

Kerugian akibat *Idle Time*

Cycle Time = 7,17 jam Work Station = 13 tempat (Keadaan Awal)
 Produksi / Bulan = 20,50 buah Efisiensi = 53,37 %

No	W/C Code	Activity	Labor	Burden	Mach	Total USS	Idle Time	Lost USS
1	A3724	Hoses	1.66	2.58	5.35	9.59	0.45	4.32
2	A3303	Control Valve	1.75	2.58	6.22			
3	A1102	Swing Frame 1	1.75	2.75	9.05	30.82	0.02	0.62
4	A3405	Floor Plate	1.75	2.58	5.89			
5	A1104	Swing Frame 2	1.75	2.75	9.05			
6	A1106	Engine	1.75	2.75	9.05	48.95	-	-
7	A1106	Swing Frame 3	1.75	2.75	9.05			
8	A1108	Swing Frame 4	1.75	2.75	9.05			
9	A1109	Swing Frame 5	1.75	2.75	9.05	25.35	1.84	46.64
10	A1110	Swing Frame 6	1.75	2.75	9.05			
11	A2101	Base Frame	1.66	2.58	7.19	11.43	4.00	45.72
12	A4111	Docking, Fuel, Oil	1.66	2.58	7.19	22.82	4.55	103.83
13	A4112	C/W & Testing	2.37	2.90	8.49			
14	A3613	Sub Boom	1.66	2.58	5.89	21.08	4.93	103.92
15	A5614	Install Boom	1.66	2.58	8.37			
16	R1016	Steam Washing	1.61	2.21	5.27	9.09	5.67	51.54
17	R2017	Sanding	1.61	2.52	3.98	8.11	5.67	45.98
18	R4019	Painting	1.72	2.62	9.74	14.08	3.97	55.90
19	R5020	Decall	1.61	2.23	3.31	7.15	3.77	26.96
20	R6027	Install Cab	1.66	2.64	4.30	8.60	4.03	34.66
21	R7022	Install Enclosure	1.66	2.64	4.30	8.60	4.56	39.22
Total :			55.07	148.84	225.67	43.46	559.30	

Lampiran 25

Kerugian akibat *Idle Time*

Cycle Time = 7,17 jam Work Station = 9 tempat
 Produksi / Bulan = 20,50 buah Efisiensi = 84,60 %

No	W/C Code	Activity	Labor	Burden	Mach	Total USS	Idle Time	Lost USS
1	A3724	Hoses	1.66	2.58	5.35	9.59	0.45	4.32
2	A3303	Control Valve	1.75	2.58	6.22			
3	A1102	Swing Frame 1	1.75	2.75	9.05	30.82	0.02	0.62
4	A3405	Floor Plate	1.75	2.58	5.89			
5	A1104	Swing Frame 2	1.75	2.75	9.05			
6	A1106	Engine	1.75	2.75	9.05	48.95	0.00	0.00
7	A1106	Swing Frame 3	1.75	2.75	9.05			
8	A1108	Swing Frame 4	1.75	2.75	9.05			
9	A1109	Swing Frame 5	1.75	2.75	9.05	25.35	1.84	46.64
10	A1110	Swing Frame 6	1.75	2.75	9.05			
11	A2101	Base Frame	1.66	2.58	7.19	21.20	1.20	25.44
12	A4111	Docking, Fuel, Oil	1.66	2.58	7.19			
13	A4112	C/W & Testing	2.37	2.90	8.49			
14	A3613	Sub Boom	1.66	2.58	5.89	32.47	0.27	8.77
15	A5614	Install Boom	1.66	2.58	8.37			
16	R1016	Steam Washing	1.61	2.21	5.27			
17	R2017	Sanding	1.61	2.52	3.98	27.95	0.97	27.11
18	R4019	Painting	1.72	2.62	9.74			
19	R5020	Decall	1.61	2.23	3.31	14.09	0.63	8.88
20	R6027	Install Cab	1.66	2.64	4.30			
21	R7022	Install Enclosure	1.66	2.64	4.30	8.60	4.56	39.22
Total :			55.07	148.84	219.02	9.94	160.99	

Lampiran 25

Kerugian akibat *Idle Time*

Cycle Time = 6,11 jam Work Station = 9 tempat
 Produksi / Bulan = 24,70 buah Efisiensi = 99,27 %

No	W/C Code	Activity	Labor	Burden	Mach	Total USS	Idle Time	Lost USS
1a	A3724	Hoses	1.49	2.32	4.82	8.80	0.06	0.53
1b	A3724	Hoses	0.17	0.26	0.53			
2	A3303	Control Valve	1.75	2.58	6.22	25.42	0.02	0.51
3	A1102	Swing Frame 1	1.75	2.75	9.05			
4a	A3405	Floor Plate	0.47	0.69	1.58			
4b	A3405	Floor Plate	1.28	1.89	4.31			
5	A1104	Swing Frame 2	1.75	2.75	9.05	39.68	0.07	2.78
6	A1106	Engine	1.75	2.75	9.05			
7a	A1106	Swing Frame 3	1.21	1.90	6.24			
7b	A1106	Swing Frame 3	0.54	0.85	2.81			
8	A1108	Swing Frame 4	1.75	2.75	9.05	33.15	0.00	0.00
9	A1109	Swing Frame 5	1.75	2.75	9.05			
10a	A1110	Swing Frame 6	0.61	0.96	3.17			
10b	A1110	Swing Frame 6	1.14	1.79	5.88			
11	A2101	Base Frame	1.66	2.58	7.19	22.34	0.03	0.67
12a	A4111	Docking, Fuel, Oil	0.55	0.86	2.39			
12b	A4111	Docking, Fuel, Oil	1.11	1.72	4.80			
13	A4112	C/W & Testing	2.37	2.90	8.49	27.47	0.01	0.27
14a	A3613	Sub Boom	1.41	2.19	5.00			
14b	A3613	Sub Boom	0.25	0.39	0.89			
15	A5614	Install Boom	1.66	2.58	8.37			
16	R1016	Steam Washing	1.61	2.21	5.27	29.42	0.04	1.18
17	R2017	Sanding	1.61	2.52	3.98			
18a	R4019	Painting	0.22	0.33	1.22			
18b	R4019	Painting	1.51	2.29	8.52			
19	R5020	Decall	1.61	2.23	3.31	22.10	0.05	1.11
20a	R6027	Install Cab	0.99	1.57	2.56			
20b	R6027	Install Cab	0.67	1.07	1.74	11.40	0.22	2.51
21	R7022	Install Enclosure	1.66	2.64	4.30			
Total :			55.07	148.84		219.78	0.50	9.55