

LAMPIRAN

Sebelum

PT. INDO RAYA ENERGI

HASIL TEST NE & TPI
BENANG RING FRASME (COP)

TANGGAL : 05/04/2021

Ganti Proses
CO 30 CPW

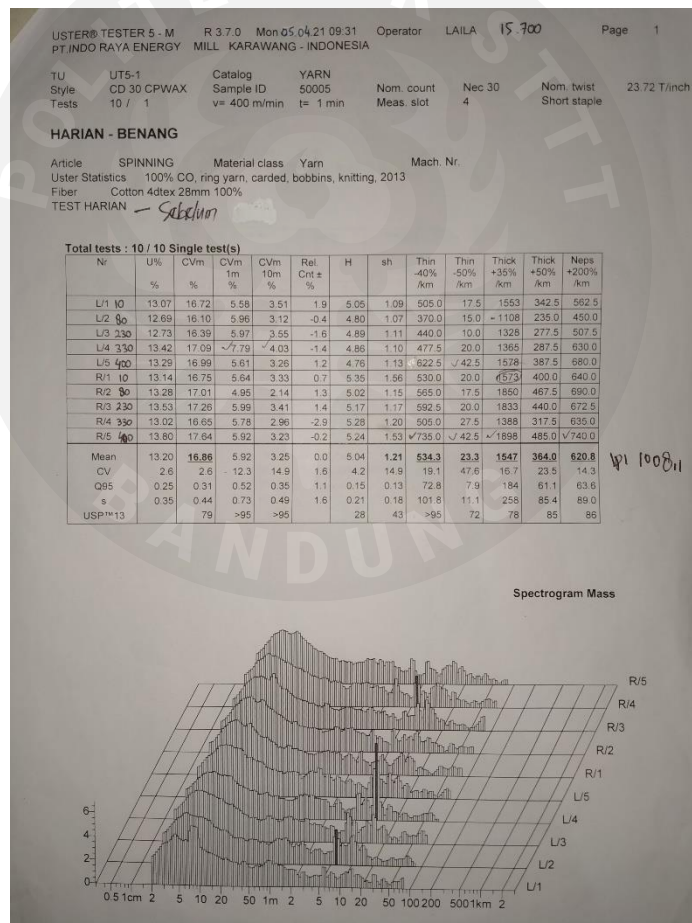
JENIS BENANG
NO. SPDL

NO. TEST	NE (L)	NO. TEST	NE (R)	NO. MC	NO. TEST	TPI (L)	NO. TEST	TPI (R)
1	2.193	1	2.152		1	23.50	1	23.95
2	2.191	2	2.194		2	23.45	2	23.60
3	2.193	3	2.193		3	23.95	3	24.00
4	2.100	4	2.086		4		4	
5	2.176	5	2.129		5		5	
6		6			6		6	
7		7			7		7	
8		8			8		8	
X	2.193	NE: 30.29			X	23.52		
CV %	1.59			40	CV %	1.11		
MAX					MAX			
MIN		R			MIN			

Mengetahui,

Sumartono
Kabag. QC

Lampiran 1. Hasil Pengujian Nomor Benang Sebelum Maintenance



Lampiran 2. Hasil Pengujian Kerataan Benang Sebelum Maintenance

USTER® TENSORAPID 4 2.7.0 UTR4/ 500N Mon 05/04/21 08:19 Operator LAILA Page 1
PT.INDORAYA ENERGI KARAWANG INDONESIA

Style CD 30 CPWAX Sample ID YARN 051119 Nom. count Nec 30 Norm. twist 23.72 T/inch
Tests 10/6 v= 5000 mm/min Fv= 9.8 cN Lh= 500 mm Pcj= 30 %

OVERALL REPORT - TABEL

Article SPINNING Material class Yarn Mach. Nr.
Uster Statistics 100% CO, ring yarn, carded, bobbins, knitting, 2013
TEST

Total: 10 / 60 Single test(s)

Nr	Time to break s	B-Force cN	Elong %	Tenacity cN/tex	B-Work cN.cm
10 1L6	0.38	341.5	6.43	17.35	569.6
20 2L6	0.39	365.8	6.53	18.99	625.5
30 3L6	0.38	370.7	6.31	18.83	599.9
30 4L6	0.38	340.8	5.95	17.31	533.0
40 5L6	0.35	329.4	5.81	16.74	507.9
10 1R6	0.37	330.4	6.10	16.78	530.7
20 2R6	0.36	303.7	5.94	15.43	478.3
30 3R6	0.36	333.3	6.09	16.93	532.9
30 4R6	0.36	305.4	5.99	15.52	479.7
40 5R6	0.37	311.1	6.24	15.81	508.0
Mean	0.37	333.2	6.14	16.93	536.5
CV	8.03	9.54	8.07	9.54	14.41
Q95	0.01	8.21	0.13	0.42	19.98
Min	0.30	257.5	4.94	13.08	340.9
Max	0.44	411.3	7.41	20.89	707.2
USP™+13		32	16	32	14

Lampiran 3. Hasil Pengujian Kekuatan Benang Sebelum Maintenance

Distance Clip
PT.INDORAYA ENERGI

HASIL TEST NE & TPI
BENANG RING FRASME (COP)

TANGGAL : 0
NO. MC : 40

JENIS BENANG CD 30 CPW
NO. SPDL

Ganti Proses

NO. TEST	NE (L)	NO. TEST	NE (R)	NO. MC	NO. TEST	TPI (L)	NO. TEST	TPI (R)
1 L/28	2,164 gr	1 R/29	2,178 gr		1	24.45	1	
2 L/29	2,216 gr	2 R/40	2,121 gr		2	24.15	2	
3 L/179	2,186 gr	3 R/105	2,192 gr		3	23.55	3	
4 L/180	2,169 gr	4 R/110	2,135 gr		4		4	
5 R/181	2,173 gr	5 L/220	2,221 gr		5		5	
6 R/190	2,187 gr	6 L/220	2,170 gr		6		6	
7		7			7		7	
8		8			8		8	
X	2-165	MAX: X: 2-160			X	24.05		
CV %	1.038	CV: 1.60			CV %	1.00		
NE MAX	20.01	NE: 20.86			MAX			
MIN		R			MIN			

Mengetahui,
Sumartono
Kabag. QC

Lampiran 4. Hasil Pengujian Nomor Benang Sebelum Maintenance

PT INDO RAYA ENERGI *Sesudah.*

HASIL TEST NE & TPI
BENANG RING FRASME (COP)

TANGGAL: 13/04/2021
NO. MC: [blank]

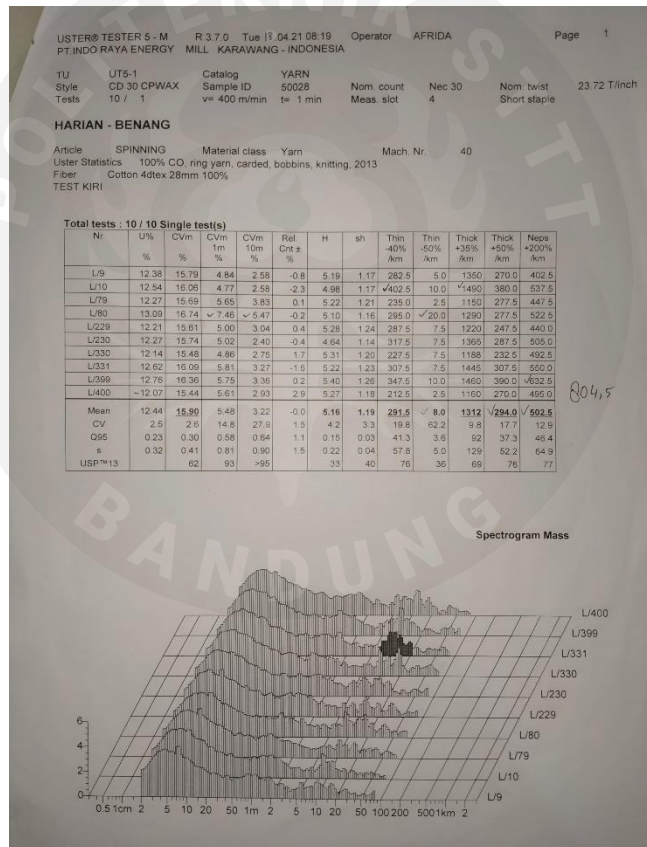
JENIS BENANG: CD 30 CPW
NO. SPDL: [blank]

Ganti Proses

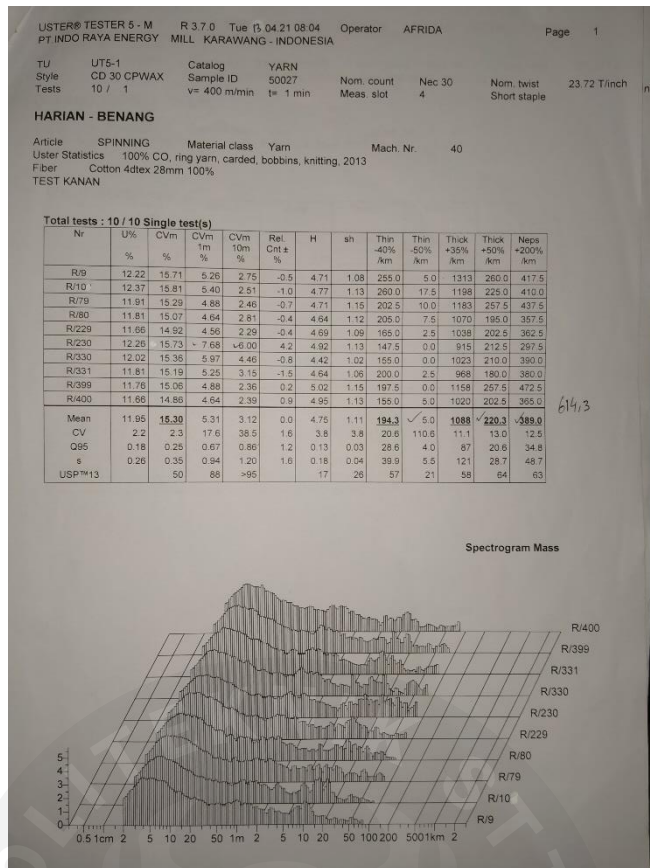
NO. TEST	NE (L)	NO. TEST	NE (R)	NO. MC	NO. TEST	TPI (L)	NO. TEST	TPI (R)
1	2-228	1	2-157		1	23-95	1	23-85
2	2-223	2	2-199		2	23-50	2	22-60
3	2-206	3	2-209		3		3	
4	2-260	4	2-242		4		4	
5	2-227	5	2-332		5		5	
6	2-222	6			6		6	
7		7			7		7	
8		8			8		8	
X	2-227	NE: 22-09			X	23-92		
CV%	2-07			40	CV%	2-19		
MAX					MAX			
MIN		R			MIN			

Merigetahui,
S. Martono
Kabag. QC

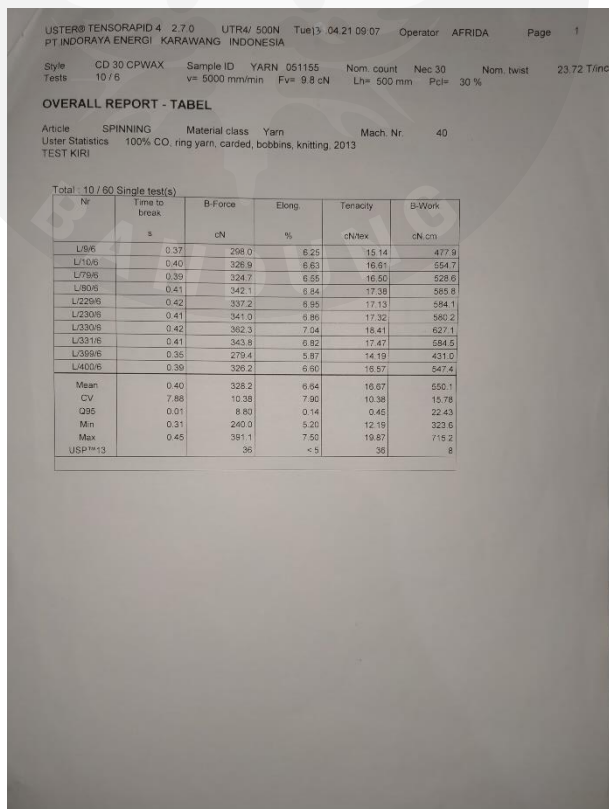
Lampiran 5. Hasil Pengujian Nomor Benang Setelah Maintenance



Lampiran 6. Hasil Pengujian Kerataan Benang Setelah Maintenance



Lampiran 7. Hasil Pengujian Kerataan Benang Setelah Maintenance (Lanjutan)



Lampiran 8. Hasil Pengujian Kekuatan Benang Setelah Maintenance

USTER® TENSORAPID 4 2.7.0 UTR4/ 500N Tue 13.04.21 09.04 Operator AFRIDA Page 1
PT.INDORAYA ENERGY KARAWANG INDONESIA

Style CD 30 CPWAX Sample ID YARN 051154 Nom. count Nec 30 Nom. twist 23.72 T/m
Tests 10 / 6 v= 5000 mm/min Fv= 9.8 cN Ln= 500 mm Pcl= 30 %

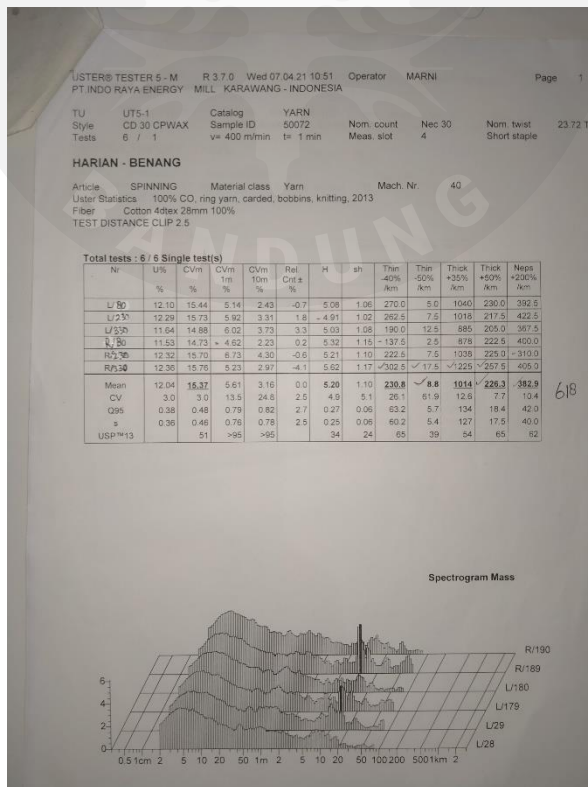
OVERALL REPORT - LABEL

Article SPINNING Material class Yarn Mach. Nr 40
Uster Statistics 100% CO, ring yarn, carded, bobbins, knitting, 2013
TEST KANAN

Total : 10 / 60 Single test(s)

Nr	Time to break s	B-Force cN	Elong %	Tenacity cN/tex	B-Work cN cm
R/9/6	0.38	328.3	6.99	15.66	543.9
R/10/6	0.38	314.8	6.40	15.96	508.5
R/7/6	0.38	314.7	6.27	15.99	511.6
R/8/6	0.38	342.8	6.49	17.42	558.6
R/23/6	0.41	358.1	6.82	18.09	614.5
R/230/6	0.42	383.4	6.98	18.46	626.8
R/330/6	0.39	320.3	6.60	16.27	530.5
R/331/6	0.42	377.1	7.06	16.16	661.8
R/36/6	0.42	348.5	6.95	17.70	596.5
R/40/6	0.41	345.3	6.79	17.94	581.5
Mean	0.40	341.1	6.69	17.33	573.5
CV	8.52	8.86	6.94	8.86	13.71
Q95	0.01	7.81	0.12	0.40	20.31
Min	0.33	274.9	5.51	13.67	404.7
Max	0.48	415.1	7.96	21.09	773.8
USP**13		27	<5	27	<5

Lampiran 9. Hasil Pengujian Kekuatan Benang Setelah Overhaul (Lanjutan)



Lampiran 10. Hasil Pengujian Kerataan Benang Setelah Penggantian Distance Clip

USTER® TENSORAPID 4 2.7.0 UTR4/ 500N Wed 07/04/21 08:41 Operator AFRIDA Page 1
PT.INDORAYA ENERGI KARAWANG - INDONESIA

Style CD 30 CPWAX Sample ID YARN 051189 Nom. count Nec 30 Nom. twist 23.72 T/mtr
Tests 6 / 6 v= 6000 mm/min Fv= 9.8 cN Utr 800 mm Pcte= 90 %

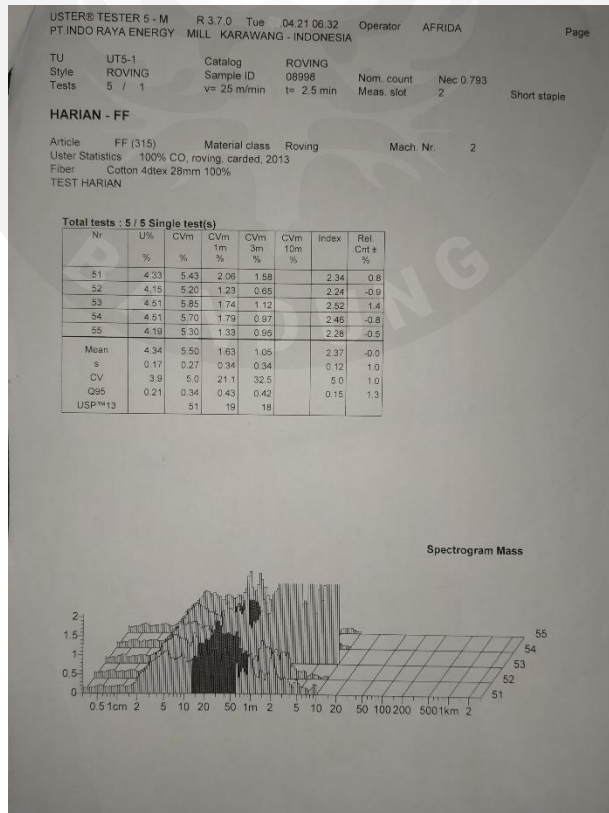
OVERALL REPORT - TABEL

Article SPINNING Material class Yarn Mach Nr 40
Uster Statistics 100% CO, ring yarn, carded, bobbins, knitting, 2013
TEST DISTANCE CLIP 2.5

Total : 6 / 36 Single test(s)

Nr	Time to break s	B-Force		Elong %	Tenacity		B-Work cN cm
		s	cN		cN/tex	cN cm	
L/206	0.37	317.0	6.12	16.19	518.7		
L/276	0.45	355.8	6.68	17.97	601.6		
L/306	0.37	322.5	6.14	16.26	513.2		
R/206	0.36	309.0	6.01	15.70	480.2		
R/276	0.38	311.7	6.03	15.84	498.1		
R/306	0.34	286.3	5.67	15.00	448.5		
Mean	0.37	318.2	6.11	16.17	508.1		
CV	8.71	9.53	8.74	9.53	15.65		
Q95	0.01	10.27	0.18	0.52	27.02		
Min	0.31	288.4	5.19	13.13	367.0		
Max	0.45	404.2	7.97	20.53	726.3		
USP™13		44	17	44	25		

Lampiran 11. Hasil Pengujian Kekuatan Benang Setelah Penggantian Distance Clip



Lampiran 12. Data Pengujian Kekuatan Roving