

Nilai Inventory Tertahan di WIP (Commulative x Idle Time)

Cycle Time = 7,17 jam, Work Station 13 tempat dan Efisiensi 53,37 % (Awal)

No	W/C Code	Activity	Com (%)	Station	Idle Time	WIP
1	A3724	Hoses	1.50	I	0.45	0.0068
2	A3303	Control Valve	5.50	II	0.02	0.0053
3	A1102	Swing Frame 1	18.50			
4	A3405	Floor Plate	26.50	III	0.00	0.0000
5	A1104	Swing Frame 2	31.50			
6	A1106	Engine	42.50			
7	A1106	Swing Frame 3	45.50			
8	A1108	Swing Frame 4	48.50	IV	1.84	1.1132
9	A1109	Swing Frame 5	53.50			
10	A1110	Swing Frame 6	60.50	V	4.00	2.9800
11	A2101	Base Frame	74.50			
12	A4111	Docking, Fuel, Oil	75.00	VI	4.55	3.4808
13	A4112	C/W & Testing	76.50			
14	A3613	Sub Boom	82.50	VII	4.93	4.1166
15	A5614	Install Boom	83.50			
16	R1016	Steam Washing	83.50	VIII	5.67	4.7345
17	R2017	Sanding	83.50	IX	5.67	4.7345
18	R4019	Painting	84.00	X	3.97	3.3348
19	R5020	Decall	85.00	XI	3.77	3.2045
20	R6027	Install Cab	94.00	XII	4.03	3.7882
21	R7022	Install Enclosure	100.00	XIII	4.56	4.5600
TOTAL					43.46	36.0590

Lampiran 27

Nilai Inventory Tertahan di WIP (Commulative x Idle Time)

Cycle Time = 7,17 jam, Work Station 9 tempat dan Efisiensi 84.60 %

No	W/C Code	Activity	Com (%)	Station	Idle Time	WIP
1	A3724	Hoses	1.50	I	0.45	0.0068
2	A3303	Control Valve	5.50	II	0.02	0.0053
3	A1102	Swing Frame 1	18.50			
4	A3405	Floor Plate	26.50			
5	A1104	Swing Frame 2	31.50	III	0.00	0.0000
6	A1106	Engine	42.50			
7	A1106	Swing Frame 3	45.50			
8	A1108	Swing Frame 4	48.50			
9	A1109	Swing Frame 5	53.50	IV	1.84	1.1132
10	A1110	Swing Frame 6	60.50			
11	A2101	Base Frame	74.50	V	1.20	0.9000
12	A4111	Docking, Fuel, Oil	75.00			
13	A4112	C/W & Testing	76.50			
14	A3613	Sub Boom	82.50	VI	0.27	0.2255
15	A5614	Install Boom	83.50			
16	R1016	Steam Washing	83.50	VII	0.97	0.8148
17	R2017	Sanding	83.50			
18	R4019	Painting	84.00			
19	R5020	Decall	85.00	VII	0.63	0.5922
20	R6027	Install Cab	94.00			
21	R7022	Install Enclosure	100.00	IX	4.56	
TOTAL					9.94	3.6577

Lampiran 27

Nilai Inventory Tertahan di WIP (Commulative x Idle Time)

Cycle Time = 6,11 jam, Work Station 9 tempat dan Efisiensi 99,27 %

No	W/C Code	Activity	Com (%)	Station	Idle Time	WIP
1a	A3724	Hoses	1.35	I	0.06	0.0008
1b	A3724	Hoses	1.50	II	0.02	0.0041
2	A3303	Control Valve	5.50			
3	A1102	Swing Frame 1	18.50			
4a	A3405	Floor Plate	20.65	III	0.07	0.0312
4b	A3405	Floor Plate	26.50			
5	A1104	Swing Frame 2	31.50			
6	A1106	Engine	42.50	IV	0.00	0.0000
7a	A1106	Swing Frame 3	44.57			
7b	A1106	Swing Frame 3	45.50			
8	A1108	Swing Frame 4	48.50	V	0.03	0.0224
9	A1109	Swing Frame 5	53.50			
10a	A1110	Swing Frame 6	55.96			
10b	A1110	Swing Frame 6	60.50	VI	0.01	0.0081
11	A2101	Base Frame	74.50			
12a	A4111	Docking, Fuel, Oil	74.67			
12b	A4111	Docking, Fuel, Oil	75.00	VII	0.04	0.0334
13	A4112	C/W & Testing	76.50			
14a	A3613	Sub Boom	81.43			
14b	A3613	Sub Boom	82.50	VIII	0.05	0.0439
15	A5614	Install Boom	83.50			
16	R1016	Steam Washing	83.50			
17	R2017	Sanding	83.50	IX	0.22	
18a	R4019	Painting	83.56			
18b	R4019	Painting	84.00			
19	R5020	Decall	85.00	IX	0.22	
20a	R6027	Install Cab	87.89			
20b	R6027	Install Cab	94.00			
21	R7022	Install Enclosure	100.00			
TOTAL					0.50	0.1441