

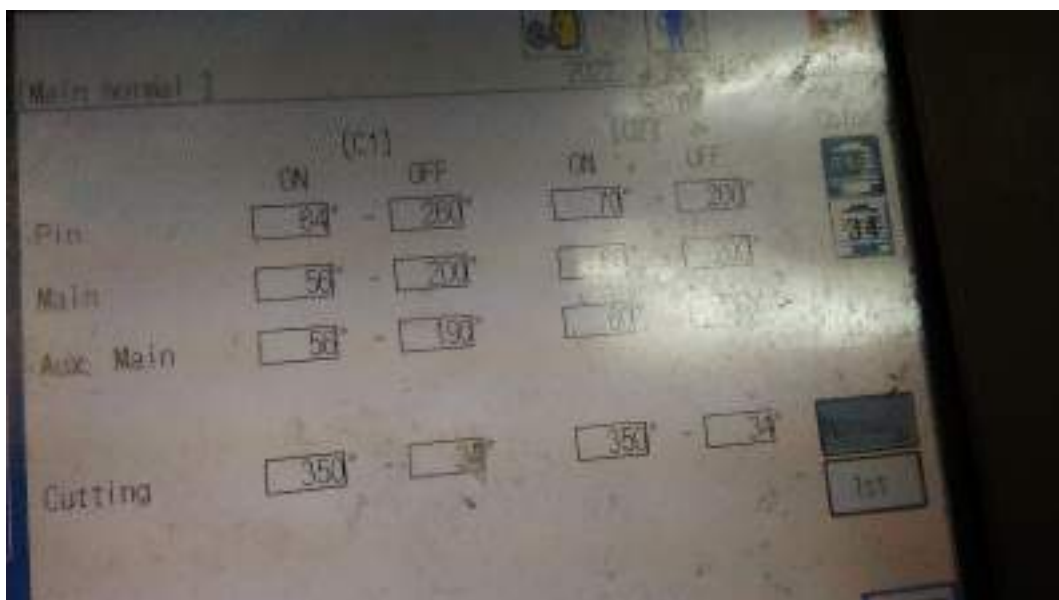
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## LAMPIRAN

Lampiran 1 Standar Angin Normal



Lampiran 2 *Stand Cone*



Lampiran 3 Standar Batas Jahitan

### STANDAR JUMLAH HELAI UNTUK TANDA BATAS (JAHITAN)

STANDART/CM	PICK	JUMLAH HELAI	KODE PRODUKSI
1,5	58	34	T 43
1,5	64	38	T 32, T 39, T 34
1,5	66	40	T 14
1,5	68	40	T 20, T 24
1,5	70	42	T 13, T 17, T 23, T 29
1,5	82	50	T 06, T 07
1,5	86	52	T 51, T 52
1,5	90	54	T 90, T 73
1,5	92	56	T 56
1,5	100	60	T 82

**Pengertian PICK ?**

Pick adalah : Jumlah helai benang pakan per inchi.

**Cara perhitungan**

panjang sarung (cm) X Pick = Jumlah helai  
Inchi

**Contoh :**

1.5 Cm X Pick = 34 Helai  
2.54

*Handwritten signature and date: 20/11/05*

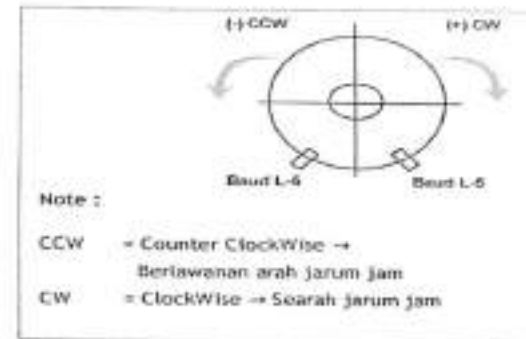
Lampiran 4 Manometer (Alat Ukur Angin)



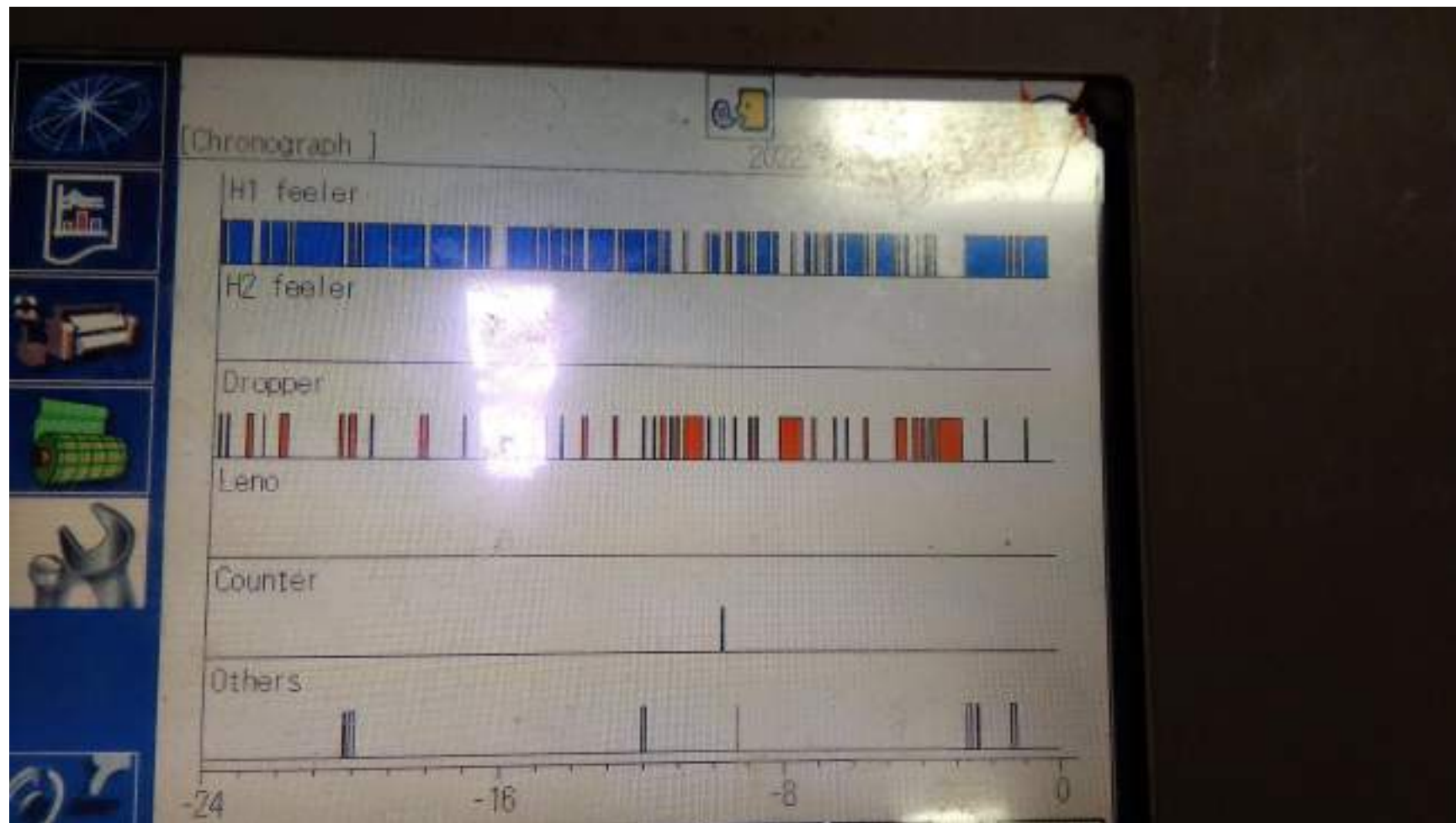
Lampiran 5 Setting Preventive

3.A SETTING PREVENTIVE KODE PRODUKSI T63 N

NO	ITEM	SETTING					
1	Cross timing	310°					
	Tinggi frame 1 & 2	107 mm					
	Tinggi frame 3 & 4	113 mm					
2	Cutter LH	20° & 2°					
3	Pin	normal	On	Off	1 <sup>st</sup>	On	Off
			70°	260°		70°	260°
			60°	180°		70°	-
			60°	170°		70°	-
4	Dropper box tinggi	2.5 - 3 cm					
	Depan, betahang	50 cm					
5	Setting timing easing	220° - 230°					
	Posisi lubang easing	Atas : Low					
		Bawah : High					
6	Jarak sub nozzle	DTY	6 - 7 cm				
		TR	7 - 8 cm				
			On	Off			
7	Setting Sub Nozzle	1	40°	160°			
		2	48°	176°			
		3	62°	188°			
		4	78°	202°			
		5	94°	218°			
		6	110°	234°			
		7	128°	250°			
		8	146°	266°			
		9	164°	280°			
		10	200°	300°			
8	RPM	800					
9	Tension lasi	1400 N					
10	Pressure	S =	3.2	M3 =	3.0	Jp 1-4 =	0.04
		M1 =	3.0	M4 =	3.0	Cp 1-4 =	0.07
		M2 =	3.0				



Lampiran 6 Hasil Pengamatan Pakan dan Lusi Putus



Lampiran 7 Box Setting Angin





Lampiran 8 Hasil Pengamatan Pakan Putus

Date	Time	Duration	Reason
1:22/03/24	11:09	0.4 min	H1 feeler C1
2:22/03/24	11:08	0.3 min	H1 feeler C3
3:22/03/24	11:04	2.1 min	H1 feeler C2
4:22/03/24	11:05	1.1 min	H1 feeler C2
5:22/03/24	11:05	1.2 min	H1 feeler C1
6:22/03/24	10:58	1.5 min	H1 feeler C3
7:22/03/24	10:58	1.2 min	H1 feeler C2
8:22/03/24	10:58	1.8 min	H1 feeler C1
9:22/03/24	10:55	1.4 min	H1 feeler C2
10:22/03/24	10:54	0.1 min	H1 feeler C2
11:22/03/24	10:53	0.2 min	H1 feeler C2
12:22/03/24	10:52	0.1 min	H1 feeler C2
13:22/03/24	10:51	1.1 min	H1 feeler C3
14:22/03/24	10:33	17.3 min	H1 feeler C1
15:22/03/24	10:32	0.1 min	H1 feeler C1
16:22/03/24	10:31	0.3 min	H1 feeler C4
17:22/03/24	10:29	1.3 min	H1 feeler C2
18:22/03/24	10:24	3.5 min	Dropper
19:22/03/24	10:22	1.1 min	H1 feeler C2

Lampiran 9 Akumulator





Lampiran 11 Kartu Pakan

MOTIF ESK  
PATRUN 362

ROT6 - 41/TS

LUSI

PAKAN

TY 150D/144

### KARTU PATRUN PAKAN KOMPUTER

MESIN <u>Alco</u>	IKT <u>ROT6</u>
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KODE PROD TP41

NO. PATRUN 0762

GEAR PICK 60

WARNA	KETERANGAN
1 FH 10	BTS AWAL
2 f=09	BODI
3 pk 06	TUMPAL
4 FS 11	BODI
	BTS AKHIR

TPL: FH / pk

TANGGAL : 17 / 02 / 22

MTC : *Setih*

$\frac{17}{2} = 8.5$

110

109

r = 27

D = 60