

DAFTAR PUSTAKA

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SNI 08-0267-2004, cara pengambilan contoh benang untuk pengujian.

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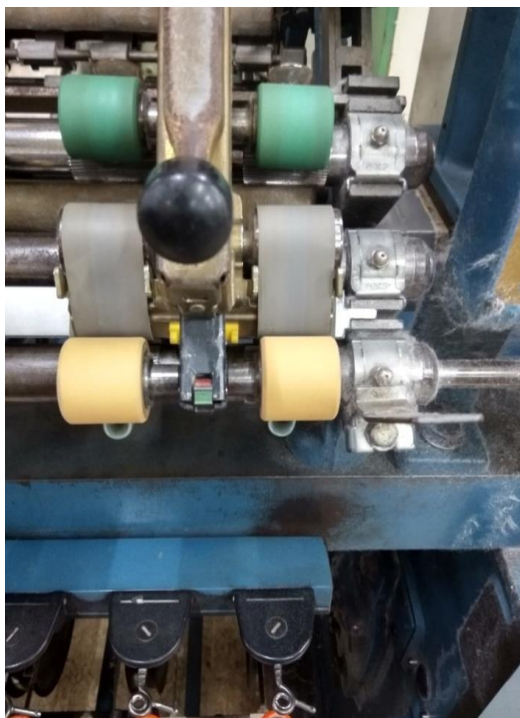
Syarif Iskandar S.Teks.,MT.Perawatan Mesin Ring Spinning

LAMPIRAN

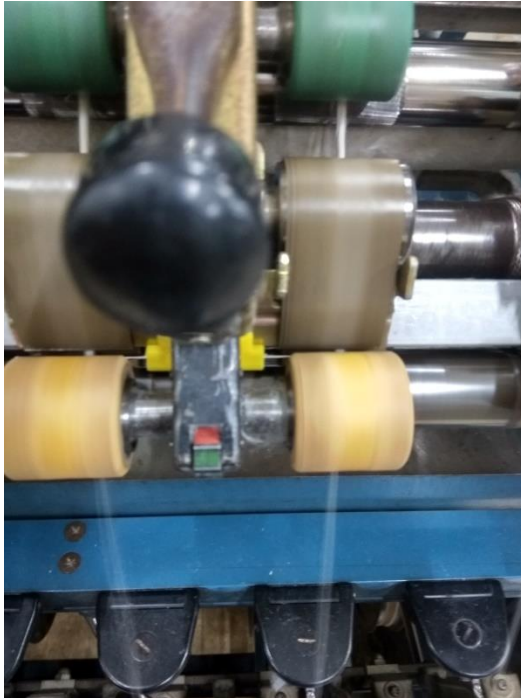
Lampiran 1 Mesin *Ring Spinning*



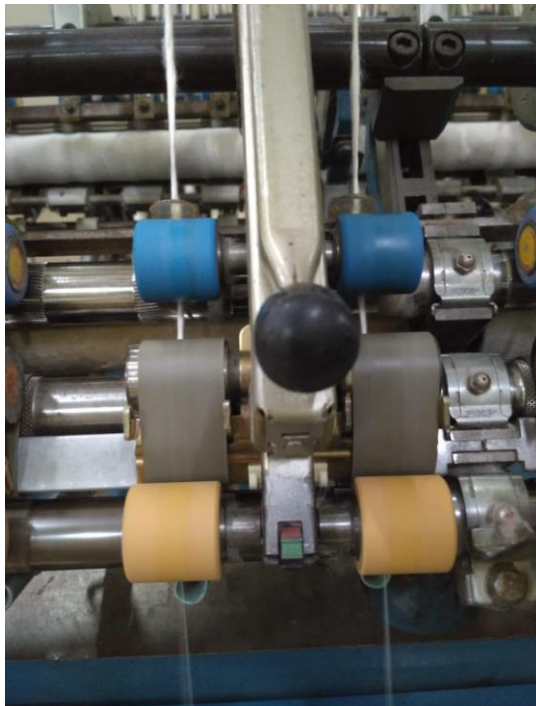
Lampiran 2 Penggunaan *distance clipkuning* pada mesin *ring spinning*



Lampiran 3 Penggunaan *spacer pinkuning* pada mesin *ring spinning*



Lampiran 4 Penggunaan *distance clip* putih pada mesin *ring spinning*



Lampiran 5 Hasil uji Singel Yarn Strenght pin spacer kuning

USTER® TENSORAPID 4 270 UTR4/ 1500N Thu 05.09.19 16:36 Operator NOVIANTO Page 1
 PT PAMOR SPINNING MILLS KARANGANYAR

Style TUBE Sample ID BENANG 031114 Nom. count Nec 30 Norm. twist 24.39 T
 Tests 6 / 4 v= 5000 mm/min Fv= 10 gF Lh= 500 mm Pcl= 30 %

DAILY REPORT PAMOR

Article 30CD-WV/RX Material class Yarn Mach. Nr. RF
 Uster Statistics 100% CO, ring yarn, carded, bobbins, weaving, 2013
 MERAH RING BESI

Total: 6 / 24 Single test(s)

Nr	Time to break s	B-Force	Elong.	Tenacity	B-Work
		gF	%	Rkm	gF.cm
1/1	0.33	301.6	5.47	15.32	434.6
1/2	0.32	298.0	5.31	15.14	413.0
1/3	0.36	340.8	5.95	17.31	529.7
1/4	0.34	302.7	5.68	15.38	451.8
2/1	0.31	282.9	5.16	14.37	387.2
2/2	0.33	308.9	5.48	15.69	442.8
2/3	0.31	287.3	5.22	14.60	390.3
2/4	0.36	338.0	6.06	17.17	531.3
3/1	0.36	329.6	5.98	16.75	514.3
3/2	0.30	273.7	4.99	13.90	353.4
3/3	0.33	303.5	5.46	15.42	423.5
3/4	0.36	297.1	6.07	15.09	457.5
4/1	0.36	349.6	5.49	17.76	498.5
4/2	0.33	290.2	5.27	14.74	413.1
4/3	0.32	290.2	5.17	15.51	413.3
4/4	0.31	305.2	5.30	15.84	425.9
5/1	0.32	311.8	6.02	15.97	492.0
5/2	0.36	314.3	6.02	15.97	492.0
5/3	0.35	339.4	5.88	17.24	507.0
5/4	0.35	280.9	5.42	14.27	392.5
6/1	0.33	280.9	5.89	15.34	446.1
6/2	0.35	302.0	5.89	15.34	446.1
6/3	0.31	308.1	5.15	15.65	411.1
6/4	0.31	314.4	5.87	15.97	481.2
7/1	0.35	314.4	5.87	15.97	481.2
7/2	0.38	337.3	6.32	17.14	547.6
7/3	0.38	337.3	6.32	17.14	547.6
7/4	0.31	270.0	5.10	13.75	353.4
Mean	0.33	307.8	5.58	15.64	446.4
CV	6.77	7.15	6.77	7.15	12.43
Q95	0.01	6.30	0.10	0.47	23.44
Min	0.30	270.6	4.99	13.75	353.4
Max	0.38	349.6	6.32	17.76	547.6
USP™ 13		71	57	72	67

Lampiran 6 Hasil uji Singel Yarn Strenghtspacer kuning

USTER® TENSORAPID 4 2.7.0 UTR4/ 1500N Thu 05.09.19 16:47 Operator NOVIANTO Page 1
 PT PAMOR SPINNING MILLS KARANGANYAR

Style TUBE Sample ID BENANG 031115 Norm count Nec 30 Norm twist 24.3
 Tests 6 / 4 v= 5000 mm/min Fv= 10 gF Lh= 500 mm Pcl= 30 %

DAILY REPORT PAMOR

Article 30CD-WV/RX Material class Yarn Mach. Nr. RF40
 Uster Statistics 100% CO, ring yarn, carded, bobbins, weaving, 2013
 MERAH RING BESI/ SPACER KUNING

Total : 6 / 24 Single test(s)

Nr	Time to break s	B-Force gF	Elong %	Tenacity Rkm	B-Work gF.cm
1/1	0.32	269.9	5.29	13.71	377.0
1/2	0.35	330.2	5.93	12.77	423.2
1/3	0.37	346.8	6.24	17.62	556.4
1/4	0.36	312.8	5.95	15.89	474.6
2/1	0.33	302.4	5.49	15.36	423.6
2/2	0.33	302.4	5.47	15.36	428.8
2/3	0.31	272.3	5.12	13.83	357.0
2/4	0.38	327.3	6.32	16.63	521.7
3/1	0.31	286.4	5.24	14.55	392.0
3/2	0.33	281.9	5.42	14.32	407.2
3/3	0.33	302.2	5.42	15.35	416.7
3/4	0.33	283.4	5.54	14.40	395.2
4/1	0.33	306.6	5.51	15.58	438.2
4/2	0.36	316.6	5.93	16.09	478.3
4/3	0.33	268.0	5.46	13.61	382.5
4/4	0.34	296.8	5.64	15.08	423.1
5/1	0.36	329.0	6.05	16.72	504.0
5/2	0.34	262.0	5.58	13.31	378.0
5/3	0.36	296.0	5.96	15.04	446.9
5/4	0.35	284.4	5.77	14.45	419.8
6/1	0.26	295.6	4.40	11.97	272.5
6/2	0.35	310.5	5.85	15.77	457.7
6/3	0.37	311.1	6.13	15.81	480.6
6/4	0.35	302.2	5.84	15.35	433.1
Mean	0.34	297.4	5.65	15.11	431.6
CV	7.36	8.48	7.37	8.48	13.94
Q95	0.01	10.65	0.18	0.54	25.41
Min	0.26	235.6	4.40	11.97	272.5
Max	0.38	346.8	6.32	17.62	556.4
USP™ 13		61	53	82	73

Lampiran 7 Hasil uji Singel Yarn Strenght spacer putih

USTER® TENSORAPID 4 2.7.0 UTR4/ 1500N Thu 05/09/19 16:54 Operator INOVANTO Page
 PT PAMOR SPINNING MILLS KARANGANYAR

Style TUBE Sample ID BENANG 031116 Nom count Nec 30 Nom twist 24
 Tests 6 / 4 v= 5000 mm/min Fv= 10 gF Lh= 500 mm Pcl= 30 %

DAILY REPORT PAMOR

Article 30CD-WV/RX Material class Yarn Mach. Nr. RF40
 Uster Statistics 100% CO, ring yarn, carded, bobbins, weaving, 2013
 MERAH RING BESI/ SPACER PUTIH

Total 6 / 24 Single test(s)

Nr	Time to break s	B-Force gF	Elong %	Tenacity Rkm	B-Modul gF/cm
1/1	0.31	267.8	5.15	13.60	354.8
1/2	0.33	307.5	5.55	13.62	433.0
1/3	0.37	326.7	6.23	16.70	518.5
1/4	0.30	251.6	4.88	12.78	324.0
2/1	0.35	318.8	5.78	16.19	488.4
2/2	0.29	282.6	4.81	14.36	358.5
2/3	0.30	301.1	4.83	15.29	394.7
2/4	0.33	310.0	5.42	15.75	440.8
3/1	0.37	290.9	6.18	14.78	451.7
3/2	0.31	271.7	5.21	13.80	364.8
3/3	0.34	308.3	5.88	15.88	442.9
3/4	0.33	275.3	5.53	13.86	398.4
4/1	0.35	302.0	5.88	15.34	465.7
4/2	0.30	292.4	4.93	14.85	382.1
4/3	0.29	296.9	4.67	15.06	378.1
4/4	0.33	276.1	5.42	14.02	387.8
5/1	0.31	281.4	5.16	14.26	400.2
5/2	0.28	282.1	4.75	14.33	360.7
5/3	0.26	293.6	4.33	11.87	271.8
5/4	0.33	282.2	5.41	14.34	402.8
6/1	0.30	311.0	5.41	15.80	438.7
6/2	0.30	302.2	5.03	15.35	405.0
6/3	0.31	294.0	5.10	14.63	413.9
6/4	0.28	260.8	4.80	13.40	324.3
Mean	0.32	288.8	5.26	14.67	386.8
CV	8.95	7.60	8.83	7.60	18.52
Q80	0.01	9.20	0.20	0.47	22.84
Min	0.26	268.6	4.88	11.87	271.8
Max	0.37	326.7	6.23	16.70	518.5
USPT® 13		88	74	91	86

Lampiran 8 Hasil Uji *USTER* spacer kuning

USTER® TESTER 5 - S400 R 5.7 Thu 05.09.19 15:57 Operator NOVIANTO Page 1
 PT. PAMOR SPINNING MILLS KARANGANYAR, INDONESIA

TU UT5-1 Catalog BENANG Temp 27.5 °C Rel.H 106.6 %
 Style CARDED Sample ID 98264 Nom. count Nec 30 Nom. twist 24.39 T/inch
 Tests 6 / 1 v= 400 m/min t= 1 min Meas. slot 4 Short staple Absorber 33 %

DAILY REPORT PAMOR

Article 30 CD-WV/ Material class Yarn Mach. Nr. RF40
 Uster Statistics 100% CO, ring yarn, carded, bobbins, weaving, 2013
 Fiber Cotton 4.1Micr 27.8mm 100%
 SPACER KUNING

Total tests : 6 / 6 Single test(s)

Nr	U%	CVm	Index	Thin -30%	Thin -50%	Thick +35%	Thick +50%	Neps +140%	Neps +200%	Rel. Cnt ±	H	sh
	%	%		/km	/km	/km	/km	/km	/km	%		
1	12.96	16.46	1.82	3550	32.5	1453	292.5	2043	352.5	-0.4	6.80	1.63
2	13.68	17.38	1.92	4343	85.0	1860	432.5	2563	545.0	-1.9	6.48	1.58
3	13.83	17.64	1.95	4393	67.5	1955	485.0	2725	592.5	-0.8	6.35	1.59
4	13.15	16.67	1.84	3723	60.0	1615	290.0	2195	347.5	0.6	6.42	1.50
5	13.75	17.46	1.93	4205	45.0	1858	450.0	2555	532.5	0.6	6.58	1.66
6	13.21	16.82	1.86	3850	40.0	1730	360.0	2530	512.5	3.1	6.53	1.61
Mean	13.43	17.07	1.89	4010	65.0	1745	385.0	2435	480.4	0.0	6.52	1.60
CV	2.7	2.8	2.8	8.7	35.6	10.6	21.6	10.6	21.7	1.7	2.4	3.5
s	0.36	0.49	0.05	351	19.6	186	83.3	259	104.4	1.7	0.16	0.06
Q95	0.38	0.51	0.06	368	20.5	195	87.4	272	109.6	1.8	0.17	0.06
Max	13.83	17.64	1.95	4393	85.0	1955	485.0	2725	592.5	3.1	6.80	1.66
Min	12.96	16.46	1.82	3550	32.5	1453	290.0	2043	347.5	-1.9	6.35	1.50
USP™13		73			93	82	85	85	63		94	78

Lampiran 9 Hasil Uji *USTER spacer putih*

USTER® TESTER 5 - S400 R 5.7 Thu 05.09.19 16:11 Operator NOVIANTO
 PT. PAMOR SPINNING MILLS KARANGANYAR, INDONESIA

Page 1

TU UT5-1 Catalog BENANG Temp 27.5 °C Rel.H 106.6 %
 Style CARDED Sample ID 98265 Nom. count Nec 30 Nom. twist 24.39 T/inch
 Tests 6 / 1 v= 400 m/min t= 1 min Meas. slot 4 Short staple
 Absorber 33 %

DAILY REPORT PAMOR

Article 30 CD-WV/ Material class Yarn Mach. Nr. RF40
 Uster Statistics 100% CO, ring yarn, carded, bobbins, weaving, 2013
 Fiber Cotton 4.1Micr 27.8mm 100%
 SPACER PUTIH

Total tests : 6 / 6 Single test(s)

Nr	U%	CVm	Index	Thin -30%	Thin -50%	Thick +35%	Thick +50%	Neps +140%	Neps +200%	Rel. Cnl ±	H	sh
	%	%		/km	/km	/km	/km	/km	/km	%		
1	13.53	17.16	1.89	3900	50.0	1690	335.0	2380	485.0	1.2	6.55	1.59
2	14.01	17.77	1.96	4500	62.5	2023	540.0	2865	527.5	-0.7	6.26	1.61
3	13.67	17.35	1.92	4130	52.5	1683	440.0	2428	477.5	0.4	6.42	1.61
4	13.70	17.51	1.93	4005	70.0	1909	425.0	2930	490.0	0.9	6.62	1.63
5	13.01	16.57	1.83	3590	25.0	1493	317.5	2215	410.0	-0.5	6.03	1.39
6	13.42	17.04	1.88	3970	47.5	1783	445.0	2623	555.0	0.4	6.09	1.47
Mean	13.57	17.23	1.90	4031	51.3	1746	417.1	2523	489.2	0.0	6.31	1.55
CV	2.5	2.4	2.4	7.4	30.0	10.0	19.5	9.1	10.1	0.8	3.5	6.2
s	0.34	0.41	0.05	300	15.4	175	81.4	229	49.6	0.8	0.22	0.10
Q05	0.39	0.43	0.05	315	16.2	181	85.1	241	52.1	0.9	0.23	0.10
Max	14.01	17.77	1.96	4500	70.0	2023	540.0	2865	555.0	1.2	6.55	1.63
Min	13.01	16.57	1.83	3590	25.0	1493	317.5	2215	410.0	-0.8	6.03	1.39
USP™13		75			90	83	88	87	64		88	73

Lampiran 10 Hasil Uji *USTERpin spacer*

USTER® TESTER 5 - S400 R 5.7 Thu 05.09.19 15:46 Operator NOVIANTO
 PT. PAMOR SPINNING MILLS KARANGANYAR, INDONESIA

TU UT5-1 Catalog BENANG Temp 27.4 °C Rel.H
 Style CARDED Sample ID 98263 Nom. count Nec 30 Norm
 Tests 6 / 1 v= 400 m/min t= 1 min Meas. slot 4 Short
 Absc

DAILY REPORT PAMOR

Article 30 CD-WV/ Material class Yarn Mach. Nr. RF40
 Uster Statistics 100% CO, ring yarn, carded, bobbins, weaving, 2013
 Fiber Cotton 4.1Micr 27.8mm 100%
 PIN SPACER

Total tests : 6 / 6 Single test(s)

Nr	U%	CVm	Index	Thin -30%	Thin -50%	Thick +35%	Thick +50%	Neps +140%	Neps +200%	Rel. Cnt ±	H
	%	%		/km	/km	/km	/km	/km	/km	%	
1	12.12	15.29	1.69	2/00	15.0	90/5	125.0	1490	202.5	1.1	6.60
2	12.96	16.42	1.81	3443	27.5	1285.0	250.0	2045	355.0	0.4	6.36
3	12.38	15.68	1.73	3133	30.0	1035.0	160.0	2015	362.5	-1.0	6.93
4	12.00	16.43	1.82	3553	25.0	1437.5	320.0	2155	472.5	0.0	5.04
5	12.34	15.65	1.73	2825	20.0	1075.0	190.0	1733	267.5	1.1	6.29
6	11.75	14.83	1.64	2390	12.5	795.0	115.0	1378	250.0	-0.6	6.94
Mean	12.41	15.72	1.74	3007	21.7	1089	193.3	1803	318.3	0.0	6.51
CV	3.8	4.1	4.1	15.0	32.4	21.8	40.8	17.8	30.7	1.0	6.0
s	0.47	0.64	0.07	450	7.0	237.6	79.0	320	97.7	1.0	0.39
Q05	0.40	0.67	0.07	172	7.1	240.1	82.0	333	102.5	1.0	0.11
Max	12.96	16.48	1.82	3553	30.0	1438	320.0	2158	472.5	1.1	6.94
Min	11.75	14.83	1.64	2390	12.5	795.0	115.0	1378	202.5	-1.0	5.94
USP™13		49			61	58	54	67	46		93

Lampiran 11 Standar Kualitas Benang

NO	NE.1	30 CDKN				
		15%	25%	35%	50%	65%
1	CV NE	1.0	1.2	1.3	1.5	1.8
2	CV M %	13.6	14.1	14.6	15.2	15.8
3	U %	10.88	11.28	11.68	12.16	12.64
4	THIN - 50%	4	6	9	13	20
5	THICK + 50%	83	108	135	188	257
6	NEPS +200%	165	223	281	396	548
	IPI	<u>252</u>	<u>337</u>	<u>425</u>	<u>597</u>	<u>825</u>
7	THIN - 30%	101	136	173	250	358
8	THICK + 35%	516	631	741	943	1180
9	NEP +140%	612	806	987	1334	1749
	IPI	<u>1229</u>	<u>1573</u>	<u>1901</u>	<u>2527</u>	<u>3287</u>
0	HAIRINNESS	5.5	5.8	6.0	6.4	6.8
1	SYS / Gf	329.5	317.7	306.3	289.9	276.2
2	CV% SYS	7.6	8	8.3	8.9	9.5
3	EL %	5.5	6.2	6	5.8	5.4
4	cNtex	16.7	16.1	15.6	14.7	14.0
5	RKM	17.07	16.46	15.87	15.02	14.31
6	LBS	81	78	75	70	67
7	CSP	2424	2331	2241	2111	2003
8	EMD	3803	3400	3044	2607	2267

