

LAMPIRAN A

Keterangan setiap proses di Buffing Small UP

Nama Proses	Fungsi	<i>Part</i>
Level Buff Manual	Untuk menghilangkan serat <i>sanding</i> (Wax YH18A)	Side Arm B1 (PE, PM/PW, PWH) Side Arm B2 (PE, PM/PW, PWH) Side Arm B3 (PM) Side Arm U1J (PM) Side Arm P116 (PE, PWH) Side Arm K121 (PE, PM/PW, PWH) Leg B2 (PE, PM/PW, PWH) Leg B3 (PE, PM/PW, PWH) Leg U1J (PE, PM/PW, PWH) Leg P116 (PE, PWH) Leg P121 (PE, PWH) Side Base P121 (PE, PWH) Top Frame R/L B2 (PE, PM/PW, PWH) Top Frame R/L B3 (PE, PM/PW, PWH) Top Frame R/L U1J (PE, PM/PW, PWH) Top Frame R/L P116 (PE, PWH) Top Frame R/L P121 (PE, PWH) Key Block B1 (PE, PM/PW, PWH) Key Block B2 (PE, PM/PW, PWH) Key Block B3 (PE, PM/PW, PWH) Key Block U1J (PE, PM/PW, PWH) Key Block P116 (PE, PWH) Key Block 121 (PE, PWH) Key Block K121 (PE, PM/PW, PWH) Side Sleeve B2 (PE, PM/PW, PWH)

		<p>Side Sleeve B3 (PE, PM/PW, PWH) Side Sleeve U1J (PE, PM/PW, PWH) Side Sleeve P116 (PE, PWH) Side Sleeve P121 (PE, PWH) Top Frame Side U1J (PE, PM/PW, PWH) Top Frame Sill U1J (PE, PM/PW, PWH) Leg Top Block P121 (PE, PWH) Music Desk B1 (PM/PW, PWH) Music Desk B2 (PM/PW, PWH) Music Desk B3 (PM, PWH) Music Desk U1J (PM) Music Desk P121 (PWH) Key Slip U1J (PE, PM/PW, PWH) Fall Back U1J (PE, PM/PW, PWH) Fall Back P121 (PE, PWH) Fall Back P116 (PE, PWH) Leg UP Part</p>
Small Buff	<p>Untuk menghilangkan serat <i>sanding</i> (Wax YH18A)</p>	<p>Side Arm B3 (PE, PWH) Side Arm U1J (PE, PWH) Side Arm P121 (PE, PWH) Side Base B2 (PE, PM/PW, PWH) Side Base B3 (PE, PM/PW, PWH) Side Base U1J (PE, PM/PW, PWH) Side Base P116 (PE, PM/PW, PWH) Side Sleeve B3 (PE, PM/PW, PWH) Key Slip B1 (PE, PM/PW, PWH) Key Slip B2 (PE, PM/PW, PWH) Key Slip B3 (PE, PM/PW, PWH) Key Slip P116 (PE, PWH) Key Slip P121 (PE, PWH)</p>

		<p>Fall Back B1 (PE, PM/PW, PWH) Fall Back B2 (PE, PM/PW, PWH) Fall Back B3 (PE, PM/PW, PWH) Pedal Rail B1 (PE, PM/PW, PWH) Pedal Rail B2 (PE, PM/PW, PWH) Pedal Rail B3 (PE, PM/PW, PWH) Pedal Rail U1J (PE, PM/PW, PWH) Pedal Rail P116 (PE, PWH) Pedal Rail P121 (PE, PWH) Hinge Stripe B1 (PE, PM/PW, PWH) Hinge Stripe B2 (PE, PM/PW, PWH) Hinge Stripe B3 (PE, PM, PWH) Hinge Stripe U1J (PE, PM/PW, PWH) Hinge Stripe P116 (PE, PWH) Hinge Stripe P121 (PE, PWH) Fall Front B1 (PE, PM/PW, PWH) Fall Front B2 (PE, PM/PW, PWH) Fall Front B3 (PE, PM/PW, PWH) Fall Front P116 (PE, PWH) Side Base UP Part (Yus 1, Yus 3)</p>
Auto Level Buff	<p>Untuk menghilangkan serat <i>sanding</i> (Wax YH18A)</p>	<p>Side Arm B1 (PE, PM/PW, PWH) Side Arm B2 (PE, PWH) Side Arm B3 (PE, PWH) Side Arm U1J (PE, PWH) Side Arm P121 (PE, PWH) Side Base B2 (PE, PM/PW, PWH) Side Base B3 (PE, PM/PW, PWH) Side Base U1J (PE, PM/PW, PWH) Side Base P116 (PE, PM/PW, PWH) Side Base P121 (PE, PM/PW, PWH)</p>

		<p>Key Block B1 (PE, PM/PW, PWH) Key Block B2 (PE, PM/PW, PWH) Key Block B3 (PE, PM/PW, PWH) Key Block U1J (PE, PM/PW, PWH) Key Block P116 (PE, PWH) Key Block 121 (PE, PWH) Side Sleeve B2 (PE, PM/PW, PWH) Side Sleeve U1J (PE, PM/PW, PWH) Fall Back U1J (PE, PM/PW, PWH) Fall Back P121 (PE, PWH) Fall Back P116 (PE, PWH) Side Base UP Part (Yus 1, Yus 3)</p>
Edge Buff	<p>Untuk menghilangkan serat <i>sanding</i> (Wax YH18A)</p>	<p>Side Arm B1 (PE, PM/PW, PWH) Side Arm B2 (PE, PM/PW, PWH) Side Arm B3 (PE, PM/PW, PWH) Side Arm U1J (PE, PM/PW, PWH) Side Arm P116 (PE, PWH) Side Arm P121 (PE, PWH) Side Base B2 (PE, PM/PW, PWH) Side Base B3 (PE, PM/PW, PWH) Side Base U1J (PE, PM/PW, PWH) Side Base P116 (PE, PWH) Side Base P121 (PE, PWH) Key Block B1 (PE, PM/PW, PWH) Key Block B2 (PE, PM/PW, PWH) Key Block B3 (PE, PM/PW, PWH) Key Block U1J (PE, PM/PW, PWH) Key Block P116 (PE, PWH) Key Block 121 (PE, PWH) Top Frame C (PE, PM/PW, PWH)</p>

		<p>Top Frame Sill (PE, PM/PW, PWH)</p> <p>Side Base UP Part (Yus 1, Yus 3)</p>
Ryoto Kasar	<p>Untuk menghilangkan serat <i>sanding</i> (Wax YH18A)</p>	<p>Side Arm B1 (PE, PM/PW, PWH)</p> <p>Side Arm B2 (PE, PM/PW, PWH)</p> <p>Side Arm B3 (PE, PM/PW, PWH)</p> <p>Side Arm U1J (PE, PM/PW, PWH)</p> <p>Side Arm P116 (PE, PWH)</p> <p>Side Arm P121 (PE, PWH)</p> <p>Leg B2 (PE, PM/PW, PWH)</p> <p>Leg B3 (PE, PM/PW, PWH)</p> <p>Leg U1J (PE, PM/PW, PWH)</p> <p>Leg P116 (PE, PWH)</p> <p>Leg P121 (PE, PWH)</p> <p>Side Base B2 (PE, PM/PW, PWH)</p> <p>Side Base B3 (PE, PM/PW, PWH)</p> <p>Side Base U1J (PE, PM/PW, PWH)</p> <p>Side Base P116 (PE, PWH)</p> <p>Side Base P121 (PE, PWH)</p> <p>Top Frame R/L B2 (PE, PM/PW, PWH)</p> <p>Top Frame R/L B3 (PE, PM/PW, PWH)</p> <p>Top Frame R/L U1J (PE, PM/PW, PWH)</p> <p>Top Frame R/L P116 (PE, PWH)</p> <p>Top Frame R/L P121 (PE, PWH)</p> <p>Key Block B1 (PE, PM/PW, PWH)</p> <p>Key Block B2 (PE, PM/PW, PWH)</p> <p>Key Block B3 (PE, PM/PW, PWH)</p> <p>Key Block U1J (PE, PM/PW, PWH)</p> <p>Key Block P116 (PE, PWH)</p> <p>Key Block 121 (PE, PWH)</p> <p>Key Block K121 (PE, PM/PW, PWH)</p>

		<p>Side Sleeve B2 (PE, PM/PW, PWH)</p> <p>Side Sleeve B3 (PE, PM/PW, PWH)</p> <p>Side Sleeve U1J (PE, PM/PW, PWH)</p> <p>Side Sleeve P116 (PE, PWH)</p> <p>Side Sleeve P121 (PE, PWH)</p> <p>Top Frame C (PE, PM/PW, PWH)</p> <p>Top Frame Side (PE, PM/PW, PWH)</p> <p>Top Frame Sill (PE, PM/PW, PWH)</p> <p>Leg Top Block P121 (PE, PWH)</p> <p>Music Desk B1 (PM/PW, PWH)</p> <p>Music Desk B2 (PM/PW, PWH)</p> <p>Music Desk B3 (PM, PWH)</p> <p>Music Desk U1J (PM)</p> <p>Music Desk P121 (PWH)</p> <p>Key Slip U1J (PE, PM/PW, PWH)</p> <p>Fall Back U1J (PE, PM/PW, PWH)</p> <p>Fall Back P121 (PE, PWH)</p> <p>Fall Back P116 (PE, PWH)</p> <p>Fall Front B1 (PE, PM/PW, PWH)</p> <p>Fall Front B2 (PE, PM/PW, PWH)</p> <p>Fall Front B3 (PE, PM/PW, PWH)</p> <p>Fall Front P116 (PE, PWH)</p>
High Polish	<p>Untuk menghilangkan wax <i>buffing</i> sebelumnya dan untuk mengkilapkan <i>part</i> (YH6Q dan Menzerna 6S)</p>	<p>Side Arm B2 (PE, PM/PW, PWH)</p> <p>Side Arm B3 (PE, PM/PW, PWH)</p> <p>Side Arm U1J (PE, PM/PW, PWH)</p> <p>Side Arm P121 (PE, PWH)</p> <p>Leg B2 (PE, PM/PW, PWH)</p> <p>Leg B3 (PE, PM/PW, PWH)</p> <p>Leg U1J (PE, PM/PW, PWH)</p> <p>Leg P116 (PE, PWH)</p>

		<p>Leg P121 (PE, PWH)</p> <p>Side Base B2 (PE, PM/PW, PWH)</p> <p>Side Base B3 (PE, PM/PW, PWH)</p> <p>Side Base U1J (PE, PM/PW, PWH)</p> <p>Side Base P116 (PE, PWH)</p> <p>Side Sleeve B2 (PE, PM/PW, PWH)</p> <p>Side Sleeve B3 (PE, PM/PW, PWH)</p> <p>Side Sleeve U1J (PE, PM/PW, PWH)</p> <p>Side Sleeve P116 (PE, PWH)</p> <p>Side Sleeve P121 (PE, PWH)</p> <p>Top Frame C (PE, PM/PW, PWH)</p> <p>Top Frame Side (PE, PM/PW, PWH)</p> <p>Key Slip B1 (PE, PM/PW, PWH)</p> <p>Key Slip B2 (PE, PM/PW, PWH)</p> <p>Key Slip B3 (PE, PM/PW, PWH)</p> <p>Key Slip U1J (PE, PM/PW, PWH)</p> <p>Key Slip P116 (PE, PWH)</p> <p>Key Slip P121 (PE, PWH)</p> <p>Fall Back B1 (PE, PM/PW, PWH)</p> <p>Fall Back B2 (PE, PM/PW, PWH)</p> <p>Fall Back B3 (PE, PM/PW, PWH)</p> <p>Pedal Rail B1 (PE, PM/PW, PWH)</p> <p>Pedal Rail B2 (PE, PM/PW, PWH)</p> <p>Pedal Rail B3 (PE, PM/PW, PWH)</p> <p>Pedal Rail U1J (PE, PM/PW, PWH)</p> <p>Pedal Rail P116 (PE, PWH)</p> <p>Pedal Rail P121 (PE, PWH)</p> <p>Hinge Stripe B1 (PE, PM/PW, PWH)</p> <p>Hinge Stripe B2 (PE, PM/PW, PWH)</p> <p>Hinge Stripe B3 (PE, PM, PWH)</p>
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		<p>Hinge Stripe U1J (PE, PM/PW, PWH) Hinge Stripe P116 (PE, PWH) Hinge Stripe P121 (PE, PWH) Leg UP Part Side Base UP Part (Yus 1, Yus 3)</p>
<p>Ryoto Halus</p>	<p>Untuk menghilangkan wax <i>buffing</i> pada proses sebelumnya (YH6Q)</p>	<p>Side Arm B1 (PE, PM/PW, PWH) Side Arm B2 (PE, PM/PW, PWH) Side Arm B3 (PE, PM/PW, PWH) Side Arm U1J (PE, PM/PW, PWH) Side Arm P116 (PE, PWH) Side Arm P121 (PE, PWH) Leg B2 (PE, PM/PW, PWH) Leg B3 (PE, PM/PW, PWH) Leg U1J (PE, PM/PW, PWH) Leg P116 (PE, PWH) Leg P121 (PE, PWH) Side Base B2 (PE, PM/PW, PWH) Side Base B3 (PE, PM/PW, PWH) Side Base U1J (PE, PM/PW, PWH) Side Base P116 (PE, PWH) Side Base P121 (PE, PWH) Top Frame R/L B2 (PE, PM/PW, PWH) Top Frame R/L B3 (PE, PM/PW, PWH) Top Frame R/L U1J (PE, PM/PW, PWH) Top Frame R/L P116 (PE, PWH) Top Frame R/L P121 (PE, PWH) Key Block B1 (PE, PM/PW, PWH) Key Block B2 (PE, PM/PW, PWH) Key Block B3 (PE, PM/PW, PWH) Key Block U1J (PE, PM/PW, PWH)</p>

		<p>Key Block P116 (PE, PWH)</p> <p>Key Block 121 (PE, PWH)</p> <p>Key Block K121 (PE, PM/PW, PWH)</p> <p>Side Sleeve B2 (PE, PM/PW, PWH)</p> <p>Side Sleeve B3 (PE, PM/PW, PWH)</p> <p>Side Sleeve U1J (PE, PM/PW, PWH)</p> <p>Side Sleeve P116 (PE, PWH)</p> <p>Side Sleeve P121 (PE, PWH)</p> <p>Top Frame C (PE, PM/PW, PWH)</p> <p>Top Frame Side (PE, PM/PW, PWH)</p> <p>Top Frame Sill (PE, PM/PW, PWH)</p> <p>Leg Top Block P121 (PE, PWH)</p> <p>Music Desk B1 (PM/PW, PWH)</p> <p>Music Desk B2 (PM/PW, PWH)</p> <p>Music Desk B3 (PM, PWH)</p> <p>Music Desk U1J (PM)</p> <p>Music Desk P121 (PWH)</p> <p>Key Slip U1J (PE, PM/PW, PWH)</p> <p>Fall Back U1J (PE, PM/PW, PWH)</p> <p>Fall Back P121 (PE, PWH)</p> <p>Fall Back P116 (PE, PWH)</p> <p>Fall Front B1 (PE, PM/PW, PWH)</p> <p>Fall Front B2 (PE, PM/PW, PWH)</p> <p>Fall Front B3 (PE, PM/PW, PWH)</p> <p>Fall Front P116 (PE, PWH)</p> <p>Leg UP Part</p> <p>Side Base UP Part (Yus 1, Yus 3)</p>
Ryoto Finish	Untuk mengkilapkan <i>part</i> (Menzerna 6S)	<p>Side Arm B1 (PE, PM/PW, PWH)</p> <p>Side Arm B2 (PE, PM/PW, PWH)</p> <p>Side Arm B3 (PE, PM/PW, PWH)</p>

		Side Arm U1J (PE, PM/PW, PWH) Side Arm P116 (PE, PWH) Side Arm P121 (PE, PWH) Leg B2 (PE, PM/PW, PWH) Leg B3 (PE, PM/PW, PWH) Leg U1J (PE, PM/PW, PWH) Leg P116 (PE, PWH) Leg P121 (PE, PWH) Side Base B2 (PE, PM/PW, PWH) Side Base B3 (PE, PM/PW, PWH) Side Base U1J (PE, PM/PW, PWH) Side Base P116 (PE, PWH) Side Base P121 (PE, PWH) Top Frame R/L B2 (PE, PM/PW, PWH) Top Frame R/L B3 (PE, PM/PW, PWH) Top Frame R/L U1J (PE, PM/PW, PWH) Top Frame R/L P116 (PE, PWH) Top Frame R/L P121 (PE, PWH) Key Block B1 (PE, PM/PW, PWH) Key Block B2 (PE, PM/PW, PWH) Key Block B3 (PE, PM/PW, PWH) Key Block U1J (PE, PM/PW, PWH) Key Block P116 (PE, PWH) Key Block 121 (PE, PWH) Key Block K121 (PE, PM/PW, PWH) Side Sleeve B2 (PE, PM/PW, PWH) Side Sleeve B3 (PE, PM/PW, PWH) Side Sleeve U1J (PE, PM/PW, PWH) Side Sleeve P116 (PE, PWH) Side Sleeve P121 (PE, PWH)
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		<p>Top Frame C (PE, PM/PW, PWH) Top Frame Side (PE, PM/PW, PWH) Top Frame Sill (PE, PM/PW, PWH) Leg Top Block P121 (PE, PWH) Music Desk B1 (PM/PW, PWH) Music Desk B2 (PM/PW, PWH) Music Desk B3 (PM, PWH) Music Desk U1J (PM) Music Desk P121 (PWH) Key Slip B1 (PE, PM/PW, PWH) Key Slip B2 (PE, PM/PW, PWH) Key Slip B3 (PE, PM/PW, PWH) Key Slip U1J (PE, PM/PW, PWH) Key Slip P116 (PE, PWH) Key Slip P121 (PE, PWH) Fall Back U1J (PE, PM/PW, PWH) Fall Back P121 (PE, PWH) Fall Back P116 (PE, PWH) Fall Front B1 (PE, PM/PW, PWH) Fall Front B2 (PE, PM/PW, PWH) Fall Front B3 (PE, PM/PW, PWH) Fall Front P116 (PE, PWH) Leg UP Part Side Base UP Part (Yus 1, Yus 3)</p>
Countersing/Bor	Untuk mempertegas lubang yang tertutup cat ketika di- <i>spray</i>	<p>Leg Top Block P121 (PE, PWH) Side Base UP Part (Yus 1, Yus 3)</p>
Black Doff	Untuk memberi warna hitam pada <i>part</i> UP Part	<p>Leg UP Part Side Base UP Part (Yus 1, Yus 3)</p>

LAMPIRAN B

Minus Buffing Small UP Juli 2018

Kabinet	Model	Minus
TOP FRAME R&L	B3	-723
FALL FRONT	B3	-361
TOP FRAME C	B3	-307
FALL BACK	B3	-303
KEY SLIP	B3	-302
SIDE SLEEVE	B3	-282
SIDE BASE L	B3	-266
SIDE ARM R	B3	-264
SIDE ARM L	B3	-263
SIDE BASE R	B3	-262
KEY BED	B3	-239
FALL FRONT	B2	-227
HINGE STRIP	B1	-214
TOP FRAME	B1	-213
FALL FRONT	B1	-210
LEG L	B3	-209
HINGE STRIP	B2	-206
FALL BACK	B1	-205
LEG R	B3	-195
TOP FRAME C	B2	-190
HINGE STRIP	B3	-180
KEY BLOCK L	B1	-158
KEY BLOCK R	B1	-158
SIDE ARM R	B2	-157
SIDE ARM L	B2	-142
KEY SLIP	B1	-137
LEG R	B2	-137
TOP FRAME R	B2	-137
KEY BLOCK L	B2	-134
KEY BLOCK R	B2	-134
TOP FRAME L	B2	-132
LEG L	B2	-131
KEY BLOCK L	B3	-130
KEY BLOCK R	B3	-130

Kabinet	Model	Minus
SIDE ARM R	B1	-126
SIDE SLEEVE	B2	-126
SIDE ARM L	B1	-125
LEG TOP BLOCK	B3	-125
FALL BACK B113 PE	B3	-125
SIDE BASE L	B2	-123
TOP FRAME SILL	B3	-122
SIDE BASE R	B2	-119
LEG L	U1J	-116
LEG R	U1J	-116
KEY SLIP	B2	-111
PEDAL RAIL	B3	-105
PEDAL RAIL	U1J	-100
SIDE BASE L	U1J	-92
PEDAL RAIL	B1	-85
MUSIC DESK	B1	-85
SIDE BASE R	U1J	-85
TOP FRAME SILL	B2	-82
KEY SLIP	U1J	-81
SIDE ARM R	U1J	-71
SIDE SLEEVE	U1J	-71
SIDE ARM L	U1J	-69
KEY BED	U1J	-69
FALL BACK	U1J	-65
TOP FRAME SILL	U1J	-62
KEY BLOCK L	U1J	-59
KEY BLOCK R	U1J	-59
LEG TOP BLOCK	P121	-56
PEDAL RAIL	B2	-55
FALL BACK	P121	-53
TOP FRAME C	U1J	-50
TOP FRAME L	U1J	-48
TOP FRAME R	U1J	-48
FALL BACK	B2	-45
HINGE STRIP	U1J	-41
TOP FRAME SIDE L	U1J	-39
SIDE SLEEVE	P121	-38
TOP FRAME SIDE R	U1J	-35
KEY SLIP	P121	-35
FALL BACK B113 PE	B2	-34

Kabinet	Model	Minus
MUSIC DESK	B2	-33
SIDE ARM L	P121	-31
LEG L	P121	-30
LEG R	P121	-30
LEG L	P116	-28
LEG R	P116	-28
PEDAL RAIL	P121	-28
SIDE ARM R	P121	-25
TOP FRAME L	P121	-25
TOP FRAME R	P121	-25
MUSIC DESK	B3	-24
HINGE STRIP	P121	-21
HINGE STRIP	P116	-19
KEY BED	B2	-18
LEG TOP BLOCK	B2	-18
MUSIC DESK	U1J	-18
SIDE BASE L	P121	-18
TOP FRAME R	P116	-17
SIDE ARM L	P116	-16
TOP FRAME L	P116	-16
SIDE BASE R	P121	-16
SIDE ARM R	P116	-15
FALL BACK	P116	-14
FALL FRONT	P116	-13
KEY BLOCK L	P116	-11
KEY BLOCK R	P116	-11
KEY SLIP	P116	-10
MUSIC DESK	P121	-10
KEY BLOCK L	P121	-7
KEY BLOCK R	P121	-7
SIDE BASE R	P116	-4
MUSIC DESK	P116	-4
SIDE BASE L	P116	-3
LEG L	B1	0
LEG R	B1	0
SIDE BASE R B113/121 PE	B3	0
SIDE BASE L B113/121 PE	B3	0
SIDE SLEEVE	P116	0
PEDAL RAIL	P116	0

LAMPIRAN C

Time Study

Lembar Pengukuran Waktu			< Informasi lapangan >			< Informasi produk >			< Informasi observasi >			Secretariat	GM	Manager	Team	Pengamat			
Lbr pengukuran waktu Ver.01			Nama lapangan			Model B3 PE			Tanggal										
			Nama proses Level Buff Manual			(Cabinet) Top Frame R/L			Waktu										
			Nama operator						Pengamat										
Proses	Satuan Pengukuran	Satuan Waktu	Waktu (baris atas : jam yg dibaca, bawah : jam terpisah) Satuan : DM (1/100 menit)												Pengecualian	Total	Min	Rata-rata	Max
			1	2	3	4	5	6	7	8	9	10	11	12					
A	Setting Jig	Detik	5.00	5.13	5.20											15.33	5.00	5.11	5.20
		Menit	0.08	0.09	0.09											0.26	0.08	0.09	0.09
B	Ambil dan setting Kabinet	Detik	9.08	3.19	4.00											16.27	3.19	5.42	9.08
		Menit	0.15	0.05	0.07											0.27	0.05	0.09	0.15
C	Proses Level Buff Manual 1	Detik	9.58	7.19	7.20											23.97	7.19	7.99	9.58
		Menit	0.16	0.12	0.12											0.40	0.12	0.13	0.16
D	Balik Kabinet	Detik	2.50	2.19	2.10											6.79	2.10	2.26	2.50
		Menit	0.04	0.04	0.04											0.11	0.04	0.04	0.04
E	Proses Level Buff Manual 2	Detik	6.50	7.19	7.20											20.89	6.50	6.96	7.20
		Menit	0.11	0.12	0.12											0.35	0.11	0.12	0.12
F	Balik Kabinet dan Penyatuan Menggunakan lakban	Detik	9.38	3.03	3.00											15.40	3.00	5.13	9.38
		Menit	0.16	0.05	0.05											0.26	0.05	0.09	0.16
G	Proses Level Buff Manual 3	Detik	5.63	2.88	2.88											11.38	2.88	3.79	5.63
		Menit	0.09	0.05	0.05											0.19	0.05	0.06	0.09
H	Balik Kabinet	Detik	1.75	1.35	2.00											5.10	1.35	1.70	2.00
		Menit	0.03	0.02	0.03											0.09	0.02	0.03	0.03
I	Proses Level Buff Manual 4	Detik	4.13	2.93	3.50											10.55	2.93	3.52	4.13
		Menit	0.07	0.05	0.06											0.18	0.05	0.06	0.07
J	Ambil taruh di rak	Detik	2.50	1.25	2.50											6.25	1.25	2.08	2.50
		Menit	0.04	0.02	0.04											0.10	0.02	0.03	0.04
Total		Detik	56.0	36.3	39.6										0.0	131.92	36.30	43.97	56.04
		Menit	0.93	0.61	0.66											2.20	0.61	0.73	0.93
< Catatan >		Jumlah Kabinet per sekali setting 12 dan 40 pos												1.47					

Lembar Pengukuran Waktu			< Informasi lapangan >				< Informasi produk >				< Informasi observasi >				Secretariat	GM	Manager	Team	Pengamat
Lbr pengukuran waktu Ver.01			Nama lapangan				Model B3 PE				Tanggal 10/08/2018								
			Nama proses Auto Level Buff 1				(Cabinet) Top Frame R/L				Waktu 14:38								
			Nama operator Tio								Pengamat Rosma								
Proses	Satuan Pengukuran	Satuan Waktu	Waktu (baris atas : jam yg dibaca, bawah : jam terpisah) Satuan : DM (1/100 menit)												Pengecualian	Total	Min	Rata-rata	Max
			1	2	3	4	5	6	7	8	9	10	11	12					
A	Setting Jig	Detik	5.00	4.00	3.50											12.50	3.50	4.17	5.00
		Menit	0.08	0.07	0.06											0.21	0.06	0.07	0.08
B	Letakkan kabinet di mesin	Detik	2.85	2.50	2.75											8.10	2.50	2.70	2.85
		Menit	0.05	0.04	0.05											0.14	0.04	0.05	0.05
C	setting jig stopper	Detik	5.00	4.40	4.50											13.90	4.40	4.63	5.00
		Menit	0.08	0.07	0.08											0.23	0.07	0.08	0.08
D	Proses auto level buff 1	Detik	9.45	9.45	9.40											28.30	9.40	9.43	9.45
		Menit	0.16	0.16	0.16											0.47	0.16	0.16	0.16
E	cek	Detik	0.80	1.00	1.20											3.00	0.80	1.00	1.20
		Menit	0.01	0.02	0.02											0.05	0.01	0.02	0.02
F	kembalikan kabinet ke rak	Detik	1.45	1.30	1.50											4.25	1.30	1.42	1.50
		Menit	0.02	0.02	0.03											0.07	0.02	0.02	0.03
G	susun kabinet pada mesin	Detik	2.80	1.60	1.98											6.38	1.60	2.13	2.80
		Menit	0.05	0.03	0.03											0.11	0.03	0.04	0.05
H	setting jig stopper	Detik	4.50	3.78	3.60											11.88	3.60	3.96	4.50
		Menit	0.08	0.06	0.06											0.20	0.06	0.07	0.08
I	Proses Level Buff Manual 2	Detik	7.50	7.50	7.45											22.45	7.45	7.48	7.50
		Menit	0.13	0.13	0.12											0.37	0.12	0.12	0.13
J	Balik kabinet	Detik	5.10	4.90	4.92											14.92	4.90	4.97	5.10
		Menit	0.09	0.08	0.08											0.25	0.08	0.08	0.09
K	Proses Level Buff Manual 3	Detik	6.50	6.52	6.50											19.52	6.50	6.51	6.52
		Menit	0.11	0.11	0.11											0.33	0.11	0.11	0.11
L	cek dan letakkan kabinet ke rak	Detik	2.45	2.50	2.35											7.30	2.35	2.43	2.50
		Menit	0.04	0.04	0.04											0.12	0.04	0.04	0.04
Total		Detik	56.3	52.0	52.4										0.0	160.60	51.95	53.53	56.25
		Menit	0.94	0.87	0.87											2.68	0.87	0.89	0.94
< Catatan >		Jumlah Kabinet per sekali setting 40 pos																1.78	

Lembar Pengukuran Waktu			< Informasi lapangan >			< Informasi produk >			< Informasi observasi >			Secretariat	GM	Manager	Team	Pengamat			
Lbr pengukuran waktu Ver.01			Nama lapangan			Model B3 PE			Tanggal										
			Nama proses Auto Level Buff 2			(Cabinet) Top Frame R/L			Waktu										
			Nama operator Tio						Pengamat										
Proses	Satuan Pengukuran	Satuan Waktu	Waktu (baris atas : jam yg dibaca, bawah : jam terpisah)												Pengecualiar	Total	Min	Rata-rata	Max
			Satuan : DM (1/100 menit)																
			1	2	3	4	5	6	7	8	9	10	11	12					
A	Setting Jig	Detik	1.67	1.60	1.70											4.97	1.60	1.66	1.70
		Menit	0.03	0.03	0.03												0.08	0.03	0.03
B	Letakkan kabinet di mesin	Detik	4.25	4.00	4.20											12.45	4.00	4.15	4.25
		Menit	0.07	0.07	0.07												0.21	0.07	0.07
C	setting jig stopper	Detik	12.42	12.30	12.20											36.92	12.20	12.31	12.42
		Menit	0.21	0.21	0.20												0.62	0.20	0.21
D	Proses auto level buff 1	Detik	13.08	13.00	13.10											39.18	13.00	13.06	13.10
		Menit	0.22	0.22	0.22												0.65	0.22	0.22
E	cek	Detik	1.25	1.30	1.50											4.05	1.25	1.35	1.50
		Menit	0.02	0.02	0.03												0.07	0.02	0.02
F	Balik kabinet (edge)	Detik	2.58	2.50	2.30											7.38	2.30	2.46	2.58
		Menit	0.04	0.04	0.04												0.12	0.04	0.04
G	setting jig stopper	Detik	3.67	3.50	3.80											10.97	3.50	3.66	3.80
		Menit	0.06	0.06	0.06												0.18	0.06	0.06
H	Proses auto level buff 2	Detik	6.58	6.60	6.55											19.73	6.55	6.58	6.60
		Menit	0.11	0.11	0.11												0.33	0.11	0.11
I	cek dan balik kabinet	Detik	2.58	2.50	2.60											7.68	2.50	2.56	2.60
		Menit	0.04	0.04	0.04												0.13	0.04	0.04
J	setting jig stopper	Detik	4.75	4.70	4.80											14.25	4.70	4.75	4.80
		Menit	0.08	0.08	0.08												0.24	0.08	0.08
K	proses auto level buff 3	Detik	5.92	6.00	5.90											17.82	5.90	5.94	6.00
		Menit	0.10	0.10	0.10												0.30	0.10	0.10
L	letakkan kabinet di rak	Detik	5.17	5.00	5.20											15.37	5.00	5.12	5.20
		Menit	0.09	0.08	0.09												0.26	0.08	0.09
Total		Detik	63.9	63.0	63.9										0.0	190.77	63.00	63.59	63.92
		Menit	1.07	1.05	1.06											3.18	1.05	1.06	1.07
< Catatan >		Jumlah Kabinet per sekali setting												12 pcs	2.12				

LAMPIRAN D

Daftar pertanyaan kemudahan penggunaan mesin

Level Buff Manual											
No	Pertanyaan	Skala									
		1	2	3	4	5	6	7	8	9	10
1	Kemudahan pemasangan jig bantalan meja mesin untuk setting kabinet pada mesin						1				
2	Kemudahan penggunaan mesin untuk proses buffing								1		
3	Kemudahan perawatan mesin								1		
4	Kemudahan perbaikan mesin saat mesin mengalami breakdown							1			
5	Kemudahan mengganti wax pada mesin								1		
6	Kemudahan pemberian wax				1						
7	Kemudahan memahami cara kerja mesin								1		
8	Kemudahan pengaturan jig stopper								1		

Auto Level Buff 1											
No	Pertanyaan	Skala									
		1	2	3	4	5	6	7	8	9	10
1	Kemudahan pemasangan jig bantalan meja mesin untuk setting kabinet pada mesin							1			
2	Kemudahan penggunaan mesin untuk proses buffing								1		
3	Kemudahan perawatan mesin							1			
4	Kemudahan perbaikan mesin saat mesin mengalami breakdown					1					
5	Kemudahan mengganti wax pada mesin							1			
6	Kemudahan pemberian wax								1		
7	Kemudahan memahami cara kerja mesin					1					
8	Kemudahan pengaturan jig stopper					1					

Auto Level Buff 2											
No	Pertanyaan	Skala									
		1	2	3	4	5	6	7	8	9	10
1	Kemudahan pemasangan jig bantalan meja mesin untuk setting kabinet pada mesin						1				
2	Kemudahan penggunaan mesin untuk proses buffing						1				
3	Kemudahan perawatan mesin								1		
4	Kemudahan perbaikan mesin saat mesin mengalami breakdown				1						
5	Kemudahan mengganti wax pada mesin							1			
6	Kemudahan pemberian wax								1		
7	Kemudahan memahami cara kerja mesin					1					
8	Kemudahan pengaturan jig stopper							1			

LAMPIRAN E

Data PSI (rencana produksi)

Model	Plan / month	Plan / day	unit / day	ratio	ST Nett
B1 PE	662	30.09	27.38	31%	15.91
B1 PM/PW	14	0.64	0.58	1%	17.12
B1 PWH	99	4.50	4.09	5%	17.49
B2 PE	373	16.95	15.43	17%	28.95
B2 PM/PW	11	0.50	0.45	1%	26.40
B2 PWH	36	1.64	1.49	2%	30.64
B3 PE	638	29.00	26.39	30%	29.23
B3 PM/PW	11	0.50	0.45	1%	23.46
B3 PWH	11	0.50	0.45	1%	35.62
U1J PE	97	4.41	4.01	5%	37.23
U1J PM/PW	7	0.32	0.29	0%	32.29
U1J PWH	5	0.23	0.21	0%	39.40
P116 PE	80	3.64	3.31	4%	28.24
P116 PWH	0	0.00	0.00	0%	30.93
P121 PE	98	4.45	4.05	5%	31.64
P121 PWH	9	0.41	0.37	0%	34.95
K121 PE	1	0.05	0.04	0%	
FALL FLAP YC1SH E-			-		-
Leg UP Part	800	36.36	36.36	30%	6.80
Side Base Yus 1	1400	63.64	63.64	52%	2.92
Side Base Yus 3	500	22.73	22.73	19%	2.92
TOTAL		220.55	211.73	200%	472.13

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Level Buff Manual	Side Arm	B1 PE	27.38	1.60	100%	1.60	43.71
Level Buff Manual	Side Arm	B1 PM/PW	0.58	1.60	100%	1.60	0.92
Level Buff Manual	Side Arm	B1 PWH	4.09	1.60	100%	1.60	6.54
Level Buff Manual	Side Arm	B2 PE	15.43	1.43	80%	1.15	17.69
Level Buff Manual	Side Arm	B2 PM/PW	0.45	1.43	80%	1.15	0.52
Level Buff Manual	Side Arm	B2 PWH	1.49	1.43	80%	1.15	1.71
Level Buff Manual	Side Arm	B3 PM/PW	0.45	1.43	80%	1.15	0.52
Level Buff Manual	Side Arm	U1J PM/PW	0.29	1.60	80%	1.28	0.37
Level Buff Manual	Side Arm	P116 PE	3.31	1.43	80%	1.15	3.79
Level Buff Manual	Side Arm	P116 PWH	0.00	1.43	80%	1.15	0.00
Level Buff Manual	Leg	B2 PE	15.43	2.44	50%	1.22	18.82
Level Buff Manual	Leg	B2 PM/PW	0.45	2.44	50%	1.22	0.56
Level Buff Manual	Leg	B2 PWH	1.49	2.44	50%	1.22	1.82
Level Buff Manual	Leg	B3 PE	26.39	2.52	50%	1.26	33.26
Level Buff Manual	Leg	B3 PM/PW	0.45	2.52	50%	1.26	0.57
Level Buff Manual	Leg	B3 PWH	0.45	2.52	50%	1.26	0.57
Level Buff Manual	Leg	U1J PE	4.01	2.44	50%	1.22	4.89
Level Buff Manual	Leg	U1J PM/PW	0.29	2.44	50%	1.22	0.35
Level Buff Manual	Leg	U1J PWH	0.21	2.44	50%	1.22	0.25
Level Buff Manual	Leg	P116 PE	3.31	2.44	50%	1.22	4.04
Level Buff Manual	Leg	P116 PWH	0.00	2.44	50%	1.22	0.00
Level Buff Manual	Leg	P121 PE	4.05	2.44	50%	1.22	4.94
Level Buff Manual	Leg	P121 PWH	0.37	2.44	50%	1.22	0.45
Level Buff Manual	Side Base	P121 PE	4.05	0.55	50%	0.27	1.11
Level Buff Manual	Side Base	P121 PWH	0.37	0.55	50%	0.27	0.10
Level Buff Manual	Top Frame R/L	B2 PE	15.43	1.45	100%	1.45	22.37
Level Buff Manual	Top Frame R/L	B2 PM/PW	0.45	1.45	100%	1.45	0.66
Level Buff Manual	Top Frame R/L	B2 PWH	1.49	1.45	100%	1.45	2.16
Level Buff Manual	Top Frame R/L	B3 PE	26.39	0.97	100%	0.97	25.61
Level Buff Manual	Top Frame R/L	B3 PM/PW	0.45	0.97	100%	0.97	0.44
Level Buff Manual	Top Frame R/L	B3 PWH	0.45	0.97	100%	0.97	0.44
Level Buff Manual	Top Frame R/L	U1J PE	4.01	1.92	100%	1.92	7.69
Level Buff Manual	Top Frame R/L	U1J PM/PW	0.29	1.92	100%	1.92	0.55

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Level Buff Manual	Top Frame R/L	U1J PWH	0.21	1.92	100%	1.92	0.40
Level Buff Manual	Top Frame R/L	P116 PE	3.31	1.92	100%	1.92	6.34
Level Buff Manual	Top Frame R/L	P116 PWH	0.00	1.92	100%	1.92	0.00
Level Buff Manual	Top Frame R/L	P121 PE	4.05	1.92	100%	1.92	7.77
Level Buff Manual	Top Frame R/L	P121 PWH	0.37	1.92	100%	1.92	0.71
Level Buff Manual	Key Block	B1 PE	27.38	0.22	50%	0.11	3.02
Level Buff Manual	Key Block	B1 PM/PW	0.58	0.22	50%	0.11	0.06
Level Buff Manual	Key Block	B1 PWH	4.09	0.22	50%	0.11	0.45
Level Buff Manual	Key Block	B2 PE	15.43	0.22	50%	0.11	1.70
Level Buff Manual	Key Block	B2 PM/PW	0.45	0.22	50%	0.11	0.05
Level Buff Manual	Key Block	B2 PWH	1.49	0.22	50%	0.11	0.16
Level Buff Manual	Key Block	B3 PE	26.39	0.22	80%	0.18	4.65
Level Buff Manual	Key Block	B3 PM/PW	0.45	0.22	80%	0.18	0.08
Level Buff Manual	Key Block	B3 PWH	0.45	0.22	80%	0.18	0.08
Level Buff Manual	Key Block	U1J PE	4.01	0.22	80%	0.18	0.71
Level Buff Manual	Key Block	U1J PM/PW	0.29	0.22	80%	0.18	0.05
Level Buff Manual	Key Block	U1J PWH	0.21	0.22	80%	0.18	0.04
Level Buff Manual	Key Block	P116 PE	3.31	0.71	80%	0.56	1.87
Level Buff Manual	Key Block	P116 PWH	0.00	0.71	80%	0.56	0.00
Level Buff Manual	Key Block	P121 PE	4.05	0.71	80%	0.56	2.29
Level Buff Manual	Key Block	P121 PWH	0.37	0.71	80%	0.56	0.21
Level Buff Manual	Side Sleeve	B2 PE	15.43	1.54	100%	1.54	23.74
Level Buff Manual	Side Sleeve	B2 PM/PW	0.45	1.54	100%	1.54	0.70
Level Buff Manual	Side Sleeve	B2 PWH	1.49	1.54	100%	1.54	2.29
Level Buff Manual	Side Sleeve	B3 PE	26.39	1.54	100%	1.54	40.60
Level Buff Manual	Side Sleeve	B3 PM/PW	0.45	1.54	100%	1.54	0.70
Level Buff Manual	Side Sleeve	B3 PWH	0.45	1.54	100%	1.54	0.70
Level Buff Manual	Side Sleeve	U1J PE	4.01	1.54	100%	1.54	6.17
Level Buff Manual	Side Sleeve	U1J PM/PW	0.29	1.54	100%	1.54	0.45
Level Buff Manual	Side Sleeve	U1J PWH	0.21	1.54	100%	1.54	0.32

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Level Buff Manual	Side Sleeve	P116 PE	3.31	1.54	100%	1.54	5.09
Level Buff Manual	Side Sleeve	P116 PWH	0.00	1.54	100%	1.54	0.00
Level Buff Manual	Side Sleeve	P121 PE	4.05	1.54	100%	1.54	6.24
Level Buff Manual	Side Sleeve	P121 PWH	0.37	1.54	100%	1.54	0.57
Level Buff Manual	Top Frame Side	U1J PE	4.01	1.48	100%	1.48	5.95
Level Buff Manual	Top Frame Side	U1J PM/PW	0.29	1.48	100%	1.48	0.43
Level Buff Manual	Top Frame Side	U1J PWH	0.21	1.48	100%	1.48	0.31
Level Buff Manual	Top Frame Sill	U1J PE	4.01	1.29	100%	1.29	5.16
Level Buff Manual	Top Frame Sill	U1J PM/PW	0.29	1.29	100%	1.29	0.37
Level Buff Manual	Top Frame Sill	U1J PWH	0.21	1.29	100%	1.29	0.27
Level Buff Manual	Leg Top Block	P121 PE	4.05	0.42	100%	0.42	1.69
Level Buff Manual	Leg Top Block	P121 PWH	0.37	0.42	100%	0.42	0.16
Level Buff Manual	Music Desk	B1 PM/PW	0.58	0.76	100%	0.76	0.44
Level Buff Manual	Music Desk	B1 PWH	4.09	0.76	100%	0.76	3.10
Level Buff Manual	Music Desk	B2 PM/PW	0.45	0.76	100%	0.76	0.34
Level Buff Manual	Music Desk	B2 PWH	1.49	0.76	100%	0.76	1.13
Level Buff Manual	Music Desk	B3 PM/PW	0.45	0.76	100%	0.76	0.34
Level Buff Manual	Music Desk	B3 PWH	0.45	0.76	100%	0.76	0.34
Level Buff Manual	Music Desk	U1J PM/PW	0.29	0.76	100%	0.76	0.22
Level Buff Manual	Music Desk	P121 PWH	0.37	0.76	100%	0.76	0.28
Level Buff Manual	Key Slip	U1J PE	4.01	1.12	100%	1.12	4.51
Level Buff Manual	Key Slip	U1J PM/PW	0.29	1.12	100%	1.12	0.33
Level Buff Manual	Key Slip	U1J PWH	0.21	1.12	100%	1.12	0.23
Level Buff Manual	Fall Back	U1J PE	4.01	2.10	60%	1.26	5.05
Level Buff Manual	Fall Back	U1J PM/PW	0.29	2.10	60%	1.26	0.36
Level Buff Manual	Fall Back	U1J PWH	0.21	2.10	60%	1.26	0.26

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Level Buff Manual	Fall Back	P121 PE	4.05	2.10	60%	1.26	5.11
Level Buff Manual	Fall Back	P121 PWH	0.37	2.10	60%	1.26	0.47
Level Buff Manual	Fall Back	P116 PE	3.31	2.10	60%	1.26	4.17
Level Buff Manual	Fall Back	P116 PWH	0.00	2.10	60%	1.26	0.00
Level Buff Manual	Leg UP Part	Leg UP Part	36.36	6.80	50%	3.40	123.55
Total UP							490.2
Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Auto Level Buff 1	Side Arm	B1 PE	27.38	5.17	0%	0.00	0.00
Auto Level Buff 1	Side Arm	B1 PM/PW	0.58	5.17	0%	0.00	0.00
Auto Level Buff 1	Side Arm	B1 PWH	4.09	5.17	0%	0.00	0.00
Auto Level Buff 1	Side Arm	B2 PE	15.43	3.76	0%	0.00	0.00
Auto Level Buff 1	Side Arm	B2 PWH	1.49	3.76	0%	0.00	0.00
Auto Level Buff 1	Side Arm	B3 PE	26.39	5.17	0%	0.00	0.00
Auto Level Buff 1	Side Arm	B3 PWH	0.45	5.17	0%	0.00	0.00
Auto Level Buff 1	Side Arm	U1J PE	4.01	5.17	50%	2.58	10.36
Auto Level Buff 1	Side Arm	U1J PWH	0.21	5.17	50%	2.58	0.53
Auto Level Buff 1	Side Arm	P121 PE	4.05	3.76	50%	1.88	7.63
Auto Level Buff 1	Side Arm	P121 PWH	0.37	3.76	50%	1.88	0.70
Auto Level Buff 1	Side Base	B2 PE	15.43	6.49	50%	3.25	50.09
Auto Level Buff 1	Side Base	B2 PM/PW	0.45	6.49	50%	3.25	1.48
Auto Level Buff 1	Side Base	B2 PWH	1.49	6.49	50%	3.25	4.83
Auto Level Buff 1	Side Base	B3 PE	26.39	6.49	50%	3.25	85.68
Auto Level Buff 1	Side Base	B3 PM/PW	0.45	6.49	20%	1.30	0.59
Auto Level Buff 1	Side Base	B3 PWH	0.45	6.49	20%	1.30	0.59
Auto Level Buff 1	Side Base	P116 PE	3.31	6.49	20%	1.30	4.30
Auto Level Buff 1	Side Base	P116 PWH	0.00	6.49	20%	1.30	0.00
Auto Level Buff 1	Side Base	U1J PE	4.01	6.49	20%	1.30	5.21
Auto Level Buff 1	Side Base	U1J PM/PW	0.29	6.49	20%	1.30	0.38
Auto Level Buff 1	Side Base	U1J PWH	0.21	6.49	20%	1.30	0.27
Auto Level Buff 1	Side Base	P121 PE	4.05	6.49	20%	1.30	5.26
Auto Level Buff 1	Side Base	P121 PWH	0.37	6.49	20%	1.30	0.48
Auto Level Buff 1	Key Block	B1 PE	27.38	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	B1 PM/PW	0.58	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	B1 PWH	4.09	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	B2 PE	15.43	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	B2 PM/PW	0.45	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	B2 PWH	1.49	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	B3 PE	26.39	3.18	0%	0.00	0.00

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Auto Level Buff 1	Key Block	B3 PM/PW	0.45	3.18	0%	0.00	0.00
Auto Level Buff 1	Key Block	B3 PWH	0.45	3.18	0%	0.00	0.00
Auto Level Buff 1	Key Block	U1J PE	4.01	3.18	0%	0.00	0.00
Auto Level Buff 1	Key Block	U1J PM/PW	0.29	3.18	0%	0.00	0.00
Auto Level Buff 1	Key Block	U1J PWH	0.21	3.18	0%	0.00	0.00
Auto Level Buff 1	Key Block	P116 PE	3.31	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	P116 PWH	0.00	2.50	0%	0.00	0.00
Auto Level Buff 1	Key Block	P121 PE	4.05	3.18	0%	0.00	0.00
Auto Level Buff 1	Key Block	P121 PWH	0.37	3.18	0%	0.00	0.00
Auto Level Buff 1	Side Sleeve	B2 PE	15.43	1.73	20%	0.35	5.33
Auto Level Buff 1	Side Sleeve	B2 PM/PW	0.45	1.73	20%	0.35	0.16
Auto Level Buff 1	Side Sleeve	B2 PWH	1.49	1.73	20%	0.35	0.51
Auto Level Buff 1	Side Sleeve	U1J PE	4.01	1.73	20%	0.35	1.39
Auto Level Buff 1	Side Sleeve	U1J PM/PW	0.29	1.73	20%	0.35	0.10
Auto Level Buff 1	Side Sleeve	U1J PWH	0.21	1.73	20%	0.35	0.07
Auto Level Buff 1	Fall Back	U1J PE	4.01	2.70	0%	0.00	0.00
Auto Level Buff 1	Fall Back	U1J PM/PW	0.29	2.70	0%	0.00	0.00
Auto Level Buff 1	Fall Back	U1J PWH	0.21	2.70	0%	0.00	0.00
Auto Level Buff 1	Fall Back	P121 PE	4.05	2.68	0%	0.00	0.00
Auto Level Buff 1	Fall Back	P121 PWH	0.37	2.68	0%	0.00	0.00
Auto Level Buff 1	Fall Back	P116 PE	3.31	2.68	0%	0.00	0.00
Auto Level Buff 1	Fall Back	P116 PWH	0.00	2.68	0%	0.00	0.00
Auto Level Buff 1	Side Base UP Part	Side Base Yus 1	63.64	2.01	80%	1.61	102.17
Auto Level Buff 1	Side Base UP Part	Side Base Yus 3	22.73	2.01	80%	1.61	36.49
Total UP							324.6
Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Auto Level Buff 2	Side Arm	B1 PE	27.38	5.17	50%	2.58	70.73
Auto Level Buff 2	Side Arm	B1 PM/PW	0.58	5.17	50%	2.58	1.50
Auto Level Buff 2	Side Arm	B1 PWH	4.09	5.17	50%	2.58	10.58
Auto Level Buff 2	Side Arm	B2 PE	15.43	3.76	50%	1.88	29.03
Auto Level Buff 2	Side Arm	B2 PWH	1.49	3.76	50%	1.88	2.80
Auto Level Buff 2	Side Arm	B3 PE	26.39	5.17	50%	2.58	68.16
Auto Level Buff 2	Side Arm	B3 PWH	0.45	5.17	50%	2.58	1.18

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Auto Level Buff 2	Side Arm	U1J PE	4.01	5.17	50%	2.58	10.36
Auto Level Buff 2	Side Arm	U1J PWH	0.21	5.17	50%	2.58	0.53
Auto Level Buff 2	Side Arm	P121 PE	4.05	3.76	50%	1.88	7.63
Auto Level Buff 2	Side Arm	P121 PWH	0.37	3.76	50%	1.88	0.70
Auto Level Buff 2	Side Base	B2 PE	15.43	6.49	50%	3.25	50.09
Auto Level Buff 2	Side Base	B2 PM/PW	0.45	6.49	50%	3.25	1.48
Auto Level Buff 2	Side Base	B2 PWH	1.49	6.49	50%	3.25	4.83
Auto Level Buff 2	Side Base	B3 PE	26.39	6.49	50%	3.25	85.68
Auto Level Buff 2	Side Base	B3 PM/PW	0.45	6.49	50%	3.25	1.48
Auto Level Buff 2	Side Base	B3 PWH	0.45	6.49	50%	3.25	1.48
Auto Level Buff 2	Side Base	P116 PE	3.31	6.49	50%	3.25	10.74
Auto Level Buff 2	Side Base	P116 PWH	0.00	6.49	50%	3.25	0.00
Auto Level Buff 2	Side Base	U1J PE	4.01	6.49	50%	3.25	13.03
Auto Level Buff 2	Side Base	U1J PM/PW	0.29	6.49	50%	3.25	0.94
Auto Level Buff 2	Side Base	U1J PWH	0.21	6.49	50%	3.25	0.67
Auto Level Buff 2	Side Base	P121 PE	4.05	6.49	50%	3.25	13.16
Auto Level Buff 2	Side Base	P121 PWH	0.37	6.49	50%	3.25	1.21
Auto Level Buff 2	Key Block	B1 PE	27.38	2.50	50%	1.25	34.24
Auto Level Buff 2	Key Block	B1 PM/PW	0.58	2.50	50%	1.25	0.72
Auto Level Buff 2	Key Block	B1 PWH	4.09	2.50	50%	1.25	5.12
Auto Level Buff 2	Key Block	B2 PE	15.43	2.50	50%	1.25	19.29
Auto Level Buff 2	Key Block	B2 PM/PW	0.45	2.50	50%	1.25	0.57
Auto Level Buff 2	Key Block	B2 PWH	1.49	2.50	50%	1.25	1.86
Auto Level Buff 2	Key Block	B3 PE	26.39	3.18	50%	1.59	42.02
Auto Level Buff 2	Key Block	B3 PM/PW	0.45	3.18	50%	1.59	0.72
Auto Level Buff 2	Key Block	B3 PWH	0.45	3.18	50%	1.59	0.72
Auto Level Buff 2	Key Block	U1J PE	4.01	3.18	50%	1.59	6.39
Auto Level Buff 2	Key Block	U1J PM/PW	0.29	3.18	50%	1.59	0.46
Auto Level Buff 2	Key Block	U1J PWH	0.21	3.18	50%	1.59	0.33
Auto Level Buff 2	Key Block	P116 PE	3.31	2.50	50%	1.25	4.14
Auto Level Buff 2	Key Block	P116 PWH	0.00	2.50	50%	1.25	0.00
Auto Level Buff 2	Key Block	P121 PE	4.05	3.18	50%	1.59	6.45
Auto Level Buff 2	Key Block	P121 PWH	0.37	3.18	50%	1.59	0.59
Auto Level Buff 2	Side Sleeve	B2 PE	15.43	1.73	100%	1.73	26.67
Auto Level Buff 2	Side Sleeve	B2 PM/PW	0.45	1.73	100%	1.73	0.79
Auto Level Buff 2	Side Sleeve	B2 PWH	1.49	1.73	100%	1.73	2.57

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Auto Level Buff 2	Side Sleeve	U1J PE	4.01	1.73	100%	1.73	6.94
Auto Level Buff 2	Side Sleeve	U1J PM/PW	0.29	1.73	100%	1.73	0.50
Auto Level Buff 2	Side Sleeve	U1J PWH	0.21	1.73	100%	1.73	0.36
Auto Level Buff 2	Fall Back	U1J PE	4.01	2.70	0%	0.00	0.00
Auto Level Buff 2	Fall Back	U1J PM/PW	0.29	2.70	0%	0.00	0.00
Auto Level Buff 2	Fall Back	U1J PWH	0.21	2.70	0%	0.00	0.00
Auto Level Buff 2	Fall Back	P121 PE	4.05	2.68	0%	0.00	0.00
Auto Level Buff 2	Fall Back	P121 PWH	0.37	2.68	0%	0.00	0.00
Auto Level Buff 2	Fall Back	P116 PE	3.31	2.68	0%	0.00	0.00
Auto Level Buff 2	Fall Back	P116 PWH	0.00	2.68	0%	0.00	0.00
Auto Level Buff 2	Side Base UP Part	Side Base Yus 1	63.64	2.01	20%	0.40	25.54
Auto Level Buff 2	Side Base UP Part	Side Base Yus 3	22.73	2.01	20%	0.40	9.12
Total UP							584.12
Edge Buff	Side Arm	B1 PE	27.38	0.39	100%	0.39	10.65
Edge Buff	Side Arm	B1 PM/PW	0.58	0.39	100%	0.39	0.23
Edge Buff	Side Arm	B1 PWH	4.09	0.39	100%	0.39	1.59
Edge Buff	Side Arm	B2 PE	15.43	0.39	100%	0.39	6.00
Edge Buff	Side Arm	B2 PM/PW	0.45	0.39	100%	0.39	0.18
Edge Buff	Side Arm	B2 PWH	1.49	0.39	100%	0.39	0.58
Edge Buff	Side Arm	B3 PE	26.39	0.39	100%	0.39	10.26
Edge Buff	Side Arm	B3 PM/PW	0.45	0.39	100%	0.39	0.18
Edge Buff	Side Arm	B3 PWH	0.45	0.39	100%	0.39	0.18
Edge Buff	Side Arm	U1J PE	4.01	0.39	100%	0.39	1.56
Edge Buff	Side Arm	U1J PM/PW	0.29	0.39	100%	0.39	0.11
Edge Buff	Side Arm	U1J PWH	0.21	0.39	100%	0.39	0.08
Edge Buff	Side Arm	P116 PE	3.31	0.39	100%	0.39	1.29
Edge Buff	Side Arm	P116 PWH	0.00	0.39	100%	0.39	0.00
Edge Buff	Side Arm	P121 PE	4.05	0.39	100%	0.39	1.58
Edge Buff	Side Arm	P121 PWH	0.37	0.56	100%	0.56	0.21
Edge Buff	Side Base	B2 PE	15.43	0.41	100%	0.41	6.40
Edge Buff	Side Base	B2 PM/PW	0.45	0.41	100%	0.41	0.19
Edge Buff	Side Base	B2 PWH	1.49	0.41	100%	0.41	0.62
Edge Buff	Side Base	B3 PE	26.39	0.41	100%	0.41	10.95
Edge Buff	Side Base	B3 PM/PW	0.45	0.41	100%	0.41	0.19
Edge Buff	Side Base	B3 PWH	0.45	0.41	100%	0.41	0.19
Edge Buff	Side Base	P116 PE	3.31	0.41	100%	0.41	1.37

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Edge Buff	Side Base	P116 PWH	0.00	0.41	100%	0.41	0.00
Edge Buff	Side Base	U1J PE	4.01	0.41	100%	0.41	1.66
Edge Buff	Side Base	U1J PM/PW	0.29	0.41	100%	0.41	0.12
Edge Buff	Side Base	U1J PWH	0.21	0.41	100%	0.41	0.09
Edge Buff	Side Base	P121 PE	4.05	0.41	100%	0.41	1.68
Edge Buff	Side Base	P121 PWH	0.37	0.41	100%	0.41	0.15
Edge Buff	Key Block	B1 PE	27.38	0.58	100%	0.58	15.97
Edge Buff	Key Block	B1 PM/PW	0.58	0.58	100%	0.58	0.34
Edge Buff	Key Block	B1 PWH	4.09	0.58	100%	0.58	2.39
Edge Buff	Key Block	B2 PE	15.43	0.58	100%	0.58	9.00
Edge Buff	Key Block	B2 PM/PW	0.45	0.58	100%	0.58	0.27
Edge Buff	Key Block	B2 PWH	1.49	0.58	100%	0.58	0.87
Edge Buff	Key Block	B3 PE	26.39	0.23	100%	0.23	6.16
Edge Buff	Key Block	B3 PM/PW	0.45	0.23	100%	0.23	0.11
Edge Buff	Key Block	B3 PWH	0.45	0.23	100%	0.23	0.11
Edge Buff	Key Block	U1J PE	4.01	0.23	100%	0.23	0.94
Edge Buff	Key Block	U1J PM/PW	0.29	0.23	100%	0.23	0.07
Edge Buff	Key Block	U1J PWH	0.21	0.23	100%	0.23	0.05
Edge Buff	Key Block	P116 PE	3.31	0.43	100%	0.43	1.42
Edge Buff	Key Block	P116 PWH	0.00	0.43	100%	0.43	0.00
Edge Buff	Key Block	P121 PE	4.05	0.43	100%	0.43	1.73
Edge Buff	Key Block	P121 PWH	0.37	0.43	100%	0.43	0.16
Edge Buff	Top Frame C	U1J PE	4.01	0.54	100%	0.54	2.18
Edge Buff	Top Frame C	U1J PM/PW	0.29	0.54	100%	0.54	0.16
Edge Buff	Top Frame C	U1J PWH	0.21	0.54	100%	0.54	0.11
Edge Buff	Top Frame Side	U1J PE	4.01	0.93	100%	0.93	3.71
Edge Buff	Top Frame Side	U1J PM/PW	0.29	0.93	100%	0.93	0.27
Edge Buff	Top Frame Side	U1J PWH	0.21	0.93	100%	0.93	0.19
Edge Buff	Side Base UP Part	Side Base Yus 1	63.64	0.19	100%	0.19	12.02
Edge Buff	Side Base UP Part	Side Base Yus 3	22.73	0.19	100%	0.19	4.29
Total UP							120.76
Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST Operator	Total ST
Small Buff	Side Arm	B3 PE	26.39	1.66	100%	1.66	43.76

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Small Buff	Side Arm	B3 PWH	0.45	1.66	100%	1.66	0.75
Small Buff	Side Arm	U1J PE	4.01	1.66	100%	1.66	6.65
Small Buff	Side Arm	U1J PWH	0.21	1.66	100%	1.66	0.34
Small Buff	Side Arm	P121 PE	4.05	0.63	100%	0.63	2.57
Small Buff	Side Arm	P121 PWH	0.37	0.63	100%	0.63	0.24
Small Buff	Side Base	B2 PE	15.43	0.46	100%	0.46	7.17
Small Buff	Side Base	B2 PM/PW	0.45	0.62	100%	0.62	0.28
Small Buff	Side Base	B2 PWH	1.49	0.62	100%	0.62	0.92
Small Buff	Side Base	B3 PE	26.39	0.46	100%	0.46	12.26
Small Buff	Side Base	B3 PM/PW	0.45	0.62	100%	0.62	0.28
Small Buff	Side Base	B3 PWH	0.45	0.62	100%	0.62	0.28
Small Buff	Side Base	P116 PE	3.31	0.46	100%	0.46	1.54
Small Buff	Side Base	P116 PWH	0.00	0.62	100%	0.62	0.00
Small Buff	Side Base	U1J PE	4.01	0.46	100%	0.46	1.86
Small Buff	Side Base	U1J PM/PW	0.29	0.62	100%	0.62	0.18
Small Buff	Side Base	U1J PWH	0.21	0.62	100%	0.62	0.13
Small Buff	Side Sleeve	B3 PE	26.39	0.50	100%	0.50	13.27
Small Buff	Side Sleeve	B3 PM/PW	0.45	0.67	100%	0.67	0.30
Small Buff	Side Sleeve	B3 PWH	0.45	0.67	100%	0.67	0.30
Small Buff	Key Slip	B1 PE	27.38	0.40	100%	0.40	11.02
Small Buff	Key Slip	B1 PM/PW	0.58	0.70	100%	0.70	0.41
Small Buff	Key Slip	B1 PWH	4.09	0.70	100%	0.70	2.88
Small Buff	Key Slip	B2 PE	15.43	0.40	100%	0.40	6.21
Small Buff	Key Slip	B2 PM/PW	0.45	0.70	100%	0.70	0.32
Small Buff	Key Slip	B2 PWH	1.49	0.70	100%	0.70	1.05
Small Buff	Key Slip	B3 PE	26.39	0.40	100%	0.40	10.62
Small Buff	Key Slip	B3 PM/PW	0.45	0.70	100%	0.70	0.32
Small Buff	Key Slip	B3 PWH	0.45	0.70	100%	0.70	0.32
Small Buff	Key Slip	P121 PE	4.05	0.40	100%	0.40	1.63
Small Buff	Key Slip	P121 PWH	0.37	0.70	100%	0.70	0.26
Small Buff	Key Slip	P116 PE	3.31	0.40	100%	0.40	1.33
Small Buff	Key Slip	P116 PWH	0.00	0.70	100%	0.70	0.00
Small Buff	Fall Back	B1 PE	27.38	0.31	100%	0.31	8.37
Small Buff	Fall Back	B1 PM/PW	0.58	0.33	100%	0.33	0.19
Small Buff	Fall Back	B1 PWH	4.09	0.33	100%	0.33	1.36
Small Buff	Fall Back	B2 PE	15.43	0.31	100%	0.31	4.71
Small Buff	Fall Back	B2 PM/PW	0.45	0.33	100%	0.33	0.15

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Small Buff	Fall Back	B2 PWH	1.49	0.33	100%	0.33	0.50
Small Buff	Fall Back	B3 PE	26.39	0.31	100%	0.31	8.06
Small Buff	Fall Back	B3 PM/PW	0.45	0.33	100%	0.33	0.15
Small Buff	Fall Back	B3 PWH	0.45	0.33	100%	0.33	0.15
Small Buff	Pedal Rail	B1 PE	27.38	0.21	100%	0.21	5.66
Small Buff	Pedal Rail	B1 PM/PW	0.58	0.27	100%	0.27	0.15
Small Buff	Pedal Rail	B1 PWH	4.09	0.27	100%	0.27	1.09
Small Buff	Pedal Rail	B2 PE	15.43	0.21	100%	0.21	3.19
Small Buff	Pedal Rail	B2 PM/PW	0.45	0.27	100%	0.27	0.12
Small Buff	Pedal Rail	B2 PWH	1.49	0.27	100%	0.27	0.40
Small Buff	Pedal Rail	B3 PE	26.39	0.21	100%	0.21	5.45
Small Buff	Pedal Rail	B3 PM/PW	0.45	0.27	100%	0.27	0.12
Small Buff	Pedal Rail	B3 PWH	0.45	0.27	100%	0.27	0.12
Small Buff	Pedal Rail	U1J PE	4.01	0.21	100%	0.21	0.83
Small Buff	Pedal Rail	U1J PM/PW	0.29	0.27	100%	0.27	0.08
Small Buff	Pedal Rail	U1J PWH	0.21	0.27	100%	0.27	0.06
Small Buff	Pedal Rail	P121 PE	4.05	0.21	100%	0.21	0.84
Small Buff	Pedal Rail	P121 PWH	0.37	0.27	100%	0.27	0.10
Small Buff	Pedal Rail	P116 PE	3.31	0.21	100%	0.21	0.68
Small Buff	Pedal Rail	P116 PWH	0.00	0.21	100%	0.21	0.00
Small Buff	Hinge Strip	B1 PE	27.38	0.15	100%	0.15	4.24
Small Buff	Hinge Strip	B1 PM/PW	0.58	0.16	100%	0.16	0.10
Small Buff	Hinge Strip	B1 PWH	4.09	0.16	100%	0.16	0.67
Small Buff	Hinge Strip	B2 PE	15.43	0.16	100%	0.16	2.47
Small Buff	Hinge Strip	B2 PM/PW	0.45	0.16	100%	0.16	0.07
Small Buff	Hinge Strip	B2 PWH	1.49	0.16	100%	0.16	0.24
Small Buff	Hinge Strip	B3 PE	26.39	0.15	100%	0.15	4.08
Small Buff	Hinge Strip	B3 PM/PW	0.45	0.16	100%	0.16	0.07
Small Buff	Hinge Strip	B3 PWH	0.45	0.16	100%	0.16	0.07
Small Buff	Hinge Strip	U1J PE	4.01	0.15	100%	0.15	0.62
Small Buff	Hinge Strip	U1J PM/PW	0.29	0.16	100%	0.16	0.05

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Small Buff	Hinge Strip	U1J PWH	0.21	0.16	100%	0.16	0.03
Small Buff	Hinge Strip	P121 PE	4.05	0.15	100%	0.15	0.63
Small Buff	Hinge Strip	P121 PWH	0.37	0.16	100%	0.16	0.06
Small Buff	Hinge Strip	P116 PE	3.31	0.15	100%	0.15	0.51
Small Buff	Hinge Strip	P116 PWH	0.00	0.16	100%	0.16	0.00
Small Buff	Fall Front	B1 PE	27.38	0.95	100%	0.95	25.99
Small Buff	Fall Front	B1 PM/PW	0.58	1.08	100%	1.08	0.62
Small Buff	Fall Front	B1 PWH	4.09	1.08	100%	1.08	4.41
Small Buff	Fall Front	B2 PE	15.43	0.95	100%	0.95	14.64
Small Buff	Fall Front	B2 PM/PW	0.45	1.08	100%	1.08	0.49
Small Buff	Fall Front	B2 PWH	1.49	1.08	100%	1.08	1.60
Small Buff	Fall Front	B3 PE	26.39	0.95	100%	0.95	25.04
Small Buff	Fall Front	B3 PM/PW	0.45	1.08	100%	1.08	0.49
Small Buff	Fall Front	B3 PWH	0.45	1.08	100%	1.08	0.49
Small Buff	Fall Front	P116 PE	3.31	0.95	100%	0.95	3.14
Small Buff	Fall Front	P116 PWH	0.00	1.08	100%	1.08	0.00
Small Buff	Side Base UP Part	Side Base Yus 1	63.64	0.26	100%	0.26	16.28
Small Buff	Side Base UP Part	Side Base Yus 3	22.73	0.26	100%	0.26	5.82
Total UP							284.93
Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST Operator	Total ST
Ryoto Kasar	Side Arm	B1 PE	27.38	0.74	100%	0.74	20.38
Ryoto Kasar	Side Arm	B1 PM/PW	0.58	2.81	100%	2.81	1.63
Ryoto Kasar	Side Arm	B1 PWH	4.09	1.23	100%	1.23	5.05
Ryoto Kasar	Side Arm	B2 PE	15.43	1.97	100%	1.97	30.34
Ryoto Kasar	Side Arm	B2 PM/PW	0.45	2.81	100%	2.81	1.28
Ryoto Kasar	Side Arm	B2 PWH	1.49	1.23	100%	1.23	1.84
Ryoto Kasar	Side Arm	B3 PE	26.39	2.71	100%	2.71	71.53
Ryoto Kasar	Side Arm	B3 PM/PW	0.45	2.81	100%	2.81	1.28
Ryoto Kasar	Side Arm	B3 PWH	0.45	1.23	100%	1.23	0.56
Ryoto Kasar	Side Arm	U1J PE	4.01	2.10	100%	2.10	8.42
Ryoto Kasar	Side Arm	U1J PM/PW	0.29	2.81	100%	2.81	0.81
Ryoto Kasar	Side Arm	U1J PWH	0.21	1.23	100%	1.23	0.26
Ryoto Kasar	Side Arm	P121 PE	4.05	1.97	100%	1.97	7.97
Ryoto Kasar	Side Arm	P121 PWH	0.37	1.23	100%	1.23	0.46

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Ryoto Kasar	Side Arm	P116 PE	3.31	1.97	100%	1.97	6.51
Ryoto Kasar	Side Arm	P116 PWH	0.00	1.23	100%	1.23	0.00
Ryoto Kasar	Leg	B2 PE	15.43	2.63	100%	2.63	40.62
Ryoto Kasar	Leg	B2 PM/PW	0.45	3.35	100%	3.35	1.52
Ryoto Kasar	Leg	B2 PWH	1.49	2.22	100%	2.22	3.30
Ryoto Kasar	Leg	B3 PE	26.39	2.63	100%	2.63	69.48
Ryoto Kasar	Leg	B3 PM/PW	0.45	3.35	100%	3.35	1.52
Ryoto Kasar	Leg	B3 PWH	0.45	2.22	100%	2.22	1.01
Ryoto Kasar	Leg	U1J PE	4.01	2.63	100%	2.63	10.56
Ryoto Kasar	Leg	U1J PM/PW	0.29	3.35	100%	3.35	0.97
Ryoto Kasar	Leg	U1J PWH	0.21	2.22	100%	2.22	0.46
Ryoto Kasar	Leg	P121 PE	4.05	2.63	100%	2.63	10.67
Ryoto Kasar	Leg	P121 PWH	0.37	2.22	100%	2.22	0.83
Ryoto Kasar	Leg	P116 PE	3.31	2.63	100%	2.63	8.71
Ryoto Kasar	Leg	P116 PWH	0.00	2.22	100%	2.22	0.00
Ryoto Kasar	Side Base	B2 PE	15.43	1.50	100%	1.50	23.14
Ryoto Kasar	Side Base	B2 PM/PW	0.45	1.50	100%	1.50	0.68
Ryoto Kasar	Side Base	B2 PWH	1.49	1.50	100%	1.50	2.23
Ryoto Kasar	Side Base	B3 PE	26.39	1.50	100%	1.50	39.58
Ryoto Kasar	Side Base	B3 PM/PW	0.45	1.50	100%	1.50	0.68
Ryoto Kasar	Side Base	B3 PWH	0.45	1.50	100%	1.50	0.68
Ryoto Kasar	Side Base	U1J PE	4.01	1.50	100%	1.50	6.02
Ryoto Kasar	Side Base	U1J PM/PW	0.29	1.50	100%	1.50	0.43
Ryoto Kasar	Side Base	U1J PWH	0.21	1.50	100%	1.50	0.31
Ryoto Kasar	Side Base	P121 PE	4.05	1.50	100%	1.50	6.08
Ryoto Kasar	Side Base	P121 PWH	0.37	1.50	100%	1.50	0.56
Ryoto Kasar	Side Base	P116 PE	3.31	1.50	100%	1.50	4.96
Ryoto Kasar	Side Base	P116 PWH	0.00	1.50	100%	1.50	0.00
Ryoto Kasar	Top Frame R/L	B2 PE	15.43	1.38	100%	1.38	21.21
Ryoto Kasar	Top Frame R/L	B2 PM/PW	0.45	2.25	100%	2.25	1.02
Ryoto Kasar	Top Frame R/L	B2 PWH	1.49	1.14	100%	1.14	1.70
Ryoto Kasar	Top Frame R/L	B3 PE	26.39	1.38	100%	1.38	36.28
Ryoto Kasar	Top Frame R/L	B3 PM/PW	0.45	2.25	100%	2.25	1.02
Ryoto Kasar	Top Frame R/L	B3 PWH	0.45	1.51	100%	1.51	0.69

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Ryoto Kasar	Top Frame R/L	U1J PE	4.01	1.38	100%	1.38	5.52
Ryoto Kasar	Top Frame R/L	U1J PM/PW	0.29	2.25	100%	2.25	0.65
Ryoto Kasar	Top Frame R/L	U1J PWH	0.21	1.14	100%	1.14	0.24
Ryoto Kasar	Top Frame R/L	P121 PE	4.05	1.38	100%	1.38	5.57
Ryoto Kasar	Top Frame R/L	P121 PWH	0.37	1.14	100%	1.14	0.42
Ryoto Kasar	Top Frame R/L	P116 PE	3.31	1.38	100%	1.38	4.55
Ryoto Kasar	Top Frame R/L	P116 PWH	0.00	1.14	100%	1.14	0.00
Ryoto Kasar	Key Block	B1 PE	27.38	1.60	100%	1.60	43.81
Ryoto Kasar	Key Block	B1 PM/PW	0.58	0.60	100%	0.60	0.35
Ryoto Kasar	Key Block	B1 PWH	4.09	0.60	100%	0.60	2.46
Ryoto Kasar	Key Block	B2 PE	15.43	0.81	100%	0.81	12.47
Ryoto Kasar	Key Block	B2 PM/PW	0.45	0.62	100%	0.62	0.28
Ryoto Kasar	Key Block	B2 PWH	1.49	0.60	100%	0.60	0.89
Ryoto Kasar	Key Block	B3 PE	26.39	0.00	100%	0.00	0.00
Ryoto Kasar	Key Block	B3 PM/PW	0.45	1.70	100%	1.70	0.77
Ryoto Kasar	Key Block	B3 PWH	0.45	0.60	100%	0.60	0.27
Ryoto Kasar	Key Block	U1J PE	4.01	0.00	100%	0.00	0.00
Ryoto Kasar	Key Block	U1J PM/PW	0.29	1.70	100%	1.70	0.49
Ryoto Kasar	Key Block	U1J PWH	0.21	0.60	100%	0.60	0.12
Ryoto Kasar	Key Block	P121 PE	4.05	0.60	100%	0.60	2.43
Ryoto Kasar	Key Block	P121 PWH	0.37	0.60	100%	0.60	0.22
Ryoto Kasar	Key Block	P116 PE	3.31	0.60	100%	0.60	1.99
Ryoto Kasar	Key Block	P116 PWH	0.00	0.60	100%	0.60	0.00
Ryoto Kasar	Side Sleeve	B2 PE	15.43	0.20	100%	0.20	3.09
Ryoto Kasar	Side Sleeve	B2 PM/PW	0.45	0.22	100%	0.22	0.10
Ryoto Kasar	Side Sleeve	B2 PWH	1.49	0.18	100%	0.18	0.27
Ryoto Kasar	Side Sleeve	B3 PE	26.39	0.21	100%	0.21	5.54
Ryoto Kasar	Side Sleeve	B3 PM/PW	0.45	0.24	100%	0.24	0.11
Ryoto Kasar	Side Sleeve	B3 PWH	0.45	0.20	100%	0.20	0.09
Ryoto Kasar	Side Sleeve	U1J PE	4.01	0.20	100%	0.20	0.80

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Ryoto Kasar	Side Sleeve	U1J PM/PW	0.29	0.22	100%	0.22	0.06
Ryoto Kasar	Side Sleeve	U1J PWH	0.21	0.18	100%	0.18	0.04
Ryoto Kasar	Side Sleeve	P121 PE	4.05	0.20	100%	0.20	0.81
Ryoto Kasar	Side Sleeve	P121 PWH	0.37	0.18	100%	0.18	0.07
Ryoto Kasar	Side Sleeve	P116 PE	3.31	0.20	100%	0.20	0.66
Ryoto Kasar	Side Sleeve	P116 PWH	0.00	0.18	100%	0.18	0.00
Ryoto Kasar	Top Frame Side	U1J PE	4.01	0.96	100%	0.96	3.85
Ryoto Kasar	Top Frame Side	U1J PM/PW	0.29	0.97	100%	0.97	0.28
Ryoto Kasar	Top Frame Side	U1J PWH	0.21	0.93	100%	0.93	0.19
Ryoto Kasar	Top Frame Sill	U1J PE	4.01	1.24	100%	1.24	4.97
Ryoto Kasar	Top Frame Sill	U1J PM/PW	0.29	1.24	100%	1.24	0.36
Ryoto Kasar	Top Frame Sill	U1J PWH	0.21	1.24	100%	1.24	0.26
Ryoto Kasar	Leg Top Block	P121 PE	4.05	0.80	100%	0.80	3.23
Ryoto Kasar	Leg Top Block	P121 PWH	0.37	1.20	100%	1.20	0.45
Ryoto Kasar	Music Desk	B1 PM/PW	0.58	3.30	100%	3.30	1.91
Ryoto Kasar	Music Desk	B1 PWH	4.09	0.00	100%	0.00	0.00
Ryoto Kasar	Music Desk	B2 PM/PW	0.45	3.30	100%	3.30	1.50
Ryoto Kasar	Music Desk	B2 PWH	1.49	0.00	100%	0.00	0.00
Ryoto Kasar	Music Desk	B3 PM/PW	0.45	3.30	100%	3.30	1.50
Ryoto Kasar	Music Desk	B3 PWH	0.45	0.00	100%	0.00	0.00
Ryoto Kasar	Music Desk	U1J PM/PW	0.29	3.30	100%	3.30	0.96
Ryoto Kasar	Music Desk	P121 PWH	0.37	0.00	100%	0.00	0.00
Ryoto Kasar	Key Slip	U1J PE	4.01	0.00	100%	0.00	0.00
Ryoto Kasar	Key Slip	U1J PM/PW	0.29	0.00	100%	0.00	0.00

Proses	Kabinet	Model	Plan Produksi	ST Net	Prosentase Kerja	ST mesin	Total ST
Ryoto Kasar	Key Slip	U1J PWH	0.21	0.00	100%	0.00	0.00
Ryoto Kasar	Fallback	U1J PE	4.01	2.12	100%	2.12	8.49
Ryoto Kasar	Fallback	U1J PM/PW	0.29	3.55	100%	3.55	1.03
Ryoto Kasar	Fallback	U1J PWH	0.21	2.10	100%	2.10	0.43
Ryoto Kasar	Fallback	P121 PE	4.05	2.10	100%	2.10	8.51
Ryoto Kasar	Fallback	P121 PWH	0.37	2.10	100%	2.10	0.78
Ryoto Kasar	Fallback	P116 PE	3.31	2.10	100%	2.10	6.95
Ryoto Kasar	Fallback	P116 PWH	0.00	2.10	100%	2.10	0.00
Ryoto Kasar	Fall Front	B1 PE	27.38	0.38	100%	0.38	10.49
Ryoto Kasar	Fall Front	B1 PM/PW	0.58	0.40	100%	0.40	0.23
Ryoto Kasar	Fall Front	B1 PWH	4.09	0.30	100%	0.30	1.23
Ryoto Kasar	Fall Front	B2 PE	15.43	0.38	100%	0.38	5.91
Ryoto Kasar	Fall Front	B2 PM/PW	0.45	0.40	100%	0.40	0.18
Ryoto Kasar	Fall Front	B2 PWH	1.49	0.30	100%	0.30	0.45
Ryoto Kasar	Fall Front	B3 PE	26.39	0.38	100%	0.38	10.11
Ryoto Kasar	Fall Front	B3 PM/PW	0.45	0.40	100%	0.40	0.18
Ryoto Kasar	Fall Front	B3 PWH	0.45	0.30	100%	0.30	0.14
Ryoto Kasar	Fall Front	P116 PE	3.31	0.38	100%	0.38	1.27
Ryoto Kasar	Fall Front	P116 PWH	0.00	0.30	100%	0.30	0.00
Total UP							626.26