

## DAFTAR PUSTAKA

Buku Pedoman Praktik Kerja Lapangan Akademi Komunitas Industri Tekstil dan Produk Tekstil Surakarta Tahun 2019.

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Sastrosumarto, S. (2018). *Buku Penelitian Tentang Warping & Sizing Break*. Surakarta.

Struktur Organisasi PT Dan Liris, Bagian Personalia dan Umum, PT Dan Liris, Sukoharjo, 2019.

Data Ketenagakerjaan PT Dan Liris, Bagian Personalia dan Umum, PT Dan Liris, Sukoharjo, 2019.

Data-data Mesin PT Dan Liris, Bagian Maintenance, PT Dan Liris, Sukoharjo, 2019.

# LAMPIRAN

**RENCANA WARPING & SIZING** ( FM.W-00-PC-09.1-002 )

RENCANA WARPING :

NO.	R.0		R.1		R.2		R.3		R.4	R.5	R.6	TANGGAL : 2019	
	Konj.	R.0	Konj.	R.1	Konj.	R.2	Konj.	R.3				R.7	R.8
I	1012	1332263	1012	1332263	1012	1332263	1012	1332263					
		368		368		325 - 370		325 - 390					
II	1012	1332263	1012	1332263	1012	1332263	1014	887047					
		368		368		350		383					
III	1012	1332263	1012	1332263	1012	1332263	1014	887047					
		357		368		359		383					
IV													

Proses code 1332263 dan 887047 ds 325 budi program dan meter lico (total sp 378)

RENCANA SIZING :

NO.	R.0		R.1		R.2		R.3	R.4	R.5	R.6
	Konj.	R.0	Konj.	R.1	Konj.	R.2				
I	1012	1332263	1014	887047	1014	887047				
		380		387		396				
II	1012	1332263	101	1332263	1014	71332263				
		368		357		366				
III										
IV										

Mengetahui : Loom : Preparation :

(Phoim M)
(Nur Khalir)
(Nur Khalir)
PPIC

Lampiran 1 Data Rencana Warping

TGL	CODE	NO BEAM	CONE	NO BNG	PANJANG	START	DOTF	PUTUS	GROUP	PARAF	KET
14/19	sp 316 1337263 PP/B	114	592	CD40	17500	16 20	18 00	31	G		ungu pih
		99				18 05	20 10	25	G		18 Maret
		09				20 16	21 35	23	G		
		20				21 40	23 00	9	G/B		3500
		80				23 05	24 00	15	B		
		89				24 05	24 50	12	B		
	1337263 PP/B	36	592	CD40	17500	24 55	01 55	12	B		
						Cleaning mc dulu					
						12H istirahat					
14/19	sp 328 1107603 B/B	91	583	PC45	23160	03 50	04 45	15	B		Hijau
		35				04 50	05 45	7	B		
		96				05 50	07 10	9	B/D		3000 m
		88				07 15	08 20	8	D		
		65				08 25	09 55	10	D		
	1107603 B/B	41	583	PC45	23160	10 00	11 30	10/7	D		
						Nopolor Bel + DOF CONE					
	sp 316					L:3		59			
14/19	1337263 PP/B	71	592	CD40	17500	14 00	15 25	21	F		1/2 1/2 PTH
		16				15 30	17 00	19	F		
		30				17 05	18 10	18	F		istirahat
		07				18 15	20 00	18	F		
		87				20 05	21 00	10	F		
		48				21 05	21 55	10	F		
	1337263 PP/B	07	592	CD40	17500	22 05	22 55	7	A		
						L1		03			
	sp 316					L:3		59			
14/19	1106060 B/B	10	571	PC30	15500	01 15	01 35	6	A		CERIKAN MC
		40				01 40	02 15	2	A		
		86				02 20	03 40	2	A		
		18				03 55	04 20	0	A		
		14				04 25	04 55	5	A		
	1106063 B/B	107	571	PC30	15500	05 10	06 10	4	A/D		set 12 500
						24 ppno					
						Cleaning ps jatan					istirahat
14/19	sp 329 887047 PP/B	50	529	LD 40	30400	10 50	11 55	77	E		set 21 m
		74				15 00	17 00	25	E		istirahat
		12				17 05	20 30	41	E		
	887047 PP/B	75	529	LD 40	30400	20 35	24 00	49	E/4		set 16000
						Cleaning ps jatan					

Lampiran 2 Data Buku Produksi Warping

FM.W-00-PR.01-09.1-004

UNIT 71 L-4 **DAFTAR PUTUS BENANG DI WARPING**

CODE: 2830 A3 H1 E JUMLAH CONE: 520  
 SP: 383 PANJANG: 30600 (Yard / meter) \* corel yang tidak perlu  
 TGL PROSES: 7-8-19  
 JENIS / NO. BENANG: 1040 WARPING NO: 4

NO	ITEM	BEAM KE				Dist	KETERANGAN
		1	2	3	4		
1	Benang Tipis						
2	Siub						
3	Kotoran Masuk Dalam Benang						
4	Off Lease						
5	Snarl						
6	Sambungan Lepas						
7	Nglakor						
8	Pinggiran Rusak						
9	Gulungan di belakang						
10	Tersangkut Ujung Cone						
11	Benang Lolos						
12	Lain Lain						
	a.						
	b.						
13	Jumlah	18	14	7	9		
		Yard	Jumlah	Yard	Jumlah	Yard	Jumlah
CONE PANJANG KURANG		4000 Up		2400		1200	
		3300		2100		900	
		3000		1800		600	
		2700		1500		300	
		Total Cone Panjang Kurang					cone

Verifikasi: (Ghuha)   
 Petakane: (Tami Paru)

Lampiran 3 Data Putus Benang Tanggal 07-08-2019

FM.W - 00 - PR . 03 - 09 . 1 - 010

**LAPORAN PENYERAPAN IMAN GREY AJL Weaving 2 ( Ex.Wv3 ) - BULAN : JULI 2019**

No.	Code	Grade						D 0 1 2	%	D 3 4	%	Sam ple	Jumlah Output			Re Check
		A	%	B	%	C	%						Meter	Pick	Kilo	
1	C	133 80 63 MK MK B B 1	529.00	60.25	349.00	59.74							878.00	1,434.06		
2	C	90 88 64 MK MK B B											71.00	104.13		
3	C D	120 60 63 RF RF B A	38,005.00	81.70	4,416.50	9.49	3,366.50	7.23					46,513.50	46,513.50		2,522.50
4	C D	120 60 63 RF RF B B	5,985.00	80.07	839.50	11.23	502.50	6.72					75.00	80.00		
5	C D	128 64 63 RF RF B A											216.50	22.89		154.00
6	C D	128 64 63 RF RF B B	304.00	32.15	51.00	5.39	374.00	39.55					16,746.50	20,095.80		
7	C D	128 72 47 RF RF A A	13,418.00	80.12	2,526.50	15.09	800.00	4.77					43,045.00	51,654.00		
8	C D	128 72 47 RF RF A B	33,493.00	77.80	4,574.00	10.62	2,486.50	5.77					4,716.00	5,859.20		
9	C D	128 72 47 RF RF B A	4,124.50	87.45	591.50	12.54							15,678.50	18,814.20		
10	C D	128 72 47 RF RF B B	12,398.00	79.07	2,588.00	16.50	482.50	3.07					210.00	1.33		
11	C D	133 72 63 RF RF B A	135,878.00	71.34	24,560.50	12.89	11,979.00	6.29	4,504.50	2.98	13,522.00	7.10	190,444.00	228,532.80		
12	C D	133 72 63 RF RF B B	119,634.00	85.01	12,469.00	8.84	6,396.50	4.53					2,264.50	1.60		
13	C D	88 70 47 RF RF A A	5,368.00	87.95	297.00	4.37	468.00	7.66								
14	C D	88 70 47 RF RF A B	90,916.00	80.35	11,399.00	10.07	7,896.00	6.97					2,926.50	2.58		
15	C D	94 70 125 RF RF B A	56,512.50	82.37	6,330.00	9.22	4,647.00	6.77	437.00	0.83	676.00	0.98	68,602.50	80,036.25		
16	C DBCI	94 70 84 RF RF C C	37,303.50	85.41	2,719.50	6.22	3,044.50	6.97	77.00	0.17	528.00	1.20	43,672.50	50,951.25		
17	C DPQ	123 70 63 RF RF A A														
18	C DTA	118 62 63 RF RF A A	614.50	100.00									614.50	634.98		
19	C DTA	118 62 63 RF RF B A	21,413.50	80.83	2,452.00	9.25	1,568.00	5.91	875.00	2.54	383.00	1.44	26,491.50	27,374.55		
20	C DTA	118 62 63 RF RF B B	5,291.50	86.82	621.50	10.19							181.50	2.97		
21	C DTA	120 60 63 RF RF B A	17,712.00	78.24	2,490.00	11.00	2,219.00	9.80	215.00	0.94			22,636.00	22,636.00		
22	C DTA	120 60 63 RF RF B B	16,182.50	81.42	1,413.50	7.11	644.00	3.24					1,635.00	8.22		
23	C DTA	130 65 63 RC RC C C											229.00	73.51		
24	C DTA	130 70 63 RC RC A A	2,728.50	38.70	3,154.00	44.73	924.00	13.10					243.50	3.45		
25	C DTA	133 72 63 RF RF B A	49,132.50	70.79	12,159.50	17.52	6,374.00	9.18	895.00	1.28	838.50	1.20	69,399.50	83,279.40		
26	C DTA	133 72 63 RF RF B B	38,666.50	66.35	8,910.00	15.29	6,939.50	11.90					3,754.50	6.44		

Lampiran 4 Kontruksi Kain Yang Diproduksi Bulan Juni lembar 1

No	Code	Grade										Sample	Jumlah Output			Re Check	
		A	%	%	C	%	D 0 1 2	%	U 3 4	%	Meter		Pick	Kilo			
27	C50 144 80 63 MM B B	17.163.00	75.77	2.970.50	13.11	2.074.50	9.15					442.00	1.95	22.850.00	30.200.00		
28	PC 110 60 63 DC DC B B	67.889.50	89.49	5.843.00	7.70	1.103.50	1.45	209.00	0.27	814.00	1.07			75.859.00	75.859.00		
29	PC 110 76 63 DH DH B B	155.705.50	84.99	19.074.00	10.41	4.856.00	2.65	934.00	0.50	2.625.00	1.43			183.194.50	232.046.36		
30	PC 133 72 47 DH DH B B	82.203.00	79.86	13.029.00	12.65	3.830.50	3.74	709.00	0.68	3.135.50	3.54			102.927.00	123.512.40		
31	PC 133 72 63 DH DH B B	16.816.50	73.18	4.016.00	17.47	1.225.00	5.33	213.00	0.92	708.00	3.08			22.978.50	27.574.20	48.50	
32	PC 136 72 63 DH DH B B	5.155.00	75.93	1.390.00	17.14	473.50	6.84							8.196.00	9.727.20		
33	PC 140 80 63 DH DH B B	21.571.50	77.34	4.145.00	14.86	981.50	3.51			1.190.50	4.26			27.888.50	37.184.66		
34	PC 89 64 63 DH DH B B																6.801.00
35	PC COX 100 48 63 DH MZ B AH									153.50	100.00			153.50	122.80		
36	PCDB 69 140 80 63 DH DH B B	3.230.00	77.49	759.00	18.21	179.00	4.29							4.168.00	5.557.33	1.771.00	
37	PCHB 133 72 63 DH DH B B	12.210.50	75.81	2.670.00	16.57	874.00	5.42	215.00	1.33	136.50	0.84			16.106.00	19.327.20		
38	PCOX 110 44 63 DC DZ B B							160.00	100.00					160.00	117.33		
39	PCPQ 126 74 63 DC DC B B	18.038.00	78.27	2.556.00	11.09	1.762.00	7.64	166.00	0.72	523.50	2.27			23.045.50	28.422.78		
40	PCTA 133 72 47 DH DH B B	2.166.50	100.00											2.166.50	2.502.20		
41	PCTA 133 72 63 DH DH B B	10.329.00	84.07	734.00	5.97	1.160.50	9.44			82.50	0.50			12.286.00	14.743.20		
42	TCL 92 86 65 JV JV B B	492.50	97.04							15.00	2.95			507.50	727.41		
43	TCLSD 144 115 63 JV JV B B																377.00
<b>Jumlah :</b>		1.119.782.50	79.3042	162.070.00	11.4779	79.651.50	5.6410	10.073.00	0.7133	40.431.50	2.8534			1.412.008.50	1.662.238.88		11.728.00

Item	Meter	%
Piece Besar	1.115.493.00	79.0004
Piece Kecil	246.011.00	17.4227
Piece Pendek	50.504.50	3.5767
Grand Total	1.412.008.50	100.00
Rata-Rata Pick	70.63295	
Target Pick	60.00000	

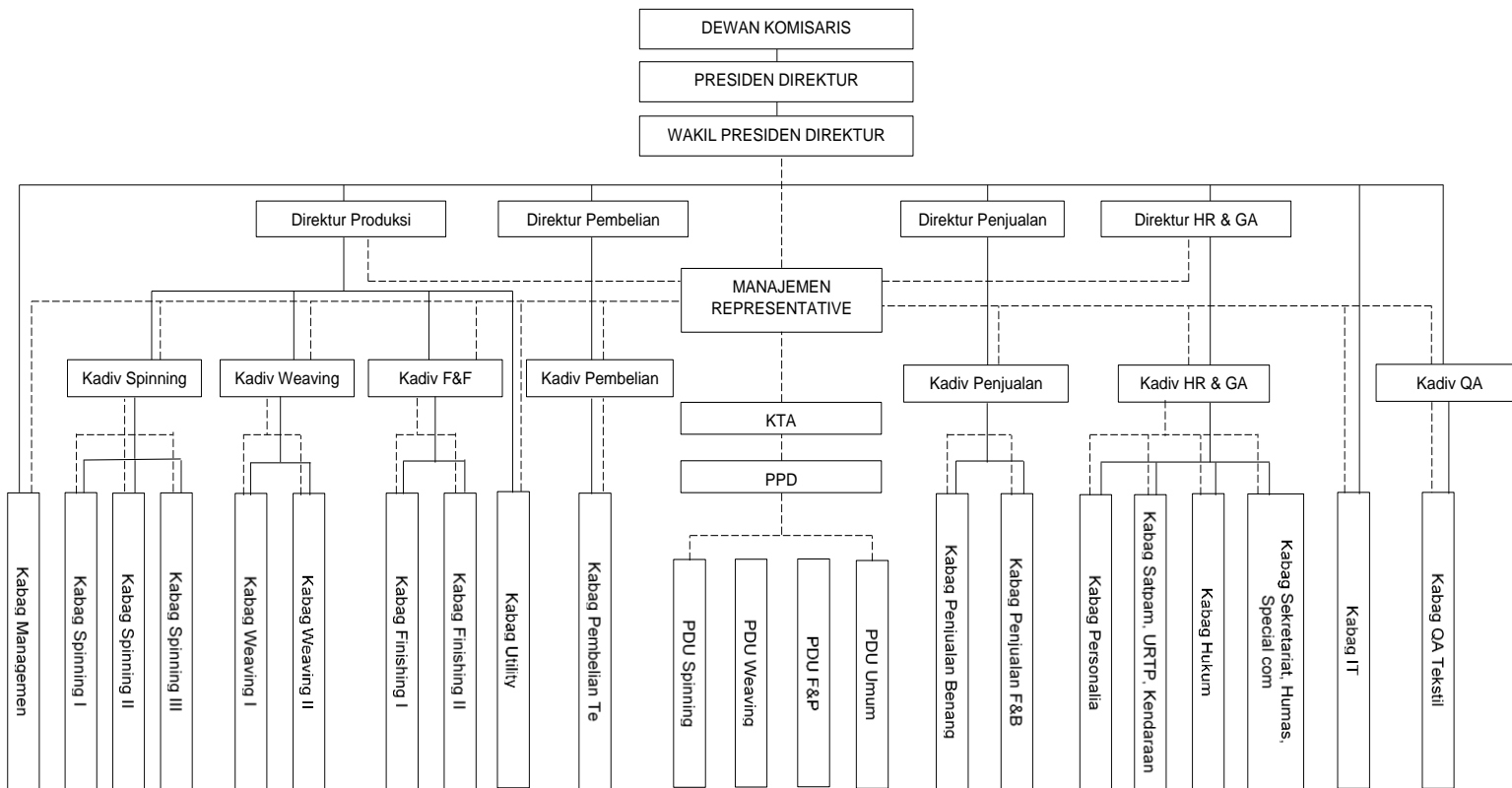
  

Waste Benang Panjang = 2048 kg	Mengetahui Banaran, 31 July 2019
Waste Benang Pendek = 4572 kg	
Fly Waste = kg	
<b>Total = 6620 kg</b>	

(E. H. H. H. H. H.)	(Faradika S.P.)	(Larsih)
Koord. Inspect.	Kasubisie	Adm. Inspect.

Lampiran 5 Kontruksi Kain Yang Diproduksi Bulan Juni lembar 2



Lampiran 6 Struktur Organisasi PT Dan Liris