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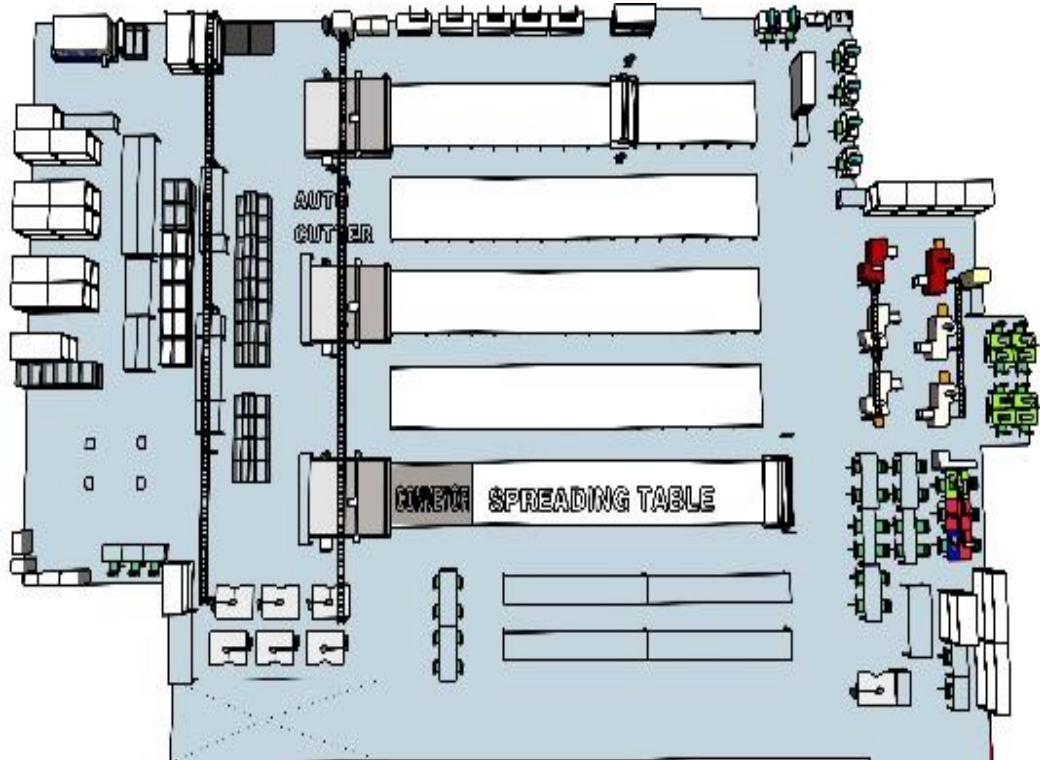
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LAMPIRAN

Lampiran 1 Tata letak departemen *cutting*




Sumber: IE departemen *cutting*, 2023

Lampiran 2 Operation breakdown style LHWPZ423

OPERATION BREAKDOWN									
BUYER	LEVIS	SAM	5.32	SAMPLE PHOTO			PT GLOBALINDO INTIMATES		
STYLE	LHWPZ421- LHWPZ423	TOTAL MANPOWER	11						
LINE	NGIRIBOYO	PITCH TIME	0.48						
DATE	21 FEBRUARI 2023	TARGET @ 100% EFF	124						
		PLANNED TGT DAY	868						
SN	CODE	COMPONENT	PROCESS	MACHINE	PROCESS TIME (SECONDS)	SAM	TARGET / HR	Theoretical Balancing	Actual manning level
1	2A	BACK	OVERLOCK JOIN CENTER BACK	4T OL	24	0.48	125	0.99	1
2	3A	FRONT	OVERLOCK JOIN CROTCH TO BACK	4T OL	25	0.50	120	1.03	1
3	4A	ASSEMBLY	OVERLOCK JOIN CROTCH TO FRONT	4T OL	23	0.46	130	0.95	1
4	4B		BASTE SIDE CROCTH	SN	16	0.32	188	0.66	1
5	4C		ATTACH ELASTIC LEG	ZIG-ZAG 3STP	40	0.80	75	1.65	1.5
6	4D		JOIN OVERLOCK SIDE SEAM	4T OL	24	0.48	125	0.99	1
7	4E		CUT ELASTIC WAIST BAND	TABLE	10	0.20	300	0.41	0.5
8	4F		JOIN ELASTIC WAIST BAND & TACKING	SN	18	0.36	167	0.74	0.5
10	4G		ATTACH ELASTIC WAIST BAND TO BODY	INTERLOCK	40	0.80	75	1.65	1.5
11	4H		ATTACH CARE LABEL & LABEL TO TOP CENTER BACK	SN	24	0.48	125	0.99	1
12	4I		BARTACK ELASTIC LEG CROCTH & TACKING SID	BT	22	0.44	136	0.91	1
TOTAL					266	5.32		11.00	11.00

Sumber: IE PT Globalindo Intimates line Ngiriboyo, 2023

Lampiran 3 Operation breakdown style 72301

PT GLOBALINDO INTIMATES									
OPERATION BREAKDOWN									
INDUSTRIAL ENGINEERING									
DOCUMENT NUMBER : G.I.F.IE.002									
BUYER	VF	SAM	15.54						
STYLE	72301-2104619	TOTAL MANPOWER	33						
LINE	NGIRI BOYO	PITCH TIME	0.47						
DATE	12 JANUARI 2023	TARGET @ 100% EFF	131						
		PLANNED TGT DAY	919						
SN	CODE	COMPONENT	PROCESS	MACHINE	PROCESS TIME (SECONDS)	SAM	TARGET / HR	THEORITICAL BALANCING	ACTUAL MANNING LEVEL
		CENTER FRAME & BACK	JOIN LINING BACK TO SIDE	SN	30	0.60	100	1.27	1
1	2A	CENTER FRAME & BACK	JOIN CENTER PANEL FRAME OUTER TO BACK OUTER	SN	20	0.40	150	0.85	1
2	2B		JOIN SIDE BACK LINING TO BACK LINING	INTERLOCK	24	0.48	125	1.02	1
3	2C		JOIN CENTER FRAME LINING TO BACK LINING	SN	20	0.40	150	0.85	1
			JOIN TACK LINING OUTER	SN	24	0.48	125	1.02	1
4	2D		JOIN OVERLOCK FRAME ASSEMBLY AT BOTTOM	2T OL	23	0.46	130	0.98	1
5	2E		ATTACH ELASTIC BOTTOM FRAME	ZIG-ZAG	30	0.60	100	1.27	1
6	2F		TOP STITCH ELASTIC BOTTOM FRAME	ZIG-ZAG	30	0.60	100	1.27	1
7	2G		ATTACH STRAP TO CENTER BACK	BT	18	0.36	167	0.76	1
8	2H		JOIN LINING OUTER AT TOP BACK	2T OL	20	0.40	150	0.85	1
9	2I		ATTACH ELASTIC TOP BACK	ZIG-ZAG	28	0.56	107	1.19	1
10	2J		TRUN BACK	TABLE	18	0.36	167	0.76	1
11	2K		BASTE BACK UNDER CUP & HOOK & EYE	SN	50	1.00	60	2.12	2
12	2L		ATTACH HOOK & EYE	ZIG-ZAG	22	0.44	136	0.93	1
13	2M		SARGE HOOK & EYE	ZIG-ZAG	23	0.46	130	0.98	1
14	3A	CUP	ATTACH STABILIZER AT UNDERBUST	SN	20	0.40	150	0.85	1
15	3B		ATTACH MID COVER LINING TO PAD	SN	75	1.50	40	3.19	3
16	3C		CUT & ATTACH STABILIZER AT PLAT FOAM	SN	20	0.40	150	0.85	1
17	3D		PREPARE PINNING OUTER BUST COVERS	TABLE	45	0.90	67	1.91	2
18	3E		TRIM MOLD OUTER NECKLINE & UNDERARM	OL CUT	30	0.60	100	1.27	1
19	3F		JOIN OUTER COVER TO PAD AT NECKLINE & UNDERARM	3T OL	45	0.90	67	1.91	2
20	3G		TURN OUTER COVER & PIN ROUND CUP	TABLE	40	0.80	75	1.70	2
21	3H		BASTE ROUND AT UNDERBUST	SN RC	24	0.48	125	1.02	1
22	4A	ASSEMBLY	JOIN CUP TO FRAME	SN	52	1.04	58	2.21	2
23	4B		ATTACH STRIPPING TO UNDER BUST	DN	50	1.00	60	2.12	2
24	4C		BARTACK STRIPPING TO SIDE & BARTACK STRAP TO PLAT FOAM 4X	BT	26	0.52	115	1.10	2
TOTAL					777	15.54		33.00	34.00

Sumber: IE PT Globalindo Intimates line Ngiriboyo, 2023