

DAFTAR LAMPIRAN

Lampiran 1 *Running Time*

Month	Week	B. Finish Dt	Group	PO	FLAVOUR	PLN HR	minutes	ACT HR
1	1	02/01/2020	A1	0390663	IMGA GCC 4x10	3,5		3,50
			A1 Total			3,5		3,50
			B2	0391143	IMGA GCC 4x10	4,5		4,50
			B2 Total			4,5		4,50
			C3	0390666	IMGA GCC 8x5	1,7		1,66
				0390664	IMGA GCC 4x10	2,8		2,85
			C3 Total			4,5		4,50
			02/01/2020 Total			12,5		12,50
		03/01/2020	A1	0391008	IMGA GCC 8x5	7,0		7,00
			A1 Total			7,0		7,00
			B2	0391060	IMGA MBS 8x5	4,7		4,73
				0391145	IMGA GCC 8x5	2,3		2,27
			B2 Total			7,0		7,00
			C3	0391061	IMGA MBS 8x5	8,0		6,50
			C3 Total			8,0		6,50
			03/01/2020 Total			22,0		20,50
		04/01/2020	A1	0391098	INDOMIE MI GRG HOT&SPICY AUST 5x8	2,3		1,79
				0391255	IMGA MBS 8x5	2,7		2,71
			A1 Total			5,0		4,50
			B2	0391099	INDOMIE MI GRG HOT&SPICY AUST 5x8	5,0		5,00
			B2 Total			5,0		5,00
			04/01/2020 Total			10,0		9,50
			1 Total			44,5	2.670,2	42,50
	2	06/01/2020	A3	0391284	GSM MA 5-1	7,3		6,63
				0391283	GRS-MA	0,7		0,67
			A3 Total			8,0		7,30
			B1	0391280	INDOMIE SOTO (ST) MA 8x5	7,0		7,00

Lampiran 2 *Data Downtime Mesin*

TH	MONTH	Katego	Notification Desc	Sum of jam dt	Sum of Total Down Time in Minutes
2020	1	Packing	PERBAIKAN MESIN EXENTRIC L-21 EXP-BAP	0,50	30,00
			PERGANTIAN BEARING SLEDING L-21EXP-DUM	1,00	60,00
			PERBAIKAN SLEDING AUTOLOADER L-21EXP-BAP	1,50	90,00
			PEMBERSIHAN CUTTER AUTOLOADER LINE 21 EXP-DUM	3,00	180,00
			PERBAIKAN ROLLER THICKNESS LINE 21 EXP-BAP	1,00	60,00
			PERBAIKAN AUTOLOADER BUMBU L-21EXP-DUM	1,00	60,00
			PERBAIKAN AUTOLOADER LINE 21 EXP-BAP	1,50	90,00
			PERBAIKAN CUTTER AUTOLOADER LINE 21 EXP-DUM	3,50	300,00
			PERBAIKAN AUTOLOADER LINE 21EXP-MJT	1,70	42,00
			PEMBERSIHAN SENSOR AUTOLOADER L-21EXP-BAP	0,50	30,00
			PEMBERSIHAN CHUTE AUTOLOADER L-21 EXP-DUM	4,35	261,00
			PERBAIKAN SLEDING AUTOLOADER 21EXP-DUM	0,50	30,00
			PEMBERSIHAN CHUTE AUTOLOADER L-21 EXP-DUM	2,50	30,00
			PERGANTIAN SENSOR AUTOLOADER LINE 21 EXP-MJT	0,50	30,00
			PERBAIKAN ROTARY DISK FEEDING LINE-21 EXP-MJT	0,50	30,00
			PERBAIKAN MESIN EXENTRIC L-21 EXP DUM	3,30	198,00
			PERBAIKAN CUTTER AUTOLOADER LINE 21EXP-BAP	2,00	120,00
			PEMBERSIHAN SENSOR AUTOLOADER L-21 EXP-DUM	1,00	60,00
			PERBAIKAN CUTTER AUTOLOADER LINE 21 EXP-DUM	4,40	264,00
			PERGANTIAN CHUTE AUTOLOADER L-21 EXP-DUM	4,60	276,00
			Total	38,85	3.331,00

Lampiran 3 Data Reject

Std Bumbu	Act Bumbu	Selisih
58.400,00	61.000,00	2.600,00
58.400,00	61.000,00	2.600,00
63.440,00	60.000,00	(3.440,00)
63.440,00	60.000,00	(3.440,00)
24.840,00	28.000,00	3.160,00
36.200,00	36.000,00	(200,00)
61.040,00	64.000,00	2.960,00
182.880,00	185.000,00	2.120,00
95.960,00	96.250,00	290,00
95.960,00	96.250,00	290,00
33.960,00	36.000,00	2.040,00
33.040,00	35.000,00	1.960,00
67.000,00	71.000,00	4.000,00
71.440,00	73.000,00	1.560,00
71.440,00	73.000,00	1.560,00
234.400,00	240.250,00	5.850,00
24.400,00	27.500,00	3.100,00
38.040,00	37.500,00	(540,00)
62.440,00	65.000,00	2.560,00
75.200,00	75.000,00	(200,00)
75.200,00	75.000,00	(200,00)
137.640,00	140.000,00	2.360,00
554.920,00	565.250,00	10.330,00
93.600,00	95.000,00	1.400,00
10.080,00	12.000,00	1.920,00
103.680,00	107.000,00	3.320,00
80.680,00	82.000,00	1.320,00
80.680,00	82.000,00	1.320,00

Lampiran 4 Hasil Produksi

B. Finish Dt	Group	PO	FLAVOUR	ACT OUT
02/01/2020	A1	0390663	IMGA GCC 4x10	58.400
	A1 Total			58.400
	B2	0391143	IMGA GCC 4x10	63.440
	B2 Total			63.440
	C3	0390666	IMGA GCC 8x5	24.840
		0390664	IMGA GCC 4x10	36.200
	C3 Total			61.040
2/01/2020 Total				182.880
03/01/2020	A1	0391008	IMGA GCC 8x5	95.960
	A1 Total			95.960
	B2	0391060	IMGA MBS 8x5	33.960
		0391145	IMGA GCC 8x5	33.040
	B2 Total			67.000
	C3	0391061	IMGA MBS 8x5	71.440
	C3 Total			71.440
3/01/2020 Total				234.400
04/01/2020	A1	0391098	INDOMIE MI GRG HOT&SPICY AUST 5x8	24.400
		0391255	IMGA MBS 8x5	38.040
	A1 Total			62.440
	B2	0391099	INDOMIE MI GRG HOT&SPICY AUST 5x8	75.200
	B2 Total			75.200
4/01/2020 Total				137.640
1 Total				554.920
06/01/2020	A3	0391284	GSM MA 5-1	93.600
		0391283	GRS-MA	10.080
	A3 Total			103.680
	R1	0391280	INDOMIF SOTO (ST) MA 8x5	80.680