

LAMPIRAN

Lampiran 1. Jumlah Operator Pada stasiun kerja

No	Nama Proses	Jumlah Operator (orang)
1	Loading	1
2	Penomoran semua komponen	1
3	Jahit lakar + rimbas + balik tutup saku	1
4	Obras 3 tutup saku depan	1
5	Stik tutup saku depan	1
6	Stik deck	1
7	Lakar + balik daun krah	1
8	Stik krah	1
9	Gabung daun + kaki krah	1
10	Pasang + stik plaket	1
11	Jahit bahu + depanan	1
12	Lakar + rimbas + balik deck	1
13	Stik kaki krah	1
14	Stik depan + klim saku depan + pen	1
15	Jahit yoke belakang	1
16	Stik bahu + yoke belakang	1
17	Gosok krah + saku depan	1
18	Gosok saku pen + depanan + tutup saku depan	1
19	Gambar saku depan	1
20	Pasang saku depan	1
21	Pasang tutup saku depan	1
22	Pasang krah + pasang label	1
23	Jahit + pasang loop	1
24	Tutup krah	1

25	Pasang lengan	1
26	Stik lengan	1
27	Obras 5 samping	1
28	Klim lengan	1
29	Pasang deck	1
30	Pasang saku pen	1
31	Klim bawah	1
32	Bartex	1
33	Lubang kancing	1
34	Tanda kancing	1
35	Pasang kancing	1
36	Triming	2
37	Quality Control	2
38	Gosok baju	4
39	Packaging plastik + lipat baju	4

Lampiran 2 Fix Resouce

Nama	Tipe
Kedatangan kain	<i>Source</i>
Loading 1	<i>Processor</i>
Loading 2	
Loading 3	
Numbering all komponen 1	<i>Processor</i>
Numbering all komponen 2	
Numbering all komponen 3	
Jahit lakar + rimbas + balik tutup saku 1	<i>Processor</i>
Jahit lakar + rimbas + balik tutup saku 2	
Jahit lakar + rimbas + balik tutup saku 3	

Obras 3 tutup saku depan 1	<i>Processor</i>
Obras 3 tutup saku depan 2	
Obras 3 tutup saku depan 3	
Stik tutup saku depan 1	<i>Processor</i>
Stik tutup saku depan 2	
Stik tutup saku depan 3	
Stik deck 1	<i>Processor</i>
Stik deck 2	
Stik deck 3	
Lakar + balik daun krah 1	<i>Processor</i>
Lakar + balik daun krah 2	
Lakar + balik daun krah 3	
Stik krah 1	<i>Processor</i>
Stik krah 2	
Stik krah 3	
Gabung daun + kaki krah 1	<i>Processor</i>
Gabung daun + kaki krah 2	
Gabung daun + kaki krah 3	
Pasang + stik plaket 1	<i>Processor</i>
Pasang + stik plaket 2	
Pasang + stik plaket 3	
Jahit bahu + depanan 1	<i>Processor</i>
Jahit bahu + depanan 2	
Jahit bahu + depanan 3	
Lakar + rimbas + balik deck 1	<i>Processor</i>
Lakar + rimbas + balik deck 2	
Lakar + rimbas + balik deck 3	
Stik kaki krah 1	<i>Processor</i>
Stik kaki krah 2	
Stik kaki krah 3	

Stik depan + klim saku depan + pen 1	<i>Processor</i>
Stik depan + klim saku depan + pen 2	
Stik depan + klim saku depan + pen 3	
Jahit yoke belakang 1	<i>Processor</i>
Jahit yoke belakang 2	
Jahit yoke belakang 3	
Stik bahu + yoke belakang 1	<i>Processor</i>
Stik bahu + yoke belakang 2	
Stik bahu + yoke belakang 3	
Gosok krah + saku depan 1	<i>Processor</i>
Gosok krah + saku depan 2	
Gosok krah + saku depan 3	
Gosok saku pen + depanan + tutup saku depan 1	<i>Processor</i>
Gosok saku pen + depanan + tutup saku depan 2	
Gosok saku pen + depanan + tutup saku depan 3	
Gambar saku depan 1	<i>Processor</i>
Gambar saku depan 2	
Gambar saku depan 3	
Pasang saku depan 1	<i>Processor</i>
Pasang saku depan 2	
Pasang saku depan 3	
Pasang tutup saku depan 1	<i>Processor</i>
Pasang tutup saku depan 2	
Pasang tutup saku depan 3	
Pasang krah + pasang label 1	<i>Processor</i>
Pasang krah + pasang label 2	
Pasang krah + pasang label 3	
Jahit + pasang loop 1	<i>Processor</i>
Jahit + pasang loop 2	
Jahit + pasang loop 3	

Tutup krah 1	<i>Processor</i>
Tutup krah 2	
Tutup krah 3	
Pasang lengan 1	<i>Processor</i>
Pasang lengan 2	
Pasang lengan 3	
Stik lengan 1	<i>Processor</i>
Stik lengan 2	
Stik lengan 3	
Obras 5 samping 1	<i>Processor</i>
Obras 5 samping 2	
Obras 5 samping 3	
Klim lengan 1	<i>Processor</i>
Klim lengan 2	
Klim lengan 3	
Pasang deck 1	<i>Processor</i>
Pasang deck 2	
Pasang deck 3	
Pasang saku pen 1	<i>Processor</i>
Pasang saku pen 2	
Pasang saku pen 3	
Klim bawah 1	<i>Processor</i>
Klim bawah 2	
Klim bawah 3	
Bartex 1	<i>Processor</i>
Bartex 2	
Bartex 3	
Lubang kancing 1	<i>Processor</i>
Lubang kancing 2	
Lubang kancing 3	

Tanda kancing 1	<i>Processor</i>
Tanda kancing 2	
Tanda kancing 3	
Pasang kancing 1	<i>Processor</i>
Pasang kancing 2	
Pasang kancing 3	
Triming 1	<i>Combiner</i>
Triming 2	
Triming 3	
Quality Control 1	<i>Processor</i>
Quality Control 2	
Quality Control 3	
Gosok baju 1	<i>Processor</i>
Gosok baju 2	
Gosok baju 3	
Packaging plastik + lipat baju 1	<i>Combiner</i>
Packaging plastik + lipat baju 2	
Packaging plastik + lipat baju 3	
Kedatangan aksesoris	<i>Source</i>
Barang cacat	<i>Queue</i>
Output kemeja PDH TNI AD	<i>Sink</i>

Lampiran 3 Kapasitas Mesin

No	Nama Proses	Kapasitas
1	Loading	1
2	Penomoran semua komponen	1
3	Jahit lakar + rimbas + balik tutup saku	1
4	Obras 3 tutup saku depan	1
5	Stik tutup saku depan	1

6	Stik deck	1
7	Lakar + balik daun krah	1
8	Stik krah	1
9	Gabung daun + kaki krah	1
10	Pasang + stik plaket	1
11	Jahit bahu + depanan	1
12	Lakar + rimbas + balik deck	1
13	Stik kaki krah	1
14	Stik depan + klim saku depan + pen	1
15	Jahit yoke belakang	1
16	Stik bahu + yoke belakang	1
17	Gosok krah + saku depan	1
18	Gosok saku pen + depanan + tutup saku depan	1
19	Gambar saku depan	1
20	Pasang saku depan	1
21	Pasang tutup saku depan	1
22	Pasang krah + pasang label	1
23	Jahit + pasang loop	1
24	Tutup krah	1
25	Pasang lengan	1
26	Stik lengan	1
27	Obras 5 samping	1
28	Klim lengan	1
29	Pasang deck	1
30	Pasang saku pen	1
31	Klim bawah	1
32	Bartex	1
33	Lubang kancing	1
34	Tanda kancing	1

35	Pasang kancing	1
36	Gosok baju	1
37	Barang cacat	1000

Lampiran 4. Bobot Tiap Pemborosan

No	Jenis Pertanyaan	Nilai Pertanyaan	Overproduction	Inventory	Defect	Motion	Transprotation	Process	Waiting
1	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
2	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
3	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
4	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
5	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
6	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
7	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14
8	<i>To Waiting</i>	5	1.6	0	2	1.6	1.6	1.6	2
9	<i>From Waiting</i>	7	0.57	0.57	0.57	0	0	0	1.43
10	<i>From Transportation</i>	4	0.5	2	1	2	2.5	0	2
11	<i>From Inventory</i>	6	1.33	1.67	1.00	1.67	1.67	0	0
12	<i>From Inventory</i>	6	1.33	1.67	1.00	1.67	1.67	0	0
13	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
14	<i>From Inventory</i>	6	1.33	1.67	1.00	1.67	1.67	0	0
15	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
16	<i>To Defect</i>	4	1.5	1.5	2.5	1.5	1	2.5	1
17	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
18	<i>From transportation</i>	4	0.5	2	1	2	2.5	0	2
19	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
20	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
21	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
22	<i>From Transportation</i>	4	0.5	2	1	2	2.5	0	2
23	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
24	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
25	<i>From Inventory</i>	6	1.33	1.67	1.00	1.67	1.67	0	0
26	<i>From Inventory</i>	6	1.33	1.67	1.00	1.67	1.67	0	0
27	<i>To Waiting</i>	5	1.6	0	2	1.6	1.6	1.6	2

28	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
29	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
30	<i>From Overproduction</i>	3	3.33	2.00	2	2.67	2	0	2.667
31	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
32	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14
33	<i>To Waiting</i>	5	1.6	0	2	1.6	1.6	1.6	2
34	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14
35	<i>From Transportation</i>	4	0.5	2	1	2	2.5	0	2
36	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
37	<i>From Overproduction</i>	3	3.33	2.00	2	2.67	2	0	2
38	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
39	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
40	<i>To Defect</i>	4	1.5	1.5	2.5	1.5	1	2.5	1
41	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
42	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
43	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14
44	<i>To Transportation</i>	3	2	3.33	3.33	0	3.33	0	0
45	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
46	<i>From Waiting</i>	8	0.5	0.5	0.5	0	0	0	1.25
47	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
48	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
49	<i>To Defect</i>	4	1.5	1.5	2.5	1.5	1	2.5	1
50	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
51	<i>From Defect</i>	8	0.5	0.75	1.25	1	1.25	0	1.25
52	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
53	<i>To Waiting</i>	5	1.6	0	2	1.6	1.6	1.6	2
54	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14
55	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14
56	<i>To Defect</i>	4	1.5	1.5	2.5	1.5	1	2.5	1
57	<i>From Inventory</i>	6	1.33	1.67	1.00	1.67	1.67	0	0
58	<i>To Transportation</i>	3	2.00	3.33	3.33	0.00	3.33	0	0
59	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
60	<i>To Transportation</i>	3	2	3.33	3.33	0	3.33	0	0
61	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
62	<i>To Motion</i>	9	0.89	1.11	0.89	1.11	0.89	1.11	0
63	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
64	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
65	<i>From Motion</i>	11	0	0.55	0.55	0.91	0	0.55	0.73
66	<i>From Overproduction</i>	3	3.33	2.00	2	2.67	2	0	2
67	<i>From Process</i>	7	0.86	0.86	1.43	1.43	0	1.43	1.14

27	To Waiting	0	0.00	0	0.00	0	0.00	0.00	0
28	From Defect	0.5	1.00	0.67	0.4	0.5	0.4	0	0.4
29	From Waiting	0.5	1	1.00	1	0	0	0	0.4
30	From Overproduction	0	0	0	0	0	0	0	0
31	To Motion	1	1.13	0.9	1.13	0.9	1.13	0.9	0
32	From Process	1	1.17	1.17	0.7	0.70	0	0.7	0.88
33	To Waiting	1	1	0	1	1	1	1	1
34	From Process	1	1.17	1.17	0.7	0.70	0	0.7	0.88
35	From Transportation	1	2	0.5	1	0.5	0.4	0	1
36	To Motion	1	1.13	0.9	1.13	0.9	1.13	0.9	0
37	From Overproduction	0	0	0	0	0	0	0	0
38	From Waiting	0.5	1	1.00	1	0	0	0	0.4
39	From Waiting	0.5	1	1.00	1	0	0	0	0.4
40	To Defect	0	0	0	0	0	0	0	0
41	From Waiting	0.5	1	1	1	0	0	0	0.4
42	To Motion	1	1.13	0.9	1.13	0.9	1.13	0.9	0
43	From Process	1	1	1	0	0	0	0	0
44	To Transportation	1	1	0	0	0	0	0	0
45	From Motion	1	0	1.83	1.83	1.1	0	1.83	1.38
46	From Waiting	1	2	2.00	2	0	0	0	0.8
47	To Motion	1	1.13	0.9	1.13	0.9	1.13	0.9	0
48	From Defect	1	2.00	1.33	0.8	1	0.8	0	0.8
49	To Defect	1	0.67	0.67	0.4	0.67	1	0.4	1
50	From Motion	1	0	1.83	1.83	1.1	0	1.83	1.38
51	From Defect	1	2.00	1.33	0.8	1	0.8	0	0.8
52	From Motion	1	0	1.83	1.83	1.1	0	1.83	1.38
53	To Waiting	1	0.63	0	0.50	0.63	0.63	0.63	0.5
54	From Process	1	1.17	1.17	0.7	0.70	0	0.7	0.88
55	From Process	1	1.17	1.17	0.7	0.70	0	0.7	0.88
56	To Defect	1	0.67	0.67	0.4	0.67	1	0.4	1
57	From Inventory	1	0.75	0.6	1	0.6	0.6	0	0
58	To Transportation	1	0.5	0.3	0.30	0	0.3	0	0
59	To Motion	0.5	0.56	0.45	0.56	0.45	0.56	0.45	0
60	To Transportation	1	0.5	0.3	0.30	0	0.3	0	0
61	To Motion	0	0	0	0	0	0	0	0
62	To Motion	1	1.13	0.9	1.13	0.9	1.13	0.9	0
63	From Motion	1	0	1.83	1.83	1.1	0	1.83	1.38
64	From Motion	1	0	1.83	1.83	1.1	0	1.83	1.38
65	From Motion	1	0	1.83	1.83	1.1	0	1.83	1.38
66	From Overproduction	1	0.3	0.5	0.5	0.38	0.5	0	0.5

67	<i>From Process</i>	1	1.17	1.17	0.70	0.70	0	0.7	0.88
68	<i>From Defect</i>	1	2	1.33	0.8	1	0.8	0	0.8
	Score (Sj)		44.76	55.07	52.94	33.78	19.53	33.47	33.81
	Frequency (Fj)		41	50	52	42	27	31	39

Lampiran 6



