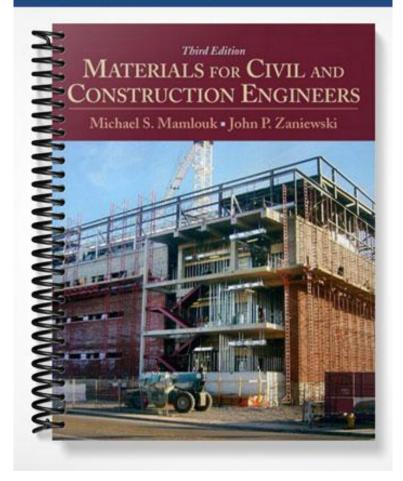
### SOLUTIONS MANUAL



This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

# MATERIALS FOR CIVIL AND CONSTRUCTION ENGINEERS

# 3<sup>rd</sup> Edition

## Michael S. Mamlouk Arizona State University

# John P. Zaniewski West Virginia University

### **Solution Manual**

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

#### FOREWORD

This solution manual includes the solutions to numerical problems at the end of various chapters of the book. It does not include answers to word questions, but the appropriate sections in the book are referenced. The procedures used in the solutions are taken from the corresponding chapters and sections of the text. Each step in the solution is taken to the lowest detail level consistent with the level of the text, with a clear progression between steps. Each problem solution is self-contained, with a minimum of dependence on other solutions. The final answer of each problem is printed in bold.

The instructors are advised not to spread the solutions electronically among students in order not to limit the instructor's choice to assign problems in future semesters.

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

#### **CHAPTER 1. MATERIALS ENGINEERING CONCEPTS**

- **1.2.** Strength at rupture = **45 ksi** Toughness =  $(45 \times 0.003) / 2 = 0.0675$  ksi
- **1.3.** A =  $0.36 \text{ in}^2$ 
  - $\label{eq:sigma_alpha} \begin{array}{l} \sigma \ = \ 138.8889 \ ksi \\ \epsilon_A \ = \ 0.0035 \ in/in \end{array}$
  - $\epsilon_L$  = -0.016667 in/in
  - $\mathbf{E} = 39682 \text{ ksi}$
  - v = 0.21
- 1.4. A = 201.06 mm<sup>2</sup>  $\sigma$  = 0.945 GPa  $\epsilon_A$  = 0.002698 m/m  $\epsilon_L$  = -0.000625 m/m E = 350.3 GPa  $\nu$  = 0.23

**1.5.** 
$$A = \pi d^2/4 = 28.27 \text{ in}^2$$
  
 $\sigma = P / A = -150,000 / 28.27 \text{ in}^2 = -5.31 \text{ ksi}$   
 $E = \sigma / \epsilon = 8000 \text{ ksi}$   
 $\epsilon_A = \sigma / E = -5.31 \text{ ksi} / 8000 \text{ ksi} = -0.0006631 \text{ in/in}$   
 $\Delta L = \epsilon_A L_o = -0006631 \text{ in/in} (12 \text{ in}) = -0.00796 \text{ in}$   
 $L_f = \Delta L + L_o = 12 \text{ in} - 0.00796 \text{ in} = 11.992 \text{ in}$   
 $v = -\epsilon_L / \epsilon_A = 0.35$   
 $\epsilon_L = \Delta d / d_o = -v \epsilon_A = -0.35 (-0.0006631 \text{ in/in}) = 0.000232 \text{ in/in}$   
 $\Delta d = \epsilon_L d_o = 0.000232 (6 \text{ in}) = 0.00139 \text{ in}$   
 $d_f = \Delta d + d_o = 6 \text{ in} + 0.00139 \text{ in} = 6.00139 \text{ in}$ 

**1.6.** 
$$A = \pi d^2/4 = 0.196 in^2$$
  
 $\sigma = P / A = 2,000 / 0.196 in^2 = 10.18 ksi (Less than the yield strength. Within the elastic region)
 $E = \sigma / \epsilon = 10,000 ksi$   
 $\epsilon_A = \sigma / E = 10.18 ksi / 10,000 ksi = 0.0010186 in/in$   
 $\Delta L = \epsilon_A L_o = 0.0010186 in/in (12 in) = 0.0122 in$   
 $L_f = \Delta L + L_o = 12 in + 0.0122 in = 12.0122 in$   
 $v = -\epsilon_L / \epsilon_A = 0.33$   
 $\epsilon_L = \Delta d / d_o = -v \epsilon_A = -0.33 (0.0010186 in/in) = -0.000336 in/in$   
 $\Delta d = \epsilon_L d_o = -0.000336 (0.5 in) = -0.000168 in$   
 $d_f = \Delta d + d_o = 0.5 in - 0.000168 in = 0.49998 in$$ 

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

1.7.  $L_x = 30 \text{ mm}, L_y = 60 \text{ mm}, L_z = 90 \text{ mm}$   $\sigma_x = \sigma_y = \sigma_z = \sigma = 100 \text{ MPa}$  E = 70 GPa v = 0.333  $\varepsilon_x = [\sigma_x - v (\sigma_y + \sigma_z)] / E$   $\varepsilon_x = [100 \times 10^6 - 0.333 (100 \times 10^6 + 100 \times 10^6)] / 70 \times 10^9 = 4.77 \times 10^{-4} = \varepsilon_y = \varepsilon_z = \varepsilon$   $\Delta L_x = \varepsilon \times L_x = 4.77 \times 10^{-4} \times 30 = 0.01431 \text{ mm}$  $\Delta L_y = \varepsilon \times L_y = 4.77 \times 10^{-4} \times 60 = 0.02862 \text{ mm}$ 

- $\Delta L_z = \varepsilon \times L_z = 4.77 \times 10^{-4} \times 90 = 0.04293 \text{ mm}$
- $\Delta V = \text{New volume Original volume} = [(L_x \Delta L_x) (L_y \Delta L_y) (L_z \Delta L_z)] L_x L_y L_z$ = (30 - 0.01431) (60 - 0.02862) (90 - 0.04293)] - (30 x 60 x 90) = 161768 - 162000 = -232 mm<sup>3</sup>
- **1.8.**  $L_x = 4$  in,  $L_y = 4$  in,  $L_z = 4$  in  $\sigma_x = \sigma_y = \sigma_z = \sigma = 15,000$  psi E = 1000 ksi v = 0.49

$$\begin{split} & \epsilon_x = [\sigma_x - \nu \; (\sigma_y + \sigma_z \;) \;] \, / E \\ & \epsilon_x = [15 - 0.49 \; (15 + 15)] \, / \; 1000 = \; 0.0003 = \epsilon_y = \epsilon_z = \epsilon \\ & \Delta L_x = \; \epsilon \; x \; L_x = 0.0003 \; x \; 15 = 0.0045 \; in \\ & \Delta L_y = \; \epsilon \; x \; L_y = 0.0003 \; x \; 15 = 0.0045 \; in \\ & \Delta L_z = \epsilon \; x \; L_z = 0.0003 \; x \; 15 = 0.0045 \; in \\ & \Delta L_z = \epsilon \; x \; L_z = 0.0003 \; x \; 15 = 0.0045 \; in \\ & \Delta V = \text{New volume - Original volume} = [(L_x - \Delta L_x) \; (L_y - \Delta L_y) \; (L_z - \Delta L_z)] - L_x \; L_y \; L_z \\ & = (15 - 0.0045) \; (15 - 0.0045) \; (15 - 0.0045)] - (15 \; x \; 15 \; x \; 15) = 3371.963 - \; 3375 \\ & = -3.037 \; \text{in}^3 \end{split}$$

**1.9.** 
$$\varepsilon = 0.3 \ge 10^{-16} \sigma^3$$
  
At  $\sigma = 50,000 \ \text{psi}$ ,  $\varepsilon = 0.3 \ge 10^{-16} (50,000)^3 = 3.75 \ge 10^{-3} \ \text{in./in.}$   
Secant Modulus  $= \frac{\Delta \sigma}{\Delta \varepsilon} = \frac{50,000}{3.75 \times 10^{-3}} = 1.33 \ge 10^7 \ \text{psi}$   
 $\frac{d\varepsilon}{d\sigma} = 0.9 \ge 10^{-16} \sigma^2$   
At  $\sigma = 50,000 \ \text{psi}$ ,  $\frac{d\varepsilon}{d\sigma} = 0.9 \ge 10^{-16} (50,000)^2 = 2.25 \ge 10^{-7} \ \text{in.}^2/\text{lb}$   
Tangent modulus  $= \frac{d\sigma}{d\varepsilon} = \frac{1}{2.25 \times 10^{-7}} = 4.44 \ge 10^6 \ \text{psi}$ 

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

1.11. 
$$\varepsilon_{\text{lateral}} = \frac{-3.25 \times 10^{-4}}{1} = -3.25 \times 10^{-4} \text{ in./in.}$$
  
 $\varepsilon_{\text{axial}} = \frac{2 \times 10^{-3}}{2} = 1 \times 10^{-3} \text{ in./in.}$   
 $v = -\frac{\varepsilon_{\text{lateral}}}{\varepsilon_{\text{axial}}} = -\frac{-3.25 \times 10^{-4}}{1 \times 10^{-3}} = 0.325$ 

**1.12.**  $\varepsilon_{lateral} = 0.05 / 50 = 0.001$  in./in.

 $\epsilon_{axial}=~\nu~x~\epsilon_{lateral}=0.33~x~0.001=0.00303$  in.

 $\Delta d = \varepsilon_{axial} x d_0 = -0.00825$  in. (Contraction)

**1.13.** L = 380 mm

D = 10 mm  
P = 24.5 kN  

$$\sigma = P/A = P/\pi r^2$$
  
 $\sigma = 24,500 \text{ N/} \pi (5 \text{ mm})^2 = 312,000 \text{ N/mm}^2 = 312 \text{ MPa}$   
 $\delta = \frac{PL}{AE} = \frac{24,500 lbx 380 mm}{\pi (5 mm)^2 E(kPa)} = \frac{118,539}{E(MPa)} \text{ mm}$ 

Material	Elastic Modulus	Yield Strength	Tensile Strength	Stress	δ
	(MPa)	(MPa)	(MPa)	(MPa)	(mm)
Copper	110,000	248	289	312	1.078
Al. alloy	70,000	255	420	312	1.693
Steel	207,000	448	551	312	0.573
Brass	101,000	345	420	312	1.174
alloy					

The problem requires the following two conditions:

a) No plastic deformation  $\Rightarrow$  Stress < Yield Strength

b) Increase in length,  $\delta < 0.9$  mm

The only material that satisfies both conditions is **steel**.

### **1.14.** a. $E = \sigma / \epsilon = 40,000 / 0.004 = 10 x 10^{6} psi$

- b. Tangent modulus at a stress of 45,000 psi is the slope of the tangent at that stress =  $4.7 \times 10^6$  psi
- c. Yield stress using an offset of 0.002 strain = 49,000 psi
- d. Maximum working stress = Failure stress / Factor of safety = 49,000 / 1.5 = 32,670 psi

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

1.15.a. Modulus of elasticity within the linear portion = 20,000 ksi.

- **b**. Yield stress at an offset strain of 0.002 in./in.  $\approx$  **70.0 ksi**
- c. Yield stress at an extension strain of 0.005 in/in.  $\approx 69.5~ksi$
- d. Secant modulus at a stress of 62 ksi.  $\approx$  18,000 ksi
- e. Tangent modulus at a stress of 65 ksi. ≈ 6,000 ksi
- **1.16.**a. Modulus of resilience = the area under the elastic portion of the stress strain curve =  $\frac{1}{2}(50 \ge 0.0025) \approx 0.0625$  ksi
  - b. Toughness = the area under the stress strain curve (using the trapezoidal integration technique)  $\approx 0.69~ksi$
  - c.  $\sigma = 40$  ksi , this stress is within the elastic range, therefore, E = 20,000 ksi  $\epsilon_{axial} = 40/20,000 = 0.002$  in./in.

$$\nu = -\frac{\varepsilon_{lateral}}{\varepsilon_{axial}} = -\frac{-0.00057}{0.002} = 0.285$$

d. The permanent strain at 70 ksi = 0.0018 in./in.

#### 1.17.

	Material A	Material B
a. Proportional limit	51 ksi	40 ksi
b. Yield stress at an offset strain of 0.002 in./in.	63 ksi	52 ksi
c. Ultimate strength	132 ksi	73 ksi
d. Modulus of resilience	0.065 ksi	<b>0.07</b> ksi
e. Toughness	8.2 ksi	7.5 ksi
f.	Material B is more ductile as it undergoes more	
	deformation before failure	

**1.18.** Assume that the stress is within the linear elastic range.

$$\sigma = \varepsilon \cdot E = \frac{\delta \cdot E}{l} = \frac{0.3x16,000}{10} = 480 \text{ ksi}$$

Thus  $\sigma > \sigma_{yield}$ 

Therefore, the applied stress is not within the linear elastic region and it is not possible to compute the magnitude of the load that is necessary to produce the change in length based on the given information.

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

**1.19.** Assume that the stress is within the linear elastic range.

$$\sigma = \varepsilon.E = \frac{\delta.E}{l} = \frac{7.6x105,000}{250} = 3,192 \text{ MPa}$$

Thus  $\sigma > \sigma_{yield}$ 

Therefore, the applied stress is not within the linear elastic region and it is not possible to compute the magnitude of the load that is necessary to produce the change in length based on the given information.

**1.20.** At  $\sigma = 60,000$  psi,  $\varepsilon = \sigma / E = 60,000 / (30 \times 10^6) = 0.002$  in./in. a. For a strain of 0.001 in./in.:  $\sigma = \varepsilon E = 0.001 \times 30 \times 10^6 = 30,000$  psi (for both i and ii)

b. For a strain of 0.004 in./in.:  $\sigma = 60,000 \text{ psi}$  (for i)  $\sigma = 60,000 + 2 \times 10^6 (0.004 - 0.002) = 64,000 \text{ psi}$  (for ii)

**1.21. a.** Slope of the elastic portion =  $600/0.003 = 2x10^5$  MPa

Slope of the plastic portion = (800-600)/(0.07-0.003) = 2,985 MPa

Strain at 650 MPa = 0.003 + (650-600)/2,985 = 0.0198 m/m

Permanent strain at 650 MPa =  $0.0198 - 650/(2x10^5) = 0.0165 \text{ m/m}$ 

- b. Percent increase in yield strength = = 100(650-600)/600 = 8.3%
- c. The strain at 625 MPa =  $625/(2x10^5) = 0.003125$  m/m This strain is elastic.
- **1.22.** See Sections 1.2.3, 1.2.4 and 1.2.5.

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

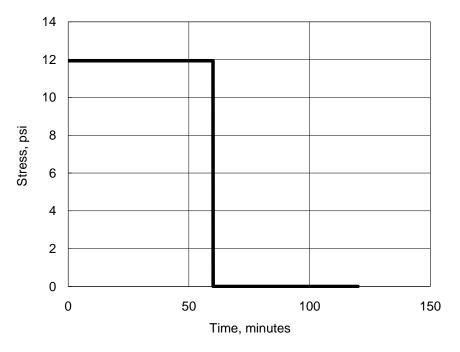
**1.23.** The stresses and strains can be calculated as follows:  $\sigma = P/A_o = 150 / (\pi \times 2^2) = 11.94 \text{ psi}$  $\epsilon = (H_o-H)/H_o = (6-H)/6$ 

The stresses and strains are shown in the following table:

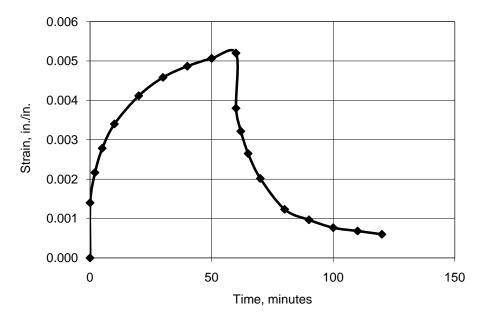
Time	Н	Strain	Stress
(min.)	(in.)	(in./in.)	(psi)
0	6	0.00000	11.9366
0.01	5.9916	0.00140	11.9366
2	5.987	0.00217	11.9366
5	5.9833	0.00278	11.9366
10	5.9796	0.00340	11.9366
20	5.9753	0.00412	11.9366
30	5.9725	0.00458	11.9366
40	5.9708	0.00487	11.9366
50	5.9696	0.00507	11.9366
60	5.9688	0.00520	11.9366
60.01	5.9772	0.00380	0.0000
62	5.9807	0.00322	0.0000
65	5.9841	0.00265	0.0000
70	5.9879	0.00202	0.0000
80	5.9926	0.00123	0.0000
90	5.9942	0.00097	0.0000
100	5.9954	0.00077	0.0000
110	5.9959	0.00068	0.0000
120	5.9964	0.00060	0.0000

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

a. Stress versus time plot for the asphalt concrete sample



Strain versus time plot for the asphalt concrete sample



- b. Elastic strain = 0.0014 in./in.
- c. The permanent strain at the end of the experiment = 0.0006 in./in.
- d. The phenomenon of the change of specimen height during static loading is called **creep** while the phenomenon of the change of specimen height during unloading called is called **recovery**.

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

**1.24.** See Figure 1.12(a).

**1.25** See Section 1.2.7.

**1.27.** a. For P = 5 kN

Stress = P / A = 5000 /  $(\pi \times 5^2)$  = 63.7 N/mm<sup>2</sup> = 63.7 MPa Stress / Strength = 63.7 / 290 = 0.22 From Figure 1.16, an **unlimited number** of repetitions can be applied without fatigue failure.

b. For P = 11 kN Stress = P / A = 11000 / ( $\pi$  x 5<sup>2</sup>) = 140.1 N/mm<sup>2</sup> = 140.1 MPa Stress / Strength = 140.1 / 290 = 0.48 From Figure 1.16, N **≈700** 

**1.28** See Section 1.2.8.

1.29.

Material	Specific Gravity	
Steel	7.9	
Aluminum	2.7	
Aggregates	2.6 - 2.7	
Concrete	2.4	
Asphalt cement	1 - 1.1	

**1.30** See Section 1.3.2.

**1.31.**  $\delta L = \alpha_L x \ \delta T \ x \ L = 12.5\text{E-06} \ x \ (115-15) \ x \ 200/1000 = 0.00025 \ \text{m} = 250 \ \text{microns}$ Rod length = L +  $\delta L = 200,000 + 250 = 200,250 \ \text{microns}$ 

### Compute change in diameter linear method

 $\delta d = \alpha_d x \ \delta T x \ d = 12.5\text{E-06 x} (115-15) \text{ x } 20 = 0.025 \text{ mm}$ Final d = **20.025 mm** 

### Compute change in diameter volume method

 $\delta V = \alpha_V x \ \delta T \ x \ V = (3 \ x \ 12.5\text{E-06}) \ x \ (115\text{-}15) \ x \ \pi \ (10/1000)^2 \ x \ 200/1000 = 2.3562 \ x \ 10^{11} \text{m}^3$ Rod final volume =  $V + \delta V = \pi r^2 L + \delta V = 6.28319 \ x \ 10^{13} + 2.3562 \ x \ 10^{11} = 6.31 \ x \ 10^{13} \ \text{m}^3$ Final d = **20.025 mm** 

There is no stress acting on the rod because the rod is free to move.

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

1.32. Since the rod is snugly fitted against two immovable nonconducting walls, the length of the

rod will not change, **L** = **200 mm** From problem 1.25,  $\delta L = 0.00025$  m  $\varepsilon = \delta L / L = 0.00025 / 0.2 = 0.00125$  m/m  $\sigma = \varepsilon E = 0.00125 \times 207,000 = 258.75$  MPa The stress induced in the bar will be compression.

- **1.33.** a. The change in length can be calculated using Equation 1.9 as follows:  $\delta L = \alpha_L x \ \delta T x L = 1.1\text{E-5 x} (5 - 40) \text{ x } 4 = -0.00154 \text{ m}$ 
  - b. The tension load needed to return the length to the original value of 4 meters can be calculated as follows:

 $\varepsilon = \delta L / L = -0.00154/4 = -0.000358 \text{ m/m}$   $\sigma = \varepsilon \text{ E} = -0.000358 \text{ x} 200,000 = -77 \text{ MPa}$  $P = \sigma \text{ x } A = -77 \text{ x} (100 \text{ x} 50) = -385,000 \text{ N} = -385 \text{ kN}$  (tension)

- c. Longitudinal strain under this load = **0.000358 m/m**
- **1.34.** If the bar was fixed at one end and free at the other end, the bar would have contracted and no stresses would have developed. In that case, the change in length can be calculated using Equation 1.9 as follows.

 $\delta L = \alpha_L x \ \delta T x L = 0.000005 \ x \ (0 - 100) \ x \ 50 = -0.025 \ in.$  $\varepsilon = \delta L / L = 0.025 / 50 = 0.0005 \ in./in.$ 

Since the bar is fixed at both ends, the length of the bar will not change. Therefore, a tensile stress will develop in the bar as follows.  $\sigma = \epsilon E = -0.0005 \text{ x } 5,000,000 = -2,500 \text{ psi}$ 

Thus, the tensile strength should be larger than 2,500 psi in order to prevent cracking.

**1.36** See Section 1.7.

1.37 See Section 1.7.1

**1.38.**  $H_0$ :  $\mu \ge 32.4$  MPa

H<sub>1</sub>: 
$$\mu < 32.4$$
 MPa  $\alpha = 0.05$ 

$$\Gamma_{\rm o} = \frac{\overline{x} - \mu}{(\sigma / \sqrt{n})} = -3$$

Degree of freedom =  $\nu = n - 1 = 15$ From the statistical t-distribution table,  $T_{\alpha, \nu} = T_{0.05, 15} = -1.753$  $T_o < T_{\alpha, \nu}$ Therefore, **reject** the hypothesis. The contractor's claim is not valid.

This material is protected by Copyright and written permission should be obtained from the publisher prior to any prohibited reproduction, storage in a retrieval system, or transmission in any form or by any means, electronic, mechanical, photocopying, recording, or likewise. For information regarding permission(s), write to: Rights and Permissions Department, Pearson Education, Inc., Upper Saddle River, NJ 07458.

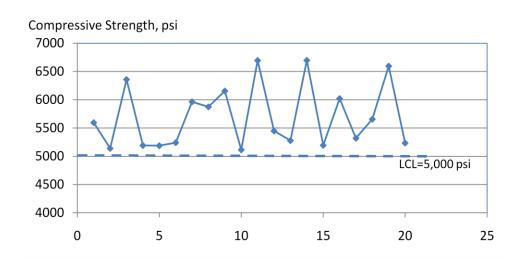
**1.39.**  $H_0$ :  $\mu \ge 5,000 \text{ psi}$ 

H<sub>1</sub>: 
$$\mu < 5,000 \text{ psi}$$
  
 $\alpha = 0.05$   
T<sub>o</sub> =  $\frac{\overline{x} - \mu}{(\sigma / \sqrt{n})} = -2.236$ 

Degree of freedom =  $\nu = n - 1 = 19$ From the statistical t-distribution table,  $T_{\alpha, \nu} = T_{0.05, 19} = -1.729$  $T_o < T_{\alpha, \nu}$ Therefore, **reject** the hypothesis. The contractor's claim is not valid.

1.40. 
$$\bar{x} = \frac{\sum_{i=1}^{n} x_i}{n} = \frac{\sum_{i=1}^{20} x_i}{20} = \frac{113,965}{20} = 5,698.25 \, psi$$
  
 $s = \left(\frac{\sum_{i=1}^{n} (x_i - \bar{x})^2}{n-1}\right)^{1/2} = \left(\frac{\sum_{i=1}^{20} (x_i - 5698.25)^2}{20-1}\right)^{1/2} = 571.35 \, psi$   
Coefficient of Variation =  $100\left(\frac{s}{\overline{x}}\right) = 100\left(\frac{571.35}{5698.25}\right) = 10.03\%$ 

b. The control chart is shown below.



The target value is any value above the specification limit of 5,000 psi. The plant production is meeting the specification requirement.