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LAMPIRAN

Lampiran 1. Standar kualitas benang Cd40

	ITEM UJI	CD 40	
		STANDAR	TOLERANSI
RING SPINNING	Ne	40,00	± 2%
	CV % Ne	0,90	Max 1,50
	U %	10,72	Max 12,00
	Thin/1000m	9,00	Max 29,00
	Thick/1000m	93,00	Max 243,0
	Nep/1000m	211,00	Max 638,0
	Total IPI	313,00	Max 910,0
	Hairiness	3,80	Max 5,50
	SYS, AVG	243,60	Min 195,00
	SYS, CV%	7,80	Max 9,20
	Elongation	6,50	Min 4,00
	TPI	28,35	Min 26,93 Max 29,77
	Blended	C = 100%	

LAMPIRAN 2. Gear ganti Proses Mesin Ring Spinning TOYODA RY

GEAR GANTI PROSES
MESIN RING FRAME TOYODA

NO.	COUNT	TDC	BDC	TC	LC/SW	SELENT TC	E/F (T)	SPINDLE	TRAVELLER	RG	KET
1	PC 45	40 T	60 T	49 T	43 T/94 T	95 T	31/81	23.8	Br 6/0	44.5 x 46	
2	PC 45	40 T	60 T	45 T		75 T	31/81	20.2	Br 6/0	44.5 x 46	
3	PC 30	60 T	51 T	51 T	38 T/64 T	72 T	31/81	23.8	Br 1/0	44.5 x 46	
4	PC 16	41 T	64 T	64 T	31 T/85.11 T	72 T	56/56	23.8	Br No. 4	44.5 x 46	
5	CD 40	40 T	53 T	38 T	41 T/60 T	75 T	31/81	20.2	Kn 10/0	44.5 x 46	
6	CD 32	50 T	53 T	45 T	36 T/67 T	75 T	31/81	20.2	Carter 6/0	44.5 x 46	
7	CD 32	50 T	53 T	49 T	36 T/67 T	95 T	31/81	23.8	Carter 6/0	44.5 x 46	
8	CM 40	46 T	50 T	41 T	43 T/64 T	95 T	31/81	23.8	Kn 10/0	44.5 x 46	
9	CM 16	43 T	64 T	55 T	31 T/78 T	72 T	56/56	20.2	Kn No. 6	44.5 x 46	
10	CM 50	37 T	51 T	38 T	45 T/72 T	95 T	31/81	23.8	Kn 5/0	44.5 x 46	
11	TENCEL 30	53 T	61 T	60 T	64 T/38 T	81 T	31/81	20.2	Br 1/0	45 x 52	
12	TENCEL 80	32 T	61 T	35 T/ 34.79	55 T/100 T	81 T	31/81	20.2	Br EM 1udr 10/0	44.5 x 46	
13	TENCEL 40	40 T	61 T	52 T	43 T/85 T	81 T	31/81	20.2	Carter 8/0	45 x 52	
14	PC 20	33 T	64 T	57 T	31 T/78 T	72 T	56/56	23.8		44.5 x 46	
15	CM 50	50 T	50 T	38 T		81 T	31/81	20.2	Carter 6/0	44.5 x 46	
16	MMC 50	36 T	55 T	43 T	50 T/91 T	81 T	31/81	20.2	Carter 6/0	44.5 x 46	

GEAR GANTI PROSES MC. RX 240 BA

No	COUNT	TDC	BDC	TC	TPI	TCA	TCB	DCA	DCB	KET
1	PC 45	49 T	50 T	45 T	24.80	47	77	35	135	Br 6/0
2	PC 36	61 T	50 T	55 T	20.29	47	77	35	135	
3	PC 30	72 T	50 T	63 T	17.71	47	77	35	135	Br 1/0
4	CD 32	61 T	52 T	45 T	24.80	47	77	35	135	Ctr 6/0
5	CD 40	49 T	52 T	38 T	29.37	47	77	35	135	Kn 10/0

LAMPIRAN 3. Standar Temperatur dan RH

AREA	STANDAR	
	SPINNING II	
	RH	TEMP
BLOWING	63 - 75 %	26 - 33 C
CARDING	60 - 70 %	26 - 33 C
DRAWING	52 - 63 %	28 - 34 C
COMBING	52 - 63 %	28 - 34 C
FLYER	50 - 62 %	28 - 34 C
RING FRAME	50 - 59 %	28 - 34 C
WINDER	63 - 73 %	28 - 35 C

LAMPIRAN 4. Mesin Ring Spinning unit spinning 2 line C3



LAMPIRAN 5. Alat Kunci untuk setting roda gigi



LAMPIRAN 6. Alat Uster Tester 3 unit Spinning 2

