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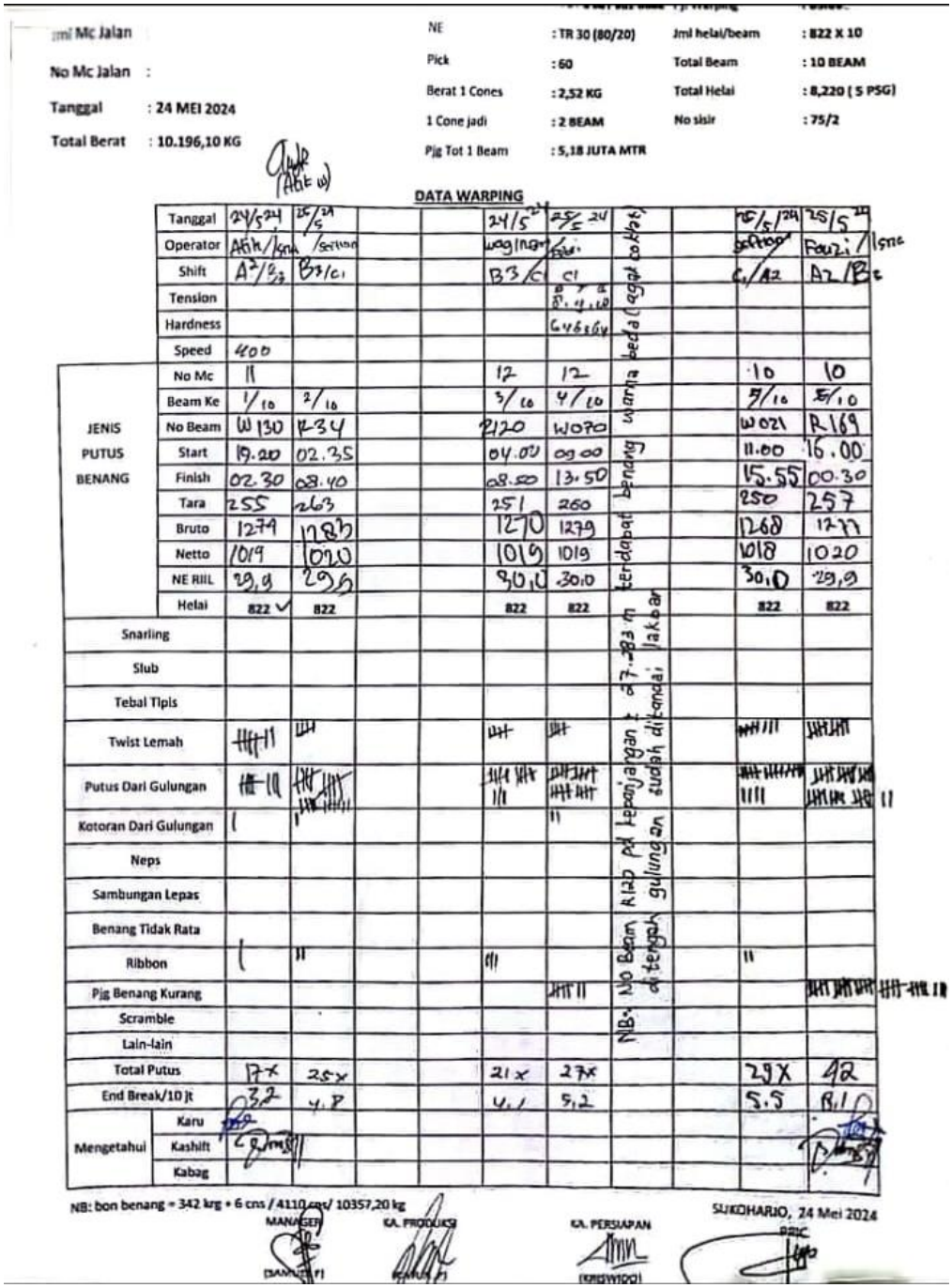
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# LAMPIRAN



Jml Mc Jalan
No Mc Jalan :
Tanggal : 24 MEI 2024
Total Berat : 10.196,10 KG

NE : TR 30 (80/20)
Pick : 60
Berat 1 Cones : 2,52 KG
1 Cone jadi : 2 BEAM
Pjg Tot 1 Beam : 5,18 JUTA MTR

Jml helai/beam : 822 X 10
Total Beam : 10 BEAM
Total Helai : 8,220 ( 5 PSG)
No sisir : 75/2

DATA WARPING

| | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | Tanggal | 24/5-24 | 25/5 | | | 24/5-24 | 25/5-24 | | | 25/5-24 | 25/5-24 |
| | Operator | Afik/Kmh | /Setiono | | | wagiman | Edi. | | | Jeffrey | Fauzi / Ismail |
| | Shift | A2/B3 | B3/C1 | | | B3/C1 | C1 | | | C1/A2 | A2/B1 |
| | Tension | | | | | | B. 4. 18 | | | | |
| | Hardness | | | | | | G46x64 | | | | |
| | Speed | 400 | | | | | | | | | |
| | No Mc | 11 | | | | 12 | 12 | | | 10 | 10 |
| | Beam Ke | 1/10 | 2/10 | | | 3/10 | 4/10 | | | 5/10 | 5/10 |
| JENIS PUTUS BENANG | No Beam | W130 | R34 | | | 2120 | W070 | | | W021 | R169 |
| | Start | 19.20 | 02.35 | | | 04.00 | 09.00 | | | 11.00 | 16.00 |
| | Finish | 02.30 | 08.40 | | | 08.50 | 13.50 | | | 15.55 | 00.30 |
| | Tara | 255 | 263 | | | 251 | 260 | | | 250 | 257 |
| | Bruto | 1279 | 1283 | | | 1270 | 1279 | | | 1268 | 1277 |
| | Netto | 1019 | 1020 | | | 1019 | 1019 | | | 1018 | 1020 |
| | NE RIIL | 29,9 | 29,5 | | | 30,0 | 30,0 | | | 30,0 | 29,9 |
| | Helai | 822 ✓ | 822 | | | 822 | 822 | | | 822 | 822 |
| Snarling | | | | | | | | | | | |
| Slub | | | | | | | | | | | |
| Tebal Tipis | | | | | | | | | | | |
| Twist Lemah | | ||||| | ||| | | | | ||||| | ||||| |
| Putus Dari Gulungan | | |||| | |||| | | | | |||| | |||| || |
| Kotoran Dari Gulungan | | | | | | | | | | | |
| Neps | | | | | | | | | | | |
| Sambungan Lepas | | | | | | | | | | | |
| Benang Tidak Rata | | | | | | | | | | | |
| Ribbon | | | | | | | | | | | |
| Pjg Benang Kurang | | | | | | | ||| | | | |
| Scramble | | | | | | | | | | | |
| Lain-lain | | | | | | | | | | | |
| Total Putus | | 17x | 25x | | | 21x | 27x | | | 29x | 42 |
| End Break/10 jt | | 3,2 | 4,9 | | | 4,1 | 5,2 | | | 5,5 | 8,1 |
| Mengetahui | Karu | | | | | | | | | | |
| | Kashift | | | | | | | | | | |
| | Kabag | | | | | | | | | | |

warna beda (tgl coklat) terdapat benang patah 7-383 m sudah ditambal/lakban

NB: No Beam R169 pd kepanjangan ± 6 gulungan di tengah

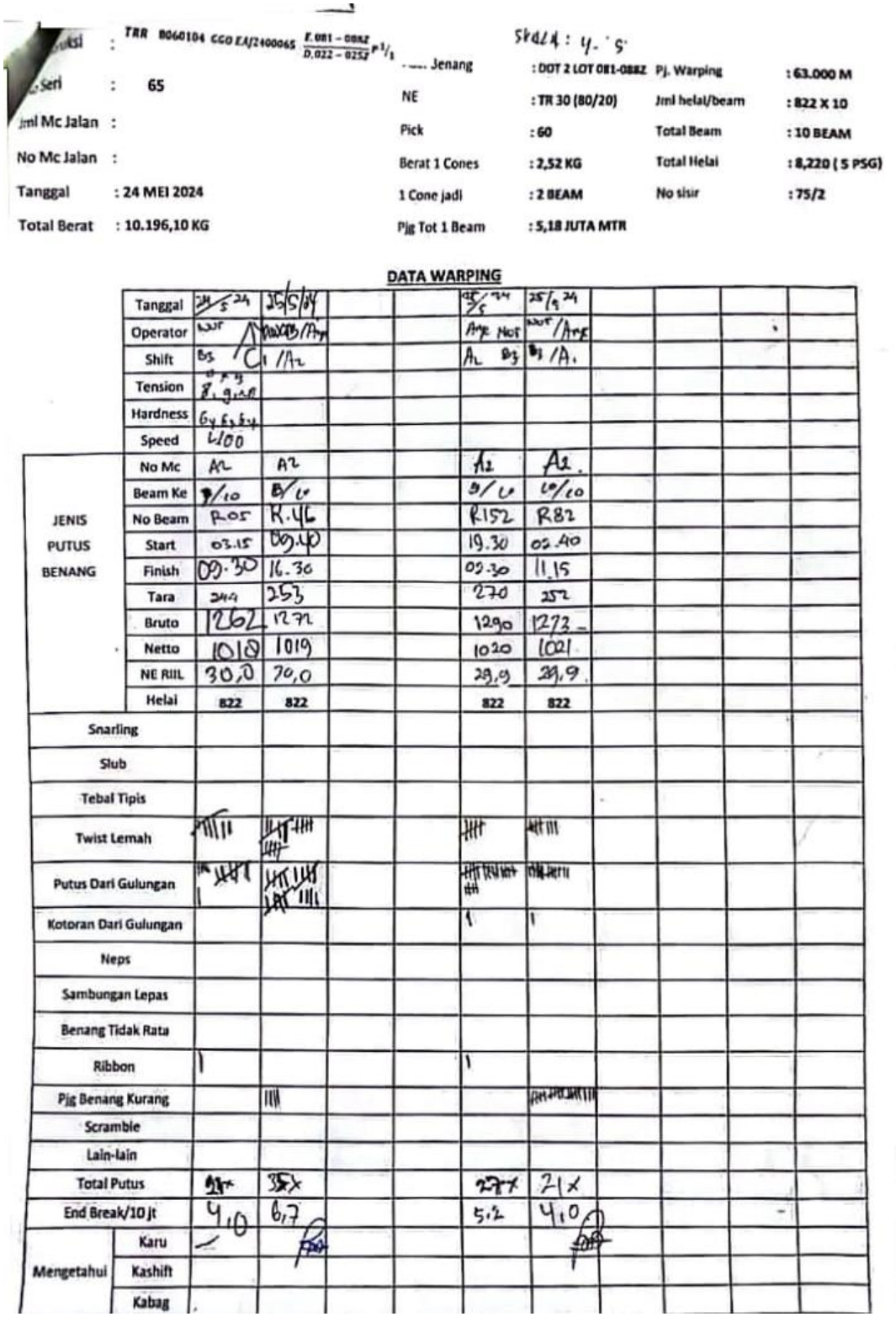
NB: bon benang = 342 krg + 6 cns / 4110 cns / 10357,20 kg

SUKOHARJO, 24 Mei 2024

MANAGER PRODUKSI KA. PRODUKSI KA. PERSIAPAN

*Sumber: PT DMDT V,2024*

Lampiran Data *Warping*



| | | | |
|---|---|---|---|
| Konstruksi | : TRR B060104 CGO EA/2400065 F.081 – 0882 / D.022 – 0252 P 1/1 | Jenang | : DOT 2 LOT 081-0882 |
| Seri | : 65 | NE | : TR 30 (80/20) |
| Jml Mc Jalan | : | Pick | : 60 |
| No Mc Jalan | : | Berat 1 Cones | : 2,52 KG |
| Tanggal | : 24 MEI 2024 | 1 Cone jadi | : 2 BEAM |
| Total Berat | : 10.196,10 KG | Pjg Tot 1 Beam | : 5,18 JUTA MTR |

Shift : 4 - 5

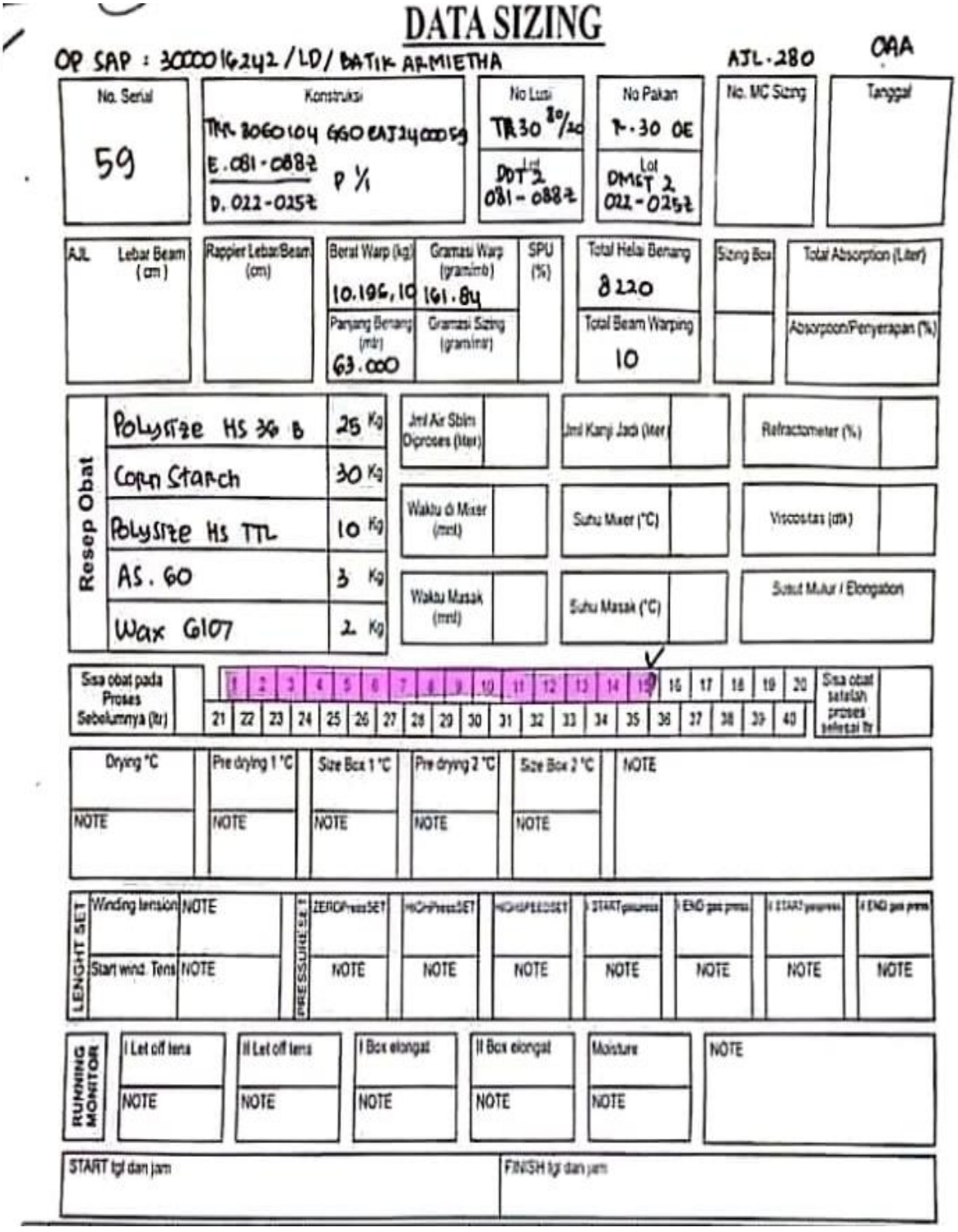
| | | | |
|---|---|---|---|
| Pj. Warping | : 63.000 M | | |
| Jml helai/beam | : 822 X 10 | | |
| Total Beam | : 10 BEAM | | |
| Total Helai | : 8,220 ( 5 PSG) | | |
| No sisir | : 75/2 | | |

**DATA WARPING**

| | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | Tanggal | 24/5 24 | 25/5/24 | | | 25/5 24 | 25/5 24 | | | | |
| | Operator | [illegible] | [illegible] | | | [illegible] | [illegible] | | | | |
| | Shift | B3 C1 /A2 | | | | A2 B3 | B3 /A1 | | | | |
| | Tension | 8,9 | | | | | | | | | |
| | Hardness | 64 64 64 | | | | | | | | | |
| | Speed | 4100 | | | | | | | | | |
| JENIS PUTUS BENANG | No Mc | A2 | A2 | | | A2 | A2 | | | | |
| | Beam Ke | 9/10 | 8/10 | | | 9/10 | 10/10 | | | | |
| | No Beam | R05 | R.46 | | | R152 | R82 | | | | |
| | Start | 03.15 | 09.40 | | | 19.30 | 02.40 | | | | |
| | Finish | 09.30 | 16.30 | | | 03.30 | 11.15 | | | | |
| | Tara | 249 | 253 | | | 270 | 252 | | | | |
| | Bruto | 1262 | 1272 | | | 1290 | 1273 | | | | |
| | Netto | 1018 | 1019 | | | 1020 | 1021 | | | | |
| | NE RIIL | 30,0 | 30,0 | | | 29,9 | 29,9 | | | | |
| | Helai | 822 | 822 | | | 822 | 822 | | | | |
| Snarling | | | | | | | | | | | |
| Slub | | | | | | | | | | | |
| Tebal Tipis | | | | | | | | | | | |
| Twist Lemah | | [illegible] | [illegible] | | | [illegible] | [illegible] | | | | |
| Putus Dari Gulungan | | [illegible] | [illegible] | | | [illegible] | [illegible] | | | | |
| Kotoran Dari Gulungan | | | | | | 1 | 1 | | | | |
| Neps | | | | | | | | | | | |
| Sambungan Lepas | | | | | | | | | | | |
| Benang Tidak Rata | | | | | | | | | | | |
| Ribbon | | 1 | | | | 1 | | | | | |
| Pjg Benang Kurang | | | [illegible] | | | | [illegible] | | | | |
| Scramble | | | | | | | | | | | |
| Lain-lain | | | | | | | | | | | |
| Total Putus | | 21 | 35 | | | 27 | 21 | | | | |
| End Break/10 jt | | 4,10 | 6,7 | | | 5,2 | 4,10 | | | | |
| Mengetahui | Karu | — | [signature] | | | | [signature] | | | | |
| | Kashift | | | | | | | | | | |
| | Kabag | | | | | | | | | | |

*Sumber: PT DMDT V,2024*

Lampiran Data *Warping*



# DATA SIZING

OP SAP : 300001624 2 / LD / BATIK ARMIETHA — AJL.280 — OAA

| No. Serial | Konstruksi | No Lusi | No Pakan | No. MC Sizing | Tanggal |
|---|---|---|---|---|---|
| 59 | TR. 80601 04 660 CAJ 24 00 59<br>E. 081 - 0882 P 1/1<br>D. 022 - 0252 | TR30 80/20<br>Lot DDT 2 081 - 0882 | P. 30 OE<br>Lot DMDT 2 022 - 0252 | | |

| AJL Lebar Beam (cm) | Rapper Lebar Beam (cm) | Berat Warp (kg) | Gramasi Warp (gram/mtr) | SPU (%) | Total Helai Benang | Sizing Box | Total Absorption (Liter) |
|---|---|---|---|---|---|---|---|
| | | 10.196,10 | 161.84 | | 8220 | | |
| | | Panjang Benang (mtr) 63.000 | Gramasi Sizing (gram/mtr) | | Total Beam Warping 10 | | Absorpsi/Penyerapan (%) |

| Resep Obat | | |
|---|---|---|
| Polysize HS 30 B | 25 | Kg |
| Corn Starch | 30 | Kg |
| Polysize HS TTL | 10 | Kg |
| AS. 60 | 3 | Kg |
| Wax G107 | 2 | Kg |

| Jml Air Sblm Diproses (liter) | Jml Kanji Jadi (liter) | Refractometer (%) |
|---|---|---|
| | | |

| Waktu di Mixer (mnt) | Suhu Mixer (°C) | Viscositas (dtk) |
|---|---|---|
| | | |

| Waktu Masak (mnt) | Suhu Masak (°C) | Susut Mulur / Elongation |
|---|---|---|
| | | |

Sisa obat pada Proses Sebelumnya (ltr) | 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 32 33 34 35 36 37 38 39 40 | Sisa obat setelah proses selesai ltr

| Drying °C | Pre drying 1 °C | Size Box 1 °C | Pre drying 2 °C | Size Box 2 °C | NOTE |
|---|---|---|---|---|---|
| NOTE | NOTE | NOTE | NOTE | NOTE | |

| LENGHT SET | | | PRESSURE SET | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Winding tension | NOTE | | ZERO Press SET | HIGH Press SET | HIGH SPEED SET | START pressure | END pressure | START pressure | END pressure |
| Start wind. Tens | NOTE | | NOTE | NOTE | NOTE | NOTE | NOTE | NOTE | NOTE |

| RUNNING MONITOR | I Let off tens | II Let off tens | I Box elongat | II Box elongat | Moisture | NOTE |
|---|---|---|---|---|---|---|
| | NOTE | NOTE | NOTE | NOTE | NOTE | |

START tgl dan jam | FINISH tgl dan jam

*Sumber: PT DMDT V,2024*

Lampiran Data *Sizing*