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# LAMPIRAN

LAMPIRAN 1 Tata letak mesin departemen *spinning*



LAMPIRAN 2 Tetap roda gigi NW1 dan NW2 pada mesin drawing finisher

**Werk Ingolstadt**  
Ingenieurmaschinenbau AG

**GETRIEBEPLAN**

RSB 851 - 413

Teil-Liste  
Indikations-Form

$VZG = \frac{D_{94} \times 22}{D_{28} \times 51} = 1.4482 \times \frac{W1}{W2}$ 
 $VWZ = \frac{D_{50} \times W1 \times 40}{D_{80} \times 60 \times 50} = 0.00694 \times W1$ 
 $VE = \frac{D_{30} \times 37 \times W8 \times 51}{D_{94} \times 37 \times W9 \times 22} = 0.7398 \times \frac{W8}{W9}$

W 1	27	28	29	D5 = $\phi$ 28	VV = $\phi$ W4 $\phi$ 30	VV' = $\phi$ W4 $\phi$ 28	W 8	76	77	78	79
W 2	39	40	41				Gestell	W 9	56	57	58
VZG	1.003	1.014	1.024				VE	1.004	0.999	0.995	0.986

$\phi$ W 4	(31.6)	34.8	38.3	42.2	(46.4)	51	(56.1)	(61.7)
VV $\phi$ 30	1.05	1.16	1.28	1.41	1.55	1.70	1.87	2.06
VV' ( $\phi$ 28)	1.13	1.24	1.36	1.50	1.66	1.82	2.00	2.20

W 1	143.9	145.3	146.7	148.1	149.5	D5 = $\phi$ 50
VWZ	0.999	1.008	1.018	1.028	1.038	Wolz.-Zufuhr

$$V = \frac{D_{40} \times \phi 114.6 \times 100 \times 1 \times Nw2 \times 37}{D_{30} \times \phi 89.1 \times 38 \times 0.75 \times Nw1 \times 37} = 6.017 \times \frac{Nw2}{Nw1}$$

4 - Fach				6 - Fach				8 - Fach				10 - Fach			
Riemens: TB LW 1248 B20				Riemens: TB LW 1304 B20				Riemens: TB LW 1304 B20				Riemens: TB LW 1248 B20			
Nw 1	Nw 2			Nw 1	Nw 2			Nw 1	Nw 2			Nw 1	Nw 2		
	37	44	V		52	58	V		52	46	V		41	35	V
62	3.59			66	4.74	(55)	5.71	56	6.48	(59)	7.72	56	8.22		
(61)	3.65			(65)	4.81	56	5.81	(57)	6.60	60	7.85	(57)	8.37		
60	3.71	4.41		64	4.89	(57)	5.91	58	6.71	(61)	7.98	58	8.51	9.97	
(59)	3.77	4.48		(63)	4.97	58	6.02	(59)	6.83	62	8.11	(59)	8.66		
58	3.84	4.57		62	5.05	(59)	6.12	60	6.94	(63)	8.24	60	8.81	10.32	
(57)	3.90	4.64		(61)	5.12	60	6.22	(61)	7.06	64	8.37	(61)	8.95	10.49	
56	3.98	4.73		60	5.22	(61)	6.33	62	7.17	(65)	8.50	62	9.10	10.66	
(55)	4.04	4.81		(59)	5.30	62	6.43	(63) /	7.29	66	8.63	(63)	9.25	10.83	
54	4.12	4.90		58	5.40	(63)	6.54	64	7.41	(67)	8.76	64	9.39	11.00	
(53)	4.20	4.99		(57)	5.49	64	6.64	(65)	7.52	68	8.90	(65)	9.54	11.17	
52	4.28	5.09		56	5.59	(65)	6.74	66	7.64	(69)	9.03	66	9.69	11.35	
(51)	4.36	5.19				66	6.85			70	9.16	(67)	9.83	11.52	
50		5.30										68	10.13	11.69	

$\phi$ W 3	56.6	57.2	57.8	58.3	58.9	VA = $\frac{D_{55} \times \phi 89.1 \times \phi W3}{D_{40} \times \phi 140.2 \times \phi 50} = 0.0175 \times \phi W3$
VA	0.99	1.00	1.01	1.02	1.03	

$\phi$ DM 50/60 Hz	109	96	124	109	136	121	147	132	157	142	165	150
$\phi$ DA 50/60 Hz	207	218	195	207	184	197	174	187	164	179	157	171
L m/min.		250		300		350		400		450		500

$\phi$ DM 50/60 Hz	173	159	179	165	185	171	190	177	195	182	200	187
$\phi$ DA 50/60 Hz	148	164	141	157	135	150	129	143	123	138	118	133
L m/min.		550		600		650		700		750		800

n. Coller  
n. Kennzahlen =  $\frac{123 \cdot 767}{45} \times \frac{x \cdot x \cdot \phi Dw2}{x \cdot \phi Dw1}$

$\phi$ DK	225 (97)	250 (147)	400 (116)	450 (118)	500 (120)	600 (124)	800 (137)	900 (136)	1000 (140)
$\phi$ BK	29	29	29	29	29	29	29	29	29
$\phi$ A	140	220	214	252	286	300	320	316	380
$\phi$ Dw 1	280	278	278	306	311	358	361	364	361
$\phi$ Dw 2	118	115	118	116	111	111	113	109	102
$\phi$	1.45	1.61	1.60	1.49	1.41	1.36	1.30	1.22	1.15

$\phi$ Dw 3		1387	1437	1537	1662	1387	1437	1537
$\phi$ Dw 4	1262							
$\phi$ S	42	42	53	29	34	42	24	29
$\phi$	37	60	57	69	88	77	70	85
Coller	225	250	400	450	500	600	800	900
Gr. 4	6.02	6.02	6.02	6.02	6.02	6.02	6.02	6.02
Gr. 5	11.95	18.2	18.7	21.8	25.8	22.4	21.4	24.2
$\phi$ last	21.9	20.7	21.2	19.9	21.8	20.6	24.6	22.4

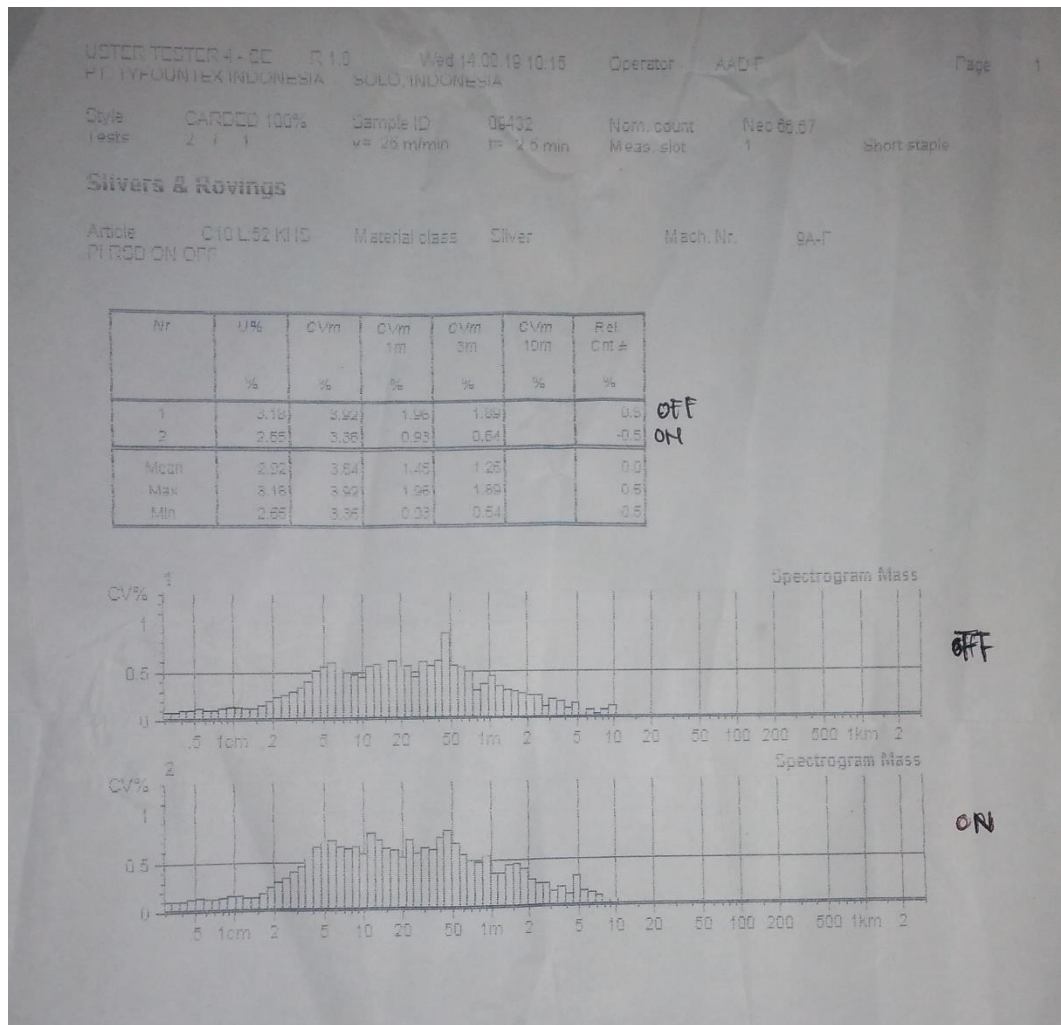
  

Max. Drehm.	95.02	ME 129	Gr. 4	6.02	Gr. 5	11.95	Gr. 6	18.2	Gr. 7	21.8	Gr. 8	25.8	Gr. 9	22.4	Gr. 10	21.4	Gr. 11	24.2	Gr. 12	24.6	Gr. 13	22.4	Gr. 14	21.8	Gr. 15	21.8	Gr. 16	20.6	Gr. 17	24.6	Gr. 18	22.4	Gr. 19	21.8	Gr. 20	21.8	Gr. 21	20.6	Gr. 22	24.6	Gr. 23	22.4	Gr. 24	21.8	Gr. 25	21.8	Gr. 26	20.6	Gr. 27	24.6	Gr. 28	22.4	Gr. 29	21.8	Gr. 30	21.8	Gr. 31	20.6	Gr. 32	24.6	Gr. 33	22.4	Gr. 34	21.8	Gr. 35	21.8	Gr. 36	20.6	Gr. 37	24.6	Gr. 38	22.4	Gr. 39	21.8	Gr. 40	21.8	Gr. 41	20.6	Gr. 42	24.6	Gr. 43	22.4	Gr. 44	21.8	Gr. 45	21.8	Gr. 46	20.6	Gr. 47	24.6	Gr. 48	22.4	Gr. 49	21.8	Gr. 50	21.8	Gr. 51	20.6	Gr. 52	24.6	Gr. 53	22.4	Gr. 54	21.8	Gr. 55	21.8	Gr. 56	20.6	Gr. 57	24.6	Gr. 58	22.4	Gr. 59	21.8	Gr. 60	21.8	Gr. 61	20.6	Gr. 62	24.6	Gr. 63	22.4	Gr. 64	21.8	Gr. 65	21.8	Gr. 66	20.6	Gr. 67	24.6	Gr. 68	22.4	Gr. 69	21.8	Gr. 70	21.8	Gr. 71	20.6	Gr. 72	24.6	Gr. 73	22.4	Gr. 74	21.8	Gr. 75	21.8	Gr. 76	20.6	Gr. 77	24.6	Gr. 78	22.4	Gr. 79	21.8	Gr. 80	21.8	Gr. 81	20.6	Gr. 82	24.6	Gr. 83	22.4	Gr. 84	21.8	Gr. 85	21.8	Gr. 86	20.6	Gr. 87	24.6	Gr. 88	22.4	Gr. 89	21.8	Gr. 90	21.8	Gr. 91	20.6	Gr. 92	24.6	Gr. 93	22.4	Gr. 94	21.8	Gr. 95	21.8	Gr. 96	20.6	Gr. 97	24.6	Gr. 98	22.4	Gr. 99	21.8	Gr. 100	21.8	Gr. 101	20.6	Gr. 102	24.6	Gr. 103	22.4	Gr. 104	21.8	Gr. 105	21.8	Gr. 106	20.6	Gr. 107	24.6	Gr. 108	22.4	Gr. 109	21.8	Gr. 110	21.8	Gr. 111	20.6	Gr. 112	24.6	Gr. 113	22.4	Gr. 114	21.8	Gr. 115	21.8	Gr. 116	20.6	Gr. 117	24.6	Gr. 118	22.4	Gr. 119	21.8	Gr. 120	21.8	Gr. 121	20.6	Gr. 122	24.6	Gr. 123	22.4	Gr. 124	21.8	Gr. 125	21.8	Gr. 126	20.6	Gr. 127	24.6	Gr. 128	22.4	Gr. 129	21.8	Gr. 130	21.8	Gr. 131	20.6	Gr. 132	24.6	Gr. 133	22.4	Gr. 134	21.8	Gr. 135	21.8	Gr. 136	20.6	Gr. 137	24.6	Gr. 138	22.4	Gr. 139	21.8	Gr. 140	21.8	Gr. 141	20.6	Gr. 142	24.6	Gr. 143	22.4	Gr. 144	21.8	Gr. 145	21.8	Gr. 146	20.6	Gr. 147	24.6	Gr. 148	22.4	Gr. 149	21.8	Gr. 150	21.8	Gr. 151	20.6	Gr. 152	24.6	Gr. 153	22.4	Gr. 154	21.8	Gr. 155	21.8	Gr. 156	20.6	Gr. 157	24.6	Gr. 158	22.4	Gr. 159	21.8	Gr. 160	21.8	Gr. 161	20.6	Gr. 162	24.6	Gr. 163	22.4	Gr. 164	21.8	Gr. 165	21.8	Gr. 166	20.6	Gr. 167	24.6	Gr. 168	22.4	Gr. 169	21.8	Gr. 170	21.8	Gr. 171	20.6	Gr. 172	24.6	Gr. 173	22.4	Gr. 174	21.8	Gr. 175	21.8	Gr. 176	20.6	Gr. 177	24.6	Gr. 178	22.4	Gr. 179	21.8	Gr. 180	21.8	Gr. 181	20.6	Gr. 182	24.6	Gr. 183	22.4	Gr. 184	21.8	Gr. 185	21.8	Gr. 186	20.6	Gr. 187	24.6	Gr. 188	22.4	Gr. 189	21.8	Gr. 190	21.8	Gr. 191	20.6	Gr. 192	24.6	Gr. 193	22.4	Gr. 194	21.8	Gr. 195	21.8	Gr. 196	20.6	Gr. 197	24.6	Gr. 198	22.4	Gr. 199	21.8	Gr. 200	21.8	Gr. 201	20.6	Gr. 202	24.6	Gr. 203	22.4	Gr. 204	21.8	Gr. 205	21.8	Gr. 206	20.6	Gr. 207	24.6	Gr. 208	22.4	Gr. 209	21.8	Gr. 210	21.8	Gr. 211	20.6	Gr. 212	24.6	Gr. 213	22.4	Gr. 214	21.8	Gr. 215	21.8	Gr. 216	20.6	Gr. 217	24.6	Gr. 218	22.4	Gr. 219	21.8	Gr. 220	21.8	Gr. 221	20.6	Gr. 222	24.6	Gr. 223	22.4	Gr. 224	21.8	Gr. 225	21.8	Gr. 226	20.6	Gr. 227	24.6	Gr. 228	22.4	Gr. 229	21.8	Gr. 230	21.8	Gr. 231	20.6	Gr. 232	24.6	Gr. 233	22.4	Gr. 234	21.8	Gr. 235	21.8	Gr. 236	20.6	Gr. 237	24.6	Gr. 238	22.4	Gr. 239	21.8	Gr. 240	21.8	Gr. 241	20.6	Gr. 242	24.6	Gr. 243	22.4	Gr. 244	21.8	Gr. 245	21.8	Gr. 246	20.6	Gr. 247	24.6	Gr. 248	22.4	Gr. 249	21.8	Gr. 250	21.8	Gr. 251	20.6	Gr. 252	24.6	Gr. 253	22.4	Gr. 254	21.8	Gr. 255	21.8	Gr. 256	20.6	Gr. 257	24.6	Gr. 258	22.4	Gr. 259	21.8	Gr. 260	21.8	Gr. 261	20.6	Gr. 262	24.6	Gr. 263	22.4	Gr. 264	21.8	Gr. 265	21.8	Gr. 266	20.6	Gr. 267	24.6	Gr. 268	22.4	Gr. 269	21.8	Gr. 270	21.8	Gr. 271	20.6	Gr. 272	24.6	Gr. 273	22.4	Gr. 274	21.8	Gr. 275	21.8	Gr. 276	20.6	Gr. 277	24.6	Gr. 278	22.4	Gr. 279	21.8	Gr. 280	21.8	Gr. 281	20.6	Gr. 282	24.6	Gr. 283	22.4	Gr. 284	21.8	Gr. 285	21.8	Gr. 286	20.6	Gr. 287	24.6	Gr. 288	22.4	Gr. 289	21.8	Gr. 290	21.8	Gr. 291	20.6	Gr. 292	24.6	Gr. 293	22.4	Gr. 294	21.8	Gr. 295	21.8	Gr. 296	20.6	Gr. 297	24.6	Gr. 298	22.4	Gr. 299	21.8	Gr. 300	21.8	Gr. 301	20.6	Gr. 302	24.6	Gr. 303	22.4	Gr. 304	21.8	Gr. 305	21.8	Gr. 306	20.6	Gr. 307	24.6	Gr. 308	22.4	Gr. 309	21.8	Gr. 310	21.8	Gr. 311	20.6	Gr. 312	24.6	Gr. 313	22.4	Gr. 314	21.8	Gr. 315	21.8	Gr. 316	20.6	Gr. 317	24.6	Gr. 318	22.4	Gr. 319	21.8	Gr. 320	21.8	Gr. 321	20.6	Gr. 322	24.6	Gr. 323	22.4	Gr. 324	21.8	Gr. 325	21.8	Gr. 326	20.6	Gr. 327	24.6	Gr. 328	22.4	Gr. 329	21.8	Gr. 330	21.8	Gr. 331	20.6	Gr. 332	24.6	Gr. 333	22.4	Gr. 334	21.8	Gr. 335	21.8	Gr. 336	20.6	Gr. 337	24.6	Gr. 338	22.4	Gr. 339	21.8	Gr. 340	21.8	Gr. 341	20.6	Gr. 342	24.6	Gr. 343	22.4
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LAMPIRAN 3 Bagian *drawing finisher* yang mengatur nilai *autolevelling*



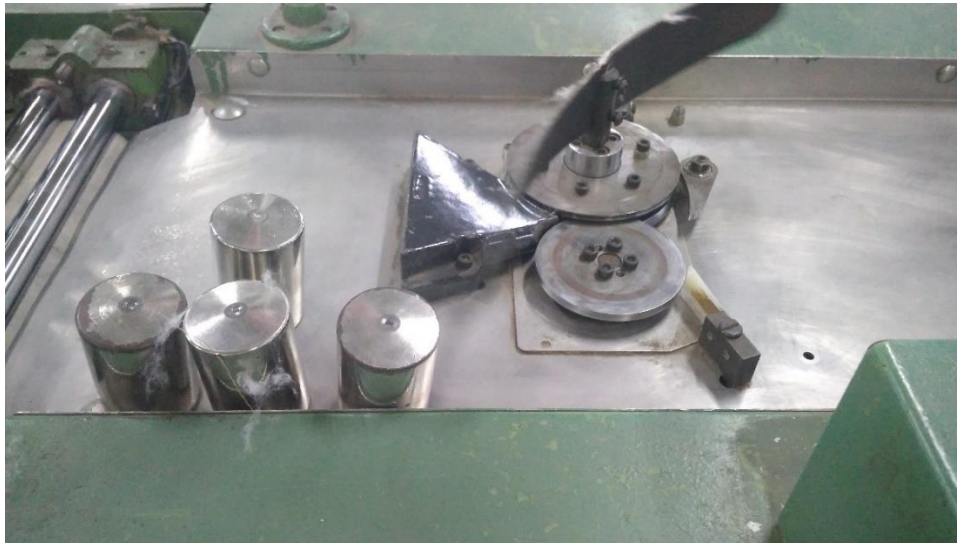
LAMPIRAN 4 Hasil pengujian  $U\%$  dan grafik spektrogram



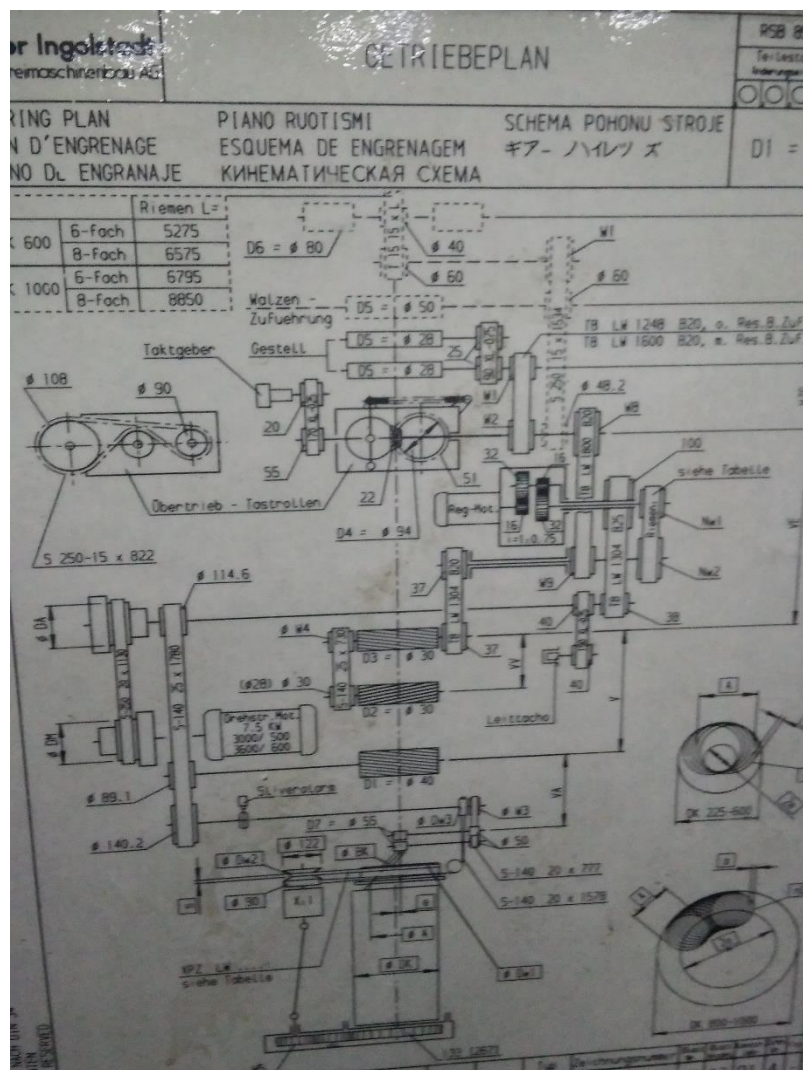
LAMPIRAN 5 Pasangan NW1 dan NW2 yang terpasang



### LAMPIRAN 6 Autolevelling




### LAMPIRAN 7 Gearing diagram RSB 851



(U %) pada Mesin *Drawing Finisher* Type RSB D-851

Pembimbing

: Mokh. Afifuddin, ST., MT.

PERTEMUAN KE	MATERI BIMBINGAN	PARAF
1	BAB I PENDAHULUAN	
2	REVISI BAB I SESUAI Kaidah Kalimat	
3	REVISI LANJUTAN BAB I DENGAN REDAKSI DAN SITASI	
4	BAB II PROGRESS LANJUTAN	
5	BAB III PROGRESS LANJUTAN	
6	Kaidah Penulisan Laporan (via Zoom)	
7	REVISI BAB III (KONSISTENSI PENULISAN & SPASI)	
8	KONSULTASI LAPORAN BAB I SAMPAI BAB IV (LANGSUNG DI KAMPUS)	
9	REVISI BAB IV DAN PROGRESS LANJUTAN BAB V (PEMBETULAN DIAGRAM FISHBONE DAN PENJELASAN)	
10	PROGRESS SELURUH LAPORAN DENGAN RINGKASAN DAN LAMPIRAN	

Surakarta, 09 / Juli / 2020

Pembimbing,

Acc TA  
9/7/2020  
Mokh Afifuddin

(Mokh. Afifuddin, ST., MT.)



# FORMULIR

Kode Dokumen  
Revisi

Tanggal Terbit  
Halaman

## LEMBAR PERBAIKAN LAPORAN PKL

Dengan ini dinyatakan bahwa Laporan Praktik Kerja Lapangan dari:

Nama : Aad Fatkur Ilma

NIM : 1801080

Program Studi : Teknik Pembuatan Benang

Judul Laporan PKL : Analisa Penggunaan *Autolevelling* dan Tanpa *Autolevelling* Dilihat dari Hasil Bahan yang Keluar Terhadap Penyimpangan CV% Berat (*Grains/6 Yards*) dan Ketidakrataan (*U %*) pada Mesin *Drawing Finisher Type RSB D-851*

telah diperbaiki sesuai dengan saran perbaikan dari ketua penguji, pembimbing, dan penguji.

Mengetahui

No	Posisi Reviewer	Nama Reviewer	Tanggal Perbaikan	Tanda Tangan
1	Ketua Penguji	Muas Turyono, S.Teks., M.M.	25/07/2020	<p>Acc TA nama : Aad Fatkur 1801080 (Muas Turyono)</p>
2	Pembimbing	Mokh. Afifuddin, ST., MT.	23/07/2020	<p>Acc TA Aad Fatkur Ilma 23/07/2020 Mokh Afifuddin</p>
3	Penguji	Agus Ardiyanto, S.Pd.	29/07/2020	<p>29/2020 7</p>