

DAFTAR PUSTAKA

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LAMPIRAN

Lampiran 1 Data Penyetelan Blowing

NO	ITEM	PE	PE	RY	CO
	BDT/PLK				
1	Rpm Beater	1100	750	750	1200
2	Traveller Speed	14 m/min			
3	Suction Pre	25 mmwc			
4	Open Depth	1,5 mm			
SINGLE ROLL					
1	Rpm	-	-	-	500
2	Grids Bar	-	-	-	15
MULTI MIXER					
1	Spike Lattice High	35%	35%	35%	35%
2	Spike Lattice Low	20%	20%	20%	20%
3	V-Belt High	0,70	0,70	0,45	0,85
4	V-Belt Low	0,45	0,45	0,34	0,75
5	Upper Pressure	12 mmwc	12	10	12
6	Lower Pressure	8mmwc	8	8	8
7	Speed Beater High	1:550	1:550	1:550	1:720
	Mp/Dp	90/215	90/215	90/215	90/175
8	Speed Beater Low	2:	2:	2:	2:
FINE OPPENER					
1	Sett Pressure	80mmwc	80	80	70
2	Propotion Grain	1,20	1,20	1,00	0,79
3	Upper Pressure	80mmwc	80	80	70
4	Lower Pressure	30mmwc	30	35	15
5	Back Single Yield	80 kg	80	80	75
6	Rpm Beater	525	525	650	525
	Pulley	250	250	200	250
7	Manual Speed	70%	70%	50%	50%
8	Grid Bar	0/0/0	0/0/0	0/0/0	0/0/0

Lampiran 2 Data Kondisi Mesin Carding

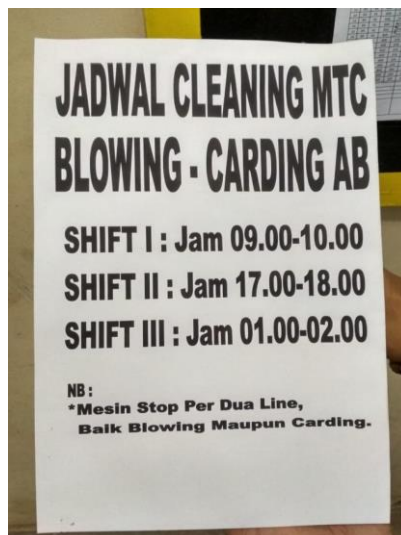
Unit: AB		PE BUKITA BINA TEXTILE B															STATUS DOKUMEN		No. Revisi :						
DATA KONDISI MESIN CARDING																	No. Form :								
Bulan: AGUSTUS																	Tahun: 2019								
NO	KAC	RAJW	GRAIN	BEATER (RPM MOTOR)				TAKER IN				TOP FLAT				CYLINDER (RPM MOTOR 1440)			SETTING		STATIONARY				
				MP	DP	RPM	DOH FEED PLATE	MP	DP	MP	DP	MP	DP	MP	DP	MP	DP	MP	DP	MP		DP	CROSS ROLL	CALENDER ROLL	BACK
1	06	PE	450	140	205	960	22	5	118	242	.8	1,4	693	26	34	125	14.14.12.12.12	118	564	297	5	6	6	12.12.12.10	10.10.8.8
2	C7	PE	450	140	205	960	22	5	118	242	.8	1,4	693	21	39	85	14.14.12.12.12	118	564	297	5	6	6	12.12.12.10	10.10.8.8
3	D1	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	14.14.12.12.12	130	564	328	5	6	6	12.12.12.10	10.10.8.8
4	D2	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	14.14.12.12.12	130	564	328	5	6	6	12.12.12.10	10.10.8.8
5	D3	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	14.14.12.12.12	130	564	328	5	6	6	12.12.12.10	10.10.8.8
6	D4	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	14.14.12.12.12	130	564	328	5	6	6	12.12.12.10	10.10.8.8
7	D5	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	14.14.12.12.12	130	564	328	5	6	6	12.12.12.10	10.10.8.8
8	D6	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	12.12.10.10.10	130	564	328	5	6	6	12.12.12.10	10.10.8.8
9	D7	PE	450	140	205	960	22	5	130	242	.8	1,4	763	26	34	131	14.14.12.12.12	130	564	328	5	6	6	12.12.12.10	10.10.8.8
10	E1	CO	370	140	205	960	30	5	118	242	.8	1,4	693	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
11	E2	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
12	E3	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
13	E4	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
14	E5	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
15	E6	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
16	E7	CO	370	140	205	960	26	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
17	E8	CO	370	140	205	960	30	5	118	242	.8	1,4	640	39	21	301	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
18	F1	CO	370	140	205	960	30	5	118	242	.8	1,4	640	39	21	301	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
19	F2	CO	370	140	205	960	30	5	118	242	.8	1,4	640	39	21	301	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
20	F3	CO	370	140	205	960	30	5	118	242	.8	1,4	640	39	21	301	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
21	F4	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
22	F5	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
23	F6	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
24	F7	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7
25	F8	CO	370	140	205	960	30	5	118	242	.8	1,4	640	26	34	125	10.10.9.9.9	118	564	297	5	6	6	8.8.8.8	7.7.7.7

Diketahui Oleh					Disetujui Oleh					Dibuat Oleh					
Nama		Sri Hanwan			Purwoko Aji			Sukarno Utomo			Nyamadi			Suryono	
Jabatan		Manager Produksi			Ass.Man.Urit AB			Ass.Kabag Mtc			Kasie Mtc Blow-Card ABCD			Spv Mtc Blow-Card AE	
Tanggal															
Tanda Tangan															


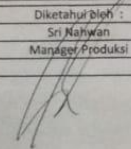


Lampiran 3 Suhu dan Temperatur Mesin carding



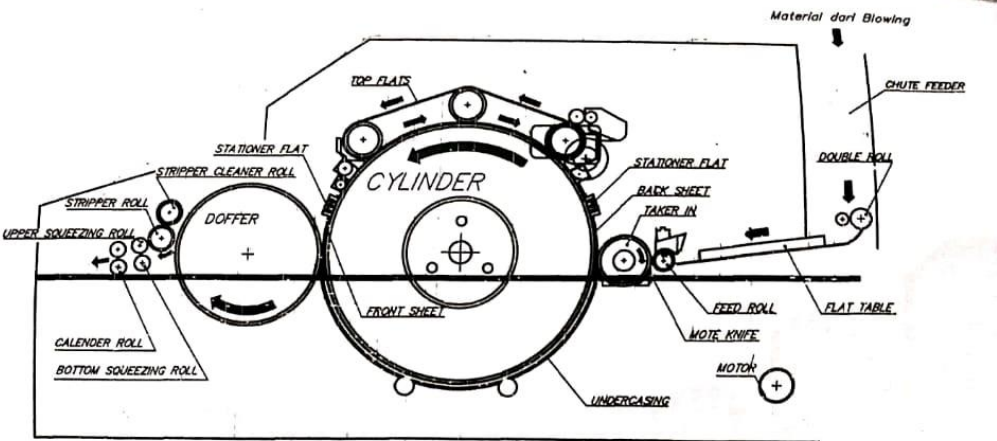
Lampiran 4 Jadwal Pembersihan Maintenance



Lampiran 5 Schedule Periodic Maintenance

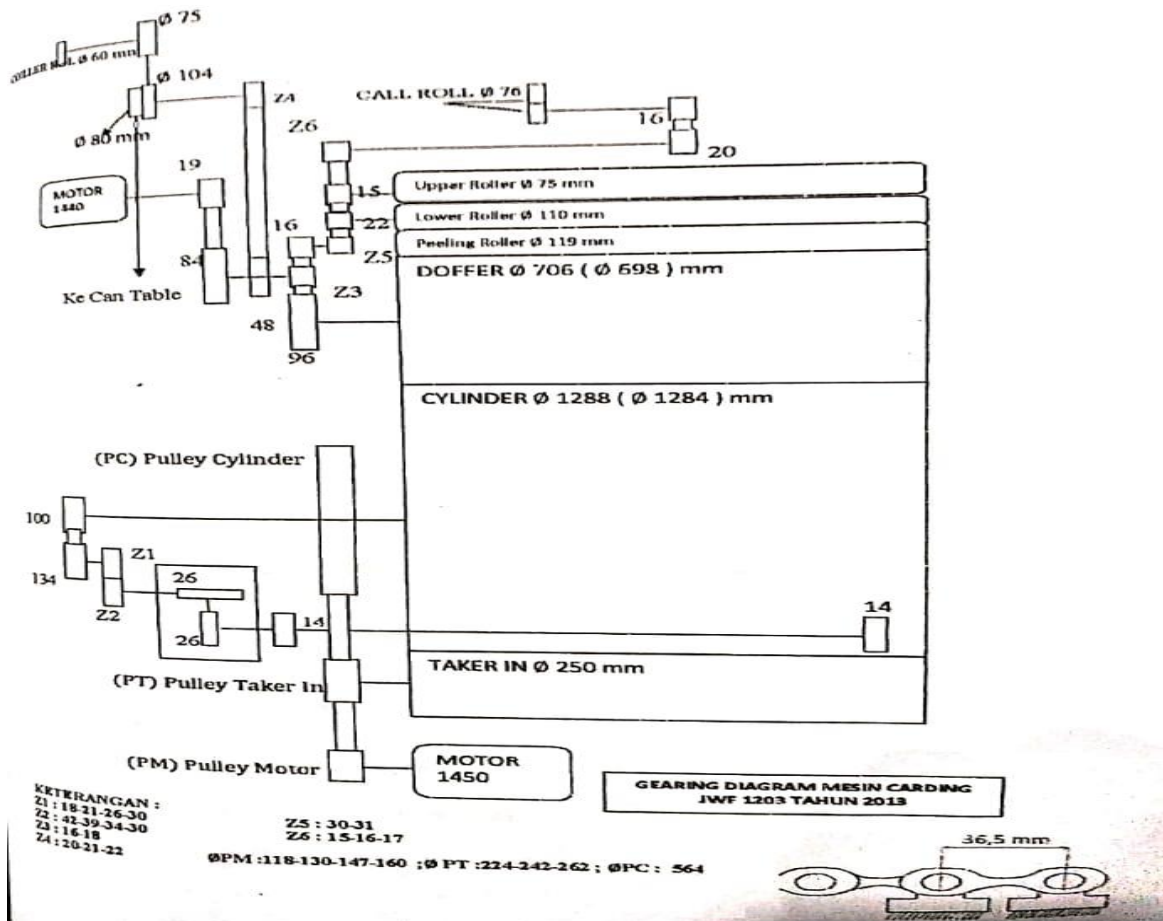
 PT. DELTA DUNIA TEXTILE II <small>PT. DELTA DUNIA TEXTILE II</small>		SCHEDULE PERIODIK MTC MESIN CARDING												STATUS DOKUMEN No. Revisi : No. Form : Tgl. Terbit :	
Unit: Ab		Bulan: JANUARI										Tahun: 2019			
NO	JOB/ PEKERJAAN	PERIODE												KETERANGAN	
		JANUARI	FEBRUARI	MARET	APRIL	MEI	JUNI	JULI	AGUSTUS	SEPTEMBER	OKTOBER	NOVEMBER	DESEMBER		
1	GREASING		▲			▲			▲			▲			3 BULAN
2	OILING RANTAI			▲			▲			▲			▲		3 BULAN
3	GANTI OLI GEAR BOX TOP FLAT											▲			14 BULAN
4	GANTI OLI GEAR BOX FEED ROLL											▲			14 BULAN
5	GRINDING CYLINDER				▲							▲			6 BULAN
6	GRINDING DOFFER				▲							▲			6 BULAN
7	GRINDING TOPLAT			▲						▲					6 BULAN
8	GRINDING LIKER-IN						▲							▲	6 BULAN
9	COILER ZONE	▲						▲							6 BULAN
10	CHUTE FEED ZONE	▲						▲							6 BULAN
11	TOUCHING ROLL DAN CROSS ROLL ZONE		▲						▲						6 BULAN
Diketahui oleh :		Ditetapkan oleh :				Disetujui oleh :				Dibuat oleh :					
Nama Sri Mahywan		Hengky K				Nyamadi				Ahmad Fauzi					
Jabatan Manager Produksi		Kabag Mtc Front				Kasie Mtc Blow-Carding				Spv Mtc Blow-Card AB					
Tanggal															
Tanda Tangan															

Lampiran 6 Skema Mesin Carding



SKEMA MESIN CARDING

Lampiran 7 Gearing Diagram Carding



Lampiran 10 Hasil NATI D7

NATI-REPORT

Weight(gm)/sample: 1

SAMPLE Card	TEST No.	TRASH			NEPS > ...mm		
		>0.25mm	>0.5mm	0.5	0.7	1.0	
D7	1	101	0	96	52	6	
D7	2	44	2	84	37	8	
D7	3	96	9	111	55	7	
MEAN		80.3	3.7	97.0	48.0	7.0	
ST. DEVIATION		31.6	4.7	13.5	9.6	1.0	
%CV		39.29	128.89	13.94	20.08	14.28	

84.0 152.

Lampiran 11 Hasil Nati Mesin Carding D6 Sebelum Pecobaan

NATI-REPORT

Weight(gm)/sample: 1

SAMPLE Card	TEST No.	TRASH			NEPS > ...mm		
		>0.25mm	>0.5mm	0.5	0.7	1.0	
D6	1	98	2	100	55	13	
D6	2	110	3	99	52	11	
D6	3	53	0	90	35	5	
MEAN		87.0	1.7	96.3	47.3	9.7	
ST. DEVIATION		30.0	1.5	5.5	10.8	4.2	
%CV		34.53	91.78	5.71	22.78	43.04	

88.7 153.3

Lampiran 14 Hasil NATI Mesin *Carding* D6 Percobaan 3

NATI-REPORT

Berat (g) Sample 1

SAMPLE	FLW	TRICH			NEPS > 240 mm		
		>0.25mm	>0.5mm	0.5	0.7	1.0	
D	34	35	1	61	17	3	
D	34	24	3	77	19	1	
D	32	17	1	61	20	1	
MEAN		25.3	2.0	66.3	18.7	1.7	
ST. DEVIATION		9.1	1.0	9.2	1.5	1.2	
SDU		35.81	50.00	13.92	8.18	69.24	

27.3 86.7