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LAMPIRAN

LAMPIRAN

Lampiran 1 Tata letak mesin *style A52* bagian *assembly*.

Proses	Mesin		Proses
packing			
QC			
hand press seal tape care label	HNP	MEJA TRANSFER - ASSEMBLY	STM
att care label to seal tape label	SNL		HNP
hemm hood curve ass 80 cm	SNL		SSM
hemming no lining +cord crv 110cm	SNL		
bartack draw cord hood, bartack draw cord bottom hemm	BTK		
insert draw cord hem with loop + stoper, insert draw cord to hood, tack draw cord to hem, tack draw cord to hood	SNL		SSM
join front facing to zipper for seam seal, stitch 1/16 inside front zipper coating 70 cm	SNL		SNC
attach eyelet to hood 2x, attach eyelet fc hemm 2x (cut hole)	SNP		SNL
Cut allowance fc bottom hem	OM		SNL
join fc to hemm straight	SNL		SNL
cuttinue zipper	SNL		BDL
seam sealing side seam normal, seam sealing neckline	SSM		HNP
join shoulder neckline, cut sparetely front body	SNC		SNC
			hand press front zipper
			seam seal inside center front zipper
			attach bemis to front zipper
			cut allow ance
			tack end off heming hood, tack end off hemm 3cm
			stitch fc hemm straight round marking eyelet hood + hemm
			join plaket
			hem cuff full elastic clean finished
			hand press side seam normal, hand press neckline
			join side seam normal

Lampiran 2 Tata letak mesin style A52 bagian unit.

Proses	Mesin	Proses
seam seal shoulder, sealing arm hole	SSM	STM
join sleeve normal	SNC	HNP
stitch shouder normal	SNL	SSM
join shoulder normal	SNC	HNP
hand press layer inner front body	HNP	STM
seam seal front body w 4 pocket	SSM	NMC
bartack zipper pocket, bartack side pocket	BTK	SNC
join side panel to front body, join backing pannel to inner side seam	SNL	SNL
stitch welt pkt zip knuckle 19 cm (1 welt + zip) w tacking, stitch zip pocket palm 19 cm (1 welt + zip) w tacking	SNL	SNT
tack zip pocket position, cut break open pocket w fc (hole), tack inside pocket	SNL	OM5
join close stormflap woven	DNL	SNL
Stitch edge stormflap square, stitch rain gaitor	SNL	SNT
cut allowance padd stormflap	SNC	SNL
join layer fc stormflap square w interlining	SNT	OM
stitch fc palm/ knuckle	SNL	SNT
join fc to palm/knuckle	OM5	

MEJA ADM

Lampiran 3 Urutan Proses Produksi Jaket A52

KODE	PART	PROSES DESCRIPTION	MACHINE
A1	Front Body	Marking front body with side pocket	NMC
A2	Front Body	Join interlining to welt pocket 17 cm	SNL
A3	Front Body	Tack zip to pocket position	SNL
A4	Front Body	Cut Break Open Pocket w FC (hole pocket)	NMC
A5	Front Body	Attach Zip to pocket (no facing)	SNL
A6	Front Body	Join fc to palm knuckle/ palm 25 cm (x2)	OM5
A7	Front Body	Stitch fc palm/knuckle straight	SNL
A8	Front Body	Join knuckle to zip hand pocket	SNL
A9	Front Body	Join palm to zip hand pocket	SNL
A10	Front Body	Stitch welt pocket zip knuckle 19 cm (1 welt+ zip) with tacking	SNL

Lampiran 3 Urutan Proses Produksi Jaket A52(Lanjutan)

KODE	PART	PROSES DESCRIPTION	MACHINE
A11	<i>Front Body</i>	<i>Stitch zip pocket palm 21 cm (1 welt+ zip) with tacking</i>	SNL
A12	<i>Front Body</i>	<i>Tack inside pocket</i>	SNL
A13	<i>Front Body</i>	<i>Join layer side pocket</i>	SNL
A14	<i>Front Body</i>	<i>Bartack zipper pocket</i>	BTK
A15	<i>Front Body</i>	<i>Join inside welt to zip side pocket straight before join side panel</i>	SNL
A16	<i>Front Body</i>	<i>Join side panel to front body with welt pocket 40 cm</i>	SNL
A17	<i>Front Body</i>	<i>Bartack side pocket</i>	BTK
A18	<i>Front Body</i>	<i>Cut allowance side panel + welt pocket</i>	SNL
A19	<i>Front Body</i>	<i>Seam seal front body with 4 pocket</i>	SSM
A20	<i>Front Body</i>	<i>Hand press front body with pocket</i>	HNP
A21	<i>Front Body</i>	<i>Attach layer inner pocket</i>	STM
A22	<i>Front Body</i>	<i>Hand press layer inner pocket</i>	HNP
A23	<i>Front Body</i>	<i>Join backing panel to inner pocket</i>	SNL
A24	<i>Front Body</i>	<i>Seam seal layer inner front body</i>	SSM
A25	<i>Front Body</i>	<i>Hand press layer front body</i>	HNP
B1	<i>Back Body</i>	<i>Cut hunger loop</i>	NMC
B2	<i>Back Body</i>	<i>Attach loop to backing panel</i>	SNL
B3	<i>Back Body</i>	<i>Bartack loop label</i>	BTK
B4	<i>Back Body</i>	<i>Join upper lower carrier label</i>	SNL
B5	<i>Back Body</i>	<i>Stitch 1/16 lower carrier label</i>	SNL
B6	<i>Back Body</i>	<i>Laser backing patch decorative</i>	LASER
B7	<i>Back Body</i>	<i>Attach bemis to inside allowance</i>	STM
B8	<i>Back Body</i>	<i>Cut allowance and remove layer bemis</i>	NMC
B9	<i>Back Body</i>	<i>Stitch carrier label</i>	SNL
B9	<i>Back Body</i>	<i>Stitch carrier label</i>	SNL
B10	<i>Back Body</i>	<i>Attach bemis patch panel</i>	STM
B11	<i>Back Body</i>	<i>Press patch panel loop</i>	HNP
C1	<i>Hood</i>	<i>Join side to middle hood</i>	SNC
C2	<i>Hood</i>	<i>Seam seal hood no tunnel</i>	SSM
C3	<i>Hood</i>	<i>Hand press hood no tunnel</i>	HNP
C4	<i>Hood</i>	<i>Join facing upper hood</i>	SNT
C5	<i>Hood</i>	<i>Stitch 1/16 fc upper hood</i>	SNL
C6	<i>Hood</i>	<i>Cut allowance fc hood</i>	SNC/OM
C7	<i>Hood</i>	<i>Stitch marking fc hood</i>	SNT
C8	<i>Hood</i>	<i>Attach eyelet to hood 2x</i>	SNP
D1	<i>Stormflap</i>	<i>Join layer stormflap w interlining</i>	SNL
D2	<i>Stormflap</i>	<i>Join interlining stormflap square</i>	SNC
D3	<i>Stormflap</i>	<i>Stitch edge stormflap square 80 cm (include turn out)</i>	SNL

Lampiran 3 Urutan Proses Produksi Jaket A52(Lanjutan)

KODE	PART	PROSES DESCRIPTION	MACHINE
D4	<i>Stormflap</i>	<i>Stitch fold rain gaitor</i>	SNL
D5	<i>Stormflap</i>	<i>Join close stormflap woven 70 cm</i>	SNL
D6	<i>Stormflap</i>	<i>Cut allowance padd stormflap</i>	SNC
D7	<i>Stormflap</i>	<i>Attach front zip to stormflap normal</i>	SNL
1	<i>Assembly</i>	<i>Join shoulder normal</i>	SNC
2	<i>Assembly</i>	<i>Stitch normal shoulder</i>	SNL
3	<i>Assembly</i>	<i>Seam seal shoulder</i>	SSM
4	<i>Assembly</i>	<i>Hand press shoulder</i>	HNP
5	<i>Assembly</i>	<i>Join sleeve normal match point</i>	SNC
6	<i>Assembly</i>	<i>Seam seal arm hole no lining</i>	SSM
7	<i>Assembly</i>	<i>Hand press arm hole no lining</i>	HNP
8	<i>Assembly</i>	<i>Join side seam normal match point</i>	SNC
9	<i>Assembly</i>	<i>Seam seal side seam normal</i>	SSM
10	<i>Assembly</i>	<i>Hand press side seam normal</i>	HNP
11	<i>Assembly</i>	<i>Tack elastis cuff clean finish 12 cm</i>	SNL
12	<i>Assembly</i>	<i>Hem cuff full elastic clean finished no tack</i>	SNL/BDL
13	<i>Assembly</i>	<i>Join collar 1 layer</i>	SNC
14	<i>Assembly</i>	<i>Seam seal neck line with tape 3x</i>	SSM
15	<i>Assembly</i>	<i>Hand press neck line</i>	HNP
16	<i>Assembly</i>	<i>Attach zip match collar + wb + pkt</i>	SNL
17	<i>Assembly</i>	<i>Cut sparate front body</i>	NMC
18	<i>Assembly</i>	<i>Join Front fc to zipper for seam seal</i>	SNL
19	<i>Assembly</i>	<i>Stitch 1/16 inside front zipper</i>	SNL
20	<i>Assembly</i>	<i>Cut allowance front zipper</i>	SNC
21	<i>Assembly</i>	<i>Attach bemis front zipper</i>	SSM
22	<i>Assembly</i>	<i>Seam seal inside center zipper</i>	SSM
23	<i>Assembly</i>	<i>Hand press front zipper</i>	HNP
24	<i>Assembly</i>	<i>Join facing to hem straight/rounded 110 cm</i>	SNL
25	<i>Assembly</i>	<i>Stitch facing hem straight/rounded 110 cm</i>	SNL
26	<i>Assembly</i>	<i>Tack end of hem 3 cm</i>	SNL
27	<i>Assembly</i>	<i>Attach eyelet facing hem 2x (include marking + cut hole)</i>	SNP
28	<i>Assembly</i>	<i>Insert drawcord hem with loop + stopper</i>	NMC
29	<i>Assembly</i>	<i>Tack drawcord hem 2X</i>	SNL
30	<i>Assembly</i>	<i>Bartack insert drawcord bottom hem</i>	BTK
31	<i>Assembly</i>	<i>Hemming no lining bottom hem</i>	SNL
32	<i>Assembly</i>	<i>Tack end off hemming hood</i>	SNL
33	<i>Assembly</i>	<i>Insert drawcord to hood</i>	NMC
34	<i>Assembly</i>	<i>Tack drawcord to hood</i>	SNL
35	<i>Assembly</i>	<i>Bartack inside drawcord hood</i>	BTK
36	<i>Assembly</i>	<i>Hemm hood curve ass 80 cm</i>	SNL

Lampiran 3 Urutan Proses Produksi Jaket A52 (Lanjutan)

KODE	PART	PROSES DESCRIPTION	MACHINE
37	<i>Assembly</i>	<i>Attach care label to seal tape label</i>	SNL
38	<i>Assembly</i>	<i>Hand press seal tape care label</i>	HNP
39	<i>Assembly</i>	<i>Steam normal jacket</i>	STM
QC		<i>Inspect normal jacket</i>	QC

Lampiran 4 Cycle time lengkap style A52

NO	MESIN	PROSES	CT GSD	CT 1	CT 2	CT 3	CT 4	CT 5
1	SNT	<i>Join facing upper hood + Stitch marking facing upper hood</i>	63	143	143	142	146	88
2	SNL	<i>Stitch 1/16 facing upper hood crv</i>	35	109	109	112	107	109
3	SNT+SNC	<i>Join layer facing stormflap w interlining + join interlining stormflap sqr + Join close stormflap woven + cut allowance padd stormflap</i>	75	138	138	136	128	92
4	SNL + DNL	<i>Stitch edge stormflap sqr (include turn out) + stirtch fold rain gaitor + runstitch</i>	73	95	95	95	93	95
5	OM5 + SNL	<i>join facing to palm/knuckle + stitch fc palm/knuckle</i>	99	138	120	127	119	115
6	SNT	<i>attach zip to pocket (no facing) + join knuckle to zip hand pocket + join palm to zip hand pocket</i>	167	197	179	148	139	135
7	SNL	<i>tack zip to pkt position + cut break open pocket w fc (hole pocket) tack inside pocket</i>	118	339	298	312	305	339
8	OM 5	<i>Join layer side pocket</i>	29	144	144	139	133	121
9	SNL	<i>Stitch welt pocket zip knuckle (1 welt + zip) with tacking + Stitch zip pocket palm (1 welt + zip) with tacking</i>	85	112	112	112	112	112
10	SNT	<i>Join Interlining to welt pocket</i>	24	142	139	140	135	132

Lampiran 4 Cycle time lengkap style A52 (lanjutan)

NO	MESIN	PROSES	CT GSD	CT 1	CT 2	CT 3	CT 4	CT 5
11	SNL	<i>Join side panel to front body w welt pocket + join backing panel to inner side seam</i>	109	132	137	131	138	135
12	SNL	<i>Join inside welt to zip side pocket straight before join side panel + join side panel to fby w welt pocket</i>	162	273	132	132	126	125
13	BTK	<i>Bartack zipper pocket + bartack side pocket</i>	52	287	125	125	131	124
14	SNC	<i>Cut allowance side panel + welt pocket</i>	49	172	180	180	185	172
15	NMC	<i>Marking layer inner pocket</i>	0	180	186	180	149	100
16	STM	<i>Attach layer inner pocket</i>	85	480	412	339	268	150
17	SSM	<i>Seam seal Inner fby + seam seal side seam normal + seam seal neckline with tape 3X (with lining)</i>	176	296	270	250	213	181
18	HNP	<i>Hand press layer fby + hand press side seam normal + hand press neck line</i>	239	207	200	183	176	158
19	SSM	<i>Seam seal front body with 4 pocket</i>	102	424	238	223	187	132
20	HNP	<i>hand press front body with 4 pocket</i>	95	289	192	167	142	128
21	SNC + SNL	<i>Join shoulder nrml + stitch shoulder + set up</i>	50	126	126	121	120	126

Lampiran 4 Cycle time lengkap style A52 (lanjutan)

NO	MESIN	PROSES	CT GSD	CT 1	CT 2	CT 3	CT 4	CT 5
22	SNT	<i>Attach front zipper match collar+wb+pkt (no full)</i>	50	158	158	133	129	121
23	SNL	<i>join sleeve normal match point 2x</i>	91	297	292	290	213	122
24	SSM	<i>Seam seal shoulder + seam seal arm hole</i>	125	309	300	256	194	111
25	HNP	<i>hand press shoulder + hand press arm hole</i>	148	341	198	171	147	131
26	SNC	<i>join side seam normal match point</i>	84	340	256	212	179	180
27	STM	<i>Steam side pocket + steam welt side pocket</i>	0	70	70	68	65	70
28	SNC	<i>join collar (1 layer) + cut separate fby</i>	66	256	256	198	149	152
29	SNL	<i>Attach front zipper match collar+wb+pkt (continue)</i>	50	135	135	135	135	135
30	SNL	<i>Join fc to hem straight + cut allowance</i>	50	173	173	159	159	142
31	SNL	<i>Stitch fc hem straight / round</i>	31	129	128	128	128	129
32	SNL	<i>Tack end of hem + tack end off hemming hood</i>	42	296	225	198	187	180
33	SNP + SNP	<i>attach eyelet hood 2x + attach eyelet fc hem 2x (include mrking & cut hole)</i>	99	217	217	187	156	132
34	SNL	<i>attach front zip to stormflap normal</i>	30	256	198	198	176	162

Lampiran 4 Cycle time lengkap style A52 (lanjutan)

NO	MESIN	PROSES	CT GSD	CT 1	CT 2	CT 3	CT 4	CT 5
35	SNL	<i>join front fc to zipper for seam seal + stitch 1/16 inside front zipper coating</i>	110	241	241	215	172	162
36	SNC	<i>Stitch close front body</i>	20	143	143	143	140	115
37	SSM	<i>Seam Seal inside center front zipper</i>	74	167	167	167	148	112
38	SSM	<i>attach bemish front zipper</i>	113	161	161	161	142	130
39	SNL	<i>insert drawcord hem with loop+stopper + tack drawcord hem + insert drawcord to hood + tack drawcord to hood</i>	148	85	85	85	85	85
40	BTK	<i>Bartack inside drawcord btm hem + bartack inside drawcord hood</i>	26	98	98	98	98	98
41	BDL	<i>tack elastic cuff clean finished + hem cuff elastic cln finished no tack</i>	122	221	182	165	145	117
42	SNL	<i>Hemm hood curve ass</i>	88	215	215	198	198	168
43	SNL	<i>Hemming no lining+cord crv</i>	105	184	184	168	156	142
44	SNL + HNP	<i>attach care label to seal tape label + hand press seal tape care label</i>	41	101	101	101	101	101
45	STM + HNP	<i>Steam hemming + steam front zipper + press front zipper + hand press front zipper</i>	282	149	149	149	149	149
TOTAL SMV			3882	9165	8007	7477	6654	6015

