

Lampiran 20

PERENCANAAN WORK STATION - 6,72

Cycle Time Minimum = 6,72 jam

Efisiensi = 90,26%

Produksi / Bulan mak = 21,90

No	Work Station	Time Remaining	Eligible Process	Assign Task		Idle Time
				Process	Time	
1	I	6.72	1,2,4,6,11,14	1	6.72	0.00
2	II	6.72	2,4,6,11,14	2	3.10	
3		3.62	3,4,6,11,14	3	1.82	
4		1.80	4,6,11,14	6	0.85	
5		0.95	4,11,14			0.95
6	III	6.72	4,11,14	4	2.23	
7		4.49	5,11,14	5	1.96	
8		2.53	7,11,14	7	2.32	
9		0.21	8,11,14			0.21
10	IV	6.72	8,11,14	8	2.04	
11		4.68	9,11,14	9	2.28	
12		2.40	10,11,14	14	2.19	
13		0.21	10,11			0.21
14	V	6.72	10,11	10	3.05	
15		3.67	11	11	3.17	
16		0.50	11			0.50
17	VI	6.72	12	12	2.80	
18		3.92	13	13	2.43	
19		1.49	15			1.49
20	VII	6.72	15	15	2.28	
21		4.44	16	16	1.50	
22		2.94	17	17	1.50	
23		1.44	18			1.44
24	VIII	6.72	18	18	3.20	
25		3.52	19	19	3.40	
26		0.12	20			0.12
27	IX	6.72	20	20	3.14	
28		3.58	21	21	2.61	
29		0.97				0.97
Total =				54.59	5.89	