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LAMPIRAN

Lampiran 1 Pemberian *Soda Ash*

Lampiran 2 Pemberian Sabun Biasa

Lampiran 3 Pemasakan

Lampiran 4 Intruksi Kerja Pengujian *Blending*

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INSTRUKSI KERJA
PENGECEKKAN PROSENTASE CAMPURAN MATERIAL (BLEND TEST)

SRITEX GROUP

1. RUANG LINGKUP
Kegiatan Instruksi Kerja Pengecekkan Prosentase Campuran Material (Blend Test).

2. TANGGUNG JAWAB DAN WEWENANG
Supervisor Quality Control bertanggung jawab dalam pelaksanaan Instruksi Kerja Pengecekkan Prosentase Campuran Material (Blend Test), sesuai persyaratan yang ditetapkan

3. INSTRUKSI KERJA

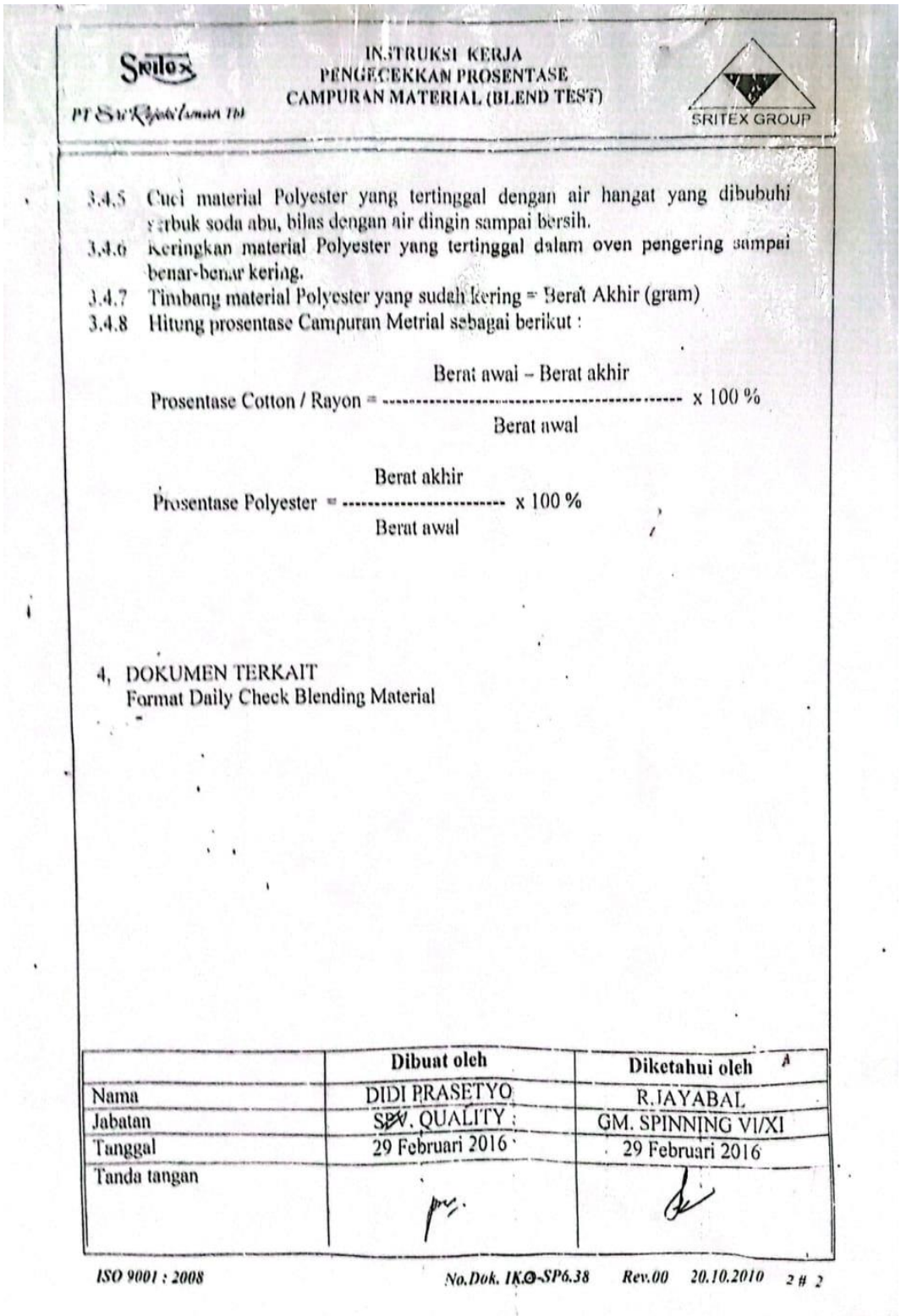
3.1 Tahapan proses produksi yang diuji Prosentase Campuran Materialnya :
3.1.1 Sliver Drawing Campuran (Blending) : untuk proses baru.
3.1.2 Benang dari Cone untuk proses yang sedang berlangsung, diuji 2x seminggu.

3.2 Pengambilan sampie :
3.2.1 Sample Sliver Drawing (Proses Baru) Passage II diambil contoh uji sebanyak 2 x (±) 2 - 3 gram sliver.
3.2.2 Benang dari cone diambil contoh uji, masing-masing Ne benang : 3 x (½) lea.

3.3 Cara membuat Asam Sulfat (H2 SO4 70% :
3.3.1 Siapkan 600 ml H2 SO4 Pekat (Glacial)
3.3.2 Siapkan 400 ml Air Suling (Aquadest) dalam gelas ukur (1000 ml).
3.3.3 Siapkan air pada penangas secukupnya (berfungsi sebagai pendingin), kemudian masukkan air Aquadest yang didalam gelas ukur tersebut diatas ke dalam penangas, tuangkan sedikit demi sedikit Asam Sulfat Pekat ke dalam Aquadest sambil diaduk rata. Tunggu sampai larutean Asam Sulfat menjadi dingin, baru boleh dipakai untuk pengujian.

3.4 Cara Pengujian :
3.4.1 Masukkan contoh uji ke dalam oven dengan suhu (±) 100°C, selama (±) 15 menit.
3.4.2 Timbang contoh uji, ulangi penimbangan setelah contoh uji dikeringkan ulang dalam oven selama 5 menit untuk memastikan bahwa contoh uji sudah benar-benar kering.
Hasil penimbangan ini = Berat Awal (gram)
3.4.3 Masukkan contoh uji ke dalam gelas ukur (250 ml/ disesuaikan dengan banyaknya contoh uji), tuangkan H2 SO4 ke dalam gelas ukur, sampai semua contoh uji terendam dalam larutan H2 SO4.
3.4.4 Siapkan kompor dan penangas yang sudah diisi air secukupnya, masukkan gelas yang berisi contoh uji ke dalam penangaas. Didihkan air dalam penangas sambil mengaduk contoh uji sampai material Cotton larut dalam larutan H2 SO4 berubah menjadi hitam. Material Polyester tidak larut dengan H2 SO4.

Lampiran 4 Intruksi Kerja Pengujian *Blending* lanjutan



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INSTRUKSI KERJA
PENGECEKKAN PROSENTASE
CAMPURAN MATERIAL (BLEND TEST)

SRITEX GROUP

3.4.5 Cuci material Polyester yang tertinggal dengan air hangat yang dibubuhi serbuk soda abu, bilas dengan air dingin sampai bersih.

3.4.6 Keringkan material Polyester yang tertinggal dalam oven pengering sampai benar-benar kering.

3.4.7 Timbang material Polyester yang sudah kering = Berat Akhir (gram)

3.4.8 Hitung prosentase Campuran Metrial sebagai berikut :

$$\text{Prosentase Cotton / Rayon} = \frac{\text{Berat awal} - \text{Berat akhir}}{\text{Berat awal}} \times 100\ \%$$

$$\text{Prosentase Polyester} = \frac{\text{Berat akhir}}{\text{Berat awal}} \times 100\ \%$$

4, DOKUMEN TERKAIT
Format Daily Check Blending Material

	Dibuat oleh	Diketahui oleh
Nama	DIDI PRASETYO	R.JAYABAL
Jabatan	SPV. QUALITY	GM. SPINNING VI/XI
Tanggal	29 Februari 2016	29 Februari 2016
Tanda tangan		

ISO 9001 : 2008 No.Dok. IK.O-SP6.38 Rev.00 20.10.2010 2 # 2

AATCC Test Method 20A-2008

Fiber Analysis: Quantitative

Developed in 1957 by AATCC Committee RA24; revised 1958, 1959, 1975, 1995, 2000, 2004, 2005, 2007, 2008; reaffirmed 1971, 1978, 1981, 1989; editorially revised 1980, 1982 (new title), 1985, 2002; 2009. Related to ISO 17751 and 1833 and IWTO 58.

1. Purpose and Scope

1.1 This method presents individual procedures for the quantitative determination of moisture content, nonfibrous content and fiber composition of textiles.

1.2 The procedures for the determination of fiber composition include mechanical, chemical and microscopical methods. They are applicable to blends of the following generic classes:

Natural Fibers	Man-Made Fibers
Cotton	Acetate
Hair	Acrylic
Hemp	Modacrylic
Linen	Nylon (see 17.1)
Ramie	Olefin
Silk	Polyester
Wool	Rayon
	Spandex

2. Uses and Limitations

2.1 The procedure given for the removal of nonfibrous materials will remove most, but not all, of these components. Each treatment is applicable only to certain categories of these substances and no general scheme can be given that is all inclusive. Some of the newer finishes may present special problems and the analyst will have to deal with these cases as they arise. Thermosetting resins and crosslinking latices are not only difficult to remove but in some cases cannot be wholly removed without destroying the fiber. When it is necessary to modify a procedure, or use a new one, one should make sure that the fibrous portion of the specimen under test is not attacked. Fiber composition is generally expressed either on the oven-dry weight of the textile as received or on the oven-dry weight of the clean fiber after nonfibrous materials are first removed from the textile before the fiber analysis is carried out, or if the treatments described in Section 9 are incapable of removing them, any such materials present will increase the percentage of the fiber constituent with which they are removed during the analysis.

2.2 The procedure for determining fiber composition by mechanical separa- composition are segregated in separate yarns, or plies, in the textile product.

2.3 The chemical procedures for fiber composition described herein are applicable to most of the current, commercial production fibers within each generic class listed. Known exceptions are noted in Table II. However, there may be instances in which a method may not be fully adequate for a newly developed fiber falling within one of the listed generic classes and for re-used and/or physically or chemically modified fibers. Caution should be exercised when applying these methods to such cases.

2.4 The microscopical procedures for fiber composition are applicable to all fibers and their accuracy depends to a considerable extent upon the ability of the analyst to identify the individual fibers present. However, owing to the tedious nature of this technique, its use is generally limited to those mixtures which cannot be separated mechanically or chemically; e.g., mixtures of hair and wool and mixtures of cotton, linen, hemp and/or ramie.

3. Terminology

3.1 **clean-fiber content,** n.—the amount of fiber after removal of nonfibrous content.

3.2 **fiber,** n.—*in textiles*, a generic term for any one of the various types of matter that form the basic elements of a textile and which are generally characterized by flexibility, fineness and high ratio of length to thickness.

3.3 **moisture content,** n.—that part of the total mass of a material that is absorbed or adsorbed water, compared to the total mass.

3.4 **nonfibrous content,** n.—products such as fiber finishes, yarn lubricants, slasher sizing, fabric softeners, starches, china-clay, soaps, waxes, oils and resins which are applied to fiber, yarn, fabric or apparel.

3.5 Additional terms used in this test method can be found in standard chemical dictionaries, in dictionaries of common terms or in *A Glossary of AATCC Standard Terminology* (located elsewhere in this TECHNICAL MANUAL).

4. Safety Precautions

NOTE: These safety precautions are for information purposes only. The precautions are ancillary to the testing procedures and are not intended to be all-inclu- materials in this test method. Manufacturers MUST be consulted for specific details such as material safety data sheets and other manufacturer's recommendations. All OSHA standards and rules must also be consulted and followed.

4.1 Good laboratory practices should be followed. Wear safety glasses in all laboratory areas.

4.2 All chemicals should be handled with care.

4.3 Perform the soxhlet extractions in Section 9, Nonfibrous Material—Clean Fiber Content, using Fluorocarbon 113 (such as Freon TF) or hydrochlorofluorocarbon (such as Genesolv 2000) and ethyl alcohol inside an adequately ventilated laboratory hood. CAUTION: Ethyl alcohol is highly flammable.

4.4 Perform Chemical Analysis Procedure No. 1 (Table II, 100% acetone) inside a ventilated laboratory hood. CAUTION: Acetone is highly flammable.

4.5 Ethyl alcohol and acetone are flammable liquids and should be stored in the laboratory only in small containers away from heat, open flame and sparks.

4.6 In preparing, dispensing, and handling hydrochloric acid (20%), sulfuric acids (59.5% and 70%), and formic acid (90%) used in Chemical Analysis Procedure Methods No. 2, 3, 4, and 6 (Table II), use chemical goggles or face shield, impervious gloves and an impervious apron. Concentrated acids should be handled only in an adequately ventilated laboratory hood. CAUTION: Always add acid to water.

4.7 In preparing ammonium hydroxide (8.92) for use in Chemical Analysis Procedure Method No. 4 (Table II, 70% sulfuric acid), use chemical goggles or face shield, impervious gloves and an impervious apron. Dispense, mix and handle ammonium hydroxide only in an adequately ventilated laboratory hood.

4.8 An eyewash/safety shower should be located nearby and a self-contained breathing apparatus should be readily available for emergency use.

4.9 Exposure to chemicals used in this procedure must be controlled at or below levels set by governmental authorities (e.g., Occupational Safety and Health Administration's [OSHA] permissible exposure limits [PEL] as found in 29 CFR 1910.1000 of January 1, 1989). In addition, the American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Values (TLVs)

AATCC Test Method 20-2007

Fiber Analysis: Qualitative

Developed by AATCC Committee RA24. Adopted as Tentative 1955; revised 1958, 1962, 1963, 1972, 1976, 1998, 1999, 2000, 2001, 2002, 2004, 2005; editorially revised and reaffirmed 1973, 1990, 1995; editorially revised 1974, 1977, 1982 (new title), 1983, 1984, 1988, 2009; editorially revised with technical correction 2008; reaffirmed 1985. Related to ISO 17751, ISO 1833, ISO 2076, and IWTO 58.

1. Purpose and Scope

1.1 This test method describes physical, chemical and microscopical techniques for identifying textile fibers used commercially in the United States. Fibers may be examined in raw fiber form or taken from yarn or fabric.

1.2 These test methods may be used to identify generic fiber types as defined by the Textile Fibers Products Identification Act and subsequent rules and regulations of the Federal Trade Commission or ISO 2076, Textiles man-made fibres-generic names. Quantitative methods for determining percentages in blends of fibers are covered by AATCC Test Method 20A, Fiber Analysis: Quantitative.

1.3 The test methods apply to fibers which are shown below grouped by generic classifications:

Natural Fibers	Man-Made Fibers
Cellulose (Vegetable)	acetate
cotton	secondary
hemp	triacetate
jute	acrylic
linen	anidex
ramie	aramid
sisal (agave)	meta aramid
manilla hemp (abaca)	para aramid
	azlon
	glass
Keratin (Animal)	metallic
alpaca	modacrylic
camel	novoloid
cashmere	nylon
horse	6
llama	6,6
mohair	11
rabbit	nytril
vicuna	olefin
wool	lastol
yak	polyethylene
	polypropylene
Fibroin (Animal)	polyester
silk	elastrelle

2. Use and Limitations

2.1 This test method describes a number of procedures—microscopical examination, solubility in solvents, melting point, refractive index, and micro-Fourier Transform Infrared Spectroscopy—which should be used in combination to identify a fiber type. For identifying certain fibers some procedures will be found to be more effective than others.

2.2 For example, microscopical examination is particularly useful in characterizing the natural fibers. It must be used with caution on man-made fibers since they are frequently produced in a number of modifications which alter the longitudinal or cross-sectional appearance. In addition, man-made fibers may contain some or no delusterant or other additive particles. Filaments of a given type may vary in size or cross-sectional shape. Individual filaments may have two or more component sections of the same or different generic types.

2.3 Even natural fibers show a fairly wide variation in typical cross-section. No specific specimen will look exactly like the pictures published. A sufficient number of fibers should be examined to cover the range of appearance in any specimen.

2.4 Successful identification of fibers depends upon experience and familiarity with the fibers. The identification of an unknown fiber is best made by comparison with properly identified fibers used as reference standards. For this reason it is desirable to have available at least one representative fiber sample from each generic class of fibers, which can be used for comparative identification.

2.5 This test method provides means for identifying the generic classification of the common fiber types. In special cases, as when dealing with fibers not described in this method or attempting to distinguish between products of different suppliers of the same generic types, one must consult standard texts on fiber identification or technical bulletins issued by suppliers of man-made fibers. See references Section 13.

3. Terminology

for information purposes only. The precautions are ancillary to the testing procedures and are not intended to be all inclusive. It is the user's responsibility to use safe and proper techniques in handling materials in this test method. Manufacturers MUST be consulted for specific details such as material safety data sheets and other manufacturer's recommendations. All OSHA standards and rules must also be consulted and followed.

4.1 Good laboratory practices should be followed. Wear safety glasses in all laboratory areas.

4.2 All chemicals should be handled with care.

4.3 In preparing, dispensing and handling the reagents outlined in Section 6, use chemical goggles or face shield, impervious gloves and an impervious apron. Concentrated acids should be handled only in an adequately ventilated laboratory hood. CAUTION: Always add acid to water.

4.4 All poisonous and flammable reagents should be mixed and handled only in an adequately ventilated laboratory hood. CAUTION: Acetone and ethyl alcohol are highly flammable and should be stored in the laboratory only in small containers away from heat, open flame and sparks.

4.5 An eyewash/safety shower should be located nearby and an organic vapor respirator should be readily available for emergency use.

4.6 Exposure to chemicals used in this procedure must be controlled at or below levels set by governmental authorities (e.g., Occupational Safety and Health Administration's [OSHA] permissible exposure limits [PEL] as found in 29 CFR 1910.1000 of January 1, 1989). In addition, the American Conference of Governmental Industrial Hygienists (ACGIH) Threshold Limit Values (TLVs) comprised of time weighted averages (TLV-TWA), short term exposure limits (TLV-STEL) and ceiling limits (TLV-C) are recommended as a general guide for air contaminant exposure which should be met (see 12.1).

5. Apparatus (see 12.2)

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REPUBLIK INDONESIA

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	Revisi		Halaman	

LEMBAR PERBAIKAN
LAPORAN PRAKTIK KERJA LAPANGAN (PKL)

Berdasarkan Ujian Praktik Kerja Lapangan dari mahasiswa di bawah ini :

Nama Mahasiswa : Adiba Faiza Alhayya

NIM : 2201002

Program Studi : TPB

Judul Laporan PKL : .....

.....

Wajib melakukan perbaikan seperti yang tercantum di bawah ini :

NO	PERBAIKAN
1.	Gunakan kalimat efektif.
2.	Struktur Organisasi → Uraian tugas sesuaikan dengan strukturn
3.	Penulisan Daftar Pustaka.
4.	Perhatikan penulisan dengan menggunakan EYD secara benar
5.	Tabel pembanding

acc

Sih

Surakarta, 30 / 07 / 2024

Penguji,

(Dra. Sih Parmawati , MM)

Kementerian Perindustrian

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FORMULIR	Kode Dokumen		Tanggal Terbit	
	Revisi		Halaman	

LEMBAR PERBAIKAN
LAPORAN PRAKTIK KERJA LAPANGAN (PKL)

Berdasarkan Ujian Praktik Kerja Lapangan dari mahasiswa di bawah ini :

Nama Mahasiswa : Adiba Faiza Alhayya

NIM : 2201002

Program Studi : TPB

Judul Laporan PKL : Pengaruh Metode PDCA pada Kelancaran Pengujian Komposisi Benang TC CD Ne 30 65/35

Wajib melakukan perbaikan seperti yang tercantum di bawah ini :

NO	PERBAIKAN
1.	Koreksi penulisan yang perlu diperhatikan untuk konsistensi.
2.	Penulisan daftar pustaka perlu diperbaiki
3.	Penyesuaian kutipan harus sesuai dalam daftar pustaka.
4.	Isi terkait penjelasan BPJS mohon diperbaiki ada kekeliruan.

Surakarta, / /

Penguji,

(Ir. Sri Suptono Basuki, MM.)