

LAMPIRAN

1. Data Perminta Produksi Bulan Oktober

| NO. | TANGGAL CONFIRM | SN | NO. WO | ORDER METER | KONTRUKSI | | | | | | WARPI NG METER | KEBUTU HAN BENANG LUSI BALE | KEBUTU HAN BENANG PAKAN BALE | TOTAL KEBUTUHA N BENANG BALE |
|-----|--------------------|-----------|-----------|----------------|-----------|------|------------|-------|-----------------|----------------------|----------------------|---|--|---------------------------------------|
| | | | | | SISIR | PICK | Lebar K | Helai | GRAMASI LUSI | GRAM ASI PAKAN | | | | |
| 1 | 01/03/2024 | R 189 | 112 | 92.050 | 67 | 48 | 125 | 3.540 | 58 | 39 | 94.812 | 30 | 20 | 50 |
| 2 | 03/03/2024 | T888 | 113 | 75.100 | 79 | 52 | 160 | 5.280 | 87 | 54 | 77.353 | 37 | 22 | 59 |
| 3 | 05/03/2024 | T32 | 114 | 110.400 | 65/ 3 | 54 | 160 | 6.426 | 105 | 56 | 113.712 | 66 | 34 | 100 |
| 4 | 05/03/2024 | R268 | 115 | 55.650 | 67 | 50 | 157 | 4.512 | 74 | 51 | 57.320 | 23 | 16 | 39 |
| 5 | 06/03/2024 | T 32 | 116 | 52.000 | 65/ 3 | 54 | 160 | 6.426 | 105 | 56 | 53.560 | 31 | 16 | 47 |
| 6 | 06/03/2024 | T 888 | 117 | 45.050 | 79 | 52 | 160 | 5.280 | 87 | 54 | 46.402 | 22 | 13 | 35 |
| 7 | 10/03/2024 | R 20 A | 118 | 35.100 | 75 | 56 | 157 | 4.512 | 74 | 57 | 36.153 | 15 | 11 | 26 |
| 8 | 10/03/2024 | R 20 | 119 | 35.000 | 75 | 50 | 158 | 5.000 | 82 | 51 | 36.050 | 16 | 10 | 26 |
| 9 | 10/03/2024 | R 11 | 120 | 60.000 | 79 | 60 | 127 | 4.594 | 75 | 49 | 61.800 | 26 | 16 | 42 |
| 10 | 11/03/2024 | T 28 | 121 | 40.250 | 70 | 58 | 160 | 6.800 | 112 | 60 | 41.458 | 25 | 13 | 39 |
| 11 | 12/10/2024 | Rp60 | 122 | 50.050 | 75 | 50 | 127 | 8.364 | 137 | 41 | 51.552 | 39 | 11 | 50 |
| 12 | 12/03/2024 | Rp15 3 | 123 | 35.000 | 75 | 50 | 126 | 8.092 | 133 | 41 | 36.050 | 26 | 8 | 34 |

2. Data Permintaan Produksi Bulan Maret

| NO | TANGGAL CONFIRM | SN | NO. WO | ORDER METER | KONTRUKSI | | | | | | WARPI NG METER | KEBUTUH AN BENANG LUSI BALE | KEBUTU HAN BENANG PAKAN BALE | TOTAL KEBUT UHAN BENAN G BALE |
|----|-----------------|--------|--------|-------------|-----------|-------|----------|-------|---------------|----------------|----------------|-----------------------------|------------------------------|-------------------------------|
| | | | | | SISI R | PIC K | Leba r K | Helai | GRAM ASI LUSI | GRAM ASI PAKAN | | | | |
| 1 | 10/10/24 | R 30 | 1214 | 103.120 | 75 | 50 | 158 | 5.000 | 82 | 51 | 106.214 | 48 | 29 | 77 |
| 2 | 12/10/24 | T 32 | 1215 | 83.090 | 70 | 58 | 160 | 6.426 | 105 | 60 | 85.583 | 50 | 27 | 77 |
| 3 | 13/10/24 | T888 | 1216 | 125.050 | 79 | 52 | 160 | 5.280 | 87 | 54 | 128.802 | 61 | 37 | 99 |
| 4 | 15/10/24 | Rp60 | 1217 | 53.100 | 79 | 50 | 127 | 8.364 | 137 | 41 | 54.693 | 41 | 12 | 53 |
| 5 | 15/10/24 | T 32 | 1218 | 52.000 | 65/ 3 | 54 | 160 | 6.426 | 105 | 56 | 53.560 | 31 | 16 | 47 |
| 6 | 15/10/24 | T 888 | 1219 | 40.800 | 79 | 52 | 125 | 5.280 | 87 | 42 | 42.024 | 20 | 9 | 30 |
| 7 | 16/10/24 | R 238 | 1220 | 34.900 | 65 | 64 | 160 | 5.200 | 85 | 66 | 35.947 | 17 | 13 | 30 |
| 8 | 16/10/24 | R 20 | 1221 | 35.900 | 75 | 50 | 158 | 5.000 | 82 | 51 | 36.977 | 17 | 10 | 27 |
| 9 | 19/10/24 | T 888 | 1222 | 54.000 | 75 | 50 | 158 | 5.280 | 87 | 51 | 55.620 | 27 | 15 | 42 |
| 10 | 20/10/24 | T 28 | 1223 | 35.900 | 70 | 58 | 160 | 6.800 | 112 | 60 | 36.977 | 23 | 12 | 35 |
| 11 | 20/10/24 | RP 153 | 1224 | 41.550 | 75 | 50 | 126 | 8.092 | 133 | 41 | 42.797 | 31 | 9 | 41 |
| 12 | 20/10/24 | RP 60 | 1225 | 35.000 | 75 | 50 | 127 | 8.364 | 137 | 41 | 36.050 | 27 | 8 | 35 |

3. Jadwal Produksi Warping

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | | | |
|---------------|---------------|-----------|-------|---------|----------|---------|----------|-----------|--------|---------|----------|---------|----------|-----------|------|---------|----------|---------|----------|---------|----------|--------|---|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | | |
| 12-Oct | 07.00 - 09.00 | 1214 | R 30 | 500 | 60.000 | 20.000 | 3 | 1215 | T 32 | 500 | 60.000 | 15.000 | 4 | | | | | | | 120.000 | 7 | | |
| | 09.00 - 11.00 | 1214 | R 30 | 500 | 60.000 | 20.000 | 3 | 1215 | T 32 | 500 | 60.000 | 15.000 | 4 | | | | | | | 120.000 | 7 | | |
| | 11.00 - 13.00 | 1214 | R 30 | 500 | 40.000 | 20.000 | 2 | 1215 | T 32 | 500 | 30.000 | 15.000 | 2 | | | | | | | 70.000 | 4 | | |
| | 13.00 - 15.00 | DOFFING 0 | | | | | | DOFFING 0 | | | | | | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | | | 36.000 | 2 |
| | Total Shift 1 | | | 500 | 160.000 | 160.000 | 8 | | | 500 | 150.000 | 150.000 | 10 | | | 300 | 36.000 | 36.000 | 2 | 346.000 | 20 | | |
| | 15.00 - 17.00 | 1215 | T 32 | 500 | 60.000 | 15.000 | 4 | | | | | | | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 96.000 | 6 | | |
| | 17.00 - 19.00 | 1215 | T 32 | 500 | 60.000 | 15.000 | 4 | | | | | | | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 96.000 | 6 | | |
| | 19.00 - 21.00 | 1215 | T 32 | 500 | 30.000 | 15.000 | 2 | | | | | | | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 66.000 | 4 | | |
| | 21.00 - 23.00 | DOFFING 0 | | | | | | 1214 | R R 30 | 500 | 60.000 | 20.000 | 3 | DOFFING 0 | | | | | | 60.000 | 3 | | |
| | Total Shift 2 | | | 500 | 150.000 | 150.000 | 10 | | | 500 | 60.000 | 60.000 | 3 | | | 300 | 108.000 | 108.000 | 6 | 318.000 | 19 | | |
| | 23.00 - 01.00 | 1216 | T 888 | 500 | 60.000 | 18.000 | 3 | 1214 | R 30 | 500 | 60.000 | 20.000 | 3 | | | | | | | 114.000 | 6 | | |
| | 01.00 - 03.00 | 1216 | T 888 | 500 | 60.000 | 18.000 | 3 | 1214 | R 30 | 500 | 40.000 | 20.000 | 2 | | | | | | | 94.000 | 5 | | |
| | 03.00 - 05.00 | 1216 | T 888 | 500 | 60.000 | 18.000 | 3 | DOFFING 0 | | | | | | | | | | | | 54.000 | 3 | | |
| | 05.00 - 07.00 | 1216 | T 888 | 500 | 20.000 | 18.000 | 1 | | | | | | | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 54.000 | 3 | | |
| Total Shift 3 | | | 500 | 200.000 | 180.000 | 10 | 1214 | R 30 | 500 | 100.000 | 100.000 | 5 | | | 300 | 36.000 | 36.000 | 2 | 316.000 | 17 | | | |
| TOTAL | | | | 510.000 | 490.000 | 28 | | | | 310.000 | 310.000 | 18 | | | | 180.000 | 180.000 | 10 | 980.000 | 56 | | | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | |
|---------------|---------------|---------------------|------|---------|----------|---------|----------|-----------|-------|---------|----------|---------|----------|-----------|-------|---------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 13-Oct | 07.00 - 09.00 | DOFF | | | | | | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | 09.00 - 11.00 | | | | | | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 | |
| | 11.00 - 13.00 | | | | | | 1216 | T 888 | 350 | 21.000 | 21.000 | 1 | 1214 | R 30 | 300 | 36.000 | 18.000 | 2 | 57.000 | 3 | |
| | 13.00 - 15.00 | NYISIR | | | | | | DOFF 0 | | | | | | | | | | | 0 | 0 | |
| | Total Shift 1 | | | | #REF! | 0 | | | | 105.000 | 105.000 | 5 | | | | 108.000 | 108.000 | 6 | 213.000 | 11 | |
| | 15.00 - 17.00 | 1214 | R 30 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1215 | T 32 | 300 | 36.000 | 18.000 | 2 | 120.000 | 6 |
| | 17.00 - 19.00 | 1214 | R 30 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1215 | T 32 | 300 | 36.000 | 18.000 | 2 | 120.000 | 6 |
| | 19.00 - 21.00 | 1214 | R 30 | 350 | 21.000 | 21.000 | 1 | 1216 | T 888 | 350 | 21.000 | 21.000 | 1 | 1215 | T 32 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | 21.00 - 23.00 | NYISIR | | | | | | DOFF 0 | | | | | | NYISIR | | | | | | 0 | 0 |
| | Total Shift 2 | | | | 105.000 | 105.000 | 5 | | | | 105.000 | 105.000 | 5 | | | | 108.000 | 108.000 | 6 | 318.000 | 16 |
| | 23.00 - 01.00 | 1214 | R 30 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1215 | T 32 | 300 | 36.000 | 18.000 | 2 | 120.000 | 6 |
| | 01.00 - 03.00 | 1214 | R 30 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1215 | T 32 | 300 | 36.000 | 18.000 | 2 | 120.000 | 6 |
| | 03.00 - 05.00 | 1214 | R 30 | 350 | 21.000 | 21.000 | 1 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | DOFF 0 | | | | | | 63.000 | 3 |
| | 05.00 - 07.00 | DOFF / PERS. T888 0 | | | | | | NYISIR | | | | | | 1216 | T 888 | 300 | 36.000 | 18.000 | 2 | 36.000 | 2 |
| Total Shift 3 | | | | 105.000 | 105.000 | 5 | 1214 | R 20 | 500 | 126.000 | 126.000 | 6 | | | | 108.000 | 108.000 | 6 | 339.000 | 17 | |
| TOTAL | | | | 210.000 | 210.000 | 10 | | | | 336.000 | 336.000 | 16 | | | | 324.000 | 324.000 | 18 | 870.000 | 44 | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | |
|---------------|---------------|-------------------|-------|---------|----------|---------|----------|--------------------------|-------|---------|----------|---------|----------|-----------|-------|---------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 14-Oct | 07.00 - 09.00 | DOFF / PERS. T888 | | | | | | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | 09.00 - 11.00 | | | | | | | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | 11.00 - 13.00 | | | | | | | DOFF 0 | | | | | | NYISIR | | | | | | 0 | 0 |
| | 13.00 - 15.00 | | | | | | | 1215 | T32 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | Total Shift 1 | | | | | 0 | | | | | 126.000 | 126.000 | 6 | | | | 108.000 | 108.000 | 6 | 234.000 | 12 |
| | 15.00 - 17.00 | | | | | | | 1215 | T32 | 350 | 42.000 | 21.000 | 2 | 1216 | T 888 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | 17.00 - 19.00 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1215 | T32 | 350 | 21.000 | 21.000 | 1 | DOFF 0 | | | | | | 63.000 | 3 |
| | 19.00 - 21.00 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | NYISIR | | | | | | | | | | | | 42.000 | 2 |
| | 21.00 - 23.00 | 1216 | T 888 | 350 | 21.000 | 21.000 | 1 | 1215 | T32 | 350 | 42.000 | 21.000 | 2 | | | | | | | 63.000 | 3 |
| | Total Shift 2 | | | | 105.000 | 105.000 | 5 | | | | 105.000 | 105.000 | 5 | | | | 36.000 | 36.000 | 2 | 246.000 | 12 |
| | 23.00 - 01.00 | NYISIR | | | | | | 1215 | T32 | 350 | 42.000 | 21.000 | 2 | | | | | | | 42.000 | 2 |
| | 01.00 - 03.00 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | 1215 | T32 | 350 | 21.000 | 21.000 | 1 | | | | | | | 63.000 | 3 |
| | 03.00 - 05.00 | 1216 | T 888 | 350 | 42.000 | 21.000 | 2 | DOFF / PERSIAPAN T 888 0 | | | | | | 1214 | R 30 | 300 | 36.000 | 9.200 | 3 | 69.600 | 5 |
| | 05.00 - 07.00 | 1216 | T 888 | 350 | 21.000 | 21.000 | 1 | | | | | | | 1214 | R 30 | 300 | 36.000 | 9.200 | 3 | 48.600 | 4 |
| Total Shift 3 | | | | 105.000 | 105.000 | 5 | | | | 63.000 | 63.000 | 3 | | | | 72.000 | 55.200 | 6 | 223.200 | 14 | |
| TOTAL | | | | 210.000 | 210.000 | 10 | | | | 294.000 | 294.000 | 14 | | | | 216.000 | 199.200 | 14 | 703.200 | 38 | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | |
|---------------|---------------|-------------------------|-----|---------|----------|---------|----------|-----------|-------|---------|----------|---------|----------|------------------|-------|---------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 15-Oct | 07.00 - 09.00 | DOFF / PERSIAPAN T 28 0 | | | | | | 1216 | T 888 | 350 | 42.000 | 19.800 | 2 | 1214 | R 30 | 300 | 24.000 | 9.200 | 2 | 58.000 | 4 |
| | 09.00 - 11.00 | | | | | | | 1216 | T 888 | 350 | 42.000 | 19.800 | 2 | PERSIAPAN T888 0 | | | | | | 39.600 | 2 |
| | 11.00 - 13.00 | 1215 | T32 | 300 | 36.000 | 16.500 | 2 | 1216 | T 888 | 350 | 42.000 | 19.800 | 2 | | | | | | | 72.600 | 4 |
| | 13.00 - 15.00 | 1215 | T32 | 300 | 36.000 | 16.500 | 2 | NYISIR | | | | | | | | | | | | 33.000 | 2 |
| | Total Shift 1 | | | | 72.000 | 66.000 | 4 | | | | 126.000 | 118.800 | 6 | | | | 24.000 | 18.400 | 2 | 203.200 | 12 |
| | 15.00 - 17.00 | 1215 | T32 | 300 | 21.000 | 21.000 | 1 | 1216 | T 888 | 350 | 42.000 | 19.800 | 2 | | | | | | | 60.600 | 3 |
| | 17.00 - 19.00 | NYISIR | | | | | | 1216 | T 888 | 350 | 42.000 | 19.800 | 2 | | | | | | | 39.600 | 2 |
| | 19.00 - 21.00 | 1215 | T32 | 300 | 36.000 | 16.500 | 2 | STOP 0 | | | | | | 1216 | T 888 | 300 | 30.000 | 10.000 | 3 | 63.000 | 5 |
| | 21.00 - 23.00 | 1215 | T32 | 300 | 36.000 | 16.500 | 2 | | | | | | | 1216 | T 888 | 300 | 30.000 | 10.000 | 3 | 63.000 | 5 |
| | Total Shift 2 | | | | 93.000 | 87.000 | 5 | | | | 84.000 | 79.200 | 4 | | | | 60.000 | 60.000 | 6 | 226.200 | 15 |
| | 23.00 - 01.00 | 1215 | T32 | 300 | 21.000 | 16.500 | 1 | | | | | | | 1216 | T 888 | 300 | 30.000 | 10.000 | 3 | 46.500 | 4 |
| | 01.00 - 03.00 | STOP 0 | | | | | | | | | | | | 1216 | T 888 | 300 | 10.000 | 10.000 | 1 | 10.000 | 1 |
| | 03.00 - 05.00 | | | | | | | | | | | | | STOP | | | | | | 0 | 0 |
| | 05.00 - 07.00 | | | | | | | | | | | | | | | | | | | 0 | 0 |
| Total Shift 3 | | | | 21.000 | 16.500 | 1 | | | | 0 | 0 | | | | | 40.000 | 40.000 | 4 | 56.500 | 5 | |
| TOTAL | | | | 186.000 | 169.500 | 10 | | | | 210.000 | 198.000 | 10 | | | | 124.000 | 118.400 | 12 | 485.900 | 32 | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | | |
|--------|---------------|------------|-------|---------|----------|---------|----------|------------|------|---------|----------|---------|----------|-----------|------|---------|----------|---------|----------|---------|----------|---|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | |
| 18-Oct | 07.00 - 09.00 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | | | | | | | 84.000 | 4 | |
| | 09.00 - 11.00 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | | | | | | | 84.000 | 4 | |
| | 11.00 - 13.00 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | | | | | | | 84.000 | 4 | |
| | 13.00 - 15.00 | NYISIR | | | | | | NYISIR | | | | | | | | | | | | | 0 | 0 |
| | Total Shift 1 | | | | 126.000 | 126.000 | 6 | | | | 126.000 | 126.000 | 6 | | | | 0 | 0 | 0 | 252.000 | 12 | |
| | 15.00 - 17.00 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | | | | | | | 84.000 | 4 | |
| | 17.00 - 19.00 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | | | | | | | 84.000 | 4 | |
| | 19.00 - 21.00 | DOFF T 888 | | | | | | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 | |
| | 21.00 - 23.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | DOFF RP 60 | | | | | | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 | |
| | Total Shift 2 | | | | 126.000 | 126.000 | 6 | | | | 126.000 | 126.000 | 6 | | | | 72.000 | 72.000 | 4 | 324.000 | 16 | |
| | 23.00 - 01.00 | NYISIR | | | | | | | | | | | | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 36.000 | 2 | |
| | 01.00 - 03.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | | | | | | | 1220 | R238 | 300 | 36.000 | 18.000 | 1 | 60.000 | 3 | |
| | 03.00 - 05.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | | | | | | | NYISIR | | | | | | 42.000 | 2 | |
| | 05.00 - 07.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | | | | | | | 1220 | R238 | 300 | 36.000 | 18.000 | 1 | 60.000 | 3 | |
| | Total Shift 3 | | | | 126.000 | 126.000 | 6 | | | | 0 | 0 | | | | | 108.000 | 72.000 | 4 | 198.000 | 10 | |
| TOTAL | | | | 378.000 | 378.000 | 18 | | | | 252.000 | 252.000 | 12 | | | | 180.000 | 144.000 | 8 | 774.000 | 38 | | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | |
|--------|---------------|-----------|-------|---------|----------|---------|----------|-----------|------|---------|----------|---------|----------|------------|------|---------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 19-Oct | 07.00 - 09.00 | NYISIR | | | | | | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | DOFF R 20 | | | | | | 42.000 | 2 |
| | 09.00 - 11.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | 1221 | R 20 | 300 | 36.000 | 18.500 | 2 | 121.000 | 6 |
| | 11.00 - 13.00 | DOFF T888 | | | | | | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | 1221 | R 20 | 300 | 36.000 | 18.500 | 2 | 79.000 | 4 |
| | 13.00 - 15.00 | NYISIR | | | | | | | | | | | | 1221 | R 20 | 300 | 36.000 | 18.500 | 1 | 18.500 | 1 |
| | Total Shift 1 | | | | 42.000 | 42.000 | 2 | | | | 126.000 | 126.000 | 6 | | | | 108.000 | 92.500 | 5 | 260.500 | 13 |
| | 15.00 - 17.00 | NYISIR | | | | | | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | NYISIR | | | | | | 42.000 | 2 |
| | 17.00 - 19.00 | NYISIR | | | | | | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | 1221 | R 20 | 300 | 36.000 | 18.500 | 2 | 79.000 | 4 |
| | 19.00 - 21.00 | NYISIR | | | | | | 1217 | Rp60 | 350 | 42.000 | 21.000 | 2 | 1221 | R 20 | 300 | 36.000 | 18.500 | 1 | 60.500 | 3 |
| | 21.00 - 23.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | DOFF | | | | | | DOFF R 238 | | | | | | 42.000 | 2 |
| | Total Shift 2 | | | | 42.000 | 42.000 | 2 | | | | 126.000 | 126.000 | 6 | | | | 36.000 | 55.500 | 3 | 223.500 | 11 |
| | 23.00 - 01.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 120.000 | 6 |
| | 01.00 - 03.00 | NYISIR | | | | | | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | 03.00 - 05.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | NYISIR | | | | | | 84.000 | 4 |
| | 05.00 - 07.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | NYISIR | | | | | | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 78.000 | 4 |
| | Total Shift 3 | | | | 126.000 | 126.000 | 6 | | | | 126.000 | 126.000 | 6 | | | | 108.000 | 108.000 | 6 | 360.000 | 18 |
| TOTAL | | | | 210.000 | 210.000 | 10 | | | | 378.000 | 378.000 | 18 | | | | 252.000 | 256.000 | 14 | 844.000 | 42 | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | | | | | | | | | |
|---------------|---------------|-----------|-------|-------|----------|---------|----------|------------|------|-------|----------|---------|----------|-----------|------|-------|----------|---------|----------|---------|----------|---------|---------|--------|---------|---------|----|---------|----|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | | | | | | | | |
| 20-Oct | 07.00 - 09.00 | 1219 | T 888 | 350 | 42.000 | 21.000 | 2 | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | 1220 | R238 | 300 | 36.000 | 18.000 | 2 | 120.000 | 6 | | | | | | | | |
| | 09.00 - 11.00 | DOFF T32 | | | | | | 1218 | T 32 | 350 | 42.000 | 21.000 | 2 | DOFF R 20 | | | | | | 42.000 | 2 | | | | | | | | |
| | 11.00 - 13.00 | | | | | | | DOFF RP 60 | | | | | | 1221 | R 20 | 300 | 36.000 | 18.500 | 2 | 37.000 | 2 | | | | | | | | |
| | 13.00 - 15.00 | | | | | | | 1217 | Rp60 | 350 | 42.000 | 12.700 | 3 | 1221 | R 20 | 300 | 36.000 | 18.500 | 1 | 56.600 | 4 | | | | | | | | |
| | Total Shift 1 | | | | | | | | | | | | | | | | | | | 126.000 | 122.100 | 7 | 108.000 | 91.500 | 5 | 255.600 | 14 | | |
| | 15.00 - 17.00 | | | | | | | 1217 | Rp60 | 350 | 42.000 | 12.700 | 3 | NYISIR | | | | | | 38.100 | 3 | | | | | | | | |
| | 17.00 - 19.00 | | | | | | | 1217 | Rp60 | 350 | 42.000 | 12.700 | 3 | 1221 | R 20 | 300 | 36.000 | 18.500 | 2 | 75.100 | 5 | | | | | | | | |
| | 19.00 - 21.00 | | | | | | | 1217 | Rp60 | 350 | 42.000 | 12.700 | 1 | 1221 | R 20 | 300 | 36.000 | 18.500 | 2 | 49.700 | 3 | | | | | | | | |
| | 21.00 - 23.00 | | | | | | | NYISIR | | | | | | 1221 | R 20 | 300 | 36.000 | 18.500 | 1 | 18.500 | 1 | | | | | | | | |
| | Total Shift 2 | | | | | | | | | | | | | | | | | | | 84.000 | 88.900 | 7 | 108.000 | 92.500 | 5 | 181.400 | 12 | | |
| | 23.00 - 01.00 | 1218 | T 32 | 350 | 42.000 | 11.600 | 3 | 1217 | Rp60 | 350 | 42.000 | 12.700 | 2 | STOP | | | | | | 60.200 | 5 | | | | | | | | |
| | 01.00 - 03.00 | 1218 | T 32 | 350 | 42.000 | 11.600 | 3 | STOP | | | | | | | | | | | | 34.800 | 3 | | | | | | | | |
| | 03.00 - 05.00 | 1218 | T 32 | 350 | 42.000 | 11.600 | 3 | | | | | | | | | | | | | 34.800 | 3 | | | | | | | | |
| | 05.00 - 07.00 | 1218 | T 32 | 350 | 42.000 | 11.600 | 1 | | | | | | | | | | | | | 11.600 | 1 | | | | | | | | |
| Total Shift 3 | | | | | | | | | | | | | | | | | | | 168.000 | 116.000 | 10 | 42.000 | 25.400 | 2 | 0 | 0 | 0 | 141.400 | 12 |
| TOTAL | | | | | | | | | | | | | | | | | | | 168.000 | 158.000 | 12 | 252.000 | 236.400 | 16 | 216.000 | 184.000 | 10 | 578.400 | 38 |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | | | | | | | | | | |
|---------------|---------------|------------|-------|-------|----------|---------|----------|------------|-------|-------|----------|---------|----------|-----------|------|-------|----------|---------|----------|---------|----------|---------|---------|---------|---------|---------|---------|---------|---------|----|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | | | | | | | | | |
| 23-Oct | 07.00 - 09.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 84.800 | 4 | | | | | | | | | |
| | 09.00 - 11.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 84.800 | 4 | | | | | | | | | |
| | 11.00 - 13.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 84.800 | 4 | | | | | | | | | |
| | 13.00 - 15.00 | NYISIR | | | | | | NYISIR | | | | | | | | | | | | 0 | 0 | | | | | | | | | |
| | Total Shift 1 | | | | | | | | | | | | | | | | | | | 126.000 | 126.000 | 6 | 126.000 | 128.400 | 6 | 0 | 0 | 254.400 | 12 | |
| | 15.00 - 17.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 84.800 | 4 | | | | | | | | | |
| | 17.00 - 19.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 84.800 | 4 | | | | | | | | | |
| | 19.00 - 21.00 | DOFF T 888 | | | | | | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 79.800 | 4 | | | | | | | | | |
| | 21.00 - 23.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | DOFF RP 60 | | | | | | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 79.000 | 4 | | | | | | | | | |
| | Total Shift 2 | | | | | | | | | | | | | | | | | | | 126.000 | 126.000 | 6 | 126.000 | 128.400 | 6 | 84.000 | 74.000 | 4 | 328.400 | 16 |
| | 23.00 - 01.00 | NYISIR | | | | | | | | | | | | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 37.000 | 2 | | | | | | | | | |
| | 01.00 - 03.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | | | | | | | NYISIR | | | | | | 42.000 | 2 | | | | | | | | | |
| | 03.00 - 05.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | | | | | | | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 79.000 | 4 | | | | | | | | | |
| | 05.00 - 07.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | | | | | | | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 79.000 | 4 | | | | | | | | | |
| Total Shift 3 | | | | | | | | | | | | | | | | | | | 126.000 | 126.000 | 6 | 0 | 0 | 126.000 | 111.000 | 6 | 237.000 | 12 | | |
| TOTAL | | | | | | | | | | | | | | | | | | | 378.000 | 378.000 | 18 | 252.000 | 256.800 | 12 | 210.000 | 185.000 | 10 | 819.800 | 40 | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | | |
|--------|---------------|------------|-------|-------|----------|---------|----------|-------------|-------|-------|----------|---------|----------|-----------|------|-------|----------|---------|----------|---------|----------|---|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | |
| 24-Oct | 07.00 - 09.00 | NYISIR | | | | | | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | DOFF T 28 | | | | | | 36.000 | 2 | |
| | 09.00 - 11.00 | 1222 | T 888 | 350 | 42000 | 21.000 | 2 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 115.000 | 6 | |
| | 11.00 - 13.00 | DOFF T888 | | | | | | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1223 | T 28 | 350 | 42000 | 18.500 | 1 | 54.500 | 3 | |
| | 13.00 - 15.00 | 1222 | T 888 | 350 | 42000 | 13.600 | 3 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 1 | NYISIR | | | | | | 58.800 | 4 | |
| | Total Shift 1 | | | | 84.000 | 82.800 | 5 | | | | 168.000 | 126.000 | 7 | | | | 84.000 | 55.500 | 3 | 264.300 | 15 | |
| | 15.00 - 17.00 | 1222 | T 888 | 350 | 42000 | 13.600 | 3 | NYISIR | | | | | | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 77.800 | 5 | |
| | 17.00 - 19.00 | NYISIR | | | | | | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1223 | T 28 | 350 | 42000 | 18.500 | 2 | 73.000 | 4 | |
| | 19.00 - 21.00 | 1222 | T 888 | 350 | 42000 | 13.600 | 3 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1223 | T 28 | 350 | 42000 | 18.500 | 1 | 95.300 | 6 | |
| | 21.00 - 23.00 | 1222 | T 888 | 350 | 42000 | 13.600 | 1 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 1 | STOP | | | | | | 31.600 | 2 | |
| | Total Shift 2 | | | | 126.000 | 95.200 | 7 | | | | 126.000 | 90.000 | 5 | | | | 126.000 | 92.500 | 5 | 277.700 | 17 | |
| | 23.00 - 01.00 | DOFF RP 60 | | | | | | DOFF RP 153 | | | | | | | | | | | | | 0 | 0 |
| | 01.00 - 03.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 78.800 | 4 | |
| | 03.00 - 05.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 78.800 | 4 | |
| | 05.00 - 07.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 78.800 | 4 | |
| | Total Shift 3 | | | | 126.000 | 108.000 | 6 | | | | 126.000 | 128.400 | 6 | | | | 0 | 0 | 0 | 236.400 | 12 | |
| | TOTAL | | | | 336.000 | 286.000 | 18 | | | | 420.000 | 344.400 | 18 | | | | 210.000 | 148.000 | 8 | 778.400 | 44 | |

| TGL | JAM | WARPING 1 | | | | | | WARPING 2 | | | | | | WARPING 3 | | | | | | TOTAL | | |
|--------|---------------|-----------|-------|-------|----------|---------|----------|-----------|-------|-------|----------|---------|----------|-----------|----|-------|----------|---------|----------|---------|----------|---|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | |
| 25-Oct | 07.00 - 09.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 1 | NYISIR | | | | | | | | | | | | | 18.000 | 1 |
| | 09.00 - 11.00 | NYISIR | | | | | | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 42.800 | 2 | |
| | 11.00 - 13.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 78.800 | 4 | |
| | 13.00 - 15.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 2 | 1224 | RP153 | 350 | 42.000 | 21.400 | 2 | | | | | | | 78.800 | 4 | |
| | Total Shift 1 | | | | 126.000 | 90.000 | 5 | | | | 126.000 | 128.400 | 6 | | | | 0 | 0 | 0 | 218.400 | 11 | |
| | 15.00 - 17.00 | 1225 | RP 60 | 350 | 42.000 | 18.000 | 1 | STOP | | | | | | | | | | | | | 18.000 | 1 |
| | 17.00 - 19.00 | STOP | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | 19.00 - 21.00 | | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | 21.00 - 23.00 | | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | Total Shift 2 | | | | 42.000 | 18.000 | 1 | | | | 0 | 0 | 0 | | | | 0 | 0 | 0 | 18.000 | 1 | |
| | 23.00 - 01.00 | | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | 01.00 - 03.00 | | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | 03.00 - 05.00 | | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | 05.00 - 07.00 | | | | | | | | | | | | | | | | | | | 0 | 0 | |
| | Total Shift 3 | | | | 0 | 0 | 0 | | | | 0 | 0 | 0 | | | | 0 | 0 | 0 | 0 | 0 | |
| | TOTAL | | | | 168.000 | 108.000 | 6 | | | | 126.000 | 128.400 | 6 | | | | 0 | 0 | 0 | 236.400 | 12 | |

4. Jadwal Produksi Sizing

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|--------------|------|---------------|---------------|-----------|----------|------------|-------|---------------|---------------|-----------|---------------|-----------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 14-Oct | 07.00 - 09.00 | 1214 | R 30 | 35 | 4.200 | 4.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 7.000 | 3 |
| | 09.00 - 11.00 | 1214 | R 30 | 35 | 4.200 | 4.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 7.000 | 3 |
| | 11.00 - 13.00 | 1214 | R 30 | 35 | 4.200 | 4.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 7.000 | 3 |
| | 13.00 - 15.00 | 1214 | R 30 | 35 | 4.200 | 4.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 7.000 | 3 |
| | Total Shift 1 | | | | 16.800 | 16.000 | 4 | | | | 16.800 | 12.000 | 8 | 28.000 | 12 |
| | 15.00 - 17.00 | 1214 | R 30 | 35 | 4.200 | 4.000 | 1 | 1215 | T 28 | 35 | 1.800 | 1.500 | 2 | 7.000 | 3 |
| | 17.00 - 19.00 | DOFFING T 28 | | | | | | DOFF T 888 | | | | | | 0 | 0 |
| | 19.00 - 21.00 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.000 | 4 |
| | 21.00 - 23.00 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.000 | 4 |
| | Total Shift 2 | | | | 12.600 | 10.000 | 5 | | | | 10.200 | 11.000 | 6 | 21.000 | 11 |
| | 23.00 - 01.00 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.000 | 4 |
| | 01.00 - 03.00 | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.000 | 4 |
| | 03.00 - 05.00 | 1215 | T 28 | 35 | 1.800 | 1.500 | 2 | 1216 | T 888 | 35 | 2.000 | 2.000 | 1 | 5.000 | 3 |
| | 05.00 - 07.00 | DOFFING R 20 | | | | | | DOFF T 888 | | | | | | 0 | 0 |
| Total Shift 3 | | | | 10.200 | 9.000 | 6 | | | | 10.400 | 10.000 | 5 | 19.000 | 11 | |
| TOTAL | | | | 39.600 | 35.000 | 15 | | | | 37.400 | 33.000 | 19 | 68.000 | 34 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|--------------|------|---------------|---------------|-----------|----------|--------------|-------|---------------|---------------|-----------|---------------|-----------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 15-Oct | 07.00 - 09.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 09.00 - 11.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 11.00 - 13.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 13.00 - 15.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | Total Shift 1 | | | | 16.800 | 16.000 | 4 | | | | 16.800 | 16.000 | 8 | 32.000 | 12 |
| | 15.00 - 17.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 17.00 - 19.00 | DOFFING R 20 | | | | | | 1216 | T 888 | 35 | 1.000 | 1.000 | 1 | 1.000 | 1 |
| | 19.00 - 21.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | DOFFING R 20 | | | | | | 4.000 | 1 |
| | 21.00 - 23.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 8.000 | 2 |
| | Total Shift 2 | | | | 12.600 | 12.000 | 3 | | | | 8.400 | 9.000 | 4 | 21.000 | 7 |
| | 23.00 - 01.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 8.000 | 2 |
| | 01.00 - 03.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 8.000 | 2 |
| | 03.00 - 05.00 | 1214 | R 20 | 35 | 2.000 | 2.000 | 1 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 6.000 | 2 |
| | 05.00 - 07.00 | DOFFING T 28 | | | | | | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 4.000 | 1 |
| Total Shift 3 | | | | 10.400 | 10.000 | 3 | | | | 18.014 | 16.000 | 4 | 26.000 | 7 | |
| TOTAL | | | | 39.800 | 38.000 | 10 | | | | 43.214 | 41.000 | 16 | 79.000 | 26 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|---------------|------|--------|----------|---------|----------|--------------|-------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 16-Oct | 07.00 - 09.00 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 1214 | R 20 | 35 | 1.000 | 1.000 | 1 | 4.600 | 3 |
| | 09.00 - 11.00 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | DOFFING T888 | | | | | | 3.600 | 2 |
| | 11.00 - 13.00 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.600 | 4 |
| | 13.00 - 15.00 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.600 | 4 |
| | Total Shift 1 | | | | 16.800 | 14.400 | 8 | | | | 9.400 | 9.000 | 5 | 23.400 | 13 |
| | 15.00 - 17.00 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 7.600 | 4 |
| | 17.00 - 19.00 | DOFFING R 20 | | | | | | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 4.000 | 2 |
| | 19.00 - 21.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 21.00 - 23.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 1.000 | 1.000 | 1 | 5.000 | 2 |
| | Total Shift 2 | | | | 12.600 | 11.600 | 4 | | | | 9.400 | 13.000 | 7 | 24.600 | 11 |
| | 23.00 - 01.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | DOFFING T 28 | | | | | | 4.000 | 1 |
| | 01.00 - 03.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 3 |
| | 03.00 - 05.00 | 1214 | R 20 | 35 | 2.000 | 2.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 5.600 | 3 |
| | 05.00 - 07.00 | DOFFING T 888 | | | | | | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 3.600 | 2 |
| Total Shift 3 | | | | 10.400 | 10.000 | 3 | | | | 9.615 | 10.800 | 6 | 20.800 | 9 | |
| TOTAL | | | | 39.800 | 36.000 | 15 | | | | 28.415 | 32.800 | 18 | 68.800 | 33 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|------------|-------|--------|----------|---------|----------|---------------|-------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 17-Oct | 07.00 - 09.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 4 |
| | 09.00 - 11.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 4 |
| | 11.00 - 13.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 3.000 | 1.500 | 2 | 7.000 | 4 |
| | 13.00 - 15.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | DOFFING T 888 | | | | | | 4.000 | 2 |
| | Total Shift 1 | | | | 16.800 | 16.000 | 8 | | | | 11.400 | 10.200 | 6 | 26.200 | 14 |
| | 15.00 - 17.00 | 1216 | T 888 | 35 | 2.000 | 2.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 6.000 | 3 |
| | 17.00 - 19.00 | DOFF R 20 | | | | | | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 4.000 | 2 |
| | 19.00 - 21.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 21.00 - 23.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | Total Shift 2 | | | | 10.400 | 10.000 | 3 | | | | 12.600 | 16.000 | 8 | 26.000 | 11 |
| | 23.00 - 01.00 | 1214 | R 20 | 35 | 4.200 | 4.000 | 1 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 8.000 | 3 |
| | 01.00 - 03.00 | DOFF T 888 | | | | | | 1216 | T 888 | 35 | 1.000 | 1.000 | 1 | 1.000 | 1 |
| | 03.00 - 05.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | DOFFING T 28 | | | | | | 4.000 | 2 |
| | 05.00 - 07.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 4 |
| Total Shift 3 | | | | 9.616 | 12.000 | 5 | | | | 6.415 | 8.600 | 5 | 20.600 | 10 | |
| TOTAL | | | | 36.816 | 38.000 | 16 | | | | 30.415 | 34.800 | 19 | 72.800 | 35 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|------------|-------|--------|----------|---------|----------|----------|------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 18 Oct | 07.00 - 09.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 4 |
| | 09.00 - 11.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 4 |
| | 11.00 - 13.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 7.600 | 4 |
| | 13.00 - 15.00 | 1216 | T 888 | 35 | 1.000 | 1.000 | 1 | 1215 | T 28 | 35 | 4.200 | 1.800 | 2 | 4.600 | 3 |
| | Total Shift 1 | | | | 13.600 | 13.000 | 7 | | | | 16.800 | 14.400 | 8 | 27.400 | 15 |
| | 15.00 - 17.00 | DOFF T 888 | | | | | | 1215 | T 28 | 35 | 4.200 | 1.500 | 2 | 3.000 | 2 |
| | 17.00 - 19.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | STOP | | | | | | 4.000 | 2 |
| | 19.00 - 21.00 | 1216 | T 888 | 35 | 4.200 | 2.000 | 2 | | | | | | | 4.000 | 2 |
| | 21.00 - 23.00 | 1216 | T 888 | 35 | 2.000 | 2.000 | 1 | | | | | | | 2.000 | 1 |
| | Total Shift 2 | | | | 7.416 | 10.000 | 5 | | | | 4.200 | 3.000 | 2 | 13.000 | 7 |
| | 23.00 - 01.00 | STOP | | | | | | | | | | | | 0 | 0 |
| | 01.00 - 03.00 | | | | | | | | | | | | | 0 | 0 |
| | 03.00 - 05.00 | | | | | | | | | | | | | 0 | 0 |
| | 05.00 - 07.00 | | | | | | | | | | | | | 0 | 0 |
| Total Shift 3 | | | | 0 | 0 | 0 | | | | 0 | 0 | 0 | 0 | 0 | |
| TOTAL | | | | 21.016 | 23.000 | 12 | | | | 21.000 | 17.400 | 10 | 40.400 | 22 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|----------|-------|--------|----------|---------|----------|------------|-------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 19 Oct | 07.00 - 09.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 09.00 - 11.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 11.00 - 13.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 13.00 - 15.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | Total Shift 1 | | | | 16.800 | 16.800 | 8 | | | | 16.800 | 16.800 | 8 | 33.600 | 16 |
| | 15.00 - 17.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 17.00 - 19.00 | DOFF | | | | | | DOFF | | | | | | 0 | 0 |
| | 19.00 - 21.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | 21.00 - 23.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | Total Shift 2 | | | | 10.200 | 10.200 | 4 | | | | 12.600 | 12.600 | 6 | 22.800 | 10 |
| | 23.00 - 01.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | 01.00 - 03.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | 03.00 - 05.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | 05.00 - 07.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | DOFF RP 60 | | | | | | 3.000 | 1 |
| Total Shift 3 | | | | 10.220 | 12.000 | 4 | | | | 12.600 | 12.600 | 6 | 24.600 | 10 | |
| TOTAL | | | | 37.220 | 39.000 | 16 | | | | 42.000 | 42.000 | 20 | 81.000 | 36 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|------------|-------|--------|----------|---------|----------|------------|------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 20-Oct | 07.00 - 09.00 | DOFF T888 | | | | | | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 4.200 | 2 |
| | 09.00 - 11.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 11.00 - 13.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 13.00 - 15.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | Total Shift 1 | | | | 12.600 | 12.600 | 6 | | | | 16.800 | 16.800 | 8 | 29.400 | 14 |
| | 15.00 - 17.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 17.00 - 19.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | DOFF T32 | | | | | | 4.200 | 2 |
| | 19.00 - 21.00 | DOFF R 238 | | | | | | 1218 | T 32 | 35 | 4.200 | 2.000 | 2 | 4.000 | 2 |
| | 21.00 - 23.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1218 | T 32 | 35 | 4.200 | 2.000 | 2 | 7.000 | 3 |
| | Total Shift 2 | | | | 8.419 | 11.400 | 5 | | | | 12.600 | 12.200 | 6 | 23.600 | 11 |
| | 23.00 - 01.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1218 | T 32 | 35 | 4.200 | 1.800 | 2 | 6.600 | 3 |
| | 01.00 - 03.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | DOFF RP 60 | | | | | | 3.000 | 1 |
| | 03.00 - 05.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | 05.00 - 07.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| Total Shift 3 | | | | 12.000 | 12.000 | 4 | | | | 9.617 | 12.000 | 6 | 24.000 | 10 | |
| TOTAL | | | | 33.019 | 36.000 | 15 | | | | 39.017 | 41.000 | 20 | 77.000 | 35 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|-----------|-------|--------|----------|---------|----------|-----------|------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 21-Oct | 07.00 - 09.00 | 1220 | R 238 | 25 | 3.000 | 3.000 | 1 | 1217 | Rp60 | 35 | 4.200 | 2.100 | 2 | 7.200 | 3 |
| | 09.00 - 11.00 | DOFF T 32 | | | | | | DOFF R 20 | | | | | | 0 | 0 |
| | 11.00 - 13.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | 7.200 | 3 |
| | 13.00 - 15.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | 7.200 | 3 |
| | Total Shift 1 | | | | 11.400 | 11.400 | 5 | | | | 10.200 | 10.200 | 4 | 21.600 | 9 |
| | 15.00 - 17.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | 7.200 | 3 |
| | 17.00 - 19.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | 7.200 | 3 |
| | 19.00 - 21.00 | 1218 | T 32 | 35 | 4.200 | 2.100 | 2 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | 7.200 | 3 |
| | 21.00 - 23.00 | DOFF R 20 | | | | | | 1221 | R 20 | 25 | 3.000 | 3.500 | 1 | 3.500 | 1 |
| | Total Shift 2 | | | | 12.600 | 12.600 | 6 | | | | 9.000 | 12.500 | 4 | 25.100 | 10 |
| | 23.00 - 01.00 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | STOP | | | | | | 3.000 | 1 |
| | 01.00 - 03.00 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | | | | | | | 3.000 | 1 |
| | 03.00 - 05.00 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | | | | | | | 3.000 | 1 |
| | 05.00 - 07.00 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | | | | | | | 3.000 | 1 |
| Total Shift 3 | | | | 10.221 | 12.000 | 4 | | | | 0 | 0 | 0 | 12.000 | 4 | |
| TOTAL | | | | 34.221 | 36.000 | 15 | | | | 19.200 | 22.700 | 8 | 58.700 | 23 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | | |
|---------------|---------------|----------|------|-------|----------|---------|----------|----------|----|-------|----------|---------|----------|---------|----------|---|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM | |
| 22-Oct | 07.00 - 09.00 | 1221 | R 20 | 25 | 3.000 | 3.000 | 1 | | | | | | | | 3.000 | 1 |
| | 09.00 - 11.00 | 1221 | R 20 | 25 | 3.000 | 3.500 | 1 | | | | | | | | 3.500 | 1 |
| | 11.00 - 13.00 | STOP | | | | | | | | | | | | | 0 | 0 |
| | 13.00 - 15.00 | | | | | | | | | | | | | | 0 | 0 |
| | Total Shift 1 | | | | 6.000 | 6.500 | 2 | | | | 0 | 0 | 0 | | 6.500 | 2 |
| | 15.00 - 17.00 | | | | | | | | | | | | | | 0 | 0 |
| | 17.00 - 19.00 | | | | | | | | | | | | | | 0 | 0 |
| | 19.00 - 21.00 | | | | | | | | | | | | | | 0 | 0 |
| | 21.00 - 23.00 | | | | | | | | | | | | | | 0 | 0 |
| | Total Shift 2 | | | | 0 | 0 | 0 | | | | 0 | 0 | | | 0 | 0 |
| | 23.00 - 01.00 | | | | | | | | | | | | | | 0 | 0 |
| | 01.00 - 03.00 | | | | | | | | | | | | | | 0 | 0 |
| | 03.00 - 05.00 | | | | | | | | | | | | | | 0 | 0 |
| | 05.00 - 07.00 | | | | | | | | | | | | | | 0 | 0 |
| Total Shift 3 | | | | 0 | 0 | 0 | | | | 0 | 0 | 0 | | 0 | 0 | |
| TOTAL | | | | | 6.000 | 6.500 | 0 | | | | 0 | 0 | 0 | 6.500 | 2 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|------------|-------|-------|----------|---------|----------|-------------|--------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 24-Oct | 07.00 - 09.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.200 | 4 |
| | 09.00 - 11.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.200 | 4 |
| | 11.00 - 13.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.200 | 4 |
| | 13.00 - 15.00 | 1219 | T 888 | 35 | 1.000 | 2.100 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.200 | 4 |
| | Total Shift 1 | | | | 13.600 | 16.800 | 8 | | | | 16.800 | 16.000 | 8 | 32.800 | 16 |
| | 15.00 - 17.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1223 | T 28 | 35 | 4.200 | 2.500 | 1 | 6.700 | 3 |
| | 17.00 - 19.00 | DOFF T888 | | | | | | DOFF RP 153 | | | | | | 0 | 0 |
| | 19.00 - 21.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 21.00 - 23.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | Total Shift 2 | | | | 12.600 | 12.600 | 6 | | | | 12.600 | 10.900 | 5 | 23.500 | 11 |
| | 23.00 - 01.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 01.00 - 03.00 | 1219 | T 888 | 35 | 1.000 | 2.100 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 8.400 | 4 |
| | 03.00 - 05.00 | 1219 | T 888 | 35 | 4.200 | 2.100 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.300 | 2 | 8.800 | 4 |
| | 05.00 - 07.00 | DOFF RP 60 | | | | | | DOFF RP 153 | | | | | | 0 | 0 |
| Total Shift 3 | | | | 9.400 | 12.600 | 6 | | | | 12.600 | 13.000 | 6 | 25.600 | 12 | |
| TOTAL | | | | | 35.600 | 42.000 | 20 | | | | 42.000 | 39.900 | 19 | 81.900 | 39 |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|-----------|-------|--------|----------|---------|----------|-------------|--------|--------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 25-Oct | 07.00 - 09.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | DOFF T28 | | | | | | 4.000 | 2 |
| | 09.00 - 11.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.000 | 4 |
| | 11.00 - 13.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.000 | 4 |
| | 13.00 - 15.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 8.000 | 4 |
| | Total Shift 1 | | | | 16.800 | 16.000 | 8 | | | | 12.600 | 12.000 | 6 | 28.000 | 14 |
| | 15.00 - 17.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 1 | 1223 | T 28 | 35 | 4.200 | 2.000 | 2 | 6.000 | 3 |
| | 17.00 - 19.00 | DOFF T888 | | | | | | 1223 | T 28 | 35 | 4.200 | 2.500 | 1 | 2.500 | 1 |
| | 19.00 - 21.00 | 1219 | T 888 | 35 | 4.200 | 2.000 | 2 | DOFF RP 153 | | | | | | 4.000 | 2 |
| | 21.00 - 23.00 | 1219 | T 888 | 35 | 4.200 | 2.000 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 8.200 | 4 |
| | Total Shift 2 | | | | 12.600 | 10.000 | 5 | | | | 8.400 | 10.700 | 5 | 20.700 | 10 |
| | 23.00 - 01.00 | 1219 | T 888 | 35 | 4.200 | 2.000 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 8.200 | 4 |
| | 01.00 - 03.00 | 1219 | T 888 | 35 | 4.200 | 1.600 | 1 | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 5.800 | 3 |
| | 03.00 - 05.00 | DOFF R 20 | | | | | | 1224 | RP 153 | 35 | 4.200 | 2.100 | 2 | 4.200 | 2 |
| | 05.00 - 07.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | 1224 | RP 153 | 35 | 4.200 | 2.300 | 2 | 8.600 | 4 |
| Total Shift 3 | | | | 9.625 | 9.600 | 5 | | | | 13.824 | 17.200 | 8 | 26.800 | 13 | |
| TOTAL | | | | 39.025 | 35.600 | 18 | | | | 34.824 | 39.900 | 19 | 75.500 | 37 | |

| TGL | JAM | SIZING 1 | | | | | | SIZING 2 | | | | | | TOTAL | |
|---------------|---------------|----------|-------|--------|----------|---------|----------|----------|----|-------|----------|---------|----------|---------|----------|
| | | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | OK | SN | SPEED | PRODUKSI | PANJANG | JML BEAM | PANJANG | JML BEAM |
| 26-Oct | 07.00 - 09.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | STOP | | | | | | 4.000 | 2 |
| | 09.00 - 11.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | | | | | | | 4.000 | 2 |
| | 11.00 - 13.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 2 | | | | | | | 4.000 | 2 |
| | 13.00 - 15.00 | 1225 | RP 60 | 35 | 4.200 | 2.000 | 1 | | | | | | | 2.000 | 1 |
| | Total Shift 1 | | | | 16.800 | 14.000 | 7 | | | | 0 | 0 | 0 | 14.000 | 7 |
| | 15.00 - 17.00 | STOP | | | | | | | | | | | | 0 | 0 |
| | 17.00 - 19.00 | | | | | | | | | | | | | 0 | 0 |
| | 19.00 - 21.00 | | | | | | | | | | | | | 0 | 0 |
| | 21.00 - 23.00 | | | | | | | | | | | | | 0 | 0 |
| | Total Shift 2 | | | | 0 | 0 | 0 | | | | 0 | 0 | | 0 | 0 |
| | 23.00 - 01.00 | | | | | | | | | | | | | 0 | 0 |
| | 01.00 - 03.00 | | | | | | | | | | | | | 0 | 0 |
| | 03.00 - 05.00 | | | | | | | | | | | | | 0 | 0 |
| | 05.00 - 07.00 | | | | | | | | | | | | | 0 | 0 |
| Total Shift 3 | | | | 0 | 0 | 0 | | | | 0 | 0 | 0 | 0 | 0 | |
| TOTAL | | | | 16.800 | 14.000 | 0 | | | | 0 | 0 | 0 | 14.000 | 7 | |

5. Rencana Pemakaian Bahan Baku Penelitian Permintaan Pertama

| No | Komponen | Jenis | Stok Awal | Buffer Stock | Jumlah Stock | Kebutuhan | Ketersediaan | Order |
|-----|-----------|---------------|-----------|--------------|--------------|-----------|--------------|-----------|
| 1. | Benang | Rayon 30s | 7 Bale | 20 Bale | 27 | 48 Bale | -41 Bale | 41 Bale |
| | | TR 20 | 5 Bale | 20 Bale | 25 | 111 Bale | -106 Bale | 100 Bale |
| 2.. | Batu Bara | Karung | 3500 Kg | 1500 Kg | 5000 Kg | 14.255 Kg | -9.255 Kg | 30.000 Kg |
| 3 | Chemical | Pro Stiff A21 | 75 Kg | 200 Kg | 275 Kg | 2.519 Kg | -2.444 Kg | 2.450 Kg |
| | | Pro Stiff A11 | 50 Kg | 240 Kg | 290 Kg | 3.625 Kg | -3.575 Kg | 3.575 Kg |

6. Rencana Pemakaian Bahan Baku Penelitian Permintaan Kedua

| No | Komponen | Jenis | Stok | Buffer Stock | Jumlah Stock | Kebutuhan | Ketersediaan | Order |
|-----|-----------|---------------|-----------|--------------|--------------|-----------|--------------|----------|
| 1. | Benang | Rayon 30s | 0 Bale | 20 Bale | 20 Bale | 75 Bale | -75 Bale | 75 Bale |
| | | TR 20 | 0 Bale | 14 Bale | 14 Bale | 51 Bale | -51 Bale | 60 Bale |
| 2.. | Batu Bara | Karung | 19.245 Kg | 1500 Kg | 20.745 Kg | 9.784 Kg | +9.461 Kg | - |
| 3 | Chemical | Pro Stiff A21 | 6 Kg | 200 Kg | 206 Kg | 1.142 Kg | -1.136 Kg | 1.150 Kg |
| | | Pro Stiff A11 | 0 Kg | 240 Kg | 240 Kg | 2.389 Kg | -2.389 Kg | 2.400 Kg |

7. Rencana Pemakaian Bahan Baku Penelitian Permintaan Ketiga

| No | Komponen | Jenis | Stok | Buffer Stock | Jumlah Stok | Kebutuhan | Ketersediaan | Order |
|-----|-----------|---------------------|------------------|-------------------|----------------|----------------|-----------------|-------------------|
| 1. | Benang | Rayon 30s | 0 <i>Bale</i> | 20 <i>Bale</i> | 20 <i>Bale</i> | 59 <i>Bale</i> | -59 <i>Bale</i> | 60 <i>Bale</i> |
| | | TR 20 | 3 <i>Bale</i> | 20 <i>Bale</i> | 23 <i>Bale</i> | 49 <i>Bale</i> | -46 <i>Bale</i> | 46 <i>Bale</i> |
| 2.. | Batu Bara | Karung | 7.961 Kg | 1500 | 9461 Kg | 7.513 Kg | +448 Kg | 30.000 Kg |
| 3 | Chemical | Pro Stiff A21 | 14 Kg | 200 Kg | 214 Kg | 1.364 Kg | -1350 Kg | 1350 Kg |
| | | Pro Stiff A11 | 11 Kg | 240 Kg | 251 Kg | 2.122 Kg | -2111 Kg | 2.100 Kg |

8. Lead Time Pengiriman permintaan pertama

| No. | Bahan Baku | Jenis | Total Kebutuhan | Tgl Pemesanan | Tahap | Tgl Penerimaan | Jumlah Dikirim | Biaya kirim | Stok Akhir |
|-----|------------|-------|-----------------|-----------------|-------|-----------------|----------------|---------------|------------|
| 1. | Benang | Ry30s | 41 Bale | 10 Oktober 2024 | 1 | 11 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | | 16 Bale | 10 Oktober 2024 | 2 | 12 Oktober 2024 | 16 Bale | Rp300.000 | 20 Bale |
| | | TR 20 | 100 Bale | 10 Oktober 2024 | 1 | 11 Oktober 2024 | 25 Bale | Rp300.000 | 14 Bale |
| | | | 75 Bale | 10 Oktober 2024 | 2 | 12 Oktober 2024 | 25 Bale | Rp300.000 | 14 Bale |
| | | | 50 Bale | 10 Oktober 2024 | 3 | 13 Oktober 2024 | 25 Bale | Rp300.000 | 14 Bale |
| | | | 25 Bale | 10 Oktober 2024 | 4 | 13 Oktober 2024 | 25 Bale | Rp300.000 | 14 Bale |
| 2. | Batu Bara | | 9.255 Kg | 10 Oktober 2024 | 1 | 14 Oktober 2024 | 30.000 Kg | Rp. 2.500.000 | 20.745 Kg |
| 3. | Chemical | A21 | 2.450 Kg | 10 Oktober 2024 | 1 | 12 Oktober 2024 | 2450 Kg | - | 206 Kg |

| | | | | | | | | | |
|--|--|-----|----------|--------------------|---|--------------------|------------|---|--------|
| | | A11 | 3.575 Kg | 10 Oktober 2024 | 1 | 12 Oktober 2024 | 1800 Kg | - | 0 Kg |
| | | | | 10 Oktober 2024 | 2 | 13 Oktober 2024 | 1775 Kg | - | 240 Kg |



9. Lead Time Pengiriman Permintaan Kedua

| No. | Bahan Baku | Jenis | Total Kebutuhan | Tgl Pemesanan | Tahap | Tgl Penerimaan | Jumlah Dikirim | Biaya kirim | Stok Akhir |
|-----|------------|-------|-----------------|-----------------|-------|-----------------|----------------|-------------|------------|
| 1. | Benang | Ry30s | 75 Bale | 16 Oktober 2024 | 1 | 17 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | | 50 Bale | 16 Oktober 2024 | 2 | 18 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | | 25 Bale | 16 Oktober 2024 | 3 | 19 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | TR 20 | 60 Bale | 16 Oktober 2024 | 1 | 17 Oktober 2024 | 25 Bale | Rp300.000 | 14 Bale |
| | | | 35 Bale | 16 Oktober 2024 | 2 | 18 Oktober 2024 | 25 Bale | Rp300.000 | 14Bale |
| | | | 10 Bale | 16 Oktober 2024 | 3 | 20 Oktober 2024 | 10 Bale | Rp300.000 | 23 Bale |
| 2. | Batu Bara | - | - | - | - | - | - | 10.981 Kg | |
| 3. | Chemical | A21 | 1.150 Kg | 16 Oktober 2024 | 1 | 18 Oktober 2024 | 1.150 kg | - | 214 Kg |
| | | A11 | 2.400 Kg | 16 Oktober 2024 | 1 | 18 Oktober 2024 | 2.400 Kg | - | 251 Kg |

10. Lead Time Pengiriman Permintaan Ketiga

| No. | Bahan Baku | Jenis | Total Kebutuhan | Tgl Pemesanan | Tahap | Tgl Penerimaan | Jumlah Dikirim | Biaya kirim | Stok Akhir |
|-----|------------|-------|-----------------|-----------------|-------|-----------------|----------------|-------------|------------|
| 1. | Benang | Ry30s | 60 Bale | 21 Oktober 2024 | 1 | 22 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | | 35 Bale | 21 Oktober 2024 | 2 | 23 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | | 10 Bale | 21 Oktober 2024 | 3 | 24 Oktober 2024 | 10 Bale | Rp300.000 | 21 Bale |
| | | TR 20 | 46 Bale | 21 Oktober 2024 | 1 | 22 Oktober 2024 | 25 Bale | Rp300.000 | 20 Bale |
| | | | 21 Bale | 21 Oktober 2024 | 2 | 23 Oktober 2024 | 21 Bale | Rp300.000 | 20 Bale |
| 2. | Batu Bara | - | - | - | - | - | - | 3448 Kg | |
| 3. | Chemical | A21 | 1.350 Kg | 21 Oktober 2024 | 1 | 23 Oktober 2024 | 1.350 Kg | - | 200 Kg |
| | | A11 | 2.100 Kg | 21 Oktober 2024 | 1 | 23 Oktober 2024 | 2.100 Kg | - | 229 Kg |

11. Lead Time Produksi

| No | WARPING | | | | | | SIZING | | | | |
|----|---------|------|----------|-------|--------|-----------------|----------|-------|--------|-----------------|------------------------|
| | SN | Ok | Tanggal | Start | Finish | Lead Time | Tanggal | Start | Finish | Lead Time | Total Lead Time |
| 1 | R30 | 1214 | 12/10/24 | 07.00 | 13.25 | 6 jam 25 menit | 14/10/24 | 07.00 | 17.15 | 8 Jam 15 Menit | 2 Hari 14 Jam 40 Menit |
| 2 | R30 | 1214 | 12/10/24 | 13.00 | 23.15 | 10 Jam 15 menit | 15/10/24 | 07.00 | 17.10 | 10 Jam 10 menit | 3 hari 20 jam 25 menit |
| 3 | R 30 | 1214 | 12/10/24 | 21.00 | 03.30 | 6 Jam 30 menit | 15/10/24 | 19.00 | 05.20 | 11 Jam 20 menit | 3 Hari 17 Jam 50 Menit |
| 4 | R 30 | 1214 | 12/10/24 | 05.00 | 13.15 | 8 Jam 15 menit | 15/10/24 | 21.00 | 09.10 | 12 Jam 10 menit | 3 Hari 20 Jam 25 menit |
| 5 | R 30 | 1214 | 13/10/24 | 15.00 | 05.35 | 14 Jam 35 menit | 16/10/24 | 19.00 | 05.25 | 10 Jam 25menit | 3 Hari 1 Jam |
| 6 | R 30 | 1214 | 14/10/24 | 03.00 | 09.00 | 6 Jam | 17/10/24 | 19.00 | 01.00 | 6 Jam | 3 Hari 12 Jam |
| 7 | T 32 | 1215 | 12/10/24 | 07.00 | 12.40 | 5 Jam 40 menit | 14/10/24 | 07.00 | 17.00 | 10 Jam | 2 Hari 15 Jam 40 menit |
| 8 | T 32 | 1215 | 12/10/24 | 15.00 | 21.00 | 6 Jam | 14/10/24 | 19.00 | 05.00 | 10 Jam | 2 Hari 16 Jam |
| 9 | T 32 | 1215 | 13/10/24 | 15.00 | 03.10 | 12 Jam 10 menit | 16/10/24 | 07.00 | 17.20 | 10 Jam 20 menit | 3 Hari 22 jam 30 menit |
| 10 | T 32 | 1215 | 14/10/24 | 13.00 | 03.00 | 14 Jam | 16/10/24 | 01.00 | 13.00 | 12 Jam | 3 Hari 2 Jam |
| 11 | T 32 | 1215 | 15/10/24 | 11.00 | 01.25 | 14 Jam 25 menit | 17/10/24 | 05.00 | 17.30 | 12 Jam 30 menit | 3 Hari 2 Jam 55 menit |
| 12 | T888 | 1216 | 12/10/24 | 23.00 | 07.00 | 8 Jam | 14/10/24 | 19.00 | 05.00 | 10 Jam | 2 Hari 18 Jam |
| 13 | T888 | 1216 | 13/10/24 | 07.15 | 21.10 | 14 Jam 25 menit | 15/10/24 | 07.00 | 19.00 | 12 Jam | 3 Hari 2 Jam 25 menit |
| 14 | T888 | 1216 | 13/10/24 | 23.20 | 11.15 | 12 Jam 35 menit | 16/10/24 | 11.10 | 23.15 | 12 Jam 25 menit | 4 Hari 1 Jam |
| 15 | T888 | 1216 | 13/10/24 | 05.00 | 16.40 | 11 jam 40 menit | 17/10/24 | 07.10 | 17.20 | 10 Jam 30 menit | 4 Hari 21 Jam 10 menit |

| | | | | | | | | | | | |
|----|-------|------|----------|-------|-------|-----------------|----------|-------|-------|-----------------|------------------------|
| 16 | T888 | 1216 | 14/10/24 | 17.20 | 07.15 | 14 Jam 35 menit | 17/10/24 | 15.00 | 03.00 | 12 Jam | 4 Hari 2 Jam 35 menit |
| 17 | T888 | 1216 | 15/10/24 | 07.00 | 19.20 | 12 Jam 20 menit | 17/10/24 | 03.00 | 15.20 | 12 Jam 20 menit | 3 Hari 40 menit |
| 18 | T888 | 1216 | 15/10/24 | 18.50 | 03.10 | 10 Jam | 18/10/24 | 17.20 | 23.00 | 6 jam 20 menit | 3 Hari 16 Jam 20 menit |
| 19 | Rp 60 | 1217 | 18/10/24 | 06.45 | 21.10 | 15 Jam 55 menit | 19/10/24 | 07.00 | 17.10 | 10 Jam 10 menit | 2 Hari 2 Jam 5 menit |
| 20 | Rp 60 | 1217 | 19/10/24 | 07.00 | 21.00 | 14 Jam | 20/10/24 | 07.00 | 17.20 | 10 Jam 20 menit | 2 Hari 20 menit |
| 21 | Rp 60 | 1217 | 20/10/24 | 13.00 | 01.00 | 12 Jam | 20/10/24 | 03.00 | 09.15 | 6 Jam 15 menit | 18 Jam 15 menit |
| 22 | T 32 | 1218 | 18/10/24 | 07.00 | 19.00 | 12 Jam | 19/10/24 | 07.00 | 17.05 | 10 Jam 5 menit | 1 Hari 22 Jam 5 menit |
| 23 | T 32 | 1218 | 19/10/24 | 23.00 | 11.10 | 12 Jam 10 menit | 20/10/24 | 19.00 | 01.00 | 6 Jam | 1 Hari 18 Jam 10 menit |
| 24 | T 32 | 1218 | 20/10/24 | 23.00 | 07.10 | 8 jam 10 menit | 21/10/24 | 11.00 | 21.05 | 10 Jam 5 menit | 1 Hari 18 Jam 15 menit |
| 25 | T 888 | 1219 | 18/10/24 | 21.00 | 11.20 | 14 Jam 20 menit | 19/10/24 | 19.00 | 05.00 | 10 Jam | 2 Hari 20 menit |
| 26 | T 888 | 1219 | 19/10/24 | 21.00 | 09.00 | 12 Jam | 20/10/24 | 09.00 | 19.10 | 10 Jam 10 menit | 1 Hari 22 Jam 10 menit |
| 27 | R 238 | 1220 | 18/10/24 | 19.10 | 07.00 | 12 Jam 10 menit | 19/10/24 | 19.00 | 07.00 | 12 Jam | 2 Hari 10 menit |
| 28 | R 238 | 1220 | 19/10/24 | 23.00 | 09.00 | 10 Jam | 20/10/24 | 21.00 | 08.50 | 6 Jam 50 menit | 1 Hari 16 Jam 50 menit |
| 29 | R 20 | 1221 | 19/10/24 | 09.00 | 20.45 | 11 Jam 45 menit | 21/10/24 | 11.00 | 23.10 | 12 Jam 10 menit | 2 Hari 23 Jam 5 menit |
| 30 | R 20 | 1221 | 20/10/24 | 10.50 | 22.40 | 13 Jam 30 menit | 21/10/24 | 23.00 | 11.00 | 12 Jam | 2 Hari 1 Jam 30 menit |

| | | | | | | | | | | | |
|----|--------|------|----------|-------|-------|-----------------|----------|-------|-------|-----------------|-------------------------|
| 32 | T 888 | 1222 | 23/10/24 | 07.10 | 18.50 | 12 Jam | 24/10/24 | 07.00 | 17.05 | 10 Jam 5 menit | 1 Hari 22 Jam 5 menit |
| 33 | T 888 | 1222 | 23/10/24 | 20.25 | 11.05 | 15 Jam 35 menit | 24/10/24 | 19.00 | 05.00 | 10 Jam | 2 Hari 1 Jam 45 menit |
| 34 | T 888 | 1222 | 24/10/24 | 13.00 | 23.00 | 10 Jam | 25/10/24 | 19.00 | 02.30 | 7 Jam 30 menit | 1 Hari 17 Jam 30 menit |
| 35 | T 28 | 1223 | 23/10/24 | 19.10 | 06.50 | 11 Jam | 24/10/24 | 07.00 | 17.00 | 10 Jam | 1 Hari 21 Jam |
| 36 | T 28 | 1223 | 24/10/24 | 09.00 | 21.00 | 12 Jam | 25/10/24 | 09.00 | 19.10 | 10 Jam 10 menit | 1 Hari 22 Jam, 10 menit |
| 37 | Rp 153 | 1224 | 23/10/24 | 07.00 | 21.20 | 14 Jam 20 menit | 24/10/24 | 19.00 | 05.10 | 10 Jam 10 menit | 2 Hari 30 menit |
| 38 | Rp 153 | 1224 | 24/10/24 | 01.00 | 15.05 | 14 Jam 5 menit | 25/10/24 | 21.00 | 07.00 | 10 Jam | 2 Hari 5 menit |
| 39 | Rp 60 | 1225 | 24/10/24 | 06.45 | 23.15 | 16 jam | 25/10/12 | 07.00 | 17.00 | 10 Jam | 2 Hari 2 Jam |
| 40 | Rp 60 | 1225 | 24/10/24 | 01.00 | 17.00 | 16 Jam | 25/10/24 | 05.00 | 15.20 | 10 Jam 20 menit | 2 Hari 2 Jam 20 menit |

12. Stock Pemakaian Harian

| DATA STOCK HARIAN BENANG | | | | |
|---------------------------------|-------|-------|-------|-------|
| NO | NON | JIT | NON | JIT |
| | Ry 30 | Ry 30 | TR 20 | TR 20 |
| 1 | 29,5 | 27 | 32,5 | 25 |
| 2 | 42,5 | 52 | 42,5 | 50 |
| 3 | 53,4 | 25,8 | 50,5 | 22,9 |
| 4 | 38,3 | 24,2 | 61,4 | 17,2 |
| 5 | 26,3 | 19,7 | 58,4 | 12,6 |
| 6 | 26,3 | 19,7 | 43,3 | 13,9 |
| 7 | 26,3 | 19,7 | 28 | 13,9 |
| 8 | 26,3 | 44,7 | 28 | 38,9 |
| 9 | 26,3 | 18,7 | 28 | 16,8 |
| 10 | 37,3 | 11,6 | 41 | 19,7 |
| 11 | 47,2 | 19,6 | 28,5 | 22,8 |
| 12 | 56,1 | 19,6 | 28,5 | 22,8 |
| 13 | 61,1 | 44,6 | 28,5 | 47,8 |
| 14 | 63,1 | 28,4 | 28,5 | 16,3 |
| 15 | 45 | 10,2 | 28,5 | 19,5 |
| 16 | 29,3 | 20,2 | - | - |

| DATA STOK HARIAN BATU BARA | | |
|-----------------------------------|---------|--------|
| NO | Non JIT | JIT |
| 1 | 15650 | 5000 |
| 2 | 11.545 | 35.000 |
| 3 | 7.425 | 32.003 |
| 4 | 5.200 | 28.533 |
| 5 | 40.875 | 25.678 |
| 6 | 37.285 | 22.468 |
| 7 | 32.985 | 20.688 |
| 8 | 32.085 | 17.128 |
| 9 | 32.085 | 13.753 |
| 10 | 30.850 | 10.893 |
| 11 | 27.545 | 10.893 |
| 12 | 24.650 | 10.893 |
| 13 | 24.650 | 7.297 |
| 14 | 24.650 | 3.977 |
| 15 | 24.650 | 3.357 |

| DATA STOCK HARIAN CHEMICALS | | | | |
|------------------------------------|---------|----------|---------|---------|
| NO | Non JIT | JIT | Non JIT | JIT |
| | A11 | A11 | A21 | A21 |
| 1 | 750 | 290 | 950 | 275 |
| 2 | 2625 | 2090 | 2100 | 2815 |
| 3 | 4810 | 1080 | 3350 | 2815 |
| 4 | 3520 | 2.003 | 3100 | 2.315 |
| 5 | 2160 | 1.500 | 2175 | 1975 |
| 6 | 1426 | 635 | 1125 | 1.585,0 |
| 7 | 900 | 230,5 | 600 | 765 |
| 8 | 525 | 1.740,50 | 600 | 200 |
| 9 | 525 | 890,5 | 600 | 925 |
| 10 | 2830 | 240,5 | 1250 | 455 |
| 11 | 2600 | 1245,5 | 925 | 205 |
| 12 | 1850 | 250,5 | 690 | 205 |
| 13 | 480 | 214,9 | 690 | 1555 |
| 14 | 480 | 214,9 | 690 | 660 |
| 15 | 480 | 214,9 | 690 | 184,2 |

13 Pemakaian Bahan Baku Benang Sebelum Just In Time

| No | Stock | Kebutuhan | Pemakaian | Kelebihan |
|----|-------|-----------|-----------|-----------|
| | Ry 30 | Ry 30 | | |
| 0 | 29,5 | 0 | 0 | |
| 1 | 42,5 | 12 | 12 | 0 |
| 2 | 53,4 | 14 | 14,1 | 0,1 |
| 3 | 38,3 | 15 | 15,1 | 0,1 |
| 4 | 26,3 | 12 | 12 | 0 |
| 5 | 26,3 | 0 | 0 | 0 |
| 6 | 26,3 | 0 | 0 | 0 |
| 7 | 26,3 | 0 | 0 | 0 |
| 8 | 26,3 | 0 | 0 | 0 |
| 9 | 37,3 | 14 | 14 | 0 |
| 10 | 47,2 | 15 | 15,1 | 0,1 |
| 11 | 56,1 | 16 | 16,1 | 0,1 |
| 12 | 61,1 | 20 | 20 | 0 |
| 13 | 63,1 | 18 | 18 | 0 |
| 14 | 45 | 18 | 18,1 | 0,1 |
| 15 | 29,3 | 15,5 | 15,7 | 0,2 |

| No | Stock | Kebutuhan | Pemakaian | Kelebihan |
|----|-------|-----------|-----------|-----------|
| | Tr 20 | Tr 20 | | |
| 0 | 32,5 | 0 | 0 | 0 |
| 1 | 42,5 | 15 | 15 | 0 |
| 2 | 50,5 | 17 | 17 | 0 |
| 3 | 61,4 | 14 | 14,1 | 0,1 |
| 4 | 58,4 | 18 | 18 | 0 |
| 5 | 43,3 | 15 | 15,1 | 0,1 |
| 6 | 28 | 15,1 | 15,3 | 0,2 |
| 7 | 28 | 0 | 0 | 0 |
| 8 | 28 | 0 | 0 | 0 |
| 9 | 41 | 12 | 12 | 0 |
| 10 | 28,5 | 12,4 | 12,5 | 0,1 |

14. Pemakaian Bahan Baku Chemicals Sebelum Just In Time

| No | Stock | Kebutuhan | Pemakaian | Kelebihan |
|----|-------|-----------|-----------|-----------|
| | A11 | A11 | | |
| 0 | 750 | 0 | 0 | 0 |
| 1 | 2625 | 1120 | 1125 | 5 |
| 2 | 4810 | 810 | 815 | 5 |
| 3 | 3520 | 1275 | 1290 | 15 |
| 4 | 2160 | 1350 | 1360 | 10 |
| 5 | 1426 | 725 | 734 | 9 |
| 6 | 900 | 500 | 526 | 26 |
| 7 | 525 | 375 | 375 | 0 |
| 8 | 525 | 0 | 0 | 0 |
| 9 | 2830 | 675 | 695 | 20 |
| 10 | 2600 | 230 | 230 | 0 |
| 11 | 1850 | 750 | 750 | 0 |
| 12 | 480 | 1350 | 1370 | 20 |

| No | Stock | Kebutuhan | Pemakaian | Kelebihan |
|----|-------|-----------|-----------|-----------|
| | A21 | A21 | | |
| 0 | 950 | 0 | 0 | 0 |
| 1 | 2100 | 825 | 850 | 25 |
| 2 | 3350 | 735 | 750 | 15 |
| 3 | 3100 | 750 | 750 | 0 |
| 4 | 2175 | 915 | 925 | 10 |
| 5 | 1125 | 1035 | 1050 | 15 |
| 6 | 600 | 500 | 525 | 25 |
| 7 | 600 | 0 | 0 | 0 |
| 8 | 600 | 0 | 0 | 0 |
| 9 | 1250 | 350 | 350 | 0 |
| 10 | 925 | 300 | 325 | 25 |
| 11 | 690 | 225 | 235 | 10 |

15. Pemakaian Bahan Baku Batu Bara Sebelum Just In Time

| TGL | Stock | kebutuhan | Pemakaian | Kelebihan (Kg) |
|-----|--------|-----------|-----------|-------------------|
| | BB | BB | | |
| 0 | 15650 | 0 | 0 | 0 |
| 1 | 11.545 | 4.100 | 4110 | 10 |
| 2 | 7.425 | 4.100 | 4120 | 20 |
| 3 | 5.200 | 2.200 | 2225 | 25 |
| 4 | 40.875 | 4.300 | 4.325 | 25 |
| 5 | 37.285 | 3.575 | 3590 | 15 |
| 6 | 36.100 | 1.150 | 1185 | 35 |
| 7 | 36.100 | 0 | 0 | 0 |
| 8 | 36.100 | 0 | 0 | 0 |
| 9 | 30.850 | 5.215 | 5250 | 35 |
| 10 | 27.545 | 3.300 | 3305 | 5 |
| 11 | 25.150 | 2.380 | 2395 | 15 |
| 12 | 24.650 | 500 | 500 | 0 |

16. Pemakaian Bahan Baku Benang Setelah Just In Time

| No | Kebutuhan | Pemakaian | Kelebihan |
|----|-----------|-----------|-----------|
| | Ry 30 | | |
| 1 | 26 | 26,2 | 0,2 |
| 2 | 17,5 | 17,6 | 0,1 |
| 3 | 4,5 | 4,5 | 0 |
| 4 | 26 | 26 | 0 |
| 5 | 32 | 32,1 | 0,1 |
| 6 | 17 | 17 | 0 |
| 7 | 16 | 16,2 | 0,2 |
| 8 | 43 | 43,2 | 0,2 |

| No | Kebutuhan | Pemakaian | Kelebihan |
|----|-----------|-----------|-----------|
| | Tr 20 | | |
| 1 | 27,1 | 27,1 | 0 |
| 2 | 30,7 | 30,7 | 0 |
| 3 | 29,5 | 29,6 | -0,1 |
| 4 | 23,7 | 23,7 | 0 |
| 5 | 22,1 | 22,1 | 0 |
| 6 | 22,1 | 22,1 | 0 |
| 7 | 6,7 | 6,9 | -0,2 |
| 8 | 31,5 | 31,5 | 0 |
| 9 | 17,5 | 17,5 | 0 |

17. Pemakaian Bahan Baku chemicals Setelah Just In Time

| No | Kebutuhan | Pemakaian | Kelebihan |
|----|-----------|-----------|-----------|
| | A11 | | |
| 1 | 1010 | 1010 | 0 |
| 2 | 852 | 852,5 | 0,5 |
| 3 | 500 | 503 | 3 |
| 4 | 863 | 865 | 2 |
| 5 | 400 | 404 | 4 |
| 6 | 890 | 890 | 0 |
| 7 | 850 | 850 | 0 |
| 8 | 649 | 650 | 1 |
| 9 | 1095 | 1095 | 0 |
| 10 | 895 | 895 | 0 |
| 11 | 132 | 135,6 | 3,6 |

| No | Kebutuhan | Pemakaian | Kelebihan |
|----|-----------|-----------|-----------|
| | A21 | | |
| 1 | 500 | 500 | 0 |
| 2 | 335 | 340 | 5 |
| 3 | 389 | 390 | 1 |
| 4 | 820 | 820 | 0 |
| 5 | 475 | 475 | 0 |
| 6 | 423 | 425 | 2 |
| 7 | 469 | 470 | 1 |
| 8 | 250 | 250 | 0 |
| 9 | 890 | 890,5 | 0,5 |
| 10 | 474 | 475,8 | 1,8 |

18. Pemakaian Bahan Baku Batu Bara Setelah Just In Time

| No | kebutuhan | Pemakaian | Kelebihan (Kg) |
|----|-----------|-----------|-------------------|
| | BB | | |
| 1 | 2.981 | 2997 | -16 |
| 2 | 3.463 | 3470 | -7 |
| 3 | 2.849 | 2855 | -6 |
| 4 | 3.191 | 3.210 | -19 |
| 5 | 1.771 | 1780 | -9 |
| 6 | 3.551 | 3560 | -9 |
| 7 | 3.375 | 3375 | 0 |
| 8 | 2.858 | 2860 | -2 |
| 9 | 3.590 | 3596 | -6 |
| 10 | 3310 | 3320 | -10 |
| 11 | 614 | 620 | -6 |