

LAMPIRAN

Lampiran 1 Data Availability Ratio Mesin ASQ-1 – ASQ-5 Periode Oktober 2016 – Maret 2017

Mesin	Bulan	Hari Kerja	Jumlah Shift Kerja	Availability Working Time (Menit)	Planned Downtime (satuhan dalam menit)					Briefing Akhir Shift	Loading Time = Availability Working Time - Planned Downtime (Menit)	Unplanned Downtime (satuhan dalam menit)					Unplanned Downtime (menit)	Operating Time (menit)	Availability (%) = Operating Time / Loading Time	
					Prev. Maintnce (PM)	Rest	Briefing Awal Shift	Start Up (awal shift)	Start Up (setelah istirahat)			Machine Breakdown	Set Up (Ganti Size)							Material Shortage (compound)
													Ganti Lebar	Ganti Tebal	Ganti Tebal & Tebal	Ganti Comp'd				
a	b = a x 3	c = b x 8 x 60	d	e	f	g	h	i	j = c - (d+e+f+g+h+i)	k	l	m	n	o	p	q = k+l+m+n+o+p	r = j - q	s = r / j		
ASQ-1	Okt-16	31	93	44.640	402	5.580	465	1507	726	465	35.496	105	441	10	4.017	2.776	0	7348	28.148	79,30
ASQ-1	Nop-16	30	90	43.200	552	5.400	450	1458	702	450	34.187	1560	422	10	3.842	2.654	46	8534	23.653	75,04
ASQ-1	Des-16	30	90	43.200	492	5.400	450	1458	702	450	34.248	1635	460	8	5.393	3.282	153	10952	23.316	68,08
ASQ-1	Jan-17	30	90	43.200	522	5.400	450	1458	702	450	34.218	3750	481	11	4.368	3.019	30	11659	22.559	65,93
ASQ-1	Feb-17	29	87	41.760	492	5.220	435	1410	679	435	33.090	365	574	18	4.141	2.906	0	8004	25.085	75,81
ASQ-1	Mar-17	31	93	44.640	894	5.580	465	1507	726	465	35.004	30	553	3	4.094	2.998	318	7995	27.008	77,16
ASQ-2	Okt-16	31	93	44.640	432	5.580	465	1673	930	465	35.095	195	619	10	1.690	3.465	0	5978	29.117	82,97
ASQ-2	Nop-16	30	90	43.200	492	5.400	450	1619	900	450	33.889	590	592	8	1.616	3.315	75	6197	27.692	81,71
ASQ-2	Des-16	30	90	43.200	552	5.400	450	1619	900	450	33.829	195	713	8	1.877	3.704	150	6647	27.182	80,35
ASQ-2	Jan-17	30	90	43.200	1512	5.400	450	1619	900	450	32.869	2200	673	11	1.838	3.774	25	8522	24.348	74,07
ASQ-2	Feb-17	29	87	41.760	1092	5.220	435	1565	870	435	32.143	2900	801	13	1.948	3.984	0	9646	22.497	69,99
ASQ-2	Mar-17	31	93	44.640	1404	5.580	465	1673	930	465	34.123	595	787	10	1.790	3.704	406	7293	26.831	78,63
ASQ-3	Okt-16	31	93	44.640	522	5.580	465	1523	728	465	35.357	415	534	43	2.200	2.056	0	5248	30.109	85,16
ASQ-3	Nop-16	30	90	43.200	492	5.400	450	1474	705	450	34.230	5165	510	42	2.104	1.967	55	9843	24.386	71,24
ASQ-3	Des-16	30	90	43.200	492	5.400	450	1474	705	450	34.230	2120	642	42	2.255	2.177	181	7416	26.814	78,33
ASQ-3	Jan-17	30	90	43.200	492	5.400	450	1474	705	450	34.230	2185	581	48	2.393	2.239	9	7454	26.776	78,22
ASQ-3	Feb-17	29	87	41.760	492	5.220	435	1424	681	435	33.072	9265	567	48	2.240	1.998	26	14144	18.929	57,23
ASQ-3	Mar-17	31	93	44.640	894	5.580	465	1523	728	465	34.985	1325	556	47	2.236	2.134	463	6760	28.225	80,68
ASQ-5	Okt-16	31	93	44.640	522	5.580	465	1312	650	465	35.646	640	868	14	-	528	0	2050	33.597	94,25
ASQ-5	Nop-16	30	90	43.200	522	5.400	450	1269	629	450	34.480	950	829	14	-	505	59	2357	32.122	93,16
ASQ-5	Des-16	30	90	43.200	552	5.400	450	1269	629	450	34.450	1235	729	21	-	515	125	2626	31.824	92,38
ASQ-5	Jan-17	30	90	43.200	582	5.400	450	1269	629	450	34.420	1420	944	16	1.246	577	30	4234	30.186	87,70
ASQ-5	Feb-17	29	87	41.760	492	5.220	435	1227	608	435	33.343	250	866	23	-	482	0	1621	31.722	95,14
ASQ-5	Mar-17	31	93	44.640	774	5.580	465	1312	650	465	35.394	1050	712	17,6	-	544	373	2697	32.698	92,38

Lampiran 2 Data *Performance Ratio* Mesin ASQ-1 – ASQ-5 Periode Oktober 2016 – Maret 2017

Bulan	Mesin	Processed Amount (Meter) a	Theoretical Cycle Time (Menit) b	Operating Time (Menit) c	Performance Ratio (%) d = a x b x c
Okt-16	ASQ-1	677.959	0,0399	28.148	96,10
Nop-16	ASQ-1	619.117	0,0399	25.653	96,29
Des-16	ASQ-1	561.904	0,0399	23.316	96,15
Jan-17	ASQ-1	563.432	0,0399	22.559	99,65
Feb-17	ASQ-1	614.572	0,0399	25.085	97,75
Mar-17	ASQ-1	649.657	0,0399	27.008	95,97
Okt-16	ASQ-2	567.489	0,0478	29.117	93,12
Nop-16	ASQ-2	537.038	0,0478	27.692	92,66
Des-16	ASQ-2	529.319	0,0478	27.182	93,04
Jan-17	ASQ-2	473.077	0,0478	24.348	92,83
Feb-17	ASQ-2	444.668	0,0478	22.497	94,44
Mar-17	ASQ-2	519.864	0,0478	26.831	92,57
Okt-16	ASQ-3	642.622	0,0437	30.109	93,35
Nop-16	ASQ-3	534.186	0,0437	24.386	95,81
Des-16	ASQ-3	583.611	0,0437	26.814	95,20
Jan-17	ASQ-3	586.865	0,0437	26.776	95,86
Feb-17	ASQ-3	410.467	0,0437	18.929	94,84
Mar-17	ASQ-3	603.277	0,0437	28.225	93,48
Okt-16	ASQ-5	786.918	0,0398	33.597	93,13
Nop-16	ASQ-5	752.943	0,0398	32.122	93,20
Des-16	ASQ-5	742.010	0,0398	31.824	92,71
Jan-17	ASQ-5	721.544	0,0398	30.186	95,04
Feb-17	ASQ-5	752.138	0,0398	31.722	94,27
Mar-17	ASQ-5	790.581	0,0398	32.698	96,14

Lampiran 3 Data *Performance Ratio* Mesin ASQ-1 – ASQ-5 Periode Oktober 2016 – Maret 2017

Bulan	Mesin	Processed Amount (Meter)	Jumlah Scrap (Meter)	Quality Ratio (%)
		a	b	$c = a - b / a$
Okt-16	ASQ-1	677.959	1.048	99,85
Nop-16	ASQ-1	619.117	1.189	99,81
Des-16	ASQ-1	561.904	794	99,86
Jan-17	ASQ-1	563.432	1.114	99,80
Feb-17	ASQ-1	614.572	1.002	99,84
Mar-17	ASQ-1	649.657	1.074	99,83
Okt-16	ASQ-2	567.489	1.047	99,82
Nop-16	ASQ-2	537.038	1.121	99,79
Des-16	ASQ-2	529.319	734	99,86
Jan-17	ASQ-2	473.077	1.026	99,78
Feb-17	ASQ-2	444.668	1.026	99,77
Mar-17	ASQ-2	519.864	1.029	99,80
Okt-16	ASQ-3	642.622	1.223	99,81
Nop-16	ASQ-3	534.186	1.389	99,74
Des-16	ASQ-3	583.611	921	99,84
Jan-17	ASQ-3	586.865	1.302	99,78
Feb-17	ASQ-3	410.467	1.300	99,68
Mar-17	ASQ-3	603.277	1.327	99,78
Okt-16	ASQ-5	786.918	1.027	99,87
Nop-16	ASQ-5	752.943	1.177	99,84
Des-16	ASQ-5	742.010	726	99,90
Jan-17	ASQ-5	721.544	1.017	99,86
Feb-17	ASQ-5	752.138	988	99,87
Mar-17	ASQ-5	790.581	1.004	99,87