

DAFTAR PUSTAKA

Buku pedoman Praktik Kerja Lapangan Akademi Komunitas Industri Tekstil dan Produk Tekstil Surakarta tahun 2019

Dokumen Distribusi Karyawan, *Department HRD* PT. Excellence Qualities Yarn

Dokumen Jadwal Pemeliharaan Mesin, *Department Maintenance* PT. Excellence Qualities Yarn

Dokumen Jumlah Karyawan, *Department HRD* PT. Excellence Qualities Yarn

Dokumen Pengujian Kekuatan Benang, *Department Quality Control* PT. Excellence Qualities Yarn

Dokumen Pengujian Mulur Benang, *Department Quality Control* PT. Excellence Qualities Yarn

Dokumen Pengujian Nomor Benang, *Department Quality Control* PT. Excellence Qualities Yarn

Dokumen Pengujian U% Benang, *Department Quality Control* PT. Excellence Qualities Yarn

Dokumen Pengujian *Twist* Benang, *Department Quality Control* PT. Excellence Qualities Yarn

Dokumen Spesifikasi Mesin, *Department Maintenance* PT. Excellence Qualities Yarn

[https://translate.googleusercontent.com/translate_c?depth=1&hl=id&nv=1&prev=search&rurl=translate.google.com&sl=en&sp=nm4&u=https://en.m.wikipedia.org/wiki/Student%2527s_t-](https://translate.googleusercontent.com/translate_c?depth=1&hl=id&nv=1&prev=search&rurl=translate.google.com&sl=en&sp=nm4&u=https://en.m.wikipedia.org/wiki/Student%2527s_t-distribution&xid=17259,15700019,15700186,15700191,15700256,15700259,15700262,15700265&usg=ALkJrhiuPCy4ONxspxpQgNgCfDyn59GnA)

[distribution&xid=17259,15700019,15700186,15700191,15700256,15700259,15700262,15700265&usg=ALkJrhiuPCy4ONxspxpQgNgCfDyn59GnA](https://translate.googleusercontent.com/translate_c?depth=1&hl=id&nv=1&prev=search&rurl=translate.google.com&sl=en&sp=nm4&u=https://en.m.wikipedia.org/wiki/Student%2527s_t-distribution&xid=17259,15700019,15700186,15700191,15700256,15700259,15700262,15700265&usg=ALkJrhiuPCy4ONxspxpQgNgCfDyn59GnA) diakses tanggal 28 Agustus 2019

Profil Perusahaan www.excellence.co.id diakses tanggal 6 Agustus 2019

LAMPIRAN

Lampiran 1 Spesifikasi Mesin

| SPESIFIKASI MESIN | |
|-------------------|-------------|
| No.Mesin | RSF.14 |
| Proses | 30 TR |
| Lot | 821 |
| Ne Roving | 1 |
| Bobin Flyer | Blue C. Red |
| Bobin Ring | Red |
| BD | 1.4 |
| TD | 32.83 |
| TPI | 18,6 |
| Speed | 18500 |
| No.Traveller | 1/10 LRT |
| Spacer | White |

Lampiran 2 Rubber cots sobek/cacat



Lampiran 3 Permukaan top front roll tidak rata



Lampiran 4 Uji Ketidakrataan Benang (U% tinggi)

ESTER 5 - S400 R 5.7 Mon 19.08.19 11:35 Operator Page 1
 LENCE QUALITIES YARN BALONGBENDO-SIDOARJO

UTS-1 Catalog EQY Temp 25 °C Ref:1 34.5 %
 COP Sample ID 60133 Norm. count Nec 30 Norm. twist 18.6 T/m
 4 / 1 v= 400 m/min t= 1 min Meas. slot 4 Short staple Absorber 67 %

REPORT

TR Material class Yarn Mach. Nr. RF.1A
 s 67/33%, 65/35% PES/CV, ring yarn, bobbins, 2013
 polyester 1.2den 38mm 65% Viscose 1.2den 38mm 35%
 COP FRONT ROLL CACAT / COP RED

| 4 / 4 Single test(s) | | | | | | | | | | | | | | | | |
|----------------------|-------|------|------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|------|------|--|
| U% | CVm | CVm | CVm | CVm | Index | Thin | Thin | Thick | Thick | Neps | Neps | Neps | Neps | H | sh | |
| % | % | 1m | 3m | 10m | | -40% | -50% | +35% | +50% | +140% | +200% | +250% | +400% | | | |
| % | % | % | % | % | | /km | /km | /km | /km | /km | /km | /km | /km | | | |
| 10.03 | 12.68 | 4.08 | 3.16 | 2.78 | 1.54 | 87.5 | 0 | 255 | 25 | 147.5 | 47.5 | 17.5 | 10 | 4.92 | 1.08 | |
| 9.45 | 11.91 | 4.45 | 2.56 | 2.1 | 1.45 | 42.5 | 0 | 130 | 7.5 | 70 | 17.5 | 2.5 | 2.5 | 4.58 | 0.94 | |
| 9.74 | 12.26 | 2.96 | 3.04 | 2.56 | 1.49 | 45 | 0 | 152.5 | 5 | 85 | 25 | 2.5 | 0 | 4.33 | 0.9 | |
| 10.24 | 12.27 | 2.64 | 2.85 | 2.41 | 1.49 | 55 | 0 | 192.5 | 10 | 95 | 12.5 | 0 | 0 | 4.42 | 0.93 | |
| 9.81 | 12.36 | 3.87 | 2.79 | 2.1 | 1.5 | 55 | 2.5 | 200 | 17.5 | 85 | 7.5 | 5 | 0 | 4.53 | 0.95 | |
| 9.85 | 12.30 | 3.80 | 2.88 | 2.39 | 1.49 | 57.00 | 0.50 | 186.0 | 13.00 | 96.50 | 22.00 | 5.50 | 2.50 | 4.56 | 0.96 | |
| 3.04 | 2.24 | 6.58 | 8.06 | 12.37 | 2.15 | 31.54 | 223.6 | 25.86 | 62.91 | 30.96 | 71.15 | 126.1 | 173.2 | 4.95 | 7.25 | |
| 0.30 | 0.28 | 0.25 | 0.23 | 0.30 | 0.03 | 17.98 | 1.12 | 48.11 | 8.18 | 29.82 | 15.65 | 6.94 | 4.33 | 0.23 | 0.03 | |

Lampiran 5 Uji Ketidakrataan Benang (U% standar)

USTER® TESTER 5 - S400 R 5.7 Mon 19.08.19 15:54 Operator DEVI Page 1
 EXCELLENCE QUALITIES YARN BALONGBENDO - SIDOARJO

UTS-1 COP 4 / 1 Catalog Sample ID 60143 vs= 400 m/min EGY' t= 1 min Temp Norm. count Nec 30 Meas. slot 4 20.2 °C Rel.H Norm. twist Short staple Absorber 34.7 % 18.6 Tim 67 %

REPORT

TR Material class Yarn Mach. Nr. RF.14
 Statistics 67/33%, 65/35% PES/CV, ring yarn, bobbins, 2013
 Polyester 1.2den 38mm 65% Viscose 1.2den 38mm 35%
 REGULER / COP RED

3 : 4 / 4 Single test(s)

| U% | CVm | CVm | CVm | Index | Thin | Thin | Thick | Thick | Neps | Neps | Neps | Neps | H | sh | |
|------|-------|-------|------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|------|
| % | % | 1m | 3m | % | -40% | -50% | +35% | +50% | +140% | +200% | +280% | +400% | | | |
| % | % | % | % | % | /km | /km | /km | /km | /km | /km | /km | /km | | | |
| 9.64 | 12.11 | 3.46 | 2.56 | 2.1 | 1.45 | 42.5 | 2.5 | 130 | 10 | 70 | 15 | 2.5 | 2.5 | 4.59 | 0.94 |
| 9.66 | 12.18 | 4.08 | 3.16 | 2.78 | 1.54 | 87.5 | 0 | 255 | 15 | 147.5 | 20 | 17.5 | 10 | 4.73 | 1.08 |
| 9.85 | 12.37 | 3.96 | 3.04 | 2.95 | 1.49 | 45 | 0 | 132.5 | 15 | 85 | 20 | 2.5 | 0 | 4.61 | 0.93 |
| 9.78 | 12.31 | 3.64 | 2.85 | 2.41 | 1.49 | 55 | 2.5 | 192.5 | 22.5 | 95 | 32.5 | 0 | 0 | 4.59 | 0.93 |
| 9.67 | 12.27 | 3.87 | 2.79 | 2.1 | 1.5 | 55 | 0 | 200 | 12.5 | 85 | 20 | 5 | 0 | 4.76 | 0.95 |
| 9.72 | 12.25 | 3.002 | 2.88 | 2.39 | 1.494 | 57 | 1 | 186 | 15 | 85 | 21.5 | 5.50 | 2.5 | 4.656 | 0.96 |
| 0.4 | 0.8 | 6.6 | 8.1 | 12.4 | 2.1 | 31.5 | 156.9 | 25.9 | 31.2 | 35.1 | 30.3 | 126.1 | 173.2 | 1.8 | 7.3 |
| 0.08 | 0.10 | 0.25 | 0.33 | 0.30 | 0.03 | 17.98 | 1.37 | 48.11 | 4.68 | 29.87 | 6.52 | 6.94 | 4.33 | 0.08 | 0.07 |

Lampiran 6 Pengecekan Reguler Strength and Elongation

PT EXCELLENCE QUALITIES YARN BALONGBENDO - SIDOARJO

Style COP 12 / 10 Sample ID MVS 082509 vs= 5000 mm/min Fv= 10 gF Norm. count Nec 30 Lh= 500 mm Pci= 40 %

Table and Diagrams

Article TR Material class Yarn Mach. Nr. RF.14
 Uster Statistics 67/33%, 65/35% PES/CV, ring yarn, bobbins, 2013
 30 TR 621 - REGULER / COP RED

| Nr | Time to break | B-Force | Elong. | Tenacity | B-Work |
|------|---------------|---------|--------|----------|--------|
| | s | gF | % | Rlm | gF.cm |
| R1 | 0.61 | 500.8 | 10.08 | 25.44 | 1329 |
| 2 | 0.67 | 559.9 | 11.12 | 28.45 | 1655 |
| 3 | 0.64 | 540.4 | 10.63 | 27.45 | 1548 |
| 4 | 0.63 | 576.2 | 10.48 | 25.71 | 1426 |
| 5 | 0.64 | 577.5 | 10.69 | 25.78 | 1457 |
| Mean | 0.64 | 523.0 | 10.6 | 26.57 | 1483 |
| CV | 3.40 | 4.95 | 3.54 | 4.96 | 8.36 |
| Min | 0.61 | 500.8 | 10.08 | 25.44 | 1329 |
| Max | 0.67 | 559.9 | 11.12 | 28.45 | 1655 |

Lampiran 7 Pengecekan Reguler Ne

COUNT (RF.14)

| | |
|------|-------|
| R1 | 30.65 |
| 2 | 30.71 |
| 3 | 30.42 |
| 4 | 30.83 |
| 5 | 30.36 |
| Mean | 30.59 |
| CV | 0.65 |

COUNT (RF.14)

| | |
|------|-------|
| R1 | 30.24 |
| 2 | 30.78 |
| 3 | 30.46 |
| 4 | 30.57 |
| 5 | 30.51 |
| Mean | 30.51 |
| CV | 0.64 |

Lampiran 8 Pengecekan Suhu Ruangan

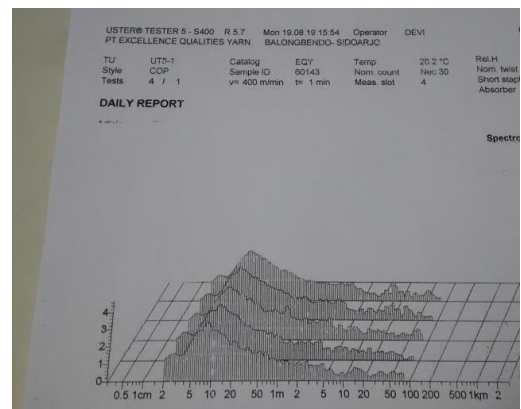
FORMULIR LOG SHEET AIR CONDITIONING & TVR

DATE: _____

| Name | SHIFT 1 | | | | SHIFT 2 | | | |
|-------------------------|---------|---|------|----|---------|----|----|----|
| | Jam | 6 | 8 | 10 | 12 | 14 | 16 | 18 |
| Yarn Conditioning | | | | | | | | |
| Temperatur | °C | | 13,1 | | | | | |
| Room Humidity | % | | 99,1 | | | | | |
| Set point Temperatur | °C | | 13,0 | | | | | |
| Set point Room Humidity | % | | 99,0 | | | | | |
| Elektro Healthy Coil | ON | | 1,5 | | | | | |

Koordinator: _____

Lampiran 9 Spectogram Mass Setelah Perbaikan



Lampiran 10 *Hardness Tester*



Lampiran 11 *Uster Tester 5*



Lampiran 12 Tabel *t-distribution*

| | | t-distribution | | | | | | | | | |
|----------|--|-----------------------|-------|-------|-------|-------|-------|-------|-------|-------|--------|
| | | Confidence Level | | | | | | | | | |
| | | 60% | 70% | 80% | 85% | 90% | 95% | 98% | 99% | 99.8% | 99.9% |
| | | Level of Significance | | | | | | | | | |
| 2 Tailed | | 0.40 | 0.30 | 0.20 | 0.15 | 0.10 | 0.05 | 0.02 | 0.01 | 0.002 | 0.001 |
| 1 Tailed | | 0.20 | 0.15 | 0.10 | 0.075 | 0.05 | 0.025 | 0.01 | 0.005 | 0.001 | 0.0005 |
| df | | | | | | | | | | | |
| 1 | | 1.376 | 1.963 | 3.133 | 4.195 | 6.320 | 12.69 | 31.81 | 63.67 | — | — |
| 2 | | 1.060 | 1.385 | 1.883 | 2.278 | 2.912 | 4.271 | 6.816 | 9.520 | 19.65 | 26.30 |
| 3 | | 0.978 | 1.250 | 1.637 | 1.924 | 2.352 | 3.179 | 4.525 | 5.797 | 9.937 | 12.39 |
| 4 | | 0.941 | 1.190 | 1.533 | 1.778 | 2.132 | 2.776 | 3.744 | 4.596 | 7.115 | 8.499 |
| 5 | | 0.919 | 1.156 | 1.476 | 1.699 | 2.015 | 2.570 | 3.365 | 4.030 | 5.876 | 6.835 |
| 6 | | 0.906 | 1.134 | 1.440 | 1.650 | 1.943 | 2.447 | 3.143 | 3.707 | 5.201 | 5.946 |
| 7 | | 0.896 | 1.119 | 1.415 | 1.617 | 1.895 | 2.365 | 2.999 | 3.500 | 4.783 | 5.403 |
| 8 | | 0.889 | 1.108 | 1.397 | 1.592 | 1.860 | 2.306 | 2.897 | 3.356 | 4.500 | 5.039 |
| 9 | | 0.883 | 1.100 | 1.383 | 1.574 | 1.833 | 2.262 | 2.822 | 3.250 | 4.297 | 4.780 |
| 10 | | 0.879 | 1.093 | 1.372 | 1.559 | 1.813 | 2.228 | 2.764 | 3.170 | 4.144 | 4.586 |
| 11 | | 0.875 | 1.088 | 1.363 | 1.548 | 1.796 | 2.201 | 2.719 | 3.106 | 4.025 | 4.437 |
| 12 | | 0.873 | 1.083 | 1.356 | 1.538 | 1.782 | 2.179 | 2.682 | 3.055 | 3.930 | 4.318 |
| 13 | | 0.870 | 1.079 | 1.350 | 1.530 | 1.771 | 2.160 | 2.651 | 3.013 | 3.852 | 4.221 |
| 14 | | 0.868 | 1.076 | 1.345 | 1.523 | 1.761 | 2.145 | 2.625 | 2.977 | 3.788 | 4.141 |
| 15 | | 0.866 | 1.074 | 1.341 | 1.517 | 1.753 | 2.131 | 2.603 | 2.947 | 3.733 | 4.073 |
| 16 | | 0.865 | 1.071 | 1.337 | 1.512 | 1.746 | 2.120 | 2.584 | 2.921 | 3.687 | 4.015 |
| 17 | | 0.863 | 1.069 | 1.333 | 1.508 | 1.740 | 2.110 | 2.567 | 2.899 | 3.646 | 3.965 |
| 18 | | 0.862 | 1.067 | 1.330 | 1.504 | 1.734 | 2.101 | 2.553 | 2.879 | 3.611 | 3.922 |
| 19 | | 0.861 | 1.066 | 1.328 | 1.500 | 1.729 | 2.093 | 2.540 | 2.861 | 3.580 | 3.884 |
| 20 | | 0.860 | 1.064 | 1.325 | 1.497 | 1.725 | 2.086 | 2.529 | 2.846 | 3.552 | 3.850 |
| 21 | | 0.859 | 1.063 | 1.323 | 1.494 | 1.721 | 2.080 | 2.518 | 2.832 | 3.528 | 3.820 |
| 22 | | 0.858 | 1.061 | 1.321 | 1.492 | 1.717 | 2.074 | 2.509 | 2.819 | 3.505 | 3.792 |
| 23 | | 0.857 | 1.060 | 1.319 | 1.489 | 1.714 | 2.069 | 2.500 | 2.808 | 3.485 | 3.768 |
| 24 | | 0.857 | 1.059 | 1.318 | 1.487 | 1.711 | 2.064 | 2.493 | 2.797 | 3.467 | 3.746 |
| 25 | | 0.856 | 1.058 | 1.316 | 1.485 | 1.708 | 2.060 | 2.486 | 2.788 | 3.451 | 3.725 |
| 26 | | 0.856 | 1.058 | 1.315 | 1.483 | 1.706 | 2.056 | 2.479 | 2.779 | 3.435 | 3.707 |
| 27 | | 0.855 | 1.057 | 1.314 | 1.482 | 1.703 | 2.052 | 2.473 | 2.771 | 3.421 | 3.690 |
| 28 | | 0.855 | 1.056 | 1.313 | 1.480 | 1.701 | 2.048 | 2.468 | 2.764 | 3.409 | 3.674 |
| 29 | | 0.854 | 1.055 | 1.311 | 1.479 | 1.699 | 2.045 | 2.463 | 2.757 | 3.397 | 3.660 |
| 30 | | 0.854 | 1.055 | 1.310 | 1.477 | 1.697 | 2.042 | 2.458 | 2.750 | 3.386 | 3.646 |
| 40 | | 0.851 | 1.050 | 1.303 | 1.468 | 1.684 | 2.021 | 2.424 | 2.705 | 3.307 | 3.551 |
| 50 | | 0.849 | 1.047 | 1.299 | 1.462 | 1.676 | 2.009 | 2.404 | 2.678 | 3.262 | 3.496 |
| 60 | | 0.848 | 1.045 | 1.296 | 1.458 | 1.671 | 2.000 | 2.391 | 2.661 | 3.232 | 3.460 |
| 70 | | 0.847 | 1.044 | 1.294 | 1.456 | 1.667 | 1.994 | 2.381 | 2.648 | 3.211 | 3.435 |
| 80 | | 0.846 | 1.043 | 1.292 | 1.453 | 1.664 | 1.990 | 2.374 | 2.639 | 3.196 | 3.417 |
| 90 | | 0.846 | 1.042 | 1.291 | 1.452 | 1.662 | 1.987 | 2.369 | 2.632 | 3.184 | 3.402 |
| 100 | | 0.845 | 1.042 | 1.290 | 1.451 | 1.660 | 1.984 | 2.365 | 2.626 | 3.174 | 3.391 |
| ∞ | | 0.842 | 1.036 | 1.282 | 1.440 | 1.645 | 1.960 | 2.327 | 2.576 | 3.091 | 3.291 |