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LAMPIRAN

Lampiran 1. 1 Jadwal preventive maintenance (JPM)

Periodic	Item/Discription	BULAN											
		1	2	3	4	5	6	7	8	9	10	11	12
1.5 Bulan	Cleaning, Check, Dan Keperluan												
	1. Top Roll Dan Bottom Apron	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	2. Bottom Cleaner & Magnetic Cleaner	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	3. Apron Bridge	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	4. Neck Bearing	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	5. Antinot Ring & Separator												
	6. Ganti Traveller												
	7. Spindle Tape	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
6 Bulan	Cleaning, Check & Resetting												
	1. Traveller Cleaner			⊗						⊗			
	2. Gear End			⊗						⊗			
	3. Spindle Hook & Tension Pulley			⊗						⊗			
	4. VPS Dan V-Belt B54			⊗						⊗			
	5. Rantai			⊗						⊗			
	6. Ring Rail			⊗						⊗			
	7. Spindle			⊗						⊗			
	8. Snail Wire			⊗						⊗			
	9. Anti Node Ring			⊗						⊗			
	10. Ganti Oli Spindle			⊗						⊗			
1 Tahun	Cleaning, Check, Dial & Risetting												
	1. Front Bottom Roll									⊗			
	2. Middle Bottom Roll									⊗			
	3. Back Bottom Roll									⊗			

Lampiran 1. 2 Data hasil pengujian Uster Jelek

2 cm 5 10 20 50 1m 2 5 10 20 50 100 200 500 1km 2

USTER TESTER 3 V2.50 SA 3-08-19 9:21 OPERATOR: VINA PAGE: 2

SINGLE-OVERALL RESULTS

Art.no.: CD 40 Test.no.: RF ACDE Fiber assembly: 40 Nec
 RI A10L331.C1R109.C10L1.D6R63.E11L70 LOT 05/19/2/CD40
 v: 400 m/min t: 2.5 min Tests: 5/1 Slot: 4 / Yarns Yarn tension: 12.5 % Imperfections: short staple

Test no.	Um (%)	CVm (%)	Thin places (-40%)	Thin places (-50%)	Thick pl. (+50%)	Neps (+140%)	Neps (+200%)	Rel. count (%)	Hairiness (-)	sh (-)
1	12.30	15.65	458	27	208	1565	311	103.1	6.27	1.50
2	12.02	15.33	314	15	209	1970	470	97.4	6.20	1.40
3	12.02	15.31	304	12	190	1739	362	95.8	6.83	1.51
4	12.37	15.85	372	19	260	2471	511	101.4	6.81	1.55
5	13.06	16.66	608	44	321	2004	489	102.3	5.63	1.37
Mean value	12.35	15.76	411 /km	23 /km	238 /km	1950 /km	429 /km	100.0	6.35	1.47
s	0.43	0.55	126	13	53	342	81	3.2	0.50	0.08
CV	0.83	0.88	156	16	66	424	100	4.0	0.62	0.10

Scanned with CamScanner

Lampiran 1. 3 Data hasil pengujian Uster Bagus

USTER TESTER 3 V2.50 WE 21-08-19 16:48 OPERATOR: ISNA PAGE: 2

SINGLE-OVERALL RESULTS

Art.no.: CD 40 Test.no.: B9 Fiber assembly: 40 Nec
 CHEDE EKOR RABI BAGUS
 v: 400 m/min t: 2.5 min Tests: 4/1 Slot: 4 / Yarns Yarn tension: 12.5 % Imperfections: short staple

Test no.	Um (%)	CVm (%)	Thin places (-40%)	Thin places (-50%)	Thick pl. (+50%)	Neps (+140%)	Neps (+200%)	Rel. count (%)	Hairiness (-)	sh (-)
1	12.69	16.12	451	28	250	1584	335	99.0	4.65	1.17
2	12.70	16.19	414	16	275	1522	333	99.8	4.79	1.15
3	12.54	15.96	420	15	268	1535	332	99.3	4.87	1.14
4	12.54	15.95	377	12	200	1588	269	101.9	5.51	1.22
Mean value	12.62	16.06	416 /km	18 /km	246 /km	1557 /km	317 /km	100.0	4.96	1.17

Lampiran 1. 4 Data hasil pengujian strangth jelek

SOLO

Test of Yarn Traction with MesdanLab Strength Tester

Customer Code SPINNING 2 Test Code CD 40 Date 8/8/2019 Time 8:17:02 PM

Sample Description
 Parcel RX A 10
 Material CD 40 Lot 06/19/2/CD40 Sample Number 20
 Examiner DESY Count 40 [Ne]

Sample Length 500 [mm] Load cell ID/FS [kg] 1 / 2 X 1
 Clamp Speed 500 [mm/min] Pretension 0 [g]
 Test Machine

Observations

Statistical Results of the Test

	Force [g]	Elongation [%]	Tenacity [cN/tex]	Average Time of Breakage [s]
Maximum	226.200 (10)	5.100 (16)	15.025 (10)	2.6 [s]
Minimum	150.400 (18)	3.600 (18)	9.990 (18)	
Average	194.155	4.416	12.897	
Stdev	39.041 [%]	33.967 [%]	39.041 [%]	
Coeff. of Variation	9.881 [%]	10.21 [%]	9.881 [%]	
5%	19.185	0.451	1.274	
95%	8.408	0.198	0.559	
99%	11.050	0.260	0.734	

Results of Single Samples

Sample #	Max Force [g]	Max Elongation [%]	Time [s]	Tenacity [cN/tex]
1	166.3	3.66	2.2	11.046
2	204.4	4.32	2.6	13.577
3	208.3	4.56	2.7	13.836
4	177.9	4.08	2.4	11.817
5	180.8	3.66	2.2	12.009
6	199.3	4.26	2.6	13.238
7	184.6	4.08	2.4	12.262
8	208.0	4.68	2.8	13.816
9	192.0	4.62	2.8	12.753
10	226.2	4.80	2.9	15.025
11	171.8	4.44	2.7	11.412
12	187.6	4.20	2.5	12.461
13	213.7	5.04	3.0	14.195
14	214.0	5.04	3.0	14.215
15	194.1	4.86	2.9	12.893
16	222.2	5.10	3.1	14.759
17	190.5	4.32	2.6	12.654
18	150.4	3.60	2.2	9.990
19	202.3	4.50	2.7	13.438
20	188.7	4.50	2.7	12.534

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Lampiran 1. 5 Data hasil pengujian strength bagus

PT. DANLIRIS
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7/23/2019 11:33:29
3.326

Test of Yarn Traction with MesdanLab Strength Tester

Customer Code **SPINNING 2** Test Code **CD 40** Date **8/10/2019 Time 9:54:52 AM**

Sample Description			Sample Number	40
Parcel		Lot	Count	40 [Nc]
Material	RF ACDE	06/19/2/CD40		
Examiner	COPS			
	VTNA			
Sample Length	500 [mm]	Load cell ID/FS [kg]	1 / 2	X 1
Clamp Speed	500 [mm/min]	Pretension	0 [g]	
Test Machine				

Observations

Statistical Results of the Test

	Force [g]	Elongation [%]	Tenacity [cN/tex]	Average Time of Breakage [s]
Maximum	254.000 (16)	6.360 (24)	16.872 (16)	3.3 [s]
Minimum	179.600 (8)	4.560 (18)	11.930 (8)	
Average	216.558	5.487	14.385	
Range	34.356 [%]	32.805 [%]	34.356 [%]	
CV	9.163 [%]	8.635 [%]	9.163 [%]	
Deviation	19.843	0.474	1.318	
IC95%	6.149	0.147	0.408	
IC99%	8.082	0.193	0.537	

Results of Single Samples

Sample #	Max Force [g]	Max Elongation [%]	Time [s]	Tenacity [cN/tex]
1	223.2	5.46	3.3	14.826
2	187.4	4.68	2.8	12.448
3	189.6	4.74	2.8	12.594
4	214.4	5.76	3.5	14.241
5	213.6	5.52	3.3	14.188
6	219.8	5.76	3.5	14.600
7	215.5	5.58	3.3	14.314
8	179.6	4.92	3.0	11.930
9	220.2	6.00	3.6	14.627
10	228.6	5.88	3.5	15.184
11	200.4	5.46	3.3	13.311
12	211.1	5.82	3.5	14.022
13	209.7	5.58	3.3	13.929
14	195.1	4.98	3.0	12.959
15	214.3	5.34	3.2	14.235
16	254.0	5.64	3.4	16.872
17	236.6	5.64	3.4	15.716
18	187.0	4.56	2.7	12.421
19	231.0	5.52	3.3	15.344
20	233.4	5.46	3.3	15.503


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Lampiran 1. 6 Data penggantian flangring


DATA FLANGRING MESIN RING FRAME SPINNING 2

O	A		B		C		D		E		F	
	MC	FLANGRING UKURAN	SPINDLE	UKURAN	MC	FLANGRING UKURAN	MC	FLANGRING UKURAN	MC	FLANGRING UKURAN	MC	FLANGRING UKURAN
R	1	RX 200 CV 2024 Ø 38 mm			1	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	1	Kanal 2013 Ø 45 mm		Kanal 2000 Ø 42 mm
X	2	RX 300 2015 Ø 38 mm			2	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	2	Kanal 2013 Ø 45 mm		Kanal 2000 Ø 42 mm
	3	RX 300 2015 Ø 38 mm			3	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	3	Kanal 2013 Ø 45 mm		Kanal 2000 Ø 42 mm
Z					4	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	4	Kanal 2013 Ø 45 mm		Kanal 2000 Ø 42 mm
4	5	Kanal 2016 Ø 45 mm		Kanal 2015 Ø 45 mm	5	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	5	Kanal 2013 Ø 45 mm		Kanal 2000 Ø 42 mm
0	6	Kanal 2016 Ø 45 mm		Kanal 2015 Ø 45 mm	6	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	6	Kanal 2013 Ø 45 mm		Kanal 2000 Ø 42 mm
2	7	Kanal 2016 Ø 45 mm		Kanal 2016 Ø 45 mm	7	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	7	Kanal 2013 Ø 45 mm		Titan 1992 Ø 41 mm
0	8	Kanal 2016 Ø 45 mm		Kanal 2016 Ø 45 mm	8	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	8	Kanal 2013 Ø 45 mm		Titan 1992 Ø 41 mm
0	9	Kanal 2016 Ø 45 mm		Kanal 2015 Ø 45 mm	9	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	9	Kanal 2013 Ø 45 mm		Titan 1992 Ø 41 mm
1	9	RX 240 BA 1997 Ø 38 mm			10	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	10	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
3	11	RX 240 BA 1997 Ø 38 mm			11	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	11	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	12	RX 240 BA 1997 Ø 38 mm			12	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	12	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
Ø	13	RX 240 BA 1997 Ø 38 mm			13	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	13	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
38	14	RX 240 BA 1997 Ø 38 mm			14	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	14	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
mm	15	RX 240 BA 1997 Ø 38 mm			15	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	15	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	16	RX 240 BA 1997 Ø 38 mm			16	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	16	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	17	RX 240 BA 1997 Ø 38 mm			17	Kanal 2015 Ø 45 mm		Kanal 2014 Ø 45 mm	17	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	18	RX 240 BA 1997 Ø 38 mm			18	SUSA 2008 Ø 38 mm		Kanal 2014 Ø 45 mm	18	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	19	RX 240 BA 1997 Ø 38 mm			19	SUSA 2008 Ø 38 mm		Kanal 2014 Ø 45 mm	19	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	20	RX 240 BA 1997 Ø 38 mm			20	SUSA 2008 Ø 38 mm		Kanal 2014 Ø 45 mm	20	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm
	21	RX 240 BA 1997 Ø 38 mm			21	SUSA 2008 Ø 38 mm		Kanal 2014 Ø 45 mm	21	Kanal 2013 Ø 45 mm		Kanal 2015 Ø 45 mm

Update : September 2017



Mengenalai
Spinning with
Cintailus Basket
Kabaq Spinning II



Robby Iva M.
Kasi Qc Spinning II

Lampiran 1. 7 Thermo higo

