

## Daftar Pustaka

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## LAMPIRAN

Lampiran 1 Data kualitas hasil tying code 887047RF mesin GB

| No | Tanggal | Shift | Code        | No Beam | No Mc | Mc Tying | CROS | Benang (-) | Benang (+) | Total |
|----|---------|-------|-------------|---------|-------|----------|------|------------|------------|-------|
| 1  | 2       | 1     | 887047RF/B  | TS 426  | 10/3  | GB       | 0    | 3          | 0          | 3     |
| 2  | 2       | 2     | 887047 RF/B | TS 486  | 6/2   | GB       | 0    | 1          | 0          | 1     |
| 3  | 2       | 2     | 887047 RF/B | TS 070  | 1/2   | GB       | 0    | 0          | 1          | 1     |
| 4  | 11      | 3     | 887047RF/B  | TS 402  | 9/4   | GB       | 0    | 1          | 0          | 1     |
| 5  | 12      | 2     | 887047 RF/B | TS 209  | 11/4  | GB       | 0    | 0          | 0          | 0     |
| 6  | 13      | 2     | 887047 RF/B | TS 278  | 10/2  | GB       | 0    | 0          | 4          | 4     |
| 7  | 14      | 3     | 887047RF/B  | TS290   | 9/3   | GB       | 0    | 0          | 0          | 0     |
| 8  | 15      | 1     | 887047RF/B  | TS 286  | 10/3  | GB       | 0    | 1          | 1          | 2     |
| 9  | 15      | 1     | 887047RF/B  | TS 723  | 10/1  | GB       | 0    | 0          | 0          | 0     |
| 10 | 15      | 2     | 887047RF/B  | TS 723  | 10/1  | GB       | 0    | 1          | 0          | 1     |
| 11 | 16      | 2     | 887047RF/B  | TS 415  | 9/2   | GB       | 0    | 0          | 0          | 0     |
| 12 | 17      | 2     | 887047RF/B  | TS569   | 9/1   | GB       | 0    | 2          | 0          | 2     |
| 13 | 19      | 2     | 887047RF/B  | TS430   | 11/2  | GB       | 0    | 3          | 0          | 3     |
| 14 | 23      | 1     | 887047RF/B  | TS427   | 7/3   | GB       | 0    | 0          | 0          | 0     |
| 15 | 26      | 2     | 887047 RF/B | TS 253  | 11/1  | GB       | 0    | 3          | 0          | 3     |
| 16 | 27      | 2     | 887047RF/B  | TS 665  | 6/1   | GB       | 0    | 1          | 0          | 1     |
| 17 | 27      | 3     | 887047RF/B  | TS729   | 9/4   | GB       | 0    | 0          | 4          | 4     |
| 18 | 28      | 1     | 887047RF/B  | TS 026  | 9/1   | GB       | 0    | 3          | 0          | 3     |
| 19 | 28      | 1     | 887047RF/B  | TS 310  | 1/14  | GB       | 0    | 2          | 2          | 4     |
| 20 | 29      | 1     | 887047RF/B  | TS657   | 10/2  | GB       | 0    | 1          | 2          | 3     |
| 21 | 30      | 2     | 887047RF/B  | TS 085  | 5/3   | GB       | 0    | 0          | 0          | 0     |
| 22 | 31      | 1     | 887047 RF/B | TS 033  | 3/2   | GB       | 0    | 0          | 2          | 2     |
| 23 | 31      | 2     | 887047RF/B  | TS125   | 9/2   | GB       | 0    | 2          | 2          | 4     |
| 24 | 3       | 2     | 887047 RF/B | TS 291  | 15/1  | GB       | 0    | 3          | 0          | 3     |
| 25 | 3       | 2     | 887047 RF/B | TS 286  | 16/2  | GB       | 0    | 3          | 0          | 3     |
| 26 | 5       | 1     | 887047RF/B  | TS591   | 11/2  | GB       | 0    | 3          | 0          | 3     |
| 27 | 5       | 3     | 887047 RF/B | TS 296  | 5/2   | GB       | 0    | 1          | 0          | 1     |
| 28 | 7       | 2     | 887047RF/B  | TS026   | 11/3  | GB       | 0    | 5          | 1          | 6     |
|    |         |       |             |         |       |          | 0    | 39         | 19         | 58    |

Lampiran 2 Data kualitas hasil tying code 887047RF mesin Todo

| No | Tanggal | Shift | Code        | No Beam | No Mc | Mc Tying | CROS | Benang (-) | Benang (+) | Total |
|----|---------|-------|-------------|---------|-------|----------|------|------------|------------|-------|
| 1  | 2       | 2     | 887047 RF/B | TS 088  | 10/1  | TODO     | 0    | 0          | 2          | 2     |
| 2  | 7       | 1     | 887047RF/B  | TS 012  | 7/3   | TODO     | 0    | 1          | 0          | 1     |
| 3  | 8       | 1     | 887047RF/B  | TS756   | 4/12  | TODO     | 0    | 3          | 0          | 3     |
| 4  | 9       | 1     | 887047RF/B  | TS569   | 9/1   | TODO     | 0    | 7          | 0          | 7     |
| 5  | 10      | 2     | 887047RF/B  | TS28    | 6/1   | TODO     | 0    | 3          | 3          | 6     |
| 6  | 10      | 2     | 887047RF/B  | TS147   | 1/3   | TODO     | 0    | 3          | 0          | 3     |
| 7  | 10      | 3     | 887047RF/B  | TS 253  | 8/3   | TODO     | 0    | 4          | 0          | 4     |
| 8  | 11      | 2     | 887047RF/B  | TS441   | 4/3   | TODO     | 0    | 2          | 0          | 2     |
| 9  | 12      | 3     | 887047RF/B  | TS282   | 1/14  | TODO     | 0    | 2          | 0          | 2     |
| 10 | 13      | 1     | 887047RF/B  | TS 033  | 7/1   | TODO     | 0    | 0          | 8          | 8     |
| 11 | 13      | 3     | 887047 RF/B | TS678   | 5/1   | TODO     | 0    | 1          | 4          | 5     |
| 12 | 15      | 1     | 887047RF/B  | TS 023  | 1/1   | TODO     | 0    | 5          | 0          | 5     |
| 13 | 16      | 1     | 887047RF/B  | TS247   | 2/4   | TODO     | 0    | 5          | 1          | 6     |
| 14 | 16      | 2     | 887047RF/B  | TS 271  | 6/3   | TODO     | 0    | 0          | 2          | 2     |
| 15 | 17      | 1     | 887047 RF/B | TS 266  | 2/3   | TODO     | 0    | 0          | 0          | 0     |
| 16 | 17      | 1     | 887047 RF/B | TS 313  | 5/4   | TODO     | 0    | 2          | 0          | 2     |
| 17 | 17      | 1     | 887047 RF/B | TS 189  | 7/4   | TODO     | 0    | 3          | 0          | 3     |
| 18 | 17      | 2     | 887047RF/B  | TS618   | 4/2   | TODO     | 0    | 1          | 2          | 3     |
| 19 | 17      | 3     | 887047RF/B  | TS 591  | 8/4   | TODO     | 0    | 4          | 6          | 10    |
| 20 | 19      | 3     | 887047RF/B  | TS159   | 5/2   | TODO     | 0    | 2          | 6          | 8     |
| 21 | 23      | 1     | 887047RF/B  | TS01    | 4/12  | TODO     | 0    | 0          | 0          | 0     |
| 22 | 24      | 2     | 887047RF/B  | TS267   | 5/1   | TODO     | 0    | 3          | 0          | 3     |
| 23 | 25      | 3     | 887047RF/B  | TS 056  | 8/3   | TODO     | 0    | 4          | 0          | 4     |
| 24 | 26      | 2     | 887047 RF/B | 443     | 1/3   | TODO     | 0    | 4          | 0          | 4     |
| 25 | 27      | 1     | 887047RF/B  | TS 209  | 8/2   | TODO     | 0    | 0          | 2          | 2     |
| 26 | 27      | 3     | 887047RF/B  | TS129   | 4/4   | TODO     | 0    | 2          | 0          | 2     |
| 27 | 28      | 2     | 887047RF/B  | TS 051  | 4/3   | TODO     | 0    | 1          | 0          | 1     |
| 28 | 28      | 2     | 887047RF/B  | TS 129  | 5/4   | TODO     | 0    | 1          | 7          | 8     |
|    |         |       |             |         |       |          | 0    | 63         | 43         | 106   |

Lampiran 3 Data kualitas hasil tying code T1025462Sa mesin GB

| no | Tanggal | Shift | Code           | No Beam | No Mc | Mc Tying | CROS | Benang (-) | Benang (+) | Total |
|----|---------|-------|----------------|---------|-------|----------|------|------------|------------|-------|
| 1  | 2       | 3     | T1025462SA/A   | TS047   | 7/8   | GB       | 0    | 2          | 0          | 2     |
| 2  | 3       | 1     | T 1025462SA/A  | TS 744  | 10/9  | GB       | 0    | 0          | 1          | 1     |
| 3  | 3       | 1     | T 1025462SA/A  | TS 144  | 12/6  | GB       | 0    | 0          | 2          | 2     |
| 4  | 3       | 2     | T 1025462 SA/A | TS 379  | 14/9  | GB       | 0    | 2          | 1          | 3     |
| 5  | 3       | 2     | T 1025462 SA/A | TS 104  | 9/11  | GB       | 0    | 2          | 0          | 2     |
| 6  | 3       | 3     | T 1025462 SA/A | TS 195  | 15/8  | GB       | 0    | 2          | 2          | 4     |
| 7  | 5       | 1     | T 1025462 SA/A | TS508   | 11/9  | GB       | 0    | 0          | 1          | 1     |
| 8  | 5       | 1     | T 1025462 SA/A | TS450   | 12/10 | GB       | 0    | 2          | 0          | 2     |
| 9  | 5       | 3     | T 1025462 SA/A | TS 130  | 15/9  | GB       | 0    | 1          | 1          | 2     |
| 10 | 5       | 3     | T 1025462 SA/A | TS 073  | 11/10 | GB       | 0    | 1          | 0          | 1     |
| 11 | 7       | 1     | T 1025462 SA/A | TS 597  | 15/20 | GB       | 0    | 0          | 3          | 3     |
| 12 | 7       | 1     | T 1025462 SA/A | TS 474  | 16/11 | GB       | 0    | 2          | 0          | 2     |
| 13 | 8       | 1     | T 1025462 SA/A | TS 193  | 10/10 | GB       | 0    | 1          | 2          | 3     |
| 14 | 8       | 1     | T 1025462 SA/A | TS 743  | 1/9   | GB       | 0    | 1          | 0          | 1     |
| 15 | 8       | 3     | T 1025462 SA/A | TS 458  | 14/20 | GB       | 0    | 0          | 3          | 3     |
| 16 | 8       | 3     | T 1025462 SA/A | TS 289  | 13/10 | GB       | 0    | 0          | 1          | 1     |
| 17 | 9       | 1     | T 1025462 SA/A | TS 030  | 14/10 | GB       | 0    | 2          | 5          | 7     |
| 18 | 9       | 3     | T 1025462 SA/A | TS155   | 12/9  | GB       | 0    | 1          | 0          | 1     |
| 19 | 10      | 1     | T 1025462 SA/A | TS 44   | 12/8  | GB       | 0    | 0          | 1          | 1     |
| 20 | 10      | 1     | T 1025462 SA/A | TS 637  | 15/8  | GB       | 0    | 2          | 0          | 2     |
| 21 | 10      | 1     | T 1025462 SA/A | TS 190  | 9/11  | GB       | 0    | 0          | 1          | 1     |
| 22 | 10      | 3     | T 1025462 SA/A | TS203   | 11/10 | GB       | 0    | 1          | 1          | 2     |
| 23 | 11      | 1     | T 1025462 SA/A | TS 449  | 12/10 | GB       | 0    | 0          | 5          | 5     |
| 24 | 11      | 1     | T 1025462 SA/A | TS 249  | 11/8  | GB       | 0    | 2          | 3          | 5     |
| 25 | 11      | 1     | T 1025462 SA/A | TS 354  | 14/8  | GB       | 0    | 0          | 3          | 3     |
| 26 | 11      | 1     | T 1025462 SA/A | TS 360  | 15/11 | GB       | 0    | 0          | 2          | 2     |
| 27 | 11      | 2     | T 1025462SA/A  | TS 717  | 10/5  | GB       | 0    | 0          | 1          | 1     |
| 28 | 11      | 3     | T1025462SA/A   | TS106   | 12/6  | GB       | 0    | 0          | 0          | 0     |
|    |         |       |                |         |       |          |      | 24         | 39         | 63    |

Lampiran 4 Data kualitas hasil tying code T1025462Sa mesin Todo

| NO | Tanggal | Shift | Code           | No Beam | No Mc | Mc Tying | CROS | Benang (-) | Benang (+) | Total |
|----|---------|-------|----------------|---------|-------|----------|------|------------|------------|-------|
| 1  | 2       | 3     | T1025462SA/A   | TS274   | 14/8  | TODO     | 0    | 6          | 2          | 8     |
| 2  | 2       | 3     | T1025462SA/A   | TS350   | 10/5  | TODO     | 0    | 3          | 7          | 10    |
| 3  | 2       | 3     | T1025462SA/A   | TS151   | 15/11 | TODO     | 0    | 7          | 1          | 8     |
| 4  | 3       | 1     | T 1025462SA/A  | TS 028  | 2/10  | TODO     | 0    | 8          | 0          | 8     |
| 5  | 3       | 2     | T 1025462 SA/A | TS 462  | 2/7   | TODO     | 0    | 4          | 2          | 6     |
| 6  | 5       | 1     | T 1025462 SA/A | TS695   | 8/9   | TODO     | 0    | 3          | 0          | 3     |
| 7  | 5       | 1     | T 1025462 SA/A | TS745   | 6/9   | TODO     | 0    | 4          | 0          | 4     |
| 8  | 5       | 1     | T 1025462 SA/A | TS712   | 5/6   | TODO     | 0    | 4          | 0          | 4     |
| 9  | 5       | 3     | T 1025462 SA/A | TS 383  | 1/10  | TODO     | 0    | 1          | 2          | 3     |
| 10 | 5       | 3     | T 1025462 SA/A | TS 020  | 6/8   | TODO     | 0    | 2          | 14         | 16    |
| 11 | 6       | 3     | T 1025462SA/A  | TS 174  | 13/8  | TODO     | 0    | 2          | 1          | 3     |
| 12 | 7       | 2     | T 1025462 SA/A | TS069   | 13/9  | TODO     | 0    | 2          | 0          | 2     |
| 13 | 8       | 2     | T 1025462 SA/A | TS223   | 3/7   | TODO     | 0    | 2          |            | 2     |
| 14 | 8       | 3     | T 1025462 SA/A | TS 607  | 7/9   | TODO     | 0    | 2          | 2          | 4     |
| 15 | 9       | 2     | T 1025462 SA/A | TS 218  | 2/10  | TODO     | 0    | 3          | 1          | 4     |
| 16 | 10      | 1     | T 1025462 SA/A | TS 275  | 5/11  | TODO     | 0    | 0          | 7          | 7     |
| 17 | 10      | 2     | T 1025462 SA/A | TS 405  | 5/5   | TODO     | 0    | 7          | 0          | 7     |
| 18 | 10      | 3     | T 1025462 SA/A | TS284   | 8/9   | TODO     | 0    | 4          | 0          | 4     |
| 19 | 11      | 1     | T 1025462 SA/A | TS 287  | 7/8   | TODO     | 0    | 1          | 1          | 2     |
| 20 | 11      | 1     | T 1025462 SA/A | TS 211  | 2/7   | TODO     | 0    | 0          | 1          | 1     |
| 21 | 11      | 2     | T 1025462 SA/A | TS 533  | 6/8   | TODO     | 0    | 2          | 2          | 4     |
| 22 | 12      | 1     | T 1025462 SA/A | TS370   | 6/10  | TODO     | 0    | 1          | 0          | 1     |
| 23 | 12      | 2     | T 1025462 SA/A | TS 218  | 1/10  | TODO     | 0    | 7          | 3          | 10    |
| 24 | 12      | 2     | T 1025462 SA/A | TS 274  | 6/9   | TODO     | 0    | 3          | 1          | 4     |
| 25 | 12      | 3     | T 1025462SA/A  | TS 144  | 5/6   | TODO     | 0    | 1          | 7          | 8     |
| 26 | 13      | 1     | T 1025462 SA/A | TS006   | 16/11 | TODO     | 0    | 2          | 0          | 2     |
| 27 | 14      | 2     | T 1025462 SA/A | TS474   | 13/10 | TODO     | 0    | 11         | 0          | 11    |
| 28 | 14      | 2     | T 1025462 SA/A | TS438   | 1/9   | TODO     | 1    | 0          |            | 1     |
|    |         |       |                |         |       |          | 1    | 92         | 54         | 147   |

Lampiran 5 No jarum selector

| No benang | No jarum   | Diameter dslam inchi |
|-----------|------------|----------------------|
| 60"S      | 25         | 0,0025               |
| 40"S      | 25 atau 35 | 0,0030 atau 0,0035   |
| 30"S      | 40 atau 45 | 0,0040 atau 0,0045   |
| 20"S      | 50 atau 55 | 0,0050 atau 0,0055   |
| 10"S      | 60 atau 55 | 0,0060 atau 0,0065   |

Lampiran 6 Bukti wawancara



Bagian : Preparation PT Dan Iris

Narasumber : Pak Siswanto (Mtc)

1. Faktor manusia yang dapat mempengaruhi proses tying?

=> Penglihatan operator

Ketepatan pembuatan sheet, sheet lusi harus bagus, harus rapi, kalau tidak bagus nanti berpengaruh terhadap hasil tyingnya.

2. faktor mesin

=> Untuk kerusakan paling sering biasanya di Feller, selain itu tergantung ke manusianya bagaimana dia menggunakan mesin. Semakin baik penggunaannya semakin awet. Faktor dari kebersihan frame tying juga berpengaruh di frame tying ada seperti roda yang bentuknya seperti bearing yang terletak dibawah clamp itu berfungsi untuk menyejajarkan bearing memudahkan feeler untuk mendeteksi bearing jadi selector mudah mengambilnya.

Narasumber : Pak Shaim (Kepala Bagian Weaving)

1. Apakah di unit weaving sudah ada instruksi kerja Penggantian Jarum selector

⇒ Belum, biasanya operator mengganti saat pergantian kontulsi dan menyesuaikan jenis benang yang akan di proses. Yang ada saat ini hanya instruksi kerja proses leasing dan tying.

2. Apakah boleh jika dalam laporan saya, saya membuat standar / instruksi kerja pemasangan selector

⇒ Sebenarnya boleh, Tapi tidak memungkinkannya karena, jika membuat ik kita harus melakukan pengujian terhadap benang dan jarum selector satu-satu, namun jika diletakan disaran tidak papa contoh Benang PE 30 sebaiknya menggunakan nomor selcion.

1. Pada proses tying, benang yang dapat di tying adalah benang yang memiliki nomor siri yang sama.
2. Kesejajaran sheet tying apakah sangat berpengaruh dalam kelancaran proses tying.
3. Hal apa saja yang harus diperhatikan sebelum proses tying dilakukan
4. Rata-rata dalam 1 <sup>sift</sup> ~~sheet~~ <sup>si</sup> dapat menyerfasi berapa kontolisi
5. Jika tiba-tiba mesin mengalami trouble apa tindakan yang dilakukan
2. Standar sheet tying harus lurus
3. Kondisi headframe harus bagus
- bamparan lusi bagus atau tidak kalo kangi tipis tidak bisa di tying
  - kebersihan di ty mc tentu
4. 4 ( 1 jam 1/2 Saat mesin berjalan )  
2 jam pembuatan sheet
5. Saat shift pagi bisa lapor bemitc tapi kalo sift 2 dan 3 blangan

(Siti S)



## PT. DAN LIRIS

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www.danliris.com



### SURAT - KETERANGAN

Nomor : 550 /DL-UM-PERSN/VII/2023

Yang bertanda tangan dibawah ini, menerangkan bahwa :

- Nama : Hastuti Febri Kurniawati
- NIM : 2102009
- Program Studi : Teknik Pembuatan Kain Tenun
- Institusi : Akademik Komunitas Industri Tekstil dan Produk Tekstil Surakarta

Benar-benar telah melaksanakan Kuliah Kerja Lapangan/Magang di PT.Dan Liris – Sukoharjo, pada tanggal 08 Mei – 06 Juli 2023.

Demikian Surat Keterangan ini dikeluarkan untuk bisa dipergunakan sebagaimana mestinya.

Dikeluarkan di : Sukoharjo  
Pada tanggal : 06 Juli 2023

PT. DAN LIRIS – SUKOHARJO

  
Harrison Silaen  
Direktur Umum