

LAMPIRAN

Lampiran 1

Form penambahan dan pengurangan mesin *short pant style A3T2U*

FORM PENAMBAHAN DAN PENGURANGAN MESIN

No. Dokumen : FM-PRD-12.R.00#17-03-2015
 Style : A3T2U
 Deskripsi : SHORT PANT
 Jumlah Mesin Yang dibutuhkan : 47 pcs
 Digunakan di Line :

 Tanggal Mulai :
 Tanggal selesai :
 Hari yang tersedia :
 QUANTITY :

Daftar Kebutuhan Mesin Sheet1

Kode Mesin	Jenis Mesin	Jumlah	Yang sudah ada di line		Aktual	Cek list
SNL	Jarum 1	27				
SNC	Jarum 1 side cutter	0				
SNF	Jarum 1 dengan corong	0				
DNL	Jarum 2	5				
DNF	Jarum 2 dengan corong	0				
OM3	Obras benang 3	10				
OM4	Obras benang 4	0				
OM5	Obras benang 5	0				
OM6	Obras benang 6	0				
KNS	Kansai	1				
KNF	Kansai dengan corong	0				
KMP	Kamput	0				
KMF	Kamput dengan corong	0				
BHM	Lobang kancing	1				
BAM	Pasang kancing	0				
SNP	SNAP	0				
BTK	Bartack	3				
MH1	Jarum 1 chainstitch	0				
MH2	Jarum 2 chainstitch	0				
VCM	Mesin pasang velcro	0				
SSM	Mesin seam seal	0				
HNP	Hand Press	0				
WAISONG	Waisong	0				
MH3	Jarum 3 chainstitch	0				
		0				
TOTAL		47	0			

Dibuat oleh	Mengetahui	Menyetujui	
.....
Teknisi IE	IE Manager	PM	Mech. Manager

Note :

Lampiran 3

Operation Process Chart Short Pant Style A3T2U

OPERATION PROCESS CHART (OPC)				INDONESIA		LINE BALANCING						
FM-IE-08.R.00#17-03-2015				INGGRES		% Allowance	19.4%					
Style / Buyer		A3T2U / TNF		GSD REF. CODE		NVA (sec.)	NVAN (sec.)	VA (sec.)	CT (sec.)	% Adjust.	SMV (Min.)	Layout Group
Created date / By		15-Nov-18 / MIMIN										
Rev.No/Date												
Description		SHORT PANT / PPS										
Part	Process Code	PROCESS DESCRIPTION	M/C	GSD REF. CODE	NVA (sec.)	NVAN (sec.)	VA (sec.)	CT (sec.)	% Adjust.	SMV (Min.)	Layout Group	
FRONT BODY (PANT)	A1	MRKG FR BODY WITH SIDE PKT 2 2	NMC	JFM005	19	0	0	19	20.0%	0.380	1	
FRONT BODY (PANT)	A2	STITCH FC PALM SIDE PKT 2 1	SNL	POS035	17	0	5	23	20.3%	0.454	1	
FRONT BODY (PANT)	A3	STITCH CLOSE GUSSET SIDE PKT 2 2	SNL	FLS010	24	0	4	28	20.3%	0.570	1	
FRONT BODY (PANT)	A4	JOIN FC WELT + GUSSET TO FBY W ACRILIC + SET 2 2	SNL	POJ178	42	0	3	45	11.6%	0.830	1	
FRONT BODY (PANT)	A5	STITCH EDGE WELT SIDE PKT 0.8 2	SNL	POS053	28	0	6	35	20.4%	0.695	1	
FRONT BODY (PANT)	A6	HEM WELT PATCH POCKET 20 CM 2.5 1	SNL	POH001	34	0	3	37	21.9%	0.748	1	
FRONT BODY (PANT)	A7	OVERLOCK LAYER PALM/KNUCKLE 15 CM 2 2	OM3	POO012	10	0	5	15	20.0%	0.294	1	
FRONT BODY (PANT)	A8	TACK PALM TO SIDE POCKET 10 CM 1 1	SNL	POT001	25	0	6	31	19.5%	0.613	1	
FRONT BODY (PANT)	A9	STITCH DECORATIVE PKT. POINTED 50 CM 2L 1.5 1	DNL	POS070	77	0	15	92	20.3%	1.835	1	
FRONT BODY (PANT)	A10	JN FRONT RISE 38 CM 1 1	SNL	PFJ007	13	0	3	17	19.6%	0.330	1	
FRONT BODY (PANT)	A11	OLLAYER FRONT RISE 28 CM 2X (WOVEN) 1 2	OM3	PFO009	8	0	3	10	20.0%	0.208	1	
FRONT BODY (PANT)	A12	STCH FRONT RISE (SNL) 38 CM 1 1	DNL	PFS005	13	0	5	18	21.2%	0.360	1	
FRONT BODY (PANT)	A13	JOIN GUSSET TO FBY 1 1	SNL	SAJ024	21	0	6	27	19.6%	0.535	1	
FRONT BODY (PANT)	A14	OVERLOCK GUSSET TO FBY 0.8 1	OM3	SOO001	10	0	12	22	21.2%	0.440	1	
FRONT BODY (PANT)	A15	STITCH GUSSET FBY 1 2	SNL	SAS016	25	0	12	37	20.9%	0.748	1	
BACK BODY (PANT)	B1	MARKING POSITION BACK PATCH POCKET (WOVEN) 1.5 2	NMC	PBM007	19	0	0	19	18.3%	0.365	1	
BACK BODY (PANT)	B2	STITCH FC PALM KNUCKLE BACK PKT 2 1	SNL	POS035	17	0	5	23	20.3%	0.454	1	
BACK BODY (PANT)	B3	TACK END OF ZIP POCKET 2 CM 1 1	SNL	POT002	4	0	1	5	19.4%	0.102	1	
BACK BODY (PANT)	B4	ATT ZIPPER POCKET U SHAPE 22 CM 1 2	SNL	POA023	28	0	4	33	19.4%	0.653	1	
BACK BODY (PANT)	B5	JOIN KNUCKLE TO BBY 1 2	SNL	POJ004	11	0	2	13	19.8%	0.265	1	
BACK BODY (PANT)	B6	OVERLOCK INSIDE POCKET STRIGHT 19 CM 1 1	OM3	POO014	9	0	3	13	19.2%	0.249	1	
BACK BODY (PANT)	B7	STCH ZIPPER PKT U SHAPE 22 CM 1 2	SNL	POS044	13	0	5	18	20.8%	0.370	1	
BACK BODY (PANT)	B8	STITCH 1/16" EDGE WELT BACK PKT 1.1 2	SNL	POS001	26	0	5	31	19.7%	0.618	1	
BACK BODY (PANT)	B9	STITCH WELT BACK PKT 1 2	SNL	POS033	30	0	8	38	20.0%	0.763	1	
BACK BODY (PANT)	B10	JOIN INSIDE WELT TO ZIPPER STRIGHT 17 CM (SIDE PKT) 1 1	SNL	POJ055	21	0	3	24	19.7%	0.480	1	
BACK BODY (PANT)	B11	TACK PALM TO BACK PKT 0.6 1	SNL	POT001	12	0	3	15	19.5%	0.307	1	
BACK BODY (PANT)	B12	JOIN LAYER POCKET SQUARE 1 1	OM3	POJ030	18	0	9	27	20.3%	0.551	1	
BACK BODY (PANT)	B13	STITCH DECORATIVE PKT. MITRE 60 CM 0.5 1	DNL	POS031	36	0	7	43	20.2%	0.858	1	
BACK BODY (PANT)	B14	MARKING BACK YOKE 2 2	NMC	SOM001	22	0	0	22	18.3%	0.430	1	
BACK BODY (PANT)	B15	JOIN BACK PKT TO BBY 1 1	SNL	POJ011	19	0	9	28	21.0%	0.559	1	
BACK BODY (PANT)	B16	JOIN YOKE TO BBY SEPARATELY 2 2	SNL	PBJ003	23	0	8	31	20.4%	0.620	1	
BACK BODY (PANT)	B17	OVERLOCK BACK YOKE 2 2	OM3	SOO002A	19	0	7	26	20.0%	0.513	1	
BACK BODY (PANT)	B18	STITCH BACK YOKE DNL STRAIGHT 38 CM (SEPARATELY) 1.5 2	DNL	PBS010	31	0	10	41	21.3%	0.822	1	
BACK BODY (PANT)	B19	JOIN BACK RISE W YOKE 45 CM 1 1	SNL	PBJ002	17	0	5	22	19.8%	0.440	1	
BACK BODY (PANT)	B20	OVERLOCK BACK RISE 1 1	OM3	PBO001	5	0	4	9	12.9%	0.167	1	
BACK BODY (PANT)	B21	STCH BACK RISE W YOKE (DNL) 45 CM 1 1	DNL	PBS003	17	0	8	25	22.1%	0.504	1	
BACK BODY (PANT)	B22	INSERT PULLER TNF 1 1	NMC	ZPI001	13	0	0	13	18.3%	0.265	1	
WAISTBAND (PANT)	C1	JN LAYER WB 10 CM 1 1	SNL	PWJ004	12	0	2	14	19.2%	0.276	1	
WAISTBAND (PANT)	C2	CUT ELASTIC WB 1 1	NMC	PWC001	10	0	0	10	18.3%	0.189	1	
WAISTBAND (PANT)	C3	JOIN ELASTIC WB 5 CM 1 1	SNL	PWJ011	1	0	9	10	19.2%	0.200	1	
WAISTBAND (PANT)	C4	MARK ELASTIC WB 3X 1 1	NMC	PWC002	9	0	0	9	18.3%	0.180	1	

Lampiran 3

Operation Process Chart Short Pant Style A3T2U (Lanjutan)

ASSEMBLY	1	1	JOIN SIDSEAM W VENT	SNL	PAJ001	32	0	13	45	19.6%	0.893	1	
ASSEMBLY	2	18	2	OVERLOCK SIDSEAM W VENT	OM3	PAO004	15	0	17	32	21.0%	0.654	1
ASSEMBLY	3	2	2	TACK CARE LABEL + ID 4 CM 2 LAYER	SNL	PWT003	8	0	1	9	19.3%	0.172	1
ASSEMBLY	4	1	1	ATT CARE LABEL TO SIDSEAM 4 CM	SNL	JAA039	16	0	1	17	18.9%	0.331	1
ASSEMBLY	5	1	1	STCH CARE LABEL LINING 4 CM	SNL	JLS006	12	0	1	14	19.2%	0.275	1
ASSEMBLY	6	1	1	TACK SIDSEAM W VENT	SNL	SAT029	32	0	1	34	11.4%	0.629	1
ASSEMBLY	7	10	2	STCH FOLD 1/4 VENT HEM 16 CM X4	SNL	SAS014	40	0	8	48	19.7%	0.956	1
ASSEMBLY	8	1	1	JOIN INSEAM NORMAL SHORT PANT 50 CM	SNL	SAJ024	21	0	6	27	19.6%	0.535	1
ASSEMBLY	9	08	1	OVERLOCK INSEAM	OM3	SOO001	10	0	12	22	21.2%	0.440	1
ASSEMBLY	10	1	1	STCH 1/16 GUSSET + INSEAM 56 CM X2	SNL	SAS016	25	0	12	37	20.9%	0.748	1
ASSEMBLY	11	2	2	TACK END OF HEM 3 CM	SNL	JAT007	19	0	2	21	18.9%	0.408	1
ASSEMBLY	12	2	2	HEM ROUNDED NO LINING W VENT 90 CM	SNL	SAH005	45	0	19	64	22.0%	1.304	1
ASSEMBLY	13	14	2	STITCH END OFF HEM	SNL	SOS001	12	0	7	20	21.4%	0.401	1
ASSEMBLY	14	1	1	JOIN WB NO ELASTIC 110 CM	SNL	PAJ014	40	0	12	52	20.2%	1.048	1
ASSEMBLY	15	1	1	OLINSIDE WAISTBAND NO ELASTIC 96 CM	OM3	PAO005	8	0	8	16	21.0%	0.320	1
ASSEMBLY	16	1	1	BUTTON HOLE INNER WB POSITION ELASTIC	BHM	SAB013	23	0	1	24	11.2%	0.443	1
ASSEMBLY	17	2	2	ATT 2 LABEL TO WB N ELASTIC 10 CM	SNL	PAA003	12	0	2	14	19.2%	0.275	1
ASSEMBLY	18	1	1	BARTACK LABEL WB	BTK	SAB015	8	0	1	9	11.2%	0.160	1
ASSEMBLY	19	2	2	TACK ELSTC WB FULL ELSTC NRML 28 CM	SNL	PAT001	10	0	1	11	19.0%	0.213	1
ASSEMBLY	20	1	1	ATT ELASTIC TO AROUND WB W TACK	KMP	PWA020	14	0	10	24	11.8%	0.443	1
ASSEMBLY	21	1	1	TACK ELASTIC WB FULL ELSTC CLEANFINSH 28 CM	SNL	PAT009	30	0	4	34	19.2%	0.677	1
ASSEMBLY	22	1	1	STCH WB FULL ELASTIC 110 CM	KNS	PAS014	21	0	17	38	23.1%	0.779	1
ASSEMBLY	23	1	1	INSERT DRAWCORD WB (NOT ELASTIC)	NMC	PAI002	26	0	0	26	18.3%	0.508	1
ASSEMBLY	24	1	1	TACK FOLD THE END OF DRAWCORD WB 2X	SNL	PAT023	27	0	2	28	18.8%	0.563	1
ASSEMBLY	25	2	2	BARTACK THE END OF DRAWCORD WB 2X	BTK	PAB022	12	0	6	18	20.0%	0.357	1
ASSEMBLY	26	1	1	BARTACK DRAWCORD CENTER BACK WB	BTK	PAB009	16	0	3	19	19.2%	0.370	1
ASSEMBLY	27	1	1	TACK END OF CHAIN STITCH 2X 6 CM	SNL	JAT015	14	0	3	16	21.3%	0.329	1
ASSEMBLY	28	1	2	BARTACK INSEAM 1X	BTK	SAB008	11	0	0	12	17.5%	0.228	1
ASSEMBLY	29	2	2	BARTACK VENT 2X	BTK	SAB014	14	0	1	15	11.1%	0.276	1
ASSEMBLY	30	2	2	BARTACK SIDE POCKET	BTK	POB001	14	0	12	26	20.7%	0.523	1
ASSEMBLY	31	1	1	TEAM SHORT PANT	STM	PAF001	34	0	0	34	20.4%	0.681	1

Lampiran 4

Cheklis Perawatan Mesin

CHEKLIST PERAWATAN MESIN HARIAN OPERATOR
Daily Maintenance Checklist

Bulan / Month: Agustus 2019
Tanggal / Date: 08/08/2019

No	Bagian Mesin	Standar	Tanggal / Date																															
			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	
1	Tiang Benang	Bersih				✓	✓	✓				✓	✓	✓																				
2	Kepala Mesin	Bersih				✓	✓	✓				✓	✓	✓																				
3	Meja Mesin	Bersih				✓	✓	✓				✓	✓	✓																				
4	Control Box (Bagian Luar)	Bersih				✓	✓	✓				✓	✓	✓																				

NIK OPERATOR: _____

CHEKLIST PERAWATAN MESIN MINGGUAN MEKANIK
Weekly Maintenance Checklist

Note: V : Baik R : Jika Mesin ad Red Tag (diisi oleh Mekanik Workshop)
X : Tidak Baik NO : Jika Mesin di Line tetapi tidak ada Operatormya? (diisi oleh Mekanik)

No	Bagian Mesin	Standar	Bulan / Month :				
			Minggu Ke 1	Minggu Ke 2	Minggu Ke 3	Minggu Ke 4	Minggu Ke 5
1	Kondisi Fisik Kabel	Cek	✓	✓	✓	✓	✓
2	Oil	> Lower Limit	✓	✓	✓	✓	✓
3	Pengaman Jarum	Berfungsi	✓	✓	✓	✓	✓
4	Kaca Pengaman	Berfungsi	✓	✓	✓	✓	✓
5	Pulley Guard	Berfungsi	✓	✓	✓	✓	✓

NIK MEKANIK: _____