

LAMPIRAN

Lampiran 1 data *visual performance board* untuk *top three defect*

VISUAL PERFORMANCE BOARD												
TANGGAL : 21-05-2024				ARTIKEL : C.RIPS C089								
HARI KE : 2				PAPAN VISUAL SEWING								
TARGET	QUALITY			TARGET EFF	RFT	DHU						
●	■	■	■									
●	■	■	■									
●	■	■	■									
	TARGET / JAM	PRODUKSI SEWING	RFT	RAR (REWORK)	SCRAP (REMAKE)	% EFF	% RFT	DHU PCS	RANDOM INLINE S ROUND	3 TOP DEFECT		
JAM KE 1	45	45	40	5		88.8889	100			Jump stitch on waistban		
JAM KE 2	45	45	40	5		88.8889	100			Broken stitch on hem		
JAM KE 3	45	45	39	6		86.6667	100			Puckering on hemming		
JAM KE 4	45	45	43	2		95.5556	100					
JAM KE 5	Ishtht					#VALUE!	#VALUE!					
JAM KE 6	45	45	45	0		100	100					
JAM KE 7	45	45	41	4		91.1111	100					
JAM KE 8	45	45	40	5		88.8889	100					
JAM KE 9	45	45	40	5		88.8889	100					

Lampiran 2 Jarum yang digunakan untuk celana panjang style *CRIPS C089*



Lampiran 3 Contoh jadwal kontrol jarum patah/rusak

KONTROL JARUM PATAH / RUSAK													
Buyer : Style : Line :				Tgl	Jam	Jenis Mesin / No. Mesin	Proses	Operator	Size	Colour	Jarum Tumpul	Jarum Rusak	Note TTD Operator
1	2	3	4	5	6	7	8	9	10	11	12	13	14
				22/01/2024	09:32	Barbek	Aty	16	16	16			Aty
				22/01/2024	10:20	Barbek	Aty	16	16	16			C-196
				22/01/2024	10:40	Barbek	Aty	16	16	16			C-196
				22/01/2024	11:15	Barbek	Aty	16	16	16			C-196
				22/01/2024	11:55	Barbek	Aty	16	16	16			C-196
				22/01/2024	12:25	Barbek	Aty	16	16	16			C-196
				22/01/2024	13:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	13:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	14:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	14:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	15:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	15:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	16:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	16:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	17:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	17:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	18:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	18:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	19:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	19:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	20:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	20:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	21:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	21:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	22:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	22:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	23:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	23:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	00:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	00:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	01:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	01:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	02:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	02:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	03:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	03:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	04:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	04:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	05:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	05:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	06:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	06:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	07:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	07:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	08:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	08:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	09:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	09:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	10:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	10:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	11:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	11:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	12:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	12:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	13:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	13:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	14:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	14:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	15:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	15:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	16:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	16:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	17:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	17:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	18:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	18:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	19:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	19:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	20:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	20:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	21:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	21:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	22:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	22:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	23:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	23:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	00:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	00:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	01:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	01:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	02:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	02:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	03:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	03:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	04:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	04:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	05:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	05:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	06:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	06:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	07:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	07:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	08:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	08:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	09:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	09:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	10:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	10:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	11:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	11:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	12:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	12:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	13:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	13:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	14:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	14:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	15:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	15:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	16:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	16:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	17:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	17:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	18:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	18:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	19:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	19:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	20:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	20:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	21:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	21:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	22:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	22:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	23:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	23:30	Barbek	Aty	16	16	16			C-196
				22/01/2024	00:00	Barbek	Aty	16	16	16			C-196
				22/01/2024	00								

Lampiran 4 Contoh Jenis *defect* yang terjadi pada celana panjang *style* CRIPS C089



Lampiran 5 Jadwal Piket yang ditetapkan untuk menjaga kebersihan pada industri

JADWAL PIKET HARIAN TERAS DAN PICK UP SAMPAH					
SENIN	SELASA	RABU	KAMIS	JUMAT	SABTU
NAZAR DEDE	STEVEN	DANIEL	IJAB	ROBI	AGUNG

"Kebersihan adalah tanda kesopanan dan kepedulian kita terhadap orang lain."

Lampiran 6 Perubahan persentase *defect* setelah dilakukan perbaikan

Keterangan	$\bar{x}$ persentase <i>defect</i>
Sebelum implementasi	6,1%
Sesudah implementasi	3%