

DAFTAR PUSTAKA

Buku Pedoman Praktik Kerja Lapangan Akademi Komunitas Industri Tekstil dan Produk Tekstil Surakarta

Dokumen PT Dan Liris 2019

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www.danliris.com (1 Agustus 2019)(Liris, 2016)

LAMPIRAN

Lampiran 1 Realisasi Order (RO)

REALISASI ORDER PRODUKSI NON PROGRAM																																																																																																																																	
NO. RO	0500000					BUYER	PT LIFUNG RIA-ALL GYMBORE																																																																																																																										
DATE	20-May-2019					DESCRIPTION	W LS GRN RVT WHT FLAD POPLIN																																																																																																																										
ISSUE DATE	28-Apr-2019					QUANTITY	4,800 PCS																																																																																																																										
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<p>REPORT DATE: 20-MAY-2019</p> <p>REPORT TIME: 10:00 AM</p> <p>REPORT USER: JH</p> <p>REPORT FROM: PT LIFUNG RIA-ALL GYMBORE</p> <p>REPORT TO: PT LIFUNG RIA-ALL GYMBORE</p> <p>REPORT BY: JH</p>																																																																																																																																	
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<p>PRESSING: HAIR PRESS</p> <p>FOLDING: 01 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>ASSORTMENT: 01 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>02 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>03 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>04 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>05 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>06 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>07 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>08 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>09 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>10 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>11 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>12 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>13 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>14 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>15 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>16 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>17 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>18 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>19 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>20 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>21 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>22 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>23 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>24 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>25 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>26 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>27 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>28 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>29 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p> <p>30 BOYS FLAT FOLDED TANPA ACCESSORIES PACKING</p>																																																																																																																																	
<p>889 TERLAMPIR UPDATED SPECS + COMMENTS TERAKHIR + PD BUYER SFP</p> <p>DICHECK OLEH: JH 20/19</p> <p>DICHECK OLEH: JH 20/19</p> <p>DICHECK OLEH: JH 20/19</p> <p>PERIKSAAN: KABAG PENJUALAN</p> <p>MUNDASIR: JH SORIANO</p> <p>KABAG SAMPLE: RINI SETIOWATI</p> <p>20-15-18/6-01</p> <p>VALID</p>																																																																																																																																	

Sumber : PT Dan Liris, Juli 2019

Lampiran 2 Operation Breakdown (OB)

OPERATION BREAKDOWN
 PT LIFUNG INA-ALL GYMBOREE (JANIE&JACK)
 JB11400K SOLID po 327995,996,,329012,018,017
 JB11400K STRIPE
 JB11400K CHECK 329436,329437
 Boy's L/S EMBRO UNDER PLKT
 875 PCS
 59 PCS
 100% Cotton / 100% Linen
 2 AREA A
 612.31

TAMBAH PO TGL 6/2

BUYER ARTIKEL =
 STYLE TARGET PER JAM = Cutting
 MATERIAL KONFEKSI = Sewing
 TOTAL SH =

NO	URUTAN PROSES	GRADE PROSES	CYCLE TIME (DETIK)	NEW		FM-00-JE-21-001A/R2		
				SMV (MENIT)	STD HOURS	TARGET PCS/JAM	KEB OPT	100%
A CUTTING								
1	Cek marker	solid+stripe	10.12	0.27	4.48	223	3.92	
2	Gelar + persiapan material (auto cutter)	solid	10.14	0.17	2.82	395	2.46	
3	Potong + persiapan material (auto cutter)	check	27.22	0.45	7.56	132	6.62	
4	Gelar + persiapan material (manual)	stripe+check	30.05	0.50	8.35	120	7.30	
5	Potong blok + persiapan material -MATCH	stripe+check	52.30	0.87	14.53	69	12.71	
6	Bandknife material 1/s	D	13.37	0.22	3.71	269	3.25	
7	Proses Vinning L/S	D	8.71	0.15	2.42	413	2.12	
8	Bundel / ticket	D	10.00	0.17	2.76	360	2.43	
9	Bersihkan & sortir bordir KECIL	under plaket	55.63	0.93	15.45	65	13.52	
10	Numbering pakai alat 14pcs	D	16.94	0.28	4.71	213	4.12	
11	Sanggit & kepras bd dgn.lgn,sk,krah,mst,lap dgn	stripe	62.48	1.04	17.36	66	15.19	
12	Gantian BS komponen Boys L/S	check	99.14	1.65	27.54	36	24.10	
13	Lengketan+press+sortir kk daun krah,mst,lap dgn kk	check	33.53	0.56	9.31	107	8.15	
14	Proses pembikinan lapisan b.down	D	83.08	1.38	23.08	43	20.19	
15	Gelar fabric + interlining	stripe	83.67	1.39	23.24	43	20.34	
16	Press lapisan b.down	check	89.55	1.49	24.88	40	21.77	
17	Potong lapisan b.down pakai mesin	D	5.11	0.09	1.42	705	1.24	
18	TOTAL HOUR CUTTING	D	4.43	0.07	1.23	813	1.08	
19		D	2.00	0.03	0.56	1,800	0.49	
20		SOLID	286.29	4.77	79.52		59.58	
21		STRIPE	374.44	6.24	104.01		91.01	
22		CHECK	436.89	7.28	121.36		106.19	
B SEWING								
1	COLLAR	SNL_A / M	D	9.38	0.16	2.61	384	0.15
2	Heming collar-band	manual	D	12.96	0.22	3.60	278	0.21
3	Gambar collar	SC_1	D	21.87	0.36	6.08	165	0.36
4	Blaabar+kepras collar-band	PRESS_A	D	11.41	0.19	3.17	316	0.19
5	Gunting+balik+press uj collar pakai mesin	PRESS_M	D	7.31	0.12	2.03	492	0.12
6	Gosok collar-band	SNL_A / M	D	18.57	0.31	5.16	194	0.30
7	Stik collar-band 5mm	SNL_A / M	B	57.37	0.96	15.94	63	0.94
8	Der+gandeng+gunting+balik panil collar	SNL_A / M	A	73.02	1.22	20.28	49	1.20
9	Der+gandeng+gunting+balik panil collar (sggt)	SNL_A / M	D	17.80	0.30	4.94	202	0.29
10	Stik krah tengah collar 1mm	SNL_A / M	D	6.66	0.11	1.85	541	0.11
11	Cap button hole b.down k/k	manual	D	18.18	0.30	5.05	198	0.30
12	Button hole 3pcs krah	BHS	D					
II CUFF K/K								
13	Manjangi s.cuff k/k	SNL_A / M	D	10.97	0.18	3.05	328	0.18
14	Blaabar + kepras s.cuff k/k	SC_1	D	22.46	0.37	6.24	160	0.37
15	Balik (manual) round s.cuff k/k	PRESS_M	D	13.59	0.23	3.78	265	0.22
16	Stik round s.cuff 5mm k/k	SNL_A / M	C	34.88	0.58	9.69	103	0.57
17	Gosok cuff jadi k/k	PRESS_M	D	13.69	0.23	3.80	263	0.22
18	Button hole 2pcs k/k	BHS	D	12.12	0.20	3.37	297	0.20
19	B/sew crossstitching 2pcs k/k	BS	D	15.56	0.26	4.32	231	0.25
20		SOLID+STRIPE		304.78	5.08	84.66		4.99
21		CHECK		320.43	5.34	89.01		5.25
III BADANAN								
22	Bikin boxsplit pakai alat JR I (solid)	SNL_A / M	D	16.30	0.27	4.53	221	0.27
23	Jahit laid on JR II (solid)	KS	C	24.13	0.40	6.70	149	0.40
24	Bikin boxsplit pakai alat JR I (stripe)	SNL_A / M	D	21.23	0.35	5.90	170	0.35
25	Jahit laid on JR II (stripe)	KS	C	29.69	0.49	8.25	121	0.49
26	Bikin boxsplit pakai alat JR I (check)	SNL_A / M	C	26.61	0.44	7.39	135	0.44
27	Jahit laid on JR II (check)	KS	B	50.78	0.85	14.11	71	0.83

Sumber : PT Dan Liris, Juli 2019

Lampiran 3 Lembar output harian

LAPORAN OUTPUT SEWING

Tanggal / Line : 26.7.2019
 NO. RD : 121203
 ART : 121203
 QTY ORDER : 25000
 MESINA :
 POKOK :
 DPM :

SIZE	QTY	M ²	JAM REGULAR								TOTAL REG	Jam Lembur			TOTAL REG+OT	KET		
			1	2	3	4	5	6	7	8		9	10	11				
30	20	20																
32	20	20																
34	20	20																
36	20	20																
38	20	20																
40	20	20																
42	20	20																
44	20	20																
46	20	20																
48	20	20																
50	20	20																
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84	20	20																
86	20	20																
88	20	20																
90	20	20																
92	20	20																
94	20	20																
96	20	20																
98	20	20																
100	20	20																
TOTAL	2000	2000																

Sumber : PT Dan Liris, Juli 2019

Lampiran 4 Catatan perawatan mesin

CATATAN PERAWATAN MESIN

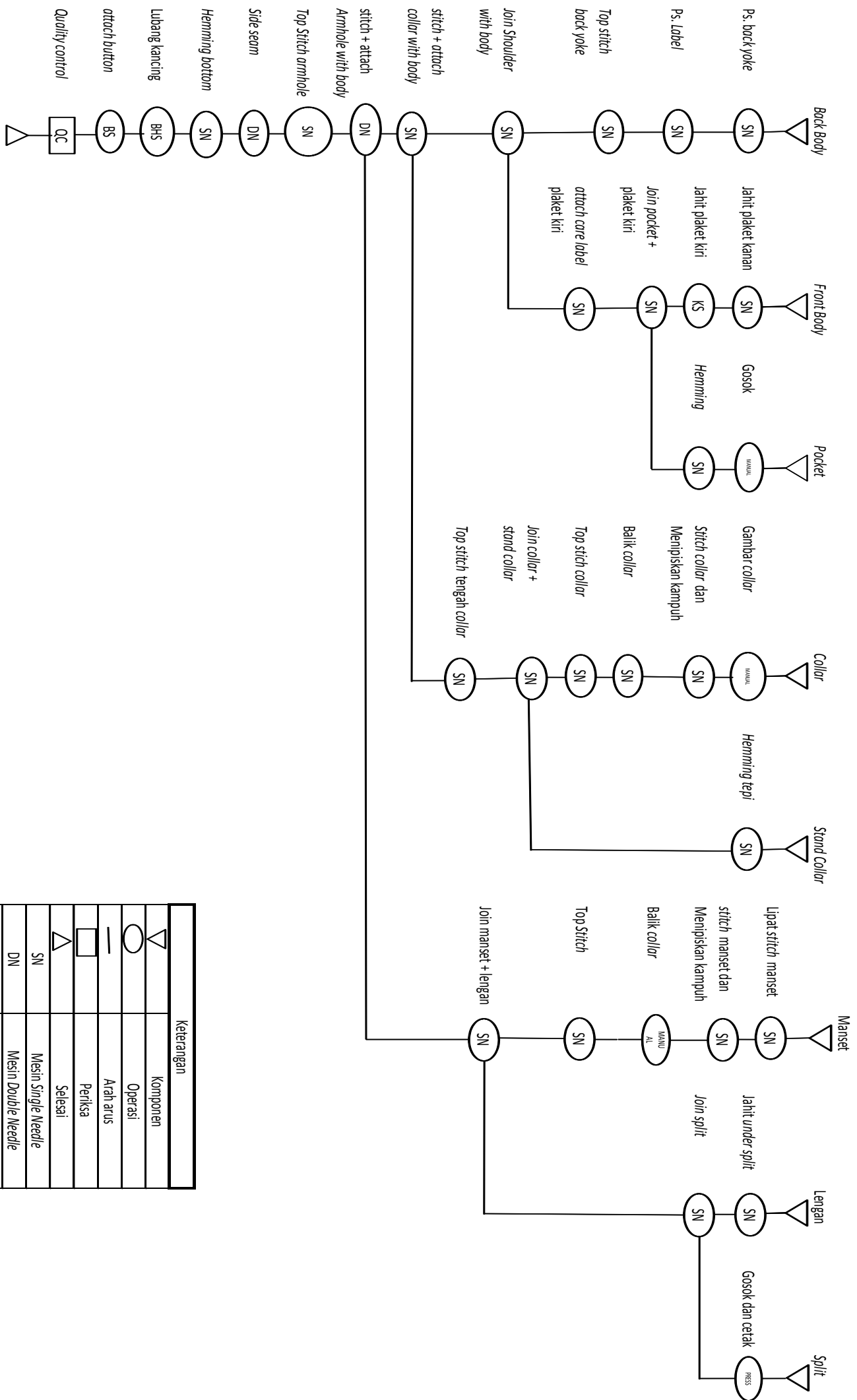
Seri Mesin : Yamato
 No. Inventaris Mesin : 00-56-03
 FM-00-ME-07-003

Tahun	Rencana Tgl.	TIANG BENANG TIDAK GOYANG	TAKE UP SPRING BEFUNGSI DGN BENAR	KETINGGIAN GIGI & TEKANAN SEPATU	DYNAMOS ERVO BERPUTAR DGN BAIK	ITEM YANG DI CEK	KARBUK & POKOK MESIN TIDAK RUMAK	OLI & GREASE HARUS CUKUP	PELUMBUNG JARUM & PERUBAHAN AL SEBUK BERSUDUT DGN BENAR	KABEL HARUS RAPI & TIDAK TERKELUPAK	Tgl. Pelaksanaan	Tanda Tangan Mekanik	Td. Tpt. Pimpinan Mekanik	Ket.
Jan	25	✓	✓	✓	✓	✓	✓	✓	✓	✓	25	[Signature]	[Signature]	
Feb	28	✓	✓	✓	✓	✓	✓	✓	✓	✓	28	[Signature]	[Signature]	
Mar	28	✓	✓	✓	✓	✓	✓	✓	✓	✓	28	[Signature]	[Signature]	
Apr	25	✓	✓	✓	✓	✓	✓	✓	✓	✓	25	[Signature]	[Signature]	
Mei	20	✓	✓	✓	✓	✓	✓	✓	✓	✓	20	[Signature]	[Signature]	
Jun	28	✓	✓	✓	✓	✓	✓	✓	✓	✓	28	[Signature]	[Signature]	
Jul	25	✓	✓	✓	✓	✓	✓	✓	✓	✓	25	[Signature]	[Signature]	
Ags	27										27	[Signature]	[Signature]	
Sep	25													
Okt	24													
Nop	27													
Des	20													

Untuk JENIS Mesin → Jahit Jarum satu lock stitch, Jarum satu chain stitch, Jarum dua chain stitch, Kansay, Obras, Over Deck, Picot, Blind Stitch, Zig Zag.

Sumber : PT Dan Liris, Juli 2019

Lampiran 6 Operation Process chart (OPC)



Keterangan	
▽	Komponen
○	Operasi
—	Arah arus
□	Periksa
△	Selesai
SN	Mesin Single Needle
DN	Mesin Double Needle
MANUAL	Manual
PRESS	Mesin Press
BHS	Mesin Lubang Kancing
BS	Mesin Pasang Kancing
KS	Mesin Kansai