


LAMPIRAN

Lembar Kerja CT

NOYER		TIME STUDY PT. GLOBALINDO INTIMATES				STYLE						
VF						76080 C22047						
LINE						TOTAL SMV						
PAC (RS)						TOTAL MP						
DATE						TARGET/DAY						
18/03/19												
NO	CELL	NAME OPERATOR	OPERATION	MACHINE	MAN POWER	CYCLE TIME					AVERAGE CT	REMARK
						1	2	3	4	5		
1	MAKE #2, CENTER PANEL	OKTA	Join bottom center lines	Z	1	6.7	6.92	6.96	7.43	8.36	7.179	
2		Tri	Base Side + Join Top	SN	1	13.74	15.09	14.51	16.23	15.81	15.302	
3												
4												
5												
1	MAKE #3, BACK WINGS	BATHAYU	Dasar Bottom	Z	1	9.63	10.07	9.16	9.38	9.97	9.636	
2		ALVY	Second Bottom	Z	1	6.11	6.58	2.85	8.24	6.69	7.094	
3		SUMAWATI	Dasar Top Back	Z	1	8.57	8.0	8.80	9.12	8.14	8.526	
4		ARIPIN	Dasar center back	Z	1	10.90	11.4	11.35	11.98	11.43	11.514	
5		ARIF	Second TOP BACK	Z	1	17.73	20.92	18.58	20.53	21.57	19.744	
6		UDIN	Second center back	Z	1	17.83	15.83	16.93	20.51	18.83	17.786	
7		IKA	Hook & eye	Z	1	20.09	23.17	21.72	18.72	23.09	21.078	
8		Tri	Locking	Z	1	21.38	23.55	24.32	22.77	25.47	23.488	
9												
10												
11												
1	MAKE #4 CUP	VICKY	Check Mand	M	1	16.83	15.47	29.93	16.68	19.46	17.226	
2		CHALWI	Attach Stabilizer	SN	1	14.88	13.77	13.53	15.48	14.67	14.368	
3		SOPA	Order neckline & bottom	overlock	1	63.07	64.87	61.43	62.48	65.41	63.552	
4		ARIF	Base Mand Underbust	SN	1	27.87	31.57	34.51	33.62	30.24	31.65	
5		ANDI	Stabilizer Underbust	SN	1	11.61	12.88	11.52	14.88	11.02	11.752	
6												
7												
8												
9												
10												
11												
1	ASSEMBLY	Supartini	Join Cup To back	SN	1	53.63	57.97	53.33	58.70	57.85	58.089	
2		Aris	DN wire	DN	1	40.04	41.22	40.62	42.57	41.62	41.214	
3		MALINI	Insert wire	M	1	24.72	23.46	24.62	19.80	23.43	24.306	
4		SITI	Passing wire loop	M	1	15.47	12.67	11.06	19.34	12.61	13.22	
5		RISWAN	Bartrac wire	Bartrac	1	28.40	25.48	22.81	24.15	23.43	23.534	
6		ALDI	Bartrac wire to cup & connect Bartrac	Bartrac	1	43.31	45.33	47.90	44.53	48.11	46.44	
7												
8												
9												
10												
11												
TOTAL												