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LAMPIRAN

Lampiran 1 Barchart sebelum improvement proses

NO	PART	PROCESS BREAKDOWN	MACHINE	MP	CT	OUT PUT/JAM
1	STROMFLAP	PREPARE + JOIN STROMFLAP	SNA+SNC	1	97	37
2		CUT SEAM ALLOWANCE STROMFLAP+PREPARE ATACH BEMISH STROMFLAP	SNC	1	82	28
3		MARKING FC CUFF + ATTACH BEMISH FC CUFF	HNP	1	58	49
4		STEAM BEMISH	STM	2	145	48
5		ATTACH BEMISH STROMFLAP+HAND PRESS STROMFLAP	HNP	1	127	28
6		ATTACH ZIP TO STROMFLAP	SNL	1	48	25
7	HOOD	JOIN SIDE TO MIDDLE HOODSHELL + LIN	SNL	1	45	80
8		OL INSIDE MIDDLE HOODSHELL + LIN + TACK TAB	OM3	1	70	51
9		STITCH HOODSHELL	MH3	1	75	48
10		PREPARE + ATTACH ZIP TO OUTER COLLAR U SHAPE	SNL	1	76	47
11		TACK END OFF WELT + CUT BREAK + STITCH ZIP OUTER COLLAR U SHAPE	SNL	1	53	67
12		JOIN CLOSE OUTER HOOD	SNL	1	60	60
13	JOIN HOOD TO ZIP COLLAR STRAIGHT	SNL	1	81	44	
14	INNER	PREPARE ZIP TO INNER COLLAR U SHAPE	SNA	1	44	81
15		ATTACH ZIP TO INNER COLLAR U SHAPE	SNA	1	49	73
16		CUT BREAK + TACK END OFF ZIP PKT + STITCH INNER COLLAR U SHAPE	SNL	1	87	41
17		BARTACK ZIP COLLAR + CUT BREAK	BTK	1	89	40
18		JOIN HOOD LIN TO ZIP INNER COLLAR STRAIGHT	SNL	1	95	37
19		STITCH UPPER OUTER COLLAR	SNL	1	50	72
20		JOIN PANEL TO UPPER INNER COLLAR	SNL	1	79	45
21		TACK INSIDE SIDE PANEL UPPER OUTER HOOD	SNL	1	56	64
22	STEAM COLLAR	STM	1	90	40	
23	COLLAR	PREPARE + JOIN INNER TO OUTER COLLAR	SNA	1	95	37
24		OL INSIDE COLLAR + STITCH 1/16 INNER COLLAR	OM3+SNL	1	59	61
25		ATT EYELETE TO COLLAR INCLUDE MARKING	BHM	1	66	54
26	PATCH POCKET	JOIN FC TO PALM + STITCH FC PALM	SNL	1	63	57
27		OL LAYER KNUCKLE + FC PALM	OM3	1	61	59
28		JOIN PALM TO ZIPPER HAND PKT + CUT BREAK	SNL	1	76	47
29		TACK INSIDE POCKET + STITCH ZIP PKT PALM	SNL	1	89	40

30		BARTACK ZIP POCKET + CUT ALLOWANCE INSIDE POCKET	BTK	1	40	90
31		JOIN KNUCKLE TO ZIP HAND POCKET	SNL	1	52	69

Lampiran 2 Barchart sebelum improvement proses (lanjutan)

NO	PART	PROCESS BREAKDOWN	MACHINE	MP	CT	OUT PUT /JAM
32	LINNING	JOIN SLEEVE TO BACK LIN REGLAND	OM4	1	51	70
33		JOIN SHOULDER ALONG SLEEVE + TACK TAB	OM4	1	56	64
34		JOIN UPPER BODY LINNING	OM4	1	62	58
35		JOIN LAYER UPPER BODY LIN + STITCH UP LIN	SNL	1	90	40
36		ATT CARE LABEL TO SIDE SEAM + ATT LOOP + SIZE LABEL TO UPPER BODY LINNING	SNL	1	77	46
37		JOIN SIDESEAM + TACK TAB	OM4	2	92	39
38		JOIN FC FRONT LINNING	OM4	1	98	36
39		STITCH FC RF LINNING	SNL	1	88	40
40		FRONT BODY	JOIN UPPER TO LOWER SIDE PANEL + OL UPPER TO LOWER SIDE PANEL	SNL	1	80
41	STITCH WELT POCKET ZIP PKT KNUCKLE + STITCH ZIP PKT PALM		SNL	1	79	45
42	JOIN UPPER LOWER TO FRONT BODY		SNL	1	90	40
43	OL UPPER LOWER SIDE PANEL		OM3	1	90	40
44	JOIN LOWER TO FRONT BODY		SNL	1	85	80
45	JOIN LAYER UPPER + LOWER POCKET BAGS		SNL	1	88	40
46	OL LAYER UPPER + LOWER PKT BAGS + JOIN TAPE DIAGONAL STITCHING		OM3+VCM	1	92	39
47	JOIN SIDE PANEL SLEEVE TO ALONG FR BODY		SNL	1	100	36
48	OL SIDE PANEL SLEEVE TO ALONG FR BODY		OM3	1	80	45
49	BACK BODY	JOIN FC BACK POCKET ROUNDED + BARTACK ZIP POCKET	BOX	1	80	45
50		STITCH 1/16 SQR FC POCKET + CUT BREAKOPEN PKT ROUNDED	SNL	1	93	38
51		TACK ZIP TO PKT POSITION + ATT ZIPPER PKT WITH FC DRCT STITCH	SNL	1	79	45
52		JOIN KNUCKLE / PALM TO ZIPPER BACK PKT	SNL	1	88	40
53		OL INSIDE BACK POCKET + STITCH 1/16 PALM	OM3+SNL	1	75	48
54		JOIN TAPE TO BACK + TACK ELSTC BK PKT STRAPE TO BUCKLE + JN LAYERPKT AQR	SNL	1	67	53
55		OL LAYER PKT SQR	OM3	1	56	64
56		JN UPPER TO LOWER SIDE PANEL + OL UP LOW SIDE PANEL + OL SIDE PANEL TO BACK BODY POINTED	OM3+SNL	2	98	36
57		JOIN SIDE PANEL TO BBY POINTED WITH CUT BREAK	SNL	1	143	50
58		JOIN UPPER TO LOWER BACK SLEEVE	SNL	1	78	46
59		OL LOWER BACK SLEEVE	OM3	1	87	41

60		JOIN LOWER BACK SLEEVE	SNL	1	75	48
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Lampiran 3 Barchart sebelum improvement proses (lanjutan)

NO	PART	PROCESS BREAKDOWN	MACHINE	MP	CT	OUTPUT/JAM
61	UNIT	JOIN BELT CLOSURE TO SHOULDER	SNL	2	136	52
62		STITCH 1/4 BELT CLOSURE TO SHOULDER	SNL	1	91	39
63		STITCH BELT CLOSURE ZZM	ZZM	1	95	37
64		JN SIDE PANEL SLV ALONG SHOULDER	SNL	2	145	49
65		OL SIDE PANEL SLV ALONG SHOULDER	OM3	1	86	41
66		JOIN TABS CUFF	SNL	1	46	78
67		STEAM SETENGAH JADI	STM	1	76	47
68		ATT VELCRO TO CUFF	VCM	1	85	42
69		JOIN SIDESEAM	SNL	2	150	48
70		OL SIDESEAM	OM3	1	82	43
71		JOIN COLLAR	SNL	1	85	42
72		JOIN LAYER FC CUFF + OL LAYER FC CUFF+ OL INSIDE COLLAR	SNL+OM3	1	70	51
73		ATT FR ZIP (RIGHT)	SNL	1	67	53
74		ATT FR ZIP (LEFT) MATCH COLLAR + WB HEM	SNL	1	86	41
75		JOIN FC CUFF TO CUFF ROUNDED	SNL	1	72	50
76		BARTACK BELT CLOSURE	BTK	1	62	58
77		BARTACK SLEEVE + PKT	BTK	1	72	50
78		OL INSIDE CUFF	OM3	1	50	72
79		STITCH FC CUFF ROUNDED	SNL	1	72	50
80		PRESS BONDING HEM CUFF	HNP	2	130	55
81	ASSEMBLY	JOIN LAYER FC HEM + JOIN FC HEM TO BODY	SNL	1	85	42
82		OL FC WB HEM + STITCH 1/16 FC HEM	SNL+OM3	1	84	42
83		JN LINNING TO COLLAR + STITCH HUNGER LOOP	SNL	2	160	45
84		OL INSIDE COLLAR + STITCH SIZE LABEL	OM3+SNL	1	85	42
85		TACK FOLD END OF IN COLLAR	SNL	1	80	45
86		BTK HUNGER LOOP + TACK DRAWCORD COLLAR + BTK DRAWCORD COLLAR	BTK+SNL	1	110	30
87		ATTACH BEMISH HEM INCLUDE MARKING + MARK FC FR LIN	STM	1	90	40
88		TACK END OF HEM	SNL	1	90	40
89		JOIN LINNING TO FR ZIP	SNL	1	89	40
90		STEAM BEMISH HEM	STM	1	90	40
91		HAND PRESS BONDING HEM JACKET	HNP	2	160	45
92		TACK ARMPIT + TACK INSIDE SHOULDER	SNL	1	65	55
93		TACK INSIDE COLLAR	SNL	1	86	41
94		JOIN LINNING TO WB HEM	SNL	2	133	54
95		OL INSIDE WB FC HEM	OM3	1	70	51

96		JOIN LIN TO INSIDE CUFF	SNL	1	95	37
97		OL INSIDE CUFF	OM3	1	82	43
98		STITCH TOP COLLAR	DNL	1	90	40
99		STITCH 1/4 FR ZIPPER	DNL	2	127	56
100		STITCH CLOSE LINNING SLEEVE	SNL	1	80	45

Lampiran 4 Barchart sesudah *improvement* proses

NO	PART	PROCESS BREAKDOWN	MACHINE	MP	CT	OUT PUT/JAM
1	STROMFLAP	PREPARE + JOIN STROMFLAP	SNA+SNC	1	97	37
2		CUT SEAM ALLOWANCE STROMFLAP+PREPARE ATACH BEMISH STROMFLAP	SNC	1	82	43
3		MARKING FC CUFF + ATTACH BEMISH FC CUFF	HNP	1	58	62
4		STEAM BEMISH	STM	2	145	49
5		PRESS BEMISH STROMFLAP+HAND PRESS STROMFLAP	HNP	1	81	44
6		PREPARE BEMISH TO STROMFLAP + ATTACH ZIP TO STROMFLAP	SNL	1	78	46
7	HOOD	JOIN SIDE TO MIDDLE HOODSHELL + LIN	SNL	1	45	80
8		OL INSIDE MIDDLE HOODSHELL + LIN + TACK TAB	OM3	1	70	51
9		STITCH HOODSHELL	MH3	1	75	48
10		PREPARE + ATTACH ZIP TO OUTER COLLAR U SHAPE	SNL	1	76	47
11		TACK END OFF WELT + CUT BREAK + STITCH ZIP OUTER COLLAR U SHAPE	SNL	1	53	67
12		JOIN CLOSE OUTER HOOD	SNL	1	60	60
13	JOIN HOOD TO ZIP COLLAR STRAIGHT	SNL	1	81	44	
14	INNER	PREPARE ZIP TO INNER COLLAR U SHAPE	SNA	1	44	81
15		ATTACH ZIP TO INNER COLLAR U SHAPE	SNA	1	49	73
16		CUT BREAK + TACK END OFF ZIP PKT + STITCH INNER COLLAR U SHAPE	SNL	1	87	41
17		BARTACK ZIP COLLAR + CUT BREAK	BTK	1	89	40
18		JOIN HOOD LIN TO ZIP INNER COLLAR STRAIGHT	SNL	1	95	37
19		STITCH UPPER OUTER COLLAR	SNL	1	50	72
20		JOIN PANEL TO UPPER INNER COLLAR	SNL	1	79	45
21		TACK INSIDE SIDE PANEL UPPER OUTER HOOD	SNL	1	56	64
22	STEAM COLLAR	STM	1	90	40	
23	COLLAR	PREPARE + JOIN INNER TO OUTER COLLAR	SNA	1	95	37
24		OL INSIDE COLLAR + STITCH 1/16 INNER COLLAR	OM3+SNL	1	59	61
25		ATT EYELETE TO COLLAR INCLUDE MARKING	BHM	1	66	54

Lampiran 5 Barchart sesudah *improvement* proses (lanjutan)

NO	PART	PROCESS BREAKDOWN	MACHINE	MP	CT	OUT PUT /JAM
26	PATCH POCKET	JOIN FC TO PALM + STITCH FC PALM	SNL	1	63	57
27		OL LAYER KNUCKLE + FC PALM	OM3	1	61	59
28		JOIN PALM TO ZIPPER HAND PKT + CUT BREAK	SNL	1	76	47
29		TACK INSIDE POCKET + STITCH ZIP PKT PALM	SNL	1	89	40
30		BARTACK ZIP POCKET + CUT ALLOWANCE INSIDE POCKET	BTK	1	40	90
31		JOIN KNUCKLE TO ZIP HAND POCKET	SNL	1	52	69
32	LINNING	JOIN SLEEVE TO BACK LIN REGLAND	OM4	1	51	70
33		JOIN SHOULDER ALONG SLEEVE + TACK TAB	OM4	1	56	64
34		JOIN UPPER BODY LINNING	OM4	1	62	58
35		JOIN LAYER UPPER BODY LIN + STITCH UP LIN	SNL	1	90	40
36		ATT CARE LABEL TO SIDE SEAM + ATT LOOP + SIZE LABEL TO UPPER BODY LINNING	SNL	1	77	46
37		JOIN SIDESEAM + TACK TAB	OM4	2	92	39
38		JOIN FC FRONT LINNING	OM4	1	98	36
39		STITCH FC RF LINNING	SNL	1	88	40
40	FRONT BODY	JOIN UPPER TO LOWER SIDE PANEL + OL UPPER TO LOWER SIDE PANEL	SNL	1	80	45
41		STITCH WELT POCKET ZIP PKT KNUCKLE + STITCH ZIP PKT PALM	SNL	1	79	45
42		JOIN UPPER LOWER TO FRONT BODY	SNL	1	90	40
43		OL UPPER LOWER SIDE PANEL	OM3	1	90	40
44		JOIN LOWER TO FRONT BODY	SNL	1	85	80
45		JOIN LAYER UPPER + LOWER POCKET BAGS	SNL	1	88	40
46		OL LAYER UPPER + LOWER PKT BAGS + JOIN TAPE DIAGONAL STITCHING	OM3+VCM	1	92	39
47		JOIN SIDE PANEL SLEEVE TO ALONG FR BODY	SNL	1	100	36
48		OL SIDE PANEL SLEEVE TO ALONG FR BODY	OM3	1	80	45
49	BACK BODY	JOIN FC BACK POCKET ROUNDED + BARTACK ZIP POCKET	BOX	1	80	45
50		STITCH 1/16 SQR FC POCKET + CUT BREAKOPEN PKT ROUNDED	SNL	1	93	38
51		TACK ZIP TO PKT POSITION + ATT ZIPPER PKT WITH FC DRCT STITCH	SNL	1	79	45
52		JOIN KNUCKLE / PALM TO ZIPPER BACK PKT	SNL	1	88	40
53		OL INSIDE BACK POCKET + STITCH 1/16 PALM	OM3+SNL	1	75	48
54		JOIN TAPE TO BACK + TACK ELSTC BK PKT STRAPE TO BUCKLE + JN LAYERPKT AQR	SNL	1	67	53
55		OL LAYER PKT SQR	OM3	1	56	64
56		JN UPPER TO LOWER SIDE PANEL + OL UP LOW SIDE PANEL + OL SIDE PANEL TO BACK BODY POINTED	OM3+SNL	2	98	36

57		JOIN SIDE PANEL TO BBY POINTED WITH CUT BREAK	SNL	1	143	50
58		JOIN UPPER TO LOWER BACK SLEEVE	SNL	1	78	46
59		OL LOWER BACK SLEEVE	OM3	1	87	41
60		JOIN LOWER BACK SLEEVE	SNL	1	75	48

Lampiran 6 Barchart sesudah *improvement* proses (lanjutan)

NO	PART	PROCESS BREAKDOWN	MACHINE	MP	CT	OUTPUT/JAM
61	UNIT	JOIN BELT CLOSURE TO SHOULDER	SNL	2	136	52
62		STITCH 1/4 BELT CLOSURE TO SHOULDER	SNL	1	91	39
63		STITCH BELT CLOSURE ZZM	ZZM	1	95	37
64		JN SIDE PANEL SLV ALONG SHOULDER	SNL	2	145	49
65		OL SIDE PANEL SLV ALONG SHOULDER	OM3	1	86	41
66		JOIN TABS CUFF	SNL	1	46	78
67		STEAM SETENGAH JADI	STM	1	76	47
68		ATT VELCRO TO CUFF	VCM	1	85	42
69		JOIN SIDESEAM	SNL	2	150	48
70		OL SIDESEAM	OM3	1	82	43
71		JOIN COLLAR	SNL	1	85	42
72		JOIN LAYER FC CUFF + OL LAYER FC CUFF+ OL INSIDE COLLAR	SNL+OM3	1	70	51
73		ATT FR ZIP (RIGHT)	SNL	1	67	53
74		ATT FR ZIP (LEFT) MATCH COLLAR + WB HEM	SNL	1	86	41
75		JOIN FC CUFF TO CUFF ROUNDED	SNL	1	72	50
76		BARTACK BELT CLOSURE	BTK	1	62	58
77		BARTACK SLEEVE + PKT	BTK	1	72	50
78		OL INSIDE CUFF	OM3	1	50	72
79		STITCH FC CUFF ROUNDED	SNL	1	72	50
80		PRESS BONDING HEM CUFF	HNP	2	130	55
81	ASSEMBLY	JOIN LAYER FC HEM + JOIN FC HEM TO BODY	SNL	1	85	42
82		OL FC WB HEM + STITCH 1/16 FC HEM	SNL+OM3	1	84	42
83		JN LINNING TO COLLAR + STITCH HUNGER LOOP	SNL	2	160	45
84		OL INSIDE COLLAR + STITCH SIZE LABEL	OM3+SNL	1	85	42
85		TACK FOLD END OF IN COLLAR	SNL	1	80	45
86		BTK HUNGER LOOP + TACK DRAWCORD COLLAR + BTK DRAWCORD COLLAR	BTK+SNL	1	110	30
87		ATTACH BEMISH HEM INCLUDE MARKING + MARK FC FR LIN	STM	1	90	40
88		TACK END OF HEM	SNL	1	90	40
89		JOIN LINNING TO FR ZIP	SNL	1	89	40
90		STEAM BEMISH HEM	STM	1	90	40
91		HAND PRESS BONDING HEM JACKET	HNP	2	160	45

92		TACK ARMPIT + TACK INSIDE SHOULDER	SNL	1	65	55
93		TACK INSIDE COLLAR	SNL	1	86	41
94		JOIN LINNING TO WB HEM	SNL	2	133	54
95		OL INSIDE WB FC HEM	OM3	1	70	51
96		JOIN LIN TO INSIDE CUFF	SNL	1	95	37
97		OL INSIDE CUFF	OM3	1	82	43
98		STITCH TOP COLLAR	DNL	1	90	40
99		STITCH 1/4 FR ZIPPER	DNL	2	127	56
100		STITCH CLOSE LINNING SLEEVE	SNL	1	80	45