659
9	9.78	59	9.76	9.817	9.975	9.659
10	9.88	60	9.78	9.817	9.975	9.659
11	9.81	61	9.75	9.817	9.975	9.659
12	9.76	62	9.76	9.817	9.975	9.659
13	9.79	63	9.87	9.817	9.975	9.659
14	9.86	64	9.83	9.817	9.975	9.659
15	9.87	65	9.88	9.817	9.975	9.659
16	9.77	66	9.83	9.817	9.975	9.659
17	9.78	67	9.86	9.817	9.975	9.659
18	9.82	68	9.82	9.817	9.975	9.659
19	9.81	69	9.87	9.817	9.975	9.659
20	9.82	70	9.82	9.817	9.975	9.659
21	9.73	71	9.86	9.817	9.975	9.659
22	9.86	72	9.77	9.817	9.975	9.659
23	9.76	73	9.8	9.817	9.975	9.659
24	9.89	74	9.9	9.817	9.975	9.659
25	9.86	75	9.76	9.817	9.975	9.659
26	9.78	76	9.83	9.817	9.975	9.659
27	9.78	77	9.74	9.817	9.975	9.659
28	9.78	78	9.78	9.817	9.975	9.659
29	9.72	79	9.82	9.817	9.975	9.659
30	9.81	80	9.74	9.817	9.975	9.659
31	9.86	81	9.76	9.817	9.975	9.659
32	9.76	82	9.77	9.817	9.975	9.659
33	9.76	83	9.86	9.817	9.975	9.659
34	9.87	84	9.75	9.817	9.975	9.659
35	9.85	85	9.8	9.817	9.975	9.659
36	9.82	86	9.88	9.817	9.975	9.659
37	9.83	87	9.82	9.817	9.975	9.659
38	9.9	88	9.85	9.817	9.975	9.659
39	9.88	89	9.86	9.817	9.975	9.659
40	9.76	90	9.83	9.817	9.975	9.659
41	9.9	91	9.86	9.817	9.975	9.659
42	9.82	92	9.82	9.817	9.975	9.659
43	9.86	93	9.84	9.817	9.975	9.659
44	9.82	94	9.87	9.817	9.975	9.659
45	9.76	95	9.79	9.817	9.975	9.659
46	9.88	96	9.82	9.817	9.975	9.659
47	9.8	97	9.88	9.817	9.975	9.659
48	9.78	98	9.74	9.817	9.975	9.659
49	9.82	99	9.74	9.817	9.975	9.659
50	9.81	100	9.8	9.817	9.975	9.659

Sumber: Pengolahan Data, 2008

**Lampiran 5.10**  
**Peta MR Diameter Bagian Belakang Mesin Bubut 1**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1	0.000	51	0.020	0.059	0.194	0
2	0.100	52	0.060	0.059	0.194	0
3	0.010	53	0.130	0.059	0.194	0
4	0.140	54	0.110	0.059	0.194	0
5	0.020	55	0.030	0.059	0.194	0
6	0.110	56	0.080	0.059	0.194	0
7	0.110	57	0.120	0.059	0.194	0
8	0.080	58	0.060	0.059	0.194	0
9	0.080	59	0.080	0.059	0.194	0
10	0.100	60	0.020	0.059	0.194	0
11	0.070	61	0.030	0.059	0.194	0
12	0.050	62	0.010	0.059	0.194	0
13	0.030	63	0.110	0.059	0.194	0
14	0.070	64	0.040	0.059	0.194	0
15	0.010	65	0.050	0.059	0.194	0
16	0.100	66	0.050	0.059	0.194	0
17	0.010	67	0.030	0.059	0.194	0
18	0.040	68	0.040	0.059	0.194	0
19	0.010	69	0.050	0.059	0.194	0
20	0.010	70	0.050	0.059	0.194	0
21	0.090	71	0.040	0.059	0.194	0
22	0.130	72	0.090	0.059	0.194	0
23	0.100	73	0.030	0.059	0.194	0
24	0.130	74	0.100	0.059	0.194	0
25	0.030	75	0.140	0.059	0.194	0
26	0.080	76	0.070	0.059	0.194	0
27	0.000	77	0.090	0.059	0.194	0
28	0.000	78	0.040	0.059	0.194	0
29	0.060	79	0.040	0.059	0.194	0
30	0.090	80	0.080	0.059	0.194	0
31	0.050	81	0.020	0.059	0.194	0
32	0.100	82	0.010	0.059	0.194	0
33	0.000	83	0.090	0.059	0.194	0
34	0.110	84	0.110	0.059	0.194	0
35	0.020	85	0.050	0.059	0.194	0
36	0.030	86	0.080	0.059	0.194	0
37	0.010	87	0.060	0.059	0.194	0
38	0.070	88	0.030	0.059	0.194	0
39	0.020	89	0.010	0.059	0.194	0
40	0.120	90	0.030	0.059	0.194	0
41	0.140	91	0.030	0.059	0.194	0
42	0.080	92	0.040	0.059	0.194	0
43	0.040	93	0.020	0.059	0.194	0
44	0.040	94	0.030	0.059	0.194	0
45	0.060	95	0.080	0.059	0.194	0
46	0.120	96	0.030	0.059	0.194	0
47	0.080	97	0.060	0.059	0.194	0
48	0.020	98	0.140	0.059	0.194	0
49	0.040	99	0.000	0.059	0.194	0
50	0.010	100	0.060	0.059	0.194	0

Sumber: Pengolahan Data, 2008



**Lampiran 5.11**  
**Peta X Diameter Bagian Belakang Mesin Bubut 2**

No Data	Data	No Data	Data	Peta X		
				CL(x)	BKA(x)	BKB(x)
1	9.77	51	9.8	9.818	9.966	9.670
2	9.8	52	9.88	9.818	9.966	9.670
3	9.87	53	9.81	9.818	9.966	9.670
4	9.78	54	9.76	9.818	9.966	9.670
5	9.76	55	9.78	9.818	9.966	9.670
6	9.86	56	9.81	9.818	9.966	9.670
7	9.77	57	9.72	9.818	9.966	9.670
8	9.72	58	9.72	9.818	9.966	9.670
9	9.86	59	9.76	9.818	9.966	9.670
10	9.81	60	9.87	9.818	9.966	9.670
11	9.82	61	9.82	9.818	9.966	9.670
12	9.79	62	9.86	9.818	9.966	9.670
13	9.86	63	9.82	9.818	9.966	9.670
14	9.72	64	9.81	9.818	9.966	9.670
15	9.83	65	9.78	9.818	9.966	9.670
16	9.88	66	9.84	9.818	9.966	9.670
17	9.72	67	9.8	9.818	9.966	9.670
18	9.89	68	9.86	9.818	9.966	9.670
19	9.83	69	9.88	9.818	9.966	9.670
20	9.8	70	9.76	9.818	9.966	9.670
21	9.88	71	9.86	9.818	9.966	9.670
22	9.84	72	9.81	9.818	9.966	9.670
23	9.88	73	9.85	9.818	9.966	9.670
24	9.87	74	9.9	9.818	9.966	9.670
25	9.78	75	9.82	9.818	9.966	9.670
26	9.79	76	9.72	9.818	9.966	9.670
27	9.72	77	9.81	9.818	9.966	9.670
28	9.75	78	9.81	9.818	9.966	9.670
29	9.82	79	9.89	9.818	9.966	9.670
30	9.82	80	9.82	9.818	9.966	9.670
31	9.78	81	9.8	9.818	9.966	9.670
32	9.8	82	9.86	9.818	9.966	9.670
33	9.76	83	9.86	9.818	9.966	9.670
34	9.81	84	9.88	9.818	9.966	9.670
35	9.86	85	9.89	9.818	9.966	9.670
36	9.72	86	9.82	9.818	9.966	9.670
37	9.81	87	9.85	9.818	9.966	9.670
38	9.81	88	9.86	9.818	9.966	9.670
39	9.86	89	9.78	9.818	9.966	9.670
40	9.81	90	9.81	9.818	9.966	9.670
41	9.78	91	9.8	9.818	9.966	9.670
42	9.78	92	9.8	9.818	9.966	9.670
43	9.88	93	9.86	9.818	9.966	9.670
44	9.82	94	9.88	9.818	9.966	9.670
45	9.86	95	9.78	9.818	9.966	9.670
46	9.81	96	9.88	9.818	9.966	9.670
47	9.88	97	9.74	9.818	9.966	9.670
48	9.9	98	9.83	9.818	9.966	9.670
49	9.78	99	9.86	9.818	9.966	9.670
50	9.82	100	9.85	9.818	9.966	9.670

Sumber: Pengolahan Data,2008

**Lampiran 5.12**  
**Peta MR Diameter Bagian Belakang Mesin Bubut 2**

No Data	MR	No Data	MR	Peta MR		
				CL(MR)	BKA(MR)	BKB(MR)
1	0.000	51	0.020	0.056	0.182	0
2	0.030	52	0.080	0.056	0.182	0
3	0.070	53	0.070	0.056	0.182	0
4	0.090	54	0.050	0.056	0.182	0
5	0.020	55	0.020	0.056	0.182	0
6	0.100	56	0.030	0.056	0.182	0
7	0.090	57	0.090	0.056	0.182	0
8	0.050	58	0.000	0.056	0.182	0
9	0.140	59	0.040	0.056	0.182	0
10	0.050	60	0.110	0.056	0.182	0
11	0.010	61	0.050	0.056	0.182	0
12	0.030	62	0.040	0.056	0.182	0
13	0.070	63	0.040	0.056	0.182	0
14	0.140	64	0.010	0.056	0.182	0
15	0.110	65	0.030	0.056	0.182	0
16	0.050	66	0.060	0.056	0.182	0
17	0.160	67	0.040	0.056	0.182	0
18	0.170	68	0.060	0.056	0.182	0
19	0.060	69	0.020	0.056	0.182	0
20	0.030	70	0.120	0.056	0.182	0
21	0.080	71	0.100	0.056	0.182	0
22	0.040	72	0.050	0.056	0.182	0
23	0.040	73	0.040	0.056	0.182	0
24	0.010	74	0.050	0.056	0.182	0
25	0.090	75	0.080	0.056	0.182	0
26	0.010	76	0.100	0.056	0.182	0
27	0.070	77	0.090	0.056	0.182	0
28	0.030	78	0.000	0.056	0.182	0
29	0.070	79	0.080	0.056	0.182	0
30	0.000	80	0.070	0.056	0.182	0
31	0.040	81	0.020	0.056	0.182	0
32	0.020	82	0.060	0.056	0.182	0
33	0.040	83	0.000	0.056	0.182	0
34	0.050	84	0.020	0.056	0.182	0
35	0.050	85	0.010	0.056	0.182	0
36	0.140	86	0.070	0.056	0.182	0
37	0.090	87	0.030	0.056	0.182	0
38	0.000	88	0.010	0.056	0.182	0
39	0.050	89	0.080	0.056	0.182	0
40	0.050	90	0.030	0.056	0.182	0
41	0.030	91	0.010	0.056	0.182	0
42	0.000	92	0.000	0.056	0.182	0
43	0.100	93	0.060	0.056	0.182	0
44	0.060	94	0.020	0.056	0.182	0
45	0.040	95	0.100	0.056	0.182	0
46	0.050	96	0.100	0.056	0.182	0
47	0.070	97	0.140	0.056	0.182	0
48	0.020	98	0.090	0.056	0.182	0
49	0.120	99	0.030	0.056	0.182	0
50	0.040	100	0.010	0.056	0.182	0

Sumber: Pengolahan Data, 2008

**LAMPIRAN 6**  
**DATA MENTAH HASIL INSPEKSI QC**

**Lampiran 6.1**  
**Data Mentah Hasil Inspeksi QC**

Tanggal Inspeksi	Sub Group	Jumlah Diperiksa	Jumlah Produk Cacat Lubang Spi Retak	Jumlah Produk Cacat Retak permukaan	Jumlah Produk Cacat Tidak Presisi	Jumlah Produk Cacat Melengkung	Jumlah Produk Cacat Drat	Jumlah Produk Cacat Buram
4-Jun-08	1	54	4	3	1	1	0	0
7-Jun-08	2	60	2	2	3	0	0	1
11-Jun-08	3	55	3	2	1	1	1	0
14-Jun-08	4	54	2	2	2	0	2	0
18-Jun-08	5	56	1	1	1	2	1	0
21-Jun-08	6	55	2	3	2	0	2	1
25-Jun-08	7	63	5	3	1	1	1	2
28-Jun-08	8	61	3	3	2	0	1	0
2-Jul-08	9	58	3	2	1	2	1	1
5-Jul-08	10	61	4	2	0	1	0	1
9-Jul-08	11	66	1	1	0	0	0	1
12-Jul-08	12	54	2	2	1	2	1	0
16-Jul-08	13	58	1	2	0	1	0	2
19-Jul-08	14	62	2	1	1	1	0	0
23-Jul-08	15	59	4	3	2	0	0	2
26-Jul-08	16	55	1	1	1	1	0	1
29-Jul-08	17	56	2	3	0	0	2	0
2-Aug-08	18	60	4	3	1	1		0
6-Aug-08	19	63	2	2	1	1	1	1
9-Aug-08	20	65	2	3	1	0	1	0
13-Aug-08	21	63	3	2	0	2	2	1
16-Aug-08	22	58	3	4	1	0	1	1
20-Aug-08	23	55	3	3	0	1	0	0
23-Aug-08	24	52	4	4	1	0	1	0
27-Aug-08	25	59	2	4	0	1	0	1
30-Aug-08	26	63	2	3	0	1	0	0
3-Sep-08	27	58	1	2	1	1	1	1
6-Sep-08	28	62	3	3	0	0	1	0
10-Sep-08	29	64	2	3	1	1	0	0
13-Sep-08	30	59	2	1	1	0	1	0
17-Sep-08	31	65	5	2	1	0	0	0
20-Sep-08	32	58	3	2	0	1	1	0
22-Oct-08	33	58	2	6	1	1	0	0
25-Oct-08	34	60	5	5	0	0	1	1
29-Oct-08	35	65	2	3	1	0	1	0
1-Nov-08	36	59	2	3	0	2	0	0
5-Nov-08	37	63	3	4	0	0	1	1
8-Nov-08	38	62	1	1	0	1	0	0
12-Nov-08	39	56	2	3	0	1	0	0
15-Nov-08	40	57	5	3	0	0	1	1
Total		2371	105	105	30	28	26	20

Sumber: Survei Data Sekunder Juni – Oktober 2008