

LAMPIRAN

Lampiran 1 Lembar pengujian benang TR 30

FRM-DYG-21-01-08

TEST BENANG T/R
QUALITY CONTROL SYSTEM

DYEING / WDG - PGG

1. Jenis Benang
2. Nomor Lot
3. Kuantitas Lot

TR 30s

5. NO. LPS
6. Tgl Dig & Uji

8 MEI 2024

NO	grhl	Mulur mm	%	Kekuatan dan Mulur			
				NO	grhl	Mulur mm	%
1	470	52	10.40	39			0.00
2	420	49	9.80	40			0.00
3	420	50	10.00	41			0.00
4	500	56	11.20	42			0.00
5	420	48	9.60	43			0.00
6	480	55	11.00	44			0.00
7	450	53	10.60	45			0.00
8	490	53	10.60	46			0.00
9	480	54	10.80	47			0.00
10	490	53	10.60	48			0.00
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25							
26							
27							
28							
29							
30							
31							
32							
33							
34							
35							
36							
37							
38							
	X			459.00	52.30	1.39	X
	SD			30.35	2.58	3.58	SD
	CV %			6.61	4.94	258.99	CV %

STANDART:

JENIS BENANG	TR No30s VIT
KEKUATAN grhl	459.00
CV % (Kekuatan)	6.61
MULUR (%)	1.39
NO.BNG (No)	#DIV/0!
BLENDING T (%)	#DIV/0!
TPI	0.00
UJI SHRINKAGE (%)	-
Grading Spun yarns for Appearance	-

SNI 06-1799-2004

Keterangan : Layak / Dipertimbangkan / Tidak Layak

Pandaan: 8 MEI 2024
Di Laporkan Di Periksa Disetujui Mengetahui

2
5 24

Lampiran 2 Pengujian kekerasan gulungan benang (*hardness*)



Lampiran 3 Data efisiensi serta stop pakan mesin 56 dan 110

Date	Shift No.	Loom No.	Efficiency of mill (%)	Efficiency of loom (%)	Total stop (menit)	Total stop (times)	Total stop (s/h)	Filling stop (minutes)	Filling stop (times)
2024/05/14	2	110	90.5	90.5				12.3	18
2024/05/14	3	110	69.2	69.2				3.3	9
2024/05/15	3	056	95.3	95.3				20.1	35
2024/05/15	1	110	88.9	88.9				11.5	13
2024/05/15	2	110	87.5	87.5				3.5	9
2024/05/15	3	110	85.9	85.9				10.6	10
2024/05/16	1	056	95.3	95.3				15.2	29
2024/05/16	2	056	97.5	97.5				6.8	14
2024/05/16	3	056	95.4	95.4				6.8	14
2024/05/16	1	110	93.5	93.5				8.6	11
2024/05/17	1	056	96.0	96.0				10.2	19
2024/05/17	2	056	95.7	95.7				12.6	20
2024/05/18	1	056	93.7	93.7				10.1	16
2024/05/18	2	056	97.1	97.1				8.5	14
2024/05/18	3	056	95.6	95.6				7.4	14
2024/05/18	1	110	91.4	91.4				14.3	42
2024/05/18	2	110	96.3	96.4				16.2	54
2024/05/18	3	110	91.6	91.6				33.8	95
2024/05/19	1	056	90.6	90.6				1.1	4
2024/05/19	2	056	92.8	92.8				11.1	15
2024/05/19	3	056	98.0	98.0				6.4	16
2024/05/19	1	110	87.7	87.7				47.6	50
2024/05/19	2	110	91.1	91.1				31.7	56

Lampiran 3 Data efisiensi serta stop pakan mesin 56 dan 110 (lanjutan)

2024/05/19	3	110	89.5	89.5				33.9	77
2024/05/21	1	056	96.2	97.2				6.6	7
2024/05/21	2	056	97.7	97.7				3.6	10
2024/05/21	3	056	98.8	98.8				1.6	4
2024/05/21	1	110	94.5	96.1				8.8	19
2024/05/21	2	110	96.5	96.5				8.7	23
2024/05/21	3	110	94.8	94.8				15.7	37
2024/05/22	1	056	59.8	59.8				8.0	15
2024/05/22	2	056	96.0	96.0				12.9	40
2024/05/22	3	056	92.3	92.3				12.5	26
2024/05/22	1	110	96.3	96.3				11.0	28
2024/05/22	2	110	96.2	96.2				12.4	20
2024/05/22	3	110	95.8	95.8				11.3	29

Lampiran 4 *Timing sub-nozzle*

ON	OFF		ON	OFF
44°	180°	10:	150°	290°
52°	190°	11:	60°	290°
66°	200°	12:	0°	0°
82°	208°	13:	0°	0°
98°	220°	14:	0°	0°
112°	234°	15:	0°	0°
126°	246°			
140°	260°			
154°	282°			

Lampiran 5 Jarak antar *sub-nozzle* pertama hingga terakhir

Variasi	Jarak <i>sub-nozzle</i> ke- (cm)									
	0--1	1--2	2--3	3--4	4--5	5--6	6--7	7--8	8--9	9--10
(A) 6.5 cm	3	8	8	8	6.5	6.5	6.5	6.5	6.5	6.5
(B) 7 cm	3	8	8	8	7	7	7	7	7	7
(C) 7.5 cm	3	8	8	8	6.5	6.5	7	7.5	7.5	7.5

Variasi	Jarak <i>sub-nozzle</i> ke- (cm)									
	10--11	11--12	12--13	13--14	14--15	15--16	16-17	17-18	18-19	19--20
(A) 6.5 cm	6.5	6.5	7	7	7	7	8	8	8	8
(B) 7 cm	7	7	8	8	8	8	8	8	8	
(C) 7.5 cm	7.5	7.5	7.5	7.5	7.5	8	8	8	8	

Lampiran 6 *Weft insertion* dan *arrival time* (32 picks sample) mesin 110

[32 picks earliest/latest/average]				
C1	Earliest	Latest	Average	Dif.
Fil. ins. timing	90	90	90	42
Release pulse 1	130	134	132	46
Release pulse 2	176	180	178	42
Release pulse 3	218	222	220	
Arrival timing	224	242	227	

Lampiran 7 *Weft insertion* dan *arrival time* (32 picks sample) mesin 56

	Earliest	Latest	Average	Dif.
ng	90	90	90	60
e 1	148	152	150	42
e 2	190	196	192	45
e 3	232	242	237	
ng	234	248	240	

Lampiran 8 *Weft insertion* dan *arrival time* (jarak 6,5 cm mesin 56)

[earliest/latest/average]				
	Earliest	Latest	Average	Dif.
	90	90	90	47
	130	136	132	48
	176	182	180	45
	222	230	225	
	224	232	228	

Lampiran 9 *Weft insertion* dan *arrival time* (jarak 7 cm mesin 56)

[2 picks earliest/latest/average]				
C2	Earliest	Latest	Average	Dif.
l. in timing	90	90	90	36
lease pulse 1	124	128	126	49
lease pulse 2	172	178	175	49
lease pulse 3	220	230	224	
rrival timing	224	244	229	

Lampiran 10 *Weft insertion* dan *arrival time* (jarak 7,5 cm mesin 56)

[earliest/latest/average]				
	Earliest	Latest	Average	Dif.
ng	90	90	90	44
se 1	130	138	134	47
se 2	176	184	181	46
se 3	220	230	227	
ing	224	234	229	

Lampiran 11 *Weft insertion* dan *arrival time* (jarak 6,5 cm mesin 110)

[rliest/latest/average]				
	Earliest	Latest	Average	Dif.
ng	90	90	90	37
e 1	124	130	127	48
e 2	172	180	175	46
e 3	218	226	221	
ng	222	234	226	

Lampiran 12 *Weft insertion* dan *arrival time* (jarak 7 cm mesin 110)

[rliest/latest/average]				
	Earliest	Latest	Average	Dif.
ng	90	90	90	37
e 1	124	130	127	50
e 2	172	182	177	49
e 3	222	232	226	
ing	224	240	230	

Lampiran 13 *Weft insertion* dan *arrival time* (jarak 7,5 cm mesin 110)

[rliest/latest/average]				
	Earliest	Latest	Average	Dif.
ng	90	90	90	38
se 1	126	132	128	50
se 2	176	182	178	48
se 3	222	230	226	
ing	224	236	230	

Lampiran 14 Pengukuran tekanan udara *sub-nozzle* dengan *manometer*



Lampiran 15 Pengukuran tekanan udara *sub-nozzle* dengan *manometer* (2)



Lampiran 16 Data cacat *short pick* sebelum dan sesudah (mesin 56 dan 110)

RANGE,C,35	LOKASI,C,10	TIPE_MSN,C,10	CODE_PROD,C,10	DE_MSN,C,10	KWALA,N,16,2	KWALB,N,16,2	KWALC,N,16,2	KWALTOT,N,16,2	Short Pick
Tanggal : 12-05-2024	AJL	TSUDAKOMA		0056					4
Tanggal : 12-05-2024	AJL	TSUDAKOMA		0110					3
Tanggal : 13-05-2024	AJL	TSUDAKOMA		0056					1
Tanggal : 13-05-2024	AJL	TSUDAKOMA		0110					3
Tanggal : 14-05-2024	AJL	TSUDAKOMA		0056					3
Tanggal : 14-05-2024	AJL	TSUDAKOMA		0110					1
Tanggal : 15-05-2024	AJL	TSUDAKOMA		0056					0
Tanggal : 15-05-2024	AJL	TSUDAKOMA		0056					2
Tanggal : 15-05-2024	AJL	TSUDAKOMA		0110					0
Tanggal : 16-05-2024	AJL	TSUDAKOMA		0056					0
Tanggal : 16-05-2024	AJL	TSUDAKOMA		0110					1
Tanggal : 17-05-2024	AJL	TSUDAKOMA		0056					0
Tanggal : 17-05-2024	AJL	TSUDAKOMA		0110					2
Tanggal : 18-05-2024	AJL	TSUDAKOMA		0056					0
Tanggal : 18-05-2024	AJL	TSUDAKOMA		0110					2
Tanggal : 19-05-2024	AJL	TSUDAKOMA		0056					1
Tanggal : 19-05-2024	AJL	TSUDAKOMA		0110					3
Tanggal : 21-05-2024	AJL	TSUDAKOMA		0056					1
Tanggal : 21-05-2024	AJL	TSUDAKOMA		0110					1
Tanggal : 22-05-2024	AJL	TSUDAKOMA		0056					0
Tanggal : 22-05-2024	AJL	TSUDAKOMA		0056					0
Tanggal : 22-05-2024	AJL	TSUDAKOMA		0110					1

Lampiran 17 Form. cek mesin *air jet loom*

FORM CEK MESIN																					
Tanggal	Kode Produksi	Nomor Mesin	Filling Insertion											Air Pressure				Let-Off		Shedding	Keterangan
			Accumulator	FDP Pin	WBS	Main Nozzle	Sub Nozzle	Cutter LH	Ring Tample	Tucker Box	Feeler H1	Feeler H2	Leno	MP1/MP2 /MP3/MP 4	SUB	CP1/CP2	JP1/JP2	Let-Off	Kick Back		
14/05/2024		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
15/05/2024		58	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
15/05/2024		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
18/05/2024		58	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
18/05/2024		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
21/05/2024		58	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
21/05/2024		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
22/05/2024		58	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
22/05/2025		58	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
22/05/2026		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
22/05/2027		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	
22/05/2028		110	✓	✓	✓	✓		✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	