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LAMPIRAN

LAMPIRAN

Lampiran 1 Operasi Buletin PDL KRI TNI-AL

biru • • •

PT Sri Rejeki Isman Tbk (Sritex)

Department of Industrial Engineering

Operation Bulletin



Buyer:	MABES TNI AL	Order Qty:	10.000 PCS
Merchant:	ARDIANI	Created By:	RIZKY & SALSA
Style No:	PDL LORENG TNI AL	Planned Factory:	GARMENT 1
Style Desc:	KEMEJA	Prepared On:	20-Mar-24

Productivity

No Of Workstations	55	Total Operation time (With Allowance)	59.05
No Of Operators in Line	39	Total Machine time (Time + 15% Allowance)	49.98
No Of Helpers in Line	5	Total Manual time (Time + 10% Allowance)	9.08
No Of Ironers in Line	11		

Target as per Standard Workstations

Targeted Efficiency	:	100%	328
Expected Average Efficiency	:	65%	213
Expected Peak Efficiency	:	75%	246

Productivity Targets	@PE	@AE	@100%
Pcs/Head/Shift	5.33	4.62	7.11
Pcs/Machine/Shift	6.30	5.46	8.40

Opr #	Operation Description	Workstation Type	Op. Time	Balanced W/S	No Of W/s	Expected Prodn@ 100%	Time in Sec
	KRAH						
1	LAKAR KRAH+BALIK	SNJBT	0.75	0.53	100	67	45
2	GOSOK KRAH	P.T	0.37	0.26	100	136	22
	LOOP						
3	JAHIT TALI LOOP KRAH	SNJBT	0.33	0.23	100	150	20
4	POTONG LOOP KRAH	H.T	0.10	0.07	100	500	6
	SAKU DEPAN						
5	TANDA ROUNDHOULE SAKU DEPAN	H.T	0.17	0.12	100	300	10
6	ROUNDHOULE SAKU DEPAN	ROUNDHOULE M/C	0.73	0.51	100	69	44
7	JAHIT TENGAH+KRES+KLIM SAKU DEPAN	SNJBT	1.33	0.94	100	38	80
8	GOSOK SAKU DEPAN	P.T	1.17	0.82	100	43	70

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9	JAHIT SUDUT+STIK DALAM	SNJBT	1.05	0.74	100	48	63
10	STIK DN LUAR+PASANG VELKRO SAKU DEPAN	SNJBT	0.97	0.68	100	52	58
	SAKU LENGAN						
11	KLIM SAKU LENGAN	SNJBT	0.58	0.41	100	86	35
12	GOSOK SAKU LENGAN	P.T	1.58	1.11	100	32	95
13	PASANG VELKRO	SNJBT	0.93	0.66	100	54	56
14	JAHIT SUDUT+STIK DALAM+STIK LUAR SAKU LENGAN	SNJBT	1.53	1.08	100	33	92
	TUTUP SAKU DEPAN						
15	GOSOK TUTUP SAKU DEPAN MENTAH	P.T	0.25	0.18	100	200	15
16	JAHIT VARIASI+LAKAR+BALIK	SNJBT	1.58	1.11	100	32	95
17	STIK DN+PASANG VELKRO TUTUP DEPAN	SNJBT	1.63	1.15	100	31	98
18	GOSOK TUTUP DEPAN JADI	P.T	0.42	0.29	100	120	25
19	LUBANG TUTUP DEPAN	B/H	0.23	0.16	100	214	14
	TUTUP SAKU LENGAN						
20	GOSOK TUTUP SAKU LENGAN MENTAH	P.T	0.20	0.14	100	250	12
21	LAKAR TUTUP+BALIK	SNJBT	0.77	0.54	100	65	46
22	STIK+PASANG VELKRO KASAR HALUS LENGAN	SNJBT	1.60	1.12	100	31	96
23	GOSOK TUTUP LENGAN JADI	P.T	0.42	0.29	100	120	25
	PLAKET DEPAN						
24	LAKAR PLAKET DEPAN+BALIK	SNJBT	0.37	0.26	100	136	22
25	GOSOK PLAKET DEPAN	P.T	0.25	0.18	100	200	15
26	LUBANG PLAKET DEPAN	B/H	0.52	0.36	100	97	31
	DECK LENGAN						
27	GOSOK DECK LENGAN	P.T	0.42	0.29	100	120	25
28	LAKAR DECK LENGAN+BALIK	SNJBT	1.17	0.82	100	43	70
29	PASANG VELKRO+STIK	SNJBT	0.97	0.68	100	52	58
	LENGAN						
30	OBRAS 5 PRINCES LENGAN	5TO/L	0.67	0.47	100	75	40
31	STIK DN PRINCES LENGAN	DN.S	0.63	0.44	100	79	38
32	GOSOK LIPAT LENGAN	P.T	0.75	0.53	100	67	45
33	TANDA PASANG SAKU+TUTUP LENGAN	H.T	0.37	0.26	100	136	22
34	JAHIT LIPAT LENGAN+PASANG DECK+PASANG VELKRO	SNJBT	2.33	1.64	100	21	140
35	PASANG SAKU+TUTUP+JAHIT KRES LENGAN	SNJBT	2.57	1.80	100	19	154

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36	BARTACK LENGAN	B/T	0.58	0.41	100		86	35	
	DEPANAN								
37	GOSOK LIPAT BODY DEPAN	P.T	0.80	0.56	100		63	48	
38	TANDA PASANG SAKU+TUTUP DEPAN	H.T	0.50	0.35	100		100	30	
39	PASANG LABEL PEMELIHARAAN	SNJBT	0.42	0.29	100		120	25	
40	JAHIT PANEL+PASANG PLAKET DEPAN	SNJBT	1.12	0.78	100		45	67	
41	TUTUP PLAKET DEPAN	SNJBT	1.72	1.21	100		29	103	
42	PASANG SAKU DEPAN	SNJBT	1.75	1.23	100		29	105	
43	PASANG TUTUP SAKU DEPAN	SNJBT	1.63	1.15	100		31	98	
44	BARTACK BODY DEPAN	B/T	0.35	0.25	100		143	21	
	ASSEMBLY								
45	OBRAS 5 BAHU	5TO/L	0.57	0.40	100		88	34	
46	PASANG+TUTUP KRAH	SNJBT	1.83	1.29	100		27	110	
47	STIK DN KELILILING DEPAN+KRAH	DNLS	1.55	1.09	100		32	93	
48	OBRAS 5 PASANG LENGAN	5TO/L	0.83	0.59	100		60	50	
49	STIK DN LENGAN	DNLS	0.90	0.63	100		56	54	
50	OBRAS 5 SAMPING	5TO/L	1.25	0.88	100		40	75	
51	STIK DN SAMPING	DNLS	2.03	1.43	100		25	122	
52	KLIM BAWAH	SNJBT	1.73	1.22	100		29	104	
53	TANDA KANCING	H.T	0.50	0.35	100		100	30	
54	PASANG KANCING	B/S	0.98	0.69	100		51	59	
55	BARTACK ALL	B/T	0.97	0.68	100		52	58	
	Total		51.71	36.32	55.00		66%	3102.5	

MACHINES	NO'S	OP Time	MANUAL	NO'S	OP Time
SNJBT	24.0	30.67	H.T	5.00	1.63
DNLS	4.0	5.12			
ROUNDHOULE M/C	1.0	0.73	C.T	0.00	0.00
3TO/L	0.0	0.00			
5TO/L	4.0	3.32	P.T	11.00	6.62
HOT CUT M/C	0.0	0.00			
B/T	3.0	1.90			
B/H	2.0	0.75			
B/S	1.0	0.98			
TOTAL	39.0	43.5	TOTAL	16.0	8.25

Prepread by | Varified by | Factory Head

M/C	FACTOR
SNJBT	2.5
DNLS	5
FOA	11
DNCS	11
SNEC	2.5
SNCS	5.5
3TO/L	15
5TO/L	20
4TO/L	18
3T F/L	18
4T F/L	25
5T F/L	28
SDLS	3.5
B/H	50
B/S	40
B/T	50
K/H	70
MNCS	11
Autoig	2.5
Needle feed m/c	2.5
ZIG ZAG M/C	7
SN FOA	16.5
BLIND HEM M/C	5
WELT M/C	5
P.T	0
H.T	0
C.T	0
CTM	0
PROFILE M/C	2.5
CHECKING TABLE	0
OVERDECK M/C	0

SNO	OPERATION'S	FOLDER MF #
1	Collar tape attach	413/563
2	Btn hole plkt hemming	204/201/206
3	Btn plkt Folder	206/205/301/302
4	Btn hole plkt cressing	527
5	Double pcs plkt (Waistband)	307
6	Jobs Plain plkt	301/302
7	Bck yoke attach	213/214
8	Box pleat Folder (Self Double side)	510
9	Cuff Hemming (Flat hem)	574/575
10	Long slv plkt hem	219
11	Slv top plkt	538/540
12	Half slv hemming	506/507
13	Slv attach / Top st	218A/218B
14	Piping attach with Cord	521/435/544/557
15	Pirping with out cord	519/520
16	Tape attach	523/524/563
17	Edge binding (edge inside)	529/530/536/566
18	Edge binding Flat edge	531/568
19	Edge binding @ More curves	565
20	Side seam FOA	243/335
21	Btm hem Less Width	503/504/505/569/570/572
22	Btm hem High width	506
23	btm hem more curves	571
24	Fine hemmer	550
25	Loop folder Lock st(Less Width)	515/516
26	Loop folder Lock st(More Width)	517/518
27	Loop Folder F/L	339/341/342
28	Loop folder @ PF	547
29	Lap Seam Lock st	240/333/334
30	Cuff attach	224

Sumber*: Industrial Engineering* PT Sri Rejeki Isman Tbk, 2024

Lampiran 2 Operasi Buletin Celana PDL KRI TNI-AL

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PT Sri Rejeki Isman Tbk (Sritex)
Department of Industrial Engineering
Operation Bulletin

Buyer :	MABES TNI AL	Order Qty:	10.000 PCS
Merchant:	ARDIANI	Created By:	RIZKY / SALSA
Style No:	PDL KRI AL	Planned Factory:	GARMENT 1
Style Desc:	CELANA	Prepared On:	20-Apr-24

Productivity

No Of Workstations	54	Total Operation Time (With Allowance)	55.10
No Of Operators in Line	39	Total Machine Time (Time + 15% Allowance)	45.63
No Of Helpers in Line	6	Total Manual Time (Time + 10% Allowance)	9.47
No Of Ironers in Line	9		

Target as per Standard Workstations

Targeted Efficiency :	100%		359
Expected Average Efficiency :	75%		269
Expected Peak Efficiency :	85%		305

Productivity Targets	@PE	@AE	@100%
Pcs/Head/Shift	6.48	5.72	7.62
Pcs/Machine/Shift	7.82	6.90	9.20

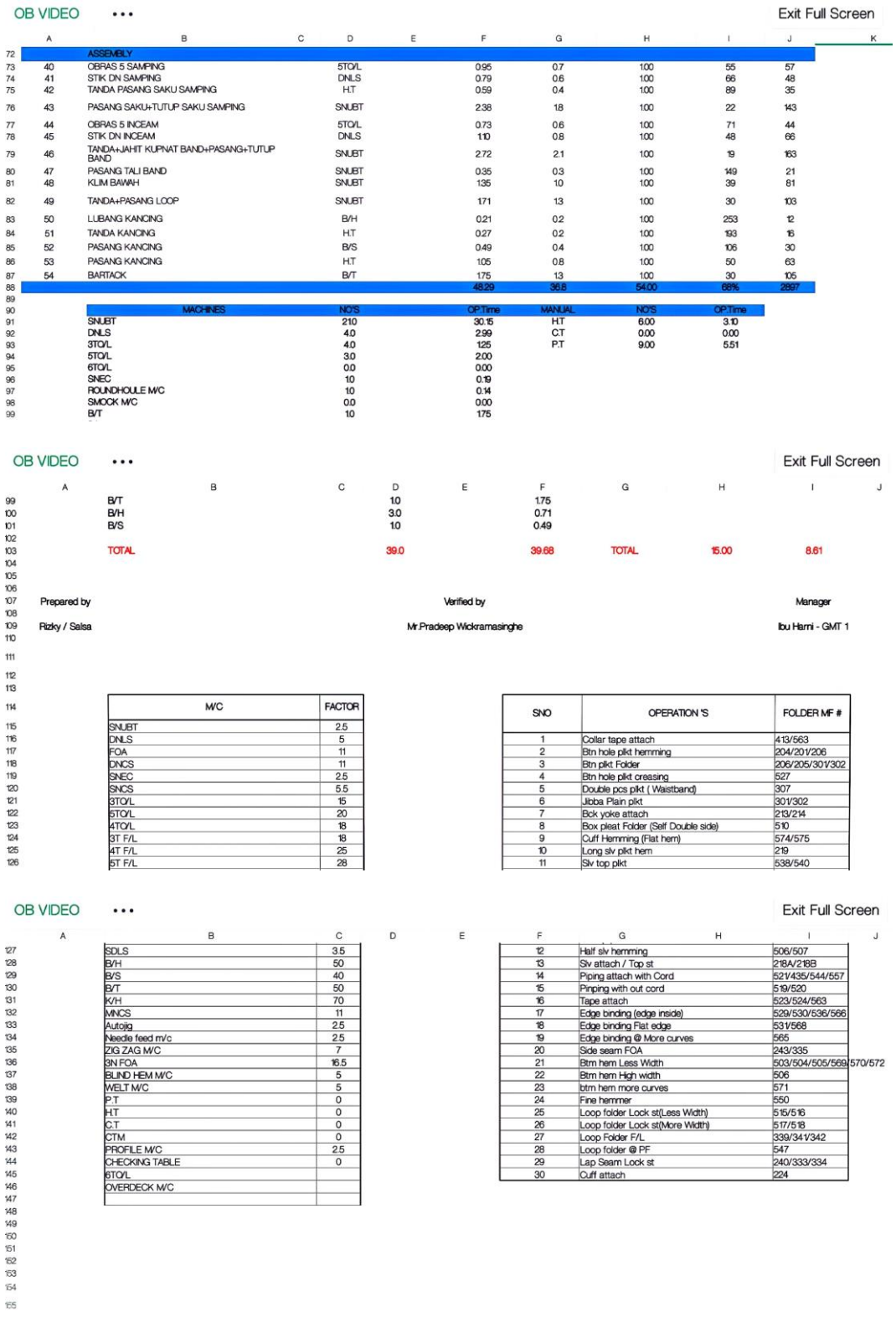
Opr #	Operation Description	Workstation Type	Op. Time	Balanced W/S	No Of W/s	Expected Prodn @100%	Time in Sec
	LOOP						
1	RIMBAS TALI LOOP	SNEC	0.19	0.1	1.00	274	11
2	CORONG LOOP	DNLS	0.73	0.6	1.00	71	44
3	UKUR+POTONG LOOP	H.T	0.32	0.2	1.00	164	19
	BAND						

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	BAND							
4	GOSOK BAND	P.T	0.59	0.4	1.00	89	35	
5	PASANG LABEL BAND	SNUBT	0.46	0.4	1.00	113	28	
6	GOSOK TALI BAND	P.T	0.98	0.8	1.00	53	59	
7	BUAT TALI BAND	SNUBT	1.13	0.9	1.00	46	68	
	SAKU SAMPING							
8	TANDA LUBANG ROUNDHOLE SAKU SAMPING	H.T	0.22	0.2	1.00	235	13	
9	LUBANG ROUNDHOLE SAKU SAMPING	ROUNDHOULE M/C	0.14	0.1	1.00	365	9	
10	JAHIT PLUH+KRES+KLIM SAKU SAMPING	SNUBT	1.52	1.2	1.00	34	91	
11	GOSOK SAKU SAMPING	P.T	1.67	1.3	1.00	31	100	
12	JAHIT SUDUT+STIK 1/16 KELILING DALAM SAKU SAMPING+STIK DN KELILING LUAR SAKU SAMPING+PASANG VELKRO	SNUBT	1.70	1.3	1.00	31	102	
	TUTUP SAKU SAMPING							
13	GOSOK TUTUP SAMPING MENTAH	P.T	0.56	0.4	1.00	94	33	
14	LUBANG TUTUP SAMPING	B/H	0.25	0.2	1.00	205	15	
15	JAHIT KRES+LAKAR TUTUP SAKU SAMPING	SNUBT	0.64	0.5	1.00	82	38	
16	BALIK+STIK DN+PASANG VELKRO TUTUP SAKU SAMPING	SNUBT	0.97	0.7	1.00	54	58	
17	GOSOK TUTUP SAMPING JADI	P.T	0.21	0.2	1.00	253	12	
	SAKU BELAKANG							
18	KLIM SAKU BELAKANG	SNUBT	0.48	0.4	1.00	110	29	
19	GOSOK SAKU BELAKANG	P.T	0.46	0.4	1.00	113	28	
	GOSOK TUTUP SAKU BELAKANG							
20	GOSOK TUTUP BELAKANG MENTAH	P.T	0.51	0.4	1.00	103	30	

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21	LUBANG TUTUP SAKU BELAKANG	B/H	0.25	0.2	1.00	205	15	
22	JAHIT KRES+LAKAR TUTUP SAKU BELAKANG	SNUBT	0.62	0.5	1.00	84	37	
23	BALIK+STIK DN+PASANG VELKRO TUTUP SAKU BELAKANG	SNUBT	0.94	0.7	1.00	56	56	
	DEPANAN						0	
24	TANDA + PASANG LABEL PEMELIHARAAN PURING SAKU DEPAN	SNUBT	0.64	0.5	1.00	82	38	
25	OBRAS 3 PURING SAKU DEPAN	3TO/L	0.33	0.3	1.00	156	20	
26	BALIK+STIK PURING SAKU DEPAN	SNUBT	1.14	0.9	1.00	46	69	
27	GOSOK PASANG INT BODY DEPAN	P.T	0.21	0.2	1.00	253	12	
28	OBRAS 3 BODY DEPAN	3TO/L	0.29	0.2	1.00	183	17	
29	PASANG SAKU DEPAN+STIK+JAHIT BANTU	SNUBT	1.92	1.5	1.00	27	115	
30	OBRAS 3 GOLBY	3TO/L	0.11	0.1	1.00	469	7	
31	OBRAS 3 CONGOT	3TO/L	0.52	0.4	1.00	100	31	
32	GOSOK CONGOT	P.T	0.33	0.3	1.00	156	20	
33	BUAT CONGOT+PASANG HAK	SNUBT	0.92	0.7	1.00	57	55	
34	PASANG GOLBY+ZIPER+CONGOT+LAKAR LUJNG BAND+JAHIT FRONRISE+STIK DN FRONRISE	SNUBT	6.22	4.7	1.00	8	373	
	BELAKANG							
35	TANDA KUPNAT BELAKANG	H.T	0.65	0.5	1.00	80	39	
36	JAHIT KUPNAT BELAKANG	SNUBT	0.46	0.4	1.00	113	28	
37	PASANG SAKU+TUTUP SAKU BELAKANG	SNUBT	1.89	1.4	1.00	28	113	
38	OBRAS 5 BACKRISE	5TO/L	0.32	0.2	1.00	164	19	
39	STIK DN BACKRISE	DNLS	0.37	0.3	1.00	143	22	
	ASSEMBLY							



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	ASSEMBLY								
40	OBRAS 5 SAMPING	5TO/L		0.95	0.7	100	55	57	
41	STIK DN SAMPING	DNLS		0.79	0.6	100	66	48	
42	TANDA PASANG SAKU SAMPING	H.T		0.59	0.4	100	89	35	
43	PASANG SAKU+TUTUP SAKU SAMPING	SNUBT		2.38	1.8	100	22	143	
44	OBRAS 5 INCEAM	5TO/L		0.73	0.6	100	71	44	
45	STIK DN INCEAM	DNLS		1.10	0.8	100	48	66	
46	TANDA+JAHIT KUPNAT BAND+PASANG+TUTUP BAND	SNUBT		2.72	2.1	100	19	163	
47	PASANG TALI BAND	SNUBT		0.35	0.3	100	149	21	
48	KLIM BAWAH	SNUBT		1.35	1.0	100	39	81	
49	TANDA+PASANG LOOP	SNUBT		1.71	1.3	100	30	103	
50	LUBANG KANCING	B/H		0.21	0.2	100	253	12	
51	TANDA KANCING	H.T		0.27	0.2	100	193	16	
52	PASANG KANCING	B/S		0.49	0.4	100	106	30	
53	PASANG KANCING	H.T		1.05	0.8	100	50	63	
54	BARTACK	B/T		1.75	1.3	100	30	105	
				48.29	36.8	54.00	68%	2897	

MACHINES	NO'S	OP.Time	MANUAL	NO'S	OP.Time
SNUBT	21.0	30.15	H.T	6.00	3.10
DNLS	4.0	2.99	C.T	0.00	0.00
3TO/L	4.0	1.25	P.T	9.00	5.51
5TO/L	3.0	2.00			
6TO/L	0.0	0.00			
SNEC	1.0	0.19			
ROUNDHOULE M/C	1.0	0.14			
SMOCK M/C	0.0	0.00			
B/T	1.0	1.75			

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B/T	1.0	1.75					
B/H	3.0	0.71					
B/S	1.0	0.49					
TOTAL	39.0	39.68	TOTAL	15.00	8.61		

Prepared by — Rizky / Salsa

Verified by — Mr.Pradeep Wickramasinghe

Manager — Ibu Hanni - GMT 1

M/C	FACTOR
SNUBT	2.5
DNLS	5
FOA	11
DNCS	11
SNEC	2.5
SNCS	5.5
3TO/L	15
5TO/L	20
4TO/L	18
3T F/L	18
4T F/L	25
5T F/L	28

SNO	OPERATION 'S	FOLDER M/F #
1	Collar tape attach	413/563
2	Btn hole plkt hemming	204/201/206
3	Btn plkt Folder	206/205/301/302
4	Btn hole plkt creasing	527
5	Double pcs plkt (Waistband)	307
6	Jibba Plain plkt	301/302
7	Bck yoke attach	213/214
8	Box pleat Folder (Self Double side)	510
9	Cuff Hemming (Flat hem)	574/575
10	Long slv plkt hem	219
11	Slv top plkt	538/540

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SDLS	3.5	
B/H	50	
B/S	40	
B/T	50	
K/H	70	
MNCS	11	
Autojig	2.5	
Needle feed m/c	2.5	
ZIG ZAG M/C	7	
3N FOA	16.5	
BLIND HEM M/C	5	
WELT M/C	5	
P.T	0	
H.T	0	
C.T	0	
CTM	0	
PROFILE M/C	2.5	
CHECKING TABLE	0	
6TO/L		
OVERDECK M/C		

12	Half slv hemming	506/507
13	Slv attach / Top st	218A/218B
14	Piping attach with Cord	521/435/544/557
15	Pinping with out cord	519/520
16	Tape attach	523/524/563
17	Edge binding (edge inside)	529/530/536/566
18	Edge binding Flat edge	531/568
19	Edge binding @ More curves	565
20	Side seam FOA	243/335
21	Btm hem Less Width	503/504/505/569/570/572
22	Btm hem High width	506
23	btm hem more curves	571
24	Fine hemmer	550
25	Loop folder Lock st(Less Width)	515/516
26	Loop folder Lock st(More Width)	517/518
27	Loop Folder F/L	339/341/342
28	Loop folder @ PF	547
29	Lap Seam Lock st	240/333/334
30	Cuff attach	224

Sumber*: Industrial Engineering* PT Sri Rejeki Isman Tbk, 2024