

## DAFTAR PUSTAKA

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## LAMPIRAN

LINE BALANCING									
Buyer					Daily Demand	560	Ratio	1.5	
Ex Fty					Net Available Time	25.200	Target/jam	80	
Operation	Machine Type	Qty : 5.183 pcs			Takt Time in		45	Tgl pembuatan	24/05/2019
		Style Name :			Cycle Time	Current Operators	Production Rate Seconds	Output/Day= net avail. Time/Production Rate	Takt Time
		ACTUAL							
		Operatin Description							
LINE									
	Manual	gambar body depan + plaketa	60	60	1.5	60	399	45	
	Manual	gosok interlining plaketa 2x	109	33	1.0	33	725	45	
	Manual	golok plket	100	36	1.0	36	665	45	
	manual	gambar lengan 4x	90	40	1.0	40	599	45	
	DN	jahit slit lengan 2x2 (lipat)	69	52	1.0	52	460	45	
	SN	jahit mti lengan	150	24	0.5	24	998	45	
	FELL	make-up lengan	80	45	1.0	45	532	45	
	SN	jahit bantu beset paspol	120	30	1.0	30	798	45	
	SN	tindes paspol bawah	60	60	1.5	60	399	45	
	SN	tindes paspol atas	50	72	1.5	72	333	45	
	OL3	Obras blacu paspol	60	60	1.5	60	399	45	
	SN	clean finish	60	60	1.5	60	399	45	
	SN	sambung saku paspol saku	120	30	1.0	30	798	45	
	BTC	bartack saku paspol 4x tack	129	28	1.0	28	855	45	
	Manual	gambar posisi saku depan	100	36	1.0	36	665	45	
	SN	tempel lapisan dalam saku depan	80	45	1.0	45	532	45	
	Manual	potong pojok saku depan (cekris)	100	36	1.0	36	665	45	
	SN	tindes lapisan dalam saku depan	60	60	1.5	60	399	45	
	DN	tempel saku dalam	53	68	1.5	68	352	45	
	BTC	bartack saku depan (4 tack)	129	28	1.0	28	855	45	
	SN	pasang tutup saku 2x + gambar	90	40	1.0	40	599	45	
	OL5	obras yoke depan	120	30	1.0	30	798	45	
	DN	tindes yoke depan	109	33	1.0	33	725	45	
	SN	Jahit pojok plaketa	90	40	1.0	40	599	45	
	SN	lipat plaketa (tindes rantai)	50	72	1.6	72	333	45	
	SN	tindes tepi plaketa	61	59	1.5	59	406	45	
	FELL	make-up pundak (shoulder)	129	28	1.0	28	855	45	
	OL5	obras lubang lengan (armhole)	60	60	1.5	60	399	45	
	DN	tindes lubang lengan (armhole)	60	60	1.5	60	399	45	
	SN	jahit care label + size label	120	30	1.0	30	798	45	
	Manual	cocok body depan + belakang	90	40	1.0	40	599	45	
	FELL	make-up lengan + samping	69	52	1.0	52	460	45	
	Manual	control make-up	164	22	0.7	22	1,088	45	
	Manual	gambar krah	100	36	0.8	36	665	45	
	SN	jahit hanger loop	133	27	0.5	27	887	45	
	SN	tempel krah		51	1.5	51	469	45	
	SN	tindes krah atas	68	53	1.0	53	452	45	
	SN	tides krah	75	48	1.1	48	499	45	
	DN	tempel pinggang (chain stitch)	100	36	1.0	36	665	45	
	SN	jahit keliling pinggang	42	85	2.0	85	282	45	
	SN	tempel manset	80	45	1.0	45	532	45	
	SN	tindes keliling manset	44	81	2.0	81	296	45	
	SN	pasang deck + tindes 2x	90	40	1.5	40	599	45	
	BTC	bartack deck (4 tack)	138	26		26	921	45	
	Manual	potong benang dalam	53	68	1.6	68	352	45	
	Manual	potong benang luar	67	54	1.4	54	443	45	
	asisten line (ambil acc + potongan)				1.0				
			SAM	2154	55				
	KEYHOLE								
	Keyhole	lubang kancing plaketa (5hole)	90	40	0.9	40	599	45	
			SAM	40	0.9				

**Lampiran 1. Line Balancing Jaket Denim Style no. FT-196**

