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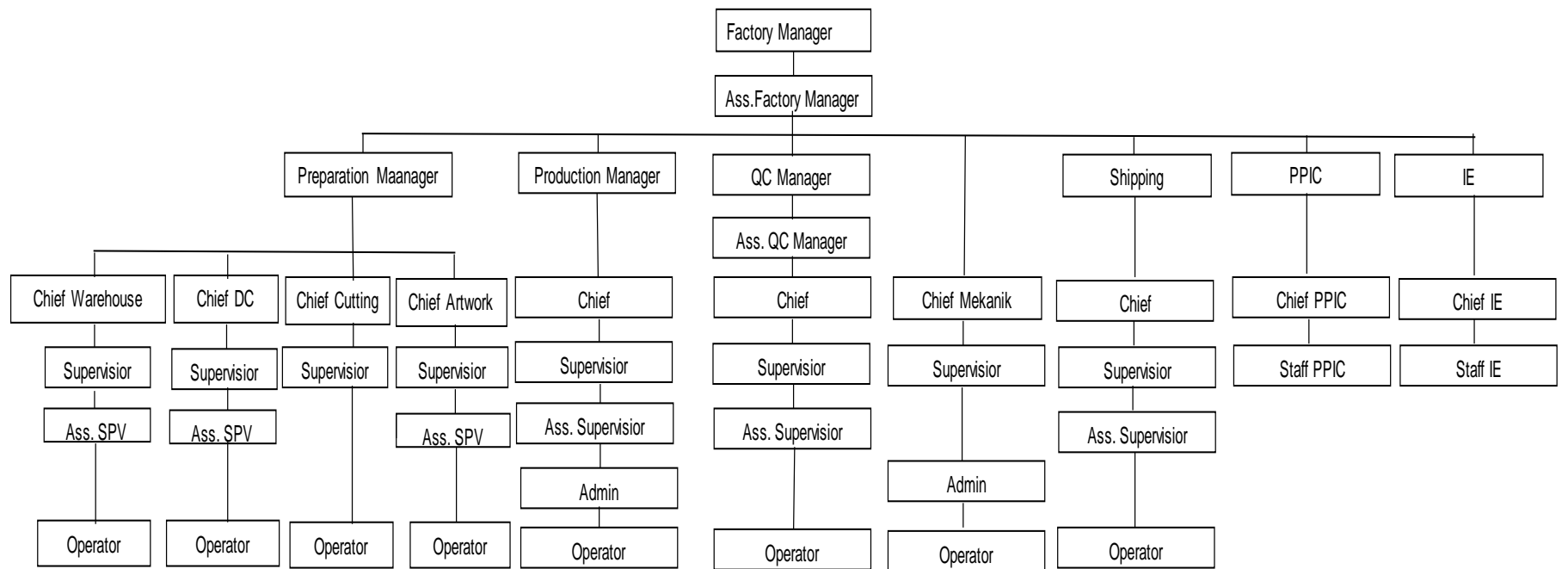
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LAMPIRAN

Lampiran 1 Struktur Organisasi PT Prima Sejati Sejahtera 1



Lampiran 2 Barchart sebelum improvement proses

LINE ALANCING WORKSHEET				
NO	Machine	style: F19020JKTM202	Proses cycle time(sec)	tack time
		product: PADDED JACKET		
operation description				
1	NMC	Marking back body + back pocket	28	106
2	SNL	join side seam lining + tack inside tape	84	
3	SNL	stitch close colar+tack draw cord+join hood to body lining	105	
4	SNL	join raglan sleeve to back body	117	
5	SNL	stitch close colar+tack draw cord+join hood to body lining	77	
6	SNL	stitch close colar+tack draw cord+join hood to body lining	80	
7	SNL	opening back pocket+attach zip to back pocket	84	
8	OM3	overlock layer back pocket+side seam	90	
9	BTK	bartack zip pocket+drawcord good	53	
10	SNL	join welt pocket to front body	92	
11	NMC/SNL	cut break corner+stitch welt side pocket	93	
12	SNL	join knuckle to side pocket	80	
13	SNL	join palm to side pocket	85	
14	SNL	stitch 1/16 knuckle+tack inside pocket	95	
15	BTK	bartack side pocket	79	
16	SNL	join hood to body shell	96	
17	OM3	overlock inside collar	44	
18	OM3	stitch close padd w quilt + cut separate front body	96	
19	SNL	join side seam sleeve lining+tack inside	76	
20	SNL	tack elastic cuff	67	
21	DNL	stitch elastic cuff	73	
22	SNL	stitch facing knuckle	55	
23	SNL	insert drawcord	92	
24	NMC	tack draw cord	64	
25	SNL	stitch zip back pocket+stitch 1/16 inside zip	95	
26	SNL	join pocket back+stitch decorative+stitch close	124	
27	SNL	join pocket back+stitch decorative+stitch close	156	
28	OM5	join side seam sleeve shell	96	
29	SNL	attach zip to side pocket	69	
30	OM3	join raglan sleeve	85	
31	STM	steam welt pocket and interlining	42	
32	SNL	att zipp to center front facing 70 cm	89	
33	SNL	att zip and tack side pocket tack tabel	84	
34	NMC	marking for hem front and back	97	
35	SNL	join facing hem	90	
36	SNP	attach snap to facing hem	78	
37	SNL&NMC	bartack drawcord	51	
38	BTK	bartack drawcord, insert drawcord to stopper	78	
39	NMC	marking for hem padd	66	
40	SNL	JOIN HEM PADD TO SHELL	68	
41	SNC	cut allowance and stitch close padd hem	91	
42	SNL	stitch facing hem	85	
43	SNL	hem sleeve lining and shell	97	
44	SNL	stitch close hem sleeve	101	
45	SNL	match poin bottom	104	
46	SNL	tack collar. Stitch close front body match to collar	97	
47	SNL	tack collar. Stitch close front body match to collar	71	
48	SNL	tack collar. Stitch close front body match to collar	52	
49	SNL	stitch zip front body	84	
50	SNL	stitch zip front body	74	
51	SNL	tack tape armpit sleeve hood	76	
52	SNL	top stitch facing hood	84	
53	BTK	bartack front zipp	66	
54	NMC	trun trough	62	
55	SNL	stitch lining sleeve	89	

Lampiran 3 Barchart sesudah improvement proses

LINE ALANCING WORKSHEET				
NO	Machine	style: F19020JKTM202	Proses cycle time(sec)	tack time
		product: PADDED JACKET		
		operation description		
1	NMC	Marking back body + back pocket	28	106
2	SNL	join side seam lining + tack inside tape	97	
3	SNL	stitch close colar+tack draw cord+join hood to body lining	68	
4	SNL	join raglan sleeve to back body	76	
5	SNL	stitch close colar+tack draw cord+join hood to body lining	61	
6	SNL	stitch close colar+tack draw cord+join hood to body lining	77	
7	SNL	opening back pocket+attach zip to back pocket	80	
8	OM3	overlock layer back pocket+side seam	84	
9	BTK	bartack zip pocket+drawcord good	90	
10	SNL	join welt pocket to front body	53	
11	NMC/SNL	cut break corner+stitch welt side pocket	92	
12	SNL	join knuckle to side pocket	93	
13	SNL	join palm to side pocket	80	
14	SNL	stitch 1/16 knuckle+tack inside pocket	85	
15	BTK	bartack side pocket	95	
16	SNL	join hood to body shell	79	
17	OM3	overlock inside collar	96	
18	OM3	stitch close padd w quilt + cut separate front body	96	
19	SNL	join side seam sleeve lining+tack inside	76	
20	SNL	tack elastic cuff	67	
21	DNL	stitch elastic cuff	73	
22	SNL	stitch facing knuckle	55	
23	SNL	insert drawcord	92	
24	NMC	tack draw cord	64	
25	SNL	stitch zip back pocket+stitch 1/16 inside zip	95	
26	SNL	join pocket back+stitch decorative+stitch close	124	
27	SNL	join pocket back+stitch decorative+stitch close	156	
28	OM5	join side seam sleeve shell	96	
29	SNL	attach zip to side pocket	69	
30	OM3	join raglan sleeve	85	
31	STM	steam welt pocket and interlining	42	
32	SNL	att zipp to center front facing 70 cm	89	
33	SNL	att zip and tack side pocket tack tabel	84	
34	NMC	marking for hem front and back	97	
35	SNL	join facing hem	90	
36	SNP	attach snap to facing hem	78	
37	SNL&NMC	bartack drawcord	51	
38	BTK	bartack drawcord, insert drawcord to stopper	78	
39	NMC	marking for hem padd	66	
40	SNL	JOIN HEM PADD TO SHELL	68	
41	SNC	cut allowance and stitch close padd hem	91	
42	SNL	stitch facing hem	85	
43	SNL	hem sleeve lining and shell	97	
44	SNL	stitch close hem sleeve	101	
45	SNL	match poin bottom	104	
46	SNL	tack collar. Stitch close front body match to collar	97	
47	SNL	tack collar. Stitch close front body match to collar	71	
48	SNL	tack collar. Stitch close front body match to collar	52	
49	SNL	stitch zip front body	84	
50	SNL	stitch zip front body	74	
51	SNL	tack tape armpit sleeve hood	76	
52	SNL	top stitch facing hood	84	
53	BTK	bartack front zipp	66	
54	NMC	trun trough	62	
55	SNL	stitch lining sleeve	89	

Lampiran 4 *Presser foot standar*



Lampiran 5 *Presser foot silinder*

