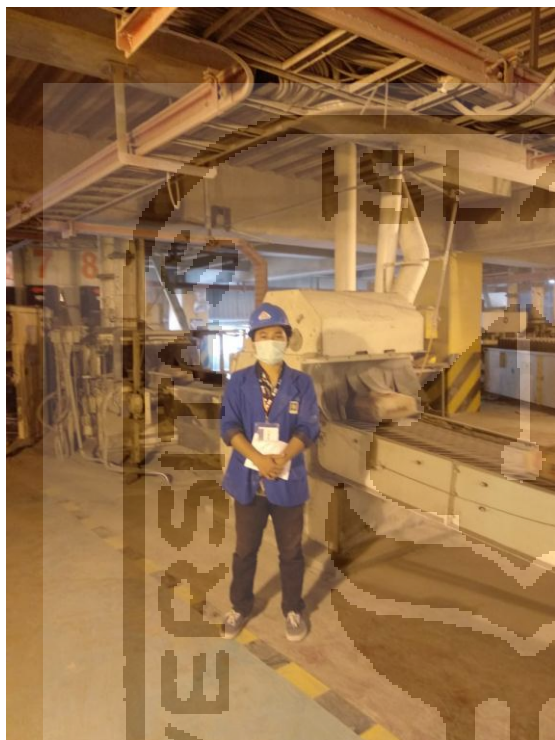


## LAMPIRAN

### Lampiran Gambar Bukti Kegiatan dan Gambar Produk



Lampiran Perhitungan Nilai *Availability* pada Mesin *Rotary Packer* 63OPM1

Menghitung Nilai <i>Availability</i> Mesin 63OPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times</i> (Hour)	467,4	448,2	450,9	430,0	487,8	454,1	418,8	484,0	478,9	481,9	407,7	476,9
Jumlah Waktu <i>Downtime</i> Mesin (Hour) / <i>Planned Downtime</i>	0,0	0,0	0,0	0,0	0,0	11,0	0,0	0,0	0,0	0,0	0,0	0,0
<i>Loading Time</i> (Hour)	467,4	448,2	450,9	430,0	487,8	443,1	418,8	484,0	478,9	481,9	407,7	476,9
Waktu <i>Setup and Adjustment</i> (Hour)	118,4	115,3	112,2	99,1	81,6	105,8	94,3	93,6	81,5	94,4	66,3	105,2
Waktu <i>Breakdown</i> Mesin (Hour)	32,3	34,6	56,6	70,4	53,1	59,3	49,7	42,4	39,6	43,7	26,0	37,9
<i>Downtime</i> (Hour)	150,7	150,0	168,7	169,4	134,7	165,1	144,0	136,0	121,1	138,1	92,3	143,1
<i>Operation Time</i> (Hour)	316,7	298,2	282,1	260,6	353,1	278,0	274,9	348,0	357,8	343,8	315,4	333,8
<b><i>Availability</i></b>	<b>67,76%</b>	<b>66,54%</b>	<b>62,58%</b>	<b>60,60%</b>	<b>72,39%</b>	<b>62,74%</b>	<b>65,63%</b>	<b>71,91%</b>	<b>74,71%</b>	<b>71,34%</b>	<b>77,36%</b>	<b>70,00%</b>

Lampiran Perhitungan Nilai *Performance* pada Mesin Rotary Packer 63OPM1

Menghitung Nilai <i>Performance</i> Mesin 63OPM1													
Indikator	Periode												
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18	
<i>Machine Working Times (Hour)</i>	467,37	448,16	450,87	430,04	487,8	454,1	418,82	484,02	478,88	481,88	407,7	476,92	
Jumlah Produksi Kotor (JPK) (PCS)	732886	708589	645023	624762	801893	652028	628500	831471	836646	820685	754491	778567	
<i>Run Time (Hour)</i>	316,7	298,2	282,1	260,6	353,1	289,0	274,9	348,0	357,8	343,8	315,4	333,8	
<i>Actual Cycle Time (Hour)</i>	0,00064	0,00063	0,00070	0,00069	0,00061	0,00070	0,00067	0,00058	0,00057	0,00059	0,00054	0,00061	
<i>Ideal Cycle time (Hour)</i>	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,00041 7	0,000417
Waktu Aktual Produksi (Hour)	316,7	298,2	282,1	260,6	353,1	278,0	274,9	348,0	357,8	343,8	315,4	333,8	
<b><i>Performance</i></b>	<b>65,34%</b>	<b>65,88%</b>	<b>59,61%</b>	<b>60,53%</b>	<b>68,50%</b>	<b>59,83%</b>	<b>62,53%</b>	<b>71,58%</b>	<b>72,79%</b>	<b>70,96%</b>	<b>77,11%</b>	<b>68,02%</b>	

Lampiran Perhitungan Nilai *Quality* pada Mesin *Rotary Packer 63OPM1*

Menghitung Nilai <i>Quality</i> Mesin 63OPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
Jumlah Produksi Kotor (JPK) (PCS)	732886	708589	645023	624762	801893	652028	628500	831471	836646	820685	754491	778567
Jumlah Produk Cacat (Scrap)	973	837	1078	1204	1122	916	767	1114	964	792	247	1020
Jumlah Produk Rework	0	0	0	0	0	0	0	0	0	0	0	0
Jumlah Produk Bersih (PCS)	731913	707752	643945	623558	800771	651112	627733	830357	835682	819893	754244	777547,333 3
<b>Quality</b>	<b>99,87%</b>	<b>99,88%</b>	<b>99,83%</b>	<b>99,81%</b>	<b>99,86%</b>	<b>99,86%</b>	<b>99,88%</b>	<b>99,87%</b>	<b>99,88%</b>	<b>99,90%</b>	<b>99,97%</b>	<b>99,87%</b>

Lampiran Perhitungan Nilai *Availability* pada Mesin *Rotary Packer* 63PPM1

Menghitung Nilai <i>Availability</i> Mesin 63PPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times</i> (Hour)	476,85	445,36	457,02	427,10	478,43	468,15	430,67	492,68	443,23	505,52	393,30	481,02
Jumlah Waktu <i>Downtime</i> Mesin (Hour) / <i>Planned Downtime</i>	0	0	0	0	0	10	0	0	28	0	0	0
<i>Loading Time</i> (Hour)	476,85	445,36	457,02	427,10	478,43	458,15	430,67	492,68	415,23	505,52	393,30	481,02
Waktu <i>Setup and Adjustment</i> (Hour)	107,3	119,6	104,61	87,35	82,6	99,05	96,63	89,5	88,42	83,15	61,3	92,43
Waktu <i>Breakdown</i> Mesin (Hour)	35,7	50,8	58,3	85,1	59,0	52,8	32,7	37,8	41,2	31,3	45,4	46,6
<i>Downtime</i> (Hour)	143,0	170,4	162,9	172,5	141,6	151,9	129,3	127,3	129,6	114,5	106,7	139,0
<i>Operation Time</i> (Hour)	333,9	275,0	294,1	254,6	336,9	306,3	301,3	365,4	285,6	391,0	286,6	342,0
<b><i>Availability</i></b>	<b>70,02%</b>	<b>61,75%</b>	<b>64,36%</b>	<b>59,62%</b>	<b>70,41%</b>	<b>66,86%</b>	<b>69,97%</b>	<b>74,16%</b>	<b>68,79%</b>	<b>77,35%</b>	<b>72,87%</b>	<b>71,11%</b>

Lampiran Perhitungan Nilai *Performance* pada Mesin *Rotary Packer 63PPM1*

Menghitung Nilai <i>Performance</i> Mesin 63PPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times (Hour)</i>	476,85	445,36	457,02	427,10	478,43	468,15	430,67	492,68	443,23	505,52	393,30	481,02
Jumlah Produksi Kotor (JPK) (PCS)	801185	653048	700666	607270	805222	731708	703199	862547	679691	918338	676177	814071
<i>Run Time (Hour)</i>	333,9	275,0	294,1	254,6	336,9	316,3	301,3	365,4	313,6	391,0	286,6	342,0
<i>Actual Cycle Time (Hour)</i>	0,00060	0,00068	0,00065	0,00070	0,00059	0,00064	0,00061	0,00057	0,00065	0,00055	0,00058	0,00059
<i>Ideal Cycle time (Hour)</i>	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417
Waktu Aktual Produksi (Hour)	310	230	303,74	312	212	299,63	281,25	252	333	338	272,68	378,37
<b><i>Performance</i></b>	<b>70,01%</b>	<b>61,10%</b>	<b>63,88%</b>	<b>59,24%</b>	<b>70,13%</b>	<b>65,12%</b>	<b>68,03%</b>	<b>72,95%</b>	<b>63,90%</b>	<b>75,69%</b>	<b>71,63%</b>	<b>70,52%</b>

Lampiran Perhitungan Nilai *Quality* pada Mesin *Rotary Packer 63PPM1*

Menghitung Nilai <i>Quality</i> Mesin 63PPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
Jumlah Produksi Kotor (JPK) (PCS)	801185	653048	700666	607270	805222	731708	703199	862547	679691	918338	676177	814071
Jumlah Produk Cacat (Scrap)	1714	1173	1315	1183	1172	939	1073	1057	1016	874	722	1153
Jumlah Produk Rework	0	0	0	0	0	0	0	0	0	0	0	0
Jumlah Produk Bersih (PCS)	799471	651875	699351	606087	804050	730769	702126	861490	678675	917464	675455	812918
<b>Quality</b>	<b>99,79%</b>	<b>99,82%</b>	<b>99,81%</b>	<b>99,81%</b>	<b>99,85%</b>	<b>99,87%</b>	<b>99,85%</b>	<b>99,88%</b>	<b>99,85%</b>	<b>99,90%</b>	<b>99,89%</b>	<b>99,86%</b>



Lampiran Perhitungan Nilai *Availability* pada Mesin *Rotary Packer* 63QPM1

Menghitung Nilai <i>Availability</i> Mesin 63QPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times</i> (Hour)	433,76	447,70	458,44	430,25	471,38	453,44	417,45	504,33	480,02	478,18	403,63	461,23
Jumlah Waktu <i>Downtime</i> Mesin (Hour) / <i>Planned Downtime</i>	0	0	0	0	0	10	0	0	0	0	0	27
<i>Loading Time</i> (Hour)	433,76	447,70	458,44	430,25	471,38	443,44	417,45	504,33	480,02	478,18	403,63	434,23
Waktu <i>Setup and Adjustment</i> (Hour)	84,9	90,2	112,7	131,4	101,2	116,2	99,0	78,0	85,4	86,5	67,0	88,9
Waktu <i>Breakdown</i> Mesin (Hour)	100,1	59,9	48,3	38,0	47,6	50,6	43,6	37,7	34,6	55,4	29,4	42,9
<i>Downtime</i> (Hour)	185,0	150,1	161,0	169,4	148,8	166,8	142,6	115,7	120,0	141,8	96,4	131,8
<i>Operation Time</i> (Hour)	248,8	297,6	297,4	260,9	322,6	276,7	274,9	388,7	360,0	336,4	307,3	302,5
<b><i>Availability</i></b>	<b>57,36%</b>	<b>66,47%</b>	<b>64,87%</b>	<b>60,63%</b>	<b>68,43%</b>	<b>62,39%</b>	<b>65,85%</b>	<b>77,07%</b>	<b>75,00%</b>	<b>70,34%</b>	<b>76,13%</b>	<b>69,66%</b>



Lampiran Perhitungan Nilai *Performance* pada Mesin *Rotary Packer 63QPM1*

Menghitung Nilai <i>Performance</i> Mesin 63QPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times (Hour)</i>	433,76	447,70	458,44	430,25	471,38	453,44	417,45	504,33	480,02	478,18	403,63	461,23
Jumlah Produksi Kotor (JPK) (PCS)	587.992	702993	707465	617529	761555	656880	642974	901968	852337	805037	728999	719184
<i>Run Time (Hour)</i>	248,8	297,6	297,4	260,9	322,6	286,7	274,9	388,7	360,0	336,4	307,3	329,5
<i>Actual Cycle Time (Hour)</i>	0,00074	0,00064	0,00065	0,00070	0,00062	0,00069	0,00065	0,00056	0,00056	0,00059	0,00055	0,00064
<i>Ideal Cycle time (Hour)</i>	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417
Waktu Aktual Produksi (Hour)	248,8	230	303,74	312	212	299,63	281,25	252	333	338	272,68	378,37
<b><i>Performance</i></b>	<b>56,48%</b>	<b>65,43%</b>	<b>64,30%</b>	<b>59,80%</b>	<b>67,32%</b>	<b>60,36%</b>	<b>64,18%</b>	<b>74,52%</b>	<b>73,99%</b>	<b>70,15%</b>	<b>75,25%</b>	<b>64,97%</b>

Lampiran Perhitungan Nilai *Quality* pada Mesin *Rotary Packer 63QPM1*

Menghitung Nilai <i>Quality</i> Mesin 63QPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
Jumlah Produksi Kotor (JPK) (PCS)	587992	702993	707465	617529	761555	656880	642974	901968	852337	805037	728999	719184
Jumlah Produk Cacat (Scrap)	1055	1094	1057	1461	1417	1088	888	1562	1253	1354	1186	1507
Jumlah Produk Rework	0	0	0	0	0	0	0	0	0	0	0	0
Jumlah Produk Bersih (PCS)	586937	701899	706408	616068	760138	655792	642086	900406	851084	803683	727813	717677
<b>Quality</b>	<b>99,82%</b>	<b>99,84%</b>	<b>99,85%</b>	<b>99,76%</b>	<b>99,81%</b>	<b>99,83%</b>	<b>99,86%</b>	<b>99,83%</b>	<b>99,85%</b>	<b>99,83%</b>	<b>99,84%</b>	<b>99,79%</b>

Lampiran Perhitungan Nilai *Availability* pada Mesin *Rotary Packer* 63RPM1

Menghitung Nilai <i>Availability</i> Mesin 63RPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times</i> (Hour)	470,84	440,79	445,59	433,22	481,65	468,83	422,56	480,97	473,72	485,10	407,57	478,92
Jumlah Waktu <i>Downtime</i> Mesin (Hour) / <i>Planned Downtime</i>	0	0	0	0	0	10	0	0	0	0	0	0
<i>Loading Time</i> (Hour)	470,84	440,79	445,59	433,22	481,65	458,83	422,56	480,97	473,72	485,10	407,57	478,92
Waktu <i>Setup and Adjustment</i> (Hour)	107,87	112,90	106,44	116,24	91,38	111,69	114,19	90,05	84,92	86,62	64,03	90,25
Waktu <i>Breakdown</i> Mesin (Hour)	41,2	61,9	67,9	49,0	47,0	39,5	23,3	49,0	41,4	48,3	28,4	50,8
<i>Downtime</i> (Hour)	149,0	174,8	174,3	165,3	138,3	151,2	137,4	139,0	126,3	134,9	92,4	141,1
<i>Operation Time</i> (Hour)	321,8	266,0	271,2	268,0	343,3	307,7	285,1	341,9	347,4	350,2	315,1	337,8
<b><i>Availability</i></b>	<b>68,35%</b>	<b>60,34%</b>	<b>60,87%</b>	<b>61,85%</b>	<b>71,28%</b>	<b>67,05%</b>	<b>67,47%</b>	<b>71,09%</b>	<b>73,34%</b>	<b>72,19%</b>	<b>77,32%</b>	<b>70,54%</b>

Lampiran Perhitungan Nilai *Performance* pada Mesin *Rotary Packer* 63RPM1

Menghitung Nilai <i>Performance</i> Mesin 63RPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
<i>Machine Working Times (Hour)</i>	470,84	440,79	445,59	433,22	481,65	468,83	422,56	480,97	473,72	485,10	407,57	478,92
Jumlah Produksi Kotor (JPK) (PCS)	742960	632484	643623	636972	814021	737671	669956	816117	827190	812555	754698	810410
<i>Run Time (Hour)</i>	321,8	266,0	271,2	268,0	343,3	317,7	285,1	341,9	347,4	350,2	315,1	337,8
<i>Actual Cycle Time (Hour)</i>	0,00063	0,00070	0,00069	0,00068	0,00059	0,00064	0,00063	0,00059	0,00057	0,00060	0,00054	0,00059
<i>Ideal Cycle time (Hour)</i>	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417	0,000417
Waktu Aktual Produksi (Hour)	310	230	303,74	312	212	299,63	281,25	252	333	338	272,68	378,37
<b><i>Performance</i></b>	<b>65,75%</b>	<b>59,79%</b>	<b>60,18%</b>	<b>61,26%</b>	<b>70,42%</b>	<b>65,56%</b>	<b>66,06%</b>	<b>70,70%</b>	<b>72,76%</b>	<b>69,79%</b>	<b>77,15%</b>	<b>70,51%</b>

Lampiran Perhitungan Nilai *Quality* pada Mesin *Rotary Packer 63RPM1*

Menghitung Nilai <i>Quality</i> Mesin 63RPM1												
Indikator	Periode											
	Aug-17	Sep-17	Oct-17	Nov-17	Dec-17	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18
Jumlah Produksi Kotor (JPK) (PCS)	742960	632484	643623	636972	814021	737671	669956	816117	827190	812555	754698	810410
Jumlah Produk Cacat (Scrap)	1013	917	906	901	753	617	435	797	916	981	700	1041
Jumlah Produk Rework	0	0	0	0	0	0	0	0	0	0	0	0
Jumlah Produk Bersih (PCS)	741947	631567	642717	636071	813268	737054	669521	815320	826274	811574	753998	809369
<b>Quality</b>	<b>99,86%</b>	<b>99,86%</b>	<b>99,86%</b>	<b>99,86%</b>	<b>99,91%</b>	<b>99,92%</b>	<b>99,94%</b>	<b>99,90%</b>	<b>99,89%</b>	<b>99,88%</b>	<b>99,91%</b>	<b>99,87%</b>