

DAFTAR PUSTAKA

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Surakarta*

*Buku Laporan Tahunan Akademi Tekstil Dan Produk Tekstil Surakarta Tahun
2016*

Dokumen PT Tyfountex Indonesia

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<https://www.tyfountex.com>

Diakses pada tanggal 22 Juli 2019

LAMPIRAN

Lampiran 1 Line Balancing

LINE BALANCING										
Buyer		-		Daily Demand Pcs/Pr		840	Ratio		1.00	
Ex Fty		-		Net Available Time		25,200	Target /jam		120	
Takt Time in Seconds				30	Tgl pembuatan		05/11/2019			
Operation	Machine Type	Qty : 9.451pcs		Target per jam	Cycle time	Process Cycle Time Sec.	Current Operators	Production Rate Seconds	Output / Day = net avail Time / Production rate	
		Style Name :							357	
		ACTUAL								
		Operation Description								
Total										
KOMPONEN :										
DN	Lipat saku belakang	129	28	28	1.0	28	855	30.0		
Manual	Gosok saku belakang	120	30	30	1.0	30	798	30.0		
Manual	Gambar beset	200	18	11	0.6	18	1,330	30.0		
SN	Lipat saku coin	327	11	4	0.4	11	2,176	30.0		
DN	Tempel saku coin + variasi	129	28	26	0.9	28	855	30.0		
OL3	Obras beset	400	9	3	0.3	9	2,660	30.0		
SN	Tempel beset	133	27	24	0.9	27	887	30.0		
OL3	Obras blacu	200	18	11	0.6	18	1,330	30.0		
SN	Tindes blacu	200	18	11	0.6	18	1,330	30.0		
OL3	Obras golbi kiri	400	9	3	0.3	9	2,660	30.0		
SN	Jahit ujung golbi kanan	360	10	3	0.3	10	2,394	30.0		
OL3	Obras golbi kanan	400	9	3	0.3	9	2,660	30.0		
DN	Tempel zipper	257	14	7	0.5	14	1,710	30.0		
DN	Jahit tali pinggang 5x	95	38	48	1.3	38	630	30.0		
SAM		267			9			30.0		

Lampiran 2 Line Balancing

LINE BALANCING										
Buyer		-		Daily Demand Pcs/Pr		840	Ratio	1.00		
Ex Fty		-		Net Available Time		25,200	Target / jam	120		
				Takt Time in Seconds		30	Tgl pembuatan	05/11/2019		
Operation	Machine Type	Qty : 9.451pcs		Target perjam	Cycle time	Process Cycle Time Sec.	Current Operators	Production Rate Seconds	Output / Day = net avail Time / Production rate	Takt Time
		Style Name :							357	
		ACTUAL								
		Operation Description								
Total										
		LINE :								
FELL		Make up yoke	120	30	30	1.0	30	798	30.0	
FELL		Make up bodi belakang	150	24	24	1.0	24	998	30.0	
Manual		Gambar bodi depan	109	33	33	1.0	33	725	30.0	
Manual		Gambar bodi belakang	120	30	30	1.0	30	798	30.0	
Manual		Gambar yoke belakang	133	27	27	1.0	27	887	30.0	
Manual		Gambar pinggang	120	30	30	1.0	30	798	30.0	
SN		Jahit main + size label	88	41	62	1.5	41	584	30.0	
DN		Tempel saku belakang	54	67	168	2.5	67	357	30.0	
BTC		Bartack saku belakang	138	26	26	1.0	26	921	30.0	
OL3		Obras pental	157	23	23	1.0	23	1,041	30.0	
SN		Tempel saku depan	124	29	29	1.0	29	826	30.0	
DN		Tindes bibir	113	32	32	1.0	32	748	30.0	
SN		sambung saku depan	113	32	34	1.1	32	748	30.0	
SN		Tempel golbi + tindes	129	28	28	1.0	28	855	30.0	
DN		Belokan golbi	133	27	27	1.0	27	887	30.0	
SN		Sambung bodi kanan kiri	120	30	30	1.0	30	798	30.0	
DN		Sambung selakang	109	33	33	1.0	33	725	30.0	
OL3		Obras samping depan	109	33	33	1.0	33	725	30.0	
OL3		Obras samping belakang	109	33	33	1.0	33	725	30.0	

LINE BALANCING

Buyer		-		Daily Demand Pcs/Pr	840	Ratio	1.00			
Ex Fty		-		Net Available Time	25,200	Target /jam	120			
Ex Fty		-		Takt Time in Seconds	30	Tgl pembuatan	05/11/2019			
Operation	Machine Type	Qty : 9.451pcs		Target perjam	Cycle time	Process Cycle Time Sec.	Current Operators	Production Rate Seconds	Output / Day = net avail. Time / Production rate	Takt Time
		Style Name :								
		ACTUAL								
		Operation Description								
		Total								
		LINE :								
Manual	Gambar yoke depan	113		32	32	1.0	32	748	30.0	
Manual	Gambar yoke belakang	120		30	30	1.0	30	798	30.0	
OL5	Obras selakang	95		38	57	1.5	38	630	30.0	
SN	Tindes selakang	86		42	63	1.5	42	570	30.0	
SN	Jahit bantu samping	72		50	100	2.0	50	479	30.0	
SN	Tindes samping atas	120		30	30	1.0	30	798	30.0	
SN	Jahit care label	133		27	27	1.0	27	887	30.0	
WB	Waistband kansai	95		38	57	1.5	38	630	30.0	
Manual	Control waistband	144		25	25	1.0	25	958	30.0	
Manual	Dedel mulu	120		30	30	1.0	30	798	30.0	
SN	Tutup mulut	57		63	132	2.1	63	380	30.0	
SN	Variasi mulut + gambar	88		41	62	1.5	41	584	30.0	
Manual	Ukur inseam	133		27	27	1.0	27	887	30.0	
SN	Lipat kaki (rantai)	54		67	134	2.0	67	357	30.0	
SN	Jahit mati rantai	138		26	26	1.0	26	921	30.0	
BTC	Bartack tali pinggang 5x (10 tack)	56		64	128	2.0	64	374	30.0	
BTC	Bartack side seam + fly (3 tack)	144		25	25	1.0	25	958	30.0	
Manual	Potong benang dalam	86		42	63	1.5	42	570	30.0	
Manual	Potong benang luar	100		36	36	1.0	36	665	30.0	
						1.0				
SAM				1341		48				

Lampiran 3 SAM Basic

Standart Allowance Minutes (SAM) adalah lama waktu proses dari suatu celana (termasuk allowance).

TOTAL SAM BASIC SEWING LINE s/d BARTACK.

Contoh 1

Jika suatu celana memiliki SAM 1.310 detik, maka targetnya adalah :

$$\begin{aligned} &= \frac{120}{(SAM\ Order / SAM\ basic)} \\ &= \frac{120}{(1.310\ detik / 1.345\ detik)} \\ &= \frac{120}{0.97} \\ &= 124\ pcs/jam \end{aligned}$$

Contoh 2

Jika suatu celana memiliki SAM 1.625 detik, maka targetnya adalah :

$$\begin{aligned} &= \frac{120}{(SAM\ Order / SAM\ basic)} \\ &= \frac{120}{(1.625\ detik / 1.345\ detik)} \\ &= \frac{120}{1.20} \\ &= 120\ pcs/jam \end{aligned}$$

Contoh 3

Jikasuat celana memiliki SAM 1.005 detik, maka targetnya adalah :

$$\begin{aligned} &= \frac{120}{(SAM\ Order / SAM\ basic)} \\ &= \frac{120}{(1.005\ detik / 1.345\ detik)} \\ &= \frac{120}{0.74} \\ &= 162\ pcs/jam \end{aligned}$$