

LAMPIRAN AVAILABILITY

Lampiran 1 Data perhitungan *availability* mesin spray drayer bulan April

APRIL								
Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
1-Apr-2019	1440	0	1440	0	0	0	1440	100%
2-Apr-2019	1440	360	1080	50	0	50	1030	95%
3-Apr-2019	1440	0	1440	0	0	0	1440	100%
4-Apr-2019	1440	0	1440	0	0	0	1440	100%
5-Apr-2019	1440	0	1440	120	180	300	1140	79%
6-Apr-2019	1440	0	1440	0	0	0	1440	100%
7-Apr-2019	1440	0	1440	0	0	0	1440	100%
8-Apr-2019	1440	0	1440	0	0	0	1440	100%
9-Apr-2019	1440	173	1267	35	0	35	1232.2	97%
10-Apr-2019	1440	0	1440	0	0	0	1440	100%
11-Apr-2019	1440	0	1440	0	60	60	1380	96%
12-Apr-2019	1440	0	1440	0	0	0	1440	100%
13-Apr-2019	1440	0	1440	0	45	45	1395	97%
14-Apr-2019	1440	0	1440	60	0	60	1380	96%
15-Apr-2019	1440	165	1275	40	0	40	1235	97%
16-Apr-2019	1440	0	1440	0	20	20	1420	99%
17-Apr-2019	0	0	0	0	0	0	0	0%
18-Apr-2019	1440	0	1440	60	0	60	1380	96%
19-Apr-2019	1440	0	1440	80	60	140	1300	90%
20-Apr-2019	1440	0	1440	95	30	125	1315	91%
21-Apr-2019	1440	0	1440	0	0	0	1440	100%
22-Apr-2019	1440	120	1320	30	0	30	1290	98%
23-Apr-2019	1440	0	1440	0	0	0	1440	100%
24-Apr-2019	1440	0	1440	0	0	0	1440	100%
25-Apr-2019	1440	0	1440	0	0	0	1440	100%
26-Apr-2019	1440	0	1440	0	0	0	1440	100%
27-Apr-2019	1440	0	1440	50	140	190	1250	87%
28-Apr-2019	1440	0	1440	0	45	45	1395	97%
Rata-rata								93%

Lampiran 2 Data perhitungan *availability* mesin spray drayer bulan Mei

MEI								
Tanggal	Working time machine	Planned Downtime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
29-Apr-2019	1440	360	1080	48	0	48	1032.00	96%
30-Apr-2019	1440	0	1440	0	0	0	1440.00	100%
1-May-2019	1440	0	1440	0	0	0	1440.00	100%
2-May-2019	1440	0	1440	0	0	0	1440.00	100%
3-May-2019	1440	0	1440	0	0	0	1440.00	100%
4-May-2019	1440	0	1440	0	0	0	1440.00	100%
5-May-2019	1440	0	1440	66	150	216	1224.00	85%
6-May-2019	1440	0	1440	80	120	200	1240.00	86%
7-May-2019	1440	405	1035	45	0	45	990.00	96%
8-May-2019	1440	0	1440	0	0	0	1440.00	100%
9-May-2019	1440	0	1440	45	60	105	1335.00	93%
10-May-2019	1440	0	1440	0	0	0	1440.00	100%
11-May-2019	1440	0	1440	0	0	0	1440.00	100%
12-May-2019	1440	0	1440	0	60	60	1380.00	96%
13-May-2019	1440	0	1440	0	0	0	1440.00	100%
14-May-2019	1440	330	1110	120	0	120	990.00	89%
15-May-2019	1440	0	1440	0	0	0	1440.00	100%
16-May-2019	1440	0	1440	0	80	80	1360.00	94%
17-May-2019	1440	0	1440	0	0	0	1440.00	100%
18-May-2019	1440	0	1440	0	0	0	1440.00	100%
19-May-2019	1440	0	1440	0	0	0	1440.00	100%
20-May-2019	1440	0	1440	45	0	45	1395.00	97%
21-May-2019	1440	570	870	50	0	50	820.00	94%
22-May-2019	1440	0	1440	84	120	204	1236.00	86%
23-May-2019	1440	0	1440	0	0	0	1440.00	100%
24-May-2019	1440	0	1440	0	0	0	1440.00	100%
25-May-2019	1440	0	1440	78	120	198	1242.00	86%
26-May-2019	1440	0	1440	0	0	0	1440.00	100%
Rata-rata								96%

Lampiran 3 Data perhitungan *availability* mesin spray drayer bulan Juni

JUNI								
Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
27-May-2019	1440	0	1440	45	0	45	1395	97%
28-May-2019	1440	480	960	50	0	50	910	95%
29-May-2019	1440	0	1440	40	0	41	1399	97%
30-May-2019	480	0	480	60	90	150	330	69%
12-Jun-2019	480	0	480	0	0	0	480	100%
13-Jun-2019	1440	0	1440	0	0	0	1440	100%
14-Jun-2019	1440	0	1440	0	0	0	1440	100%
15-Jun-2019	1440	0	1440	50	60	110	1330	92%
16-Jun-2019	1440	0	1440	0	0	0	1440	100%
17-Jun-2019	1440	0	1440	0	0	0	1440	100%
18-Jun-2019	1440	480	960	60	0	60	900	94%
19-Jun-2019	1440	0	1440	0	0	0	1440	100%
20-Jun-2019	1440	0	1440	50	60	110	1330	92%
21-Jun-2019	1440	0	1440	0	0	0	1440	100%
22-Jun-2019	1440	0	1440	0	0	0	1440	100%
23-Jun-2019	1440	0	1440	0	35	35	1405	98%
24-Jun-2019	1440	0	1440	0	20	20	1420	99%
25-Jun-2019	1440	480	960	60	0	60	900	94%
26-Jun-2019	1440	0	1440	0	0	0	1440	100%
27-Jun-2019	1440	0	1440	0	35	35	1405	98%
28-Jun-2019	1440	0	1440	0	0	0	1440	100%
29-Jun-2019	1440	0	1440	40	120	160	1280	89%
30-Jun-2019	1440	0	1440	0	0	0	1440	100%
Total								96%

Lampiran 4 Data perhitungan *availability* mesin spray drayer bulan Juli

JULI								
Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
1-Jul-2019	1440	0	1440		0	0	1440	100%
2-Jul-2019	1440	0	1440	45	30	75	1365	95%
3-Jul-2019	1440	0	1440		0	0	1440	100%
4-Jul-2019	1440	480	960	60	0	60	900	94%
5-Jul-2019	1440	0	1440		0	0	1440	100%
6-Jul-2019	1440	0	1440	120	190	310	1130	78%
7-Jul-2019	1440	0	1440		0	0	1440	100%
8-Jul-2019	1440	0	1440		0	0	1440	100%
9-Jul-2019	1440	0	1440		45	45	1395	97%
10-Jul-2019	1440	0	1440		0	0	1440	100%
11-Jul-2019	1440	240	1200	45	0	45	1155	96%
12-Jul-2019	1440	0	1440		0	0	1440	100%
13-Jul-2019	1440	0	1440		0	0	1440	100%
14-Jul-2019	1440	0	1440		0	0	1440	100%
15-Jul-2019	1440	0	1440	25	15	40	1400	97%
16-Jul-2019	1440	0	1440		0	0	1440	100%
17-Jul-2019	1440	0	1440		0	0	1440	100%
18-Jul-2019	1440	480	960	30	90	120	840	88%
19-Jul-2019	1440	0	1440		0	0	1440	100%
20-Jul-2019	1440	0	1440	35	30	65	1375	95%
21-Jul-2019	1440	0	1440	25	15	40	1400	97%
22-Jul-2019	1440	0	1440		0	0	1440	100%
23-Jul-2019	1440	0	1440		0	0	1440	100%
24-Jul-2019	1440	0	1440		0	0	1440	100%
25-Jul-2019	1440	480	960	60	0	60	900	94%
26-Jul-2019	1440	0	1440		0	0	1440	100%
27-Jul-2019	1440	0	1440	30	50	80	1360	94%
28-Jul-2019	1440	0	1440		0	0	1440	100%
Rata-rata								97%

Lampiran 5 Data perhitungan *availability* mesin spray drayer bulan Agustus

AGUSTUS								
Tanggal	Working time machine	Planned Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
29-Jul-2019	1440	0	1440	35	15	50	1390.00	97%
30-Jul-2019	1440	0	1440		0	0	1440.00	100%
31-Jul-2019	1440	267	1173	40	15	55	1118.00	95%
1-Aug-2019	1440	0	1440		0	0	1440.00	100%
2-Aug-2019	1440	0	1440		0	0	1440.00	100%
3-Aug-2019	1440	0	1440		0	0	1440.00	100%
4-Aug-2019	1440	0	1440	90	300	390	1050.00	73%
5-Aug-2019	1440	0	1440		0	0	1440.00	100%
6-Aug-2019	1440	0	1440		0	0	1440.00	100%
7-Aug-2019	1440	480	960	60	0	60	900.00	94%
8-Aug-2019	1440	0	1440		25	25	1415.00	98%
9-Aug-2019	1440	0	1440		0	0	1440.00	100%
10-Aug-2019	1440	0	1440		0	0	1440.00	100%
11-Aug-2019	1440	0	1440	30	30	60	1380.00	96%
12-Aug-2019	1440	0	1440		60	60	1380.00	96%
13-Aug-2019	1440	0	1440		0	0	1440.00	100%
14-Aug-2019	1440	480	960		0	0	960.00	100%
15-Aug-2019	1440	0	1440		0	0	1440.00	100%
16-Aug-2019	1440	0	1440		35	35	1405.00	98%
17-Aug-2019	1440	0	1440		50	50	1390.00	97%
18-Aug-2019	1440	0	1440		0	0	1440.00	100%
19-Aug-2019	1440	0	1440		0	0	1440.00	100%
20-Aug-2019	1440	0	1440		0	0	1440.00	100%
21-Aug-2019	1440	480	960	60	0	60	900.00	94%
22-Aug-2019	1440	0	1440		0	0	1440.00	100%
23-Aug-2019	1440	0	1440	75	240	315	1125.00	78%
24-Aug-2019	1440	0	1440		0	0	1440.00	100%
25-Aug-2019	1440	0	1440		0	0	1440.00	100%
Rata-rata								97%

Lampiran 6 Data perhitungan *availability* mesin spray drayer bulan September

SEPTEMBER								
Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
26-Aug-2019	1440	0	1440	0	25	25	1415	98%
27-Aug-2019	1440	0	1440	0	0	0	1440	100%
28-Aug-2019	1440	480	960	60	0	60	900	94%
29-Aug-2019	1440	0	1440	0	0	0	1440	100%
30-Aug-2019	1440	0	1440	0	35	35	1405	98%
31-Aug-2019	1440	0	1440	0	15	15	1425	99%
1-Sep-2019	1440	0	1440	0	0	0	1440	100%
2-Sep-2019	1440	0	1440	0	0	0	1440	100%
3-Sep-2019	1440	0	1440	0	0	0	1440	100%
4-Sep-2019	1440	480	960	80	20	100	860	90%
5-Sep-2019	1440	0	1440	0	0	0	1440	100%
6-Sep-2019	1440	0	1440	0	0	0	1440	100%
7-Sep-2019	1440	0	1440	0	25	25	1415	98%
8-Sep-2019	1440	0	1440	0	15	15	1425	99%
9-Sep-2019	1440	0	1440	0	0	0	1440	100%
10-Sep-2019	1440	0	1440	0	0	0	1440	100%
11-Sep-2019	1440	480	960	60	0	60	900	94%
12-Sep-2019	1440	0	1440	0	0	0	1440	100%
13-Sep-2019	1440	0	1440	0	0	0	1440	100%
14-Sep-2019	1440	0	1440	0	0	0	1440	100%
15-Sep-2019	1440	0	1440	0	45	45	1395	97%
16-Sep-2019	1440	0	1440	0	0	0	1440	100%
17-Sep-2019	1440	0	1440	0	0	0	1440	100%
18-Sep-2019	1440	480	960	75	0	75	885	92%
19-Sep-2019	1440	0	1440	0	0	0	1440	100%
20-Sep-2019	1440	0	1440	0	0	0	1440	100%
21-Sep-2019	1440	0	1440	45	90	135	1305	91%
22-Sep-2019	1440	0	1440	0	0	0	1440	100%
23-Sep-2019	1440	0	1440	0	0	0	1440	100%
24-Sep-2019	1440	0	1440	0	0	0	1440	100%
25-Sep-2019	1440	480	960	60	0	60	900	94%
26-Sep-2019	1440	0	1440	0	0	0	1440	100%
27-Sep-2019	1440	0	1440	15	50	65	1375	95%
28-Sep-2019	1440	0	1440	0	0	0	1440	100%
29-Sep-2019	1440	0	1440	0	0	0	1440	100%
Rata-rata								98%

Lampiran 7 Data perhitungan *availability* mesin spray drayer bulan Oktober

OKTOBER								
Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
30-Sep-2019	1440	0	1440	0	35	35	1405	98%
1-Oct-2019	1440	0	1440	0	0	0	1440	100%
2-Oct-2019	1440	480	960	60	0	60	900	94%
3-Oct-2019	1440	0	1440	25	60	85	1355	94%
4-Oct-2019	1440	0	1440	0	0	0	1440	100%
5-Oct-2019	1440	0	1440	0	0	0	1440	100%
6-Oct-2019	1440	0	1440	0	0	0	1440	100%
7-Oct-2019	1440	0	1440	0	0	0	1440	100%
8-Oct-2019	1440	0	1440	80	180	260	1180	82%
9-Oct-2019	1440	480	960	75	0	75	885	92%
10-Oct-2019	1440	0	1440	0	0	0	1440	100%
11-Oct-2019	1440	0	1440	0	40	40	1400	97%
12-Oct-2019	1440	0	1440	0	15	15	1425	99%
13-Oct-2019	1440	0	1440	0	0	0	1440	100%
14-Oct-2019	1440	0	1440	0	0	0	1440	100%
15-Oct-2019	1440	0	1440	0	0	0	1440	100%
16-Oct-2019	1440	480	960	60	30	90	870	91%
17-Oct-2019	1440	0	1440	0	0	0	1440	100%
18-Oct-2019	1440	0	1440	0	0	0	1440	100%
19-Oct-2019	1440	0	1440	30	30	60	1380	96%
20-Oct-2019	1440	0	1440	0	0	0	1440	100%
21-Oct-2019	1440	0	1440	0	0	0	1440	100%
22-Oct-2019	1440	0	1440	0	0	0	1440	100%
23-Oct-2019	1440	480	960	60	0	60	900	94%
24-Oct-2019	1440	0	1440	0	0	0	1440	100%
25-Oct-2019	1440	0	1440	0	0	0	1440	100%
26-Oct-2019	1440	0	1440	0	0	0	1440	100%
27-Oct-2019	1440	0	1440	0	0	0	1440	100%
Rata-rata								98%

Lampiran 8 Data perhitungan *availability* mesin spray drayer bulan November

NOVEMBER								
Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
28-Oct-2019	1440	0	1440	0	0	0	1440	100%
29-Oct-2019	1440	0	1440	0	0	0	1440	100%
30-Oct-2019	1440	480	960	70	120	190	770	80%
31-Oct-2019	1440	0	1440	0	0	0	1440	100%
1-Nov-2019	1440	0	1440	0	45	45	1395	97%
2-Nov-2019	1440	0	1440	0	0	0	1440	100%
3-Nov-2019	1440	0	1440	0	0	0	1440	100%
4-Nov-2019	1440	0	1440	0	0	0	1440	100%
5-Nov-2019	1440		1440	0	0	0	1440	100%
6-Nov-2019	1440	480	960	60	0	60	900	94%
7-Nov-2019	1440	0	1440	0	0	0	1440	100%
8-Nov-2019	1440	0	1440	0	0	0	1440	100%
9-Nov-2019	0	0	0	0	0	0	0	0%
10-Nov-2019	1440	0	1440	0	0	0	1440	100%
11-Nov-2019	1440	0	1440	0	0	0	1440	100%
12-Nov-2019	1440		1440	25	80	105	1335	93%
13-Nov-2019	1440	480	960	0	0	0	960	100%
14-Nov-2019	1440	0	1440	0	0	0	1440	100%
15-Nov-2019	1440	0	1440	15	30	45	1395	97%
16-Nov-2019	1440	0	1440	0	0	0	1440	100%
17-Nov-2019	1440	0	1440	0	0	0	1440	100%
18-Nov-2019	1440	0	1440	0	0	0	1440	100%
19-Nov-2019	780		780	60	0	60	720	92%
20-Nov-2019	780	480	300	0	0	0	300	100%
21-Nov-2019	1440	0	1440	0	0	0	1440	100%
22-Nov-2019	1440	0	1440	0	0	0	1440	100%
23-Nov-2019	1440	0	1440	0	20	20	1420	99%
24-Nov-2019	1440	0	1440	0	0	0	1440	100%
25-Nov-2019	1440	0	1440	0	0	0	1440	100%
26-Nov-2019	1440	0	1440	0	0	0	1440	100%
27-Nov-2019	1440	480	960	60	0	60	900	94%
28-Nov-2019	1440	0	1440	0	0	0	1440	100%
29-Nov-2019	1440	0	1440	0	35	35	1405	98%
30-Nov-2019	1440	0	1440	0	15	15	1425	99%
1-Dec-2019	1440	0	1440	0	0	0	1440	100%
Rata-rata								95%

Lampiran 9 Data perhitungan *availability* mesin spray drayer bulan Desember

Tanggal	Working time machine	Planed Dontime	Loading Time	Set UP	Downtime Machine	Total Downtime	Operation Time	Availability
2-Dec-2019	1440	0	1440	0	0	0	1440	100%
3-Dec-2019	1440	0	1440	0	0	0	1440	100%
4-Dec-2019	1440	480	960	60	0	60	900	94%
5-Dec-2019	1440	0	1440	0	0	0	1440	100%
6-Dec-2019	1440	0	1440	0	0	0	1440	100%
7-Dec-2019	1440	0	1440	0	0	0	1440	100%
8-Dec-2019	1440	0	1440	0	0	0	1440	100%
9-Dec-2019	1440	0	1440	0	65	65	1375	95%
10-Dec-2019	1440	0	1440	0	0	0	1440	100%
11-Dec-2019	1440	480	960	80	0	80	880	92%
12-Dec-2019	1440	0	1440	0	0	0	1440	100%
13-Dec-2019	1440	0	1440	0	0	0	1440	100%
14-Dec-2019	1440	0	1440	0	0	0	1440	100%
15-Dec-2019	1440	0	1440	0	0	0	1440	100%
16-Dec-2019	1440		1440	20	90	110	1330	92%
17-Dec-2019	1440	0	1440	0	0	0	1440	100%
18-Dec-2019	1440	480	960	65	0	65	895	93%
19-Dec-2019	1440	0	1440	0	0	0	1440	100%
20-Dec-2019	1440	0	1440	0	0	0	1440	100%
21-Dec-2019	1440	0	1440	0	0	0	1440	100%
22-Dec-2019	1440	0	1440	0	0	0	1440	100%
23-Dec-2019	1440	0	1440	0	0	0	1440	100%
24-Dec-2019	780	0	780	0	0	0	780	100%
Total								99%

LAMPIRAN PERFORMANCE

Lampiran 10 Data perhitungan *performance* mesin spray drayer bulan April

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
1-Apr-2019	28670	0.048	1440	96%
2-Apr-2019	19305	0.048	1030	90%
3-Apr-2019	28325	0.048	1440	94%
4-Apr-2019	27135	0.048	1440	90%
5-Apr-2019	22030	0.048	1140	93%
6-Apr-2019	28175	0.048	1440	94%
7-Apr-2019	28325	0.048	1440	94%
8-Apr-2019	28450	0.048	1440	95%
9-Apr-2019	25165	0.048	1232.2	98%
10-Apr-2019	28710	0.048	1440	96%
11-Apr-2019	25365	0.048	1380	88%
12-Apr-2019	28735	0.048	1440	96%
13-Apr-2019	28500	0.048	1395	98%
14-Apr-2019	27745	0.048	1380	97%
15-Apr-2019	25460	0.048	1235	99%
16-Apr-2019	28750	0.048	1420	97%
17-Apr-2019	0	0	0	0%
18-Apr-2019	27985	0.048	1380	97%
19-Apr-2019	26850	0.048	1300	99%
20-Apr-2019	27150	0.048	1315	99.1%
21-Apr-2019	28920	0.048	1440	96%
22-Apr-2019	26410	0.048	1290	98%
23-Apr-2019	28380	0.048	1440	95%
24-Apr-2019	28750	0.048	1440	96%
25-Apr-2019	26295	0.048	1440	88%
26-Apr-2019	25640	0.048	1440	85%
27-Apr-2019	28930	0.048	1250	111%
28-Apr-2019	24215	0.048	1395	83%
Total				92%

Lampiran 11 Data perhitungan *performance* mesin spray drayer bulan Mei

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
29-Apr-2019	17765	0.048	1032	83%
30-Apr-2019	28960	0.048	1440	97%
1-May-2019	9860	0.144	1440	99%
2-May-2019	29580	0.048	1440	99%
3-May-2019	27505	0.048	1440	92%
4-May-2019	29750	0.048	1440	99%
5-May-2019	24850	0.048	1224	97%
6-May-2019	24950	0.048	1240	97%
7-May-2019	19080	0.048	990	93%
8-May-2019	28520	0.048	1440	95%
9-May-2019	27650	0.048	1335	99%
10-May-2019	29455	0.048	1440	98%
11-May-2019	25095	0.048	1440	84%
12-May-2019	28085	0.048	1380	98%
13-May-2019	29395	0.048	1440	98%
14-May-2019	19850	0.048	990	96%
15-May-2019	26330	0.048	1440	88%
16-May-2019	24565	0.048	1360	87%
17-May-2019	26105	0.048	1440	87%
18-May-2019	25420	0.048	1440	85%
19-May-2019	25635	0.048	1440	85%
20-May-2019	27705	0.048	1395	95%
21-May-2019	14450	0.048	820	85%
22-May-2019	24900	0.048	1236	97%
23-May-2019	24685	0.048	1440	82%
24-May-2019	27775	0.048	1440	93%
25-May-2019	24550	0.048	1242	95%
26-May-2019	29100	0.048	1440	97%
Total				93%

Lampiran 12 Data perhitungan *performance* mesin spray drayer bulan Juni

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
27-May-2019	28550	0.048	1395	98%
28-May-2019	15900	0.048	910	84%
29-May-2019	28675	0.048	1399	98%
30-May-2019	5095	0.048	330	74%
12-Jun-2019	6330	0.048	480	63%
13-Jun-2019	27320	0.048	1440	91%
14-Jun-2019	26765	0.048	1440	89%
15-Jun-2019	25995	0.048	1330	94%
16-Jun-2019	26610	0.048	1440	89%
17-Jun-2019	27305	0.048	1440	91%
18-Jun-2019	17850	0.048	900	95%
19-Jun-2019	26675	0.048	1440	89%
20-Jun-2019	26850	0.048	1330	97%
21-Jun-2019	27340	0.048	1440	91%
22-Jun-2019	27000	0.048	1440	90%
23-Jun-2019	26985	0.048	1405	92%
24-Jun-2019	27490	0.048	1420	93%
25-Jun-2019	17850	0.048	900	95%
26-Jun-2019	27510	0.048	1440	92%
27-Jun-2019	27000	0.048	1405	92%
28-Jun-2019	27340	0.048	1440	91%
29-Jun-2019	23050	0.048	1280	86%
30-Jun-2019	27000	0.048	1440	90%
Total				90%

Lampiran 13 Data perhitungan *performance* mesin spray drayer bulan Juli

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
1-Jul-2019	29050	0.048	1440	97%
2-Jul-2019	26510	0.048	1365	93%
3-Jul-2019	25960	0.048	1440	87%
4-Jul-2019	17855	0.048	900	95%
5-Jul-2019	27080	0.048	1440	90%
6-Jul-2019	23045	0.048	1130	98%
7-Jul-2019	22290	0.048	1440	74%
8-Jul-2019	26960	0.048	1440	90%
9-Jul-2019	26000	0.048	1395	89%
10-Jul-2019	25960	0.048	1440	87%
11-Jul-2019	23500	0.048	1155	98%
12-Jul-2019	26170	0.048	1440	87%
13-Jul-2019	26000	0.048	1440	87%
14-Jul-2019	26000	0.048	1440	87%
15-Jul-2019	26320	0.048	1400	90%
16-Jul-2019	25890	0.048	1440	86%
17-Jul-2019	26045	0.048	1440	87%
18-Jul-2019	14900	0.048	840	85%
19-Jul-2019	27850	0.048	1440	93%
20-Jul-2019	26045	0.048	1375	91%
21-Jul-2019	25040	0.048	1400	86%
22-Jul-2019	29080	0.048	1440	97%
23-Jul-2019	26900	0.048	1440	90%
24-Jul-2019	28000	0.048	1440	93%
25-Jul-2019	16700	0.048	900	89%
26-Jul-2019	26510	0.048	1440	88%
27-Jul-2019	27000	0.048	1360	95%
28-Jul-2019	27510	0.048	1440	92%
Rata-rata				90%

Lampiran 14 Data perhitungan *performance* mesin spray drayer bulan Agustus

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
29-Jul-2019	27800	0.048	1390	96.0%
30-Jul-2019	29100	0.048	1440	97.0%
31-Jul-2019	23000	0.048	1118	99%
1-Aug-2019	26960	0.048	1440	90%
2-Aug-2019	28010	0.048	1440	93%
3-Aug-2019	28900	0.048	1440	96%
4-Aug-2019	20025	0.048	1050	92%
5-Aug-2019	27650	0.048	1440	92%
6-Aug-2019	27055	0.048	1440	90%
7-Aug-2019	18500	0.048	900	99%
8-Aug-2019	27055	0.048	1415	92%
9-Aug-2019	27205	0.048	1440	91%
10-Aug-2019	26900	0.048	1440	90%
11-Aug-2019	23575	0.048	1380	82%
12-Aug-2019	28595	0.048	1380	99%
13-Aug-2019	29545	0.048	1440	98%
14-Aug-2019	18350	0.048	960	92%
15-Aug-2019	29055	0.048	1440	97%
16-Aug-2019	28055	0.048	1405	96%
17-Aug-2019	28055	0.048	1390	97%
18-Aug-2019	28055	0.048	1440	94%
19-Aug-2019	29105	0.048	1440	97%
20-Aug-2019	29080	0.048	1440	97%
21-Aug-2019	17900	0.048	900	95%
22-Aug-2019	28110	0.048	1440	94%
23-Aug-2019	22250	0.048	1125	95%
24-Aug-2019	28555	0.048	1440	95%
25-Aug-2019	28555	0.048	1440	95%
Rata-rata				94%

Lampiran 15 Data perhitungan *performance* mesin spray drayer bulan September

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
26-Aug-2019	28155	0.048	1415	96%
27-Aug-2019	28945	0.048	1440	96%
28-Aug-2019	14950	0.048	900	80%
29-Aug-2019	25900	0.048	1440	86%
30-Aug-2019	26050	0.048	1405	89%
31-Aug-2019	26650	0.048	1425	90%
1-Sep-2019	27900	0.048	1440	93%
2-Sep-2019	28550	0.048	1440	95%
3-Sep-2019	27650	0.048	1440	92%
4-Sep-2019	16800	0.048	860	94%
5-Sep-2019	29100	0.048	1440	97%
6-Sep-2019	27650	0.048	1440	92%
7-Sep-2019	27650	0.048	1415	94%
8-Sep-2019	27800	0.048	1425	94%
9-Sep-2019	27650	0.048	1440	92%
10-Sep-2019	28630	0.048	1440	95%
11-Sep-2019	16850	0.048	900	90%
12-Sep-2019	27900	0.048	1440	93%
13-Sep-2019	23575	0.048	1440	79%
14-Sep-2019	28595	0.048	1440	95%
15-Sep-2019	28500	0.048	1395	98%
16-Sep-2019	28350	0.048	1440	95%
17-Sep-2019	26650	0.048	1440	89%
18-Sep-2019	16020	0.048	885	87%
19-Sep-2019	26650	0.048	1440	89%
20-Sep-2019	26650	0.048	1440	89%
21-Sep-2019	26650	0.048	1305	98%
22-Sep-2019	26650	0.048	1440	89%
23-Sep-2019	26650	0.048	1440	89%
24-Sep-2019	27630	0.048	1440	92%
25-Sep-2019	16950	0.048	900	90%
26-Sep-2019	28645	0.048	1440	95%
27-Sep-2019	26155	0.048	1375	91%
28-Sep-2019	26650	0.048	1440	89%
29-Sep-2019	29650	0.048	1440	99%
Rata-rata				92%

Lampiran 16 Data perhitungan *performance* mesin spray drayer bulan Oktober

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
30-Sep-2019	30490	0.044	1405	95%
1-Oct-2019	31240	0.044	1440	95%
2-Oct-2019	20340	0.044	900	99%
3-Oct-2019	29400	0.044	1355	95%
4-Oct-2019	30490	0.044	1440	92%
5-Oct-2019	29740	0.044	1440	90%
6-Oct-2019	29040	0.044	1440	88%
7-Oct-2019	28445	0.044	1440	86%
8-Oct-2019	24480	0.044	1180	91%
9-Oct-2019	19480	0.044	885	96%
10-Oct-2019	28595	0.044	1440	87%
11-Oct-2019	28290	0.044	1400	88%
12-Oct-2019	31090	0.044	1425	95%
13-Oct-2019	29985	0.044	1440	91%
14-Oct-2019	30935	0.044	1440	94%
15-Oct-2019	30890	0.044	1440	94%
16-Oct-2019	19390	0.044	870	97%
17-Oct-2019	30690	0.044	1440	93%
18-Oct-2019	30840	0.044	1440	93%
19-Oct-2019	29985	0.044	1380	95%
20-Oct-2019	29890	0.044	1440	91%
21-Oct-2019	29740	0.044	1440	90%
22-Oct-2019	30290	0.044	1440	92%
23-Oct-2019	21240	0.044	900	103%
24-Oct-2019	24390	0.044	1440	74%
25-Oct-2019	28350	0.044	1440	86%
26-Oct-2019	29400	0.044	1440	89%
27-Oct-2019	31190	0.044	1440	95%
Rata-rata				92%

Lampiran 17 Data perhitungan *performance* mesin spray drayer bulan November

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
28-Oct-2019	32975	0.044	1440	99.9%
29-Oct-2019	31900	0.044	1440	96.7%
30-Oct-2019	16850	0.044	770	95.5%
31-Oct-2019	32460	0.044	1440	98.4%
1-Nov-2019	31850	0.044	1395	99.6%
2-Nov-2019	32975	0.044	1440	99.9%
3-Nov-2019	32850	0.044	1440	99.5%
4-Nov-2019	32980	0.044	1440	99.9%
5-Nov-2019	32450	0.044	1440	98.3%
6-Nov-2019	18900	0.044	900	91.6%
7-Nov-2019	32310	0.044	1440	97.9%
8-Nov-2019	32950	0.044	1440	99.8%
10-Nov-2019	31185	0.044	1440	94.5%
11-Nov-2019	32330	0.044	1440	98.0%
12-Nov-2019	30220	0.044	1335	98.8%
13-Nov-2019	19100	0.044	960	86.8%
14-Nov-2019	31750	0.044	1440	96.2%
15-Nov-2019	30220	0.044	1395	94.5%
16-Nov-2019	18900	0.044	1440	57.3%
17-Nov-2019	32310	0.044	1440	97.9%
18-Nov-2019	32950	0.044	1440	99.8%
19-Nov-2019	14850	0.047	720	97.5%
20-Nov-2019	5985	0.047	300	94.3%
21-Nov-2019	15050	0.087	1440	91.2%
22-Nov-2019	32030	0.044	1440	97.1%
23-Nov-2019	31975	0.044	1420	98.3%
24-Nov-2019	32980	0.044	1440	99.9%
25-Nov-2019	33010	0.044	1440	100.0%
26-Nov-2019	33980	0.042	1440	99.9%
27-Nov-2019	19100	0.041	900	87.3%
28-Nov-2019	31150	0.041	1440	89.0%
29-Nov-2019	32050	0.044	1405	99.5%
30-Nov-2019	31900	0.044	1425	97.7%
1-Dec-2019	32540	0.040	1440	90.4%
Rata-rata				95.4%

Lampiran 18 Data perhitungan *performance* mesin spray drayer bulan Desember

Tanggal	Hasil Produksi	Ideal Cycle time (menit)	Operation Time	Performance rate (%)
2-Dec-2019	33130	0.044	1440	100%
3-Dec-2019	30875	0.044	1440	94%
4-Dec-2019	19100	0.044	900	93%
5-Dec-2019	31635	0.044	1440	96%
6-Dec-2019	27470	0.044	1440	83%
7-Dec-2019	27450	0.044	1440	83%
8-Dec-2019	32985	0.044	1440	100%
9-Dec-2019	31200	0.044	1375	99%
10-Dec-2019	33000	0.044	1440	100%
11-Dec-2019	18855	0.044	880	93%
12-Dec-2019	32970	0.044	1440	100%
13-Dec-2019	32490	0.044	1440	98%
14-Dec-2019	32980	0.044	1440	100%
15-Dec-2019	28245	0.044	1440	86%
16-Dec-2019	29085	0.044	1330	95%
17-Dec-2019	32985	0.044	1440	100%
18-Dec-2019	18900	0.044	895	92%
19-Dec-2019	33850	0.044	1440	103%
20-Dec-2019	31170	0.044	1440	94%
21-Dec-2019	31300	0.044	1440	95%
22-Dec-2019	31695	0.044	1440	96%
23-Dec-2019	27110	0.044	1440	82%
Rata-rata				95%

LAMPIRAN QUALITY RATE

Lampiran 19 Data perhitungan *rate of quality* mesin spray drayer bulan April

APRIL			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
1-Apr-2019	28670	510	98%
2-Apr-2019	19305	0	100%
3-Apr-2019	28325	1020	96%
4-Apr-2019	27135	1000	96%
5-Apr-2019	22030	340	98%
6-Apr-2019	28175	0	100%
7-Apr-2019	28325	150	99%
8-Apr-2019	28450	170	99%
9-Apr-2019	25165	0	100%
10-Apr-2019	28710	0	100%
11-Apr-2019	25365	490	98%
12-Apr-2019	28735	0	100%
13-Apr-2019	28500	0	100%
14-Apr-2019	27745	0	100%
15-Apr-2019	25460	170	99%
16-Apr-2019	28750	0	100%
18-Apr-2019	27985	680	98%
19-Apr-2019	26850	0	100%
20-Apr-2019	27150	0	100%
21-Apr-2019	28920	170	99%
22-Apr-2019	26410	0	100%
23-Apr-2019	28380	0	100%
24-Apr-2019	28750	0	100%
25-Apr-2019	26295	510	98%
26-Apr-2019	25640	0	100%
27-Apr-2019	28930	820	97%
28-Apr-2019	24215	340	99%
Rata-rata			99.1%

Lampiran 20 Data perhitungan *rate of quality* mesin spray drayer bulan Mei

MEI			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
29-Apr-2019	17765	0	100%
30-Apr-2019	28960	540	98%
1-May-2019	9860	0	100%
2-May-2019	29580	0	100%
3-May-2019	27505	0	100%
4-May-2019	29750	340	99%
5-May-2019	24850	510	98%
6-May-2019	24950	0	100%
7-May-2019	19080	150	99%
8-May-2019	28520	0	100%
9-May-2019	27650	0	100%
10-May-2019	29455	400	99%
11-May-2019	25095	170	99%
12-May-2019	28085	680	98%
13-May-2019	29395	340	99%
14-May-2019	19850	0	100%
15-May-2019	26330	0	100%
16-May-2019	24565	340	99%
17-May-2019	26105	0	100%
18-May-2019	25420	100	100%
19-May-2019	25635	0	100%
20-May-2019	27705	280	99%
21-May-2019	14450	0	100%
22-May-2019	24900	0	100%
23-May-2019	24685	0	100%
24-May-2019	27775	0	100%
25-May-2019	24550	170	99%
26-May-2019	29100	670	98%
Rata-rata			99.4%

Lampiran 21 Data perhitungan *rate of quality* mesin spray drayer bulan Juni

Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
27-May-2019	28550	150	99%
28-May-2019	15900	0	100%
29-May-2019	28675	210	99%
30-May-2019	5095	0	100%
12-Jun-2019	6330	0	100%
13-Jun-2019	27320	320	99%
14-Jun-2019	26765	0	100%
15-Jun-2019	25995	0	100%
16-Jun-2019	26610	170	99%
17-Jun-2019	27305	565	98%
18-Jun-2019	17850	150	99%
19-Jun-2019	26675	170	99%
20-Jun-2019	26850	0	100%
21-Jun-2019	27340	510	98%
22-Jun-2019	27000	0	100%
23-Jun-2019	26985	0	100%
24-Jun-2019	27490	490	98%
25-Jun-2019	17850	0	100%
26-Jun-2019	27510	510	98%
27-Jun-2019	27000	0	100%
28-Jun-2019	27340	340	99%
29-Jun-2019	23050	120	99%
30-Jun-2019	27000	0	100%
Rata-rata			99.4%

Lampiran 22 Data perhitungan *rate of quality* mesin spray drayer bulan Juli

JULI			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
1-Jul-2019	29050	450	98%
2-Jul-2019	26510	510	98%
3-Jul-2019	25960	0	100%
4-Jul-2019	17855	0	100%
5-Jul-2019	27080	510	98%
6-Jul-2019	23045	0	100%
7-Jul-2019	22290	0	100%
8-Jul-2019	26960	1000	96%
9-Jul-2019	26000	0	100%
10-Jul-2019	25960	0	100%
11-Jul-2019	23500	0	100%
12-Jul-2019	26170	170	99%
13-Jul-2019	26000	0	100%
14-Jul-2019	26000	0	100%
15-Jul-2019	26320	320	99%
16-Jul-2019	25890	0	100%
17-Jul-2019	26045	170	99%
18-Jul-2019	14900	170	99%
19-Jul-2019	27850	0	100%
20-Jul-2019	26045	170	99%
21-Jul-2019	25040	0	100%
22-Jul-2019	29080	340	99%
23-Jul-2019	26900	150	99%
24-Jul-2019	28000	180	99%
25-Jul-2019	16700	0	100%
26-Jul-2019	26510	510	98%
27-Jul-2019	27000	110	100%
28-Jul-2019	27510	345	99%
Rata-rata			99.3%

Lampiran 23 Data perhitungan *rate of quality* mesin spray drayer bulan Agustus

AGUSTUS			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
29-Jul-2019	27800	0	100%
30-Jul-2019	29100	250	99%
31-Jul-2019	23000	0	100%
1-Aug-2019	26960	0	100%
2-Aug-2019	28010	490	98%
3-Aug-2019	28900	170	99%
4-Aug-2019	20025	25	100%
5-Aug-2019	27650	0	100%
6-Aug-2019	27055	0	100%
7-Aug-2019	18500	170	99%
8-Aug-2019	27055	0	100%
9-Aug-2019	27205	150	99%
10-Aug-2019	26900	0	100%
11-Aug-2019	23575	0	100%
12-Aug-2019	28595	0	100%
13-Aug-2019	29545	130	100%
14-Aug-2019	18350	0	100%
15-Aug-2019	29055	230	99%
16-Aug-2019	28055	170	99%
17-Aug-2019	28055	320	99%
18-Aug-2019	28055	0	100%
19-Aug-2019	29105	300	99%
20-Aug-2019	29080	250	99%
21-Aug-2019	17900	0	100%
22-Aug-2019	28110	450	98%
23-Aug-2019	22250	0	100%
24-Aug-2019	28555	745	97%
25-Aug-2019	28555	450	98%
Rata-rata			99.4%

Lampiran 24 Data perhitungan *rate of quality* mesin spray drayer bulan September

SEPTEMBER			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
26-Aug-2019	28155	1530	95%
27-Aug-2019	28945	170	99%
28-Aug-2019	14950	0	100%
29-Aug-2019	25900	0	100%
30-Aug-2019	26050	150	99%
31-Aug-2019	26650	0	100%
1-Sep-2019	27900	340	99%
2-Sep-2019	28550	785	97%
3-Sep-2019	27650	0	100%
4-Sep-2019	16800	0	100%
5-Sep-2019	29100	1200	96%
6-Sep-2019	27650	120	100%
7-Sep-2019	27650	110	100%
8-Sep-2019	27800	150	99%
9-Sep-2019	27650	800	97%
10-Sep-2019	28630	145	99%
11-Sep-2019	16850	0	100%
12-Sep-2019	27900	600	98%
13-Sep-2019	23575	150	99%
14-Sep-2019	28595	450	98%
15-Sep-2019	28500	800	97%
16-Sep-2019	28350	690	98%
17-Sep-2019	26650	85	100%
18-Sep-2019	16020	0	100%
19-Sep-2019	26650	190	99%
20-Sep-2019	26650	370	99%
21-Sep-2019	26650	145	99%
22-Sep-2019	26650	500	98%
23-Sep-2019	26650	135	99%
24-Sep-2019	27630	150	99%
25-Sep-2019	16950	0	100%
26-Sep-2019	28645	1200	96%
27-Sep-2019	26155	450	98%
28-Sep-2019	26650	300	99%
29-Sep-2019	29650	1300	96%
Rata-rata			98.7%

Lampiran 25 Data perhitungan *rate of quality* mesin spray drayer bulan Oktober

OKTOBER			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
30-Sep-2019	30490	0	100%
1-Oct-2019	31240	490	98%
2-Oct-2019	20340	125	99%
3-Oct-2019	29400	170	99%
4-Oct-2019	30490	600	98%
5-Oct-2019	29740	650	98%
6-Oct-2019	29040	450	98%
7-Oct-2019	28445	170	99%
8-Oct-2019	24480	220	99%
9-Oct-2019	19480	0	100%
10-Oct-2019	28595	800	97%
11-Oct-2019	28290	685	98%
12-Oct-2019	31090	1205	96%
13-Oct-2019	29985	390	99%
14-Oct-2019	30935	450	99%
15-Oct-2019	30890	600	98%
16-Oct-2019	19390	0	100%
17-Oct-2019	30690	200	99%
18-Oct-2019	30840	155	99%
19-Oct-2019	29985	435	99%
20-Oct-2019	29890	300	99%
21-Oct-2019	29740	350	99%
22-Oct-2019	30290	200	99%
23-Oct-2019	21240	50	100%
24-Oct-2019	24390	235	99%
25-Oct-2019	28350	100	100%
26-Oct-2019	29400	90	100%
27-Oct-2019	31190	235	99%
Rata-rata			98.9%

Lanjutan Tabel **Lampiran 26** Data perhitungan *rate of quality* mesin spray drayer bulan
November

NOVEMBER			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
28-Oct-2019	32975	120	100%
29-Oct-2019	31900	110	100%
30-Oct-2019	16850	150	99%
31-Oct-2019	32460	800	98%
1-Nov-2019	31850	145	100%
2-Nov-2019	32975	150	100%
3-Nov-2019	32850	600	98%
4-Nov-2019	32980	150	100%
5-Nov-2019	32450	450	99%
6-Nov-2019	18900	800	96%
7-Nov-2019	32310	690	98%
8-Nov-2019	32950	85	100%
10-Nov-2019	31185	90	100%
11-Nov-2019	32330	190	99%
12-Nov-2019	30220	370	99%
13-Nov-2019	19100	145	99%
14-Nov-2019	31750	120	100%
15-Nov-2019	30220	340	99%
16-Nov-2019	18900	340	98%
17-Nov-2019	32310	435	99%
18-Nov-2019	32950	300	99%
19-Nov-2019	14850	350	98%
20-Nov-2019	5985	200	97%
21-Nov-2019	15050	50	100%
22-Nov-2019	32030	235	99%
23-Nov-2019	31975	100	100%
24-Nov-2019	32980	90	100%
25-Nov-2019	33010	500	98%
26-Nov-2019	33980	0	100%
27-Nov-2019	19100	0	100%
28-Nov-2019	31150	80	100%
29-Nov-2019	32050	95	100%
30-Nov-2019	31900	120	100%
1-Dec-2019	32540	80	100%
Rata-rata			99.0%

Lampiran 27 Data perhitungan *rate of quality* mesin spray drayer bulan Desember

DESEMBER			
Tanggal	Total produksi (kg)	Reject (Kg)	Rate Of Quality (%)
2-Dec-2019	33130	150	99.5%
3-Dec-2019	30875	90	100%
4-Dec-2019	32190	200	99%
5-Dec-2019	31635	300	99%
6-Dec-2019	27470	350	99%
7-Dec-2019	27450	200	99%
8-Dec-2019	32985	50	100%
9-Dec-2019	33000	235	99%
10-Dec-2019	33000	100	100%
11-Dec-2019	32995	90	99.7%
12-Dec-2019	32970	500	98%
13-Dec-2019	32490	90	100%
14-Dec-2019	32980	1200	96%
15-Dec-2019	28245	120	100%
16-Dec-2019	33000	110	100%
17-Dec-2019	32985	150	100%
18-Dec-2019	32985	800	98%
19-Dec-2019	33850	145	100%
20-Dec-2019	31170	200	99%
21-Dec-2019	33270	270	99%
22-Dec-2019	31695	250	99%
23-Dec-2019	27110	325	99%
Rata-rata			99%

LAMPIRAN *Breakdown Losses*

Lampiran 28 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Februari

FEBRUARI			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
28-Jan-2019	0	930	0%
29-Jan-2019	0	1440	0%
30-Jan-2019	120	1440	8%
31-Jan-2019	50	1440	3%
1-Feb-2019	0	1440	0%
2-Feb-2019	0	1440	0%
3-Feb-2019	0	1440	0%
4-Feb-2019	0	1020	0%
5-Feb-2019	0	1440	0%
6-Feb-2019	0	1440	0%
7-Feb-2019	240	1440	17%
8-Feb-2019	0	1440	0%
9-Feb-2019	0	1440	0%
10-Feb-2019	55	1440	4%
11-Feb-2019	0	1050	0%
12-Feb-2019	0	1440	0%
13-Feb-2019	0	1440	0%
14-Feb-2019	0	1440	0%
15-Feb-2019	90	1440	6%
16-Feb-2019	0	1440	0%
17-Feb-2019	0	480	0%
18-Feb-2019	0	480	0%
19-Feb-2019	0	1140	0%
20-Feb-2019	0	1440	0%
21-Feb-2019	95	1440	7%
22-Feb-2019	0	1440	0%
23-Feb-2019	0	1440	0%
24-Feb-2019	120	1440	8%
Total	770	36780	2.1%

Lampiran 29 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Maret

Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
25-Feb-2019	0	1440	0%
26-Feb-2019	0	1080	0%
27-Feb-2019	0	1440	0%
28-Feb-2019	0	1440	0%
1-Mar-2019	0	1440	0%
2-Mar-2019	0	1170	0%
3-Mar-2019	30	1440	2%
4-Mar-2019	0	1440	0%
5-Mar-2019	0	1170	0%
6-Mar-2019	0	1440	0%
7-Mar-2019	0	1440	0%
8-Mar-2019	125	1440	9%
9-Mar-2019	0	1440	0%
10-Mar-2019	0	1440	0%
11-Mar-2019	0	1440	0%
12-Mar-2019	60	1440	4%
13-Mar-2019	0	1020	0%
14-Mar-2019	0	1440	0%
15-Mar-2019	0	1440	0%
16-Mar-2019	90	1440	6%
17-Mar-2019	0	1440	0%
18-Mar-2019	0	1440	0%
19-Mar-2019	0	1095	0%
20-Mar-2019	70	1440	5%
21-Mar-2019	90	1440	6%
22-Mar-2019	0	1440	0%
23-Mar-2019	150	1440	10%
24-Mar-2019	0	1440	0%
25-Mar-2019	0	1440	0%
26-Mar-2019	0	1020	0%
27-Mar-2019	0	1440	0%
28-Mar-2019	0	1440	0%
29-Mar-2019	30	1440	2%
30-Mar-2019	45	1440	3%
31-Mar-2019	0	1440	0%
Total	690	48315	1.4%

Lampiran 30 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan April

APRIL			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
1-Apr-2019	0	1440	0%
2-Apr-2019	0	1080	0%
3-Apr-2019	0	1440	0%
4-Apr-2019	0	1440	0%
5-Apr-2019	180	1440	13%
6-Apr-2019	0	1440	0%
7-Apr-2019	0	1440	0%
8-Apr-2019	0	1440	0%
9-Apr-2019	0	1267.2	0%
10-Apr-2019	0	1440	0%
11-Apr-2019	60	1440	4%
12-Apr-2019	0	1440	0%
13-Apr-2019	45	1440	3%
14-Apr-2019	0	1440	0%
15-Apr-2019	0	1275	0%
16-Apr-2019	20	1440	1%
17-Apr-2019	0	0	0%
18-Apr-2019	0	1440	0%
19-Apr-2019	60	1440	4%
20-Apr-2019	30	1440	2%
21-Apr-2019	0	1440	0%
22-Apr-2019	0	1320	0%
23-Apr-2019	0	1440	0%
24-Apr-2019	0	1440	0%
25-Apr-2019	0	1440	0%
26-Apr-2019	0	1440	0%
27-Apr-2019	140	1440	10%
28-Apr-2019	45	1440	3%
Total	580	38062.2	1.5%

Lampiran 31 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Mei

MEI			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
29-Apr-2019	0	1080	0%
30-Apr-2019	0	1440	0%
1-May-2019	0	1440	0%
2-May-2019	0	1440	0%
3-May-2019	0	1440	0%
4-May-2019	0	1440	0%
5-May-2019	150	1440	10%
6-May-2019	120	1440	8%
7-May-2019	0	1035	0%
8-May-2019	0	1440	0%
9-May-2019	60	1440	4%
10-May-2019	0	1440	0%
11-May-2019	0	1440	0%
12-May-2019	60	1440	4%
13-May-2019	0	1440	0%
14-May-2019	0	1110	0%
15-May-2019	0	1440	0%
16-May-2019	80	1440	6%
17-May-2019	0	1440	0%
18-May-2019	0	1440	0%
19-May-2019	0	1440	0%
20-May-2019	0	1440	0%
21-May-2019	0	870	0%
22-May-2019	120	1440	8%
23-May-2019	0	1440	0%
24-May-2019	0	1440	0%
25-May-2019	120	1440	8%
26-May-2019	0	1440	0%
Total	710	38655	1.8%

Lampiran 32 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Juni

Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
27-May-2019	0	1440	0%
28-May-2019	0	960	0%
29-May-2019	0	1440	0%
30-May-2019	90	480	19%
31-May-2019	0	0	0%
1-Jun-2019	0	0	0%
2-Jun-2019	0	0	0%
3-Jun-2019	0	0	0%
4-Jun-2019	0	0	0%
5-Jun-2019	0	0	0%
6-Jun-2019	0	0	0%
7-Jun-2019	0	0	0%
8-Jun-2019	0	0	0%
9-Jun-2019	0	0	0%
10-Jun-2019	0	0	0%
11-Jun-2019	0	0	0%
12-Jun-2019	0	480	0%
13-Jun-2019	0	1440	0%
14-Jun-2019	0	1440	0%
15-Jun-2019	60	1440	4%
16-Jun-2019	0	1440	0%
17-Jun-2019	0	1440	0%
18-Jun-2019	0	960	0%
19-Jun-2019	0	1440	0%
20-Jun-2019	60	1440	4%
21-Jun-2019	0	1440	0%
22-Jun-2019	0	1440	0%
23-Jun-2019	35	1440	2%
24-Jun-2019	20	1440	1%
25-Jun-2019	0	960	0%
26-Jun-2019	0	1440	0%
27-Jun-2019	35	1440	2%
28-Jun-2019	0	1440	0%
29-Jun-2019	120	1440	8%
30-Jun-2019	0	1440	0%
Total	420	29760	1.4%

Lampiran 33 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Juli

JULI			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
1-Jul-2019	0	1440	0%
2-Jul-2019	30	1440	2%
3-Jul-2019	0	1440	0%
4-Jul-2019	0	960	0%
5-Jul-2019	0	1440	0%
6-Jul-2019	190	1440	13%
7-Jul-2019	0	1440	0%
8-Jul-2019	0	1440	0%
9-Jul-2019	45	1440	3%
10-Jul-2019	0	1440	0%
11-Jul-2019	0	1200	0%
12-Jul-2019	0	1440	0%
13-Jul-2019	0	1440	0%
14-Jul-2019	0	1440	0%
15-Jul-2019	15	1440	1%
16-Jul-2019	0	1440	0%
17-Jul-2019	0	1440	0%
18-Jul-2019	90	960	9%
19-Jul-2019	0	1440	0%
20-Jul-2019	30	1440	2%
21-Jul-2019	15	1440	1%
22-Jul-2019	0	1440	0%
23-Jul-2019	0	1440	0%
24-Jul-2019	0	1440	0%
25-Jul-2019	0	960	0%
26-Jul-2019	0	1440	0%
27-Jul-2019	50	1440	3%
28-Jul-2019	0	1440	0%
Total	465	38640	1.2%

Lampiran 34 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Agustus

AGUSTUS			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
29-Jul-2019	15	1440	1%
30-Jul-2019	0	1440	0%
31-Jul-2019	15	1173	1%
1-Aug-2019	0	1440	0%
2-Aug-2019	0	1440	0%
3-Aug-2019	0	1440	0%
4-Aug-2019	300	1440	21%
5-Aug-2019	0	1440	0%
6-Aug-2019	0	1440	0%
7-Aug-2019	0	960	0%
8-Aug-2019	25	1440	2%
9-Aug-2019	0	1440	0%
10-Aug-2019	0	1440	0%
11-Aug-2019	30	1440	2%
12-Aug-2019	60	1440	4%
13-Aug-2019	0	1440	0%
14-Aug-2019	0	960	0%
15-Aug-2019	0	1440	0%
16-Aug-2019	35	1440	2%
17-Aug-2019	50	1440	3%
18-Aug-2019	0	1440	0%
19-Aug-2019	0	1440	0%
20-Aug-2019	0	1440	0%
21-Aug-2019	0	960	0%
22-Aug-2019	0	1440	0%
23-Aug-2019	240	1440	17%
24-Aug-2019	0	1440	0%
25-Aug-2019	0	1440	0%
Total	770	38613	2.0%

Lampiran 35 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan September

Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
26-Aug-2019	25	1440	2%
27-Aug-2019	0	1440	0%
28-Aug-2019	0	960	0%
29-Aug-2019	0	1440	0%
30-Aug-2019	35	1440	2%
31-Aug-2019	15	1440	1%
1-Sep-2019	0	1440	0%
2-Sep-2019	0	1440	0%
3-Sep-2019	0	1440	0%
4-Sep-2019	20	960	2%
5-Sep-2019	0	1440	0%
6-Sep-2019	0	1440	0%
7-Sep-2019	25	1440	2%
8-Sep-2019	15	1440	1%
9-Sep-2019	0	1440	0%
10-Sep-2019	0	1440	0%
11-Sep-2019	0	960	0%
12-Sep-2019	0	1440	0%
13-Sep-2019	0	1440	0%
14-Sep-2019	0	1440	0%
15-Sep-2019	45	1440	3%
16-Sep-2019	0	1440	0%
17-Sep-2019	0	1440	0%
18-Sep-2019	0	960	0%
19-Sep-2019	0	1440	0%
20-Sep-2019	0	1440	0%
21-Sep-2019	90	1440	6%
22-Sep-2019	0	1440	0%
23-Sep-2019	0	1440	0%
24-Sep-2019	0	1440	0%
25-Sep-2019	0	960	0%
26-Sep-2019	0	1440	0%
27-Sep-2019	50	1440	3%
28-Sep-2019	0	1440	0%
29-Sep-2019	0	1440	0%
Total	320	48000	0.7%

Lampiran 36 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Oktober

OKTOBER			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
30-Sep-2019	35	1440	2%
1-Oct-2019	0	1440	0%
2-Oct-2019	0	960	0%
3-Oct-2019	60	1440	4%
4-Oct-2019	0	1440	0%
5-Oct-2019	0	1440	0%
6-Oct-2019	0	1440	0%
7-Oct-2019	0	1440	0%
8-Oct-2019	180	1440	13%
9-Oct-2019	0	960	0%
10-Oct-2019	0	1440	0%
11-Oct-2019	40	1440	3%
12-Oct-2019	15	1440	1%
13-Oct-2019	0	1440	0%
14-Oct-2019	0	1440	0%
15-Oct-2019	0	1440	0%
16-Oct-2019	30	960	3%
17-Oct-2019	0	1440	0%
18-Oct-2019	0	1440	0%
19-Oct-2019	30	1440	2%
20-Oct-2019	0	1440	0%
21-Oct-2019	0	1440	0%
22-Oct-2019	0	1440	0%
23-Oct-2019	0	960	0%
24-Oct-2019	0	1440	0%
25-Oct-2019	0	1440	0%
26-Oct-2019	0	1440	0%
27-Oct-2019	0	1440	0%
Total	390	38400	1.0%

Lampiran 37 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan November

Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
28-Oct-2019	0	1440	0%
29-Oct-2019	0	1440	0%
30-Oct-2019	120	960	13%
31-Oct-2019	0	1440	0%
1-Nov-2019	45	1440	3%
2-Nov-2019	0	1440	0%
3-Nov-2019	0	1440	0%
4-Nov-2019	0	1440	0%
5-Nov-2019	0	1440	0%
6-Nov-2019	0	960	0%
7-Nov-2019	0	1440	0%
8-Nov-2019	0	1440	0%
9-Nov-2019	0	0	0%
10-Nov-2019	0	1440	0%
11-Nov-2019	0	1440	0%
12-Nov-2019	80	1440	6%
13-Nov-2019	0	960	0%
14-Nov-2019	0	1440	0%
15-Nov-2019	30	1440	2%
16-Nov-2019	0	1440	0%
17-Nov-2019	0	1440	0%
18-Nov-2019	0	1440	0%
19-Nov-2019	0	780	0%
20-Nov-2019	0	300	0%
21-Nov-2019	0	1440	0%
22-Nov-2019	0	1440	0%
23-Nov-2019	20	1440	1%
24-Nov-2019	0	1440	0%
25-Nov-2019	0	1440	0%
26-Nov-2019	0	1440	0%
27-Nov-2019	0	960	0%
28-Nov-2019	0	1440	0%
29-Nov-2019	35	1440	2%
30-Nov-2019	15	1440	1%
1-Dec-2019	0	1440	0%
TOTAL	345	45240	0.8%

Lampiran 38 Data perhitungan *breakdown losses* mesin *spraydrayer* bulan Desember

DESEMBER			
Tanggal	Total Breakdown	Loading Time	Breakdown Loss %
2-Dec-2019	0	1440	0%
3-Dec-2019	0	1440	0%
4-Dec-2019	0	960	0%
5-Dec-2019	0	1440	0%
6-Dec-2019	0	1440	0%
7-Dec-2019	0	1440	0%
8-Dec-2019	0	1440	0%
9-Dec-2019	65	1440	5%
10-Dec-2019	0	1440	0%
11-Dec-2019	0	960	0%
12-Dec-2019	0	1440	0%
13-Dec-2019	0	1440	0%
14-Dec-2019	0	1440	0%
15-Dec-2019	0	1440	0%
16-Dec-2019	90	1440	6%
17-Dec-2019	0	1440	0%
18-Dec-2019	0	960	0%
19-Dec-2019	0	1440	0%
20-Dec-2019	0	1440	0%
21-Dec-2019	0	1440	0%
22-Dec-2019	0	1440	0%
23-Dec-2019	0	1440	0%
24-Dec-2019	0	780	0%
TOTAL	155	31020	0.5%

LAMPIRAN *Set Up & Adjstment*

Lampiran 39 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Februari

FEBRUARI			
Tanggal	Set Up	Loading Time	Set Up Losses %
28-Jan-2019	150	930	16%
29-Jan-2019	0	1440	0%
30-Jan-2019	66	1440	5%
31-Jan-2019	40	1440	3%
1-Feb-2019	0	1440	0%
2-Feb-2019	0	1440	0%
3-Feb-2019	0	1440	0%
4-Feb-2019	150	1020	15%
5-Feb-2019	0	1440	0%
6-Feb-2019	0	1440	0%
7-Feb-2019	0	1440	0%
8-Feb-2019	0	1440	0%
9-Feb-2019	0	1440	0%
10-Feb-2019	35	1440	2%
11-Feb-2019	60	1050	6%
12-Feb-2019	0	1440	0%
13-Feb-2019	45	1440	3%
14-Feb-2019	30	1440	2%
15-Feb-2019	30	1440	2%
16-Feb-2019	0	1440	0%
17-Feb-2019	0	480	0%
18-Feb-2019	0	480	0%
19-Feb-2019	72	1140	6%
20-Feb-2019	0	1440	0%
21-Feb-2019	40	1440	3%
22-Feb-2019	0	1440	0%
23-Feb-2019	0	1440	0%
24-Feb-2019	45	1440	3%
Total	763	36780	2.1%

Lampiran 40 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Maret

Tanggal	Set Up	Loading Time	Set Up Losses %
25-Feb-2019	0	1440	0%
26-Feb-2019	120	1080	11%
27-Feb-2019	60	1440	4%
28-Feb-2019	0	1440	0%
1-Mar-2019	0	1440	0%
2-Mar-2019	40	1170	3%
3-Mar-2019	35	1440	2%
4-Mar-2019	0	1440	0%
5-Mar-2019	0	1170	0%
6-Mar-2019	45	1440	3%
7-Mar-2019	0	1440	0%
8-Mar-2019	45	1440	3%
9-Mar-2019	0	1440	0%
10-Mar-2019	0	1440	0%
11-Mar-2019	50	1440	3%
12-Mar-2019	30	1440	2%
13-Mar-2019	90	1020	9%
14-Mar-2019	45	1440	3%
15-Mar-2019	0	1440	0%
16-Mar-2019	60	1440	4%
17-Mar-2019	0	1440	0%
18-Mar-2019	0	1440	0%
19-Mar-2019	120	1095	11%
20-Mar-2019	0	1440	0%
21-Mar-2019	135	1440	9%
22-Mar-2019	0	1440	0%
23-Mar-2019	90	1440	6%
24-Mar-2019	150	1440	10%
25-Mar-2019	0	1440	0%
26-Mar-2019	120	1020	12%
27-Mar-2019	66	1440	5%
28-Mar-2019	0	1440	0%
29-Mar-2019	0	1440	0%
30-Mar-2019	0	1440	0%
31-Mar-2019	0	1440	0%
Total	1301	48315	2.7%

Lampiran 41 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan April

APRIL			
Tanggal	Set Up	Loading Time	Set Up Losses %
1-Apr-2019	0	1440	0%
2-Apr-2019	50	1080	5%
3-Apr-2019	0	1440	0%
4-Apr-2019	0	1440	0%
5-Apr-2019	120	1440	8%
6-Apr-2019	0	1440	0%
7-Apr-2019	0	1440	0%
8-Apr-2019	0	1440	0%
9-Apr-2019	35	1267.2	3%
10-Apr-2019	0	1440	0%
11-Apr-2019	0	1440	0%
12-Apr-2019	0	1440	0%
13-Apr-2019	0	1440	0%
14-Apr-2019	60	1440	4%
15-Apr-2019	40	1275	3%
16-Apr-2019	0	1440	0%
17-Apr-2019	0	0	0%
18-Apr-2019	60	1440	4%
19-Apr-2019	80	1440	6%
20-Apr-2019	95	1440	7%
21-Apr-2019	0	1440	0%
22-Apr-2019	30	1320	2%
23-Apr-2019	0	1440	0%
24-Apr-2019	0	1440	0%
25-Apr-2019	0	1440	0%
26-Apr-2019	0	1440	0%
27-Apr-2019	50	1440	3%
28-Apr-2019	0	1440	0%
Total	620	38062.2	1.6%

Lampiran 42 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Mei

MEI			
Tanggal	Set Up	Loading Time	Set Up Losses %
29-Apr-2019	48	1080	4%
30-Apr-2019	0	1440	0%
1-May-2019	0	1440	0%
2-May-2019	0	1440	0%
3-May-2019	0	1440	0%
4-May-2019	0	1440	0%
5-May-2019	66	1440	5%
6-May-2019	80	1440	6%
7-May-2019	45	1035	4%
8-May-2019	0	1440	0%
9-May-2019	45	1440	3%
10-May-2019	0	1440	0%
11-May-2019	0	1440	0%
12-May-2019	0	1440	0%
13-May-2019	0	1440	0%
14-May-2019	120	1110	11%
15-May-2019	0	1440	0%
16-May-2019	0	1440	0%
17-May-2019	0	1440	0%
18-May-2019	0	1440	0%
19-May-2019	0	1440	0%
20-May-2019	45	1440	3%
21-May-2019	50	870	6%
22-May-2019	84	1440	6%
23-May-2019	0	1440	0%
24-May-2019	0	1440	0%
25-May-2019	78	1440	5%
26-May-2019	0	1440	0%
Total	661	38655	1.7%

Lampiran 43 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Juni

Tanggal	Set Up	Loading Time	Set Up Losses %
27-May-2019	45	1440	3%
28-May-2019	50	960	5%
29-May-2019	40	1440	3%
30-May-2019	60	480	13%
31-May-2019	0	0	0%
1-Jun-2019	0	0	0%
2-Jun-2019	0	0	0%
3-Jun-2019	0	0	0%
4-Jun-2019	0	0	0%
5-Jun-2019	0	0	0%
6-Jun-2019	0	0	0%
7-Jun-2019	0	0	0%
8-Jun-2019	0	0	0%
9-Jun-2019	0	0	0%
10-Jun-2019	0	0	0%
11-Jun-2019	0	0	0%
12-Jun-2019	0	480	0%
13-Jun-2019	0	1440	0%
14-Jun-2019	0	1440	0%
15-Jun-2019	50	1440	3%
16-Jun-2019	0	1440	0%
17-Jun-2019	0	1440	0%
18-Jun-2019	60	960	6%
19-Jun-2019	0	1440	0%
20-Jun-2019	50	1440	3%
21-Jun-2019	0	1440	0%
22-Jun-2019	0	1440	0%
23-Jun-2019	0	1440	0%
24-Jun-2019	0	1440	0%
25-Jun-2019	60	960	6%
26-Jun-2019	0	1440	0%
27-Jun-2019	0	1440	0%
28-Jun-2019	0	1440	0%
29-Jun-2019	40	1440	3%
30-Jun-2019	0	1440	0%
Total	455	29760	1.5%

Lampiran 44 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Juli

JULI			
Tanggal	Set Up	Loading Time	Set Up Losses %
1-Jul-2019	0	1440	0%
2-Jul-2019	45	1440	3%
3-Jul-2019	0	1440	0%
4-Jul-2019	60	960	6%
5-Jul-2019	0	1440	0%
6-Jul-2019	120	1440	8%
7-Jul-2019	0	1440	0%
8-Jul-2019	0	1440	0%
9-Jul-2019	0	1440	0%
10-Jul-2019	0	1440	0%
11-Jul-2019	45	1200	4%
12-Jul-2019	0	1440	0%
13-Jul-2019	0	1440	0%
14-Jul-2019	0	1440	0%
15-Jul-2019	25	1440	2%
16-Jul-2019	0	1440	0%
17-Jul-2019	0	1440	0%
18-Jul-2019	30	960	3%
19-Jul-2019	0	1440	0%
20-Jul-2019	35	1440	2%
21-Jul-2019	25	1440	2%
22-Jul-2019	0	1440	0%
23-Jul-2019	0	1440	0%
24-Jul-2019	0	1440	0%
25-Jul-2019	60	960	6%
26-Jul-2019	0	1440	0%
27-Jul-2019	30	1440	2%
28-Jul-2019	0	1440	0%
Total	475	38640	1.2%

Lampiran 45 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Agustus

AGUSTUS			
Tanggal	Set Up	Loading Time	Set Up Losses %
29-Jul-2019	35	1440	2%
30-Jul-2019	0	1440	0%
31-Jul-2019	40	1173	3%
1-Aug-2019	0	1440	0%
2-Aug-2019	0	1440	0%
3-Aug-2019	0	1440	0%
4-Aug-2019	90	1440	6%
5-Aug-2019	0	1440	0%
6-Aug-2019	0	1440	0%
7-Aug-2019	60	960	6%
8-Aug-2019	0	1440	0%
9-Aug-2019	0	1440	0%
10-Aug-2019	0	1440	0%
11-Aug-2019	30	1440	2%
12-Aug-2019	0	1440	0%
13-Aug-2019	0	1440	0%
14-Aug-2019	0	960	0%
15-Aug-2019	0	1440	0%
16-Aug-2019	0	1440	0%
17-Aug-2019	0	1440	0%
18-Aug-2019	0	1440	0%
19-Aug-2019	0	1440	0%
20-Aug-2019	0	1440	0%
21-Aug-2019	60	960	6%
22-Aug-2019	0	1440	0%
23-Aug-2019	75	1440	5%
24-Aug-2019	0	1440	0%
25-Aug-2019	0	1440	0%
Total	390	38613	1.0%

Lampiran 46 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan September

Tanggal	Set Up	Loading Time	Set Up Losses %
26-Aug-2019	0	1440	0%
27-Aug-2019	0	1440	0%
28-Aug-2019	60	960	6%
29-Aug-2019	0	1440	0%
30-Aug-2019	0	1440	0%
31-Aug-2019	0	1440	0%
1-Sep-2019	0	1440	0%
2-Sep-2019	0	1440	0%
3-Sep-2019	0	1440	0%
4-Sep-2019	80	960	8%
5-Sep-2019	0	1440	0%
6-Sep-2019	0	1440	0%
7-Sep-2019	0	1440	0%
8-Sep-2019	0	1440	0%
9-Sep-2019	0	1440	0%
10-Sep-2019	0	1440	0%
11-Sep-2019	60	960	6%
12-Sep-2019	0	1440	0%
13-Sep-2019	0	1440	0%
14-Sep-2019	0	1440	0%
15-Sep-2019	0	1440	0%
16-Sep-2019	0	1440	0%
17-Sep-2019	0	1440	0%
18-Sep-2019	75	960	8%
19-Sep-2019	0	1440	0%
20-Sep-2019	0	1440	0%
21-Sep-2019	45	1440	3%
22-Sep-2019	0	1440	0%
23-Sep-2019	0	1440	0%
24-Sep-2019	0	1440	0%
25-Sep-2019	60	960	6%
26-Sep-2019	0	1440	0%
27-Sep-2019	15	1440	1%
28-Sep-2019	0	1440	0%
29-Sep-2019	0	1440	0%
Total	395	48000	0.8%

Lampiran 47 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Oktober

OKTOBER			
Tanggal	Set Up	Loading Time	Set Up Losses %
30-Sep-2019	0	1440	0%
1-Oct-2019	0	1440	0%
2-Oct-2019	60	960	6%
3-Oct-2019	25	1440	2%
4-Oct-2019	0	1440	0%
5-Oct-2019	0	1440	0%
6-Oct-2019	0	1440	0%
7-Oct-2019	0	1440	0%
8-Oct-2019	80	1440	6%
9-Oct-2019	75	960	8%
10-Oct-2019	0	1440	0%
11-Oct-2019	0	1440	0%
12-Oct-2019	0	1440	0%
13-Oct-2019	0	1440	0%
14-Oct-2019	0	1440	0%
15-Oct-2019	0	1440	0%
16-Oct-2019	60	960	6%
17-Oct-2019	0	1440	0%
18-Oct-2019	0	1440	0%
19-Oct-2019	30	1440	2%
20-Oct-2019	0	1440	0%
21-Oct-2019	0	1440	0%
22-Oct-2019	0	1440	0%
23-Oct-2019	60	960	6%
24-Oct-2019	0	1440	0%
25-Oct-2019	0	1440	0%
26-Oct-2019	0	1440	0%
27-Oct-2019	0	1440	0%
Total	390	38400	1.0%

Lampiran 48 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan November

Tanggal	Set Up	Loading Time	Set Up Losses %
28-Oct-2019	0	1440	0%
29-Oct-2019	0	1440	0%
30-Oct-2019	70	960	7%
31-Oct-2019	0	1440	0%
1-Nov-2019	0	1440	0%
2-Nov-2019	0	1440	0%
3-Nov-2019	0	1440	0%
4-Nov-2019	0	1440	0%
5-Nov-2019	0	1440	0%
6-Nov-2019	60	960	6%
7-Nov-2019	0	1440	0%
8-Nov-2019	0	1440	0%
9-Nov-2019	0	0	0%
10-Nov-2019	0	1440	0%
11-Nov-2019	0	1440	0%
12-Nov-2019	25	1440	2%
13-Nov-2019	0	960	0%
14-Nov-2019	0	1440	0%
15-Nov-2019	15	1440	1%
16-Nov-2019	0	1440	0%
17-Nov-2019	0	1440	0%
18-Nov-2019	0	1440	0%
19-Nov-2019	60	780	8%
20-Nov-2019	0	300	0%
21-Nov-2019	0	1440	0%
22-Nov-2019	0	1440	0%
23-Nov-2019	0	1440	0%
24-Nov-2019	0	1440	0%
25-Nov-2019	0	1440	0%
26-Nov-2019	0	1440	0%
27-Nov-2019	60	960	6%
28-Nov-2019	0	1440	0%
29-Nov-2019	0	1440	0%
30-Nov-2019	0	1440	0%
1-Dec-2019	0	1440	0%
Total	290	45240	0.6%

Lampiran 49 Data perhitungan *Set Up & Adjustment* mesin *spraydrayer* bulan Desember

DESEMBER			
Tanggal	Set Up	Loading Time	Set Up Losses %
2-Dec-2019	0	1440	0%
3-Dec-2019	0	1440	0%
4-Dec-2019	60	960	6%
5-Dec-2019	0	1440	0%
6-Dec-2019	0	1440	0%
7-Dec-2019	0	1440	0%
8-Dec-2019	0	1440	0%
9-Dec-2019	0	1440	0%
10-Dec-2019	0	1440	0%
11-Dec-2019	80	960	8%
12-Dec-2019	0	1440	0%
13-Dec-2019	0	1440	0%
14-Dec-2019	0	1440	0%
15-Dec-2019	0	1440	0%
16-Dec-2019	20	1440	1%
17-Dec-2019	0	1440	0%
18-Dec-2019	65	960	7%
19-Dec-2019	0	1440	0%
20-Dec-2019	0	1440	0%
21-Dec-2019	0	1440	0%
22-Dec-2019	0	1440	0%
23-Dec-2019	0	1440	0%
24-Dec-2019	0	780	0%
Total	225	31020	0.7%

LAMPIRAN *Idle and Minor Stopage*

Lampiran 50 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Februari

FEBRUARI			
Tanggal	Idle Time	Loading Time	idling minor stopage %
28-Jan-2019	45	930	5%
29-Jan-2019	0	1440	0%
30-Jan-2019	10	1440	1%
31-Jan-2019	45	1440	3%
1-Feb-2019	0	1440	0%
2-Feb-2019	0	1440	0%
3-Feb-2019	0	1440	0%
4-Feb-2019	75	1020	7%
5-Feb-2019	0	1440	0%
6-Feb-2019	0	1440	0%
7-Feb-2019	0	1440	0%
8-Feb-2019	0	1440	0%
9-Feb-2019	0	1440	0%
10-Feb-2019	20	1440	1%
11-Feb-2019	45	1050	4%
12-Feb-2019	0	1440	0%
13-Feb-2019	35	1440	2%
14-Feb-2019	0	1440	0%
15-Feb-2019	0	1440	0%
16-Feb-2019	0	1440	0%
17-Feb-2019	0	480	0%
18-Feb-2019	0	480	0%
19-Feb-2019	20	1140	2%
20-Feb-2019	0	1440	0%
21-Feb-2019	0	1440	0%
22-Feb-2019	25	1440	2%
23-Feb-2019	0	1440	0%
24-Feb-2019	0	1440	0%
Total	320	36780	0.9%

Lampiran 51 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Maret

Tanggal	Idle Time	Loading Time	idling minor stopage %
25-Feb-2019	0	1440	0%
26-Feb-2019	75	1080	7%
27-Feb-2019	0	1440	0%
28-Feb-2019	0	1440	0%
1-Mar-2019	0	1440	0%
2-Mar-2019	0	1170	0%
3-Mar-2019	0	1440	0%
4-Mar-2019	0	1440	0%
5-Mar-2019	0	1170	0%
6-Mar-2019	45	1440	3%
7-Mar-2019	0	1440	0%
8-Mar-2019	90	1440	6%
9-Mar-2019	0	1440	0%
10-Mar-2019	0	1440	0%
11-Mar-2019	0	1440	0%
12-Mar-2019	0	1440	0%
13-Mar-2019	0	1020	0%
14-Mar-2019	90	1440	6%
15-Mar-2019	0	1440	0%
16-Mar-2019	0	1440	0%
17-Mar-2019	0	1440	0%
18-Mar-2019	0	1440	0%
19-Mar-2019	45	1095	4%
20-Mar-2019	15	1440	1%
21-Mar-2019	0	1440	0%
22-Mar-2019	0	1440	0%
23-Mar-2019	0	1440	0%
24-Mar-2019	0	1440	0%
25-Mar-2019	0	1440	0%
26-Mar-2019	0	1020	0%
27-Mar-2019	0	1440	0%
28-Mar-2019	0	1440	0%
29-Mar-2019	0	1440	0%
30-Mar-2019	0	1440	0%
31-Mar-2019	0	1440	0%
Total	360	48315	0.7%

Lampiran 52 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan April

APRIL			
Tanggal	Idle Time	Loading Time	idling minor stopage %
1-Apr-2019	0	1440	0%
2-Apr-2019	20	1080	2%
3-Apr-2019	0	1440	0%
4-Apr-2019	0	1440	0%
5-Apr-2019	0	1440	0%
6-Apr-2019	0	1440	0%
7-Apr-2019	0	1440	0%
8-Apr-2019	0	1440	0%
9-Apr-2019	0	1267.2	0%
10-Apr-2019	0	1440	0%
11-Apr-2019	0	1440	0%
12-Apr-2019	0	1440	0%
13-Apr-2019	30	1440	2%
14-Apr-2019	45	1440	3%
15-Apr-2019	0	1275	0%
16-Apr-2019	0	1440	0%
17-Apr-2019	0	0	0%
18-Apr-2019	0	1440	0%
19-Apr-2019	0	1440	0%
20-Apr-2019	0	1440	0%
21-Apr-2019	0	1440	0%
22-Apr-2019	0	1320	0%
23-Apr-2019	20	1440	1%
24-Apr-2019	0	1440	0%
25-Apr-2019	0	1440	0%
26-Apr-2019	0	1440	0%
27-Apr-2019	0	1440	0%
28-Apr-2019	0	1440	0%
Total	115	38062.2	0.3%

Lampiran 53 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Mei

MEI			
Tanggal	Idle Time	Loading Time	idling minor stopage %
29-Apr-2019	25	1080	2%
30-Apr-2019	0	1440	0%
1-May-2019	0	1440	0%
2-May-2019	0	1440	0%
3-May-2019	0	1440	0%
4-May-2019	0	1440	0%
5-May-2019	15	1440	1%
6-May-2019	0	1440	0%
7-May-2019	0	1035	0%
8-May-2019	0	1440	0%
9-May-2019	0	1440	0%
10-May-2019	0	1440	0%
11-May-2019	0	1440	0%
12-May-2019	0	1440	0%
13-May-2019	80	1440	6%
14-May-2019	0	1110	0%
15-May-2019	0	1440	0%
16-May-2019	0	1440	0%
17-May-2019	0	1440	0%
18-May-2019	0	1440	0%
19-May-2019	0	1440	0%
20-May-2019	45	1440	3%
21-May-2019	0	870	0%
22-May-2019	0	1440	0%
23-May-2019	0	1440	0%
24-May-2019	0	1440	0%
25-May-2019	0	1440	0%
26-May-2019	0	1440	0%
Total	165	38655	0.4%

Lampiran 54 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Juni

Tanggal	Idle Time	Loading Time	idling minor stopage %
27-May-2019	50	1440	3%
28-May-2019	15	960	2%
29-May-2019	0	1440	0%
30-May-2019	0	480	0%
31-May-2019	0	0	0%
1-Jun-2019	0	0	0%
2-Jun-2019	0	0	0%
3-Jun-2019	0	0	0%
4-Jun-2019	0	0	0%
5-Jun-2019	0	0	0%
6-Jun-2019	0	0	0%
7-Jun-2019	0	0	0%
8-Jun-2019	0	0	0%
9-Jun-2019	0	0	0%
10-Jun-2019	0	0	0%
11-Jun-2019	0	0	0%
12-Jun-2019	0	480	0%
13-Jun-2019	0	1440	0%
14-Jun-2019	0	1440	0%
15-Jun-2019	35	1440	2%
16-Jun-2019	0	1440	0%
17-Jun-2019	0	1440	0%
18-Jun-2019	0	960	0%
19-Jun-2019	0	1440	0%
20-Jun-2019	35	1440	2%
21-Jun-2019	0	1440	0%
22-Jun-2019	0	1440	0%
23-Jun-2019	0	1440	0%
24-Jun-2019	0	1440	0%
25-Jun-2019	0	960	0%
26-Jun-2019	0	1440	0%
27-Jun-2019	0	1440	0%
28-Jun-2019	0	1440	0%
29-Jun-2019	0	1440	0%
30-Jun-2019	0	1440	0%
Total	135	29760	0.5%

Lampiran 55 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Juli

JULI			
Tanggal	Idle Time	Loading Time	idling minor stoppage %
1-Jul-2019	0	1440	0%
2-Jul-2019	0	1440	0%
3-Jul-2019	20	1440	1%
4-Jul-2019	0	960	0%
5-Jul-2019	0	1440	0%
6-Jul-2019	0	1440	0%
7-Jul-2019	0	1440	0%
8-Jul-2019	0	1440	0%
9-Jul-2019	0	1440	0%
10-Jul-2019	0	1440	0%
11-Jul-2019	60	1200	5%
12-Jul-2019	0	1440	0%
13-Jul-2019	0	1440	0%
14-Jul-2019	0	1440	0%
15-Jul-2019	0	1440	0%
16-Jul-2019	0	1440	0%
17-Jul-2019	0	1440	0%
18-Jul-2019	0	960	0%
19-Jul-2019	35	1440	2%
20-Jul-2019	0	1440	0%
21-Jul-2019	0	1440	0%
22-Jul-2019	0	1440	0%
23-Jul-2019	0	1440	0%
24-Jul-2019	0	1440	0%
25-Jul-2019	0	960	0%
26-Jul-2019	0	1440	0%
27-Jul-2019	0	1440	0%
28-Jul-2019	0	1440	0%
Total	115	38640	0.3%

Lampiran 56 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Agustus

AGUSTUS			
Tanggal	Idle Time	Loading Time	idling minor stopage %
29-Jul-2019	0	1440	0%
30-Jul-2019	0	1440	0%
31-Jul-2019	90	1173	8%
1-Aug-2019	0	1440	0%
2-Aug-2019	0	1440	0%
3-Aug-2019	0	1440	0%
4-Aug-2019	0	1440	0%
5-Aug-2019	0	1440	0%
6-Aug-2019	0	1440	0%
7-Aug-2019	0	960	0%
8-Aug-2019	0	1440	0%
9-Aug-2019	0	1440	0%
10-Aug-2019	0	1440	0%
11-Aug-2019	0	1440	0%
12-Aug-2019	0	1440	0%
13-Aug-2019	45	1440	3%
14-Aug-2019	0	960	0%
15-Aug-2019	0	1440	0%
16-Aug-2019	0	1440	0%
17-Aug-2019	0	1440	0%
18-Aug-2019	0	1440	0%
19-Aug-2019	0	1440	0%
20-Aug-2019	0	1440	0%
21-Aug-2019	0	960	0%
22-Aug-2019	0	1440	0%
23-Aug-2019	0	1440	0%
24-Aug-2019	20	1440	1%
25-Aug-2019	0	1440	0%
Total	155	38613	0.4%

Lampiran 57 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan September

Tanggal	Idle Time	Loading Time	idling minor stopage %
26-Aug-2019	0	1440	0%
27-Aug-2019	0	1440	0%
28-Aug-2019	0	960	0%
29-Aug-2019	0	1440	0%
30-Aug-2019	35	1440	2%
31-Aug-2019	0	1440	0%
1-Sep-2019	55	1440	4%
2-Sep-2019	0	1440	0%
3-Sep-2019	0	1440	0%
4-Sep-2019	0	960	0%
5-Sep-2019	45	1440	3%
6-Sep-2019	0	1440	0%
7-Sep-2019	0	1440	0%
8-Sep-2019	0	1440	0%
9-Sep-2019	0	1440	0%
10-Sep-2019	0	1440	0%
11-Sep-2019	0	960	0%
12-Sep-2019	0	1440	0%
13-Sep-2019	0	1440	0%
14-Sep-2019	0	1440	0%
15-Sep-2019	0	1440	0%
16-Sep-2019	0	1440	0%
17-Sep-2019	0	1440	0%
18-Sep-2019	0	960	0%
19-Sep-2019	0	1440	0%
20-Sep-2019	0	1440	0%
21-Sep-2019	35	1440	2%
22-Sep-2019	0	1440	0%
23-Sep-2019	0	1440	0%
24-Sep-2019	0	1440	0%
25-Sep-2019	0	960	0%
26-Sep-2019	0	1440	0%
27-Sep-2019	0	1440	0%
28-Sep-2019	0	1440	0%
29-Sep-2019	0	1440	0%
Total	170	48000	0.4%

Lampiran 58 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Oktober

OKTOBER			
Tanggal	Idle Time	Loading Time	idling minor stopage %
30-Sep-2019	0	1440	0%
1-Oct-2019	0	1440	0%
2-Oct-2019	0	960	0%
3-Oct-2019	0	1440	0%
4-Oct-2019	0	1440	0%
5-Oct-2019	90	1440	6%
6-Oct-2019	0	1440	0%
7-Oct-2019	0	1440	0%
8-Oct-2019	50	1440	3%
9-Oct-2019	0	960	0%
10-Oct-2019	0	1440	0%
11-Oct-2019	0	1440	0%
12-Oct-2019	0	1440	0%
13-Oct-2019	0	1440	0%
14-Oct-2019	0	1440	0%
15-Oct-2019	0	1440	0%
16-Oct-2019	0	960	0%
17-Oct-2019	0	1440	0%
18-Oct-2019	0	1440	0%
19-Oct-2019	15	1440	1%
20-Oct-2019	0	1440	0%
21-Oct-2019	20	1440	1%
22-Oct-2019	0	1440	0%
23-Oct-2019	0	960	0%
24-Oct-2019	0	1440	0%
25-Oct-2019	0	1440	0%
26-Oct-2019	0	1440	0%
27-Oct-2019	0	1440	0%
Total	175	38400	0.5%

Lampiran 59 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan November

Tanggal	Idle Time	Loading Time	idling minor stopage %
28-Oct-2019	0	1440	0%
29-Oct-2019	0	1440	0%
30-Oct-2019	0	960	0%
31-Oct-2019	0	1440	0%
1-Nov-2019	30	1440	2%
2-Nov-2019	0	1440	0%
3-Nov-2019	0	1440	0%
4-Nov-2019	0	1440	0%
5-Nov-2019	0	1440	0%
6-Nov-2019	0	960	0%
7-Nov-2019	0	1440	0%
8-Nov-2019	0	1440	0%
9-Nov-2019	0	0	0%
10-Nov-2019	0	1440	0%
11-Nov-2019	0	1440	0%
12-Nov-2019	95	1440	7%
13-Nov-2019	0	960	0%
14-Nov-2019	0	1440	0%
15-Nov-2019	0	1440	0%
16-Nov-2019	0	1440	0%
17-Nov-2019	0	1440	0%
18-Nov-2019	30	1440	2%
19-Nov-2019	0	780	0%
20-Nov-2019	0	300	0%
21-Nov-2019	0	1440	0%
22-Nov-2019	0	1440	0%
23-Nov-2019	0	1440	0%
24-Nov-2019	0	1440	0%
25-Nov-2019	0	1440	0%
26-Nov-2019	0	1440	0%
27-Nov-2019	40	960	4%
28-Nov-2019	0	1440	0%
29-Nov-2019	0	1440	0%
30-Nov-2019	0	1440	0%
1-Dec-2019	0	1440	0%
Total	195	45240	0.4%

Lampiran 60 Data perhitungan *Idle and minor stoppage* mesin *spraydrayer* bulan Desember

DESEMBER			
Tanggal	Idle Time	Loading Time	idling minor stopage %
2-Dec-2019	0	1440	0%
3-Dec-2019	70	1440	5%
4-Dec-2019	0	960	0%
5-Dec-2019	0	1440	0%
6-Dec-2019	0	1440	0%
7-Dec-2019	0	1440	0%
8-Dec-2019	0	1440	0%
9-Dec-2019	0	1440	0%
10-Dec-2019	15	1440	1%
11-Dec-2019	0	960	0%
12-Dec-2019	0	1440	0%
13-Dec-2019	0	1440	0%
14-Dec-2019	0	1440	0%
15-Dec-2019	0	1440	0%
16-Dec-2019	0	1440	0%
17-Dec-2019	0	1440	0%
18-Dec-2019	0	960	0%
19-Dec-2019	0	1440	0%
20-Dec-2019	20	1440	1%
21-Dec-2019	0	1440	0%
22-Dec-2019	0	1440	0%
23-Dec-2019	0	1440	0%
24-Dec-2019	0	780	0%
Total	105	31020	0.3%

LAMPIRAN *Reduce Speed*

Lampiran 61 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Februari

FEBRUARI				
Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
28-Jan-2019	0.048	930	10065	32%
29-Jan-2019	0.048	1440	26820	0%
30-Jan-2019	0.048	1440	24950	4%
31-Jan-2019	0.048	1440	28050	0%
1-Feb-2019	0.048	1440	21680	28%
2-Feb-2019	0.048	1440	25380	15%
3-Feb-2019	0.048	1440	20570	31%
4-Feb-2019	0.048	1020	12740	25%
5-Feb-2019	0.048	1440	26840	11%
6-Feb-2019	0.048	1440	22895	24%
7-Feb-2019	0.048	1440	24550	1%
8-Feb-2019	0.048	1440	25255	16%
9-Feb-2019	0.048	1440	24960	17%
10-Feb-2019	0.048	1440	25255	10%
11-Feb-2019	0.048	1050	14850	26%
12-Feb-2019	0.048	1440	25300	16%
13-Feb-2019	0.048	1440	22035	23%
14-Feb-2019	0.048	1440	25010	15%
15-Feb-2019	0.048	1440	26245	4%
16-Feb-2019	0.048	1440	27235	9%
17-Feb-2019	0.048	480	9550	4%
18-Feb-2019	0.048	480	9800	2%
19-Feb-2019	0.048	1140	19875	10%
20-Feb-2019	0.048	1440	28850	4%
21-Feb-2019	0.048	1440	24755	8%
22-Feb-2019	0.048	1440	27255	9%
23-Feb-2019	0.048	1440	26375	12%
24-Feb-2019	0.048	1440	25850	2%
Total	0.048	36780	632995	13.2%

Lampiran 62 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Maret

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
25-Feb-2019	0.048	1440	29510	2%
26-Feb-2019	0.048	1080	18570	0%
27-Feb-2019	0.048	1440	27210	5%
28-Feb-2019	0.048	1440	27950	7%
1-Mar-2019	0.048	1440	28890	4%
2-Mar-2019	0.048	1170	23050	2%
3-Mar-2019	0.048	1440	26800	6%
4-Mar-2019	0.048	1440	29275	2%
5-Mar-2019	0.048	1170	24105	1%
6-Mar-2019	0.048	1440	21875	24%
7-Mar-2019	0.048	1440	29350	2%
8-Mar-2019	0.048	1440	25500	3%
9-Mar-2019	0.048	1440	28540	5%
10-Mar-2019	0.048	1440	27330	9%
11-Mar-2019	0.048	1440	26530	8%
12-Mar-2019	0.048	1440	25150	10%
13-Mar-2019	0.048	1020	18295	5%
14-Mar-2019	0.048	1440	18055	37%
15-Mar-2019	0.048	1440	28690	4%
16-Mar-2019	0.048	1440	26350	2%
17-Mar-2019	0.048	1440	28790	4%
18-Mar-2019	0.048	1440	29435	2%
19-Mar-2019	0.048	1095	18035	10%
20-Mar-2019	0.048	1440	28015	2%
21-Mar-2019	0.048	1440	22015	11%
22-Mar-2019	0.048	1440	28315	6%
23-Mar-2019	0.048	1440	22600	8%
24-Mar-2019	0.048	1440	22065	16%
25-Mar-2019	0.048	1440	28495	5%
26-Mar-2019	0.048	1020	12500	29%
27-Mar-2019	0.048	1440	27580	3%
28-Mar-2019	0.048	1440	22670	24%
29-Mar-2019	0.048	1440	29305	0%
30-Mar-2019	0.048	1440	28050	3%
31-Mar-2019	0.048	1440	28060	6%
Total	0.048	48315	886955	7.8%

Lampiran 63 Data perhitungan *reduce speed* mesin *spraydrayer* bulan April

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
1-Apr-2019	0.048	1439.952	28670	4%
2-Apr-2019	0.048	1029.952	19305	0%
3-Apr-2019	0.048	1439.952	28325	6%
4-Apr-2019	0.048	1439.952	27135	10%
5-Apr-2019	0.048	1139.952	22030	7%
6-Apr-2019	0.048	1439.952	28175	6%
7-Apr-2019	0.048	1439.952	28325	6%
8-Apr-2019	0.048	1439.952	28450	5%
9-Apr-2019	0.048	1232.152	25165	2%
10-Apr-2019	0.048	1439.952	28710	4%
11-Apr-2019	0.048	1379.952	25365	12%
12-Apr-2019	0.048	1439.952	28735	4%
13-Apr-2019	0.048	1394.952	28500	2%
14-Apr-2019	0.048	1379.952	27745	3%
15-Apr-2019	0.048	1234.952	25460	1%
16-Apr-2019	0.048	1419.952	28750	3%
17-Apr-2019	0	0	0	0%
18-Apr-2019	0.048	1379.952	27985	3%
19-Apr-2019	0.048	1299.952	26850	1%
20-Apr-2019	0.048	1314.952	27150	1%
21-Apr-2019	0.048	1439.952	28920	4%
22-Apr-2019	0.048	1289.952	26410	2%
23-Apr-2019	0.048	1439.952	28380	5%
24-Apr-2019	0.048	1439.952	28750	4%
25-Apr-2019	0.048	1439.952	26295	12%
26-Apr-2019	0.048	1439.952	25640	15%
27-Apr-2019	0.048	1249.952	28930	-11%
28-Apr-2019	0.048	1394.952	24215	17%
Total	0.048	38062.20	728370	5.0%

Lampiran 64 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Mei

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
29-Apr-2019	0.048	1032	17765	17%
30-Apr-2019	0.048	1440	28960	0%
1-May-2019	0.048	1440	9860	67%
2-May-2019	0.048	1440	29580	1%
3-May-2019	0.048	1440	27505	8%
4-May-2019	0.048	1440	29750	1%
5-May-2019	0.048	1224	24850	3%
6-May-2019	0.048	1240	24950	3%
7-May-2019	0.048	990	19080	7%
8-May-2019	0.048	1440	28520	5%
9-May-2019	0.048	1335	27650	1%
10-May-2019	0.048	1440	29455	2%
11-May-2019	0.048	1440	25095	16%
12-May-2019	0.048	1380	28085	2%
13-May-2019	0.048	1440	29395	2%
14-May-2019	0.048	990	19850	4%
15-May-2019	0.048	1440	26330	12%
16-May-2019	0.048	1360	24565	13%
17-May-2019	0.048	1440	26105	13%
18-May-2019	0.048	1440	25420	15%
19-May-2019	0.048	1440	25635	15%
20-May-2019	0.048	1395	27705	5%
21-May-2019	0.048	820	14450	15%
22-May-2019	0.048	1236	24900	3%
23-May-2019	0.048	1440	24685	18%
24-May-2019	0.048	1440	27775	7%
25-May-2019	0.048	1242	24550	5%
26-May-2019	0.048	1440	29100	3%
Total	0.048	38655	701570	9.3%

Lampiran 65 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Juni

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
27-May-2019	0.048	1440	28550	2%
28-May-2019	0.048	960	15900	0%
29-May-2019	0.048	1440	28675	2%
30-May-2019	0.048	480	5095	18%
31-May-2019	0.048	0	0	0%
1-Jun-2019	0.048	0	0	0%
2-Jun-2019	0.048	0	0	0%
3-Jun-2019	0.048	0	0	0%
4-Jun-2019	0.048	0	0	0%
5-Jun-2019	0.048	0	0	0%
6-Jun-2019	0.048	0	0	0%
7-Jun-2019	0.048	0	0	0%
8-Jun-2019	0.048	0	0	0%
9-Jun-2019	0.048	0	0	0%
10-Jun-2019	0.048	0	0	0%
11-Jun-2019	0.048	0	0	0%
12-Jun-2019	0.048	480	6330	37%
13-Jun-2019	0.048	1440	27320	9%
14-Jun-2019	0.048	1440	26765	11%
15-Jun-2019	0.048	1440	25995	6%
16-Jun-2019	0.048	1440	26610	11%
17-Jun-2019	0.048	1440	27305	9%
18-Jun-2019	0.048	960	17850	4%
19-Jun-2019	0.048	1440	26675	11%
20-Jun-2019	0.048	1440	26850	3%
21-Jun-2019	0.048	1440	27340	9%
22-Jun-2019	0.048	1440	27000	10%
23-Jun-2019	0.048	1440	26985	8%
24-Jun-2019	0.048	1440	27490	7%
25-Jun-2019	0.048	960	17850	4%
26-Jun-2019	0.048	1440	27510	8%
27-Jun-2019	0.048	1440	27000	8%
28-Jun-2019	0.048	1440	27340	9%
29-Jun-2019	0.048	1440	23050	12%
30-Jun-2019	0.048	1440	27000	10%
Total	0.048	29760	548485	8.6%

Lampiran 66 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Juli

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
1-Jul-2019	0.048	1440	29050	3%
2-Jul-2019	0.048	1440	26510	0%
3-Jul-2019	0.048	1440	25960	13%
4-Jul-2019	0.048	960	17855	4%
5-Jul-2019	0.048	1440	27080	10%
6-Jul-2019	0.048	1440	23045	2%
7-Jul-2019	0.048	1440	22290	26%
8-Jul-2019	0.048	1440	26960	10%
9-Jul-2019	0.048	1440	26000	10%
10-Jul-2019	0.048	1440	25960	13%
11-Jul-2019	0.048	1200	23500	2%
12-Jul-2019	0.048	1440	26170	13%
13-Jul-2019	0.048	1440	26000	13%
14-Jul-2019	0.048	1440	26000	13%
15-Jul-2019	0.048	1440	26320	9%
16-Jul-2019	0.048	1440	25890	14%
17-Jul-2019	0.048	1440	26045	13%
18-Jul-2019	0.048	960	14900	13%
19-Jul-2019	0.048	1440	27850	7%
20-Jul-2019	0.048	1440	26045	9%
21-Jul-2019	0.048	1440	25040	14%
22-Jul-2019	0.048	1440	29080	3%
23-Jul-2019	0.048	1440	26900	10%
24-Jul-2019	0.048	1440	28000	7%
25-Jul-2019	0.048	960	16700	10%
26-Jul-2019	0.048	1440	26510	12%
27-Jul-2019	0.048	1440	27000	4%
28-Jul-2019	0.048	1440	27510	8%
Total	0.048	38640	706170	9.8%

Lampiran 67 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Agustus

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
29-Jul-2019	0.048	1440	27800	7%
30-Jul-2019	0.048	1118	29100	0%
31-Jul-2019	0.048	1440	23000	23%
1-Aug-2019	0.048	1440	26960	10%
2-Aug-2019	0.048	1440	28010	7%
3-Aug-2019	0.048	1050	28900	-32%
4-Aug-2019	0.048	1440	20025	33%
5-Aug-2019	0.048	1440	27650	8%
6-Aug-2019	0.048	900	27055	-44%
7-Aug-2019	0.048	1415	18500	37%
8-Aug-2019	0.048	1440	27055	10%
9-Aug-2019	0.048	1440	27205	9%
10-Aug-2019	0.048	1380	26900	6%
11-Aug-2019	0.048	1380	23575	18%
12-Aug-2019	0.048	1440	28595	5%
13-Aug-2019	0.048	960	29545	-48%
14-Aug-2019	0.048	1440	18350	39%
15-Aug-2019	0.048	1405	29055	1%
16-Aug-2019	0.048	1390	28055	3%
17-Aug-2019	0.048	1440	28055	6%
18-Aug-2019	0.048	1440	28055	6%
19-Aug-2019	0.048	1440	29105	3%
20-Aug-2019	0.048	900	29080	-55%
21-Aug-2019	0.048	1440	17900	40%
22-Aug-2019	0.048	1125	28110	-20%
23-Aug-2019	0.048	1440	22250	26%
24-Aug-2019	0.048	1440	28555	5%
25-Aug-2019	0.048	1440	28555	5%
Total	0.048	38613	735000	5.6%

Lampiran 68 Data perhitungan *reduce speed* mesin *spraydrayer* bulan September

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
26-Aug-2019	0.048	1440	28155	4%
27-Aug-2019	0.048	1440	28945	0%
28-Aug-2019	0.048	960	14950	19%
29-Aug-2019	0.048	1440	25900	14%
30-Aug-2019	0.048	1440	26050	11%
31-Aug-2019	0.048	1440	26650	10%
1-Sep-2019	0.048	1440	27900	7%
2-Sep-2019	0.048	1440	28550	5%
3-Sep-2019	0.048	1440	27650	8%
4-Sep-2019	0.048	960	16800	6%
5-Sep-2019	0.048	1440	29100	3%
6-Sep-2019	0.048	1440	27650	8%
7-Sep-2019	0.048	1440	27650	6%
8-Sep-2019	0.048	1440	27800	6%
9-Sep-2019	0.048	1440	27650	8%
10-Sep-2019	0.048	1440	28630	5%
11-Sep-2019	0.048	960	16850	9%
12-Sep-2019	0.048	1440	27900	7%
13-Sep-2019	0.048	1440	23575	21%
14-Sep-2019	0.048	1440	28595	5%
15-Sep-2019	0.048	1440	28500	2%
16-Sep-2019	0.048	1440	28350	6%
17-Sep-2019	0.048	1440	26650	11%
18-Sep-2019	0.048	960	16020	12%
19-Sep-2019	0.048	1440	26650	11%
20-Sep-2019	0.048	1440	26650	11%
21-Sep-2019	0.048	1440	26650	2%
22-Sep-2019	0.048	1440	26650	11%
23-Sep-2019	0.048	1440	26650	11%
24-Sep-2019	0.048	1440	27630	8%
25-Sep-2019	0.048	960	16950	9%
26-Sep-2019	0.048	1440	28645	5%
27-Sep-2019	0.048	1440	26155	8%
28-Sep-2019	0.048	1440	26650	11%
29-Sep-2019	0.048	1440	29650	1%
Total	0.048	48000	905400	8.0%

Lampiran 69 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Oktober

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
30-Sep-2019	0.044	1440	30490	5%
1-Oct-2019	0.044	1440	31240	0%
2-Oct-2019	0.044	960	20340	1%
3-Oct-2019	0.044	1440	29400	5%
4-Oct-2019	0.044	1440	30490	8%
5-Oct-2019	0.044	1440	29740	10%
6-Oct-2019	0.044	1440	29040	12%
7-Oct-2019	0.044	1440	28445	14%
8-Oct-2019	0.044	1440	24480	8%
9-Oct-2019	0.044	960	19480	4%
10-Oct-2019	0.044	1440	28595	13%
11-Oct-2019	0.044	1440	28290	11%
12-Oct-2019	0.044	1440	31090	5%
13-Oct-2019	0.044	1440	29985	9%
14-Oct-2019	0.044	1440	30935	6%
15-Oct-2019	0.044	1440	30890	6%
16-Oct-2019	0.044	960	19390	2%
17-Oct-2019	0.044	1440	30690	7%
18-Oct-2019	0.044	1440	30840	7%
19-Oct-2019	0.044	1440	29985	5%
20-Oct-2019	0.044	1440	29890	9%
21-Oct-2019	0.044	1440	29740	10%
22-Oct-2019	0.044	1440	30290	8%
23-Oct-2019	0.044	960	21240	0%
24-Oct-2019	0.044	1440	24390	26%
25-Oct-2019	0.044	1440	28350	14%
26-Oct-2019	0.044	1440	29400	11%
27-Oct-2019	0.044	1440	31190	5%
Total	0.044	38400	788325	8%

Lampiran 70 Data perhitungan *reduce speed* mesin *spraydrayer* bulan November

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
28-Oct-2019	0.044	1440	32975	0%
29-Oct-2019	0.044	1440	31900	0%
30-Oct-2019	0.044	960	16850	4%
31-Oct-2019	0.044	1440	32460	2%
1-Nov-2019	0.044	1440	31850	0%
2-Nov-2019	0.044	1440	32975	0%
3-Nov-2019	0.044	1440	32850	0%
4-Nov-2019	0.044	1440	32980	0%
5-Nov-2019	0.044	1440	32450	2%
6-Nov-2019	0.044	960	18900	8%
7-Nov-2019	0.044	1440	32310	2%
8-Nov-2019	0.044	1440	32950	0%
9-Nov-2019	0.000	0	0	0%
10-Nov-2019	0.044	1440	32330	2%
11-Nov-2019	0.044	1440	30220	8%
12-Nov-2019	0.044	1440	19100	35%
13-Nov-2019	0.044	960	31750	0%
14-Nov-2019	0.044	1440	30220	8%
15-Nov-2019	0.044	1440	18900	40%
16-Nov-2019	0.044	1440	32310	2%
17-Nov-2019	0.044	1440	32950	0%
18-Nov-2019	0.047	1440	14850	51%
19-Nov-2019	0.047	780	5985	56%
20-Nov-2019	0.087	300	15050	0%
21-Nov-2019	0.044	1440	32030	3%
22-Nov-2019	0.044	1440	31975	3%
23-Nov-2019	0.044	1440	32980	0%
24-Nov-2019	0.044	1440	33010	0%
25-Nov-2019	0.042	1440	33980	0%
26-Nov-2019	0.041	1440	19100	45%
27-Nov-2019	0.041	960	31150	0%
28-Nov-2019	0.044	1440	32050	3%
29-Nov-2019	0.044	1440	31900	1%
30-Nov-2019	0.040	1440	32540	9%
1-Dec-2019	0.048	1440	36000	0%
Total	0.045	45240	967015	2.6%

Lampiran 71 Data perhitungan *reduce speed* mesin *spraydrayer* bulan Desember

Tanggal	Cycle Time	Loading Time	Proses Amount	Reduce Speed Loss %
2-Dec-2019	0.044	1440	33130	0%
3-Dec-2019	0.044	1440	30875	0%
4-Dec-2019	0.044	960	32190	5%
5-Dec-2019	0.044	1440	31635	4%
6-Dec-2019	0.044	1440	27470	17%
7-Dec-2019	0.044	1440	27450	17%
8-Dec-2019	0.044	1440	32985	0%
9-Dec-2019	0.044	1440	33000	1%
10-Dec-2019	0.044	1440	33000	0%
11-Dec-2019	0.044	960	32995	4%
12-Dec-2019	0.044	1440	32970	0%
13-Dec-2019	0.044	1440	32490	2%
14-Dec-2019	0.044	1440	32980	0%
15-Dec-2019	0.044	1440	28245	14%
16-Dec-2019	0.044	1440	33000	4%
17-Dec-2019	0.044	1440	32985	0%
18-Dec-2019	0.044	960	32985	5%
19-Dec-2019	0.044	1440	33850	-3%
20-Dec-2019	0.044	1440	31170	6%
21-Dec-2019	0.044	1440	33270	5%
22-Dec-2019	0.044	1440	31695	4%
23-Dec-2019	0.044	1440	27110	18%
24-Dec-2019	0.048	780	1905	0%
Total	0.044	31020	699385	0.2%

LAMPIRAN Reject Losses

Lampiran 72 Data perhitungan *reject losses* mesin *spraydrayer* bulan Februari

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
28-Jan-2019	0.048	0	930	0.00
29-Jan-2019	0.048	170	1440	0.57
30-Jan-2019	0.048	0	1440	0.00
31-Jan-2019	0.048	50	1440	0.17
1-Feb-2019	0.048	1360	1440	4.53
2-Feb-2019	0.048	340	1440	1.13
3-Feb-2019	0.048	660	1440	2.20
4-Feb-2019	0.048	170	1020	0.80
5-Feb-2019	0.048	170	1440	0.57
6-Feb-2019	0.048	510	1440	1.70
7-Feb-2019	0.048	560	1440	1.87
8-Feb-2019	0.048	340	1440	1.13
9-Feb-2019	0.048	0	1440	0.00
10-Feb-2019	0.048	300	1440	1.00
11-Feb-2019	0.048	340	1050	1.55
12-Feb-2019	0.048	0	1440	0.00
13-Feb-2019	0.048	850	1440	2.83
14-Feb-2019	0.048	170	1440	0.57
15-Feb-2019	0.048	680	1440	2.27
16-Feb-2019	0.048	0	1440	0.00
17-Feb-2019	0.048	0	480	0.00
18-Feb-2019	0.048	0	480	0.00
19-Feb-2019	0.048	510	1140	2.15
20-Feb-2019	0.048	0	1440	0.00
21-Feb-2019	0.048	0	1440	0.00
22-Feb-2019	0.048	0	1440	0.00
23-Feb-2019	0.048	0	1440	0.00
24-Feb-2019	0.048	170	1440	0.57
Total	0.048	7350	36780	0.96

Lampiran 73 Data perhitungan *reject losses* mesin *spraydrayer* bulan Maret

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
25-Feb-2019	0.048	355	1440	1.18
26-Feb-2019	0.048	0	1080	0.00
27-Feb-2019	0.048	320	1440	1.07
28-Feb-2019	0.048	340	1440	1.13
1-Mar-2019	0.048	515	1440	1.72
2-Mar-2019	0.048	510	1170	2.09
3-Mar-2019	0.048	0	1440	0.00
4-Mar-2019	0.048	0	1440	0.00
5-Mar-2019	0.048	0	1170	0.00
6-Mar-2019	0.048	0	1440	0.00
7-Mar-2019	0.048	490	1440	1.63
8-Mar-2019	0.048	170	1440	0.57
9-Mar-2019	0.048	0	1440	0.00
10-Mar-2019	0.048	0	1440	0.00
11-Mar-2019	0.048	340	1440	1.13
12-Mar-2019	0.048	0	1440	0.00
13-Mar-2019	0.048	0	1020	0.00
14-Mar-2019	0.048	835	1440	2.78
15-Mar-2019	0.048	1680	1440	5.60
16-Mar-2019	0.048	0	1440	0.00
17-Mar-2019	0.048	340	1440	1.13
18-Mar-2019	0.048	1340	1440	4.47
19-Mar-2019	0.048	510	1095	2.24
20-Mar-2019	0.048	1730	1440	5.77
21-Mar-2019	0.048	340	1440	1.13
22-Mar-2019	0.048	270	1440	0.90
23-Mar-2019	0.048	0	1440	0.00
24-Mar-2019	0.048	1275	1440	4.25
25-Mar-2019	0.048	1525	1440	5.08
26-Mar-2019	0.048	0	1020	0.00
27-Mar-2019	0.048	170	1440	0.57
28-Mar-2019	0.048	975	1440	3.25
29-Mar-2019	0.048	170	1440	0.57
30-Mar-2019	0.048	0	1440	0.00
31-Mar-2019	0.048	170	1440	0.57
Total	0.048	14370	48315	1.43

Lampiran 74 Data perhitungan *reject losses* mesin *spraydrayer* bulan April

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
1-Apr-2019	0.048	510	1440	1.70
2-Apr-2019	0.048	0	1080	0.00
3-Apr-2019	0.048	1020	1440	3.40
4-Apr-2019	0.048	1000	1440	3.33
5-Apr-2019	0.048	340	1440	1.13
6-Apr-2019	0.048	0	1440	0.00
7-Apr-2019	0.048	150	1440	0.50
8-Apr-2019	0.048	170	1440	0.57
9-Apr-2019	0.048	0	1267.2	0.00
10-Apr-2019	0.048	0	1440	0.00
11-Apr-2019	0.048	490	1440	1.63
12-Apr-2019	0.048	0	1440	0.00
13-Apr-2019	0.048	0	1440	0.00
14-Apr-2019	0.048	0	1440	0.00
15-Apr-2019	0.048	170	1275	0.64
16-Apr-2019	0.048	0	1440	0.00
17-Apr-2019	0	680	0	0.00
18-Apr-2019	0.048	0	1440	0.00
19-Apr-2019	0.048	0	1440	0.00
20-Apr-2019	0.048	170	1440	0.57
21-Apr-2019	0.048	0	1440	0.00
22-Apr-2019	0.048	0	1320	0.00
23-Apr-2019	0.048	0	1440	0.00
24-Apr-2019	0.048	510	1440	1.70
25-Apr-2019	0.048	0	1440	0.00
26-Apr-2019	0.048	820	1440	2.73
27-Apr-2019	0.048	340	1440	1.13
28-Apr-2019	0.048	340	1440	1.13
Total	0.048	6710	38062.2	0.80

Lampiran 75 Data perhitungan *reject losses* mesin *spraydrayer* bulan Mei

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
29-Apr-2019	0.048	0	1080	0.00
30-Apr-2019	0.048	540	1440	1.80
1-May-2019	0.048	0	1440	0.00
2-May-2019	0.048	0	1440	0.00
3-May-2019	0.048	0	1440	0.00
4-May-2019	0.048	340	1440	1.13
5-May-2019	0.048	510	1440	1.70
6-May-2019	0.048	0	1440	0.00
7-May-2019	0.048	150	1035	0.70
8-May-2019	0.048	0	1440	0.00
9-May-2019	0.048	0	1440	0.00
10-May-2019	0.048	400	1440	1.33
11-May-2019	0.048	170	1440	0.57
12-May-2019	0.048	680	1440	2.27
13-May-2019	0.048	340	1440	1.13
14-May-2019	0.048	0	1110	0.00
15-May-2019	0.048	0	1440	0.00
16-May-2019	0.048	340	1440	1.13
17-May-2019	0.048	0	1440	0.00
18-May-2019	0.048	100	1440	0.33
19-May-2019	0.048	0	1440	0.00
20-May-2019	0.048	280	1440	0.93
21-May-2019	0.048	0	870	0.00
22-May-2019	0.048	0	1440	0.00
23-May-2019	0.048	0	1440	0.00
24-May-2019	0.048	0	1440	0.00
25-May-2019	0.048	170	1440	0.57
26-May-2019	0.048	670	1440	2.23
Total	0.048	4690	38655	0.58

Lampiran 76 Data perhitungan *reject losses* mesin *spraydrayer* bulan Juni

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
27-May-2019	0.048	150	1440	0.50
28-May-2019	0.048	0	960	0.00
29-May-2019	0.048	0	1440	0.00
30-May-2019	0.048	0	480	0.00
31-May-2019	0	0	0	0.00
1-Jun-2019	0	0	0	0.00
2-Jun-2019	0	0	0	0.00
3-Jun-2019	0	0	0	0.00
4-Jun-2019	0	0	0	0.00
5-Jun-2019	0	0	0	0.00
6-Jun-2019	0	0	0	0.00
7-Jun-2019	0	0	0	0.00
8-Jun-2019	0	0	0	0.00
9-Jun-2019	0	0	0	0.00
10-Jun-2019	0	0	0	0.00
11-Jun-2019	0	0	0	0.00
12-Jun-2019	0.048	0	480	0.00
13-Jun-2019	0.048	320	1440	1.07
14-Jun-2019	0.048	0	1440	0.00
15-Jun-2019	0.048	0	1440	0.00
16-Jun-2019	0.048	170	1440	0.57
17-Jun-2019	0.048	565	1440	1.88
18-Jun-2019	0.048	150	960	0.75
19-Jun-2019	0.048	170	1440	0.57
20-Jun-2019	0.048	0	1440	0.00
21-Jun-2019	0.048	510	1440	1.70
22-Jun-2019	0.048	0	1440	0.00
23-Jun-2019	0.048	0	1440	0.00
24-Jun-2019	0.048	490	1440	1.63
25-Jun-2019	0.048	0	960	0.00
26-Jun-2019	0.048	510	1440	1.70
27-Jun-2019	0.048	0	1440	0.00
28-Jun-2019	0.048	340	1440	1.13
29-Jun-2019	0.048	0	1440	0.00
30-Jun-2019	0.048	0	1440	0.00
Total	0.048	3375	29760	0.60

Lampiran 77 Data perhitungan *reject losses* mesin *spraydrayer* bulan Juli

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
1-Jul-2019	0.048	450	1440	1.50
2-Jul-2019	0.048	510	1440	1.70
3-Jul-2019	0.048	0	1440	0.00
4-Jul-2019	0.048	0	960	0.00
5-Jul-2019	0.048	510	1440	1.70
6-Jul-2019	0.048	0	1440	0.00
7-Jul-2019	0.048	0	1440	0.00
8-Jul-2019	0.048	1000	1440	3.33
9-Jul-2019	0.048	0	1440	0.00
10-Jul-2019	0.048	0	1440	0.00
11-Jul-2019	0.048	0	1200	0.00
12-Jul-2019	0.048	170	1440	0.57
13-Jul-2019	0.048	0	1440	0.00
14-Jul-2019	0.048	0	1440	0.00
15-Jul-2019	0.048	320	1440	1.07
16-Jul-2019	0.048	0	1440	0.00
17-Jul-2019	0.048	170	1440	0.57
18-Jul-2019	0.048	170	960	0.85
19-Jul-2019	0.048	0	1440	0.00
20-Jul-2019	0.048	170	1440	0.57
21-Jul-2019	0.048	0	1440	0.00
22-Jul-2019	0.048	340	1440	1.13
23-Jul-2019	0.048	150	1440	0.50
24-Jul-2019	0.048	180	1440	0.60
25-Jul-2019	0.048	0	960	0.00
26-Jul-2019	0.048	510	1440	1.70
27-Jul-2019	0.048	110	1440	0.37
28-Jul-2019	0.048	345	1440	1.15
Total	0.048	5105	38640	0.63

Lampiran 78 Data perhitungan *reject losses* mesin *spraydrayer* bulan Agustus

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
29-Jul-2019	0.048	0	1440	0.00
30-Jul-2019	0.048	250	1440	0.83
31-Jul-2019	0.048	0	1440	0.00
1-Aug-2019	0.048	0	960	0.00
2-Aug-2019	0.048	490	1440	1.63
3-Aug-2019	0.048	170	1440	0.57
4-Aug-2019	0.048	25	1440	0.08
5-Aug-2019	0.048	0	1440	0.00
6-Aug-2019	0.048	0	1440	0.00
7-Aug-2019	0.048	170	1440	0.57
8-Aug-2019	0.048	0	1200	0.00
9-Aug-2019	0.048	150	1440	0.50
10-Aug-2019	0.048	0	1440	0.00
11-Aug-2019	0.048	0	1440	0.00
12-Aug-2019	0.048	0	1440	0.00
13-Aug-2019	0.048	130	1440	0.43
14-Aug-2019	0.048	0	1440	0.00
15-Aug-2019	0.048	230	960	1.15
16-Aug-2019	0.048	170	1440	0.57
17-Aug-2019	0.048	320	1440	1.07
18-Aug-2019	0.048	0	1440	0.00
19-Aug-2019	0.048	300	1440	1.00
20-Aug-2019	0.048	250	1440	0.83
21-Aug-2019	0.048	0	1440	0.00
22-Aug-2019	0.048	450	960	2.25
23-Aug-2019	0.048	0	1440	0.00
24-Aug-2019	0.048	745	1440	2.48
25-Aug-2019	0.048	450	1440	1.50
Total	0.048	4300	38640	0.53

Lampiran 79 Data perhitungan *reject losses* mesin *spraydrayer* bulan September

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
26-Aug-2019	0.048	1530	1440	5.10
27-Aug-2019	0.048	170	1440	0.57
28-Aug-2019	0.048	0	960	0.00
29-Aug-2019	0.048	0	1440	0.00
30-Aug-2019	0.048	150	1440	0.50
31-Aug-2019	0.048	0	1440	0.00
1-Sep-2019	0.048	340	1440	1.13
2-Sep-2019	0.048	785	1440	2.62
3-Sep-2019	0.048	0	1440	0.00
4-Sep-2019	0.048	0	960	0.00
5-Sep-2019	0.048	1200	1440	4.00
6-Sep-2019	0.048	120	1440	0.40
7-Sep-2019	0.048	110	1440	0.37
8-Sep-2019	0.048	150	1440	0.50
9-Sep-2019	0.048	800	1440	2.67
10-Sep-2019	0.048	145	1440	0.48
11-Sep-2019	0.048	0	960	0.00
12-Sep-2019	0.048	600	1440	2.00
13-Sep-2019	0.048	150	1440	0.50
14-Sep-2019	0.048	450	1440	1.50
15-Sep-2019	0.048	800	1440	2.67
16-Sep-2019	0.048	690	1440	2.30
17-Sep-2019	0.048	85	1440	0.28
18-Sep-2019	0.048	0	960	0.00
19-Sep-2019	0.048	190	1440	0.63
20-Sep-2019	0.048	370	1440	1.23
21-Sep-2019	0.048	145	1440	0.48
22-Sep-2019	0.048	500	1440	1.67
23-Sep-2019	0.048	135	1440	0.45
24-Sep-2019	0.048	150	1440	0.50
25-Sep-2019	0.048	0	960	0.00
26-Sep-2019	0.048	1200	1440	4.00
27-Sep-2019	0.048	450	1440	1.50
28-Sep-2019	0.048	300	1440	1.00
29-Sep-2019	0.048	1300	1440	4.33
Total	0.048	13015	48000	1.30

Lampiran 80 Data perhitungan *reject losses* mesin *spraydrayer* bulan Oktober

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
30-Sep-2019	0.044	0	1440	0.00
1-Oct-2019	0.044	490	1440	1.50
2-Oct-2019	0.044	125	960	0.57
3-Oct-2019	0.044	170	1440	0.52
4-Oct-2019	0.044	600	1440	1.83
5-Oct-2019	0.044	650	1440	1.99
6-Oct-2019	0.044	450	1440	1.38
7-Oct-2019	0.044	170	1440	0.52
8-Oct-2019	0.044	220	1440	0.67
9-Oct-2019	0.044		960	0.00
10-Oct-2019	0.044	800	1440	2.44
11-Oct-2019	0.044	685	1440	2.09
12-Oct-2019	0.044	1205	1440	3.68
13-Oct-2019	0.044	390	1440	1.19
14-Oct-2019	0.044	450	1440	1.38
15-Oct-2019	0.044	600	1440	1.83
16-Oct-2019	0.044	0	960	0.00
17-Oct-2019	0.044	200	1440	0.61
18-Oct-2019	0.044	155	1440	0.47
19-Oct-2019	0.044	435	1440	1.33
20-Oct-2019	0.044	300	1440	0.92
21-Oct-2019	0.044	350	1440	1.07
22-Oct-2019	0.044	200	1440	0.61
23-Oct-2019	0.044	50	960	0.23
24-Oct-2019	0.044	235	1440	0.72
25-Oct-2019	0.044	100	1440	0.31
26-Oct-2019	0.044	90	1440	0.28
27-Oct-2019	0.044	235	1440	0.72
Total	0.048	9355	38400	1.07

Lampiran 81 Data perhitungan *reject losses* mesin *spraydrayer* bulan November

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
28-Oct-2019	0.044	120	1440	0.37
29-Oct-2019	0.044	110	1440	0.34
30-Oct-2019	0.044	150	960	0.69
31-Oct-2019	0.044	800	1440	2.44
1-Nov-2019	0.044	145	1440	0.44
2-Nov-2019	0.044	150	1440	0.46
3-Nov-2019	0.044	600	1440	1.83
4-Nov-2019	0.044	150	1440	0.46
5-Nov-2019	0.044	450	1440	1.38
6-Nov-2019	0.044	800	960	3.67
7-Nov-2019	0.044	690	1440	2.11
8-Nov-2019	0.044	85	1440	0.26
9-Nov-2019	0.044	90	0	0.00
10-Nov-2019	0.044	190	1440	0.58
11-Nov-2019	0.044	370	1440	1.13
12-Nov-2019	0.044	145	1440	0.44
13-Nov-2019	0.044	120	960	0.55
14-Nov-2019	0.044	340	1440	1.04
15-Nov-2019	0.044	340	1440	1.04
16-Nov-2019	0.044	435	1440	1.33
17-Nov-2019	0.044	300	1440	0.92
18-Nov-2019	0.044	350	1440	1.07
19-Nov-2019	0.044	200	780	1.13
20-Nov-2019	0.044	50	300	0.73
21-Nov-2019	0.044	235	1440	0.72
22-Nov-2019	0.044	100	1440	0.31
23-Nov-2019	0.044	90	1440	0.28
24-Nov-2019	0.044	500	1440	1.53
25-Nov-2019	0.044	0	1440	0.00
26-Nov-2019	0.044	0	1440	0.00
27-Nov-2019	0.044	80	960	0.37
28-Nov-2019	0.044	95	1440	0.29
29-Nov-2019	0.044	120	1440	0.37
30-Nov-2019	0.044	80	1440	0.24
1-Dec-2019	0.044	0	1440	0.00
Total	0.048	8480	45240	0.84

Lampiran 82 Data perhitungan *reject losses* mesin *spraydrayer* bulan Desember

Tanggal	Cycle time	Reject	Loading Time	Reject Losses
2-Dec-2019	0.044	150	1440	0.46
3-Dec-2019	0.044	90	1440	0.28
4-Dec-2019	0.044	200	960	0.92
5-Dec-2019	0.044	300	1440	0.92
6-Dec-2019	0.044	350	1440	1.07
7-Dec-2019	0.044	200	1440	0.61
8-Dec-2019	0.044	50	1440	0.15
9-Dec-2019	0.044	235	1440	0.72
10-Dec-2019	0.044	100	1440	0.31
11-Dec-2019	0.044	90	960	0.41
12-Dec-2019	0.044	500	1440	1.53
13-Dec-2019	0.044	90	1440	0.28
14-Dec-2019	0.044	1200	1440	3.67
15-Dec-2019	0.044	120	1440	0.37
16-Dec-2019	0.044	110	1440	0.34
17-Dec-2019	0.044	150	1440	0.46
18-Dec-2019	0.044	800	960	3.67
19-Dec-2019	0.044	145	1440	0.44
20-Dec-2019	0.044	200	1440	0.61
21-Dec-2019	0.044	270	1440	0.83
22-Dec-2019	0.044	250	1440	0.76
24-Dec-2019	0.044	325	1440	0.99
Total	0.044	5925	30240	0.84

LAMPIRAN Failure Mode and Effect Analysis (FMEA)
 Lampiran 83 *Failure Mode and Effect Analysis (FMEA)*

Jenis Losses	Failure	Failure Mode	Failure Effect
Reduce Speed	Lama waktu mesin bekerja tidak maksimal	Brix cairan coffee rendah <45	Waktu proses menurun (penyesuaian cairan)
		FS rendah (Floating Sedimen)	
		Proses Transfer Cairan Lambat	Banyaknya waktu mesin berhenti dengan percuma, sehingga proses produksi terhenti dan berjalan tidak maksimal (operating time berkurang)
		Waktu persiapan produksi terlalu lama (planned downtime)	
Setup and adjustment	Tingginya waktu Setting saat stop mesin (preventiv)	Proses <i>heating</i> pada mesin lama(1 - 1,5 jam)	Waktu set up mesin lama membuat waktu proses produksi berkurang
		waktu <i>Suap Test</i> (hasil analisa qc) yang relatif lama (1 jam)	
		Kurangnya skill operator dalam proses start awal	
Idling and Minor Stoppages	Cairan Minim	Bottleneck pada proses (cairan mimim)	Mesin spray drayer akan terhenti
		Procces M.pump Trasfer tidak maksimal	Operating time mesin berkurang
Breakdown	PLN OFF	Suplay Listrik Off	Keseluruhan proses produksi terhenti
	M. Sivter Short Body	M. Sivter Mati	Prose Spray terhenti delay waktu dan operating time tidak optimal
	M. Pump HPP Trouble	Membram HPP Jebol	Mesin berhenti dan proses terhambat
	Jalur Produk Bocor	Jalur Produk Retak	Tidak optimal proses spray ,mesin terhenti dan menghambat proses
	Burner Trouble	Sensor error	Proses spray lambat karan pemanasan mesin tidak optimal , product reject
	Exhaust Fan Trouble	Bearing rusak ,suara kasar	Mesin rusak dan menghambat proses spray
	M. Pump Screw Trouble	Motor Short Body	Mesin berhenti dan proses terhambat
	M.5 Tidak maksimal transfer	Mechanical seal motor bocor	Mesin berhenti dan menghambat proses sehingga operating time tidak optimal

LAMPIRAN SAVERITY
Lampiran 84 Saverity (S)

Jenis Losses	Failure	Failure Mode	Failure Effect	Severity
Reduce Speed	Lama waktu mesin bekerja tidak maksimal	Brix cairan coffee rendah <45	Waktu proses menurun (penyesuaian cairan)	5
		FS rendah (Floating Sedimen)		
		Proses Transfer Cairan Lambat	Banyaknya waktu mesin berhenti dengan percuma, sehingga proses produksi terhenti dan berjalan tidak maksimal (operating time berkurang)	5
		Waktu persiapan produksi terlalu lama (planned downtime)		4
Setup and adjustment	Tingginya waktu Setting saat stop mesin (preventiv)	Proses <i>heating</i> pada mesin lama(1 - 1,5 jam)	Waktu set up mesin lama membuat waktu proses produksi berkurang	5
		waktu <i>Suap Test</i> (hasil analisa qc) yang relatif lama (1 jam)		5
		Kurangnya skill operator dalam proses start awal		5
Idling and Minor Stoppages	Cairan Minim	Bottleneck pada proses (cairan mimim)	Mesin spray drayer akan terhenti	5
		Procces M.pump Trasfer tidak maksimal	Operating time mesin berkurang	5
Breakdown	PLN OFF	Suplay Listrik Off	Keseluruhan proses produksi terhenti	5
	M. Sivter Short Body	M. Sivter Mati	Prose Spray terhenti delay waktu dan operating time tidak optimal	6
	M. Pump HPP Trouble	Membram HPP Jebol	Mesin berhenti dan proses terhambat	7
	Jalur Produk Bocor	Jalur Produk Retak	Tidak optimal proses spray ,mesin terhenti dan menghambat proses	7
	Burner Trouble	Sensor error	Proses spray lambat karan pemanasan mesin tidak optimal , product reject	7
	Exhaust Fan Trouble	Bearing rusak ,suara kasar	Mesin rusak dan menghambat proses spray	5
	M. Pump Screw Trouble	Motor Short Body	Mesin berhenti dan proses terhambat	7
	M.5 Tidak maksimal transfer	Mechanical seal motor bocor	Mesin berhenti dan menghambat proses sehingga operating time tidak optimal	5

LAMPIRAN OCCURANCE

Lampiran 85 Occurance (O)

Jenis Losses	Failure	Failure Mode	Failure Effect	Ocurance
Reduce Speed	Lama waktu mesin bekerja tidak maksimal	Brix cairan coffee rendah <45	Waktu proses menurun (penyesuaian cairan)	6
		FS rendah (Floating Sedimen)		
		Proses Transfer Cairan Lambat	Banyaknya waktu mesin berhenti dengan percuma, sehingga proses produksi terhenti dan berjalan tidak maksimal (operating time berkurang)	5
		Waktu persiapan produksi terlalu lama (planned downtime)		6
Setup and adjustment	Tingginya waktu Setting saat stop mesin (preventiv)	Proses <i>heating</i> pada mesin lama(1 - 1,5 jam)	Waktu set up mesin lama membuat waktu proses produksi berkurang	5
		waktu <i>Suap Test</i> (hasil analisa qc) yang relatif lama (1 jam)		5
		Kurangnya skill operator dalam proses start awal		5
Idling and Minor Stoppages	Cairan Minim	Bottleneck pada proses (cairan mimim)	Mesin spray drayer akan terhenti	5
		Procces M.pump Trasfer tidak maksimal	Operating time mesin berkurang	4
Breakdown	PLN OFF	Suplay Listrik Off	Keseluruhan proses produksi terhenti	2
	M. Sivter Short Body	M. Sivter Mati	Prose Spray terhenti delay waktu dan operating time tidak optimal	6
	M. Pump HPP Trouble	Membram HPP Jebol	Mesin berhenti dan proses terhambat	5
	Jalur Produk Bocor	Jalur Produk Retak	Tidak optimal proses spray ,mesin terhenti dan menghambat proses	6
	Burner Trouble	Sensor error	Proses spray lambat karan pemanasan mesin tidak optimal , product reject	4
	Exhaust Fan Trouble	Bearing rusak ,suara kasar	Mesin rusak dan menghambat proses spray	2
	M. Pump Screw Trouble	Motor Short Body	Mesin berhenti dan proses terhambat	5
	M.5 Tidak maksimal transfer	Mechanical seal motor bocor	Mesin berhenti dan menghambat proses sehingga operating time tidak optimal	6

LAMPIRAN *DETECTION*
Lampiran 86 *Detection* (D)

Jenis Losses	Failure	Failure Mode	Failure Effect	Detection
Reduce Speed	Lama waktu mesin bekerja tidak maksimal	Brix cairan coffee rendah <45	Waktu proses menurun (penyesuaian cairan)	6
		FS rendah (Floating Sedimen)		
		Proses Transfer Cairan Lambat	Banyaknya waktu mesin berhenti dengan percuma, sehingga proses produksi terhenti dan berjalan tidak maksimal (operating time berkurang)	8
		Waktu persiapan produksi terlalu lama (planned downtime)		6
Setup and adjustment	Tingginya waktu Setting saat stop mesin (preventiv)	Proses <i>heating</i> pada mesin lama(1 - 1,5 jam)	Waktu set up mesin lama membuat waktu proses produksi berkurang	7
		waktu <i>Suap Test</i> (hasil analisa qc) yang relatif lama (1 jam)		6
		Kurangnya skill operator dalam proses start awal		7
Idling and Minor Stoppages	Cairan Minim	Bottleneck pada proses (cairan mimim)	Mesin spray drayer akan terhenti	7
		Proces M.pump Trasfer tidak maksimal	Operating time mesin berkurang	5
Breakdown	PLN OFF	Suplay Listrik Off	Keseluruhan proses produksi terhenti	8
	M. Sivter Short Body	M. Sivter Mati	Prose Spray terhenti delay waktu dan operating time tidak optimal	8
	M. Pump HPP Trouble	Membram HPP Jebol	Mesin berhenti dan proses terhambat	8
	Jalur Produk Bocor	Jalur Produk Retak	Tidak optimal proses spray ,mesin terhenti dan menghambat proses	7
	Burner Trouble	Sensor error	Proses spray lambat karan pemanasan mesin tidak optimal , product reject	7
	Exhaust Fan Trouble	Bearing rusak ,suara kasar	Mesin rusak dan menghambat proses spray	4
	M. Pump Screw Trouble	Motor Short Body	Mesin berhenti dan proses terhambat	7
	M.5 Tidak maksimal transfer	Mechanical seal motor bocor	Mesin berhenti dan menghambat proses sehingga operating time tidak optimal	8

LAMPIRAN Risk Priority Number
Lampiran 87 Risk Priority Number (RPN)

<i>Failure Mode and Effect Analysis (FMEA)</i>							
Jenis Losses	Failure	Failure Mode	Failure Effect	Severity	Occurance	Detection	RPN
Reduce Speed	Lama waktu mesin bekerja tidak maksimal	Brix cairan coffee rendah <45	Waktu proses menurun (penyesuaian cairan)	5	6	6	180
		FS rendah (Floating Sedimen)					
		Proses Transfer Cairan Lambat	Banyaknya waktu mesin berhenti dengan percuma, sehingga proses produksi terhenti dan berjalan tidak maksimal (operating time berkurang)	5	5	8	200
		Waktu persiapan produksi terlalu lama (planned downtime)		4	6	6	144
Setup and adjustment	Tingginya waktu Setting saat stop mesin (preventiv)	Proses <i>heating</i> pada mesin lama(1 - 1,5 jam)	Waktu set up mesin lama membuat waktu proses produksi berkurang	5	5	7	175
		waktu <i>Suap Test</i> (hasil analisa qc) yang relatif lama (1 jam)		5	5	6	150
		Kurangnya skill operator dalam proses start awal		5	5	7	175
Idling and Minor Stoppages	Cairan Minim	Bottleneck pada proses (cairan mimim)	Mesin spray drayer akan terhenti	5	5	7	175
		Procces M.pump Trasfer tidak maksimal	Operating time mesin berkurang	5	4	5	25
Breakdown	PLN OFF	Suplay Listrik Off	Keseluruhan proses produksi terhenti	5	2	8	80
	M. Sivter Short Body	M. Sivter Mati	Prose Spray terhenti delay waktu dan operating time tidak optimal	6	6	8	288
	M. Pump HPP Trouble	Membram HPP Jebol	Mesin berhenti dan proses terhambat	7	5	8	280

Jalur Produk Bocor	Jalur Produk Retak	Tidak optimal proses spray ,mesin terhenti dan menghambat proses	7	6	7	294
Burner Trouble	Sensor error	Proses spray lambat karan pemanasan mesin tidak optimal , product reject	7	4	7	196
Exhaust Fan Trouble	Bearing rusak ,suara kasar	Mesin rusak dan menghambat proses spray	5	2	4	40
M. Pump Screw Trouble	Motor Short Body	Mesin berhenti dan proses terhambat	7	5	7	245
M.5 Tidak maksimal transfer	Mechanical seal motor bocor	Mesin berhenti dan menghambat proses sehingga operating time tidak optimal	5	6	8	240