

DAFTAR PUSTAKA

Buku Pedoman Praktik Kerja Lapangan Akademi Komunitas Industri Tekstil dan Produk Tekstil Surakarta. (2020)


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Diakses pada tanggal 15 Juni 2020

Lampiran 1

Line Balancing Worksheet Short Pants Style S#22ON036B



LINE BALANCE WORKSHEET

Date : 10 JANUARI 2020
By : SHELLA

FACTORY / LINE	ESGI 1 / LINE 14	Hourly Target	113	Hourly Cap.	50	pcs.	Pitch Time	65.00
BUYER	UNIQLO	Task Time	32	TCT	3,419	Sec.	UCL	72.22
PRD. FAMILY	PANTS	Allowance rate	10%	Actual MP	53		LCL	57.78
MODEL no.	S20N036A	PPH	0.28	SMV Sewing	61.14			
SMV	78.00	Efficiency	30.52%	Kapasitas Line	490			
TARGET	1071	Work hour	9.5					

Cmt. Process	GSD code	Operator Name	Process name	Machine	Time Study		MP		Process Rate	Process cap. 30 min
					CT	CT+ALL	EST	ACT		
FRONT BODY										
A										
A1	NA	TIKA	MARKING FRONT BODY	NMC	30	33.00	1.03	1	33.00	55
A2	NA	SUTANTO	STEAM LIPAT VARIASI FRONT + TEMPEL INTER KNUCKLE	STM	35	38.50	1.21	1	38.50	47
A3	NA	KRIS	STITCH LIPAT VARIASI FRONT (PINTUCK)	SNL	27	29.70	0.93	1	29.70	61
A4	NA	DANING	OV PALM + KNUCKLE SIDE POCKET + TEMPEL INTER KNUCKLE	OM13	46	50.60	1.58	1	50.60	36
A5	NA	LATIFAH	JOIN STITCH KNUCKLE SIDE POCKET	SNL	28	30.80	0.96	1	30.80	58
A6	NA	TARI	JOIN STITCH PALM SIDE POCKET	SNL	28	30.80	0.96	1	30.80	58
A7	NA	SURASMI	OV SIDE POCKET	OM13	29	31.90	1.00	1	31.90	56
A8	NA	HARTINI	STITCH 3/4 IN SIDE POCKET	SNL	65	71.50	2.24	1	71.50	25
A9	NA	SRI	STITCH 3/4 IN SIDE POCKET	SNL	108	118.80	3.72	1	118.80	15
A10	NA	RINA	JOIN SIDE POCKET	SNL	70	77.00	2.41	1	77.00	23
A11	NA	RINI	JOIN SIDE POCKET	SNL	76	83.60	2.62	1	83.60	22
A12	NA	IRM	CUT ALLOWANCE SIDE POCKET + BOBOK SIDE POCKET	OM	42	46.20	1.45	1	46.20	39
A13	NA	BAYU	TACK UPPER LOWER + MARKING POST LOOP	SNL	49	50.60	1.58	1	50.60	36
A14	NA	LING LING	STITCH MOUTH SIDE POCKET	DNL	46	50.60	1.58	1	50.60	36
A15	NA	YANTI	TACK LAPISAN SIDE POCKET + HANGER LOOP	SNL	38	41.80	1.31	1	41.80	43
TOTAL							785	25	15.00	
KAPASITAS									663	

B1	NA	REKA	MARKING BACK BODY + TEMPEL INTER	NMC	65	71.50	2.24	1	71.50	25
B2	NA	IRI	BOBOK BACK POCKET + TACK SEGITIGA	SNL	58	63.80	2.00	1	63.80	28
B3	NA	PLUR	STITCH LOWER + KNUCKLE BACK POCKET	SNL	38	41.80	1.31	1	41.80	43
B4	NA	JARWO	JOIN STITCH PALM + TACK BACK POCKET	SNL	35	38.50	1.21	1	38.50	47
B5	NA	ARIE	OV BACK POCKET + BAIK	SNL	35	38.50	1.21	1	38.50	47
B6	NA	PLUR	STITCH 3/4 IN BACK POCKET	SNL	53	58.30	1.83	1	58.30	31
B7	NA	JUMILAH	STITCH UPPER BACK POCKET	SNL	20	22.00	0.69	1	22.00	82
TOTAL							334	10	7.00	
KAPASITAS									716	
ASSEMBLY										
AS										
AS1	NA	NGARSINI	HELPER SET BODY	NMC	40	44.00	1.38	1	44.00	41
AS2	NA	ANITA	TACK UPPER SIDE SEAM	SNL	41	45.10	1.41	1	45.10	40
AS3	NA	EKO	OV SIDE SEAM	OM15	48	52.80	1.65	1	52.80	34
AS4.1	NA	NUBI	STITCH SIDE SEAM DALAM (POCKET)	DNL	75	82.50	2.58	1	82.50	22
AS4.2	NA	WIKE	STITCH SIDE SEAM DALAM (POCKET)	DNL	69	75.90	2.38	1	75.90	24
AS5.1	NA	YANTI	STITCH SIDE SEAM LUAR	DNL	88	96.80	3.03	1	96.80	19
AS5.2	NA	SAPTO	STITCH SIDE SEAM LUAR	DNL	91	100.10	3.13	1	100.10	18
AS6	NA	KHAMID	TACK POCKETING + RAJA	SNL	42	46.20	1.45	1	46.20	39
AS7	NA	MEGA	BARTACK SIDE POCKET + MARKING HEMMING	BTX	36	39.60	1.24	1	39.60	45
AS8	NA	AMBAR	OV BACK RISE + FRONT RISE	OM15	42	46.20	1.45	1	46.20	39
AS9	NA	NANANG	STEAM WAISTBAND	STM		0.00	0.00	1	0.00	
AS10	NA		STEAM HEMMING	STM	46	50.60	1.58	1	50.60	36
AS11	NA	KARIMANI	BUTTON HOLE + MARKING POST BUTTON HOLE	BHTA	35	38.50	1.21	1	38.50	47
AS12	NA	WABIDI	STITCH BACK RISE + FRONT RISE	SNL	47	51.70	1.62	1	51.70	35
AS13	NA		TACK ELASTIC WB BELUNDED + SAMBLUNG LOOP	SNL	10	11.00	0.34	0.4	27.50	65
AS14	NA	TEGUH	CUT ALLOWANCE WB	DNL	19	20.90	0.65	0.6	14.83	52
AS15	NA	SRI	MARKING ELASTIC + POST WB	NMC	30	33.00	1.03	1.0	20.63	87
AS16.1	NA	IRM	ATTACH LABEL	SNL	49	53.90	1.69	1	53.90	33
AS16.2	NA	FATHIM	ATTACH LABEL	SNL	44	48.40	1.52	1	48.40	37
AS17.1	NA	ANTON	JOIN ELASTIC TO BODY UPPER WB	KVS	75	82.50	2.58	1	82.50	22
AS17.2	NA	ROSDANI	JOIN ELASTIC TO BODY UPPER WB	KVS	62	68.20	2.14	1	68.20	26
AS18.1	NA	HAR	TACK CLOSE WAISTBAND	SNL	101	111.10	3.48	1	111.10	16
AS18.2	NA	BARTOHI	TACK CLOSE WAISTBAND	SNL	83	91.30	2.86	1	91.30	20
AS18.3	NA	SRI RAHAYU	TACK CLOSE WAISTBAND	SNL	97	106.70	3.34	1	106.70	17
AS19.1	NA	EDO	STITCH CLOSE WAISTBAND	KVS	146	159.50	4.99	1	159.50	11
AS19.2	NA	SURAMTI	STITCH CLOSE WAISTBAND	KVS	106	115.50	3.62	1	115.50	16
AS19.3	NA	TOHR	STITCH CLOSE WAISTBAND	KVS	72	79.20	2.48	1	79.20	23
AS20	NA		BARTACK CROTCH + TACK KUNG WB + BACK POCKET	BTX	15	16.50	0.52	0.5	16.50	55
AS21	NA		OV INSEAM	OM15	21	23.10	0.72	0.5	23.10	89
AS22.1	NA	KORIS	STITCH HEMMING	DNL	203	223.30	6.99	1	223.30	8
AS22.2	NA		STITCH HEMMING	DNL	189	207.90	6.51	1	207.90	9
AS22.3	NA	PODI	STITCH HEMMING	DNL	213	234.30	7.34	1	234.30	8
AS23	NA		HEMMING	NMC	104	114.40	3.58	1	114.40	18
AS24	NA		CCK TRIMMING	NMC	61	67.10	2.10	1	67.10	27
TOTAL							2549	80	30.6	

Lampiran 2

OPC Short Pants Style S#22ON036B

