Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 5.
Produksi maksimum : 13.34 unit / bulan

Efisiensi 99.07%
Cycle Time : 11.02

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	10.98	I	0.04
2	A3303	Control Valve			
3	A1102	Swing Frame 1			
		Oper : 2140			
4	A3405	Floor Plate	**11.02**	**II**	-
5	A1104	Swing Frame 2			
6	A1106	Engine			
7	A1106	Swing Frame 3			
8	A1108	Swing Frame 4			
9	A1109	Swing Frame 5			
		Oper : 8070			
10	A1110	Swing Frame 6	10.94	III	0.08
11	A2101	Base Frame			
12	A4111	Docking, Fuel, Oil			
13	A4112	C/W & Testing			
		Oper : 11030			
14	A3613	Sub Boom	11.00	IV	0.02
15	A5614	Install Boom			
16	R1016	Steam Washing			
17	R2017	Sanding			
18	R4019	Painting			
		Oper : 17010			
19	R5020	Decall	10.65	V	0.37
20	R6027	Install Cab			
21	R7022	Install Enclosure			

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 6. Efisiensi 99.44%
Produksi maksimum : 16.07 unit / bulan Cycle Time : 9.15

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses			
2	A3303	Control Valve	9.12	I	0.03
		Oper : 3220			
3	A1102	Swing Frame 1			
4	A3405	Floor Plate			
5	A1104	Swing Frame 2	9.08	II	0.07
6	A1106	Engine			
7	A1106	Swing Frame 3			
		Oper : 6240			
8	A1108	Swing Frame 4			
9	A1109	Swing Frame 5			
10	A1110	Swing Frame 6	**9.15**	**III**	-
11	A2101	Base Frame			
		Oper : 1040			
12	A4111	Docking, Fuel, Oil			
13	A4112	C/W & Testing	8.99	IV	0.16
14	A3613	Sub Boom			
		Oper : 12040			
15	A5614	Install Boom			
16	R1016	Steam Washing			
17	R2017	Sanding	9.10	V	0.05
18	R4019	Painting			
		Oper : 17020			
19	R5020	Decall			
20	R6027	Install Cab	**9.15**	**VI**	-
21	R7022	Install Enclosure			

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 7. Efisiensi 97.12%
Produksi maksimum : 18.31 unit / bulan Cycle Time : 8.03

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses			
2	A3303	Control Valve	7.80	I	0.23
		Oper : 3140			
3	A1102	Swing Frame 1			
4	A3405	Floor Plate	**8.03**	II	-
5	A1104	Swing Frame 2			
		Oper : 4120			
6	A1106	Engine			
7	A1106	Swing Frame 3			
8	A1108	Swing Frame 4	7.81	III	0.22
9	A1109	Swing Frame 5			
10	A1110	Swing Frame 6			
		Oper : 9010			
11	A2101	Base Frame			
12	A4111	Docking, Fuel, Oil	7.79	IV	0.24
		Oper : 10090			
13	A4112	C/W & Testing			
14	A3613	Sub Boom	7.81	V	0.22
15	A5614	Install Boom			
		Oper : 13110			
16	R1016	Steam Washing			
17	R2017	Sanding			
18	R4019	Painting	7.35	VI	0.68
19	R5020	Decall			
		Oper : 18020			
20	R6027	Install Cab	8.00	VII	0.03
21	R7022	Install Enclosure			

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 8. Efisiensi 98.04%
Produksi maksimum : 21.13 unit / bulan Cycle Time : 6.96

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses			
2	A3303	Control Valve	6.82	I	0.14
		Oper : 3010			
3	A1102	Swing Frame 1			
4	A3405	Floor Plate	**6.96**	**II**	-
		Oper : 5210			
5	A1104	Swing Frame 2			
6	A1106	Engine			
7	A1106	Swing Frame 3	6.76	III	0.20
8	A1108	Swing Frame 4			
		Oper : 7100			
9	A1109	Swing Frame 5			
10	A1110	Swing Frame 6	6.81	IV	0.15
11	A2101	Base Frame			
		Oper : 1040			
12	A4111	Docking, Fuel, Oil			
13	A4112	C/W & Testing	6.92	V	0.04
		Oper : 11040			
14	A3613	Sub Boom			
15	A5614	Install Boom	6.47	VI	0.49
16	R1016	Steam Washing			
		Oper : 14010			
17	R2017	Sanding			
18	R4019	Painting	6.95	VII	0.01
19	R5020	Decall			
		Oper : 18010			
20	R6027	Install Cab	6.90	VII	0.06
21	R7022	Install Enclosure			

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 9. Efisiensi 99.27%
Produksi maksimum : 24.07 unit / bulan Cycle Time : 6.11

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	6.05	I	0.06
		Oper : 1400			
2	A3303	Control Valve	6.09	II	0.02
3	A1102	Swing Frame 1			
4	A3405	Floor Plate			
		Oper : 5070			
5	A1104	Swing Frame 2	6.04	III	0.07
6	A1106	Engine			
7	A1106	Swing Frame 3			
		Oper : 6260			
8	A1108	Swing Frame 4	**6.11**	**IV**	-
9	A1109	Swing Frame 5			
10	A1110	Swing Frame 6			
		Oper : 9050			
11	A2101	Base Frame	6.08	V	0.03
12	A4111	Docking, Fuel, Oil			
		Oper : 10040			
13	A4112	C/W & Testing	6.10	VI	0.01
14	A3613	Sub Boom			
		Oper : 12050			
15	A5614	Install Boom	6.07	VII	0.04
16	R1016	Steam Washing			
17	R2017	Sanding			
18	R4019	Painting			
		Oper : 16010			
19	R5020	Decall	6.06	VIII	0.05
20	R6027	Install Cab			
		Oper : 19040			
21	R7022	Install Enclosure	5.89	IX	0.22

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 10. Efisiensi 98.89%
Produksi maksimum : 26,64 unit / bulan Cycle Time : 5,52

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	5.48	I	0.04
		Oper 1400			
2	A3303	Control Valve	5.50	II	0.02
3	A1102	Swing Frame 1			
		Oper : 2140			
4	A3405	Floor Plate	5.49	III	0.03
5	A1104	Swing Frame 2			
6	A1106	Engine			
		Oper : 6040			
7	A1106	Swing Frame 3	5.36	IV	0.16
8	A1108	Swing Frame 4			
9	A1109	Swing Frame 5			
		Oper : 8060			
10	A1110	Swing Frame 6	5.52	V	-
11	A2101	Base Frame			
		Oper : 1040			
12	A4111	Docking, Fuel, Oil	5.51	VI	0.01
13	A4112	C/W & Testing			
		Oper : 11020			
14	A3613	Sub Boom	5.46	VII	0.06
15	A5614	Install Boom			
		Oper : 13090			
16	R1016	Steam Washing	5.42	VIII	0.10
17	R2017	Sanding			
18	R4019	Painting			
		Oper : 16010			
19	R5020	Decall	5.37	IX	0.15
20	R6027	Install Cab			
		Oper : 19010			
21	R7022	Install Enclosure	5.48	X	0.04

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 11. Efisiensi 94.71%
Produksi maksimum : 28,06 unit / bulan Cycle Time : 5,24

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	5.06	I	0.18
		Oper : 1400			
2	A3303	Control Valve			
3	A1102	Swing Frame 1	5.03	II	0.21
		Oper : 2050			
4	A3405	Floor Plate			
5	A1104	Swing Frame 2	5.06	III	0.18
		Oper : 4070			
6	A1106	Engine			
7	A1106	Swing Frame 3	5.05	IV	0.19
8	A1108	Swing Frame 4			
		Oper : 7070			
9	A1109	Swing Frame 5			
10	A1110	Swing Frame 6	5.00	V	0.24
		Oper : 9110			
11	A2101	Base Frame			
12	A4111	Docking, Fuel, Oil	5.08	VI	0.16
		Oper : 10070			
13	A4112	C/W & Testing			
14	A3613	Sub Boom	5.24	VII	-
		Oper : 12040			
15	A5614	Install Boom			
16	R1016	Steam Washing	5.22	IX	0.02
		Oper : 14010			
17	R2017	Sanding			
18	R4019	Painting	4.70	X	0.54
		Oper : 17020			
19	R5020	Decall			
20	R6027	Install Cab	4.73	XI	0.51
		Oper : 19050			
21	R7022	Install Enclosure	4.42	XI	0.82

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 14. Efisiensi 96.47%
Produksi maksimum : 37,13 unit / bulan Cycle Time : 3,96

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	2.92	I	1.04
		Oper : 1200			
2	A3303	Control Valve	3.90	II	0.06
		Oper : 3010			
3	A1102	Swing Frame 1	3.90	III	0.06
		Oper : 2110			
4	A3405	Floor Plate	**3.96**	**IV**	-
5	A1104	Swing Frame 2			
		Oper : 4060			
6	A1106	Engine	3.94	V	0.02
7	A1106	Swing Frame 3			
		Oper : 6250			
8	A1108	Swing Frame 4	**3.96**	**VI**	-
9	A1109	Swing Frame 5			
		Oper : 8150			
10	A1110	Swing Frame 6	3.91	VII	0.05
11	A2101	Base Frame			
		Oper : 1030			
12	A4111	Docking, Fuel, Oil	3.59	VIII	0.37
		Oper : 10030			
13	A4112	C/W & Testing	3.84	IX	0.12
		Oper : 11040			
14	A3613	Sub Boom	**3.96**	**X**	-
15	A5614	Install Boom			
		Oper : 13060			
16	R1016	Steam Washing	2.86	XI	1.10
		Oper : 14010			
17	R2017	Sanding	3.20	XII	0.76
18	R4019	Painting			
		Oper : 17010			
19	R5020	Decall	3.20	XIII	0.21
		Oper : 18010			
20	R6027	Install Cab	3.75	XIV	0.12
		Oper : 19130			
21	R7022	Install Enclosure	3.06	I / XI	

Lampiran 21

Detail Perencanaan Work Station dari 5 s.d. 15 tempat

Work Station 15. Efisiensi 99.44%
Produksi maksimum : 40,18 unit / bulan Cycle Time : 3,66

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	2.92	I	0.74
		Oper : 1200			
		Oper : 1400	3.64	II	0.02
2	A3303	Control Valve	3.65	III	0.01
3	A1102	Swing Frame 1			
		Oper : 2040			
4	A3405	Floor Plate	**3.66**	**IV**	-
		Oper : 5230			
5	A1104	Swing Frame 2	3.64	V	0.02
6	A1106	Engine			
7	A1106	Swing Frame 3			
		Oper : 6160			
8	A1108	Swing Frame 4	3.65	VI	0.01
9	A1109	Swing Frame 5			
		Oper : 8020			
10	A1110	Swing Frame 6	3.65	VII	0.01
		Oper : 9080			
11	A2101	Base Frame	3.64	VIII	0.02
		Oper : 1050			
12	A4111	Docking, Fuel, Oil	3.64	IX	0.02
		Oper : 10120			
13	A4112	C/W & Testing	**3.66**	**X**	-
14	A3613	Sub Boom			
		Oper : 12050			
15	A5614	Install Boom	3.49	XI	0.17
		Oper : 13110			
16	R1016	Steam Washing	3.60	XII	0.06
17	R2017	Sanding			
18	R4019	Painting			
		Oper : 16010			
19	R5020	Decall	3.60	XIII	0.06
		Oper : 18020			
20	R6027	Install Cab	**3.66**	**XIV**	-
		Oper : 19110			
21	R7022	Install Enclosure	3.64	XV	0.02
		Oper : 20040			
		Oper : 20110	0.85	I	