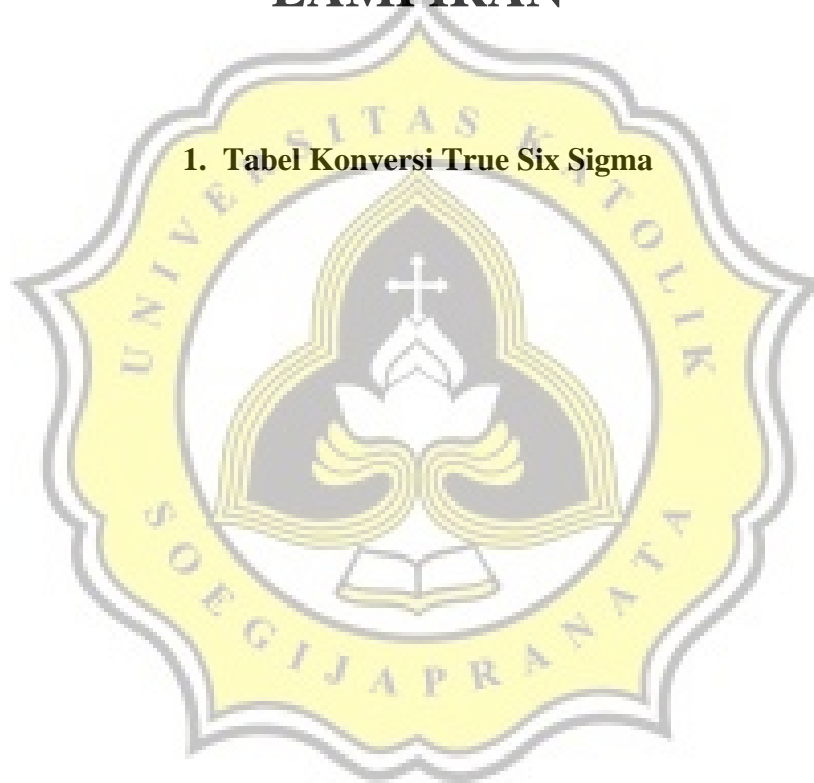
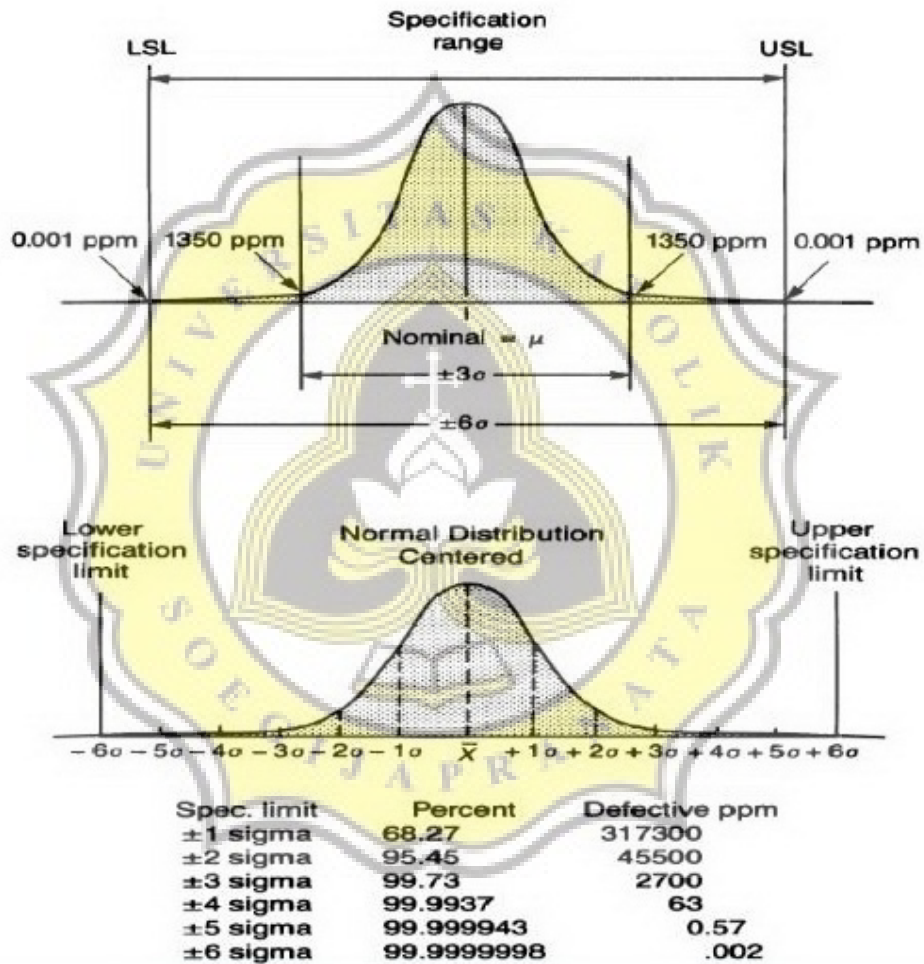


# LAMPIRAN

## 1. Tabel Konversi True Six Sigma



Tabel Konversi Indeks Kapabilitas Proses (Cpk) dan Hasil Bebas Cacat (FPY) ke Nilai DPMO atau DPM dan Nilai Sigma Berdasarkan True-6-Sigma Process (Normal Distribution Centered)  
 Disusun Oleh: Vincent Gaspersz  
 Lean Six Sigma Master Black Belt



Cpk	Hasil Bebas Cacat (%)	DPMO atau DPM	Nilai Sigma
0.00	0.00%	1000.000	0.00
0.02	3.99%	960.122	0.05
0.03	7.97%	920.344	0.10
0.05	11.92%	880.765	0.15
0.07	15.85%	841.481	0.20
0.08	19.74%	802.587	0.25
0.10	23.58%	764.177	0.30
0.12	27.37%	726.339	0.35
0.13	31.08%	689.157	0.40
0.15	34.73%	652.710	0.45
0.17	38.29%	617.075	0.50
0.18	41.77%	582.319	0.55
0.20	45.16%	548.506	0.60
0.22	48.43%	515.692	0.65
0.23	51.61%	483.927	0.70
0.25	54.67%	453.255	0.75
0.27	57.63%	423.711	0.80
0.28	60.47%	395.325	0.85
0.30	63.19%	368.120	0.90
0.32	65.79%	342.112	0.95
0.33	68.27%	317.311	1.00
0.35	70.63%	293.718	1.05
0.37	72.87%	271.332	1.10
0.38	74.99%	250.144	1.15
0.40	76.99%	230.139	1.20
0.42	78.87%	211.300	1.25
0.43	80.64%	193.601	1.30
0.45	82.30%	177.016	1.35
0.47	83.85%	161.513	1.40
0.48	85.29%	147.059	1.45
0.50	86.64%	133.614	1.50
0.52	87.89%	121.142	1.55
0.53	89.04%	109.599	1.60
0.55	90.11%	98.943	1.65
0.57	91.09%	89.131	1.70
0.58	91.99%	80.118	1.75
0.60	92.81%	71.861	1.80
0.62	93.57%	64.314	1.85
0.63	94.26%	57.433	1.90
0.65	94.88%	51.176	1.95
0.67	95.45%	45.500	2.00
0.68	95.96%	40.364	2.05
0.70	96.43%	35.729	2.10
0.72	96.84%	31.555	2.15
0.73	97.22%	27.807	2.20
0.75	97.56%	24.449	2.25

0.77	97.86%	21448	2.30
0.78	98.12%	18.773	2.35
0.80	98.36%	16.395	2.40
0.82	98.57%	14.286	2.45
0.83	98.76%	12.419	2.50
0.85	98.92%	10.772	2.55
0.87	99.07%	9.322	2.60
0.88	99.20%	8.049	2.65
0.90	99.32%	6.934	2.70
0.92	99.40%	5.960	2.75
0.93	99.49%	5.110	2.80
0.95	99.56%	4.372	2.85
0.97	99.63%	3.732	2.90
0.98	99.68%	3.178	2.95
1.00	99.73%	2.700	3.00
1.02	99.77%	2.288	3.05
1.03	99.81%	1.935	3.10
1.05	99.84%	1.633	3.15
1.07	99.86%	1.374	3.20
1.08	99.88%	1.154	3.25
1.10	99.90%	967	3.30
1.12	99.91988%	808	3.35
1.13	99.93264%	674	3.40
1.15	99.94394%	561	3.45
1.17	99.95347%	465	3.50
1.18	99.96147%	385	3.55
1.20	99.96847%	318	3.60
1.22	99.97376%	262	3.65
1.23	99.97844%	216	3.70
1.25	99.98231%	177	3.75
1.27	99.98553%	145	3.80
1.28	99.98818%	118	3.85
1.30	99.99038%	96	3.90
1.32	99.99218%	78	3.95
1.33	99.99366%	63	4.00
1.35	99.99487%	51	4.05
1.37	99.99586%	41	4.10
1.38	99.99667%	33	4.15
1.40	99.99733%	27	4.20
1.42	99.99786%	21	4.25
1.43	99.99829%	17	4.30
1.45	99.99863%	13.61	4.35
1.47	99.99891%	10.83	4.40
1.48	99.99914%	8.59	4.45
1.50	99.9993205%	6.795346	4.50
1.52	99.9994635%	5.364592	4.55
1.53	99.9995775%	4.224909	4.60
1.55	99.9996681%	3.319350	4.65

157	99.9997398%	2.60615	4.70
158	99.9997966%	2.03466	4.75
160	99.9998443%	1.586657	4.80
162	99.9998765%	1.23465	4.85
163	99.9999042%	0.958366	4.90
165	99.9999258%	0.742135	4.95
167	99.9999427%	0.573304	5.00
168	99.9999558%	0.441810	5.05
170	99.9999660%	0.339653	5.10
172	99.9999740%	0.260486	5.15
173	99.9999801%	0.199289	5.20
175	99.9999848%	0.152099	5.25
177	99.9999884%	0.116803	5.30
178	99.9999912%	0.087954	5.35
180	99.9999933%	0.066641	5.40
182	99.9999950%	0.050370	5.45
183	99.9999962%	0.037979	5.50
185	99.9999976%	0.028567	5.55
187	99.9999979%	0.021435	5.60
188	99.9999984%	0.016045	5.65
190	99.9999988%	0.011981	5.70
192	99.9999991%	0.008924	5.75
193	99.9999993%	0.006631	5.80
195	99.9999995%	0.004916	5.85
197	99.9999996%	0.003635	5.90
198	99.9999997%	0.002681	5.95
2.00	99.9999998%	0.001973	6.00

Source: Vincent Gasperz, <http://centerforleansigma.blogspot.com>

DPM = Defects per Million; DPMO = Defects per Million Opportunities; Yield = First-Pass Yield (FPY)—hasil bebas cacat pertama kali.

\*\*\*) Vincent Gasperz, adalah Guru Besar (Professor) dalam bidang Operations and Total Quality Management pada Program Pascasarjana MIM Universitas Trisakti, Jakarta (SK Mendiknas RI No. 38044/A2.III1/KP/2002). Ia memperoleh pendidikan dalam bidang Magister Sains (S2) Statistika Terapan, IPB, 1985; Doktor Teknik Sistem dan Manajemen Industri, ITB, 1991 (IPK = 4.0), dan Doctor of Science in Management of Engineering and Technology, Southern California University for Professional Studies (GPA = 4.0). Ia memperoleh sertifikat CPIM (1996) dan CFPIM (1998) dari APICS dan telah mempertahankan gelar CFPIM sampai April 2008. Ia adalah Senior Member of the ASQ (American Society for Quality) sejak 1994 dan Member of APICS sejak 1995. Selama 2006, Ia memperoleh empat gelar profesional dari ASQ: Certified Six Sigma Black Belt (CSSBB), Certified Quality Engineer (CQE), Certified Quality Auditor (CQA), dan Certified Manager of Quality/Organizational Excellence (CMQ/OE). Pada Agustus 2005, Ia memperoleh IQF (International Quality Federation) Six Sigma Master Black Belt by Exam—SSMBB. Ia juga terdaftar sebagai RAB (Registration Accreditation Board) Quality System Auditor, USA. Ia pernah bekerja pada Salim Group of Companies