

## LAMPIRAN

A- Data Perhitungan *Availability rate*

<b>Mesin Kobayashi 1</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Total Downtime</b>	<b>Operation Time (menit)</b>	<b>Availability</b>
1	2/04/2018	UP <i>Single</i>	0	770	100%
2	3/04/2018	UP <i>Single</i>	0	770	100%
3	4/04/2018	UP <i>Single</i>	0	770	100%
4	5/04/2018	UP <i>Single</i>	80	690	90%
5	6/04/2018	UP <i>Single</i>	0	690	90%
6	9/04/2018	GB	0	770	100%
7	10/04/2018	GB	0	770	100%
8	11/04/2018	GB	0	770	100%
9	12/04/2018	GB	0	770	100%
10	13/04/2018	GB	200	490	64%
11	16/04/2018	GB	60	710	92%
12	17/04/2018	GB	0	770	100%
13	18/04/2018	GB	0	770	100%
14	19/04/2018	GB	270	500	65%
15	20/04/2018	UP <i>Single</i>	0	690	90%
16	23/04/2018	UP <i>Single</i>	0	770	100%
17	24/04/2018	UP <i>Single</i>	0	770	100%
18	25/04/2018	UP <i>Single</i>	0	770	100%
19	26/04/2018	UP <i>Single</i>	0	770	100%
20	27/04/2018	UP <i>Single</i>	0	690	90%
21	2/05/2018	UP <i>Single</i>	50	720	94%
22	3/05/2018	UP <i>Single</i>	0	770	100%
23	4/05/2018	UP <i>Single</i>	0	690	90%
24	7/05/2018	UP <i>Double</i>	0	770	100%
25	8/05/2018	UP <i>Double</i>	0	770	100%
26	9/05/2018	UP <i>Double</i>	0	770	100%
27	11/05/2018	UP <i>Double</i>	0	690	90%
28	14/05/2018	UP <i>Double</i>	0	770	100%
29	17/05/2018	UP <i>Double</i>	0	770	100%
30	18/05/2018	UP <i>Single</i>	0	690	90%
31	21/05/2018	UP <i>Single</i>	0	770	100%
32	22/05/2018	UP <i>Single</i>	0	770	100%
33	23/05/2018	UP <i>Single</i>	0	770	100%

<b>Mesin Kobayashi 1</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Total Downtime</b>	<b>Operation Time (menit)</b>	<b>Availability</b>
34	24/05/2018	UP <i>Single</i>	0	770	100%
35	25/05/2018	UP <i>Double</i>	0	690	90%
36	28/05/2018	UP <i>Double</i>	0	770	100%
37	30/05/2018	UP <i>Double</i>	0	770	100%
Rata-rata					95%

<b>Mesin Kobayashi 2</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Total Downtime (menit)</b>	<b>Operation Time (menit)</b>	<b>Availability</b>
1	2/04/2018	UP <i>Double</i>	0	770	100%
2	3/04/2018	UP <i>Double</i>	0	770	100%
3	4/04/2018	UP <i>Double</i>	0	770	100%
4	5/04/2018	UP <i>Double</i>	0	770	100%
5	6/04/2018	UP <i>Double</i>	0	690	90%
6	9/04/2018	UP <i>Double</i>	0	770	100%
7	10/04/2018	UP <i>Double</i>	0	770	100%
8	11/04/2018	UP <i>Double</i>	0	770	100%
9	12/04/2018	UP <i>Double</i>	0	770	100%
10	13/04/2018	UP <i>Double</i>	200	490	64%
11	16/04/2018	UP <i>Double</i>	60	710	92%
12	17/04/2018	UP <i>Double</i>	0	770	100%
13	18/04/2018	UP <i>Double</i>	0	770	100%
14	19/04/2018	UP <i>Double</i>	770	0	0%
15	20/04/2018	UP <i>Double</i>	190	500	65%
16	23/04/2018	UP <i>Double</i>	0	770	100%
17	24/04/2018	UP <i>Double</i>	0	770	100%
18	25/04/2018	UP <i>Double</i>	0	770	100%
19	26/04/2018	UP <i>Double</i>	0	770	100%
20	27/04/2018	UP <i>Double</i>	0	690	90%
21	2/05/2018	UP <i>Single</i>	50	720	94%
22	3/05/2018	UP <i>Single</i>	0	770	100%
23	4/05/2018	UP <i>Single</i>	0	690	90%
24	7/05/2018	UP <i>Double</i>	0	770	100%
25	8/05/2018	UP <i>Double</i>	0	770	100%
26	9/05/2018	UP <i>Double</i>	0	770	100%
27	11/05/2018	UP <i>Double</i>	0	690	90%
28	14/05/2018	UP <i>Double</i>	0	770	100%

<b>Mesin Kobayashi 2</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Total Downtime (menit)</b>	<b>Operation Time (menit)</b>	<b>Availability</b>
29	17/05/2018	UP <i>Double</i>	440	330	43%
30	18/05/2018	UP <i>Single</i>	0	690	90%
31	21/05/2018	UP <i>Single</i>	0	770	100%
32	22/05/2018	UP <i>Single</i>	0	770	100%
33	23/05/2018	UP <i>Single</i>	0	770	100%
34	24/05/2018	UP <i>Single</i>	0	770	100%
35	25/05/2018	UP <i>Double</i>	0	690	90%
36	28/05/2018	UP <i>Double</i>	0	770	100%
37	30/05/2018	UP <i>Double</i>	0	770	100%
Rata-rata					92%

<b>Mesin Liencheh</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Total Downtime</b>	<b>Operation Time (menit)</b>	<b>Availability</b>
1	2/4/2018	<i>Fall back</i> YU5	0	770	100%
2	3/4/2018	<i>Fall back</i> YU5	0	770	100%
3	4/4/2018	<i>Fall back</i> YU5	0	770	100%
4	5/4/2018	<i>Fall back</i> YU5	0	770	100%
5	6/4/2018	<i>Fall back</i> YU5	150	540	70%
6	9/4/2018	<i>Fall back</i> YU5	20	750	97%
7	10/4/2018	<i>Fall back</i> YU5	0	770	100%
8	11/4/2018	<i>Fall back</i> YU5	0	770	100%
9	12/4/2018	<i>Fall back</i> YU5	0	770	100%
10	13/04/2018	<i>Fall back</i> YU5	200	490	64%
11	16/04/2018	<i>Fall back</i> U1J	140	630	82%
12	17/04/2018	<i>Fall back</i> U1J	320	450	58%
13	18/04/2018	<i>Fall back</i> U1J	0	770	100%
14	19/04/2018	<i>Fall back</i> U1J	0	770	100%
15	20/04/2018	<i>Fall back</i> U1J	200	490	64%
16	23/04/2018	<i>Fall back</i> YU5	0	770	100%
17	24/04/2018	<i>Fall back</i> YU5	0	770	100%
18	25/04/2018	<i>Fall back</i> YU5	0	770	100%
19	26/04/2018	<i>Fall back</i> YU5	0	770	100%
20	27/04/2018	<i>Fall back</i> YU5	0	690	90%
21	2/5/2018	<i>Fall back</i> YU5	50	720	94%
22	3/5/2018	<i>Fall back</i> YU5	0	770	100%

<b>Mesin Liencheh</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Total Downtime</b>	<b>Operation Time (menit)</b>	<b>Availability</b>
23	4/5/2018	<i>Fall board</i> GB	0	690	90%
24	7/5/2018	<i>Fall board</i> GB	0	770	100%
25	8/5/2018	<i>Fall board</i> GB	0	770	100%
26	9/5/2018	<i>Fall board</i> GB	0	770	100%
27	11/5/2018	<i>Fall board</i> GB	0	690	90%
28	14/5/2018	<i>Fall board</i> GB	0	770	100%
29	17/5/2018	<i>Fall back</i> YU5	0	770	100%
30	18/5/2018	<i>Fall back</i> YU5	0	690	90%
31	21/5/2018	<i>Fall back</i> YU5	0	770	100%
32	22/5/2018	<i>Fall back</i> YU5	0	770	100%
33	23/5/2018	<i>Fall back</i> YU5	0	770	100%
34	24/5/2018	<i>Fall back</i> YU5	0	770	100%
35	25/5/2018	<i>Fall back</i> YU5	0	690	90%
36	28/5/2018	<i>Fall back</i> YU5	600	170	22%
37	30/5/2018	<i>Fall back</i> YU5	190	580	75%
<b>Rata-rata</b>					<b>91%</b>

**B- Data Perhitungan *Performance rate***

<b>Mesin Kobayashi 1 bulan April mei 2018</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b><i>Processed Amount (Pcs)</i></b>	<b><i>Cycle Time (Menit/Pcs)</i></b>	<b><i>Operation Time</i></b>	<b><i>Performance Rate (%)</i></b>
1	2/4/2018	UP Double	152	3.01	640	72%
2	3/4/2018	UP Double	92	3.01	340	82%
3	4/4/2018	UP Double	236	3.01	770	92%
4	5/4/2018	UP Double	216	3.01	690	94%
5	6/4/2018	UP Double	236	3.01	690	103%
6	9/4/2018	UP Double	260	3.01	770	102%
7	10/4/2018	UP Double	264	3.01	770	103%
8	11/4/2018	UP Double	272	3.01	770	106%
9	12/4/2018	UP Double	280	3.01	770	110%
10	13/04/2018	UP Double	212	3.01	490	130%
11	16/04/2018	UP Double	268	3.01	710	114%
12	17/04/2018	UP Double	270	3.01	770	106%
13	18/04/2018	UP Double	284	3.01	770	111%
14	19/04/2018	UP Double	284	3.01	500	171%
15	20/04/2018	UP Double	264	3.01	690	115%
16	23/04/2018	UP Double	280	3.01	770	110%
17	24/04/2018	UP Double	284	3.01	770	111%
18	25/04/2018	UP Double	280	3.01	770	110%
19	26/04/2018	UP Double	280	3.01	770	110%
20	27/04/2018	UP Double	240	3.01	690	105%
21	2/5/2018	UP Single	134	5.77	720	107%
22	3/5/2018	UP Single	139	5.77	770	104%
23	4/5/2018	UP Single	126	5.77	690	105%
24	7/5/2018	UP Double	172	3.01	770	67%
25	8/5/2018	UP Double	140	3.01	770	55%
26	9/5/2018	UP Double	250	3.01	770	98%
27	11/5/2018	UP Double	278	3.01	690	121%
28	14/5/2018	UP Double	254	3.01	770	99%
29	17/5/2018	UP Double	50	3.01	330	46%
30	18/5/2018	UP Single	100	5.77	690	84%
31	21/5/2018	UP Single	73	5.77	770	55%
32	22/5/2018	UP Single	116	5.77	770	87%
33	23/5/2018	UP Single	136	5.77	770	102%
34	24/5/2018	UP Single	142	5.77	770	106%
35	25/5/2018	UP Double	164	3.01	690	72%
36	28/5/2018	UP Double	268	3.01	660	122%
37	30/5/2018	UP Double	284	3.01	770	111%

<b>Mesin Kobayashi 1 bulan April mei 2018</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processed Amount (Pcs)</b>	<b>Cycle Time (Menit/Pcs)</b>	<b>Operation Time</b>	<b>Performance Rate (%)</b>
Rata-rata						100%

<b>Mesin Kobayashi 2 bulan April dan mei 2018</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processed Amount (Pcs)</b>	<b>Cycle Time (Menit/Pcs)</b>	<b>Operation Time</b>	<b>Performance Rate (%)</b>
1	2/4/2018	UP Single	72	5.77	640	65%
2	3/4/2018	UP Single	18	5.77	525	20%
3	4/4/2018	UP Single	56	5.77	770	42%
4	5/4/2018	UP Single	107	5.77	770	80%
5	6/4/2018	UP Single	84	5.77	690	70%
6	9/4/2018	GB	109	4.77	580	90%
7	10/4/2018	GB	122	4.77	770	76%
8	11/4/2018	GB	130	4.77	770	80%
9	12/4/2018	GB	144	4.77	770	89%
10	13/04/2018	GB	106	4.77	490	103%
11	16/04/2018	GB	128	4.77	710	86%
12	17/04/2018	GB	57	4.77	190	143%
13	18/04/2018	GB	133	4.77	770	82%
14	19/04/2018	GB	0	4.77	0	0%
15	20/04/2018	UP Single	127	5.77	500	146%
16	23/04/2018	UP Single	140	5.77	770	105%
17	24/04/2018	UP Single	144	5.77	770	108%
18	25/04/2018	UP Single	130	5.77	770	97%
19	26/04/2018	UP Single	113	5.77	770	85%
20	27/04/2018	UP Single	112	5.77	690	94%
21	2/5/2018	UP Double	276	3.01	720	116%
22	3/5/2018	UP Double	288	3.01	770	113%
23	4/5/2018	UP Double	268	3.01	690	117%
24	7/5/2018	UP Double	280	3.01	770	110%
25	8/5/2018	UP Double	260	3.01	770	102%
26	9/5/2018	UP Double	250	3.01	770	98%
27	11/5/2018	UP Double	278	3.01	690	121%
28	14/5/2018	UP Double	254	3.01	770	99%
29	17/5/2018	GP	150	4.77	770	93%
30	18/5/2018	GP	120	4.77	690	83%
31	21/5/2018	GP	120	4.77	770	74%
32	22/5/2018	GP	82	4.77	770	51%

<b>Mesin Kobayashi 2 bulan April dan mei 2018</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processed Amount (Pcs)</b>	<b>Cycle Time (Menit/Pcs)</b>	<b>Operation Time</b>	<b>Performance Rate (%)</b>
33	23/5/2018	GP	142	4.77	770	88%
34	24/5/2018	GP	144	4.77	770	89%
35	25/5/2018	GP	54	4.77	600	43%
36	28/5/2018	GP	156	4.77	770	97%
37	30/5/2018	GP	122	4.77	770	76%
<b>Rata-rata</b>						<b>87%</b>

<b>Mesin Liencheh bulan April 2018</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processed Amount (Pcs)</b>	<b>Cycle Time (Menit/Pcs)</b>	<b>Operation Time</b>	<b>Performance Rate (%)</b>
1	2/4/2018	F. Back YU5	80	4.99	640	62%
2	3/4/2018	F. Back YU5	100	4.99	410	122%
3	4/4/2018	F. Back YU5	80	4.99	770	52%
4	5/4/2018	F. Back YU5	84	4.99	710	59%
5	6/4/2018	F. Back YU5	34	4.99	180	94%
6	9/4/2018	F. Back YU5	140	4.99	750	93%
7	10/4/2018	F. Back YU5	130	4.99	770	84%
8	11/4/2018	F. Back YU5	130	4.99	770	84%
9	12/4/2018	F. Back YU5	144	4.99	770	93%
10	13/04/2018	F. Back YU5	106	4.99	490	108%
11	16/04/2018	F. Back U1J	98	4.99	630	78%
12	17/04/2018	F. Back U1J	113	4.99	450	125%
13	18/04/2018	F. Back U1J	100	4.99	770	65%
14	19/04/2018	F. Back U1J	139	4.99	770	0%
15	20/04/2018	F. Back U1J	30	4.99	490	31%
16	23/04/2018	F. Back YU5	150	4.99	770	97%
17	24/04/2018	F. Back YU5	150	4.99	770	97%
18	25/04/2018	F. Back YU5	154	4.99	770	100%
19	26/04/2018	F. Back YU5	138	4.99	770	89%
20	27/04/2018	F. Back YU5	110	4.99	690	80%
21	2/5/2018	<i>Fall back</i> YU5	124	4.99	720	86%
22	3/5/2018	<i>Fall back</i> YU5	150	4.99	770	97%
23	4/5/2018	<i>Fall board</i> GB	86	4.77	690	59%

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**Mesin Liencheh bulan April 2018**


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<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processed Amount (Pcs)</b>	<b>Cycle Time (Menit/Pcs)</b>	<b>Operation Time</b>	<b>Performance Rate (%)</b>
24	7/5/2018	<i>Fall board</i> GB	110	4.77	770	68%
25	8/5/2018	<i>Fall board</i> GB	122	4.77	770	76%
26	9/5/2018	<i>Fall board</i> GB	126	4.77	770	78%
27	11/5/2018	<i>Fall board</i> GB	96	4.77	690	66%
28	14/5/2018	<i>Fall board</i> GB	104	4.77	770	64%
29	17/5/2018	<i>Fall back</i> YU5	130	4.99	770	84%
30	18/5/2018	<i>Fall back</i> YU5	122	4.99	690	88%
31	21/5/2018	<i>Fall back</i> YU5	148	4.99	770	96%
32	22/5/2018	<i>Fall back</i> YU5	146	4.99	770	95%
33	23/5/2018	<i>Fall back</i> YU5	84	4.99	770	54%
34	24/5/2018	<i>Fall back</i> YU5	86	4.99	770	56%
35	25/5/2018	<i>Fall back</i> YU5	126	4.99	690	91%
36	28/5/2018	<i>Fall back</i> YU5	36	4.99	770	23%
37	30/5/2018	<i>Fall back</i> YU5	112	4.99	770	73%
Rata-rata						78%

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**C- Data Perhitungan *Quality Rate***

<i>Quality rate Kobayashi 1</i>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<i>Processes</i>		<i>Not Good</i>	<i>Quality rate</i>
			<i>amount (hasil press)</i>	<i>Repair</i>		
1	2/04/2018	UP Double	152	3	4	95%
2	3/04/2018	UP Double	92	0	0	100%
3	4/04/2018	UP Double	236	26	17	82%
4	5/04/2018	UP Double	216	0	0	100%
5	6/04/2018	UP Double	236	34	15	79%
6	9/04/2018	UP Double	260	0	0	100%
7	10/04/2018	UP Double	264	27	11	86%
8	11/04/2018	UP Double	272	0	8	97%
9	12/04/2018	UP Double	280	0	0	100%
10	13/04/2018	UP Double	212	0	0	100%
11	16/04/2018	UP Double	268	0	17	94%
12	17/04/2018	UP Double	270	15	1	94%
13	18/04/2018	UP Double	284	15	23	87%
14	19/04/2018	UP Double	284	0	0	100%
15	20/04/2018	UP Double	264	5	5	96%
16	23/04/2018	UP Double	280	0	0	100%
17	24/04/2018	UP Double	284	14	15	90%
18	25/04/2018	UP Double	280	17	15	89%
19	26/04/2018	UP Double	280	11	1	96%
20	27/04/2018	UP Double	240	2	7	96%
21	2/05/2018	UP Double	134	16	11	80%
22	3/05/2018	UP Double	139	5	4	94%
23	4/05/2018	UP Double	126		3	98%
24	7/05/2018	UP Double	172		28	84%
25	8/05/2018	UP Double	140	30	41	49%
26	9/05/2018	UP Double	250	11	21	87%
27	11/05/2018	UP Double	278			100%
28	14/05/2018	UP Double	254	5	22	89%
29	17/05/2018	GB	50			100%
30	18/05/2018	GB	100	1		99%
31	21/05/2018	GB	73	4	3	90%
32	22/05/2018	GB	116			100%
33	23/05/2018	GB	136			100%
34	24/05/2018	GB	142			100%
35	25/05/2018	GB	164	1	2	98%
36	28/05/2018	GB	268			100%
37	30/05/2018	GB	284	2	7	97%

<b>Quality rate Kobayashi 1</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processes</b>		<b>Not Good</b>	<b>Quality rate</b>
			<b>amount (hasil press)</b>	<b>Repair</b>		
<b>Rata-Rata</b>						<b>93%</b>

<b>Quality Rate Kobayashi 2</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processes</b>		<b>Not Good</b>	<b>Quality Rate</b>
			<b>amount (hasil press)</b>	<b>Repair</b>		
1	2/04/2018	UP Single	72	0	0	100%
2	3/04/2018	UP Single	18	0	0	100%
3	4/04/2018	UP Single	56	0	0	100%
4	5/04/2018	UP Single	107	0	0	100%
5	6/04/2018	UP Single	84	0	0	100%
6	9/04/2018	GB	109	0	0	100%
7	10/04/2018	GB	122	0	0	100%
8	11/04/2018	GB	130	106	0	18%
9	12/04/2018	GB	144	72	5	47%
10	13/04/2018	GB	106	42	5	56%
11	16/04/2018	GB	128	0	0	100%
12	17/04/2018	GB	57	2	3	91%
13	18/04/2018	GB	133	7	0	95%
14	19/04/2018	GB	0	0	0	0%
15	20/04/2018	UP Single	127	0	0	100%
16	23/04/2018	UP Single	140	0	0	100%
17	24/04/2018	UP Single	144	0	0	100%
18	25/04/2018	UP Single	130	0	0	100%
19	26/04/2018	UP Single	113	0	0	100%
20	27/04/2018	UP Single	112	0	0	100%
21	2/05/2018	UP Single	276			100%
22	3/05/2018	UP Single	288		4	99%
23	4/05/2018	UP Single	268		2	99%
24	7/05/2018	UP Double	280		0	100%
25	8/05/2018	UP Double	260	30	41	73%
26	9/05/2018	UP Double	250	12	22	86%

<b>Quality Rate Kobayashi 2</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processes amount (hasil press)</b>	<b>Repair</b>	<b>Not Good</b>	<b>Quality Rate</b>
27	11/05/2018	UP Double	278			100%
28	14/05/2018	UP Double	254	5	23	89%
29	17/05/2018	UP Double	150			100%
30	18/05/2018	UP Single	120		6	95%
31	21/05/2018	UP Single	120			100%
32	22/05/2018	UP Single	82		1	99%
33	23/05/2018	UP Single	142			100%
34	24/05/2018	UP Single	144	1	2	98%
35	25/05/2018	UP Double	54			100%
36	28/05/2018	UP Double	156	1	17	88%
37	30/05/2018	UP Double	122		13	89%
<b>Rata-Rata</b>						<b>90%</b>

<b>Quality Rate Liencheh</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processes amount (hasil press)</b>	<b>Repair (Pcs)</b>	<b>Not Good (Pcs)</b>	<b>Quality Rate (%)</b>
1	2/4/2018	F. Back YU5	80	0	0	100%
2	3/4/2018	F. Back YU5	100	0	0	100%
3	4/4/2018	F. Back YU5	80	0	0	100%
4	5/4/2018	F. Back YU5	84	0	0	100%
5	6/4/2018	F. Back YU5	34	15	14	15%
6	9/4/2018	F. Back YU5	140	0	0	100%
7	10/4/2018	F. Back YU5	130	0	0	100%
8	11/4/2018	F. Back YU5	130	1	0	99%
9	12/4/2018	F. Back YU5	144	0	5	97%
10	13/04/2018	F. Back YU5	106	2	0	98%
11	16/04/2018	F. Back U1J	98	0	0	100%
12	17/04/2018	F. Back U1J	113	0	0	100%
13	18/04/2018	F. Back U1J	100	0	0	100%
14	19/04/2018	F. Back U1J	139	0	0	100%

<b>Quality Rate Liencheh</b>						
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Processes amount (hasil press)</b>	<b>Repair (Pcs)</b>	<b>Not Good (Pcs)</b>	<b>Quality Rate (%)</b>
15	20/04/2018	F. Back UIJ	30	18	0	40%
16	23/04/2018	F. Back YU5	150	4	2	96%
17	24/04/2018	F. Back YU5	150	0	0	100%
18	25/04/2018	F. Back YU5	154	0	0	100%
19	26/04/2018	F. Back YU5	138	0	0	100%
20	27/04/2018	F. Back YU5	110	1	11	89%
21	2/05/2018	<i>Fall back</i> YU5	124			100%
22	3/05/2018	<i>Fall back</i> YU5	150	10	18	81%
23	4/05/2018	<i>Fall board</i> GB	86			100%
24	7/05/2018	<i>Fall board</i> GB	110	4	13	85%
25	8/05/2018	<i>Fall board</i> GB	122	6	1	94%
26	9/05/2018	<i>Fall board</i> GB	126			100%
27	11/05/2018	<i>Fall board</i> GB	96			100%
28	14/05/2018	<i>Fall board</i> GB	104		10	90%
29	17/05/2018	<i>Fall back</i> YU5	130			100%
30	18/05/2018	<i>Fall back</i> YU5	122		3	98%
31	21/05/2018	<i>Fall back</i> YU5	148	4	18	85%
32	22/05/2018	<i>Fall back</i> YU5	146			100%
33	23/05/2018	<i>Fall back</i> YU5	84			100%
34	24/05/2018	<i>Fall back</i> YU5	86			100%
35	25/05/2018	<i>Fall back</i> YU5	126			100%
36	28/05/2018	<i>Fall back</i> YU5	36			100%
37	30/05/2018	<i>Fall back</i> YU5	112			100%
<b>Rata-Rata</b>						<b>94%</b>

**D- Data perhitungan *Downtime Loss***

<i>Kobayashi 1</i>				
<b>No</b>	<b>Tanggal</b>	<b><i>Downtime</i> (Menit)</b>	<b><i>Loading Time</i> (Menit)</b>	<b><i>Downtime Loss</i></b>
1	2/04/2018	0	790	0%
2	3/04/2018	0	790	0%
3	4/04/2018	0	790	0%
4	5/04/2018	80	790	10%
5	6/04/2018	0	790	0%
6	9/04/2018	0	790	0%
7	10/04/2018	0	790	0%
8	11/04/2018	0	790	0%
9	12/04/2018	0	790	0%
10	13/04/2018	180	790	23%
11	16/04/2018	60	790	8%
12	17/04/2018	0	790	0%
13	18/04/2018	0	790	0%
14	19/04/2018	270	790	34%
15	20/04/2018	0	790	0%
16	23/04/2018	0	790	0%
17	24/04/2018	0	790	0%
18	25/04/2018	0	790	0%
19	26/04/2018	0	790	0%
20	27/04/2018	0	790	0%
21	2/05/2018	0	790	0%
22	3/05/2018	0	790	0%
23	4/05/2018	0	790	0%
24	7/05/2018	0	790	0%
25	8/05/2018	0	790	0%
26	9/05/2018	0	790	0%
27	11/05/2018	0	790	0%
28	14/05/2018	0	790	0%
29	17/05/2018	440	790	56%
30	18/05/2018	0	790	0%
31	21/05/2018	0	790	0%
32	22/05/2018	0	790	0%
33	23/05/2018	0	790	0%
34	24/05/2018	0	790	0%
35	25/05/2018	0	790	0%
36	28/05/2018	0	790	0%
37	30/05/2018	0	790	0%

		<b>Rata-rata</b>			<b>4%</b>
<hr/>					
<i>Kobayashi 2</i>					
<b>No</b>	<b>Tanggal</b>	<b>Downtime (Menit)</b>	<b>Loading Time (Menit)</b>	<b>Downtime Loss</b>	
<hr/>					
1	2/04/2018	0	790	0%	
2	3/04/2018	0	790	0%	
3	4/04/2018	0	790	0%	
4	5/04/2018	0	790	0%	
5	6/04/2018	0	790	0%	
6	9/04/2018	0	790	0%	
7	10/04/2018	0	790	0%	
8	11/04/2018	0	790	0%	
9	12/04/2018	0	790	0%	
10	13/04/2018	180	790	23%	
11	16/04/2018	60	790	8%	
12	17/04/2018	0	790	0%	
13	18/04/2018	0	790	0%	
14	19/04/2018	0	790	0%	
15	20/04/2018	0	790	0%	
16	23/04/2018	0	790	0%	
17	24/04/2018	0	790	0%	
18	25/04/2018	0	790	0%	
19	26/04/2018	0	790	0%	
20	27/04/2018	0	790	0%	
21	2/05/2018	0	790	0%	
22	3/05/2018	0	790	0%	
23	4/05/2018	0	790	0%	
24	7/05/2018	0	790	0%	
25	8/05/2018	0	790	0%	
26	9/05/2018	0	790	0%	
27	11/05/2018	0	790	0%	
28	14/05/2018	0	790	0%	
29	17/05/2018	0	790	0%	
30	18/05/2018	0	790	0%	
31	21/05/2018	0	790	0%	
32	22/05/2018	0	790	0%	
33	23/05/2018	0	790	0%	
34	24/05/2018	0	790	0%	
35	25/05/2018	0	790	0%	

36	28/05/2018	0	790	0%
37	30/05/2018	0	790	0%
<hr/>				
Rata-rata				1%
<hr/>				

<i>Liencheh</i>				
<b>No</b>	<b>Tanggal</b>	<b>Downtime (Menit)</b>	<b>Loading Time (Menit)</b>	<b>Downtime Loss</b>
1	2/04/2018	0	790	0%
2	3/04/2018	0	790	0%
3	4/04/2018	0	790	0%
4	5/04/2018	0	790	0%
5	6/04/2018	0	790	0%
6	9/04/2018	20	790	3%
7	10/04/2018	0	790	0%
8	11/04/2018	0	790	0%
9	12/04/2018	0	790	0%
10	13/04/2018	180	790	23%
11	16/04/2018	0	790	0%
12	17/04/2018	0	790	0%
13	18/04/2018	0	790	0%
14	19/04/2018	0	790	0%
15	20/04/2018	0	790	0%
16	23/04/2018	0	790	0%
17	24/04/2018	0	790	0%
18	25/04/2018	0	790	0%
19	26/04/2018	0	790	0%
20	27/04/2018	0	790	0%
21	2/05/2018	50	790	6%
22	3/05/2018	0	790	0%
23	4/05/2018	0	790	0%
24	7/05/2018	0	790	0%
25	8/05/2018	0	790	0%
26	9/05/2018	0	790	0%
27	11/05/2018	0	790	0%
28	14/05/2018	0	790	0%
29	17/05/2018	0	790	0%
30	18/05/2018	0	790	0%
31	21/05/2018	0	790	0%
32	22/05/2018	0	790	0%
33	23/05/2018	0	790	0%
34	24/05/2018	0	790	0%
35	25/05/2018	0	790	0%
36	28/05/2018	0	790	0%
37	30/05/2018	0	790	0%
Rata-rata				1%



**E- Data Perhitungan *Set Up and Adjustment***

<i>Kobayashi 1</i>				
<b>No</b>	<b>Tanggal</b>	<b><i>Set Up Time</i> (Menit)</b>	<b><i>Loading Time</i> (Menit)</b>	<b><i>Set Up Loss</i></b>
1	2/04/2018	0	790	0%
2	3/04/2018	0	790	0%
3	4/04/2018	0	790	0%
4	5/04/2018	0	790	0%
5	6/04/2018	0	790	0%
6	9/04/2018	0	790	0%
7	10/04/2018	0	790	0%
8	11/04/2018	0	790	0%
9	12/04/2018	0	790	0%
10	13/04/2018	20	790	3%
11	16/04/2018	0	790	0%
12	17/04/2018	0	790	0%
13	18/04/2018	0	790	0%
14	19/04/2018	0	790	0%
15	20/04/2018	0	790	0%
16	23/04/2018	0	790	0%
17	24/04/2018	0	790	0%
18	25/04/2018	0	790	0%
19	26/04/2018	0	790	0%
20	27/04/2018	0	790	0%
21	2/05/2018	50	790	6%
22	3/05/2018	0	790	0%
23	4/05/2018	0	790	0%
24	7/05/2018	0	790	0%
25	8/05/2018	0	790	0%
26	9/05/2018	0	790	0%
27	11/05/2018	0	790	0%
28	14/05/2018	0	790	0%
29	17/05/2018	0	790	0%
30	18/05/2018	0	790	0%
31	21/05/2018	0	790	0%
32	22/05/2018	0	790	0%
33	23/05/2018	0	790	0%
34	24/05/2018	0	790	0%
35	25/05/2018	0	790	0%
36	28/05/2018	0	790	0%
37	30/05/2018	0	790	0%

Rata-rata	0%
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<i>Kobayashi 2</i>				
No	Tanggal	<i>Set Up Time</i> (Menit)	<i>Loading Time</i> (Menit)	<i>Set Up Loss</i>
1	2/04/2018	0	790	0%
2	3/04/2018	0	790	0%
3	4/04/2018	0	790	0%
4	5/04/2018	0	790	0%
5	6/04/2018	0	790	0%
6	9/04/2018	0	790	0%
7	10/04/2018	0	790	0%
8	11/04/2018	0	790	0%
9	12/04/2018	0	790	0%
10	13/04/2018	20	790	3%
11	16/04/2018	0	790	0%
12	17/04/2018	0	790	0%
13	18/04/2018	0	790	0%
14	19/04/2018	770	790	97%
15	20/04/2018	190	790	24%
16	23/04/2018	0	790	0%
17	24/04/2018	0	790	0%
18	25/04/2018	0	790	0%
19	26/04/2018	0	790	0%
20	27/04/2018	0	790	0%
21	2/05/2018	50	790	6%
22	3/05/2018	0	790	0%
23	4/05/2018	0	790	0%
24	7/05/2018	0	790	0%
25	8/05/2018	0	790	0%
26	9/05/2018	0	790	0%
27	11/05/2018	0	790	0%
28	14/05/2018	0	790	0%
29	17/05/2018	0	790	0%
30	18/05/2018	0	790	0%
31	21/05/2018	0	790	0%
32	22/05/2018	0	790	0%
33	23/05/2018	0	790	0%
34	24/05/2018	0	790	0%
35	25/05/2018	0	790	0%
36	28/05/2018	0	790	0%

37	30/05/2018	0	790	0%
<b>Rata-rata</b>				<b>4%</b>

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*Liencheh*

No	Tanggal	Set Up Time (Menit)	Loading Time (Menit)	Set Up Loss
1	2/04/2018	0	790	0%
2	3/04/2018	0	790	0%
3	4/04/2018	0	790	0%
4	5/04/2018	0	790	0%
5	6/04/2018	150	790	19%
6	9/04/2018	0	790	0%
7	10/04/2018	0	790	0%
8	11/04/2018	0	790	0%
9	12/04/2018	0	790	0%
10	13/04/2018	20	790	3%
11	16/04/2018	140	790	18%
12	17/04/2018	320	790	41%
13	18/04/2018	0	790	0%
14	19/04/2018	0	790	0%
15	20/04/2018	200	790	25%
16	23/04/2018	0	790	0%
17	24/04/2018	0	790	0%
18	25/04/2018	0	790	0%
19	26/04/2018	0	790	0%
20	27/04/2018	0	790	0%
21	2/05/2018	0	790	0%
22	3/05/2018	0	790	0%
23	4/05/2018	0	790	0%
24	7/05/2018	0	790	0%
25	8/05/2018	0	790	0%
26	9/05/2018	0	790	0%
27	11/05/2018	0	790	0%
28	14/05/2018	0	790	0%
29	17/05/2018	0	790	0%
30	18/05/2018	0	790	0%
31	21/05/2018	0	790	0%
32	22/05/2018	0	790	0%
33	23/05/2018	0	790	0%
34	24/05/2018	0	790	0%
35	25/05/2018	0	790	0%

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*Liencheh*

<b>No</b>	<b>Tanggal</b>	<b><i>Set Up Time</i> (Menit)</b>	<b><i>Loading Time</i> (Menit)</b>	<b><i>Set Up Loss</i></b>
36	28/05/2018	600	790	76%
37	30/05/2018	190	790	24%
<b>Rata-rata</b>				<b>6%</b>

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**F- Data Perhitungan Reduce Speed Loss**

<i>Kobayashi 1</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operati on Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/ Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
1	2/04/2018	770	UP <i>Double</i>	152	3.01	770	458.09	311.91	41%
2	3/04/2018	770	UP <i>Double</i>	92	3.01	770	277.26	492.74	64%
3	4/04/2018	770	UP <i>Double</i>	236	3.01	770	711.24	58.76	8%
4	5/04/2018	690	UP <i>Double</i>	216	3.01	770	650.97	39.03	5%
5	6/04/2018	690	UP <i>Double</i>	236	3.01	690	711.24	-21.24	-3%
6	9/04/2018	770	UP <i>Double</i>	260	3.01	770	783.57	-13.57	-2%
7	10/04/2018	770	UP <i>Double</i>	264	3.01	770	795.63	-25.63	-3%
8	11/04/2018	770	UP <i>Double</i>	272	3.01	770	819.74	-49.74	-6%
9	12/04/2018	770	UP <i>Double</i>	280	3.01	770	843.85	-73.85	-10%
10	13/04/2018	490	UP <i>Double</i>	212	3.01	690	638.91	-148.91	-22%

<i>Kobayashi 1</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operati on Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/ Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
11	16/04/2018	710	UP <i>Double</i>	268	3.01	770	807.68	-97.68	-13%
12	17/04/2018	770	UP <i>Double</i>	270	3.01	770	813.71	-43.71	-6%
13	18/04/2018	770	UP <i>Double</i>	284	3.01	770	855.90	-85.90	-11%
14	19/04/2018	500	UP <i>Double</i>	284	3.01	770	855.90	-355.90	-46%
15	20/04/2018	690	UP <i>Double</i>	264	3.01	690	795.63	-105.63	-15%
16	23/04/2018	770	UP <i>Double</i>	280	3.01	770	843.85	-73.85	-10%
17	24/04/2018	770	UP <i>Double</i>	284	3.01	770	855.90	-85.90	-11%
18	25/04/2018	770	UP <i>Double</i>	280	3.01	770	843.85	-73.85	-10%
19	26/04/2018	770	UP <i>Double</i>	280	3.01	770	843.85	-73.85	-10%
20	27/04/2018	690	UP <i>Double</i>	240	3.01	690	723.30	-33.30	-5%
21	2/05/2018	720	UP <i>Single</i>	134	5.77	770	772.82	-52.82	-7%

<i>Kobayashi 1</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operati on Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/ Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
22	3/05/2018	770	UP Single	139	5.77	770	801.66	-31.66	-4%
23	4/05/2018	690	UP Single	126	5.77	690	726.68	-36.68	-5%
24	7/05/2018	770	UP Double	172	3.01	770	518.36	251.64	33%
25	8/05/2018	770	UP Double	140	3.01	770	421.92	348.08	45%
26	9/05/2018	770	UP Double	250	3.01	770	753.43	16.57	2%
27	11/05/2018	690	UP Double	278	3.01	690	837.82	-147.82	-21%
28	14/05/2018	770	UP Double	254	3.01	770	765.49	4.51	1%
29	17/05/2018	770	UP Double	50	3.01	770	150.69	619.31	80%
30	18/05/2018	690	UP Single	100	5.77	690	576.73	113.27	16%
31	21/05/2018	770	UP Single	73	5.77	770	421.01	348.99	45%
32	22/05/2018	770	UP Single	116	5.77	770	669.01	100.99	13%

<i>Kobayashi 1</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operati on Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/ Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
33	23/05/2018	770	UP Single	136	5.77	770	784.35	-14.35	-2%
34	24/05/2018	770	UP Single	142	5.77	770	818.96	-48.96	-6%
35	25/05/2018	690	UP Double	164	3.01	690	494.25	195.75	28%
36	28/05/2018	770	UP Double	268	3.01	770	807.68	-37.68	-5%
37	30/05/2018	770	UP Double	284	3.01	770	855.90	-85.90	-11%
<b>Rata-rata</b>									<b>4%</b>

<i>Kobayashi 2</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit /Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
1	2/04/2018	640	UP Single	72	5.77	770	415.25	224.75	29%



<i>Kobayashi 2</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit /Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
2	3/04/2018	525	UP Single	18	5.77	770	103.81	421.19	55%
3	4/04/2018	770	UP Single	56	5.77	770	322.97	447.03	58%
4	5/04/2018	770	UP Single	107	5.77	770	617.10	152.90	20%
5	6/04/2018	690	UP Single	84	5.77	690	484.45	205.55	30%
6	9/04/2018	580	GB	109	4.77	770	519.64	60.36	8%
7	10/04/2018	770	GB	122	4.77	770	581.61	188.39	24%
8	11/04/2018	770	GB	130	4.77	770	619.75	150.25	20%
9	12/04/2018	770	GB	144	4.77	770	686.49	83.51	11%
10	13/04/2018	490	GB	106	4.77	690	505.33	-15.33	-2%
11	16/04/2018	710	GB	128	4.77	770	610.22	99.78	13%
12	17/04/2018	190	GB	57	4.77	770	271.74	-81.74	-11%
13	18/04/2018	770	GB	133	4.77	770	634.05	135.95	18%
14	19/04/2018	0	GB	0	4.77	770	0.00	0.00	0%
15	20/04/2018	500	UP Single	127	5.77	690	732.45	-232.45	-34%
16	23/04/2018	770	UP Single	140	5.77	770	807.42	-37.42	-5%

<i>Kobayashi 2</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit /Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
17	24/04/2018	770	UP <i>Single</i>	144	5.77	770	830.49	-60.49	-8%
18	25/04/2018	770	UP <i>Single</i>	130	5.77	770	749.75	20.25	3%
19	26/04/2018	770	UP <i>Single</i>	113	5.77	770	651.71	118.29	15%
20	27/04/2018	690	UP <i>Single</i>	112	5.77	690	645.94	44.06	6%
21	2/05/2018	720	UP <i>Double</i>	276	3.01	770	831.79	-111.79	-15%
22	3/05/2018	770	UP <i>Double</i>	288	3.01	770	867.96	-97.96	-13%
23	4/05/2018	690	UP <i>Double</i>	268	3.01	690	807.68	-117.68	-17%
24	7/05/2018	770	UP <i>Double</i>	280	3.01	770	843.85	-73.85	-10%
25	8/05/2018	770	UP <i>Double</i>	260	3.01	770	783.57	-13.57	-2%
26	9/05/2018	770	UP <i>Double</i>	250	3.01	770	753.43	16.57	2%
27	11/05/2018	690	UP <i>Double</i>	278	3.01	690	837.82	-147.82	-21%

<i>Kobayashi 2</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit /Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
			UP						
28	14/05/2018	770	Double	254	3.01	770	765.49	4.51	1%
29	17/05/2018	770	GP	150	3.01	770	452.06	317.94	41%
30	18/05/2018	690	GP	120	5.77	690	692.08	-2.08	0%
31	21/05/2018	770	GP	120	5.77	770	692.08	77.92	10%
32	22/05/2018	770	GP	82	5.77	770	472.92	297.08	39%
33	23/05/2018	770	GP	142	5.77	770	818.96	-48.96	-6%
34	24/05/2018	770	GP	144	5.77	770	830.49	-60.49	-8%
35	25/05/2018	600	GP	54	5.77	690	311.43	288.57	42%
36	28/05/2018	770	GP	156	5.77	770	899.70	-129.70	-17%
37	30/05/2018	770	GP	122	5.77	770	703.61	66.39	9%
<b>Rata-rata</b>									<b>8%</b>

<i>Liencheh</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
1	2/04/2018	770	F. Back YU5	80	4.99	770	399.34	370.66	48%
2	3/04/2018	770	F. Back YU5	100	4.99	770	499.17	270.83	35%
3	4/04/2018	770	F. Back YU5	80	4.99	770	399.34	370.66	48%
4	5/04/2018	770	F. Back YU5	84	4.99	770	419.31	350.69	46%
5	6/04/2018	540	F. Back YU5	34	4.99	690	169.72	370.28	54%
6	9/04/2018	750	F. Back YU5	140	4.99	770	698.84	51.16	7%
7	10/04/2018	770	F. Back YU5	130	4.99	770	648.93	121.07	16%
8	11/04/2018	770	F. Back YU5	130	4.99	770	648.93	121.07	16%
9	12/04/2018	770	F. Back YU5	144	4.99	770	718.81	51.19	7%
10	13/04/2018	490	F. Back YU5	106	4.99	690	529.12	-39.12	-6%
11	16/04/2018	630	F. Back UIJ	98	4.99	770	489.19	140.81	18%

<i>Liencheh</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
12	17/04/2018	450	F. Back U1J	113	4.99	770	564.07	-114.07	-15%
13	18/04/2018	770	F. Back U1J	100	4.99	770	499.17	270.83	35%
14	19/04/2018	770	F. Back U1J	139	4.99	770	693.85	76.15	10%
15	20/04/2018	490	F. Back U1J	30	4.99	690	149.75	340.25	49%
16	23/04/2018	770	F. Back YU5	150	4.99	770	748.76	21.24	3%
17	24/04/2018	770	F. Back YU5	150	4.99	770	748.76	21.24	3%
18	25/04/2018	770	F. Back YU5	154	4.99	770	768.73	1.27	0%
19	26/04/2018	770	F. Back YU5	138	4.99	770	688.86	81.14	11%
20	27/04/2018	690	F. Back YU5	110	4.99	690	549.09	140.91	20%
21	2/05/2018	720	Fall back YU5	124	4.99	770	618.98	101.02	13%

<i>Liencheh</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
22	3/05/2018	770	<i>Fall back</i> YU5	150	4.99	770	748.76	21.24	3%
23	4/05/2018	690	<i>Fall board</i> GB	86	4.77	690	409.99	280.01	41%
24	7/05/2018	770	<i>Fall board</i> GB	110	4.77	770	524.40	245.60	32%
25	8/05/2018	770	<i>Fall board</i> GB	122	4.77	770	581.61	188.39	24%
26	9/05/2018	770	<i>Fall board</i> GB	126	4.77	770	600.68	169.32	22%
27	11/05/2018	690	<i>Fall board</i> GB	96	4.77	690	457.66	232.34	34%
28	14/05/2018	770	<i>Fall board</i> GB	104	4.77	770	495.80	274.20	36%

<i>Liencheh</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
29	17/05/2018	770	<i>Fall back</i> YU5	130	4.99	770	648.93	121.07	16%
30	18/05/2018	690	<i>Fall back</i> YU5	122	4.99	690	608.99	81.01	12%
31	21/05/2018	770	<i>Fall back</i> YU5	148	4.99	770	738.78	31.22	4%
32	22/05/2018	770	<i>Fall back</i> YU5	146	4.99	770	728.79	41.21	5%
33	23/05/2018	770	<i>Fall back</i> YU5	84	4.99	770	419.31	350.69	46%
34	24/05/2018	770	<i>Fall back</i> YU5	86	4.99	770	429.29	340.71	44%
35	25/05/2018	690	<i>Fall back</i> YU5	126	4.99	690	628.96	61.04	9%

<i>Liencheh</i>									
<b>No</b>	<b>Tanggal</b>	<b>Operation Time (menit)</b>	<b>Model</b>	<b>Total Product (Pcs)</b>	<b>Ideal Cycle Time (menit/ Pcs)</b>	<b>Loading Time (menit)</b>	<b>Ideal Production Time</b>	<b>Reduced Speed Time</b>	<b>Reduced Speed Loss</b>
36	28/05/2018	170	<i>Fall back</i> YU5	36	4.99	770	179.70	-9.70	-1%
37	30/05/2018	580	<i>Fall back</i> YU5	112	4.99	770	559.07	20.93	3%
<b>Rata-rata</b>								<b>20%</b>	



**G- Data Perhitungan *Idling and Minor Stoppages***

<i>Kobayashi 1</i>					
No	Tanggal	Model	<i>Loading time (Menit)</i>	<i>Nonproductive time (menit)</i>	<i>Idling and Minor Stoppages</i>
1	2/04/2018	UP Double	790	130	16%
2	3/04/2018	UP Double	790	430	54%
3	4/04/2018	UP Double	790	0	0%
4	5/04/2018	UP Double	790	0	0%
5	6/04/2018	UP Double	790	0	0%
6	9/04/2018	UP Double	790	0	0%
7	10/04/2018	UP Double	790	0	0%
8	11/04/2018	UP Double	790	0	0%
9	12/04/2018	UP Double	790	0	0%
10	13/04/2018	UP Double	790	0	0%
11	16/04/2018	UP Double	790	0	0%
12	17/04/2018	UP Double	790	0	0%
13	18/04/2018	UP Double	790	0	0%
14	19/04/2018	UP Double	790	0	0%
15	20/04/2018	UP Double	790	0	0%
16	23/04/2018	UP Double	790	0	0%
17	24/04/2018	UP Double	790	0	0%
18	25/04/2018	UP Double	790	0	0%
19	26/04/2018	UP Double	790	0	0%
20	27/04/2018	UP Double	790	0	0%
21	2/05/2018	UP Double	790	0	0%
22	3/05/2018	UP Double	790	0	0%
23	4/05/2018	UP Double	790	0	0%
24	7/05/2018	UP Double	790	0	0%
25	8/05/2018	UP Double	790	0	0%
26	9/05/2018	UP Double	790	0	0%
27	11/05/2018	UP Double	790	0	0%
28	14/05/2018	UP Double	790	0	0%
29	17/05/2018	GB	790	0	0%
30	18/05/2018	GB	790	0	0%
31	21/05/2018	GB	790	0	0%
32	22/05/2018	GB	790	0	0%
33	23/05/2018	GB	790	0	0%
34	24/05/2018	GB	790	0	0%
35	25/05/2018	GB	790	0	0%
36	28/05/2018	GB	790	110	14%
37	30/05/2018	GB	790	0	0%

<b>Kobayashi 1</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Loading time (Menit)</b>	<b>Nonproductive time (menit)</b>	<b>Idling and Minor Stoppages</b>
<b>Rata-rata</b>					<b>2%</b>
<b>Kobayashi 2</b>					
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Loading time (Menit)</b>	<b>Nonproductive time (menit)</b>	<b>Idling and Minor Stoppages</b>
1	2/4/2018	UP <i>Single</i>	790	130	16%
2	3/4/2018	UP <i>Single</i>	790	245	31%
3	4/4/2018	UP <i>Single</i>	790	0	0%
4	5/4/2018	UP <i>Single</i>	790	0	0%
5	6/4/2018	UP <i>Single</i>	790	0	0%
6	9/4/2018	GB	790	190	24%
7	10/4/2018	GB	790	0	0%
8	11/4/2018	GB	790	0	0%
9	12/4/2018	GB	790	0	0%
10	13/04/2018	GB	790	0	0%
11	16/04/2018	GB	790	0	0%
12	17/04/2018	GB	790	580	73%
13	18/04/2018	GB	790	0	0%
14	19/04/2018	GB	790	0	0%
15	20/04/2018	UP <i>Single</i>	790	0	0%
16	23/04/2018	UP <i>Single</i>	790	0	0%
17	24/04/2018	UP <i>Single</i>	790	0	0%
18	25/04/2018	UP <i>Single</i>	790	0	0%
19	26/04/2018	UP <i>Single</i>	790	0	0%
20	27/04/2018	UP <i>Single</i>	790	0	0%
21	2/5/2018	UP <i>Single</i>	790	0	0%
22	3/5/2018	UP <i>Single</i>	790	0	0%
23	4/5/2018	UP <i>Single</i>	790	0	0%
24	7/5/2018	UP <i>Double</i>	790	0	0%
25	8/5/2018	UP <i>Double</i>	790	0	0%
26	9/5/2018	UP <i>Double</i>	790	0	0%
27	11/5/2018	UP <i>Double</i>	790	0	0%
28	14/5/2018	UP <i>Double</i>	790	0	0%
29	17/5/2018	UP <i>Double</i>	790	0	0%
30	18/5/2018	UP <i>Single</i>	790	0	0%
31	21/5/2018	UP <i>Single</i>	790	0	0%
32	22/5/2018	UP <i>Single</i>	790	0	0%

33	23/5/2018	UP <i>Single</i>	790	0	0%
34	24/5/2018	UP <i>Single</i>	790	0	0%
35	25/5/2018	UP <i>Double</i>	790	90	11%
36	28/5/2018	UP <i>Double</i>	790	0	0%
37	30/5/2018	UP <i>Double</i>	790	0	0%
<b>Rata-rata</b>					<b>4%</b>

<i>Liencheh</i>					
No	Tanggal	Model	<i>Loading time (Menit)</i>	<i>Nonproductive time (menit)</i>	<i>Idling and Minor Stoppages</i>
1	2/04/2018	F. Back YU5	790	130	16%
2	3/04/2018	F. Back YU5	790	360	46%
3	4/04/2018	F. Back YU5	790	0	0%
4	5/04/2018	F. Back YU5	790	60	8%
5	6/04/2018	F. Back YU5	790	360	46%
6	9/04/2018	F. Back YU5	790	0	0%
7	10/04/2018	F. Back YU5	790	0	0%
8	11/04/2018	F. Back YU5	790	0	0%
9	12/04/2018	F. Back YU5	790	0	0%
10	13/04/2018	F. Back YU5	790	0	0%
11	16/04/2018	F. Back U1J	790	0	0%
12	17/04/2018	F. Back U1J	790	0	0%
13	18/04/2018	F. Back U1J	790	0	0%
14	19/04/2018	F. Back U1J	790	0	0%
15	20/04/2018	F. Back U1J	790	0	0%
16	23/04/2018	F. Back YU5	790	0	0%
17	24/04/2018	F. Back YU5	790	0	0%
18	25/04/2018	F. Back YU5	790	0	0%
19	26/04/2018	F. Back YU5	790	0	0%
20	27/04/2018	F. Back YU5	790	0	0%
21	2/05/2018	<i>Fall back</i> YU5	790	0	0%
22	3/05/2018	<i>Fall back</i> YU5	790	0	0%
23	4/05/2018	<i>Fall board</i> GB	790	0	0%
24	7/05/2018	<i>Fall board</i> GB	790	0	0%
25	8/05/2018	<i>Fall board</i> GB	790	0	0%
26	9/05/2018	<i>Fall board</i> GB	790	0	0%
27	11/05/2018	<i>Fall board</i> GB	790	0	0%
28	14/05/2018	<i>Fall board</i> GB	790	0	0%
29	17/05/2018	<i>Fall back</i> YU5	790	0	0%
30	18/05/2018	<i>Fall back</i> YU5	790	0	0%
31	21/05/2018	<i>Fall back</i> YU5	790	0	0%

32	22/05/2018	<i>Fall back YU5</i>	790	0	0%
33	23/05/2018	<i>Fall back YU5</i>	790	0	0%
34	24/05/2018	<i>Fall back YU5</i>	790	0	0%
35	25/05/2018	<i>Fall back YU5</i>	790	0	0%
36	28/05/2018	<i>Fall back YU5</i>	790	0	0%
37	30/05/2018	<i>Fall back YU5</i>	790	0	0%
<b>Rata-rata</b>					<b>3%</b>

**H- Data Perhitungan *Defect Loss***

<i>Kobayashi 1</i>							
No	Tanggal	Model	<i>Loading Time</i> (menit)	<i>Ideal Cycle Time</i> (Menit/Pcs)	<i>Defect</i>	<i>Defect Time</i>	<i>Defect Loss</i>
1	2/04/2018	UP Double	770	3.01	7	21.1	3%
2	3/04/2018	UP Double	770	3.01	0	0.0	0%
3	4/04/2018	UP Double	770	3.01	43	129.6	17%
4	5/04/2018	UP Double	770	3.01	0	0.0	0%
5	6/04/2018	UP Double	690	3.01	49	147.7	21%
6	9/04/2018	UP Double	770	3.01	0	0.0	0%
7	10/04/2018	UP Double	770	3.01	38	114.5	15%
8	11/04/2018	UP Double	770	3.01	8	24.1	3%
9	12/04/2018	UP Double	770	3.01	0	0.0	0%
10	13/04/2018	UP Double	690	3.01	0	0.0	0%
11	16/04/2018	UP Double	770	3.01	17	51.2	7%
12	17/04/2018	UP Double	770	3.01	16	48.2	6%
13	18/04/2018	UP Double	770	3.01	38	114.5	15%
14	19/04/2018	UP Double	770	3.01	0	0.0	0%
15	20/04/2018	UP Double	690	3.01	10	30.1	4%
16	23/04/2018	UP Double	770	3.01	0	0.0	0%
17	24/04/2018	UP Double	770	3.01	29	87.4	11%
18	25/04/2018	UP Double	770	3.01	32	96.4	13%
19	26/04/2018	UP Double	770	3.01	12	36.2	5%
20	27/04/2018	UP Double	690	3.01	9	27.1	4%
21	2/05/2018	UP Double	770	3.01	27	81.4	11%
22	3/05/2018	UP Double	770	3.01	9	27.1	4%
23	4/05/2018	UP Double	690	3.01	3	9.0	1%
24	7/05/2018	UP Double	770	3.01	28	84.4	11%
25	8/05/2018	UP Double	770	3.01	71	214.0	28%
26	9/05/2018	UP Double	770	3.01	32	96.4	13%
27	11/05/2018	UP Double	690	3.01	0	0.0	0%
28	14/05/2018	UP Double	770	3.01	27	81.4	11%
29	17/05/2018	GB	770	4.77	0	0.0	0%
30	18/05/2018	GB	690	4.77	1	4.8	1%
31	21/05/2018	GB	770	4.77	7	33.4	4%
32	22/05/2018	GB	770	4.77	0	0.0	0%
33	23/05/2018	GB	770	4.77	0	0.0	0%
34	24/05/2018	GB	770	4.77	0	0.0	0%
35	25/05/2018	GB	690	4.77	3	14.3	2%

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*Kobayashi 1*

No	Tanggal	Model	<i>Loading Time</i> (menit)	<i>Ideal Cycle Time</i> (Menit/Pcs)	<i>Defect</i>	<i>Defect Time</i>	<i>Defect Loss</i>
36	28/05/2018	GB	770	4.77	0	0.0	0%
37	30/05/2018	GB	770	4.77	9	42.9	6%
<b>Rata-rata</b>						<b>43.7</b>	<b>6%</b>

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*Kobayashi 2*

No	Tanggal	Model	<i>Loading Time</i> (menit)	<i>Ideal Cycle Time</i> (Menit/Pcs)	<i>Defect</i>	<i>Defect Time</i>	<i>Defect Loss</i>
1	2/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
2	3/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
3	4/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
4	5/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
5	6/04/2018	UP <i>Single</i>	690	5.77	0	0.0	0%
6	9/04/2018	GB	770	4.77	0	0.0	0%
7	10/04/2018	GB	770	4.77	0	0.0	0%
8	11/04/2018	GB	770	4.77	106	505.3	66%
9	12/04/2018	GB	770	4.77	77	367.1	48%
10	13/04/2018	GB	690	4.77	47	224.1	32%
11	16/04/2018	GB	770	4.77	0	0.0	0%
12	17/04/2018	GB	770	4.77	5	23.8	3%
13	18/04/2018	GB	770	4.77	7	33.4	4%
14	19/04/2018	GB	770	4.77	0	0.0	0%
15	20/04/2018	UP <i>Single</i>	690	5.77	0	0.0	0%
16	23/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
17	24/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
18	25/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
19	26/04/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
20	27/04/2018	UP <i>Single</i>	690	5.77	0	0.0	0%
21	2/05/2018	UP <i>Single</i>	770	5.77	0	0.0	0%
22	3/05/2018	UP <i>Single</i>	770	5.77	4	23.1	3%
23	4/05/2018	UP <i>Single</i>	690	5.77	2	11.5	2%
24	7/05/2018	UP <i>Double</i>	770	3.01	0	0.0	0%
25	8/05/2018	UP <i>Double</i>	770	3.01	71	214.0	28%
26	9/05/2018	UP <i>Double</i>	770	3.01	34	102.5	13%

*Kobayashi 2*

No	Tanggal	Model	Loading Time (menit)	Ideal Cycle Time (Menit/Pcs)	Defect	Defect Time	Defect Loss
27	11/05/2018	UP Double	690	3.01	0	0.0	0%
28	14/05/2018	UP Double	770	3.01	28	84.4	11%
29	17/05/2018	UP Double	770	3.01	0	0.0	0%
30	18/05/2018	UP Single	690	5.77	6	34.6	5%
31	21/05/2018	UP Single	770	5.77	0	0.0	0%
32	22/05/2018	UP Single	770	5.77	1	5.8	1%
33	23/05/2018	UP Single	770	5.77	0	0.0	0%
34	24/05/2018	UP Single	770	5.77	3	17.3	2%
35	25/05/2018	UP Double	690	5.77	0	0.0	0%
36	28/05/2018	UP Double	770	5.77	18	103.8	13%
37	30/05/2018	UP Double	770	5.77	13	75.0	10%
<b>Rata-rata</b>						<b>49.3</b>	<b>7%</b>

*Liencheh*

No	Tanggal	Model	Loading Time (menit)	Ideal Cycle Time (Menit/Pcs)	Defect	Defect Time	Defect Loss
1	2/04/2018	F. Back YU5	770	4.99	0	0.0	0%
2	3/04/2018	F. Back YU5	770	4.99	0	0.0	0%
3	4/04/2018	F. Back YU5	770	4.99	0	0.0	0%
4	5/04/2018	F. Back YU5	770	4.99	0	0.0	0%
5	6/04/2018	F. Back YU5	690	4.99	29	144.8	21%
6	9/04/2018	F. Back YU5	770	4.99	0	0.0	0%
7	10/04/2018	F. Back YU5	770	4.99	0	0.0	0%
8	11/04/2018	F. Back YU5	770	4.99	1	5.0	1%
9	12/04/2018	F. Back YU5	770	4.99	5	25.0	3%
10	13/04/2018	F. Back YU5	690	4.99	2	10.0	1%
11	16/04/2018	F. Back U1J	770	4.99	0	0.0	0%
12	17/04/2018	F. Back U1J	770	4.99	0	0.0	0%
13	18/04/2018	F. Back U1J	770	4.99	0	0.0	0%
14	19/04/2018	F. Back U1J	770	4.99	0	0.0	0%
15	20/04/2018	F. Back U1J	690	4.99	18	89.9	13%
16	23/04/2018	F. Back YU5	770	4.99	6	30.0	4%
17	24/04/2018	F. Back YU5	770	4.99	0	0.0	0%

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*Liencheh*

No	Tanggal	Model	Loading Time (menit)	Ideal Cycle Time (Menit/Pcs)	Defect	Defect Time	Defect Loss
18	25/04/2018	F. Back YU5	770	4.99	0	0.0	0%
19	26/04/2018	F. Back YU5	770	4.99	0	0.0	0%
20	27/04/2018	F. Back YU5	690	4.99	12	59.9	9%
21	2/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
22	3/05/2018	Fall Back YU5	770	4.99	28	139.8	18%
23	4/05/2018	Fall Board GB	690	4.77	0	0.0	0%
24	7/05/2018	Fall Board GB	770	4.77	17	81.0	11%
25	8/05/2018	Fall Board GB	770	4.77	7	33.4	4%
26	9/05/2018	Fall Board GB	770	4.77	0	0.0	0%
27	11/05/2018	Fall Board GB	690	4.77	0	0.0	0%
28	14/05/2018	Fall Board GB	770	4.77	10	47.7	6%
29	17/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
30	18/05/2018	Fall Back YU5	690	4.99	3	15.0	2%
31	21/05/2018	Fall Back YU5	770	4.99	22	109.8	14%
32	22/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
33	23/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
34	24/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
35	25/05/2018	Fall Back YU5	690	4.99	0	0.0	0%
36	28/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
37	30/05/2018	Fall Back YU5	770	4.99	0	0.0	0%
<b>Rata-rata</b>						<b>21.4</b>	<b>3%</b>

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### I- Daftar kendala mesin kobayashi 1

<b>Mesin Kobayashi 1</b>			
<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Keterangan</b>
1	2/04/2018	UP <i>Single</i>	Start jam 10.00
2	3/04/2018	UP <i>Single</i>	<i>veneer</i> habis
3	4/04/2018	UP <i>Single</i>	Proses lem lebih lama
4	5/04/2018	UP <i>Single</i>	jig bocor
5	6/04/2018	UP <i>Single</i>	<i>Oke</i>
6	9/04/2018	GB	<i>Oke</i>
7	10/04/2018	GB	<i>Oke</i>
8	11/04/2018	GB	<i>Oke</i>
9	12/04/2018	GB	<i>Oke</i>
10	13/04/2018	GB	boiler mati
11	16/04/2018	GB	service boiler
12	17/04/2018	GB	<i>Oke</i>
13	18/04/2018	GB	<i>Oke</i>
14	19/04/2018	GB	pipa <i>steam</i> robek
15	20/04/2018	UP <i>Single</i>	<i>Oke</i>
16	23/04/2018	UP <i>Single</i>	<i>Oke</i>
17	24/04/2018	UP <i>Single</i>	<i>Oke</i>
18	25/04/2018	UP <i>Single</i>	<i>Oke</i>
19	26/04/2018	UP <i>Single</i>	<i>Oke</i>
20	27/04/2018	UP <i>Single</i>	<i>Oke</i>
21	2/05/2018	UP <i>Single</i>	Menunggu suhu jig naik
22	3/05/2018	UP <i>Single</i>	<i>Oke</i>
23	4/05/2018	UP <i>Single</i>	<i>Oke</i>
24	7/05/2018	UP <i>Double</i>	<i>Oke</i>
25	8/05/2018	UP <i>Double</i>	<i>Oke</i>
26	9/05/2018	UP <i>Double</i>	<i>Oke</i>
27	11/05/2018	UP <i>Double</i>	<i>Oke</i>
28	14/05/2018	UP <i>Double</i>	<i>Oke</i>
29	17/05/2018	UP <i>Double</i>	Jig Bocor kemudian ganti jig
30	18/05/2018	UP <i>Single</i>	<i>Oke</i>
31	21/05/2018	UP <i>Single</i>	<i>Oke</i>
32	22/05/2018	UP <i>Single</i>	<i>Oke</i>
33	23/05/2018	UP <i>Single</i>	<i>Oke</i>
34	24/05/2018	UP <i>Single</i>	<i>Oke</i>
35	25/05/2018	UP <i>Double</i>	<i>Oke</i>
36	28/05/2018	UP <i>Double</i>	Bongkar Tembaga

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**Mesin Kobayashi 1**

<b>No</b>	<b>Tanggal</b>	<b>Model</b>	<b>Keterangan</b>
37	30/05/2018	UP <i>Double</i>	<i>Oke</i>

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