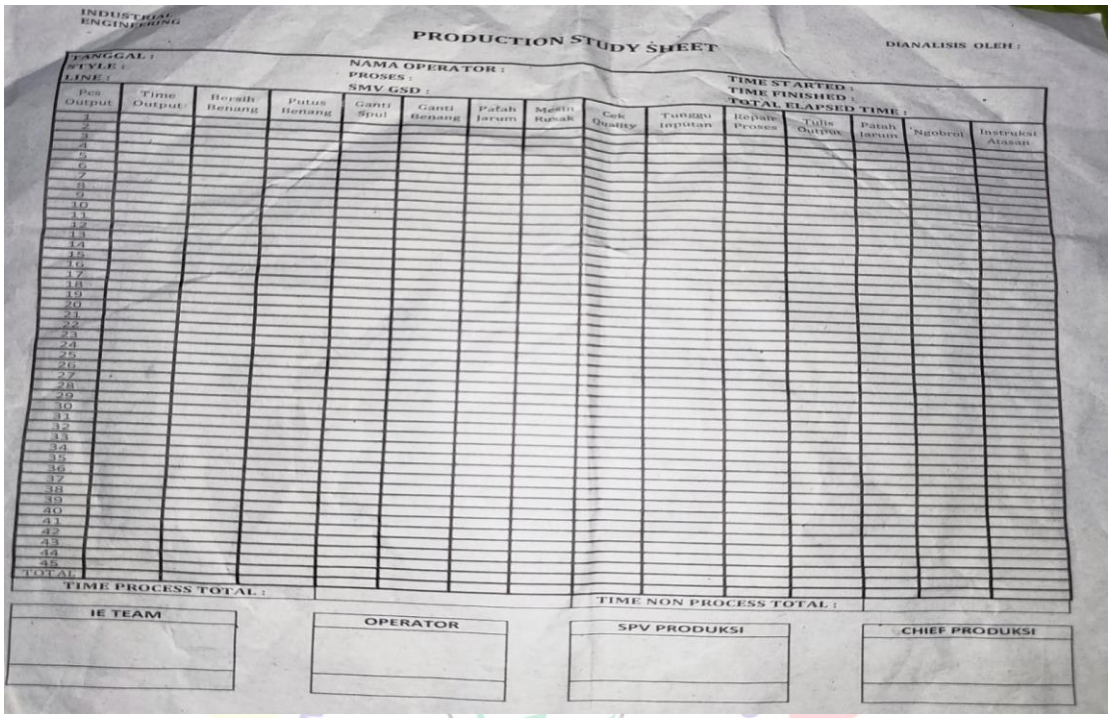
LAMPIRAN



INDUSTRIAL ENGINEERING

PRODUCTION STUDY SHEET

DIANALISIS OLEH :

TANGGAL :
STYLE :
LINE :

NAMA OPERATOR :
PROSES :
SMV GSD :

TIME STARTED :
TIME FINISHED :
TOTAL ELAPSED TIME :

Pcs Output	Time Output	Bersih Benang	Putus Benang	Ganti Spul	Ganti Benang	Patah Jarum	Mesin Rusak	Cek Quality	Tunggu Imputan	Repair Proses	Tulis Output	Patah Jarum	Ngobrol	Instruksi Atasan
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44														
45														
TOTAL														

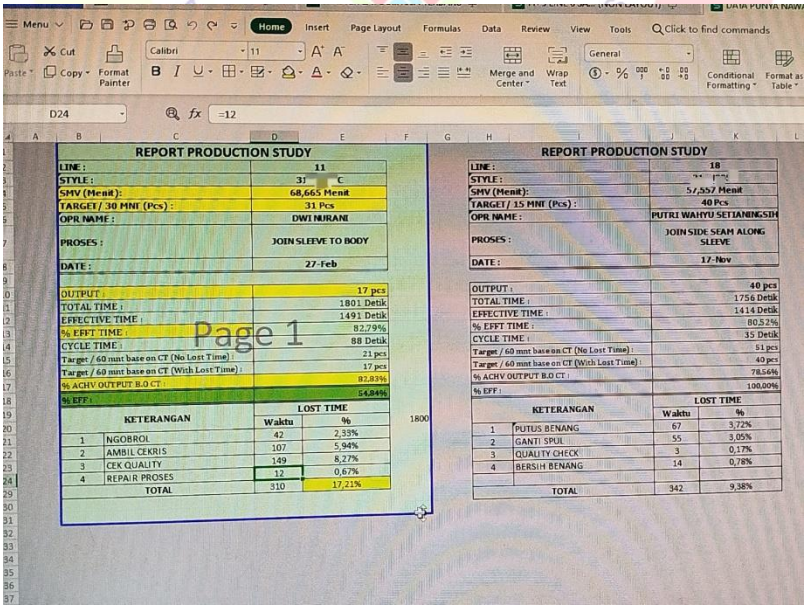
TIME PROCESS TOTAL :

TIME NON PROCESS TOTAL :

IE TEAM	OPERATOR	SPV PRODUKSI	CHIEF PRODUKSI

Sumber : Departemen *IE* (2026)

Production Study Sheet



REPORT PRODUCTION STUDY

LINE :	11
STYLE :	3[illegible] C
SMV (Menit):	68,665 Menit
TARGET / 30 MNT (Pcs) :	31 Pcs
OPR NAME :	DWI NURANI
PROSES :	JOIN SLEEVE TO BODY
DATE :	27-Feb
OUTPUT :	17 pcs
TOTAL TIME :	1801 Detik
EFFECTIVE TIME :	1491 Detik
% EFFT TIME :	82,79%
CYCLE TIME :	88 Detik
Target / 60 mnt base on CT (No Lost Time) :	21 pcs
Target / 60 mnt base on CT (With Lost Time) :	17 pcs
% ACHV OUTPUT B.O CT :	82,89%
% EFF :	54,84%

	KETERANGAN	LOST TIME Waktu	%
1	NGOBROL	42	2,33%
2	AMBIL CEKRIS	107	5,94%
3	CEK QUALITY	149	8,27%
4	REPAIR PROSES	12	0,67%
	TOTAL	310	17,21%

1800

REPORT PRODUCTION STUDY

LINE :	18
STYLE :	[illegible]
SMV (Menit):	57,557 Menit
TARGET / 15 MNT (Pcs) :	40 Pcs
OPR NAME :	PUTRI WAHYU SETIANINGSIH
PROSES :	JOIN SIDE SEAM ALONG SLEEVE
DATE :	17-Nov
OUTPUT :	40 pcs
TOTAL TIME :	1756 Detik
EFFECTIVE TIME :	1414 Detik
% EFFT TIME :	80,52%
CYCLE TIME :	35 Detik
Target / 60 mnt base on CT (No Lost Time) :	51 pcs
Target / 60 mnt base on CT (With Lost Time) :	40 pcs
% ACHV OUTPUT B.O CT :	78,56%
% EFF :	100,00%

	KETERANGAN	LOST TIME Waktu	%
1	PUTUS BENANG	67	3,72%
2	GANTI SPUL	55	3,05%
3	QUALITY CHECK	3	0,17%
4	BERSIH BENANG	14	0,78%
	TOTAL	342	9,38%

Page 1

Sumber : Departemen *IE* (2026)

Contoh *Production Study Sheet*