

DAFTAR PUSTAKA

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LAMPIRAN

Lampiran 1 *Line Balancing Style Ladies Pants* Komponen

LINE BALANCING										
Buyer		XXX			Daily Demand Pcs		875	Ratio		0,96
					Net Available Time		25.200	Target / jam		125
Ex Fty		Juni 25, 2019			Takt Time in Seconds		29	Tgl pembuatan		13/06/2019
Operation	Machine Type	Qty : 15.500 pcs		Target per jam	Cycle time	Current Operators	Production Rate Seconds	Output / Day = net avail. Time / Production rate		Takt Time
		Style Name : Ladies Pants						368		
		ACTUAL								
		Operation Description								
		Total								
		KOMPONEN :								
	SN	Lipat saku belakang		140	26	0,9	26	932	29,0	
	Manual	Gosok saku belakang		120	30	1,0	24	991	29,0	
	Manual	Gambar beset		200	18	0,6	18	1.330	29,0	
	SN	Ngecek zipper 2x		250	14	0,5	14	1.663	29,0	
	SN	Jahit bantu zipper		150	24	0,8	24	998	29,0	
	SN	Paspol saku coin		80	45	1,6	45	532	29,0	
	SN	Jahit bantu beset		120	30	1,0	30	798	29,0	
	BTC	Bartack saku coin (2 tack)		222	16	0,6	16	1.478	29,0	
	OL3	Obras beset		400	9	0,3	9	2.660	29,0	
	SN	Tempel beset		135	27	0,9	27	900	29,0	
	OL3	Obras blacu		200	18	0,6	18	1.330	29,0	
	SN	Tindes blacu		200	18	0,6	18	1.330	29,0	
	OL3	Obras golbi kiri		400	9	0,3	9	2.660	29,0	
	SN	Jahit ujung golbi kanan		350	10	0,4	10	2.329	29,0	
	OL3	Obras golbi kanan		400	9	0,3	9	2.660	29,0	
	DN	Tempel zipper		250	14	0,5	14	1.663	29,0	
	DN	Jahit tali pinggang 5x		95	38	1,3	38	630	29,0	
		SAM		356	12					

Lampiran 2 Line Balancing Style Ladies Pants Poduksi

LINE BALANCING									
Buyer		XXX			Daily Demand Pcs		875	Ratio	0,96
					Net Available Time		25.200	Target / jam	
Ex Fty		Juni 25, 2019			Takt Time in Seconds		29	Tgl pembuatan	13/06/2019
Operation	Machine Type	Qty : 15.500 pcs		Target per jam	Cycle time	Current Operators	Production Rate Seconds	Output / Day = net avail. Time / Production rate	
		Style Name : Ladies Pants						368	Takt Time
		ACTUAL							
		Operation Description							
		Total							
		LINE :							
	FELL	Make up yoke		120	30	1,0	30	798	29,0
	FELL	Make up backrise		150	24	1,0	24	998	29,0
	Manual	Gambar bodi depan		110	33	1,0	33	732	29,0
	Manual	Gambar bodi belakang		120	30	1,0	30	798	29,0
	Manual	Gambar yoke belakang		133	27	1,0	27	887	29,0
	Manual	Gambar pinggang		120	30	1,0	30	798	29,0
	SN	Tempel saku belakang		55	65	2,5	65	368	29,0
	Manual	Gambar variasi saku belakang		138	26	1,0	26	921	29,0
	SN	Variasi saku belakang		60	60	2,0	60	399	29,0
	BTC	Bartack saku belakang (4 tack)		144	25	1,0	25	958	29,0
	OL3	Obras pental		157	23	1,0	23	1.041	29,0
	SN	Tempel saku depan		120	30	1,0	30	798	29,0
	DN	Tindes bibir		110	33	1,0	33	732	29,0
	SN	Sambung saku depan		124	29	1,0	29	826	29,0
	SN	Tempel golbi + tindes		120	30	1,0	30	798	29,0
	DN	Belokan golbi		133	27	1,0	27	887	29,0
	SN	Sambung bodi kanan kiri		124	29	1,0	29	826	29,0
	DN	Sambung selakang		110	33	1,0	33	732	29,0
	Manual	Gambar yoke depan		113	32	1,0	32	748	29,0
	Manual	Cocok bodi depan + belakang		120	30	1,0	30	798	29,0
	FELL	Make up selakang		110	33	1,0	33	732	29,0
	Manual	Control make up		157	23	1,0	23	1.041	29,0

Lampiran 2 Line Balancing Style Ladies Pants Poduksi Lanjutan

LINE BALANCING									
Buyer		XXX		Daily Demand Pcs		875	Ratio	0,96	
Ex Fty		Juni 25, 2019		Takt Time in Seconds		29	Tgl pembuatan	13/06/2019	
Operation	Machine Type	Qty : 15.500 pcs		Target per jam	Cycle time	Current Operators	Production Rate Seconds	Output / Day = net avail. Time / Production rate	Takt Time
		Style Name : Ladies Pants							
		ACTUAL							
		Operation Description							
		Total							
		LINE :							
	SN	Tindes samping atas		120	30	1,0	30	798	29,0
	SN	Jahit care label		138	26	1,0	26	921	29,0
	SN	Gathering pinggang		120	30	1,0	30	798	29,0
	WB	Waitsband kansai		95	38	1,5	38	630	29,0
	Manual	Control kansai		144	25	1,0	25	958	29,0
	Manual	Dedel mulut		120	30	1,0	30	798	29,0
	SN	Tutup mulut		60	60	2,0	60	399	29,0
	Manual	Ukur inseam		133	27	1,0	27	887	29,0
	SN	Lipat kaki (<i>rantai</i>)		60	60	2,0	60	399	29,0
	SN	Jahit mati rantai		138	26	1,0	26	921	29,0
	BTC	Bartack tali pinggang 5x (10 tack		56	64	2,5	64	374	29,0
	BTC	Bartack fly + sideseam (4 tack)		133	27	1,0	27	887	29,0
	Manual	Potong benang dalam		86	42	1,6	42	570	29,0
	Manual	Potong benang luar		100	36	1,4	36	665	29,0
ASSISTEN LINE (ambil acc + potongan)						1,0			
		SAM		1278	47				
		KEYHOLE :							
	Keyhole	Lubang kancing pinggang (1 hc		280	13	0,4	13	1.863	29,0
		SAM		13	0,4				

Lampiran 3 SAM Basic

Standard Allowence Minutes (SAM) adalah lama waktu proses dari suatu celana (termasuk toleransi)

TOTAL SAM *BASIC* 1.345 DETIK *SEWING LINE – BARTACK*

TARGET UNTUK *BASIC* 120 PCS/JAM

Contoh 1

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

$$\begin{aligned} &= \frac{120}{(\text{SAM Order} / \text{SAM Basic})} \\ &= \frac{120}{(1.310 \text{ detik} / 1.291 \text{ detik})} \\ &= \frac{120}{1,01} \\ &= 119 \text{ Pcs/Jam} \end{aligned}$$

Contoh 2

Jika suatu celana memiliki SAM 1.125 detik, maka targetnya adalah :

$$\begin{aligned} &= \frac{120}{(\text{SAM Order} / \text{SAM Basic})} \\ &= \frac{120}{(1.125 \text{ detik} / 1.291 \text{ detik})} \\ &= \frac{120}{0,87} \\ &= 138 \text{ Pcs/Jam} \end{aligned}$$

Contoh 3

Jika suatu celana memiliki SAM 1.625 detik, maka targetnya :

$$\begin{aligned} &= \frac{120}{(\text{SAM Order} / \text{SAM Basic})} \\ &= \frac{120}{(1.625 \text{ detik} / 1.291 \text{ detik})} \\ &= \frac{120}{1,26} \\ &= 95 \text{ Pcs/Jam} \end{aligned}$$

Contoh 4

Jika suatu celana memiliki SAM 1.005 detik, maka targetnya :

$$\begin{aligned} &= \frac{120}{(\text{SAM Order} / \text{SAM Basic})} \\ &= \frac{120}{(1.005 \text{ detik} / 1.291 \text{ detik})} \\ &= \frac{120}{0,78} \\ &= 154 \text{ Pcs/Jam} \end{aligned}$$