

Lampiran 6. Hasil Perhitungan *Line Balance* Keseluruhan *Final Regulation Assy GP*a. *Line Balance Before*

No	Nama	Proses	ST Margin	Takt Time	Pitch Time
1	Hesti	Final Regulation (Piano)	23.23	24.21	23.23
2	Novi	Final Regulation (Piano)	23.23	24.21	23.23
3	Ivan	Final Regulation (Meja)	21.71	24.21	23.23
4	Siti	Final Regulation (Meja)	21.71	24.21	23.23
5	Feby H	Leveling of Damper	22.17	24.21	23.23
6	Irwan Winata	Leveling of Damper	22.17	24.21	23.23
7	Agus Triatmaja	Leveling of Damper	23.13	24.21	23.23
Total			157.35	24.21	23.23

Rekapitulasi Perhitungan		
Total ST Margin	157.35	menit
Takt Time	24	menit
Pitch Time	23.23	menit
Operator	7	orang
Plan Prod	19	unit / 8 hour
Potensial Output	19.80	unit / 8 hour
Line Balancing	97%	

b. *Line Balance After*

No	Nama	Proses	ST Margin	Takt Time	Pitch Time
1	Hesti	Final Regulation (Piano)	23.23	24.21	24.14
2	Novi	Final Regulation (Piano)	23.23	24.21	24.14
3	Ivan	Final Regulation (Meja)	21.71	24.21	24.14
4	Siti	Final Regulation (Meja)	21.71	24.21	24.14
5	Feby H	Leveling of Damper	23.64	24.21	24.14
6	Irwan Winata	Leveling of Damper	23.64	24.21	24.14
7	Agus Triatmaja	Leveling of Damper	24.14	24.21	24.14
Total			161.30	24.21	24.14

Rekapitulasi Perhitungan		
Total ST Margin	161.30	menit
Takt Time	24	menit
Pitch Time	24.14	menit
Operator	7	orang
Plan Prod	19	unit / 8 hour
Potensial Output	19.06	unit / 8 hour
Line Balancing	95%	