

Lampiran

Tabel Produktivitas

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| NO | IP | FINISH/D | | EFISIENSI FINISHING | PCS/MONTH | ACT.MP | MD/BLN | MP | EST KENAIKAN PRODUKTIFITAS | NOTE |
|----|--------|----------|-------|------------------------|-----------|--------|--------|------|-------------------------------|-------------------------------------|
| | | STD | ACT | | | | | | | |
| 1 | 195001 | 1.260 | 1.650 | 131 % | | 11,15 | 328 | 14,6 | | MODIFIKASI CUT FLOW |
| 2 | 58016 | 1.316 | 2.625 | 199 % | | 9,43 | 420,9 | 18,8 | | BUAT MOLD BARU = 2 SET |
| 3 | 58021 | 1.225 | 600 | 49 % | | 4,49 | 49,1 | 2,2 | | IMPROVE CUT FLOW |
| 4 | 006075 | 560 | 1.275 | 228 % | | 4,08 | 208,2 | 9,3 | | IMPROVE BURRY DI INNER METAL |
| 5 | 87024 | 658 | 375 | 57 % | | 4,04 | 50,8 | 2,3 | | BUAT MOLD BARU (KONFIRMASI MKT) |
| 6 | 177003 | 630 | 840 | 133 % | | 3,23 | 95,4 | 4,3 | | IMPROVE CUT FLOW |
| 7 | 58026 | 2.191 | 1.050 | 48 % | | 2,71 | 29,6 | 1,3 | | BUAT MOLD BARU (SHOOT 64 K) |
| 8 | 006074 | 3.500 | 750 | 21 % | | 2,33 | 12,1 | 0,5 | | BUAT MOLD BARU (SHOOT 15 K) |
| 9 | 151001 | 1.750 | 1.552 | 89 % | | 1,92 | 38,2 | 1,7 | | |
| 10 | 006077 | 1.400 | 750 | 54 % | | 1,87 | 21,4 | 1 | | IMPROVE CUT FLOW |
| 11 | 6003 | 7.679 | 7.500 | 98 % | | 1,43 | 31,9 | 1,4 | | METODE PUNCH |
| 12 | 006076 | 700 | 1.950 | 279 % | | 1,40 | 88,5 | 3,9 | | FINISHING INNER DIAMETER METAL |
| 13 | 87026 | 350 | 382 | 109 % | | 1,37 | 34 | 1,5 | | BUAT MOLD BARU (KONFIRMASI MKT) |
| 14 | 87002 | 5.600 | 6.000 | 107 % | | 1,21 | 28,6 | 1,3 | | |
| 15 | 6002 | 4.689 | 7.500 | 160 % | | 1,13 | 40,2 | 1,8 | | |
| 16 | 58017 | 1.316 | 4.005 | 304 % | | 1,12 | 75,4 | 3,4 | | |
| 17 | 91008 | 4.004 | 4.290 | 107 % | | 1,08 | 23,7 | 1,1 | | |
| 18 | 87001 | 12.250 | 9.000 | 73 % | | 0,95 | 16,3 | 0,7 | | IMPROVE PROSES FINISHING |
| 19 | 169003 | 1.400 | 1.500 | 107 % | | 0,84 | 19,2 | 0,9 | | |
| 20 | 95017 | 1.750 | 2.122 | 121 % | | 0,82 | 21,9 | 1 | | |
| 21 | 005024 | 350 | 300 | 86 % | | 0,70 | 13,6 | 0,6 | | IMPROVE MOLD = REKONDISI PLAT BAWAH |
| 22 | 005025 | 350 | 825 | 236 % | | 0,68 | 36,3 | 1,6 | | IMPROVE MOLD = REKONDISI PLAT BAWAH |
| 23 | 99014 | 525 | 562 | 107 % | | 0,56 | 13 | 0,6 | | REPAIR MOLD |
| 24 | 87017 | 630 | 675 | 107 % | | 0,56 | 14,5 | 0,6 | | BUAT MOLD BARU (KONFIRMASI MKT) |
| 25 | 178002 | 2.100 | 2.250 | 107 % | | 0,56 | 13,6 | 0,6 | | |
| 26 | 31021 | 1.225 | 2.392 | 195 % | | 0,26 | 11,5 | 0,5 | | |

Contoh pengambilan data Di Produksi

| LEMBAR PENGUKURAN WAKTU | | | | | | | | | | | PART NAME | | PROSES | | Moulding | |
|-------------------------|---------------------|-----------------|-----|-----|-----|-----|-----|-----|-----|-----|--------------|--------------------------|------------|--|--------------------|--|
| | | | | | | | | | | | IP 006071 | | NAMA | | AMIR | |
| | | | | | | | | | | | MESIN | | TANGGAL | | 25-10-2019 | |
| | | | | | | | | | | | GP 200 No 16 | | CAVITY STD | | : 100 | |
| | | | | | | | | | | | | | | | CAVITY AKTUAL : 95 | |
| NO | ELEMEN KERJA | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | KETERANGAN | | | | |
| 1. | Pengambilan Produk | 180 | 182 | 181 | 184 | 184 | 186 | 184 | 184 | 184 | 185 | Operator Memegang | | | | |
| 2. | Pemasangan Material | 40 | 42 | 40 | 42 | 41 | 41 | 37 | 38 | 40 | 40 | 2 Mesin | | | | |
| 3. | Check Produk | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | 0 | GP 200 No 15 | | | | |
| 4. | Siapkan Material | Mejal 48 60m | 50 | 50 | 60 | 48 | 55 | 56 | 55 | 50 | 50 | IP 005021 | | | | |
| 5. | Mold Menutup | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 7 Jam : 25200 detik | | | | |
| 6. | Transfer + Bumping | 67 | 67 | 67 | 67 | 67 | 67 | 67 | 67 | 67 | 67 | 742 | | | | |
| 7. | Curing | 420 | 420 | 420 | 420 | 420 | 420 | 420 | 420 | 420 | 420 | = 33 Shot/Shift | | | | |
| 8. | Mold Membuka | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 33 X 95 = 3135 Pes/Shift | | | | |
| | | | | | | | | | | | | Allowance | | | | |
| | | | | | | | | | | | | 33 X 95 = 28 Shot/Shift | | | | |
| | | | | | | | | | | | | 28 X 95 = 2660 Pes/Shift | | | | |
| | | | | | | | | | | | | Aktual : 27 | | | | |
| | CYCLE TIME | | | | | | | | | | 742 | | | | | |

Contoh Data yang sudah Di Verifikasi

| NO | IP | M/C | CAV | | C/T (Sec.) Ver | C/T (Sec.) R&D | MOLDING | | | | Kapasitas Qty/Day |
|----|----------|-----------------------|-----|-----|-------------------|-------------------|----------|-------------|------------|--------|----------------------|
| | | | STD | ACT | | | Estimasi | Shoot/Shift | | Aktual | |
| | | | | | | | | R&D | Verifikasi | | |
| 1 | 006071-1 | GP 20-16 | 100 | 95 | 660 420 | | 25 | | | | 2400 |
| 2 | 006071-2 | GP 200-16 M3 250-1 | 100 | 100 | 615 420 | | 25 | 24 | 24 | | 1600 |
| 3 | 006072-1 | 13 200-3 | 64 | 64 | 876 480 | | 25 | 25 | 25 | | 1024 |
| 4 | 006073-1 | 1W 250-4 M3 250-1 | 64 | 64 | 797 500 | | 25 | 16 | 16 | | 1024 |
| 5 | 006074-1 | 16 300-3 | 32 | 32 | 718 420 | | 36 | 32 | 32 | | 1880 |
| 6 | 006075-1 | GP 200-13 | 49 | 47 | 580 360 | | 21 | 40 | 40 | | 1054 |
| 7 | 006076-1 | GP 200-15 | 36 | 34 | 1135 480 | | 21 | 31 | 31 | | 1989 |
| 8 | 006075-2 | | | | | | | | | | |
| 9 | 006076-2 | | | | | | | | | | |
| 10 | 006077-1 | GP 100-3 | 64 | 69 | 794 480 | | 30 | 31 | 31 | | |
| 11 | 006077-2 | | 64 | | | | 30 | | | | |
| 12 | 006078-1 | | 64 | | 794 | | 30 | | | | |
| 13 | 177003-1 | GP 250-1 | 48 | 48 | 702 480 | | 25 | | | | |
| 14 | 177004-1 | GP 300 100-1 | 64 | 69 | 420 714 | | 30 | 35 | 35 | | 2240 |
| 15 | 195001-1 | | 144 | | 606 | | 30 | | | | |
| 16 | 195001-2 | GP 300-3 | 224 | 224 | 778 360 | | 25 | 27 | 27 | | 6048 |