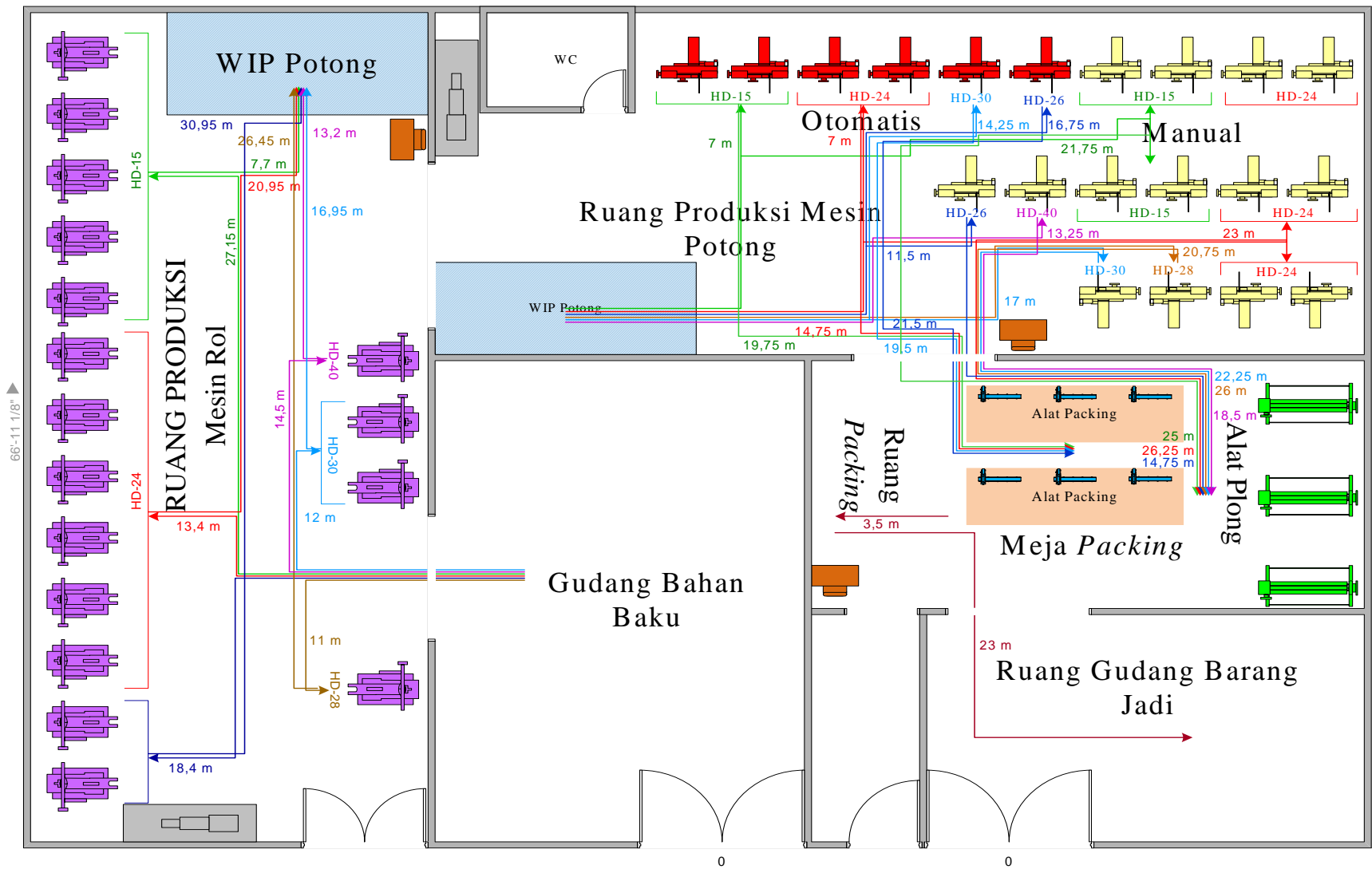


# **LAMPIRAN 1**

## **Sampel Bon Pengeluaran Barang Jadwal Pesanan**

## **LAMPIRAN 2**

### **Jarak Perpindahan Material**



## **LAMPIRAN 3**

**Waktu Proses per Gulung  
Perhitungan Waktu Perpindahan**

### Perhitungan Waktu Proses Per Gulung

- Data-data yang Diperlukan

Tipe Kantong Kresek a	Jmlh/ Pack (Lembar) b	Jmlh/ Ikat (Pack) c	Jmlh/ Bal (Ikat) d	Berat/Ikat (Kg) e	Berat/ Gulung (Kg) f	Berat/Bal (Kg) g	Jmlh Ikat/ Gulung h	Jmlh Lembar/ Gulung $i = b \times c \times h$	Jmlh Pak/ Gulung $j = i / b$
HD 15	100	10	30	1.8	22.5	54	12	12000	120
HD 24	100	10	15	2.9	27.5	43.5	9	9000	90
HD 26	100	10	10	4.2	30	42	7	7000	70
HD 28	100	10	6	6.5	32.5	39	5	5000	50
HD 30	100	10	5	7	40	35	5	5000	50
HD 40	50	5	10	4.25	42.5	42.5	10	2500	50

- Waktu Proses Per Gulung

Proses di-	Waktu Proses untuk Kantong Kresek Tipe – (menit)					
	HD 15	HD 24	HD 26	HD 28	HD 30	HD 40
M Rol	45	46	48	50	52	50
M Potong Otomatis	138	142	124	126	139	149
M Potong Manual	133	138	121	121	137	146

### Proses Pengeplongan

<b>Tipe Kantong Kresek</b> a	<b>Jmlh Ikat/ Gulung</b> b	<b>Waktu Proses per Ikat (dtk)</b> c	<b>Waktu Proses per Gulung (menit)</b> d = b x c
HD 15	12	26.69	5.34
HD 24	9	26.69	4.00
HD 26	7	26.69	3.11
HD 28	5	26.69	2.22
HD 30	5	26.69	2.22
HD 40	10	26.69	4.45

### Proses Pembungkusan Plastik

<b>Tipe Kantong Kresek</b> a	<b>Jmlh Pak/ Gulung</b> b	<b>Waktu Proses per Ikat (dtk)</b> c	<b>Waktu Proses per Gulung (menit)</b> d = b x c
HD 15	120	8.97	17.94
HD 24	90	8.97	13.46
HD 26	70	8.97	10.47
HD 28	50	8.97	7.48
HD 30	50	8.97	7.48
HD 40	50	8.97	7.48

### Proses Perekatan Plastik

<b>Tipe Kantong Kresek</b> a	<b>Jmlh Pak/ Gulung</b> b	<b>Waktu Proses per Ikat (dtk)</b> c	<b>Waktu Proses per Gulung (menit)</b> d = b x c
HD 15	120	7.66	15.32
HD 24	90	7.66	11.49
HD 26	70	7.66	8.94
HD 28	50	7.66	6.38
HD 30	50	7.66	6.38
HD 40	50	7.66	6.38

### Proses Pengikatan

Tipe Kantong Kresek a	Jmlh Ikat/ Gulung b	Waktu Proses per Ikat (dtk) c	Waktu Proses per Gulung (menit) d = b x c
HD 15	12	55.59	11.12
HD 24	9	55.59	8.34
HD 26	7	55.59	6.49
HD 28	5	55.59	4.63
HD 30	5	55.59	4.63
HD 40	10	55.59	9.27

### Proses Packing Karung

Tipe Kantong Kresek a	Jmlh Ikat/ Bal b	Jmlh Ikat/ Gulung c	Jmlh Gulung/ Bal d = b / c	Waktu Proses per Bal (menit) e	Waktu Proses per Gulung (menit) f = d x e
HD 15	30	12	2.5	3	7.5
HD 24	15	9	1.67	3	5
HD 26	10	7	1.43	3	4.29
HD 28	6	5	1.2	3	3.6
HD 30	5	5	1	3	3
HD 40	10	10	1	3	3

### Perhitungan Waktu Perpindahan

Asumsi Waktu perpindahan material adalah 12,57 detik per 8 meter.

Waktu perpindahan = (Jarak / 8 meter) x 12,57 detik

- Gudang Bahan Baku ke Mesin Rol

Tipe Kantong Kresek	Jarak (meter)	Waktu Perpindahan (dtk)
HD 15	27.15	42.66
HD 24	13.4	21.06
HD 26	18.4	28.91
HD 28	11	17.29
HD 30	12	18.86
HD 40	14.5	22.79

- Mesin Rol ke WIP Potong

Waktu perpindahan = ((Jarak / 8 meter) x 12,57 detik) + Wkt penurunan plastik dari mesin rol

Wkt penurunan plastik dari mesin rol = 60 detik

<b>Tipe Kantong Kresek</b>	<b>Jarak (meter)</b>	<b>Waktu Perpindahan (dtk)</b>
HD 15	7.7	1.20
HD 24	20.95	1.55
HD 26	30.95	1.81
HD 28	26.45	1.69
HD 30	16.95	1.44
HD 40	13.2	1.35

- WIP Potong ke Mesin Potong Otomatis

Waktu perpindahan = ((Jarak / 8 meter) x 12,57 detik) + Wkt penurunan plastik dari mesin rol

Wkt penurunan plastik dari mesin rol = 30 detik

<b>Tipe Kantong Kresek</b>	<b>Jarak (meter)</b>	<b>Waktu Perpindahan (dtk)</b>
HD 15	7	41
HD 24	7	41
HD 26	16.75	56.32
HD 28	-	-
HD 30	14.25	52.39
HD 40	-	-

- WIP Potong ke Mesin Potong Manual

Waktu perpindahan = ((Jarak / 8 meter) x 12,57 detik) + Wkt penurunan plastik dari mesin rol

Wkt penurunan plastik dari mesin rol = 30 detik

<b>Tipe Kantong Kresek</b>	<b>Jarak (meter)</b>	<b>Waktu Perpindahan (dtk)</b>
HD 15	21.75	64.18
HD 24	23	66.14
HD 26	11.5	48.07
HD 28	20.75	62.61
HD 30	17	56.71
HD 40	13.25	50.82



- Mesin Potong Otomatis ke WIP Packing

Waktu perpindahan = (Jarak / 8 meter) x 12,57 detik

<b>Tipe Kantong Kresek</b>	<b>Jarak (meter)</b>	<b>Waktu Perpindahan (dtk)</b>
HD 15	19.75	31.04
HD 24	14.75	23.18
HD 26	21.5	33.79
HD 28	-	
HD 30	19.5	30.64
HD 40	-	

- Mesin Potong Manual ke WIP Plong

Waktu perpindahan = (Jarak / 8 meter) x 12,57 detik

<b>Tipe Kantong Kresek</b>	<b>Jarak (meter)</b>	<b>Waktu Perpindahan (dtk)</b>
HD 15	25	39.29
HD 24	26.25	41.25
HD 26	14.75	23.18
HD 28	26	40.86
HD 30	22.25	34.96
HD 40	18.5	29.07

- Packing ke Packing Karung

Waktu perpindahan = (Jarak / 8 meter) x 12,57 detik + Waktu pengangkutan  
 (3,5 meter / 8 meter) x 12,57 detik + 10 detik  
 = 15,5 detik

- Packing Karung ke Gudang Barang Jadi

Waktu perpindahan = (Jarak / 8 meter) x 12,57 detik + Waktu pengangkutan  
 (23 meter / 8 meter) x 12,57 detik + 10 detik  
 = 46,14 detik

# **LAMPIRAN 4**

## **Pengujian Distribusi Jumlah Pesanan**

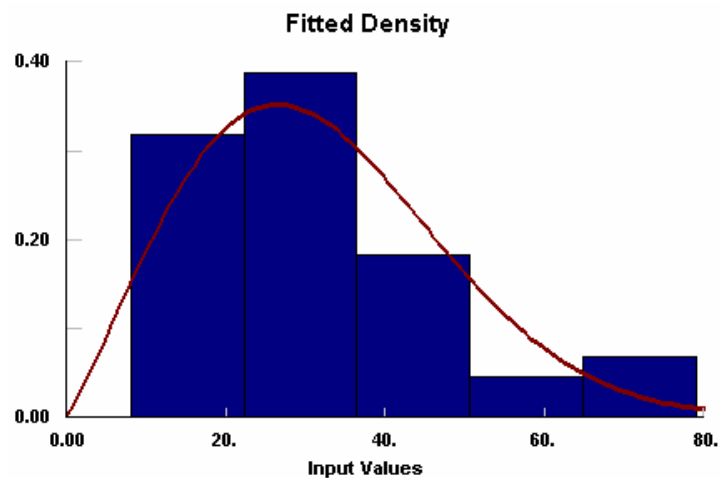
**Kantong Kresek HD-15**

<b>No</b>	<b>Data Permintaan HD-15</b>
1	31
2	26
3	44
4	33
5	24
6	27
7	44
8	27
9	20
10	34
11	12
12	15
13	17
14	23
15	17
16	19
17	17
18	19
19	67
20	35
21	37
22	55

<b>No</b>	<b>Data Permintaan HD-15</b>
23	61
24	48
25	79
26	44
27	42
28	42
29	18
30	42
31	71
32	15
33	25
34	36
35	28
36	24
37	12
38	26
39	8
40	27
41	21
42	29
43	32
44	22

## Auto::Fit of Distributions

distribution	rank	acceptance
Inverse Gaussian(0., 114, 31.7)	100	do not reject
Lognormal(0., 3.34, 0.496)	99.6	do not reject
Pearson 5(0., 4.19, 104)	98.7	do not reject
Pearson 6(0., 14.9, 12.1, 6.65)	98.6	do not reject
LogLogistic(0., 3.51, 28.1)	94.6	do not reject
Erlang(0., 4., 7.93)	92.7	do not reject
Gamma(0., 4.29, 7.4)	87.2	do not reject
Beta(0., 2.28e+005, 4.29, 3.09e+004)	80.1	do not reject
Rayleigh(0., 25.1)	74.7	do not reject
Inverse Weibull(0., 2.01, 4.57e-002)	66.9	do not reject
Weibull(0., 2.11, 36.)	64.1	do not reject
Triangular(0., 83., 18.9)	5.57	do not reject
Chi Squared(0., 29.1)	4.89e-003	reject
Exponential(0., 31.7)	1.04e-003	reject
Power Function(0., 80.2, 0.954)	1.07e-004	reject
Uniform(0., 79.)	5.9e-005	reject
Pareto	no fit	reject
Johnson SB	no fit	reject



goodness of fit

data points 44  
 estimates maximum likelihood estimates  
 accuracy of fit 3.e-004  
 level of significance 5.e-002

summary

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 2.28e+005, 4.29, 3.09e+004)	8.63e-002	0.275
Chi Squared(0., 29.1)	0.215	8.02
Erlang(0., 4., 7.93)	7.96e-002	0.261
Exponential(0., 31.7)	0.309	5.64
Gamma(0., 4.29, 7.4)	8.63e-002	0.274
Inverse Gaussian(0., 114, 31.7)	6.15e-002	0.136
Inverse Weibull(0., 2.01, 4.57e-002)	9.48e-002	0.629
Johnson SB	no fit	no fit
LogLogistic(0., 3.51, 28.1)	7.68e-002	0.154
Lognormal(0., 3.34, 0.496)	6.39e-002	0.132
Pareto	no fit	no fit
Pearson 5(0., 4.19, 104)	6.76e-002	0.232
Pearson 6(0., 14.9, 12.1, 6.65)	6.81e-002	0.134
Power Function(0., 80.2, 0.954)	0.299	5.12
Rayleigh(0., 25.1)	9.51e-002	0.619
Triangular(0., 83., 18.9)	0.149	1.12
Uniform(0., 79.)	0.307	7.36
Weibull(0., 2.11, 36.)	0.102	0.618

Weibull

minimum = 0. [fixed]  
 alpha = 2.11112  
 beta = 35.961

Kolmogorov-Smirnov

data points 44  
 ks stat 0.102  
 alpha 5.e-002  
 ks stat(44,5.e-002) 0.201  
 p-value 0.712  
 result DO NOT REJECT

Anderson-Darling

data points 44  
 ad stat 0.618  
 alpha 5.e-002  
 ad stat(5.e-002) 2.49  
 p-value 0.631  
 result DO NOT REJECT

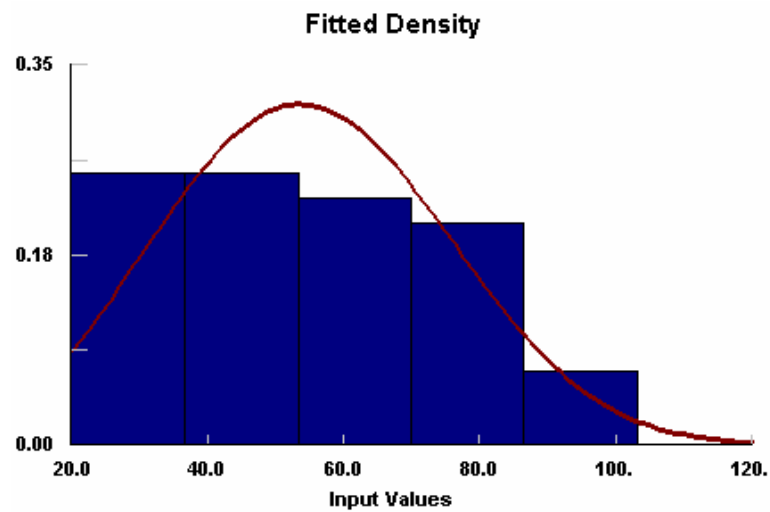
**Kantong Kresek HD-24**

No	Data Permintaan HD-24
1	85
2	67
3	90
4	58
5	56
6	64
7	79
8	73
9	52
10	73
11	34
12	26
13	46
14	40
15	35
16	32
17	53
18	34
19	71
20	58
21	38
22	49

No	Data Permintaan HD-24
23	71
24	66
25	93
26	71
27	39
28	59
29	28
30	86
31	103
32	37
33	44
34	74
35	52
36	33
37	31
38	31
39	20
40	58
41	52
42	63
43	62
44	28

## Auto::Fit of Distributions

distribution	rank	acceptance
Erlang(0., 7., 7.84)	97.8	do not reject
Gamma(0., 7.01, 7.83)	97.6	do not reject
Weibull(0., 2.97, 61.6)	87.5	do not reject
Pearson 6(0., 165, 9.05, 28.2)	83.8	do not reject
LogLogistic(0., 4.29, 51.9)	82.1	do not reject
Beta(0., 103, 3.39, 3.06)	78.6	do not reject
Lognormal(0., 3.93, 0.392)	64.	do not reject
Inverse Gaussian(0., 334, 54.9)	57.8	do not reject
Triangular(0., 107, 61.)	43.4	do not reject
Pearson 5(0., 6.48, 305)	29.7	do not reject
Inverse Weibull(0., 2.54, 2.4e-002)	11.8	reject
Rayleigh(0., 41.3)	11.5	reject
Uniform(0., 103)	3.17e-002	reject
Power Function(0., 105, 1.39)	1.01e-002	reject
Exponential(0., 54.9)	1.18e-005	reject
Chi Squared(0., 52.)	0.	reject
Johnson SB(0., 72.6, -0.707, 0.805)	0.	reject
Pareto	no fit	reject



goodness of fit

data points	44
estimates	maximum likelihood estimates
accuracy of fit	3.e-004
level of significance	5.e-002

summary

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 103, 3.39, 3.06)	9.57e-002	2.43
Chi Squared(0., 52.)	0.232	13.
Erlang(0., 7., 7.84)	8.78e-002	0.44
Exponential(0., 54.9)	0.355	7.94
Gamma(0., 7.01, 7.83)	8.8e-002	0.441
Inverse Gaussian(0., 334, 54.9)	0.115	0.568
Inverse Weibull(0., 2.54, 2.4e-002)	0.156	1.04
Johnson SB(0., 72.6, -0.707, 0.805)	1.	19.5
LogLogistic(0., 4.29, 51.9)	9.45e-002	0.622
Lognormal(0., 3.93, 0.392)	0.111	0.566
Pareto	no fit	no fit
Pearson 5(0., 6.48, 305)	0.136	0.761
Pearson 6(0., 165, 9.05, 28.2)	9.76e-002	0.5
Power Function(0., 105, 1.39)	0.246	3.51
Rayleigh(0., 41.3)	0.159	1.72
Triangular(0., 107, 61.)	9.67e-002	0.64
Uniform(0., 103)	0.23	5.
Weibull(0., 2.97, 61.6)	9.85e-002	0.358

Weibull

minimum	=	0. [fixed]
alpha	=	2.96509
beta	=	61.6235

Kolmogorov-Smirnov

data points	44
ks stat	9.85e-002
alpha	5.e-002
ks stat(44,5.e-002)	0.201
p-value	0.75
result	DO NOT REJECT

Anderson-Darling

data points	44
ad stat	0.358
alpha	5.e-002
ad stat(5.e-002)	2.49
p-value	0.889
result	DO NOT REJECT



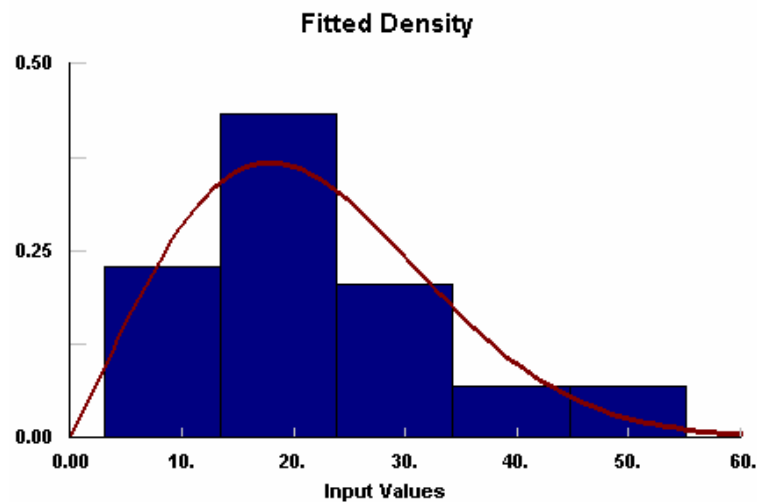
**Kantong Kresek HD-26**

No	Data Permintaan HD-26
1	40
2	48
3	55
4	28
5	25
6	34
7	46
8	36
9	26
10	31
11	18
12	21
13	23
14	25
15	14
16	23
17	18
18	14
19	18
20	13
21	15
22	18

No	Data Permintaan HD-26
23	18
24	15
25	15
26	15
27	11
28	16
29	3
30	16
31	22
32	9
33	12
34	23
35	12
36	10
37	11
38	11
39	8
40	19
41	37
42	29
43	34
44	27

### Auto::Fit of Distributions

distribution	rank	acceptance
Lognormal(0., 2.95, 0.544)	100	do not reject
LogLogistic(0., 3.32, 19.3)	93.2	do not reject
Inverse Gaussian(0., 61.2, 21.9)	91.4	do not reject
Pearson 6(0., 65.2, 4.97, 15.8)	89.2	do not reject
Gamma(0., 3.85, 5.68)	74.	do not reject
Erlang(0., 4., 5.47)	69.2	do not reject
Pearson 5(0., 3.1, 49.9)	65.3	do not reject
Rayleigh(0., 17.4)	63.4	do not reject
Beta(0., 941, 3.72, 156)	62.4	do not reject
Weibull(0., 2.06, 24.8)	51.4	do not reject
Inverse Weibull(0., 1.53, 6.97e-002)	13.	do not reject
Triangular(0., 57.5, 14.4)	4.82	do not reject
Chi Squared(0., 20.1)	0.387	do not reject
Exponential(0., 21.9)	1.67e-003	reject
Power Function(0., 56.3, 0.925)	1.38e-003	reject
Uniform(0., 55.)	5.07e-004	reject
Pareto	no fit	reject
Johnson SB	no fit	reject



**goodness of fit**

**data points** 44  
**estimates** maximum likelihood estimates  
**accuracy of fit** 3.e-004  
**level of significance** 5.e-002

**summary**

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 941, 3.72, 156)	0.102	0.295
Chi Squared(0., 20.1)	0.155	4.57
Erlang(0., 4., 5.47)	0.105	0.295
Exponential(0., 21.9)	0.304	5.27
Gamma(0., 3.85, 5.68)	0.1	0.284
Inverse Gaussian(0., 61.2, 21.9)	8.26e-002	0.401
Inverse Weibull(0., 1.53, 6.97e-002)	0.132	1.75
Johnson SB	no fit	no fit
LogLogistic(0., 3.32, 19.3)	8.03e-002	0.206
Lognormal(0., 2.95, 0.544)	6.59e-002	0.245
Pareto	no fit	no fit
Pearson 5(0., 3.1, 49.9)	0.103	0.718
Pearson 6(0., 65.2, 4.97, 15.8)	8.55e-002	0.221
Power Function(0., 56.3, 0.925)	0.254	4.87
Rayleigh(0., 17.4)	0.108	0.538
Triangular(0., 57.5, 14.4)	0.152	1.25
Uniform(0., 55.)	0.268	7.27
Weibull(0., 2.06, 24.8)	0.118	0.548

**Weibull**

**minimum** = 0. [fixed]  
**alpha** = 2.05999  
**beta** = 24.7659

**Kolmogorov-Smirnov**

**data points** 44  
**ks stat** 0.118  
**alpha** 5.e-002  
**ks stat(44,5.e-002)** 0.201  
**p-value** 0.53  
**result** DO NOT REJECT

**Anderson-Darling**

**data points** 44  
**ad stat** 0.548  
**alpha** 5.e-002  
**ad stat(5.e-002)** 2.49  
**p-value** 0.699  
**result** DO NOT REJECT

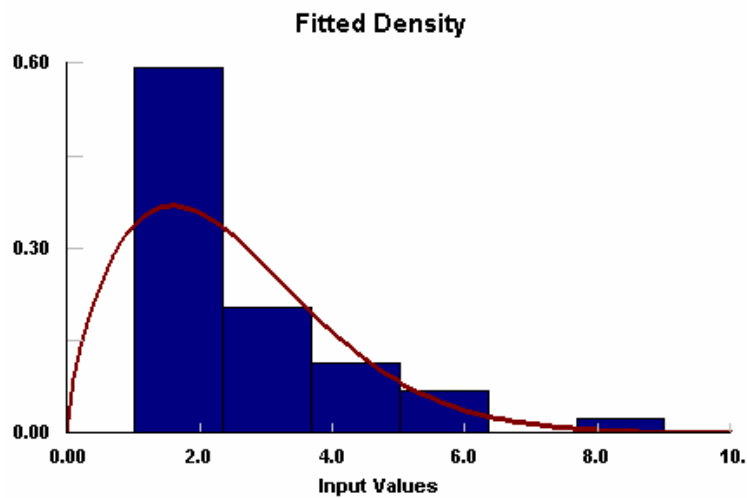
**Kantong Kresek HD-28**

No	Data Permintaan HD-28
1	1
2	2
3	5
4	1
5	9
6	1
7	5
8	3
9	1
10	4
11	4
12	2
13	3
14	2
15	4
16	1
17	2
18	2
19	2
20	1
21	3
22	2

No	Data Permintaan HD-28
23	1
24	1
25	3
26	4
27	1
28	3
29	1
30	3
31	2
32	3
33	1
34	2
35	1
36	6
37	2
38	4
39	1
40	1
41	1
42	3
43	3
44	2

## Auto::Fit of Distributions

distribution	rank	acceptance
Weibull(0., 1.66, 2.79)	100	do not reject
Gamma(0., 2.82, 0.879)	31.2	reject
Erlang(0., 3., 0.826)	19.6	reject
LogLogistic(0., 2.74, 2.04)	19.5	reject
Lognormal(0., 0.719, 0.607)	15.4	reject
Inverse Gaussian(0., 5.74, 2.48)	14.5	reject
Chi Squared(0., 2.98)	13.1	reject
Pearson 6(0., 0.142, 41.3, 3.3)	7.73	reject
Beta(0., 7.02e+005, 2.83, 8.03e+005)	7.54	reject
Pearson 5(0., 3.08, 5.33)	7.15	reject
Rayleigh(0., 2.1)	5.37	reject
Inverse Weibull(0., 1.93, 0.655)	4.51	reject
Exponential(0., 2.48)	1.17e-002	reject
Triangular(0., 9.28, 1.05)	2.21e-004	reject
Uniform(0., 9.)	0.	reject
Power Function(0., 13.5, 0.531)	0.	reject
Pareto	no fit	reject
Johnson SB	no fit	reject



goodness of fit

data points 44  
 estimates maximum likelihood estimates  
 accuracy of fit 3.e-004  
 level of significance 5.e-002

summary

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 7.02e+005, 2.83, 8.03e+005)	0.208	1.83
Chi Squared(0., 2.98)	0.202	2.64
Erlang(0., 3., 0.826)	0.218	1.97
Exponential(0., 2.48)	0.332	4.16
Gamma(0., 2.82, 0.879)	0.208	1.82
Inverse Gaussian(0., 5.74, 2.48)	0.225	2.06
Inverse Weibull(0., 1.93, 0.655)	0.237	2.81
Johnson SB	no fit	no fit
LogLogistic(0., 2.74, 2.04)	0.216	2.01
Lognormal(0., 0.719, 0.607)	0.223	2.05
Pareto	no fit	no fit
Pearson 5(0., 3.08, 5.33)	0.234	2.47
Pearson 6(0., 0.142, 41.3, 3.3)	0.233	2.42
Power Function(0., 13.5, 0.531)	0.385	9.39
Rayleigh(0., 2.1)	0.233	2.82
Triangular(0., 9.28, 1.05)	0.312	6.86
Uniform(0., 9.)	0.465	17.9
Weibull(0., 1.66, 2.79)	0.175	1.7

Weibull

minimum = 0. [fixed]  
 alpha = 1.65868  
 beta = 2.79416

Kolmogorov-Smirnov

data points 44  
 ks stat 0.175  
 alpha 5.e-002  
 ks stat(44,5.e-002) 0.201  
 p-value 0.121  
 result DO NOT REJECT

Anderson-Darling

data points 44  
 ad stat 1.7  
 alpha 5.e-002  
 ad stat(5.e-002) 2.49  
 p-value 0.136  
 result DO NOT REJECT

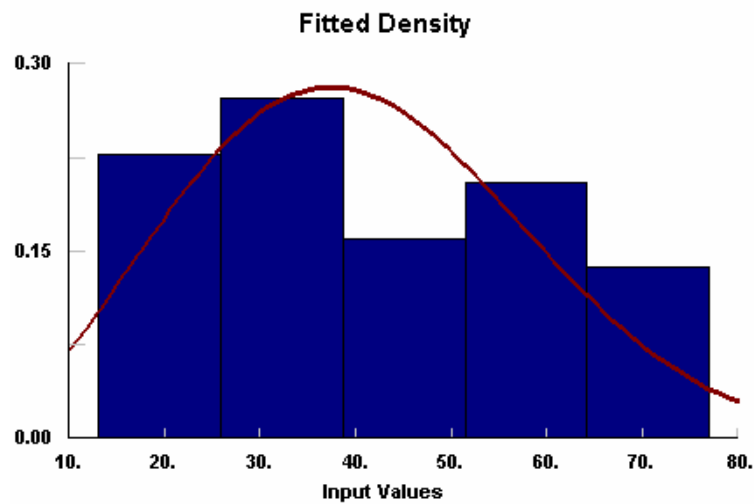
**Kantong Kresek HD-30**

No	Data Permintaan HD-30
1	66
2	62
3	77
4	39
5	52
6	66
7	69
8	66
9	51
10	71
11	42
12	52
13	30
14	58
15	30
16	26
17	46
18	32
19	19
20	40
21	15
22	28

No	Data Permintaan HD-30
23	32
24	35
25	27
26	29
27	22
28	32
29	13
30	32
31	47
32	21
33	15
34	48
35	21
36	19
37	24
38	29
39	19
40	56
41	55
42	63
43	57
44	53

Auto::Fit of Distributions

distribution	rank	acceptance
Rayleigh(0., 31.3)	100	do not reject
Gamma(0., 4.86, 8.35)	72.8	do not reject
Erlang(0., 5., 8.12)	65.8	do not reject
LogLogistic(0., 3.49, 37.2)	65.	do not reject
Pearson 6(0., 120, 6.23, 19.3)	63.1	do not reject
Triangular(0., 85.2, 31.)	57.9	do not reject
Lognormal(0., 3.6, 0.477)	56.2	do not reject
Inverse Gaussian(0., 162, 40.6)	52.5	do not reject
Weibull(0., 2.5, 45.9)	39.7	do not reject
Pearson 5(0., 4.41, 143)	35.8	do not reject
Inverse Weibull(0., 2.11, 3.5e-002)	34.2	do not reject
Beta(0., 77., 2.31, 2.12)	26.2	do not reject
Power Function(0., 77.7, 1.32)	1.7	do not reject
Uniform(0., 77.)	1.49	reject
Exponential(0., 40.6)	1.21e-003	reject
Chi Squared(0., 37.5)	0.	reject
Johnson SB(0., 61.5, -0.333, 0.899)	0.	reject
Pareto	no fit	reject





**goodness of fit**

data points **44**  
 estimates **maximum likelihood estimates**  
 accuracy of fit **3.e-004**  
 level of significance **5.e-002**

**summary**

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 77., 2.31, 2.12)	0.148	2.69
Chi Squared(0., 37.5)	0.294	16.1
Erlang(0., 5., 8.12)	0.118	0.681
Exponential(0., 40.6)	0.306	6.11
Gamma(0., 4.86, 8.35)	0.114	0.635
Inverse Gaussian(0., 162, 40.6)	0.124	0.699
Inverse Weibull(0., 2.11, 3.5e-002)	0.125	1.04
Johnson SB(0., 61.5, -0.333, 0.899)	1.	17.2
LogLogistic(0., 3.49, 37.2)	0.114	0.728
Lognormal(0., 3.6, 0.477)	0.122	0.691
Pareto	no fit	no fit
Pearson 5(0., 4.41, 143)	0.134	0.859
Pearson 6(0., 120, 6.23, 19.3)	0.119	0.663
Power Function(0., 77.7, 1.32)	0.168	1.93
Rayleigh(0., 31.3)	9.98e-002	0.766
Triangular(0., 85.2, 31.)	0.111	0.626
Uniform(0., 77.)	0.179	3.63
Weibull(0., 2.5, 45.9)	0.144	0.651

**Weibull**

minimum = **0. [fixed]**  
 alpha = **2.49708**  
 beta = **45.9334**

**Kolmogorov-Smirnov**

data points **44**  
 ks stat **0.144**  
 alpha **5.e-002**  
 ks stat(44,5.e-002) **0.201**  
 p-value **0.293**  
 result **DO NOT REJECT**

**Anderson-Darling**

data points **44**  
 ad stat **0.651**  
 alpha **5.e-002**  
 ad stat(5.e-002) **2.49**  
 p-value **0.601**  
 result **DO NOT REJECT**

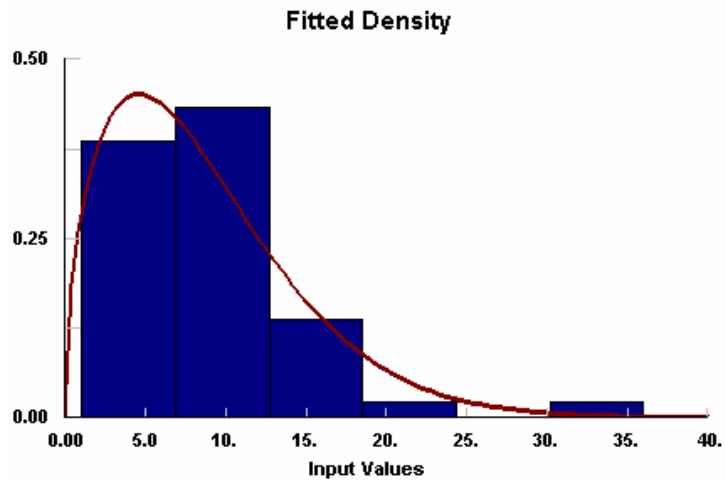
**Kantong Kresek HD-40**

No	Data Permintaan HD-40
1	7
2	9
3	19
4	9
5	9
6	6
7	9
8	14
9	8
10	6
11	6
12	7
13	1
14	1
15	1
16	3
17	5
18	3
19	14
20	15
21	16
22	11

No	Data Permintaan HD-40
23	11
24	9
25	14
26	36
27	2
28	9
29	9
30	18
31	7
32	12
33	3
34	12
35	8
36	10
37	4
38	3
39	3
40	4
41	4
42	4
43	10
44	11

Auto::Fit of Distributions

distribution	rank	acceptance
Weibull(0., 1.5, 9.64)	99.2	do not reject
Gamma(0., 2.08, 4.18)	75.2	do not reject
Erlang(0., 2., 4.34)	72.4	do not reject
Pearson 6(0., 34.7, 2.47, 10.8)	50.5	do not reject
LogLogistic(0., 2.3, 7.18)	46.8	do not reject
Beta(0., 36., 1.98, 6.94)	41.4	do not reject
Lognormal(0., 1.9, 0.784)	24.2	do not reject
Rayleigh(0., 7.53)	10.1	do not reject
Inverse Gaussian(0., 10.1, 8.68)	5.98	do not reject
Inverse Weibull(0., 1.13, 0.227)	2.71	reject
Chi Squared(0., 7.67)	2.16	do not reject
Pearson 5(0., 1.52, 7.1)	2.11	do not reject
Exponential(0., 8.68)	1.4	reject
Triangular(0., 37.2, 0.845)	2.32e-004	reject
Uniform(0., 36.)	0.	reject
Power Function(0., 325, 0.258)	0.	reject
Pareto	no fit	reject
Johnson SB	no fit	reject



**goodness of fit**

data points **44**  
 estimates **maximum likelihood estimates**  
 accuracy of fit **3.e-004**  
 level of significance **5.e-002**

**summary**

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 36., 1.98, 6.94)	0.133	2.41
Chi Squared(0., 7.67)	0.188	2.42
Erlang(0., 2., 4.34)	0.113	0.474
Exponential(0., 8.68)	0.201	2.51
Gamma(0., 2.08, 4.18)	0.112	0.461
Inverse Gaussian(0., 10.1, 8.68)	0.176	1.64
Inverse Weibull(0., 1.13, 0.227)	0.176	2.31
Johnson SB	no fit	no fit
LogLogistic(0., 2.3, 7.18)	0.127	0.783
Lognormal(0., 1.9, 0.784)	0.147	0.986
Pareto	no fit	no fit
Pearson 5(0., 1.52, 7.1)	0.19	2.23
Pearson 6(0., 34.7, 2.47, 10.8)	0.129	0.577
Power Function(0., 325, 0.258)	0.496	13.3
Rayleigh(0., 7.53)	0.164	1.85
Triangular(0., 37.2, 0.845)	0.287	5.51
Uniform(0., 36.)	0.497	21.3
Weibull(0., 1.5, 9.64)	9.42e-002	0.437

**Weibull**

minimum = **0. [fixed]**  
 alpha = **1.4963**  
 beta = **9.64354**

**Kolmogorov-Smirnov**

data points **44**  
 ks stat **9.42e-002**  
 alpha **5.e-002**  
 ks stat(44,5.e-002) **0.201**  
 p-value **0.796**  
 result **DO NOT REJECT**

**Anderson-Darling**

data points **44**  
 ad stat **0.437**  
 alpha **5.e-002**  
 ad stat(5.e-002) **2.49**  
 p-value **0.812**  
 result **DO NOT REJECT**

**LAMPIRAN 5**  
**Pengujian Distribusi Waktu**

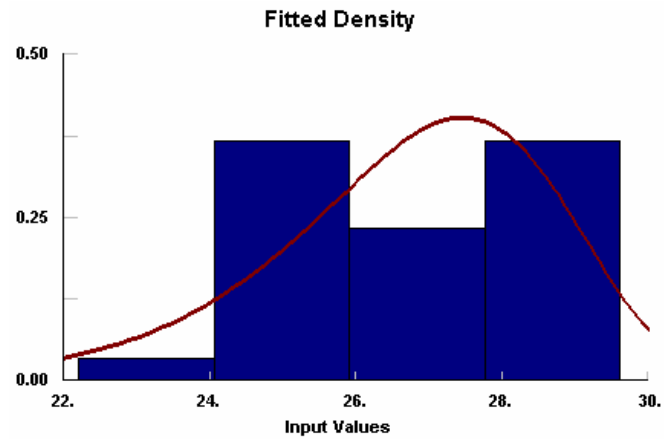
### Proses Pengeplongan

No	Waktu proses pengeplongan
1	24.39
2	26.65
3	25.76
4	29.45
5	25.45
6	25.19
7	28.9
8	24.69
9	25.64
10	27.61
11	22.2
12	28.26
13	28.34
14	29.62
15	26.58

No	Waktu proses pengeplongan
16	24.24
17	28.97
18	27.14
19	26.97
20	28.95
21	26.06
22	26.7
23	27.87
24	29.3
25	25.01
26	25.27
27	24.35
28	28.74
29	24.13
30	28.35

### Auto::Fit of Distributions

distribution	rank	acceptance
Weibull(0., 16.2, 27.6)	97.2	do not reject
LogLogistic(0., 22.9, 26.7)	89.7	reject
Lognormal(0., 3.28, 7.31e-002)	86.	reject
Pearson 5(0., 186, 4.93e+003)	85.5	reject
Beta(0., 29.6, 14.8, 1.67)	73.9	do not reject
Power Function(0., 29.6, 9.36)	16.7	reject
Rayleigh(0., 18.9)	3.47e-009	reject
Triangular(0., 30.4, 29.4)	0.	reject
Uniform(0., 29.6)	0.	reject
Johnson SB	no fit	reject



Weibull Distribution

**goodness of fit**

data points	30
estimates	maximum likelihood estimates
accuracy of fit	3.e-004
level of significance	5.e-002

**summary**

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 29.6, 14.8, 1.67)	0.116	2.66
Johnson SB	no fit	no fit
LogLogistic(0., 22.9, 26.7)	0.122	0.527
Lognormal(0., 3.28, 7.31e-002)	0.126	0.489
Pearson 5(0., 186, 4.93e+003)	0.127	0.493
Power Function(0., 29.6, 9.36)	0.159	1.02
Rayleigh(0., 18.9)	0.523	10.1
Triangular(0., 30.4, 29.4)	0.62	17.5
Uniform(0., 29.6)	0.781	38.9
Weibull(0., 16.2, 27.6)	0.118	0.56

**Weibull**  
 minimum = 0. [fixed]  
 alpha = 16.2443  
 beta = 27.5757  
**Kolmogorov-Smirnov**  
 data points 30  
 ks stat 0.118  
 alpha 5.e-002  
 ks stat(30,5.e-002) 0.242  
 p-value 0.751  
 result DO NOT REJECT  
**Anderson-Darling**  
 data points 30  
 ad stat 0.56  
 alpha 5.e-002  
 ad stat(5.e-002) 2.49  
 p-value 0.687  
 result DO NOT REJECT

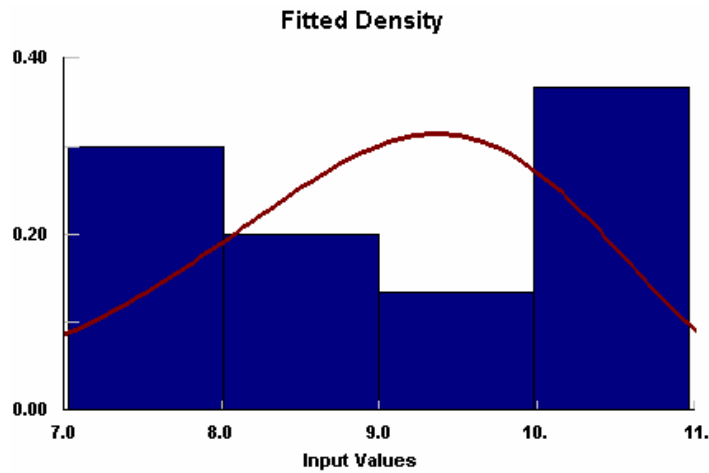
### Proses Pembungkusan Menggunakan Plastik

No	waktu proses pembungkusan	No	waktu proses pembungkusan
1	9.23	16	10.13
2	10.21	17	9.11
3	8.17	18	10.07
4	7.03	19	7.93
5	10.96	20	10.86
6	8.66	21	7.56
7	7.45	22	7.35
8	10.03	23	10.93
9	7.41	24	8.31
10	10.24	25	10.15
11	9.38	26	10.28
12	8.48	27	7.38
13	10.39	28	9.32
14	8.06	29	8.96
15	7.15	30	8.01



Auto::Fit of Distributions

distribution	rank	acceptance
Beta(0., 11., 6.42, 1.44)	62.6	do not reject
Weibull(0., 8.21, 9.52)	61.9	do not reject
Inverse Gaussian(0., 449, 8.97)	58.6	do not reject
LogLogistic(0., 11.5, 8.91)	43.9	reject
Gamma(0., 50.9, 0.176)	38.	do not reject
Erlang(0., 51., 0.176)	37.9	do not reject
Pearson 6(0., 9.7, 97., 106)	36.3	do not reject
Lognormal(0., 2.18, 0.141)	36.3	do not reject
Inverse Weibull(0., 7.77, 0.121)	35.3	reject
Pearson 5(0., 50.4, 444)	34.8	do not reject
Power Function(0., 11., 4.77)	16.5	do not reject
Chi Squared(0., 9.87)	2.77e-003	reject
Triangular(0., 11.2, 10.9)	1.14e-005	reject
Rayleigh(0., 6.41)	4.37e-006	reject
Exponential(0., 8.97)	8.37e-010	reject
Uniform(0., 11.)	0.	reject
Pareto	no fit	reject
Johnson SB	no fit	reject



Weibull Distribution

goodness of fit

data points	30
estimates	maximum likelihood estimates
accuracy of fit	3.e-004
level of significance	5.e-002

summary

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 11., 6.42, 1.44)	0.119	2.97
Chi Squared(0., 9.87)	0.349	5.11
Erlang(0., 51., 0.176)	0.171	0.791
Exponential(0., 8.97)	0.543	10.2
Gamma(0., 50.9, 0.176)	0.171	0.79
Inverse Gaussian(0., 449, 8.97)	0.151	0.829
Inverse Weibull(0., 7.77, 0.121)	0.165	0.875
Johnson SB	no fit	no fit
LogLogistic(0., 11.5, 8.91)	0.164	0.787
Lognormal(0., 2.18, 0.141)	0.172	0.797
Pareto	no fit	no fit
Pearson 5(0., 50.4, 444)	0.173	0.808
Pearson 6(0., 9.7, 97., 106)	0.172	0.798
Power Function(0., 11., 4.77)	0.157	1.39
Rayleigh(0., 6.41)	0.452	7.26
Triangular(0., 11.2, 10.9)	0.405	6.09
Uniform(0., 11.)	0.641	22.2
Weibull(0., 8.21, 9.52)	0.151	0.784

Weibull

minimum	=	0. [fixed]
alpha	=	8.20858
beta	=	9.52208

Kolmogorov-Smirnov

data points	30
ks stat	0.151
alpha	5.e-002
ks stat(30,5.e-002)	0.242
p-value	0.46
result	DO NOT REJECT

Anderson-Darling

data points	30
ad stat	0.784
alpha	5.e-002
ad stat(5.e-002)	2.49
p-value	0.492
result	DO NOT REJECT

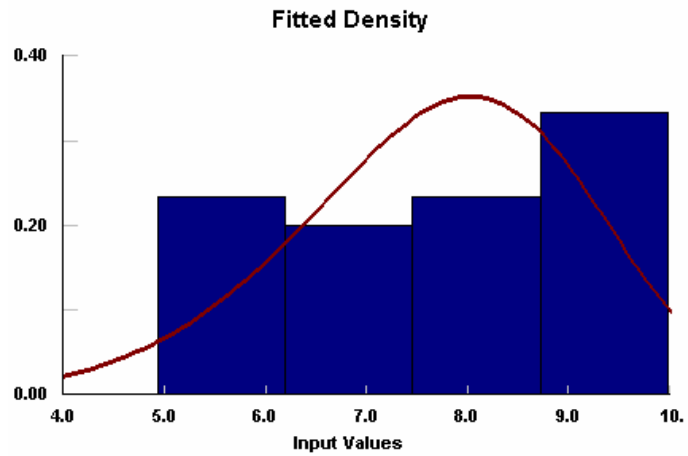
### Proses Perekatan Plastik Pembungkus

No	waktu proses perekatan
1	7.13
2	8.11
3	9.07
4	4.93
5	8.86
6	6.56
7	5.35
8	8.93
9	5.31
10	9.11
11	8.28
12	7.38
13	9.29
14	5.96
15	6.01

No	waktu proses perekatan
16	8.03
17	9.01
18	9.97
19	5.83
20	9.76
21	7.46
22	5.96
23	9.83
24	6.21
25	8.05
26	9.18
27	7.28
28	8.22
29	6.86
30	7.91

#### Auto::Fit of Distributions

distribution	rank	acceptance
Beta(0., 9.97, 5.34, 1.65)	91.7	do not reject
Weibull(0., 6.18, 8.26)	84.7	do not reject
LogLogistic(0., 8.34, 7.62)	78.2	do not reject
Lognormal(0., 2.02, 0.2)	56.	reject
Pearson 5(0., 24.4, 180)	43.4	reject
Power Function(0., 9.97, 3.53)	22.	reject
Triangular(0., 10.1, 9.8)	0.135	reject
Rayleigh(0., 5.52)	4.54e-003	reject
Uniform(0., 9.97)	0.	reject
Johnson SB	no fit	reject



Weibull Distribution

**goodness of fit**

data points	30
estimates	maximum likelihood estimates
accuracy of fit	3.e-004
level of significance	5.e-002

**summary**

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 9.97, 5.34, 1.65)	0.102	2.41
Johnson SB	no fit	no fit
LogLogistic(0., 8.34, 7.62)	0.113	0.65
Lognormal(0., 2.02, 0.2)	0.134	0.675
Pearson 5(0., 24.4, 180)	0.145	0.754
Power Function(0., 9.97, 3.53)	0.148	0.817
Rayleigh(0., 5.52)	0.338	5.39
Triangular(0., 10.1, 9.8)	0.25	2.87
Uniform(0., 9.97)	0.499	15.6
Weibull(0., 6.18, 8.26)	0.119	0.452

**Weibull**  
 minimum = 0. [fixed]  
 alpha = 6.18294  
 beta = 8.26316  
**Kolmogorov-Smirnov**  
 data points 30  
 ks stat 0.119  
 alpha 5.e-002  
 ks stat[30,5.e-002] 0.242  
 p-value 0.747  
 result DO NOT REJECT  
**Anderson-Darling**  
 data points 30  
 ad stat 0.452  
 alpha 5.e-002  
 ad stat[5.e-002] 2.49  
 p-value 0.796  
 result DO NOT REJECT

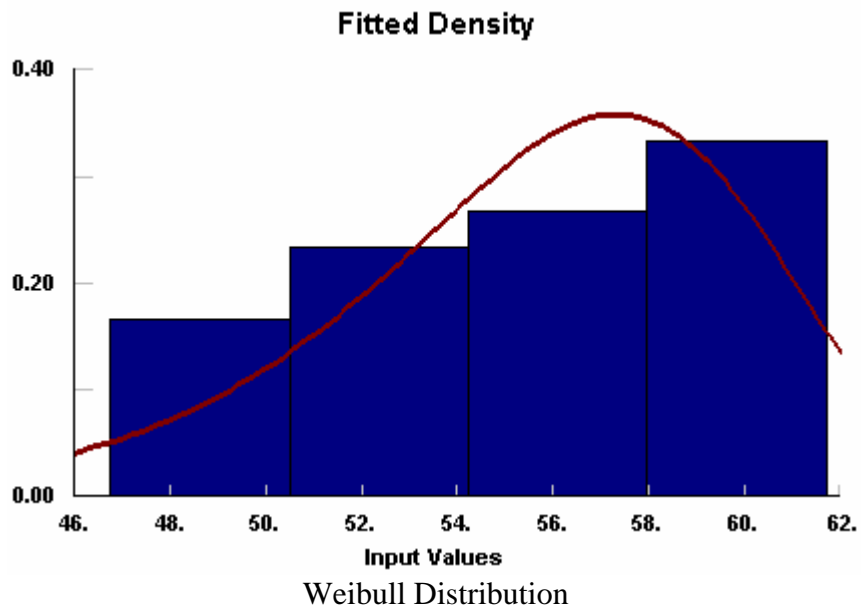
**Proses Pengikatan**

No	Waktu proses pengikatan
1	47.04
2	61.31
3	52.17
4	53.21
5	59.56
6	60.33
7	46.73
8	55.19
9	59.87
10	57.26
11	56.72
12	60.67
13	61.34
14	52.28
15	53.44

No	Waktu proses pengikatan
16	61.46
17	49.23
18	48.18
19	54.06
20	57.68
21	53.39
22	61.71
23	53.22
24	55.76
25	58.81
26	54.96
27	49.1
28	61.39
29	55.24
30	56.37

## Auto::Fit of Distributions

distribution	rank	acceptance
LogLogistic(0., 20.6, 55.7)	99.8	do not reject
Weibull(0., 14.9, 57.6)	98.2	do not reject
Lognormal(0., 4.01, 8.25e-002)	93.9	do not reject
Pearson 5(0., 145, 8.02e+003)	93.1	do not reject
Beta(0., 61.7, 10.5, 1.18)	61.4	do not reject
Power Function(0., 61.7, 9.26)	36.8	do not reject
Rayleigh(0., 39.4)	1.61 e-008	reject
Triangular(0., 63.3, 61.2)	0.	reject
Uniform(0., 61.7)	0.	reject
Johnson SB	no fit	reject



goodness of fit

data points	30
estimates	maximum likelihood estimates
accuracy of fit	3.e-004
level of significance	5.e-002

summary

distribution	Kolmogorov Smirnov	Anderson Darling
Beta(0., 61.7, 10.5, 1.18)	0.119	2.76
Johnson SB	no fit	no fit
LogLogistic(0., 20.6, 55.7)	0.107	0.525
Lognormal(0., 4.01, 8.25e-002)	0.11	0.58
Pearson 5(0., 145, 8.02e+003)	0.109	0.609
Power Function(0., 61.7, 9.26)	0.143	0.877
Rayleigh(0., 39.4)	0.505	9.76
Triangular(0., 63.3, 61.2)	0.564	17.5
Uniform(0., 61.7)	0.757	39.3
Weibull(0., 14.9, 57.6)	0.107	0.522

Weibull

minimum	=	0. [fixed]
alpha	=	14.9223
beta	=	57.6075

Kolmogorov-Smirnov

data points	30
ks stat	0.107
alpha	5.e-002
ks stat(30,5.e-002)	0.242
p-value	0.847
result	DO NOT REJECT

Anderson-Darling

data points	30
ad stat	0.522
alpha	5.e-002
ad stat(5.e-002)	2.49
p-value	0.724
result	DO NOT REJECT

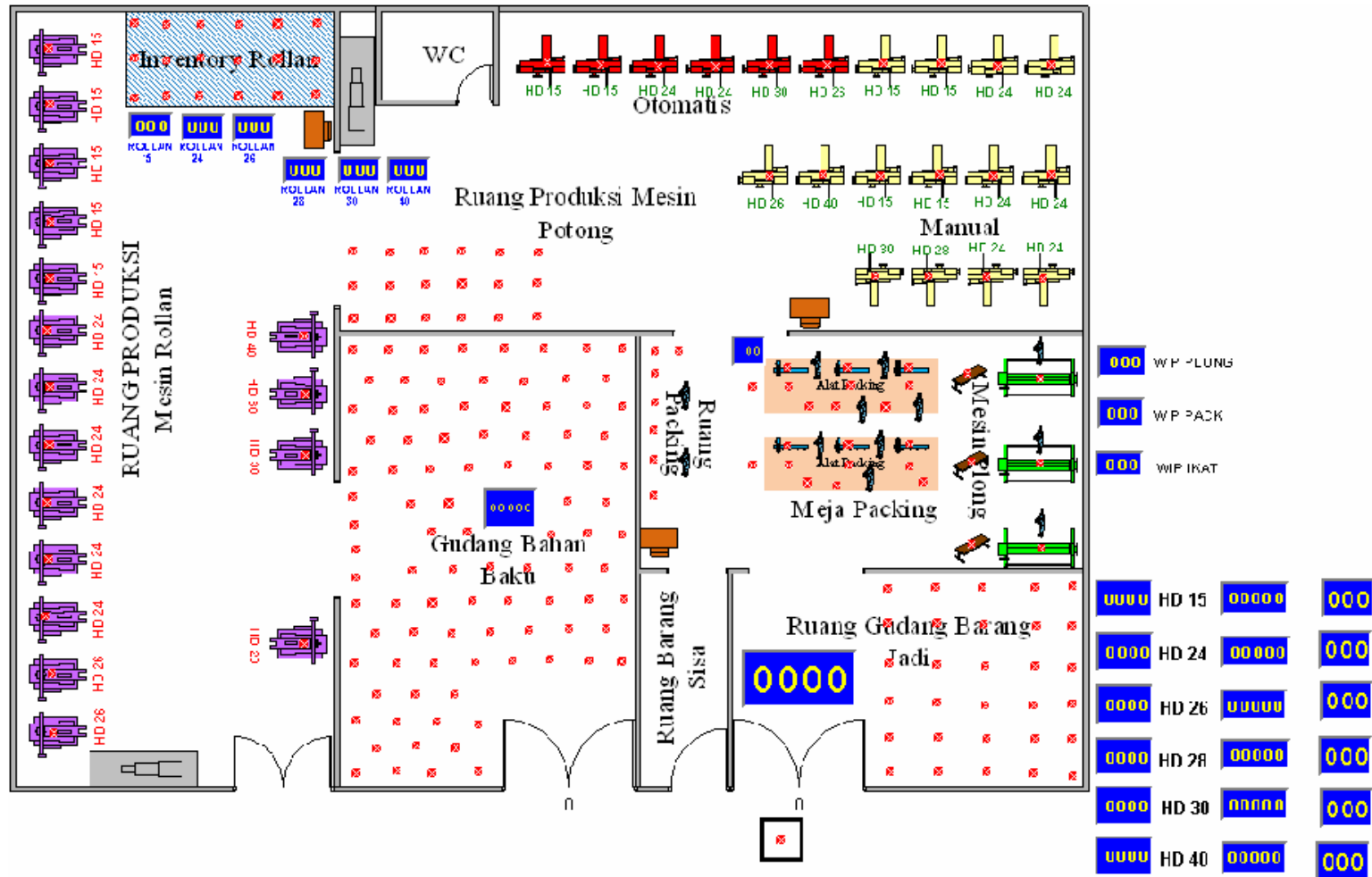
# **LAMPIRAN 6**

## **Simulasi Kondisi Aktual**

- *Layout Simulasi*
- *Input*
- **Output**



• *Layout Simulasi*



• **Input**

```
*****
*
*                               Formatted Listing of Model:                               *
* E:\DATA\Sherly Works\TA SHERLY\TA FIX\SIMULASI AKTUAL\New Folder\SIMULASI PABRIK AKTUAL FIX OK!!!!!!!!!.MOD COBA.MOD *
*
*****
```

```
Time Units:           day
Distance Units:      Feet
Initialization Logic:  ACTIVATE Sub1()
```

```
*****
*                               Locations                               *
*****
```

Name	Cap	Units	Stats	Rules	Cost
ROLLAN_15	1	5	Time Series	Oldest, , Longest Empty	
ROLLAN_15.1	1	1	Time Series	Oldest, ,	
ROLLAN_15.2	1	1	Time Series	Oldest, ,	
ROLLAN_15.3	1	1	Time Series	Oldest, ,	
ROLLAN_15.4	1	1	Time Series	Oldest, ,	
ROLLAN_15.5	1	1	Time Series	Oldest, ,	
ROLLAN_24	1	6	Time Series	Oldest, , Longest Empty	
ROLLAN_24.1	1	1	Time Series	Oldest, ,	
ROLLAN_24.2	1	1	Time Series	Oldest, ,	
ROLLAN_24.3	1	1	Time Series	Oldest, ,	
ROLLAN_24.4	1	1	Time Series	Oldest, ,	
ROLLAN_24.5	1	1	Time Series	Oldest, ,	
ROLLAN_24.6	1	1	Time Series	Oldest, ,	
ROLLAN_26	1	2	Time Series	Oldest, , Longest Empty	
ROLLAN_26.1	1	1	Time Series	Oldest, ,	

ROLLAN_26.2	1	1	Time Series Oldest, ,
ROLLAN_28	1	1	Time Series Oldest, ,
ROLLAN_30	1	2	Time Series Oldest, , Longest Empty
ROLLAN_30.1	1	1	Time Series Oldest, ,
ROLLAN_30.2	1	1	Time Series Oldest, ,
ROLLAN_40	1	1	Time Series Oldest, ,
POTONG_M_15	2	4	Time Series Oldest, , Fewest
POTONG_M_15.1	2	1	Time Series Oldest, ,
POTONG_M_15.2	2	1	Time Series Oldest, ,
POTONG_M_15.3	2	1	Time Series Oldest, ,
POTONG_M_15.4	2	1	Time Series Oldest, ,
POTONG_M_24	2	6	Time Series Oldest, , Fewest
POTONG_M_24.1	2	1	Time Series Oldest, ,
POTONG_M_24.2	2	1	Time Series Oldest, ,
POTONG_M_24.3	2	1	Time Series Oldest, ,
POTONG_M_24.4	2	1	Time Series Oldest, ,
POTONG_M_24.5	2	1	Time Series Oldest, ,
POTONG_M_24.6	2	1	Time Series Oldest, ,
POTONG_M_26	2	1	Time Series Oldest, , First
POTONG_M_28	2	1	Time Series Oldest, , First
POTONG_M_30	3	1	Time Series Oldest, , First
POTONG_O_15	2	2	Time Series Oldest, , Fewest
POTONG_O_15.1	2	1	Time Series Oldest, ,
POTONG_O_15.2	2	1	Time Series Oldest, ,
POTONG_O_24	2	2	Time Series Oldest, , Fewest
POTONG_O_24.1	2	1	Time Series Oldest, ,
POTONG_O_24.2	2	1	Time Series Oldest, ,
POTONG_O_26	2	1	Time Series Oldest, , First
POTONG_O_30	2	1	Time Series Oldest, , First
POTONG_M_40	2	1	Time Series Oldest, ,
PLONG	1	3	Time Series Oldest, , By turn
PLONG.1	1	1	Time Series Oldest, ,
PLONG.2	1	1	Time Series Oldest, ,
PLONG.3	1	1	Time Series Oldest, ,
PACK	6	1	Time Series Oldest, ,
PACKING	1	6	Time Series Oldest, , By turn
PACKING.1	1	1	Time Series Oldest, ,
PACKING.2	1	1	Time Series Oldest, ,

PACKING.3	1	1	Time Series Oldest, ,
PACKING.4	1	1	Time Series Oldest, ,
PACKING.5	1	1	Time Series Oldest, ,
PACKING.6	1	1	Time Series Oldest, ,
GUDANG_BAHAN	160000	1	Time Series Oldest, ,
INV_ROLLAN_15	1038	1	Time Series Oldest, ,
INV_ROLLAN_24	801	1	Time Series Oldest, ,
INV_ROLLAN_26	307	1	Time Series Oldest, ,
INV_ROLLAN_28	27	1	Time Series Oldest, ,
INV_ROLLAN_30	299	1	Time Series Oldest, ,
INV_ROLLAN_40	60	1	Time Series Oldest, ,
WIP_PLONG	4500	1	Time Series Oldest, , First
WIP_PACK	4500	1	Time Series Oldest, , First
IKAT	2	1	Time Series Oldest, , First
WIP_IKAT	4500	1	Time Series Oldest, ,
GUDANG_BARANG	4687	1	Time Series Oldest, ,
WIP_KARUNG	4500	1	Time Series Oldest, , First
BHN_BAKU_15	1	1	Time Series Oldest, ,
BHN_BAKU_24	1	1	Time Series Oldest, ,
BHN_BAKU_26	1	1	Time Series Oldest, ,
BHN_BAKU_28	1	1	Time Series Oldest, ,
BHN_BAKU_30	1	1	Time Series Oldest, ,
BHN_BAKU_40	1	1	Time Series Oldest, ,
TEMPAT_KARUNG	20000	1	Time Series Oldest, ,
KARUNG_HD_15	1	1	Time Series Oldest, ,
KARUNG_HD_24	1	1	Time Series Oldest, ,
KARUNG_HD_26	1	1	Time Series Oldest, ,
KARUNG_HD_28	1	1	Time Series Oldest, ,
KARUNG_HD_30	1	1	Time Series Oldest, ,
KARUNG_HD_40	1	1	Time Series Oldest, ,
ORDERAN	INF	1	Time Series Oldest, ,
PT_15	1	1	Time Series Oldest, ,
PT_24	1	1	Time Series Oldest, ,
PT_26	1	1	Time Series Oldest, ,
PT_28	1	1	Time Series Oldest, ,
PT_30	1	1	Time Series Oldest, ,
PT_40	1	1	Time Series Oldest, ,

```

*****
*                               Entities                               *
*****

```

Name	Speed (fpm)	Stats	Cost
HD_15	150	Time Series	
HD_24	150	Time Series	
HD_26	150	Time Series	
HD_28	150	Time Series	
HD_30	150	Time Series	
HD_40	150	Time Series	
BIJI_PLASTIK	150	Time Series	
PEWARNA	150	Time Series	
PESANAN	150	Time Series	
KARUNG_15	150	Time Series	
KARUNG_24	150	Time Series	
KARUNG_26	150	Time Series	
KARUNG_28	150	Time Series	
KARUNG_30	150	Time Series	
KARUNG_40	150	Time Series	

```

*****
*                               Path Networks                           *
*****

```

Name	Type	T/S	From	To	BI	Dist/Time	Speed Factor
Net1	Passing	Time	N1	N2	Bi	0 SEC	
			N1	N3	Bi	0 SEC	
			N1	N4	Bi	0 SEC	
			N1	N5	Bi	0 SEC	
			N1	N6	Bi	0 SEC	
			N2	N8	Bi	1.20 MIN	
			N3	N8	Bi	1.55 MIN	
			N4	N8	Bi	1.81 MIN	

Net2      Passing      Time

N6	N8	Bi	1.44 MIN
N5	N8	Bi	1.69 MIN
N1	N7	Bi	0 SEC
N7	N8	Bi	1.35 MIN
N2	N3	Bi	41 SEC
N2	N4	Bi	41 SEC
N2	N5	Bi	52.39 SEC
N2	N6	Bi	56.32 SEC
N2	N7	Bi	64.18 SEC
N2	N8	Bi	66.14 SEC
N2	N9	Bi	48.07 SEC
N2	N10	Bi	62.61 SEC
N2	N11	Bi	56.71 SEC
N2	N12	Bi	50.82 SEC
N3	N13	Bi	31.04 SEC
N4	N13	Bi	23.18 SEC
N5	N13	Bi	30.64 SEC
N6	N13	Bi	33.79 SEC
N7	N14	Bi	39.29 SEC
N8	N14	Bi	41.25 SEC
N9	N14	Bi	23.18 SEC
N10	N14	Bi	40.86 SEC
N11	N14	Bi	34.96 SEC
N12	N14	Bi	29.07 SEC
N15	N16	Bi	46.14 SEC

```

*****
*                               Interfaces                               *
*****

```

Net	Node	Location	
Net1	N1	BHN_BAKU_15	
	N1	BHN_BAKU_24	
	N1	BHN_BAKU_26	
	N1	BHN_BAKU_28	
	N1	BHN_BAKU_30	
	N1	BHN_BAKU_40	
	N2	ROLLAN_15	
	N3	ROLLAN_24	
	N4	ROLLAN_26	
	N5	ROLLAN_28	
	N6	ROLLAN_30	
	N7	ROLLAN_40	
	N8	INV_ROLLAN_15	
	N8	INV_ROLLAN_24	
	N8	INV_ROLLAN_26	
	N8	INV_ROLLAN_28	
	N8	INV_ROLLAN_30	
	N8	INV_ROLLAN_40	
	Net2	N3	POTONG_O_15
		N4	POTONG_O_24
N5		POTONG_O_30	
N6		POTONG_O_26	
N8		POTONG_M_24	
N9		POTONG_M_26	
N10		POTONG_M_28	
N11		POTONG_M_30	
N12		POTONG_M_40	
N13		WIP_PACK	
N14		WIP_PLONG	
N15		KARUNG_HD_15	
N15		KARUNG_HD_24	
N15		KARUNG_HD_26	

N15	KARUNG_HD_28
N15	KARUNG_HD_30
N15	KARUNG_HD_40
N16	GUDANG_BARANG
N2	PT_15
N2	PT_24
N2	PT_26
N2	PT_28
N2	PT_30
N2	PT_40
N7	POTONG_M_15

\*\*\*\*\*  
 \* Resources \*

Name	Units	Stats	Res Search	Ent Search	Path	Motion	Cost
OP_pack	12	By Unit	None	Oldest		Empty: 150 fpm Full: 150 fpm	

\*\*\*\*\*  
 \* Processing \*

Process			Routing				
Entity	Location	Operation	Blk	Output	Destination	Rule	Move Logic
PEWARNA	GUDANG_BAHAN		1	PEWARNA	BHN_BAKU_15	FIRST 1	MOVE FOR 0
				PEWARNA	BHN_BAKU_24	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_26	FIRST	MOVE FOR 0



				PEWARNA	BHN_BAKU_28	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_30	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_40	FIRST	MOVE FOR 0
BIJI_PLASTIK	GUDANG_BAHAN	1	BIJI_PLASTIK	BHN_BAKU_15	JOIN 1	MOVE FOR 0	
			BIJI_PLASTIK	BHN_BAKU_24	JOIN	MOVE FOR 0	
			BIJI_PLASTIK	BHN_BAKU_26	JOIN	MOVE FOR 0	
			BIJI_PLASTIK	BHN_BAKU_28	JOIN	MOVE FOR 0	
			BIJI_PLASTIK	BHN_BAKU_30	JOIN	MOVE FOR 0	
			BIJI_PLASTIK	BHN_BAKU_40	JOIN	MOVE FOR 0	
PEWARNA	BHN_BAKU_15		JOIN 9	BIJI_PLASTIK			
			IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_15 = 0 THEN				
			{				
			ROUTE 1				
			}				
			ELSE				
			{				
			DEC STOP_15				
			ROUTE 2				
			}				
		1	BIJI_PLASTIK	ROLLAN_15	FIRST 1	MOVE ON Net1	
		2	BIJI_PLASTIK	ROLLAN_15	SEND 1	MOVE ON Net1	
PEWARNA	BHN_BAKU_24		JOIN 11	BIJI_PLASTIK			
			IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_24 = 0 THEN				
			{				
			ROUTE 1				
			}				
			ELSE				
			{				
			DEC STOP_24				
			ROUTE 2				
			}				
		1	BIJI_PLASTIK	ROLLAN_24	FIRST 1	MOVE ON Net1	
		2	BIJI_PLASTIK	ROLLAN_24	SEND 1	MOVE ON Net1	

```

PEWARNA      BHN_BAKU_26  JOIN 12 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_26 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_26
                ROUTE 2
                }
                1      BIJI_PLASTIK ROLLAN_26      FIRST 1      MOVE ON Net1
                2      BIJI_PLASTIK ROLLAN_26      SEND 1      MOVE ON Net1

PEWARNA      BHN_BAKU_28  JOIN 13 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_28 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_28
                ROUTE 2
                }
                1      BIJI_PLASTIK ROLLAN_28      FIRST 1      MOVE ON Net1
                2      BIJI_PLASTIK ROLLAN_28      SEND 1      MOVE ON Net1

PEWARNA      BHN_BAKU_30  JOIN 16 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_30 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_30
                ROUTE 2
                }
                1      BIJI_PLASTIK ROLLAN_30      FIRST 1      MOVE ON Net1
                2      BIJI_PLASTIK ROLLAN_30      SEND 1      MOVE ON Net1

PEWARNA      BHN_BAKU_40  JOIN 17 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_40 = 0 THEN
                {
                ROUTE 1
                }

```

```

ELSE
{
DEC STOP_40
ROUTE 2
}
1 BIJI_PLASTIK ROLLAN_40 FIRST 1 MOVE ON Net1
2 BIJI_PLASTIK ROLLAN_40 SEND 1 MOVE ON Net1
BIJI_PLASTIK ROLLAN_15 WAIT 45 MIN
IF (CONTENTS(INV_ROLLAN_15) < 1028) and RuleRoute_15 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC RuleRoute_15
ROUTE 2
}
1 HD_15 INV_ROLLAN_15 FIRST 1 MOVE ON Net1
2 HD_15 INV_ROLLAN_15 SEND 1 MOVE ON Net1
BIJI_PLASTIK ROLLAN_24 WAIT 46 MIN
IF (CONTENTS(INV_ROLLAN_24) < 789) and RuleRoute_24 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC RuleRoute_24
ROUTE 2
}
1 HD_24 INV_ROLLAN_24 FIRST 1 MOVE ON Net1
2 HD_24 INV_ROLLAN_24 SEND 1 MOVE ON Net1
BIJI_PLASTIK ROLLAN_26 WAIT 48 MIN
IF (CONTENTS(INV_ROLLAN_26) < 303) and RuleRoute_26 = 0 THEN

```

```

{
ROUTE 1
}
ELSE
{
DEC RuleRoute_26
ROUTE 2
}
1 HD_26 INV_ROLLAN_26 FIRST 1
2 HD_26 INV_ROLLAN_26 SEND 1
MOVE ON Net1
MOVE ON Net1

BIJI_PLASTIK ROLLAN_28
WAIT 50 MIN
IF (CONTENTS(INV_ROLLAN_28) < 25) and RuleRoute_28 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC RuleRoute_28
ROUTE 2
}
1 HD_28 INV_ROLLAN_28 FIRST 1
2 HD_28 INV_ROLLAN_28 SEND 1
MOVE ON Net1
MOVE ON Net1

BIJI_PLASTIK ROLLAN_30
WAIT 52 MIN
IF (CONTENTS(INV_ROLLAN_30) < 295) and RuleRoute_30 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC RuleRoute_30
ROUTE 2
}
1 HD_30 INV_ROLLAN_30 FIRST 1
2 HD_30 INV_ROLLAN_30 SEND 1
MOVE ON Net1
MOVE ON Net1

```

```

BIJI_PLASTIK ROLLAN_40      WAIT 50 MIN
                             IF (CONTENTS(INV_ROLLAN_40) < 58) and RuleRoute_40 = 0 THEN
                             {
                             ROUTE 1
                             }
                             ELSE
                             {
                             DEC RuleRoute_40
                             ROUTE 2
                             }
                             1      HD_40      INV_ROLLAN_40 FIRST 1      MOVE ON Net1
                             2      HD_40      INV_ROLLAN_40 SEND 1      MOVE ON Net1

HD_15      INV_ROLLAN_15 IF CONTENTS(INV_ROLLAN_15) >= 1028 THEN
                             {
                             RuleRoute_15 = 5
                             Henti_15 = 1
                             }

                             1      HD_15      PT_15      FIRST 1      IF (CONTENTS(INV_ROLLAN_15) =
192) and (Henti_15 = 1) THEN
                             { WAIT 120 MIN
                             WAIT 45 MIN
                             SEND 5 HD_15 TO INV_ROLLAN_15

                             Henti_15 = 0
                             }

HD_24      INV_ROLLAN_24 IF CONTENTS(INV_ROLLAN_24) >= 789 THEN
                             {
                             RuleRoute_24 = 6
                             Henti_24 = 1
                             }

                             1      HD_24      PT_24      FIRST 1      IF (CONTENTS(INV_ROLLAN_24) =
180) and (Henti_24 = 1) THEN

```

```

{ WAIT 120 MIN
  WAIT 46 MIN
  SEND 6 HD_24 TO INV_ROLLAN_24

  Henti_24 = 0
}

HD_26      INV_ROLLAN_26 IF CONTENTS(INV_ROLLAN_26) >= 303 THEN
{
  RuleRoute_26 = 2
  Henti_26 = 1
}

and (Henti_26 = 1) THEN
1      HD_26      PT_26      FIRST 1  IF (CONTENTS(INV_ROLLAN_26) = 60)
{ WAIT 120 MIN
  WAIT 48 MIN
  SEND 2 HD_26 TO INV_ROLLAN_26

  Henti_26 = 0
}

HD_28      INV_ROLLAN_28 IF CONTENTS(INV_ROLLAN_28) >= 25 THEN
{
  RuleRoute_28 = 1
  Henti_28 = 1
}
and (Henti_28 = 1) THEN
1      HD_28      PT_28      FIRST 1  IF (CONTENTS(INV_ROLLAN_28) = 6)
{ WAIT 120 MIN
  WAIT 50 MIN
  SEND 1 HD_28 TO INV_ROLLAN_28

  Henti_28 = 0
}

HD_30      INV_ROLLAN_30 IF CONTENTS(INV_ROLLAN_30) >= 295 THEN
{
  RuleRoute_30 = 2
}

```

```

                Henti_30 = 1
            }

and (Henti_30 = 1) THEN
                                1    HD_30    PT_30    FIRST 1  IF (CONTENTS(INV_ROLLAN_30) = 50)
                                { WAIT 120 MIN
                                WAIT 52 MIN
                                SEND 2 HD_30 TO INV_ROLLAN_30

                                Henti_30 = 0
                                }

HD_40    INV_ROLLAN_40 IF CONTENTS(INV_ROLLAN_40) >= 58 THEN
            {
            RuleRoute_40 = 1
            Henti_40 = 1
            }

and (Henti_40 = 1) THEN
                                1    HD_40    PT_40    FIRST 1  IF (CONTENTS(INV_ROLLAN_40) = 12)
                                { WAIT 120 MIN
                                WAIT 50 MIN
                                SEND 1 HD_40 TO INV_ROLLAN_40

                                Henti_40 = 0
                                }

HD_15    PT_15    IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_15 = 0 THEN
            {
            ROUTE 1
            }
            ELSE
            {
            DEC STOP_15
            ROUTE 2
            }
                                1    HD_15    POTONG_O_15  FIRST 1  MOVE ON Net2
                                HD_15    POTONG_M_15  FIRST    MOVE ON Net2

```

```

                2      HD_15      POTONG_O_15  SEND 1      MOVE ON Net2
                HD_15      POTONG_M_15  SEND      MOVE ON Net2

HD_24      PT_24      IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_24 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_24
                ROUTE 2
                }

                1      HD_24      POTONG_O_24  FIRST 1      MOVE ON Net2
                HD_24      POTONG_M_24  FIRST      MOVE ON Net2
                2      HD_24      POTONG_O_24  SEND 1      MOVE ON Net2
                HD_24      POTONG_M_24  SEND      MOVE ON Net2

HD_26      PT_26      IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_26 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_26
                ROUTE 2
                }

                1      HD_26      POTONG_O_26  FIRST 1      MOVE ON Net2
                HD_26      POTONG_M_26  FIRST      MOVE ON Net2
                2      HD_26      POTONG_O_26  SEND 1      MOVE ON Net2
                HD_26      POTONG_M_26  SEND      MOVE ON Net2

HD_28      PT_28      IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_28 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_28

```



```

ROUTE 2
}
1 HD_28 POTONG_M_28 FIRST 1 MOVE ON Net2
2 HD_28 POTONG_M_28 SEND 1 MOVE ON Net2
HD_30 PT_30 IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_30 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC STOP_30
ROUTE 2
}
1 HD_30 POTONG_O_30 FIRST 1 MOVE ON Net2
HD_30 POTONG_M_30 FIRST MOVE ON Net2
2 HD_30 POTONG_O_30 SEND 1 MOVE ON Net2
HD_30 POTONG_M_30 SEND MOVE ON Net2
HD_40 PT_40 IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_40 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC STOP_40
ROUTE 2
}
1 HD_40 POTONG_M_40 FIRST 1 MOVE ON Net2
2 HD_40 POTONG_M_40 SEND 1 MOVE ON Net2
HD_15 POTONG_O_15 WAIT 138 MIN
1 HD_15 WIP_PACK FIRST 12 GRAPHIC 3
MOVE ON Net2
HD_24 POTONG_O_24 WAIT 142 MIN
1 HD_24 WIP_PACK FIRST 9 GRAPHIC 3
MOVE ON Net2
HD_26 POTONG_O_26 WAIT 124 MIN
1 HD_26 WIP_PACK FIRST 7 GRAPHIC 3

```

Job ID	Material	Operation	Wait Time	Quantity	Station	Program	Priority	Order	Graphic	Move
										MOVE ON Net2
HD_30	POTONG_O_30	WAIT 139 MIN		1	HD_30	WIP_PACK	FIRST 5		GRAPHIC 3	MOVE ON Net2
HD_40	POTONG_M_40	WAIT 146 MIN		1	HD_40	WIP_PLONG	FIRST 10		GRAPHIC 3	MOVE ON Net2
HD_15	POTONG_M_15	WAIT 133 MIN		1	HD_15	WIP_PLONG	FIRST 12		GRAPHIC 2	MOVE ON Net2
HD_24	POTONG_M_24	WAIT 138 MIN		1	HD_24	WIP_PLONG	FIRST 9		GRAPHIC 2	MOVE ON Net2
HD_26	POTONG_M_26	WAIT 121 MIN		1	HD_26	WIP_PLONG	FIRST 7		GRAPHIC 2	MOVE ON Net2
HD_28	POTONG_M_28	WAIT 121 MIN		1	HD_28	WIP_PLONG	FIRST 5		GRAPHIC 2	MOVE ON Net2
HD_30	POTONG_M_30	WAIT 137 MIN		1	HD_30	WIP_PLONG	FIRST 5		GRAPHIC 2	MOVE ON Net2
ALL	WIP_PLONG			1	ALL	PLONG	FIRST 1			MOVE FOR 0
ALL	PLONG	USE OP_pack FOR W(16.2443, 27.5757)SEC		1	ALL	WIP_PACK	FIRST 1		GRAPHIC 3	MOVE FOR 0

ALL WIP\_PACK 1 ALL PACK FIRST 1 MOVE FOR 0

ALL PACK USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
USE OP\_pack FOR W(8.20858, 9.52208)SEC  
1 ALL PACKING FIRST 1 MOVE FOR 0

HD\_15 PACKING USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
1 HD\_15 WIP\_IKAT FIRST 1 GRAPHIC 4  
MOVE FOR 0

HD\_24 PACKING USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
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USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
1 HD\_24 WIP\_IKAT FIRST 1 GRAPHIC 4  
MOVE FOR 0

HD\_26 PACKING USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
1 HD\_26 WIP\_IKAT FIRST 1 GRAPHIC 4  
MOVE FOR 0

HD\_28 PACKING USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
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USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
USE OP\_pack FOR W(6.18294, 8.26316)SEC  
1 HD\_28 WIP\_IKAT FIRST 1 GRAPHIC 4  
MOVE FOR 0

HD_30	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_30	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
HD_40	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_40	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
ALL	WIP_IKAT		1	ALL	IKAT	FIRST 1 MOVE FOR 0
ALL	IKAT	USE OP_pack FOR W(9.51749, 37.5274)SEC				
			1	ALL	WIP_KARUNG	FIRST 1 MOVE FOR 0
HD_15	WIP_KARUNG	ACCUM 6				

			1	HD_15	KARUNG_HD_15	JOIN 1	MOVE FOR 15.5 SEC
HD_24	WIP_KARUNG	ACCUM 6					
			1	HD_24	KARUNG_HD_24	JOIN 1	MOVE FOR 15.5 SEC
HD_26	WIP_KARUNG	ACCUM 6					
			1	HD_26	KARUNG_HD_26	JOIN 1	MOVE FOR 15.5 SEC
HD_28	WIP_KARUNG	ACCUM 6					
			1	HD_28	KARUNG_HD_28	JOIN 1	MOVE FOR 15.5 SEC
HD_30	WIP_KARUNG	ACCUM 6					
			1	HD_30	KARUNG_HD_30	JOIN 1	MOVE FOR 15.5 SEC
HD_40	WIP_KARUNG	ACCUM 6					
			1	HD_40	KARUNG_HD_40	JOIN 1	MOVE FOR 15.5 SEC
KARUNG_15	TEMPAT_KARUNG						
			1	KARUNG_15	KARUNG_HD_15	FIRST 1	
KARUNG_24	TEMPAT_KARUNG						
			1	KARUNG_24	KARUNG_HD_24	FIRST 1	
KARUNG_26	TEMPAT_KARUNG						
			1	KARUNG_26	KARUNG_HD_26	FIRST 1	
KARUNG_28	TEMPAT_KARUNG						
			1	KARUNG_28	KARUNG_HD_28	FIRST 1	
KARUNG_30	TEMPAT_KARUNG						
			1	KARUNG_30	KARUNG_HD_30	FIRST 1	
KARUNG_40	TEMPAT_KARUNG						
			1	KARUNG_40	KARUNG_HD_40	FIRST 1	
KARUNG_15	KARUNG_HD_15	JOIN 30 HD_15 USE OP_pack FOR 3 MIN					
			1	KARUNG_15	GUDANG_BARANG	FIRST 1	MOVE ON Net2

```

KARUNG_24    KARUNG_HD_24  JOIN 15 HD_24
              USE OP_pack FOR 3 MIN
              1      KARUNG_24    GUDANG_BARANG FIRST 1  MOVE ON Net2

KARUNG_26    KARUNG_HD_26  JOIN 10 HD_26
              USE OP_pack FOR 3 MIN
              1      KARUNG_26    GUDANG_BARANG FIRST 1  MOVE ON Net2

KARUNG_28    KARUNG_HD_28  JOIN 6 HD_28
              USE OP_pack FOR 3 MIN
              1      KARUNG_28    GUDANG_BARANG FIRST 1  MOVE ON Net2

KARUNG_30    KARUNG_HD_30  JOIN 5 HD_30
              USE OP_pack FOR 3 MIN
              1      KARUNG_30    GUDANG_BARANG FIRST 1  MOVE ON Net2

KARUNG_40    KARUNG_HD_40  JOIN 10 HD_40
              USE OP_pack FOR 3 MIN
              1      KARUNG_40    GUDANG_BARANG FIRST 1  MOVE ON Net2

ALL          GUDANG_BARANG IF CONTENTS(GUDANG_BARANG) >= 4600 THEN
              {
                STOP_15 = 1
                STOP_24 = 1
                STOP_26 = 1
                STOP_28 = 1
                STOP_30 = 1
                STOP_40 = 1
                BERHENTI = 1
              }

              gudang_15 = CONTENTS(GUDANG_BARANG, KARUNG_15)
              gudang_24 = CONTENTS(GUDANG_BARANG, KARUNG_24)
              gudang_26 = CONTENTS(GUDANG_BARANG, KARUNG_26)
              gudang_28 = CONTENTS(GUDANG_BARANG, KARUNG_28)

```

```
gudang_30 = CONTENTS(GUDANG_BARANG, KARUNG_30)
gudang_40 = CONTENTS(GUDANG_BARANG, KARUNG_40)
1      ALL      EXIT
```

```
SEND 1  IF (CONTENTS(GUDANG_BARANG) =
2000) and (BERHENTI = 1) THEN
{
  WAIT 120 MIN
  SEND 5 BIJI_PLASTIK TO ROLLAN_15
  SEND 6 BIJI_PLASTIK TO ROLLAN_24
  SEND 2 BIJI_PLASTIK TO ROLLAN_26
  SEND 1 BIJI_PLASTIK TO ROLLAN_40
  SEND 1 BIJI_PLASTIK TO ROLLAN_28
  SEND 2 BIJI_PLASTIK TO ROLLAN_30

  SEND 4 HD_15 TO POTONG_O_15
  SEND 4 HD_24 TO POTONG_O_24
  SEND 2 HD_26 TO POTONG_O_26
  SEND 2 HD_40 TO POTONG_O_30

  SEND 9 HD_15 TO POTONG_M_15
  SEND 12 HD_24 TO POTONG_M_24
  SEND 2 HD_26 TO POTONG_M_26
  SEND 2 HD_28 TO POTONG_M_28
  SEND 4 HD_30 TO POTONG_M_30
  SEND 2 HD_40 TO POTONG_M_40

  BERHENTI = 0
}
```

PESANAN            ORDERAN

```
PESANAN_15 = W(2.11, 35.961)
PESANAN_24 = W(2.965, 61.624)
PESANAN_26 = W(2.05999, 24.7659)
PESANAN_28 = W(1.65868, 2.79416)
PESANAN_30 = W(2.49708, 45.9334)
PESANAN_40 = W(1.4963, 9.64354)
```

```
SEND PESANAN_15 KARUNG_15 TO EXIT
SEND PESANAN_24 KARUNG_24 TO EXIT
SEND PESANAN_26 KARUNG_26 TO EXIT
```



SEND PESANAN\_28 KARUNG\_28 TO EXIT  
 SEND PESANAN\_30 KARUNG\_30 TO EXIT  
 SEND PESANAN\_40 KARUNG\_40 TO EXIT

TOTAL\_PESANAN\_15 = TOTAL\_PESANAN\_15 + PESANAN\_15  
 TOTAL\_PESANAN\_24 = TOTAL\_PESANAN\_24 + PESANAN\_24  
 TOTAL\_PESANAN\_26 = TOTAL\_PESANAN\_26 + PESANAN\_26  
 TOTAL\_PESANAN\_28 = TOTAL\_PESANAN\_28 + PESANAN\_28  
 TOTAL\_PESANAN\_30 = TOTAL\_PESANAN\_30 + PESANAN\_30  
 TOTAL\_PESANAN\_40 = TOTAL\_PESANAN\_40 + PESANAN\_40

1 PESANAN EXIT FIRST 1

\*\*\*\*\*  
 \* Arrivals \*  
 \*\*\*\*\*

Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
BIJI_PLASTIK	GUDANG_BAHAN	6000	0	INF	24 HR	
PEWARNA	GUDANG_BAHAN	600	0	INF	24 HR	
KARUNG_15	TEMPAT_KARUNG	2500	0	INF	480 HR	
KARUNG_24	TEMPAT_KARUNG	2500	0	INF	480 HR	
KARUNG_26	TEMPAT_KARUNG	1500	0	INF	480 HR	
KARUNG_28	TEMPAT_KARUNG	1000	0	INF	480 HR	
KARUNG_30	TEMPAT_KARUNG	1500	0	inf	480 HR	
KARUNG_40	TEMPAT_KARUNG	1000	0	INF	480 HR	
PESANAN	ORDERAN	1	2 HR	INF	24 HR	

\*\*\*\*\*  
 \* Shift Assignments \*  
 \*\*\*\*\*

Locations Resources Shift Files Priorities Disable Logic

ORDERAN

E:\DATA\Sherly Works\TA SHERLY 99,99,99,99 No

\*\*\*\*\*  
\* Variables (global) \*  
\*\*\*\*\*

ID	Type	Initial value	Stats
RuleRoute_15	Integer	0	Time Series
RuleRoute_24	Integer	0	Time Series
RuleRoute_26	Integer	0	Time Series
RuleRoute_28	Integer	0	Time Series
RuleRoute_30	Integer	0	Time Series
RuleRoute_40	Integer	0	Time Series
Henti_15	Integer	0	Time Series
Henti_24	Integer	0	Time Series
Henti_26	Integer	0	Time Series
Henti_28	Integer	0	Time Series
Henti_30	Integer	0	Time Series
Henti_40	Integer	0	Time Series
PESANAN_15	Integer	0	Time Series
PESANAN_24	Integer	0	Time Series
PESANAN_26	Integer	0	Time Series
PESANAN_28	Integer	0	Time Series
PESANAN_30	Integer	0	Time Series
PESANAN_40	Integer	0	Time Series
BERHENTI	Integer	0	Time Series
STOP_15	Integer	0	Time Series
STOP_24	Integer	0	Time Series
STOP_26	Integer	0	Time Series
STOP_28	Integer	0	Time Series
STOP_30	Integer	0	Time Series
STOP_40	Integer	0	Time Series
TOTAL_PESANAN_15	Integer	0	Time Series
TOTAL_PESANAN_24	Integer	0	Time Series

TOTAL_PESANAN_26	Integer	0	Time Series
TOTAL_PESANAN_28	Integer	0	Time Series
TOTAL_PESANAN_30	Integer	0	Time Series
TOTAL_PESANAN_40	Integer	0	Time Series
gudang_15	Integer	0	Time Series
gudang_24	Integer	0	Time Series
gudang_26	Integer	0	Time Series
gudang_28	Integer	0	Time Series
gudang_30	Integer	0	Time Series
gudang_40	Integer	0	Time Series

\*\*\*\*\*  
 \* Subroutines \*  
 \*\*\*\*\*

ID	Type	Parameter	Type	Logic
Sub1	None			ORDER 192 HD_15 TO INV_ROLLAN_15 ORDER 180 HD_24 TO INV_ROLLAN_24 ORDER 60 HD_26 TO INV_ROLLAN_26 ORDER 6 HD_28 TO INV_ROLLAN_28 ORDER 50 HD_30 TO INV_ROLLAN_30 ORDER 12 HD_40 TO INV_ROLLAN_40  ORDER 155 KARUNG_15 TO GUDANG_BARANG ORDER 332 KARUNG_24 TO GUDANG_BARANG ORDER 137 KARUNG_26 TO GUDANG_BARANG ORDER 17 KARUNG_28 TO GUDANG_BARANG ORDER 305 KARUNG_30 TO GUDANG_BARANG ORDER 54 KARUNG_40 TO GUDANG_BARANG

\*\*\*\*\*  
 \* External Files \*  
 \*\*\*\*\*

ID	Type	File Name	Prompt
(null)	Shift	E:\DATA\Sherly Works\TA SHERLY\PESANAN.sft	

- *Output*

-----  
 General Report

Output from E:\DATA\Sherly Works\TA SHERLY\TA FIX\SIMULASI AKTUAL\yang trakhir\SIMULASI  
 PABRIK AKTUAL FIX OK!!!!!!!!!.MOD COBA.MOD

Date: Apr/29/2008 Time: 09:48:28 AM  
 -----

Scenario : Normal Run

Replication : 1 of 1

Simulation Time : 1210 hr  
 -----

LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Days Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
ROLLAN 15.1	1210	1	828	0.06	1	1	1	100.00
ROLLAN 15.2	1210	1	828	0.06	1	1	1	100.00
ROLLAN 15.3	1210	1	828	0.06	1	1	1	100.00
ROLLAN 15.4	1210	1	828	0.06	1	1	1	100.00
ROLLAN 15.5	1210	1	828	0.06	1	1	1	100.00
ROLLAN 15	6050	5	4140	0.06	1	5	5	100.00
ROLLAN 24.1	1210	1	897	0.05	1	1	1	100.00
ROLLAN 24.2	1210	1	897	0.05	0.99	1	1	99.96
ROLLAN 24.3	1210	1	897	0.05	0.99	1	1	99.96

ROLLAN 24.4	1210	1	897	0.05	0.99	1	1	99.96
ROLLAN 24.5	1210	1	897	0.05	0.99	1	1	99.94
ROLLAN 24.6	1210	1	897	0.05	0.99	1	1	99.94
ROLLAN 24	7260	6	5382	0.05	0.99	6	6	99.96
ROLLAN 26.1	1210	1	816	0.03	0.64	1	1	64.19
ROLLAN 26.2	1210	1	815	0.03	0.64	1	1	64.13
ROLLAN 26	2420	2	1631	0.03	0.64	2	2	64.16
ROLLAN 28	1210	1	775	0.04	0.64	1	1	64.18
ROLLAN 30.1	1210	1	896	0.03	0.64	1	1	64.13
ROLLAN 30.2	1210	1	896	0.03	0.64	1	1	64.13
ROLLAN 30	2420	2	1792	0.03	0.64	2	2	64.13
ROLLAN 40	1210	1	659	0.04	0.64	1	1	64.20
POTONG M 15.1	1210	2	698	0.09	1.27	2	2	63.77
POTONG M 15.2	1210	2	698	0.09	1.27	2	2	63.77
POTONG M 15.3	1210	2	696	0.09	1.27	2	2	63.69
POTONG M 15.4	1210	2	696	0.09	1.27	2	2	63.69
POTONG M 15	4840	8	2788	0.09	1.27	8	8	63.73
POTONG M 24.1	1210	2	671	0.09	1.27	2	2	63.69
POTONG M 24.2	1210	2	670	0.09	1.27	2	1	63.64
POTONG M 24.3	1210	2	670	0.09	1.27	2	2	63.59
POTONG M 24.4	1210	2	670	0.09	1.27	2	2	63.59
POTONG M 24.5	1210	2	670	0.09	1.27	2	2	63.59
POTONG M 24.6	1210	2	670	0.09	1.27	2	2	63.59
POTONG M 24	7260	12	4021	0.09	1.27	12	11	63.62
POTONG M 26	1210	2	767	0.08	1.27	2	2	63.90
POTONG M 28	1210	2	765	0.08	1.27	2	2	63.71
POTONG M 30	1210	3	1014	0.09	1.91	3	3	63.67
POTONG O 15.1	1210	2	675	0.09	1.27	2	2	63.99
POTONG O 15.2	1210	2	674	0.09	1.27	2	2	63.90

POTONG O 15	2420	4	1349	0.09	1.27	4	4	63.95
POTONG O 24.1	1210	2	654	0.09	1.27	2	2	63.89
POTONG O 24.2	1210	2	654	0.09	1.27	2	2	63.89
POTONG O 24	2420	4	1308	0.09	1.27	4	4	63.89
POTONG O 26	1210	2	748	0.08	1.27	2	2	63.75
POTONG O 30	1210	2	667	0.09	1.27	2	2	63.80
POTONG M 40	1210	2	636	0.10	1.27	2	2	63.82
PLONG.1	1210	1	29972	0.00	0.21	1	1	21.92
PLONG.2	1210	1	30007	0.00	0.21	1	1	21.94
PLONG.3	1210	1	30013	0.00	0.21	1	1	21.94
PLONG	3630	3	89992	0.00	0.21	3	3	21.93
PACK	1210	6	126399	0.00	3.28	6	6	54.72
PACKING.1	1210	1	21565	0.00	0.50	1	1	50.22
PACKING.2	1210	1	21410	0.00	0.50	1	1	50.15
PACKING.3	1210	1	21189	0.00	0.49	1	1	49.85
PACKING.4	1210	1	20994	0.00	0.49	1	1	49.62
PACKING.5	1210	1	20729	0.00	0.49	1	1	49.16
PACKING.6	1210	1	20506	0.00	0.48	1	1	48.76
PACKING	7260	6	126393	0.00	0.49	6	6	49.62
GUDANG BAHAN	1210	160000	336600	7.19	48009.3	158319	156153	30.01
INV ROLLAN 15	1210	1038	4327	8.10	695.26	1028	189	66.98
INV ROLLAN 24	1210	801	5556	5.01	552.11	789	225	68.93
INV ROLLAN 26	1210	307	1689	4.22	141.60	303	173	46.13
INV ROLLAN 28	1210	27	780	0.81	12.68	25	14	46.98
INV ROLLAN 30	1210	299	1840	3.16	115.56	159	158	38.65
INV ROLLAN 40	1210	60	670	3.05	40.57	58	33	67.63
WIP PLONG	1210	4500	90006	0.00	10.71	206	14	0.24
WIP PACK	1210	4500	126412	0.01	30.51	222	13	0.68
IKAT	1210	2	126380	0.00	1.13	2	2	56.73

WIP IKAT	1210	4500	126387	0.00	3.65	30	7	0.08
GUDANG BARANG	1210	4687	9835	14.94	2915.42	4633	2646	62.20
WIP KARUNG	1210	4500	126378	0.00	12.57	34	18	0.28
BHN BAKU 15	1210	1	4141	0.01	1	1	1	100.00
BHN BAKU 24	1210	1	5383	0.00	1	1	1	100.00
BHN BAKU 26	1210	1	1632	0.03	1	1	1	100.00
BHN BAKU 28	1210	1	776	0.06	1	1	1	100.00
BHN BAKU 30	1210	1	1793	0.02	1	1	1	100.00
BHN BAKU 40	1210	1	660	0.07	1	1	1	100.00
TEMPAT KARUNG	1210	20000	27408	22.22	12079.5	20000	18567	60.40
KARUNG HD 15	1210	1	1649	0.03	1	1	1	100.00
KARUNG HD 24	1210	1	3188	0.01	1	1	1	100.00
KARUNG HD 26	1210	1	1058	0.04	1	1	1	100.00
KARUNG HD 28	1210	1	636	0.07	1	1	1	100.00
KARUNG HD 30	1210	1	1676	0.03	1	1	1	100.00
KARUNG HD 40	1210	1	634	0.07	1	1	1	100.00
ORDERAN	396	999999	44	0.00	0	1	0	0.00
PT 15	1210	1	4138	0.01	0.99	1	1	99.92
PT 24	1210	1	5331	0.00	0.99	1	1	99.92
PT 26	1210	1	1516	0.03	0.99	1	1	99.91
PT 28	1210	1	766	0.06	0.99	1	1	99.37
PT 30	1210	1	1682	0.02	1	1	1	100.00
PT 40	1210	1	637	0.07	0.99	1	1	99.64

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location	Scheduled	% Partially	%	%
----------	-----------	-------------	---	---

Name	Hours	Empty	Occupied	Full	Down
POTONG M 15.1	1210	36.23	0.00	63.77	0.00
POTONG M 15.2	1210	36.23	0.00	63.77	0.00
POTONG M 15.3	1210	36.31	0.00	63.69	0.00
POTONG M 15.4	1210	36.31	0.00	63.69	0.00
POTONG M 15	4840	36.27	0.00	63.73	0.00
POTONG M 24.1	1210	36.22	0.19	63.59	0.00
POTONG M 24.2	1210	36.29	0.14	63.56	0.00
POTONG M 24.3	1210	36.41	0.00	63.59	0.00
POTONG M 24.4	1210	36.41	0.00	63.59	0.00
POTONG M 24.5	1210	36.41	0.00	63.59	0.00
POTONG M 24.6	1210	36.41	0.00	63.59	0.00
POTONG M 24	7260	36.35	0.06	63.59	0.00
POTONG M 26	1210	36.02	0.17	63.81	0.00
POTONG M 28	1210	36.21	0.17	63.62	0.00
POTONG M 30	1210	36.33	0.00	63.67	0.00
POTONG O 15.1	1210	35.91	0.19	63.90	0.00
POTONG O 15.2	1210	36.10	0.00	63.90	0.00
POTONG O 15	2420	36.01	0.10	63.90	0.00
POTONG O 24.1	1210	36.11	0.00	63.89	0.00
POTONG O 24.2	1210	36.11	0.00	63.89	0.00
POTONG O 24	2420	36.11	0.00	63.89	0.00
POTONG O 26	1210	36.25	0.00	63.75	0.00
POTONG O 30	1210	36.11	0.19	63.70	0.00
POTONG M 40	1210	35.79	0.79	63.42	0.00
PACK	1210	44.31	2.01	53.68	0.00
Gudang Bahan	1210	0.00	100.00	0.00	0.00
INV ROLLAN 15	1210	0.00	100.00	0.00	0.00



INV ROLLAN 24	1210	0.00	100.00	0.00	0.00
INV ROLLAN 26	1210	0.00	100.00	0.00	0.00
INV ROLLAN 28	1210	0.00	100.00	0.00	0.00
INV ROLLAN 30	1210	0.00	100.00	0.00	0.00
INV ROLLAN 40	1210	0.00	100.00	0.00	0.00
WIP PLONG	1210	78.84	21.16	0.00	0.00
WIP PACK	1210	46.99	53.01	0.00	0.00
IKAT	1210	42.30	1.93	55.77	0.00
WIP IKAT	1210	49.96	50.04	0.00	0.00
GUDANG BARANG	1210	0.00	100.00	0.00	0.00
WIP KARUNG	1210	0.19	99.81	0.00	0.00
TEMPAT KARUNG	1210	0.00	89.70	10.30	0.00
ORDERAN	396	100.00	0.00	0.00	0.00

LOCATION STATES BY PERCENTAGE (Single Capacity/Tanks)

Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down
-----	-----	-----	-----	-----	-----	-----	-----
ROLLAN 15.1	1210	51.31	0.00	0.00	48.69	0.00	0.00
ROLLAN 15.2	1210	51.31	0.00	0.00	48.69	0.00	0.00
ROLLAN 15.3	1210	51.31	0.00	0.00	48.69	0.00	0.00
ROLLAN 15.4	1210	51.31	0.00	0.00	48.69	0.00	0.00
ROLLAN 15.5	1210	51.31	0.00	0.00	48.69	0.00	0.00
ROLLAN 15	6050	51.31	0.00	0.00	48.69	0.00	0.00
ROLLAN 24.1	1210	56.81	0.00	0.00	43.19	0.00	0.00
ROLLAN 24.2	1210	56.81	0.00	0.04	43.15	0.00	0.00
ROLLAN 24.3	1210	56.81	0.00	0.04	43.15	0.00	0.00

ROLLAN 24.4	1210	56.81	0.00	0.04	43.15	0.00	0.00
ROLLAN 24.5	1210	56.81	0.00	0.06	43.13	0.00	0.00
ROLLAN 24.6	1210	56.81	0.00	0.06	43.13	0.00	0.00
ROLLAN 24	7260	56.81	0.00	0.04	43.15	0.00	0.00
ROLLAN 26.1	1210	53.91	0.00	35.81	10.28	0.00	0.00
ROLLAN 26.2	1210	53.84	0.00	35.87	10.29	0.00	0.00
ROLLAN 26	2420	53.88	0.00	35.84	10.28	0.00	0.00
ROLLAN 28	1210	53.31	0.00	35.82	10.87	0.00	0.00
ROLLAN 30.1	1210	64.13	0.00	35.87	0.00	0.00	0.00
ROLLAN 30.2	1210	64.13	0.00	35.87	0.00	0.00	0.00
ROLLAN 30	2420	64.13	0.00	35.87	0.00	0.00	0.00
ROLLAN 40	1210	45.33	0.00	35.80	18.87	0.00	0.00
PLONG.1	1210	18.40	0.00	78.08	3.52	0.00	0.00
PLONG.2	1210	18.41	0.00	78.06	3.53	0.00	0.00
PLONG.3	1210	18.42	0.00	78.06	3.52	0.00	0.00
PLONG	3630	18.41	0.00	78.07	3.52	0.00	0.00
PACKING.1	1210	37.69	0.00	49.78	12.53	0.00	0.00
PACKING.2	1210	37.41	0.00	49.85	12.74	0.00	0.00
PACKING.3	1210	37.02	0.00	50.15	12.83	0.00	0.00
PACKING.4	1210	36.69	0.00	50.38	12.93	0.00	0.00
PACKING.5	1210	36.17	0.00	50.84	12.99	0.00	0.00
PACKING.6	1210	35.81	0.00	51.24	12.95	0.00	0.00
PACKING	7260	36.80	0.00	50.38	12.82	0.00	0.00
BHN BAKU 15	1210	0.00	0.00	0.00	0.00	100.00	0.00
BHN BAKU 24	1210	0.00	0.00	0.00	0.07	99.93	0.00
BHN BAKU 26	1210	0.00	0.00	0.00	35.87	64.13	0.00
BHN BAKU 28	1210	0.00	0.00	0.00	35.94	64.06	0.00
BHN BAKU 30	1210	0.00	0.00	0.00	35.97	64.03	0.00
BHN BAKU 40	1210	0.00	0.00	0.00	35.92	64.08	0.00

KARUNG HD 15	1210	6.81	0.00	0.00	93.19	0.00	0.00
KARUNG HD 24	1210	13.17	0.00	0.00	86.83	0.00	0.00
KARUNG HD 26	1210	4.37	0.00	0.00	95.63	0.00	0.00
KARUNG HD 28	1210	2.62	0.00	0.00	97.38	0.00	0.00
KARUNG HD 30	1210	6.92	0.00	0.00	93.08	0.00	0.00
KARUNG HD 40	1210	2.62	0.00	0.00	97.38	0.00	0.00
PT 15	1210	0.00	0.00	0.08	35.80	64.12	0.00
PT 24	1210	0.00	0.00	0.08	35.83	64.09	0.00
PT 26	1210	0.00	0.00	0.09	35.77	64.14	0.00
PT 28	1210	0.00	0.00	0.63	35.84	63.53	0.00
PT 30	1210	0.00	0.00	0.00	35.88	64.12	0.00
PT 40	1210	0.00	0.00	0.36	35.87	63.77	0.00

#### RESOURCES

Resource Name	Units	Scheduled Hours	Number Of Times Used	Average Days Per Usage	% Util
OP pack.1	1	1210	229767	0.00	56.62
OP pack.2	1	1210	229580	0.00	56.62
OP pack.3	1	1210	229982	0.00	56.62
OP pack.4	1	1210	229020	0.00	56.62
OP pack.5	1	1210	229435	0.00	56.62
OP pack.6	1	1210	229569	0.00	56.62
OP pack.7	1	1210	228569	0.00	56.62
OP pack.8	1	1210	229924	0.00	56.62

OP pack.9	1	1210	228757	0.00	56.62
OP pack.10	1	1210	230040	0.00	56.62
OP pack.11	1	1210	229074	0.00	56.62
OP pack.12	1	1210	229323	0.00	56.62
OP pack	12	14520	2.75	0.00	56.62

RESOURCE STATES BY PERCENTAGE

Resource Name	Scheduled Hours	% In Use	% Idle	% Down
-----	-----	-----	-----	-----
OP pack.1	1210	56.62	43.38	0.00
OP pack.2	1210	56.62	43.38	0.00
OP pack.3	1210	56.62	43.38	0.00
OP pack.4	1210	56.62	43.38	0.00
OP pack.5	1210	56.62	43.38	0.00
OP pack.6	1210	56.62	43.38	0.00
OP pack.7	1210	56.62	43.38	0.00
OP pack.8	1210	56.62	43.38	0.00
OP pack.9	1210	56.62	43.38	0.00
OP pack.10	1210	56.62	43.38	0.00
OP pack.11	1210	56.62	43.38	0.00
OP pack.12	1210	56.62	43.38	0.00
OP pack	14520	56.62	43.38	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
-----	-----	-----
BIJI PLASTIK	GUDANG BAHAN	0
PEWARNA	GUDANG BAHAN	0
PESANAN	ORDERAN	7
KARUNG 15	TEMPAT KARUNG	0
KARUNG 24	TEMPAT KARUNG	0
KARUNG 26	TEMPAT KARUNG	0
KARUNG 28	TEMPAT KARUNG	92
KARUNG 30	TEMPAT KARUNG	1500
KARUNG 40	TEMPAT KARUNG	1000

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Days In System	Average Days In Move Logic	Average Days Wait For Res, etc.	Average Days In Operation	Average Days Blocked
-----	-----	-----	-----	-----	-----	-----	-----
HD 15	49452	250	9.77	0.00	0.00	0.12	9.64
HD 24	47814	254	8.50	0.00	0.00	0.12	8.37
HD 26	10572	183	9.04	0.00	0.01	0.11	8.90
HD 28	3810	22	6.99	0.00	0.03	0.12	6.83
HD 30	8376	168	7.79	0.00	0.01	0.13	7.64
HD 40	6336	40	7.81	0.00	0.01	0.13	7.66

BIJI PLASTIK	166062	139955	3.10	0.00	0.00	0.00	3.10
PEWARNA	0	16221	-	-	-	-	-
PESANAN	44	0	0.00	0.00	0.00	0.00	0.00
KARUNG 15	1403	6252	24.56	0.00	0.01	0.00	24.55
KARUNG 24	2497	5335	25.89	0.00	0.00	0.00	25.88
KARUNG 26	1022	3615	27.13	0.00	0.02	0.00	27.11
KARUNG 28	101	2824	23.87	0.00	0.04	0.00	23.83
KARUNG 30	1761	1544	24.28	0.00	0.02	0.00	24.25
KARUNG 40	405	1649	26.65	0.00	0.04	0.00	26.60

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
-----	-----	-----	-----	-----
HD 15	0.02	0.01	1.29	98.68
HD 24	0.03	0.03	1.53	98.41
HD 26	0.03	0.17	1.32	98.48
HD 28	0.04	0.47	1.73	97.75
HD 30	0.03	0.16	1.71	98.10
HD 40	0.03	0.14	1.77	98.07
BIJI PLASTIK	0.00	0.00	0.00	100.00
PEWARNA	-	-	-	-
PESANAN	-	-	-	-
KARUNG 15	0.00	0.06	0.01	99.93
KARUNG 24	0.00	0.03	0.01	99.96
KARUNG 26	0.00	0.09	0.01	99.90
KARUNG 28	0.00	0.17	0.01	99.82

KARUNG 30	0.00	0.10	0.01	99.89
KARUNG 40	0.00	0.16	0.01	99.83

VARIABLES

Variable Name	Total Changes	Average Days Per Change	Minimum Value	Maximum Value	Current Value	Average Value
-----	-----	-----	-----	-----	-----	-----
RuleRoute 15	6	4.30	0	5	0	0.00
RuleRoute 24	7	3.81	0	6	0	0.00
RuleRoute 26	3	6.15	0	2	0	0.00
RuleRoute 28	14	3.43	0	1	0	0.00
RuleRoute 30	0	0.00	0	0	0	0
RuleRoute 40	8	5.70	0	1	0	0.00
Henti 15	2	25.18	0	1	0	0.48
Henti 24	2	24.21	0	1	0	0.43
Henti 26	2	11.82	0	1	0	0.10
Henti 28	14	3.49	0	1	0	0.11
Henti 30	0	0.00	0	0	0	0
Henti 40	8	6.00	0	1	0	0.19
PESANAN 15	44	1.13	0	71	31	32.19
PESANAN 24	44	1.13	0	105	85	54.98
PESANAN 26	44	1.13	0	67	4	23.59
PESANAN 28	44	1.13	0	5	5	2.35
PESANAN 30	44	1.13	0	91	28	40.37
PESANAN 40	44	1.13	0	30	6	9.24
BERHENTI	169	0.26	0	1	0	0.35

STOP 15	36	1.25	0	1	0	0.35
STOP 24	36	1.25	0	1	0	0.35
STOP 26	37	1.21	0	1	0	0.35
STOP 28	37	1.21	0	1	0	0.35
STOP 30	37	1.21	-1	1	0	0.35
STOP 40	37	1.21	0	1	0	0.35
TOTAL PESANAN 15	44	1.13	0	1403	1403	719.27
TOTAL PESANAN 24	44	1.13	0	2497	2497	1214.55
TOTAL PESANAN 26	44	1.13	0	1022	1022	471.88
TOTAL PESANAN 28	44	1.13	0	101	101	53.17
TOTAL PESANAN 30	44	1.13	0	1761	1761	912.85
TOTAL PESANAN 40	44	1.13	0	405	405	190.90
gudang 15	9835	0.00	0	749	400	536.63
gudang 24	9835	0.00	0	1693	1022	1258.48
gudang 26	9835	0.00	0	521	172	391.80
gudang 28	9835	0.00	0	551	551	363.23
gudang 30	9835	0.00	0	813	219	580.23
gudang 40	9835	0.00	0	372	282	276.59

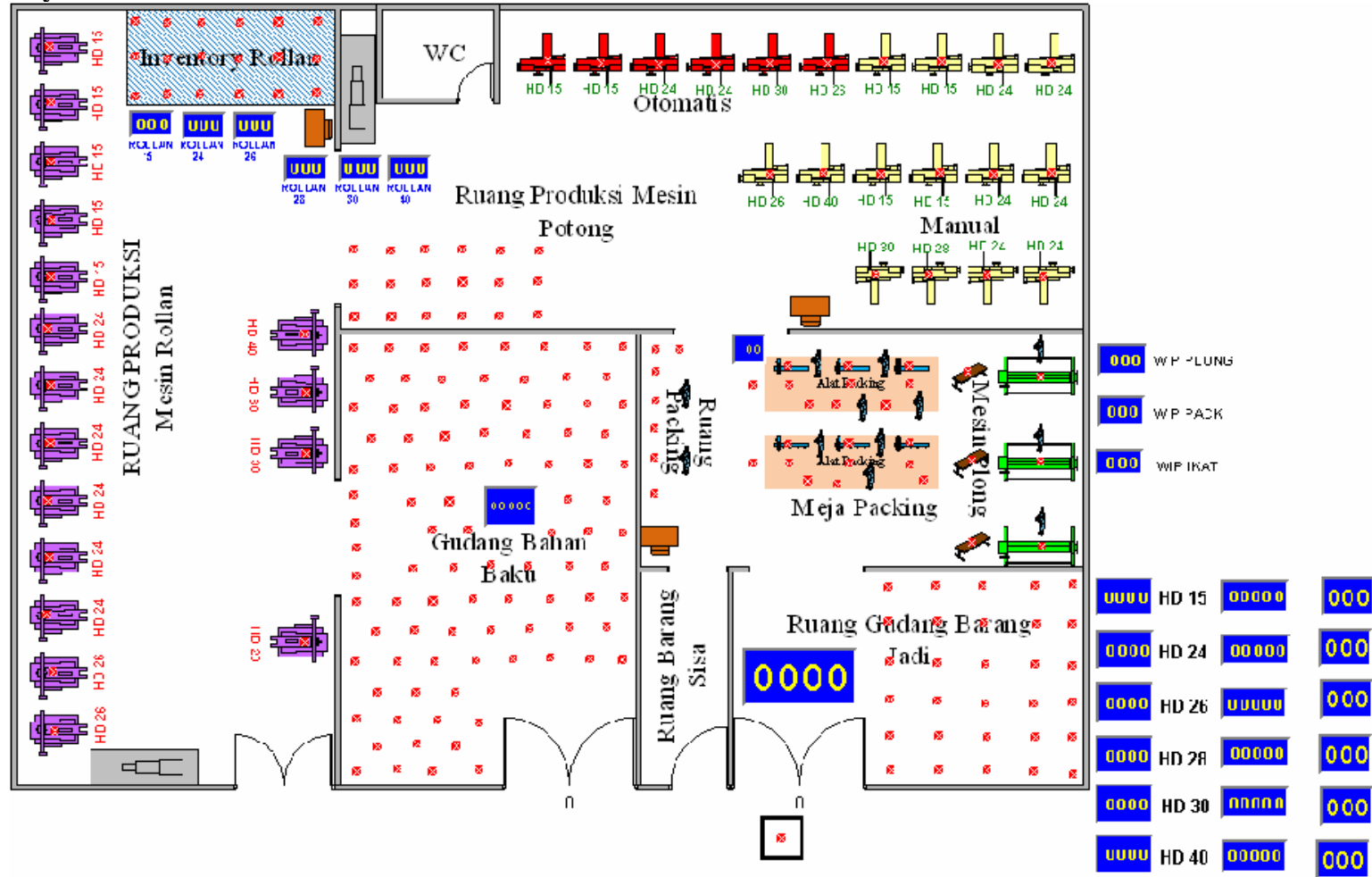


## **LAMPIRAN 7**

### **Simulasi Skenario 1**

- *Layout Simulasi*
- *Input*
- **Output**

Layout Simulasi



• **Input**

```
*****
*
*                               Formatted Listing of Model:
*       E:\DATA\Sherly Works\TA SHERLY\TA FIX\usulan\aktual\skenario 1.MOD
*
*****
```

```
Time Units:           day
Distance Units:      Feet
Initialization Logic:  ACTIVATE Sub1()
```

```
*****
*                               Locations
*
*****
```

Name	Cap	Units	Stats	Rules	Cost
ROLLAN_15	1	5	Time Series	Oldest, , Longest Empty	
ROLLAN_15.1	1	1	Time Series	Oldest, ,	
ROLLAN_15.2	1	1	Time Series	Oldest, ,	
ROLLAN_15.3	1	1	Time Series	Oldest, ,	
ROLLAN_15.4	1	1	Time Series	Oldest, ,	
ROLLAN_15.5	1	1	Time Series	Oldest, ,	
ROLLAN_24	1	6	Time Series	Oldest, , Longest Empty	
ROLLAN_24.1	1	1	Time Series	Oldest, ,	
ROLLAN_24.2	1	1	Time Series	Oldest, ,	
ROLLAN_24.3	1	1	Time Series	Oldest, ,	
ROLLAN_24.4	1	1	Time Series	Oldest, ,	
ROLLAN_24.5	1	1	Time Series	Oldest, ,	
ROLLAN_24.6	1	1	Time Series	Oldest, ,	
ROLLAN_26	1	2	Time Series	Oldest, , Longest Empty	
ROLLAN_26.1	1	1	Time Series	Oldest, ,	

ROLLAN_26.2	1	1	Time Series Oldest, ,
ROLLAN_28	1	1	Time Series Oldest, ,
ROLLAN_30	1	2	Time Series Oldest, , Longest Empty
ROLLAN_30.1	1	1	Time Series Oldest, ,
ROLLAN_30.2	1	1	Time Series Oldest, ,
ROLLAN_40	1	1	Time Series Oldest, ,
POTONG_M_15	2	4	Time Series Oldest, , Fewest
POTONG_M_15.1	2	1	Time Series Oldest, ,
POTONG_M_15.2	2	1	Time Series Oldest, ,
POTONG_M_15.3	2	1	Time Series Oldest, ,
POTONG_M_15.4	2	1	Time Series Oldest, ,
POTONG_M_24	2	6	Time Series Oldest, , Fewest
POTONG_M_24.1	2	1	Time Series Oldest, ,
POTONG_M_24.2	2	1	Time Series Oldest, ,
POTONG_M_24.3	2	1	Time Series Oldest, ,
POTONG_M_24.4	2	1	Time Series Oldest, ,
POTONG_M_24.5	2	1	Time Series Oldest, ,
POTONG_M_24.6	2	1	Time Series Oldest, ,
POTONG_M_26	2	1	Time Series Oldest, , First
POTONG_M_28	2	1	Time Series Oldest, , First
POTONG_M_30	3	1	Time Series Oldest, , First
POTONG_O_15	2	2	Time Series Oldest, , Fewest
POTONG_O_15.1	2	1	Time Series Oldest, ,
POTONG_O_15.2	2	1	Time Series Oldest, ,
POTONG_O_24	2	2	Time Series Oldest, , Fewest
POTONG_O_24.1	2	1	Time Series Oldest, ,
POTONG_O_24.2	2	1	Time Series Oldest, ,
POTONG_O_26	2	1	Time Series Oldest, , First
POTONG_O_30	2	1	Time Series Oldest, , First
POTONG_M_40	2	1	Time Series Oldest, ,
PLONG	1	3	Time Series Oldest, , By turn
PLONG.1	1	1	Time Series Oldest, ,
PLONG.2	1	1	Time Series Oldest, ,
PLONG.3	1	1	Time Series Oldest, ,
PACK	6	1	Time Series Oldest, ,
PACKING	1	6	Time Series Oldest, , By turn
PACKING.1	1	1	Time Series Oldest, ,
PACKING.2	1	1	Time Series Oldest, ,

PACKING.3	1	1	Time Series Oldest, ,
PACKING.4	1	1	Time Series Oldest, ,
PACKING.5	1	1	Time Series Oldest, ,
PACKING.6	1	1	Time Series Oldest, ,
GUDANG_BAHAN	160000	1	Time Series Oldest, ,
INV_ROLLAN_15	1038	1	Time Series Oldest, ,
INV_ROLLAN_24	801	1	Time Series Oldest, ,
INV_ROLLAN_26	307	1	Time Series Oldest, ,
INV_ROLLAN_28	27	1	Time Series Oldest, ,
INV_ROLLAN_30	299	1	Time Series Oldest, ,
INV_ROLLAN_40	60	1	Time Series Oldest, ,
WIP_PLONG	4500	1	Time Series Oldest, , First
WIP_PACK	4500	1	Time Series Oldest, , First
IKAT	2	1	Time Series Oldest, , First
WIP_IKAT	4500	1	Time Series Oldest, ,
GUDANG_BARANG	4687	1	Time Series Oldest, ,
WIP_KARUNG	4500	1	Time Series Oldest, , First
BHN_BAKU_15	1	1	Time Series Oldest, ,
BHN_BAKU_24	1	1	Time Series Oldest, ,
BHN_BAKU_26	1	1	Time Series Oldest, ,
BHN_BAKU_28	1	1	Time Series Oldest, ,
BHN_BAKU_30	1	1	Time Series Oldest, ,
BHN_BAKU_40	1	1	Time Series Oldest, ,
TEMPAT_KARUNG	20000	1	Time Series Oldest, ,
KARUNG_HD_15	1	1	Time Series Oldest, ,
KARUNG_HD_24	1	1	Time Series Oldest, ,
KARUNG_HD_26	1	1	Time Series Oldest, ,
KARUNG_HD_28	1	1	Time Series Oldest, ,
KARUNG_HD_30	1	1	Time Series Oldest, ,
KARUNG_HD_40	1	1	Time Series Oldest, ,
ORDERAN	INF	1	Time Series Oldest, ,
PT_15	1	1	Time Series Oldest, ,
PT_24	1	1	Time Series Oldest, ,
PT_26	1	1	Time Series Oldest, ,
PT_28	1	1	Time Series Oldest, ,
PT_30	1	1	Time Series Oldest, ,
PT_40	1	1	Time Series Oldest, ,

```

*****
*                               Entities                               *
*****

```

Name	Speed (fpm)	Stats	Cost
HD_15	150	Time Series	
HD_24	150	Time Series	
HD_26	150	Time Series	
HD_28	150	Time Series	
HD_30	150	Time Series	
HD_40	150	Time Series	
BIJI_PLASTIK	150	Time Series	
PEWARNA	150	Time Series	
PESANAN	150	Time Series	
KARUNG_15	150	Time Series	
KARUNG_24	150	Time Series	
KARUNG_26	150	Time Series	
KARUNG_28	150	Time Series	
KARUNG_30	150	Time Series	
KARUNG_40	150	Time Series	

```

*****
*                               Path Networks                               *
*****

```

Name	Type	T/S	From	To	BI	Dist/Time	Speed Factor
Net1	Passing	Time	N1	N2	Bi	0 SEC	
			N1	N3	Bi	0 SEC	
			N1	N4	Bi	0 SEC	
			N1	N5	Bi	0 SEC	
			N1	N6	Bi	0 SEC	
			N2	N8	Bi	1.20 MIN	
			N3	N8	Bi	1.55 MIN	
			N4	N8	Bi	1.81 MIN	

Net2	Passing	Time				
			N6	N8	Bi	1.44 MIN
			N5	N8	Bi	1.69 MIN
			N1	N7	Bi	0 SEC
			N7	N8	Bi	1.35 MIN
			N2	N3	Bi	41 SEC
			N2	N4	Bi	41 SEC
			N2	N5	Bi	52.39 SEC
			N2	N6	Bi	56.32 SEC
			N2	N7	Bi	64.18 SEC
			N2	N8	Bi	66.14 SEC
			N2	N9	Bi	48.07 SEC
			N2	N10	Bi	62.61 SEC
			N2	N11	Bi	56.71 SEC
			N2	N12	Bi	50.82 SEC
			N3	N13	Bi	31.04 SEC
			N4	N13	Bi	23.18 SEC
			N5	N13	Bi	30.64 SEC
			N6	N13	Bi	33.79 SEC
			N7	N14	Bi	39.29 SEC
			N8	N14	Bi	41.25 SEC
			N9	N14	Bi	23.18 SEC
			N10	N14	Bi	40.86 SEC
			N11	N14	Bi	34.96 SEC
			N12	N14	Bi	29.07 SEC
			N15	N16	Bi	46.14 SEC

\*\*\*\*\*  
 \* Interfaces \*

Net	Node	Location
Net1	N1	BHN_BAKU_15
	N1	BHN_BAKU_24
	N1	BHN_BAKU_26
	N1	BHN_BAKU_28
	N1	BHN_BAKU_30

	N1	BHN_BAKU_40
	N2	ROLLAN_15
	N3	ROLLAN_24
	N4	ROLLAN_26
	N5	ROLLAN_28
	N6	ROLLAN_30
	N7	ROLLAN_40
	N8	INV_ROLLAN_15
	N8	INV_ROLLAN_24
	N8	INV_ROLLAN_26
	N8	INV_ROLLAN_28
	N8	INV_ROLLAN_30
	N8	INV_ROLLAN_40
Net2	N3	POTONG_O_15
	N4	POTONG_O_24
	N5	POTONG_O_30
	N6	POTONG_O_26
	N8	POTONG_M_24
	N9	POTONG_M_26
	N10	POTONG_M_28
	N11	POTONG_M_30
	N12	POTONG_M_40
	N13	WIP_PACK
	N14	WIP_PLONG
	N15	KARUNG_HD_15
	N15	KARUNG_HD_24
	N15	KARUNG_HD_26
	N15	KARUNG_HD_28
	N15	KARUNG_HD_30
	N15	KARUNG_HD_40
	N16	GUDANG_BARANG
	N2	PT_15
	N2	PT_24
	N2	PT_26
	N2	PT_28
	N2	PT_30
	N2	PT_40
	N7	POTONG_M_15



\*\*\*\*\*  
 \* Resources \*  
 \*\*\*\*\*

Name	Units	Stats	Res Search	Ent Search Path	Motion	Cost
OP_pack	12	By Unit	None	Oldest	Empty: 150 fpm Full: 150 fpm	

\*\*\*\*\*  
 \* Processing \*  
 \*\*\*\*\*

Process			Routing				
Entity	Location	Operation	Blk	Output	Destination	Rule	Move Logic
PEWARNA	GUDANG_BAHAN		1	PEWARNA	BHN_BAKU_15	FIRST 1	MOVE FOR 0
				PEWARNA	BHN_BAKU_24	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_26	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_28	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_30	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_40	FIRST	MOVE FOR 0
BIJI_PLASTIK	GUDANG_BAHAN		1	BIJI_PLASTIK	BHN_BAKU_15	JOIN 1	MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_24	JOIN	MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_26	JOIN	MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_28	JOIN	MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_30	JOIN	MOVE FOR 0

```

                                BIJI_PLASTIK BHN_BAKU_40  JOIN      MOVE FOR 0
PEWARNA  BHN_BAKU_15  JOIN 9 BIJI_PLASTIK
IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_15 = 0 THEN
{
  ROUTE 1
}
ELSE
{
  DEC STOP_15
  ROUTE 2
}
                                1  BIJI_PLASTIK ROLLAN_15  FIRST 1  MOVE ON Net1
                                2  BIJI_PLASTIK ROLLAN_15  SEND 1  MOVE ON Net1

PEWARNA  BHN_BAKU_24  JOIN 11 BIJI_PLASTIK
IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_24 = 0 THEN
{
  ROUTE 1
}
ELSE
{
  DEC STOP_24
  ROUTE 2
}
                                1  BIJI_PLASTIK ROLLAN_24  FIRST 1  MOVE ON Net1
                                2  BIJI_PLASTIK ROLLAN_24  SEND 1  MOVE ON Net1

PEWARNA  BHN_BAKU_26  JOIN 12 BIJI_PLASTIK
IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_26 = 0 THEN
{
  ROUTE 1
}
ELSE
{
  DEC STOP_26
  ROUTE 2
}
                                1  BIJI_PLASTIK ROLLAN_26  FIRST 1  MOVE ON Net1
                                2  BIJI_PLASTIK ROLLAN_26  SEND 1  MOVE ON Net1

```

```

PEWARNA      BHN_BAKU_28  JOIN 13 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_28 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_28
                ROUTE 2
                }
                1      BIJI_PLASTIK ROLLAN_28      FIRST 1      MOVE ON Net1
                2      BIJI_PLASTIK ROLLAN_28      SEND 1      MOVE ON Net1

PEWARNA      BHN_BAKU_30  JOIN 16 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_30 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_30
                ROUTE 2
                }
                1      BIJI_PLASTIK ROLLAN_30      FIRST 1      MOVE ON Net1
                2      BIJI_PLASTIK ROLLAN_30      SEND 1      MOVE ON Net1

PEWARNA      BHN_BAKU_40  JOIN 17 BIJI_PLASTIK
                IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_40 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_40
                ROUTE 2
                }
                1      BIJI_PLASTIK ROLLAN_40      FIRST 1      MOVE ON Net1
                2      BIJI_PLASTIK ROLLAN_40      SEND 1      MOVE ON Net1

BIJI_PLASTIK ROLLAN_15  WAIT 45 MIN
                IF (CONTENTS(INV_ROLLAN_15) < 192) and RuleRoute_15 = 0 THEN
                {
                ROUTE 1
                }

```

```

ELSE
{
DEC RuleRoute_15
ROUTE 2
}

1 HD_15 INV_ROLLAN_15 FIRST 1 MOVE ON Net1
2 HD_15 INV_ROLLAN_15 SEND 1 MOVE ON Net1

BIJI_PLASTIK ROLLAN_24 WAIT 46 MIN
IF (CONTENTS(INV_ROLLAN_24) < 168) and RuleRoute_24 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC RuleRoute_24
ROUTE 2
}
1 HD_24 INV_ROLLAN_24 FIRST 1 MOVE ON Net1
2 HD_24 INV_ROLLAN_24 SEND 1 MOVE ON Net1

BIJI_PLASTIK ROLLAN_26 WAIT 48 MIN
IF (CONTENTS(INV_ROLLAN_26) < 60) and RuleRoute_26 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC RuleRoute_26
ROUTE 2
}
1 HD_26 INV_ROLLAN_26 FIRST 1 MOVE ON Net1
2 HD_26 INV_ROLLAN_26 SEND 1 MOVE ON Net1

```

```

BIJI_PLASTIK ROLLAN_28      WAIT 50 MIN
                             IF (CONTENTS(INV_ROLLAN_28) < 27) and RuleRoute_28 = 0 THEN
                             {
                             ROUTE 1
                             }
                             ELSE
                             {
                             DEC RuleRoute_28
                             ROUTE 2
                             }
                             1      HD_28      INV_ROLLAN_28 FIRST 1      MOVE ON Net1
                             2      HD_28      INV_ROLLAN_28 SEND 1      MOVE ON Net1

BIJI_PLASTIK ROLLAN_30      WAIT 52 MIN
                             IF (CONTENTS(INV_ROLLAN_30) < 42) and RuleRoute_30 = 0 THEN
                             {
                             ROUTE 1
                             }
                             ELSE
                             {
                             DEC RuleRoute_30
                             ROUTE 2
                             }
                             1      HD_30      INV_ROLLAN_30 FIRST 1      MOVE ON Net1
                             2      HD_30      INV_ROLLAN_30 SEND 1      MOVE ON Net1

BIJI_PLASTIK ROLLAN_40      WAIT 50 MIN
                             IF (CONTENTS(INV_ROLLAN_40) < 30) and RuleRoute_40 = 0 THEN
                             {
                             ROUTE 1
                             }
                             ELSE
                             {
                             DEC RuleRoute_40
                             ROUTE 2
                             }
                             1      HD_40      INV_ROLLAN_40 FIRST 1      MOVE ON Net1

```

```

                2   HD_40   INV_ROLLAN_40 SEND 1
HD_15   INV_ROLLAN_15 IF CONTENTS(INV_ROLLAN_15) >= 192 THEN
        {
            RuleRoute_15 = 5
            Henti_15 = 1
        }
                1   HD_15   PT_15   FIRST 1
24) and (Henti_15 = 1) THEN
        {
            WAIT 120 MIN
            WAIT 45 MIN
            SEND 5 HD_15 TO INV_ROLLAN_15

            Henti_15 = 0
        }

HD_24   INV_ROLLAN_24 IF CONTENTS(INV_ROLLAN_24) >= 168 THEN
        {
            RuleRoute_24 = 6
            Henti_24 = 1
        }
                1   HD_24   PT_24   FIRST 1
32) and (Henti_24 = 1) THEN
        {
            WAIT 120 MIN
            WAIT 46 MIN
            SEND 6 HD_24 TO INV_ROLLAN_24

            Henti_24 = 0
        }

HD_26   INV_ROLLAN_26 IF CONTENTS(INV_ROLLAN_26) >= 60 THEN
        {
            RuleRoute_26 = 2
            Henti_26 = 1
        }

```

```

8) and (Henti_26 = 1) THEN
                                1   HD_26   PT_26   FIRST 1  IF (CONTENTS(INV_ROLLAN_26) =
                                { WAIT 120 MIN
                                WAIT 48 MIN
                                SEND 2 HD_26 TO INV_ROLLAN_26
                                Henti_26 = 0
                                }

HD_28   INV_ROLLAN_28 IF CONTENTS(INV_ROLLAN_28) >= 27 THEN
                                {
                                RuleRoute_28 = 1
                                Henti_28 = 1
                                }
4) and (Henti_28 = 1) THEN
                                1   HD_28   PT_28   FIRST 1  IF (CONTENTS(INV_ROLLAN_28) =
                                { WAIT 120 MIN
                                WAIT 50 MIN
                                SEND 1 HD_28 TO INV_ROLLAN_28
                                Henti_28 = 0
                                }

HD_30   INV_ROLLAN_30 IF CONTENTS(INV_ROLLAN_30) >= 42 THEN
                                {
                                RuleRoute_30 = 2
                                Henti_30 = 1
                                }
10) and (Henti_30 = 1) THEN
                                1   HD_30   PT_30   FIRST 1  IF (CONTENTS(INV_ROLLAN_30) =
                                { WAIT 120 MIN
                                WAIT 52 MIN
                                SEND 2 HD_30 TO INV_ROLLAN_30
                                Henti_30 = 0
                                }

```

```

HD_40      INV_ROLLAN_40 IF CONTENTS(INV_ROLLAN_40) >= 30 THEN
                {
                RuleRoute_40 = 1
                Henti_40 = 1
                }

4) and (Henti_40 = 1) THEN
                1   HD_40      PT_40      FIRST 1   IF (CONTENTS(INV_ROLLAN_40) =
                {   WAIT 120 MIN
                WAIT 50 MIN
                SEND 1 HD_40 TO INV_ROLLAN_40

                Henti_40 = 0
                }

HD_15      PT_15      IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_15 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_15
                ROUTE 2
                }
                1   HD_15      POTONG_O_15  FIRST 1   MOVE ON Net2
                HD_15      POTONG_M_15  FIRST      MOVE ON Net2
                2   HD_15      POTONG_O_15  SEND 1   MOVE ON Net2
                HD_15      POTONG_M_15  SEND      MOVE ON Net2

HD_24      PT_24      IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_24 = 0 THEN
                {
                ROUTE 1
                }
                ELSE
                {
                DEC STOP_24

```



```

ROUTE 2
}
1 HD_24 POTONG_O_24 FIRST 1 MOVE ON Net2
HD_24 POTONG_M_24 FIRST MOVE ON Net2
2 HD_24 POTONG_O_24 SEND 1 MOVE ON Net2
HD_24 POTONG_M_24 SEND MOVE ON Net2
HD_26 PT_26 IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_26 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC STOP_26
ROUTE 2
}
1 HD_26 POTONG_O_26 FIRST 1 MOVE ON Net2
HD_26 POTONG_M_26 FIRST MOVE ON Net2
2 HD_26 POTONG_O_26 SEND 1 MOVE ON Net2
HD_26 POTONG_M_26 SEND MOVE ON Net2
HD_28 PT_28 IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_28 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC STOP_28
ROUTE 2
}
1 HD_28 POTONG_M_28 FIRST 1 MOVE ON Net2
2 HD_28 POTONG_M_28 SEND 1 MOVE ON Net2
HD_30 PT_30 IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_30 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC STOP_30

```

```

ROUTE 2
}
1 HD_30 POTONG_O_30 FIRST 1 MOVE ON Net2
HD_30 POTONG_M_30 FIRST MOVE ON Net2
2 HD_30 POTONG_O_30 SEND 1 MOVE ON Net2
HD_30 POTONG_M_30 SEND MOVE ON Net2
HD_40 PT_40 IF (CONTENTS(GUDANG_BARANG) < 4600) and STOP_40 = 0 THEN
{
ROUTE 1
}
ELSE
{
DEC STOP_40
ROUTE 2
}
1 HD_40 POTONG_M_40 FIRST 1 MOVE ON Net2
2 HD_40 POTONG_M_40 SEND 1 MOVE ON Net2
HD_15 POTONG_O_15 WAIT 138 MIN
1 HD_15 WIP_PACK FIRST 12 GRAPHIC 3
MOVE ON Net2
HD_24 POTONG_O_24 WAIT 142 MIN
1 HD_24 WIP_PACK FIRST 9 GRAPHIC 3
MOVE ON Net2
HD_26 POTONG_O_26 WAIT 124 MIN
1 HD_26 WIP_PACK FIRST 7 GRAPHIC 3
MOVE ON Net2
HD_30 POTONG_O_30 WAIT 139 MIN
1 HD_30 WIP_PACK FIRST 5 GRAPHIC 3
MOVE ON Net2
HD_40 POTONG_M_40 WAIT 146 MIN
1 HD_40 WIP_PLONG FIRST 10 GRAPHIC 3
MOVE ON Net2

```



		USE OP_pack FOR W(8.20858, 9.52208)SEC				
		USE OP_pack FOR W(8.20858, 9.52208)SEC				
		USE OP_pack FOR W(8.20858, 9.52208)SEC				
		USE OP_pack FOR W(8.20858, 9.52208)SEC	1	ALL	PACKING	FIRST 1 MOVE FOR 0
HD_15	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_15	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
HD_24	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_15	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
HD_26	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				

		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
			1	HD_15	WIP_IKAT
					FIRST 1
					GRAPHIC 4
					MOVE FOR 0
HD_28	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
			1	HD_15	WIP_IKAT
					FIRST 1
					GRAPHIC 4
					MOVE FOR 0
HD_30	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
			1	HD_15	WIP_IKAT
					FIRST 1
					GRAPHIC 4
					MOVE FOR 0
HD_40	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			
		USE OP_pack FOR W(6.18294, 8.26316)SEC			

USE OP\_pack FOR W(6.18294, 8.26316)SEC  
 USE OP\_pack FOR W(6.18294, 8.26316)SEC  
 USE OP\_pack FOR W(6.18294, 8.26316)SEC  
 USE OP\_pack FOR W(6.18294, 8.26316)SEC  
 USE OP\_pack FOR W(6.18294, 8.26316)SEC  
 USE OP\_pack FOR W(6.18294, 8.26316)SEC  
 USE OP\_pack FOR W(6.18294, 8.26316)SEC

1 HD\_15 WIP\_IKAT FIRST 1 GRAPHIC 4  
 MOVE FOR 0

ALL WIP\_IKAT 1 ALL IKAT FIRST 1 MOVE FOR 0  
 ALL IKAT USE OP\_pack FOR W(9.51749, 37.5274)SEC

1 ALL WIP\_KARUNG FIRST 1 MOVE FOR 0

HD\_15 WIP\_KARUNG ACCUM 6

1 HD\_15 KARUNG\_HD\_15 JOIN 1 MOVE FOR 15.5 SEC

HD\_24 WIP\_KARUNG ACCUM 6

1 HD\_24 KARUNG\_HD\_24 JOIN 1 MOVE FOR 15.5 SEC

HD\_26 WIP\_KARUNG ACCUM 6

1 HD\_26 KARUNG\_HD\_26 JOIN 1 MOVE FOR 15.5 SEC

HD\_28 WIP\_KARUNG ACCUM 6

1 HD\_28 KARUNG\_HD\_28 JOIN 1 MOVE FOR 15.5 SEC

HD\_30 WIP\_KARUNG ACCUM 6

1 HD\_30 KARUNG\_HD\_30 JOIN 1 MOVE FOR 15.5 SEC

HD\_40 WIP\_KARUNG ACCUM 6

			1	HD_40	KARUNG_HD_40	JOIN 1		MOVE FOR 15.5 SEC
KARUNG_15	TEMPAT_KARUNG							
			1	KARUNG_15	KARUNG_HD_15	FIRST 1		
KARUNG_24	TEMPAT_KARUNG		1	KARUNG_24	KARUNG_HD_24	FIRST 1		
KARUNG_26	TEMPAT_KARUNG		1	KARUNG_26	KARUNG_HD_26	FIRST 1		
KARUNG_28	TEMPAT_KARUNG		1	KARUNG_28	KARUNG_HD_28	FIRST 1		
KARUNG_30	TEMPAT_KARUNG		1	KARUNG_30	KARUNG_HD_30	FIRST 1		
KARUNG_40	TEMPAT_KARUNG		1	KARUNG_40	KARUNG_HD_40	FIRST 1		
KARUNG_15	KARUNG_HD_15	JOIN 30 HD_15 USE OP_pack FOR 3 MIN						
			1	KARUNG_15	GUDANG_BARANG	FIRST 1		MOVE ON Net2
KARUNG_24	KARUNG_HD_24	JOIN 15 HD_24 USE OP_pack FOR 3 MIN						
			1	KARUNG_24	GUDANG_BARANG	FIRST 1		MOVE ON Net2
KARUNG_26	KARUNG_HD_26	JOIN 10 HD_26 USE OP_pack FOR 3 MIN						
			1	KARUNG_26	GUDANG_BARANG	FIRST 1		MOVE ON Net2
KARUNG_28	KARUNG_HD_28	JOIN 6 HD_28 USE OP_pack FOR 3 MIN						
			1	KARUNG_28	GUDANG_BARANG	FIRST 1		MOVE ON Net2
KARUNG_30	KARUNG_HD_30	JOIN 5 HD_30 USE OP_pack FOR 3 MIN						
			1	KARUNG_30	GUDANG_BARANG	FIRST 1		MOVE ON Net2
KARUNG_40	KARUNG_HD_40	JOIN 10 HD_40 USE OP_pack FOR 3 MIN						
			1	KARUNG_40	GUDANG_BARANG	FIRST 1		MOVE ON Net2

```

ALL          GUDANG_BARANG IF CONTENTS(GUDANG_BARANG) >= 4600 THEN
              {
                STOP_15 = 1
                STOP_24 = 1
                STOP_26 = 1
                STOP_28 = 1
                STOP_30 = 1
                STOP_40 = 1
                BERHENTI = 1
              }

              gudang_15 = CONTENTS(GUDANG_BARANG, KARUNG_15)
              gudang_24 = CONTENTS(GUDANG_BARANG, KARUNG_24)
              gudang_26 = CONTENTS(GUDANG_BARANG, KARUNG_26)
              gudang_28 = CONTENTS(GUDANG_BARANG, KARUNG_28)
              gudang_30 = CONTENTS(GUDANG_BARANG, KARUNG_30)
              gudang_40 = CONTENTS(GUDANG_BARANG, KARUNG_40)

              1      ALL      EXIT

2000) and (BERHENTI = 1) THEN

SEND 1      IF (CONTENTS(GUDANG_BARANG) =
              {
                WAIT 120 MIN
                SEND 5 BIJI_PLASTIK TO
                  ROLLAN_15
                SEND 6 BIJI_PLASTIK TO
                  ROLLAN_24
                SEND 2 BIJI_PLASTIK TO
                  ROLLAN_26
                SEND 1 BIJI_PLASTIK TO
                  ROLLAN_40
                SEND 1 BIJI_PLASTIK TO
                  ROLLAN_28
                SEND 2 BIJI_PLASTIK TO
                  ROLLAN_30

                SEND 4 HD_15 TO POTONG_O_15
                SEND 4 HD_24 TO POTONG_O_24
                SEND 2 HD_26 TO POTONG_O_26
              }

```



SEND 2 HD\_40 TO POTONG\_O\_30

SEND 8 HD\_15 TO POTONG\_M\_15  
SEND 12 HD\_24 TO POTONG\_M\_24  
SEND 2 HD\_26 TO POTONG\_M\_26  
SEND 2 HD\_28 TO POTONG\_M\_28  
SEND 3 HD\_30 TO POTONG\_M\_30  
SEND 2 HD\_40 TO POTONG\_M\_40

BERHENTI = 0

}

PESANAN ORDERAN

PESANAN\_15 = W(2.11, 35.961)  
PESANAN\_24 = W(2.965, 61.624)  
PESANAN\_26 = W(2.05999, 24.7659)  
PESANAN\_28 = W(1.65868, 2.79416)  
PESANAN\_30 = W(2.49708, 45.9334)  
PESANAN\_40 = W(1.4963, 9.64354)

SEND PESANAN\_15 KARUNG\_15 TO EXIT  
SEND PESANAN\_24 KARUNG\_24 TO EXIT  
SEND PESANAN\_26 KARUNG\_26 TO EXIT  
SEND PESANAN\_28 KARUNG\_28 TO EXIT  
SEND PESANAN\_30 KARUNG\_30 TO EXIT  
SEND PESANAN\_40 KARUNG\_40 TO EXIT

TOTAL\_PESANAN\_15 = TOTAL\_PESANAN\_15 + PESANAN\_15  
TOTAL\_PESANAN\_24 = TOTAL\_PESANAN\_24 + PESANAN\_24  
TOTAL\_PESANAN\_26 = TOTAL\_PESANAN\_26 + PESANAN\_26  
TOTAL\_PESANAN\_28 = TOTAL\_PESANAN\_28 + PESANAN\_28  
TOTAL\_PESANAN\_30 = TOTAL\_PESANAN\_30 + PESANAN\_30  
TOTAL\_PESANAN\_40 = TOTAL\_PESANAN\_40 + PESANAN\_40

1 PESANAN EXIT

FIRST 1

```
*****
*                               Arrivals                               *
*****
```

Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
BIJI_PLASTIK	GUDANG_BAHAN	6000	0	INF	24 HR	
PEWARNA	GUDANG_BAHAN	600	0	INF	24 HR	
KARUNG_15	TEMPAT_KARUNG	2500	0	INF	480 HR	
KARUNG_24	TEMPAT_KARUNG	2500	0	INF	480 HR	
KARUNG_26	TEMPAT_KARUNG	1500	0	INF	480 HR	
KARUNG_28	TEMPAT_KARUNG	1000	0	INF	480 HR	
KARUNG_30	TEMPAT_KARUNG	1500	0	inf	480 HR	
KARUNG_40	TEMPAT_KARUNG	1000	0	INF	480 HR	
PESANAN	ORDERAN	1	2 HR	INF	24 HR	

```
*****
*                               Shift Assignments                       *
*****
```

Locations	Resources	Shift Files	Priorities	Disable Logic
ORDERAN		E:\DATA\Sherly Works\TA SHERLY	99,99,99,99	No

```
*****
*                               Variables (global)                       *
*****
```

ID	Type	Initial value	Stats
RuleRoute_15	Integer	0	Time Series

RuleRoute_24	Integer	0	Time Series
RuleRoute_26	Integer	0	Time Series
RuleRoute_28	Integer	0	Time Series
RuleRoute_30	Integer	0	Time Series
RuleRoute_40	Integer	0	Time Series
Henti_15	Integer	0	Time Series
Henti_24	Integer	0	Time Series
Henti_26	Integer	0	Time Series
Henti_28	Integer	0	Time Series
Henti_30	Integer	0	Time Series
Henti_40	Integer	0	Time Series
PESANAN_15	Integer	0	Time Series
PESANAN_24	Integer	0	Time Series
PESANAN_26	Integer	0	Time Series
PESANAN_28	Integer	0	Time Series
PESANAN_30	Integer	0	Time Series
PESANAN_40	Integer	0	Time Series
BERHENTI	Integer	0	Time Series
STOP_15	Integer	0	Time Series
STOP_24	Integer	0	Time Series
STOP_26	Integer	0	Time Series
STOP_28	Integer	0	Time Series
STOP_30	Integer	0	Time Series
STOP_40	Integer	0	Time Series
TOTAL_PESANAN_15	Integer	0	Time Series
TOTAL_PESANAN_24	Integer	0	Time Series
TOTAL_PESANAN_26	Integer	0	Time Series
TOTAL_PESANAN_28	Integer	0	Time Series
TOTAL_PESANAN_30	Integer	0	Time Series
TOTAL_PESANAN_40	Integer	0	Time Series
gudang_15	Integer	0	Time Series
gudang_24	Integer	0	Time Series
gudang_26	Integer	0	Time Series
gudang_28	Integer	0	Time Series
gudang_30	Integer	0	Time Series
gudang_40	Integer	0	Time Series

\*\*\*\*\*  
 \* Subroutines \*  
 \*\*\*\*\*

ID	Type	Parameter	Type	Logic
Sub1	None			ORDER 192 HD_15 TO INV_ROLLAN_15 ORDER 180 HD_24 TO INV_ROLLAN_24 ORDER 60 HD_26 TO INV_ROLLAN_26 ORDER 6 HD_28 TO INV_ROLLAN_28 ORDER 50 HD_30 TO INV_ROLLAN_30 ORDER 12 HD_40 TO INV_ROLLAN_40  ORDER 155 KARUNG_15 TO GUDANG_BARANG ORDER 332 KARUNG_24 TO GUDANG_BARANG ORDER 137 KARUNG_26 TO GUDANG_BARANG ORDER 17 KARUNG_28 TO GUDANG_BARANG ORDER 305 KARUNG_30 TO GUDANG_BARANG ORDER 54 KARUNG_40 TO GUDANG_BARANG

\*\*\*\*\*  
 \* External Files \*  
 \*\*\*\*\*

ID	Type	File Name	Prompt
(null)	Shift	E:\DATA\Sherly Works\TA SHERLY\PESANAN.sft	

- *Output*

-----  
 General Report

Output from E:\DATA\Sherly Works\TA SHERLY\TA FIX\usulan\aktual\skenario 1.MOD

Date: Jun/14/2008 Time: 05:15:32 AM  
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Scenario : Normal Run

Replication : 1 of 1

Simulation Time : 1210 hr  
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LOCATIONS

Location Name Util	Scheduled Hours	Capacity	Total Entries	Average Days Per Entry	Average Contents	Maximum Contents	Current Contents	%
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ROLLAN 15.1 61.90	1210	1	768	0.04	0.61	1	1	
ROLLAN 15.2 61.84	1210	1	767	0.04	0.61	1	1	
ROLLAN 15.3 61.84	1210	1	767	0.04	0.61	1	1	
ROLLAN 15.4 61.84	1210	1	767	0.04	0.61	1	1	

ROLLAN 15.5 61.84	1210	1	767	0.04	0.61	1	1
ROLLAN 15 61.85	6050	5	3836	0.04	0.61	5	5
ROLLAN 24.1 61.89	1210	1	838	0.03	0.61	1	1
ROLLAN 24.2 61.83	1210	1	837	0.03	0.61	1	1
ROLLAN 24.3 61.83	1210	1	837	0.03	0.61	1	1
ROLLAN 24.4 61.83	1210	1	837	0.03	0.61	1	1
ROLLAN 24.5 61.83	1210	1	837	0.03	0.61	1	1
ROLLAN 24.6 61.83	1210	1	837	0.03	0.61	1	1
ROLLAN 24 61.84	7260	6	5023	0.03	0.61	6	6
ROLLAN 26.1 61.86	1210	1	716	0.04	0.61	1	1
ROLLAN 26.2 61.79	1210	1	715	0.04	0.61	1	1
ROLLAN 26 61.83	2420	2	1431	0.04	0.61	2	2
ROLLAN 28 61.88	1210	1	739	0.04	0.61	1	1
ROLLAN 30.1 61.89	1210	1	790	0.03	0.61	1	1

ROLLAN 30.2 61.82	1210	1	789	0.03	0.61	1	1
ROLLAN 30 61.86	2420	2	1579	0.03	0.61	2	2
ROLLAN 40 61.88	1210	1	627	0.04	0.61	1	1
POTONG M 15.1 61.44	1210	2	672	0.09	1.22	2	2
POTONG M 15.2 61.44	1210	2	672	0.09	1.22	2	2
POTONG M 15.3 61.44	1210	2	672	0.09	1.22	2	2
POTONG M 15.4 61.44	1210	2	672	0.09	1.22	2	2
POTONG M 15 61.44	4840	8	2688	0.09	1.22	8	8
POTONG M 24.1 61.38	1210	2	647	0.09	1.22	2	2
POTONG M 24.2 61.29	1210	2	646	0.09	1.22	2	2
POTONG M 24.3 61.29	1210	2	646	0.09	1.22	2	2
POTONG M 24.4 61.29	1210	2	646	0.09	1.22	2	2
POTONG M 24.5 61.29	1210	2	646	0.09	1.22	2	2
POTONG M 24.6 61.29	1210	2	646	0.09	1.22	2	2

POTONG M 24 61.30	7260	12	3877	0.09	1.22	12	12
POTONG M 26 61.54	1210	2	739	0.08	1.23	2	2
POTONG M 28 61.36	1210	2	737	0.08	1.22	2	2
POTONG M 30 61.20	1210	3	975	0.09	1.83	3	3
POTONG O 15.1 61.53	1210	2	648	0.09	1.23	2	2
POTONG O 15.2 61.53	1210	2	648	0.09	1.23	2	2
POTONG O 15 61.53	2420	4	1296	0.09	1.23	4	4
POTONG O 24.1 61.53	1210	2	630	0.09	1.23	2	2
POTONG O 24.2 61.53	1210	2	630	0.09	1.23	2	2
POTONG O 24 61.53	2420	4	1260	0.09	1.23	4	4
POTONG O 26 61.44	1210	2	720	0.08	1.22	2	2
POTONG O 30 61.44	1210	2	643	0.09	1.22	2	2
POTONG M 40 61.54	1210	2	613	0.10	1.23	2	2
PLONG.1 21.07	1210	1	28939	0.00	0.21	1	0



PLONG.2 21.04	1210	1	28891	0.00	0.21	1	0
PLONG.3 21.06	1210	1	28919	0.00	0.21	1	0
PLONG 21.06	3630	3	86749	0.00	0.21	3	0
PACK 52.62	1210	6	121745	0.00	3.15	6	6
PACKING.1 47.70	1210	1	20299	0.00	0.47	1	1
PACKING.2 47.67	1210	1	20294	0.00	0.47	1	1
PACKING.3 47.66	1210	1	20298	0.00	0.47	1	0
PACKING.4 47.69	1210	1	20281	0.00	0.47	1	1
PACKING.5 47.67	1210	1	20275	0.00	0.47	1	1
PACKING.6 47.69	1210	1	20292	0.00	0.47	1	1
PACKING 47.68	7260	6	121739	0.00	0.47	6	5
GUDANG BAHAN 39.37	1210	160000	323422	9.81	62989.5	160000	157624
INV ROLLAN 15 11.77	1210	1038	4023	1.53	122.18	211	38
INV ROLLAN 24 14.30	1210	801	5197	1.11	114.53	183	59

INV ROLLAN 26 7.63	1210	307	1489	0.79	23.40	55	29
INV ROLLAN 28 31.85	1210	27	744	0.58	8.60	20	6
INV ROLLAN 30 6.10	1210	299	1627	0.56	18.23	44	8
INV ROLLAN 40 31.91	1210	60	638	1.51	19.14	30	24
WIP PLONG 0.16	1210	4500	86749	0.00	7.07	201	0
WIP PACK 0.52	1210	4500	121788	0.00	23.52	214	43
IKAT 54.66	1210	2	121725	0.00	1.09	2	2
WIP IKAT 0.07	1210	4500	121734	0.00	3.35	27	9
GUDANG BARANG 62.87	1210	4687	9507	15.62	2946.77	4636	2709
WIP KARUNG 0.24	1210	4500	121723	0.00	10.75	36	13
BHN BAKU 15 100.00	1210	1	3837	0.01	1	1	1
BHN BAKU 24 100.00	1210	1	5024	0.01	1	1	1
BHN BAKU 26 100.00	1210	1	1432	0.03	1	1	1
BHN BAKU 28 100.00	1210	1	740	0.06	1	1	1

BHN BAKU 30 100.00	1210	1	1580	0.03	1	1	1
BHN BAKU 40 100.00	1210	1	628	0.08	1	1	1
TEMPAT KARUNG 60.60	1210	20000	27357	22.33	12120.7	20000	18844
KARUNG HD 15 100.00	1210	1	1589	0.03	1	1	1
KARUNG HD 24 100.00	1210	1	3069	0.01	1	1	1
KARUNG HD 26 100.00	1210	1	1019	0.04	1	1	1
KARUNG HD 28 100.00	1210	1	613	0.08	1	1	1
KARUNG HD 30 100.00	1210	1	1612	0.03	1	1	1
KARUNG HD 40 100.00	1210	1	611	0.08	1	1	1
ORDERAN 0.00	396	999999	44	0.00	0	1	0
PT 15 99.59	1210	1	3985	0.01	0.99	1	1
PT 24 99.58	1210	1	5138	0.00	0.99	1	1
PT 26 99.22	1210	1	1460	0.03	0.99	1	1
PT 28 99.28	1210	1	738	0.06	0.99	1	1

PT 30	1210	1	1619	0.03	0.99	1	1
99.45							
PT 40	1210	1	614	0.08	0.99	1	1
99.37							

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	% Empty	% Partially Occupied	% Full	% Down
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POTONG M 15.1	1210	38.56	0.00	61.44	0.00
POTONG M 15.2	1210	38.56	0.00	61.44	0.00
POTONG M 15.3	1210	38.56	0.00	61.44	0.00
POTONG M 15.4	1210	38.09	0.95	60.96	0.00
POTONG M 15	4840	38.45	0.24	61.32	0.00
POTONG M 24.1	1210	38.17	0.89	60.94	0.00
POTONG M 24.2	1210	38.28	0.87	60.85	0.00
POTONG M 24.3	1210	38.17	1.09	60.75	0.00
POTONG M 24.4	1210	38.17	1.09	60.75	0.00
POTONG M 24.5	1210	38.17	1.09	60.75	0.00
POTONG M 24.6	1210	38.17	1.09	60.75	0.00
POTONG M 24	7260	38.19	1.02	60.80	0.00
POTONG M 26	1210	38.38	0.17	61.45	0.00
POTONG M 28	1210	38.11	1.05	60.84	0.00
POTONG M 30	1210	38.39	0.97	60.64	0.00
POTONG O 15.1	1210	38.47	0.00	61.53	0.00

POTONG O 15.2	1210	38.36	0.23	61.42	0.00
POTONG O 15	2420	38.41	0.11	61.47	0.00
POTONG O 24.1	1210	38.47	0.00	61.53	0.00
POTONG O 24.2	1210	38.47	0.00	61.53	0.00
POTONG O 24	2420	38.47	0.00	61.53	0.00
POTONG O 26	1210	38.56	0.00	61.44	0.00
POTONG O 30	1210	38.16	0.79	61.05	0.00
POTONG M 40	1210	38.03	0.85	61.12	0.00
PACK	1210	46.25	2.49	51.27	0.00
GUDANG BAHAN	1210	0.00	99.76	0.24	0.00
INV ROLLAN 15	1210	0.00	100.00	0.00	0.00
INV ROLLAN 24	1210	0.00	100.00	0.00	0.00
INV ROLLAN 26	1210	0.00	100.00	0.00	0.00
INV ROLLAN 28	1210	0.00	100.00	0.00	0.00
INV ROLLAN 30	1210	0.00	100.00	0.00	0.00
INV ROLLAN 40	1210	0.00	100.00	0.00	0.00
WIP PLONG	1210	80.12	19.88	0.00	0.00
WIP PACK	1210	49.43	50.57	0.00	0.00
IKAT	1210	44.54	1.60	53.85	0.00
WIP IKAT	1210	50.75	49.25	0.00	0.00
GUDANG BARANG	1210	0.00	100.00	0.00	0.00
WIP KARUNG	1210	0.20	99.80	0.00	0.00
TEMPAT KARUNG	1210	0.00	87.71	12.29	0.00
ORDERAN	396	100.00	0.00	0.00	0.00

LOCATION STATES BY PERCENTAGE (Single Capacity/Tanks)

Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down
ROLLAN 15.1	1210	47.57	0.00	38.10	14.33	0.00	0.00
ROLLAN 15.2	1210	47.51	0.00	38.16	14.33	0.00	0.00
ROLLAN 15.3	1210	47.51	0.00	38.16	14.33	0.00	0.00
ROLLAN 15.4	1210	47.51	0.00	38.16	14.33	0.00	0.00
ROLLAN 15.5	1210	47.51	0.00	38.16	14.33	0.00	0.00
ROLLAN 15	6050	47.52	0.00	38.15	14.33	0.00	0.00
ROLLAN 24.1	1210	53.12	0.00	38.11	8.77	0.00	0.00
ROLLAN 24.2	1210	53.05	0.00	38.17	8.78	0.00	0.00
ROLLAN 24.3	1210	53.05	0.00	38.17	8.78	0.00	0.00
ROLLAN 24.4	1210	53.05	0.00	38.17	8.78	0.00	0.00
ROLLAN 24.5	1210	53.05	0.00	38.17	8.78	0.00	0.00
ROLLAN 24.6	1210	53.05	0.00	38.17	8.78	0.00	0.00
ROLLAN 24	7260	53.06	0.00	38.16	8.78	0.00	0.00
ROLLAN 26.1	1210	47.30	0.00	38.14	14.56	0.00	0.00
ROLLAN 26.2	1210	47.23	0.00	38.21	14.56	0.00	0.00
ROLLAN 26	2420	47.26	0.00	38.17	14.57	0.00	0.00
ROLLAN 28	1210	50.87	0.00	38.12	11.01	0.00	0.00
ROLLAN 30.1	1210	56.56	0.00	38.11	5.33	0.00	0.00
ROLLAN 30.2	1210	56.49	0.00	38.18	5.33	0.00	0.00
ROLLAN 30	2420	56.53	0.00	38.14	5.33	0.00	0.00
ROLLAN 40	1210	43.11	0.00	38.12	18.77	0.00	0.00
PLONG.1	1210	17.76	0.00	78.93	3.31	0.00	0.00
PLONG.2	1210	17.72	0.00	78.96	3.32	0.00	0.00
PLONG.3	1210	17.73	0.00	78.94	3.33	0.00	0.00

PLONG	3630	17.74	0.00	78.94	3.32	0.00	0.00
PACKING.1	1210	35.46	0.00	52.30	12.24	0.00	0.00
PACKING.2	1210	35.42	0.00	52.33	12.25	0.00	0.00
PACKING.3	1210	35.43	0.00	52.34	12.23	0.00	0.00
PACKING.4	1210	35.46	0.00	52.31	12.23	0.00	0.00
PACKING.5	1210	35.41	0.00	52.33	12.26	0.00	0.00
PACKING.6	1210	35.45	0.00	52.31	12.24	0.00	0.00
PACKING	7260	35.44	0.00	52.32	12.24	0.00	0.00
BHN BAKU 15	1210	0.00	0.00	0.00	38.16	61.84	0.00
BHN BAKU 24	1210	0.00	0.00	0.00	38.17	61.83	0.00
BHN BAKU 26	1210	0.00	0.00	0.00	38.21	61.79	0.00
BHN BAKU 28	1210	0.00	0.00	0.00	38.19	61.81	0.00
BHN BAKU 30	1210	0.00	0.00	0.00	38.18	61.82	0.00
BHN BAKU 40	1210	0.00	0.00	0.00	38.19	61.81	0.00
KARUNG HD 15	1210	6.56	0.00	0.00	93.44	0.00	0.00
KARUNG HD 24	1210	12.68	0.00	0.00	87.32	0.00	0.00
KARUNG HD 26	1210	4.21	0.00	0.00	95.79	0.00	0.00
KARUNG HD 28	1210	2.53	0.00	0.00	97.47	0.00	0.00
KARUNG HD 30	1210	6.66	0.00	0.00	93.34	0.00	0.00
KARUNG HD 40	1210	2.52	0.00	0.00	97.48	0.00	0.00
PT 15	1210	0.00	0.00	0.41	38.17	61.42	0.00
PT 24	1210	0.00	0.00	0.42	38.19	61.39	0.00
PT 26	1210	0.00	0.00	0.78	38.06	61.16	0.00
PT 28	1210	0.00	0.00	0.72	38.15	61.13	0.00
PT 30	1210	0.00	0.00	0.55	38.22	61.23	0.00
PT 40	1210	0.00	0.00	0.63	38.17	61.20	0.00

RESOURCES

Resource Name	Units	Scheduled Hours	Number Of Times Used	Average Days Per Usage	% Util
OP pack.1	1	1210	220174	0.00	54.54
OP pack.2	1	1210	221226	0.00	54.54
OP pack.3	1	1210	220785	0.00	54.54
OP pack.4	1	1210	220622	0.00	54.54
OP pack.5	1	1210	221164	0.00	54.54
OP pack.6	1	1210	220746	0.00	54.54
OP pack.7	1	1210	220902	0.00	54.54
OP pack.8	1	1210	221904	0.00	54.54
OP pack.9	1	1210	220775	0.00	54.54
OP pack.10	1	1210	220894	0.00	54.54
OP pack.11	1	1210	221280	0.00	54.54
OP pack.12	1	1210	221300	0.00	54.55
OP pack	12	14520	2.65	0.00	54.54

RESOURCE STATES BY PERCENTAGE

Resource Name	Scheduled Hours	% In Use	% Idle	% Down
OP pack.1	1210	54.54	45.46	0.00
OP pack.2	1210	54.54	45.46	0.00



OP pack.3	1210	54.54	45.46	0.00
OP pack.4	1210	54.54	45.46	0.00
OP pack.5	1210	54.54	45.46	0.00
OP pack.6	1210	54.54	45.46	0.00
OP pack.7	1210	54.54	45.46	0.00
OP pack.8	1210	54.54	45.46	0.00
OP pack.9	1210	54.54	45.46	0.00
OP pack.10	1210	54.54	45.46	0.00
OP pack.11	1210	54.54	45.46	0.00
OP pack.12	1210	54.55	45.45	0.00
OP pack	14520	54.54	45.46	0.00

#### FAILED ARRIVALS

Entity Name	Location Name	Total Failed
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BIJI PLASTIK	GUDANG BAHAN	10178
PEWARNA	GUDANG BAHAN	3000
PESANAN	ORDERAN	7
KARUNG 15	TEMPAT KARUNG	0
KARUNG 24	TEMPAT KARUNG	0
KARUNG 26	TEMPAT KARUNG	0
KARUNG 28	TEMPAT KARUNG	143
KARUNG 30	TEMPAT KARUNG	1500
KARUNG 40	TEMPAT KARUNG	1000

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Days In System	Average Days In Move Logic	Average Days Wait For Res, etc.	Average Days In Operation	Average Days Blocked
HD 15	47658	57	8.44	0.00	0.00	0.12	8.31
HD 24	46032	133	8.26	0.00	0.00	0.12	8.13
HD 26	10182	37	8.22	0.00	0.01	0.11	8.09
HD 28	3672	12	8.21	0.00	0.02	0.12	8.06
HD 30	8058	21	8.11	0.00	0.01	0.13	7.96
HD 40	6108	29	8.47	0.00	0.01	0.13	8.32
BIJI PLASTIK	152557	143282	5.98	0.00	0.00	0.00	5.98
PEWARNA	0	14365	-	-	-	-	-
PESANAN	44	0	0.00	0.00	0.00	0.00	0.00
KARUNG 15	1461	6194	24.38	0.00	0.01	0.00	24.36
KARUNG 24	2180	5652	25.45	0.00	0.00	0.00	25.44
KARUNG 26	992	3645	24.55	0.00	0.02	0.00	24.52
KARUNG 28	72	2802	25.31	0.00	0.03	0.00	25.27
KARUNG 30	1733	1572	24.15	0.00	0.02	0.00	24.12
KARUNG 40	360	1694	22.65	0.00	0.04	0.00	22.61

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
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HD 15	0.02	0.02	1.49	98.47
HD 24	0.03	0.03	1.57	98.37
HD 26	0.03	0.16	1.45	98.36
HD 28	0.04	0.33	1.47	98.16
HD 30	0.03	0.12	1.64	98.21
HD 40	0.03	0.13	1.63	98.21
BIJI PLASTIK	0.00	0.00	0.00	100.00
PEWARNA	-	-	-	-
PESANAN	-	-	-	-
KARUNG 15	0.00	0.06	0.01	99.93
KARUNG 24	0.00	0.03	0.01	99.96
KARUNG 26	0.00	0.10	0.01	99.89
KARUNG 28	0.00	0.15	0.01	99.84
KARUNG 30	0.00	0.11	0.01	99.89
KARUNG 40	0.00	0.18	0.01	99.81

VARIABLES

Variable Name	Total Changes	Average Days Per Change	Minimum Value	Maximum Value	Current Value	Average Value
RuleRoute 15	32	1.51	0	5	0	0.01
RuleRoute 24	42	1.14	0	6	0	0.01
RuleRoute 26	37	1.29	0	2	0	0.01
RuleRoute 28	16	3.06	0	1	0	0.00
RuleRoute 30	32	1.56	0	2	0	0.00
RuleRoute 40	14	3.34	0	1	0	0.00
Henti 15	12	4.16	0	1	0	0.14
Henti 24	17	2.88	0	1	0	0.09
Henti 26	28	1.74	0	1	0	0.15
Henti 28	16	3.11	0	1	0	0.11
Henti 30	26	1.93	0	1	0	0.05
Henti 40	14	3.44	0	1	0	0.19
PESANAN 15	44	1.13	0	65	24	34.05
PESANAN 24	44	1.13	0	89	29	50.17
PESANAN 26	44	1.13	0	51	17	22.40
PESANAN 28	44	1.13	0	5	2	1.61
PESANAN 30	44	1.13	0	72	39	39.35
PESANAN 40	44	1.13	0	25	1	8.33
BERHENTI	80	0.57	0	1	0	0.38
STOP 15	40	1.15	0	1	0	0.38
STOP 24	40	1.15	0	1	0	0.38

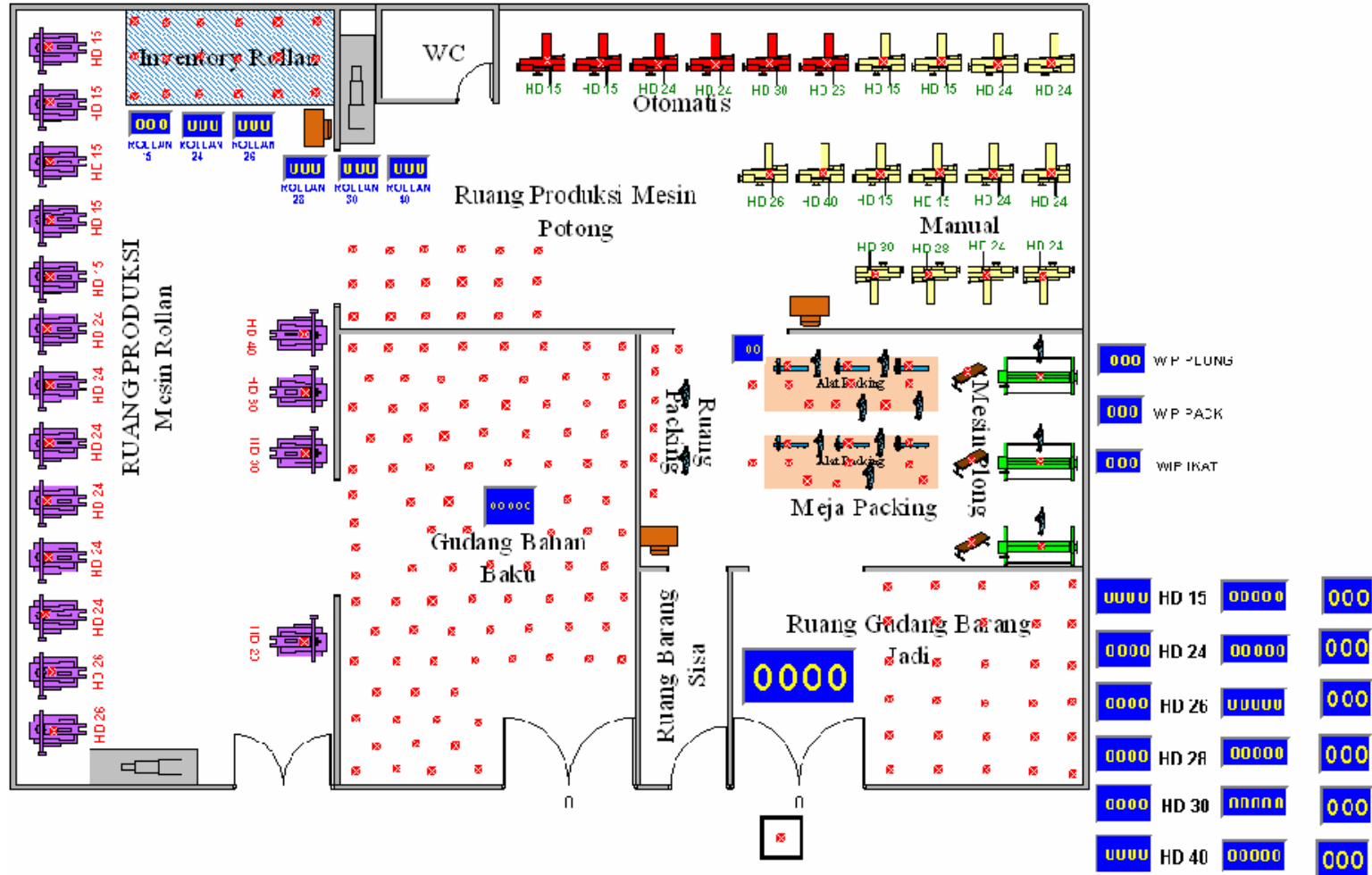
STOP 26	40	1.15	0	1	0	0.38
STOP 28	40	1.15	0	1	0	0.38
STOP 30	40	1.15	0	1	0	0.38
STOP 40	40	1.15	0	1	0	0.38
TOTAL PESANAN 15	44	1.13	0	1461	1461	754.37
TOTAL PESANAN 24	44	1.13	0	2180	2180	1079.52
TOTAL PESANAN 26	44	1.13	0	992	992	508.95
TOTAL PESANAN 28	44	1.13	0	72	72	35.84
TOTAL PESANAN 30	44	1.13	0	1733	1733	902.67
TOTAL PESANAN 40	44	1.13	0	360	360	198.22
gudang 15	9507	0.00	0	715	282	506.55
gudang 24	9507	0.00	0	1830	1220	1384.99
gudang 26	9507	0.00	0	491	163	353.75
gudang 28	9507	0.00	0	557	557	376.53
gudang 30	9507	0.00	0	730	183	557.44
gudang 40	9507	0.00	0	365	304	268.40

## **LAMPIRAN 8**

### **Simulasi Skenario 2**

- *Layout* Simulasi
- *Input*
- **Output**

• *Layout Simulasi*



• **Input**

```
*****
*
*                               Formatted Listing of Model:
*       E:\DATA\Sherly Works\TA SHERLY\TA FIX\usulan\skenario 3\1\1.MOD
*
*****
```

```
Time Units:           day
Distance Units:      Feet
Initialization Logic: ACTIVATE Sub1()
```

```
*****
*                               Locations
*
*****
```

Name	Cap	Units	Stats	Rules	Cost
ROLLAN_15	1	5	Time Series	Oldest, , Longest Empty	
ROLLAN_15.1	1	1	Time Series	Oldest, ,	
ROLLAN_15.2	1	1	Time Series	Oldest, ,	
ROLLAN_15.3	1	1	Time Series	Oldest, ,	
ROLLAN_15.4	1	1	Time Series	Oldest, ,	
ROLLAN_15.5	1	1	Time Series	Oldest, ,	
ROLLAN_24	1	6	Time Series	Oldest, , Longest Empty	
ROLLAN_24.1	1	1	Time Series	Oldest, ,	
ROLLAN_24.2	1	1	Time Series	Oldest, ,	
ROLLAN_24.3	1	1	Time Series	Oldest, ,	
ROLLAN_24.4	1	1	Time Series	Oldest, ,	
ROLLAN_24.5	1	1	Time Series	Oldest, ,	
ROLLAN_24.6	1	1	Time Series	Oldest, ,	
ROLLAN_26	1	2	Time Series	Oldest, , Longest Empty	
ROLLAN_26.1	1	1	Time Series	Oldest, ,	



ROLLAN_26.2	1	1	Time Series Oldest, ,
ROLLAN_28	1	1	Time Series Oldest, ,
ROLLAN_30	1	2	Time Series Oldest, , Longest Empty
ROLLAN_30.1	1	1	Time Series Oldest, ,
ROLLAN_30.2	1	1	Time Series Oldest, ,
ROLLAN_40	1	1	Time Series Oldest, ,
POTONG_M_15	3	4	Time Series Oldest, , Fewest
POTONG_M_15.1	3	1	Time Series Oldest, ,
POTONG_M_15.2	3	1	Time Series Oldest, ,
POTONG_M_15.3	3	1	Time Series Oldest, ,
POTONG_M_15.4	3	1	Time Series Oldest, ,
POTONG_M_24	3	6	Time Series Oldest, , Fewest
POTONG_M_24.1	3	1	Time Series Oldest, ,
POTONG_M_24.2	3	1	Time Series Oldest, ,
POTONG_M_24.3	3	1	Time Series Oldest, ,
POTONG_M_24.4	3	1	Time Series Oldest, ,
POTONG_M_24.5	3	1	Time Series Oldest, ,
POTONG_M_24.6	3	1	Time Series Oldest, ,
POTONG_M_26	3	1	Time Series Oldest, , First
POTONG_M_28	3	1	Time Series Oldest, , First
POTONG_M_30	3	1	Time Series Oldest, , First
POTONG_O_15	2	2	Time Series Oldest, , Fewest
POTONG_O_15.1	2	1	Time Series Oldest, ,
POTONG_O_15.2	2	1	Time Series Oldest, ,
POTONG_O_24	2	2	Time Series Oldest, , Fewest
POTONG_O_24.1	2	1	Time Series Oldest, ,
POTONG_O_24.2	2	1	Time Series Oldest, ,
POTONG_O_26	2	1	Time Series Oldest, , First
POTONG_O_30	2	1	Time Series Oldest, , First
POTONG_M_40	2	1	Time Series Oldest, ,
PLONG	1	3	Time Series Oldest, , Fewest
PLONG.1	1	1	Time Series Oldest, ,
PLONG.2	1	1	Time Series Oldest, ,
PLONG.3	1	1	Time Series Oldest, ,
PACK	9	1	Time Series Oldest, ,
PACKING	1	6	Time Series Oldest, , Fewest
PACKING.1	1	1	Time Series Oldest, ,
PACKING.2	1	1	Time Series Oldest, ,

PACKING.3	1	1	Time Series Oldest, ,
PACKING.4	1	1	Time Series Oldest, ,
PACKING.5	1	1	Time Series Oldest, ,
PACKING.6	1	1	Time Series Oldest, ,
GUDANG_BAHAN	160000	1	Time Series Oldest, ,
INV_ROLLAN_15	1038	1	Time Series Oldest, ,
INV_ROLLAN_24	801	1	Time Series Oldest, ,
INV_ROLLAN_26	307	1	Time Series Oldest, ,
INV_ROLLAN_28	27	1	Time Series Oldest, ,
INV_ROLLAN_30	299	1	Time Series Oldest, ,
INV_ROLLAN_40	60	1	Time Series Oldest, ,
WIP_PLONG	4500	1	Time Series Oldest, , First
WIP_PACK	4500	1	Time Series Oldest, , First
IKAT	4	1	Time Series Oldest, , First
WIP_IKAT	4500	1	Time Series Oldest, ,
GUDANG_BARANG	inf	1	Time Series Oldest, ,
WIP_KARUNG	4500	1	Time Series Oldest, , First
BHN_BAKU_15	1	1	Time Series Oldest, ,
BHN_BAKU_24	1	1	Time Series Oldest, ,
BHN_BAKU_26	1	1	Time Series Oldest, ,
BHN_BAKU_28	1	1	Time Series Oldest, ,
BHN_BAKU_30	1	1	Time Series Oldest, ,
BHN_BAKU_40	1	1	Time Series Oldest, ,
TEMPAT_KARUNG	inf	1	Time Series Oldest, ,
KARUNG_HD_15	1	1	Time Series Oldest, ,
KARUNG_HD_24	1	1	Time Series Oldest, ,
KARUNG_HD_26	1	1	Time Series Oldest, ,
KARUNG_HD_28	1	1	Time Series Oldest, ,
KARUNG_HD_30	1	1	Time Series Oldest, ,
KARUNG_HD_40	1	1	Time Series Oldest, ,
ORDERAN	INF	1	Time Series Oldest, ,
PT_15	1	1	Time Series Oldest, ,
PT_24	1	1	Time Series Oldest, ,
PT_26	1	1	Time Series Oldest, ,
PT_28	1	1	Time Series Oldest, ,
PT_30	1	1	Time Series Oldest, ,
PT_40	1	1	Time Series Oldest, ,

```

*****
*                               Entities                               *
*****

```

Name	Speed (fpm)	Stats	Cost
HD_15	150	Time Series	
HD_24	150	Time Series	
HD_26	150	Time Series	
HD_28	150	Time Series	
HD_30	150	Time Series	
HD_40	150	Time Series	
BIJI_PLASTIK	150	Time Series	
PEWARNA	150	Time Series	
PESANAN	150	Time Series	
KARUNG_15	150	Time Series	
KARUNG_24	150	Time Series	
KARUNG_26	150	Time Series	
KARUNG_28	150	Time Series	
KARUNG_30	150	Time Series	
KARUNG_40	150	Time Series	

```

*****
*                               Path Networks                           *
*****

```

Name	Type	T/S	From	To	BI	Dist/Time	Speed Factor
Net1	Passing	Time	N1	N2	Bi	0 SEC	
			N1	N3	Bi	0 SEC	
			N1	N4	Bi	0 SEC	
			N1	N5	Bi	0 SEC	
			N1	N6	Bi	0 SEC	
			N2	N8	Bi	1.20 MIN	
			N3	N8	Bi	1.55 MIN	
			N4	N8	Bi	1.81 MIN	

Net2	Passing	Time				
			N6	N8	Bi	1.44 MIN
			N5	N8	Bi	1.69 MIN
			N1	N7	Bi	0 SEC
			N7	N8	Bi	1.35 MIN
			N2	N3	Bi	41 SEC
			N2	N4	Bi	41 SEC
			N2	N5	Bi	52.39 SEC
			N2	N6	Bi	56.32 SEC
			N2	N7	Bi	64.18 SEC
			N2	N8	Bi	66.14 SEC
			N2	N9	Bi	48.07 SEC
			N2	N10	Bi	62.61 SEC
			N2	N11	Bi	56.71 SEC
			N2	N12	Bi	50.82 SEC
			N3	N13	Bi	31.04 SEC
			N4	N13	Bi	23.18 SEC
			N5	N13	Bi	30.64 SEC
			N6	N13	Bi	33.79 SEC
			N7	N14	Bi	39.29 SEC
			N8	N14	Bi	41.25 SEC
			N9	N14	Bi	23.18 SEC
			N10	N14	Bi	40.86 SEC
			N11	N14	Bi	34.96 SEC
			N12	N14	Bi	29.07 SEC
			N15	N16	Bi	46.14 SEC

```
*****
*                               Interfaces                               *
*****
```

```
Net      Node      Location
```

```

-----
Net1      N1      BHN_BAKU_15
          N1      BHN_BAKU_24
          N1      BHN_BAKU_26
          N1      BHN_BAKU_28
          N1      BHN_BAKU_30
          N1      BHN_BAKU_40
          N2      ROLLAN_15
          N3      ROLLAN_24
          N4      ROLLAN_26
          N5      ROLLAN_28
          N6      ROLLAN_30
          N7      ROLLAN_40
          N8      INV_ROLLAN_15
          N8      INV_ROLLAN_24
          N8      INV_ROLLAN_26
          N8      INV_ROLLAN_28
          N8      INV_ROLLAN_30
          N8      INV_ROLLAN_40
Net2      N3      POTONG_O_15
          N4      POTONG_O_24
          N5      POTONG_O_30
          N6      POTONG_O_26
          N8      POTONG_M_24
          N9      POTONG_M_26
          N10     POTONG_M_28
          N11     POTONG_M_30
          N12     POTONG_M_40
          N13     WIP_PACK
          N14     WIP_PLONG
          N15     KARUNG_HD_15
          N15     KARUNG_HD_24
          N15     KARUNG_HD_26
          N15     KARUNG_HD_28
          N15     KARUNG_HD_30
          N15     KARUNG_HD_40
          N16     GUDANG_BARANG
          N2      PT_15

```

N2 PT\_24  
 N2 PT\_26  
 N2 PT\_28  
 N2 PT\_30  
 N2 PT\_40  
 N7 POTONG\_M\_15

\*\*\*\*\*  
 \* Resources \*  
 \*\*\*\*\*

Name	Units	Stats	Res Search	Ent Search Path	Motion	Cost
OP_pack	18	By Unit	None	Oldest	Empty: 150 fpm Full: 150 fpm	

\*\*\*\*\*  
 \* Processing \*  
 \*\*\*\*\*

Process			Routing				
Entity	Location	Operation	Blk	Output	Destination	Rule	Move Logic
PEWARNA	GUDANG_BAHAN		1	PEWARNA	BHN_BAKU_15	FIRST 1	MOVE FOR 0
				PEWARNA	BHN_BAKU_24	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_26	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_28	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_30	FIRST	MOVE FOR 0
				PEWARNA	BHN_BAKU_40	FIRST	MOVE FOR 0

BIJI_PLASTIK	GUDANG_BAHAN		1	BIJI_PLASTIK	BHN_BAKU_15	JOIN	1	MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_24	JOIN		MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_26	JOIN		MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_28	JOIN		MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_30	JOIN		MOVE FOR 0
				BIJI_PLASTIK	BHN_BAKU_40	JOIN		MOVE FOR 0
PEWARNA	BHN_BAKU_15	JOIN 9	BIJI_PLASTIK	1	BIJI_PLASTIK	ROLLAN_15	FIRST 1	MOVE ON Net1
PEWARNA	BHN_BAKU_24	JOIN 11	BIJI_PLASTIK	1	BIJI_PLASTIK	ROLLAN_24	FIRST 1	MOVE ON Net1
PEWARNA	BHN_BAKU_26	JOIN 12	BIJI_PLASTIK	1	BIJI_PLASTIK	ROLLAN_26	FIRST 1	MOVE ON Net1
PEWARNA	BHN_BAKU_28	JOIN 13	BIJI_PLASTIK	1	BIJI_PLASTIK	ROLLAN_28	FIRST 1	MOVE ON Net1
PEWARNA	BHN_BAKU_30	JOIN 16	BIJI_PLASTIK	1	BIJI_PLASTIK	ROLLAN_30	FIRST 1	MOVE ON Net1
PEWARNA	BHN_BAKU_40	JOIN 17	BIJI_PLASTIK	1	BIJI_PLASTIK	ROLLAN_40	FIRST 1	MOVE ON Net1
BIJI_PLASTIK	ROLLAN_15	WAIT 45 MIN		1	HD_15	INV_ROLLAN_15	FIRST 1	MOVE ON Net1
BIJI_PLASTIK	ROLLAN_24	WAIT 46 MIN		1	HD_24	INV_ROLLAN_24	FIRST 1	MOVE ON Net1
BIJI_PLASTIK	ROLLAN_26	WAIT 48 MIN		1	HD_26	INV_ROLLAN_26	FIRST 1	MOVE ON Net1
BIJI_PLASTIK	ROLLAN_28	WAIT 50 MIN		1	HD_28	INV_ROLLAN_28	FIRST 1	MOVE ON Net1
BIJI_PLASTIK	ROLLAN_30	WAIT 52 MIN		1	HD_30	INV_ROLLAN_30	FIRST 1	MOVE ON Net1
BIJI_PLASTIK	ROLLAN_40	WAIT 50 MIN		1	HD_40	INV_ROLLAN_40	FIRST 1	MOVE ON Net1

												MOVE ON Net1
HD_15	INV_ROLLAN_15		1	HD_15	PT_15	FIRST	1					
HD_24	INV_ROLLAN_24		1	HD_24	PT_24	FIRST	1					
HD_26	INV_ROLLAN_26		1	HD_26	PT_26	FIRST	1					
HD_28	INV_ROLLAN_28		1	HD_28	PT_28	FIRST	1					
HD_30	INV_ROLLAN_30		1	HD_30	PT_30	FIRST	1					
HD_40	INV_ROLLAN_40		1	HD_40	PT_40	FIRST	1					
HD_15	PT_15											
			1	HD_15	POTONG_O_15	FIRST	1					MOVE ON Net2
				HD_15	POTONG_M_15	FIRST						MOVE ON Net2
HD_24	PT_24		1	HD_24	POTONG_O_24	FIRST	1					MOVE ON Net2
				HD_24	POTONG_M_24	FIRST						MOVE ON Net2
HD_26	PT_26		1	HD_26	POTONG_O_26	FIRST	1					MOVE ON Net2
				HD_26	POTONG_M_26	FIRST						MOVE ON Net2
HD_28	PT_28		1	HD_28	POTONG_M_28	FIRST	1					MOVE ON Net2
HD_30	PT_30		1	HD_30	POTONG_O_30	FIRST	1					MOVE ON Net2
				HD_30	POTONG_M_30	FIRST						MOVE ON Net2
HD_40	PT_40		1	HD_40	POTONG_M_40	FIRST	1					MOVE ON Net2
HD_15	POTONG_O_15	WAIT 138 MIN										
			1	HD_15	WIP_PACK	FIRST	12					GRAPHIC 3 MOVE ON Net2
HD_24	POTONG_O_24	WAIT 142 MIN										
			1	HD_24	WIP_PACK	FIRST	9					GRAPHIC 3 MOVE ON Net2
HD_26	POTONG_O_26	WAIT 124 MIN										
			1	HD_26	WIP_PACK	FIRST	7					GRAPHIC 3 MOVE ON Net2
HD_30	POTONG_O_30	WAIT 139 MIN										
			1	HD_30	WIP_PACK	FIRST	5					GRAPHIC 3 MOVE ON Net2
HD_40	POTONG_M_40	WAIT 146 MIN										
			1	HD_40	WIP_PLONG	FIRST	10					GRAPHIC 3







		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_26	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
HD_28	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_28	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
HD_30	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC	1	HD_30	WIP_IKAT	FIRST 1 GRAPHIC 4 MOVE FOR 0
HD_40	PACKING	USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				
		USE OP_pack FOR W(6.18294, 8.26316)SEC				

			USE OP_pack FOR W(6.18294, 8.26316)SEC				
			USE OP_pack FOR W(6.18294, 8.26316)SEC				
			USE OP_pack FOR W(6.18294, 8.26316)SEC				
			USE OP_pack FOR W(6.18294, 8.26316)SEC				
			USE OP_pack FOR W(6.18294, 8.26316)SEC				
			1 HD_40 WIP_IKAT FIRST 1 GRAPHIC 4				MOVE FOR 0
ALL	WIP_IKAT		1 ALL IKAT FIRST 1 MOVE FOR 0				
ALL	IKAT		USE OP_pack FOR W(9.51749, 37.5274)SEC				
			1 ALL WIP_KARUNG FIRST 1 MOVE FOR 0				
HD_15	WIP_KARUNG	ACCUM 6					
			1 HD_15 KARUNG_HD_15 JOIN 1 MOVE FOR 15.5 SEC				
HD_24	WIP_KARUNG	ACCUM 6					
			1 HD_24 KARUNG_HD_24 JOIN 1 MOVE FOR 15.5 SEC				
HD_26	WIP_KARUNG	ACCUM 6					
			1 HD_26 KARUNG_HD_26 JOIN 1 MOVE FOR 15.5 SEC				
HD_28	WIP_KARUNG	ACCUM 6					
			1 HD_28 KARUNG_HD_28 JOIN 1 MOVE FOR 15.5 SEC				
HD_30	WIP_KARUNG	ACCUM 6					
			1 HD_30 KARUNG_HD_30 JOIN 1 MOVE FOR 15.5 SEC				
HD_40	WIP_KARUNG	ACCUM 6					
			1 HD_40 KARUNG_HD_40 JOIN 1 MOVE FOR 15.5 SEC				

KARUNG_15	TEMPAT_KARUNG							
			1	KARUNG_15	KARUNG_HD_15	FIRST	1	
KARUNG_24	TEMPAT_KARUNG		1	KARUNG_24	KARUNG_HD_24	FIRST	1	
KARUNG_26	TEMPAT_KARUNG		1	KARUNG_26	KARUNG_HD_26	FIRST	1	
KARUNG_28	TEMPAT_KARUNG		1	KARUNG_28	KARUNG_HD_28	FIRST	1	
KARUNG_30	TEMPAT_KARUNG		1	KARUNG_30	KARUNG_HD_30	FIRST	1	
KARUNG_40	TEMPAT_KARUNG		1	KARUNG_40	KARUNG_HD_40	FIRST	1	
KARUNG_15	KARUNG_HD_15	JOIN 30 HD_15 USE OP_pack FOR 3 MIN	1	KARUNG_15	GUDANG_BARANG	FIRST	1	MOVE ON Net2
KARUNG_24	KARUNG_HD_24	JOIN 15 HD_24 USE OP_pack FOR 3 MIN	1	KARUNG_24	GUDANG_BARANG	FIRST	1	MOVE ON Net2
KARUNG_26	KARUNG_HD_26	JOIN 10 HD_26 USE OP_pack FOR 3 MIN	1	KARUNG_26	GUDANG_BARANG	FIRST	1	MOVE ON Net2
KARUNG_28	KARUNG_HD_28	JOIN 6 HD_28 USE OP_pack FOR 3 MIN	1	KARUNG_28	GUDANG_BARANG	FIRST	1	MOVE ON Net2
KARUNG_30	KARUNG_HD_30	JOIN 5 HD_30 USE OP_pack FOR 3 MIN	1	KARUNG_30	GUDANG_BARANG	FIRST	1	MOVE ON Net2
KARUNG_40	KARUNG_HD_40	JOIN 10 HD_40 USE OP_pack FOR 3 MIN	1	KARUNG_40	GUDANG_BARANG	FIRST	1	MOVE ON Net2
ALL	GUDANG_BARANG	gudang_15 = CONTENTS(GUDANG_BARANG, KARUNG_15) gudang_24 = CONTENTS(GUDANG_BARANG, KARUNG_24) gudang_26 = CONTENTS(GUDANG_BARANG, KARUNG_26) gudang_28 = CONTENTS(GUDANG_BARANG, KARUNG_28)						

```

gudang_30 = CONTENTS(GUDANG_BARANG, KARUNG_30)
gudang_40 = CONTENTS(GUDANG_BARANG, KARUNG_40)
1 ALL EXIT FIRST 1

```

```

*****
* Arrivals *
*****

```

Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
BIJI_PLASTIK	GUDANG_BAHAN	6000	0	INF	24 HR	
PEWARNA	GUDANG_BAHAN	600	0	INF	24 HR	
KARUNG_15	TEMPAT_KARUNG	2500	0	INF	240 HR	
KARUNG_24	TEMPAT_KARUNG	2500	0	INF	240 HR	
KARUNG_26	TEMPAT_KARUNG	1500	0	INF	240 HR	
KARUNG_28	TEMPAT_KARUNG	1000	0	INF	240 HR	
KARUNG_30	TEMPAT_KARUNG	1500	0	inf	240 HR	
KARUNG_40	TEMPAT_KARUNG	1000	0	INF	240 HR	

```

*****
* Shift Assignments *
*****

```

Locations	Resources	Shift Files	Priorities	Disable Logic
ORDERAN		E:\DATA\Sherly Works\TA SHERLY	99,99,99,99	No

```

*****
* Variables (global) *
*****

```

ID	Type	Initial value	Stats
RuleRoute_15	Integer	0	Time Series

RuleRoute_24	Integer	0	Time Series
RuleRoute_26	Integer	0	Time Series
RuleRoute_28	Integer	0	Time Series
RuleRoute_30	Integer	0	Time Series
RuleRoute_40	Integer	0	Time Series
Henti_15	Integer	0	Time Series
Henti_24	Integer	0	Time Series
Henti_26	Integer	0	Time Series
Henti_28	Integer	0	Time Series
Henti_30	Integer	0	Time Series
Henti_40	Integer	0	Time Series
PESANAN_15	Integer	0	Time Series
PESANAN_24	Integer	0	Time Series
PESANAN_26	Integer	0	Time Series
PESANAN_28	Integer	0	Time Series
PESANAN_30	Integer	0	Time Series
PESANAN_40	Integer	0	Time Series
BERHENTI	Integer	0	Time Series
STOP_15	Integer	0	Time Series
STOP_24	Integer	0	Time Series
STOP_26	Integer	0	Time Series
STOP_28	Integer	0	Time Series
STOP_30	Integer	0	Time Series
STOP_40	Integer	0	Time Series
TOTAL_PESANAN_15	Integer	0	Time Series
TOTAL_PESANAN_24	Integer	0	Time Series
TOTAL_PESANAN_26	Integer	0	Time Series
TOTAL_PESANAN_28	Integer	0	Time Series
TOTAL_PESANAN_30	Integer	0	Time Series
TOTAL_PESANAN_40	Integer	0	Time Series
gudang_15	Integer	0	Time Series
gudang_24	Integer	0	Time Series
gudang_26	Integer	0	Time Series
gudang_28	Integer	0	Time Series
gudang_30	Integer	0	Time Series
gudang_40	Integer	0	Time Series

\*\*\*\*\*  
 \* Subroutines \*  
 \*\*\*\*\*

ID	Type	Parameter	Type	Logic
Sub1	None			ORDER 602 HD_15 TO INV_ROLLAN_15 ORDER 474 HD_24 TO INV_ROLLAN_24 ORDER 161 HD_26 TO INV_ROLLAN_26 ORDER 15 HD_28 TO INV_ROLLAN_28 ORDER 99 HD_30 TO INV_ROLLAN_30 ORDER 33 HD_40 TO INV_ROLLAN_40

\*\*\*\*\*  
 \* External Files \*  
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ID	Type	File Name	Prompt
(null)	Shift	E:\DATA\Sherly Works\TA SHERLY\PESANAN.sft	



- *Output*

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 General Report

Output from E:\DATA\Sherly Works\TA SHERLY\TA FIX\usulan\skenario 3\1\1.MOD

Date: May/13/2008 Time: 01:33:23 AM  
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Scenario : Normal Run

Replication : 1 of 1

Simulation Time : 1210 hr  
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LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Days Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
ROLLAN 15.1	1210	1	1614	0.03	1	1	1	100.00
ROLLAN 15.2	1210	1	1614	0.03	1	1	1	100.00
ROLLAN 15.3	1210	1	1614	0.03	1	1	1	100.00
ROLLAN 15.4	1210	1	1614	0.03	1	1	1	100.00
ROLLAN 15.5	1210	1	1614	0.03	1	1	1	100.00
ROLLAN 15	6050	5	8070	0.03	1	5	5	100.00
ROLLAN 24.1	1210	1	1578	0.03	1	1	1	100.00
ROLLAN 24.2	1210	1	1577	0.03	0.99	1	1	99.96
ROLLAN 24.3	1210	1	1577	0.03	0.99	1	1	99.96

ROLLAN 24.4	1210	1	1577	0.03	0.99	1	1	99.96
ROLLAN 24.5	1210	1	1577	0.03	0.99	1	1	99.94
ROLLAN 24.6	1210	1	1577	0.03	0.99	1	1	99.94
ROLLAN 24	7260	6	9463	0.03	0.99	6	6	99.96
ROLLAN 26.1	1210	1	1513	0.03	1	1	1	100.00
ROLLAN 26.2	1210	1	1513	0.03	1	1	1	100.00
ROLLAN 26	2420	2	3026	0.03	1	2	2	100.00
ROLLAN 28	1210	1	1453	0.03	1	1	1	100.00
ROLLAN 30.1	1210	1	1396	0.03	1	1	1	100.00
ROLLAN 30.2	1210	1	1395	0.03	0.99	1	1	99.95
ROLLAN 30	2420	2	2791	0.03	0.99	2	2	99.98
ROLLAN 40	1210	1	1019	0.04	1	1	1	100.00
POTONG M 15.1	1210	3	1626	0.09	2.97	3	3	99.19
POTONG M 15.2	1210	3	1626	0.09	2.97	3	3	99.19
POTONG M 15.3	1210	3	1626	0.09	2.97	3	3	99.19
POTONG M 15.4	1210	3	1626	0.09	2.97	3	3	99.19
POTONG M 15	4840	12	6504	0.09	2.97	12	12	99.19
POTONG M 24.1	1210	3	1334	0.09	2.53	3	2	84.49
POTONG M 24.2	1210	3	1334	0.09	2.53	3	2	84.49
POTONG M 24.3	1210	3	1334	0.09	2.53	3	2	84.47
POTONG M 24.4	1210	3	1334	0.09	2.53	3	3	84.46
POTONG M 24.5	1210	3	1334	0.09	2.53	3	3	84.45
POTONG M 24.6	1210	3	1333	0.09	2.53	3	2	84.44
POTONG M 24	7260	18	8003	0.09	2.53	18	14	84.46
POTONG M 26	1210	3	1791	0.08	2.98	3	3	99.36
POTONG M 28	1210	3	1467	0.08	2.44	3	2	81.45
POTONG M 30	1210	3	1581	0.09	2.97	3	3	99.30
POTONG O 15.1	1210	2	1048	0.09	1.99	2	2	99.52
POTONG O 15.2	1210	2	1048	0.09	1.99	2	2	99.52

POTONG O 15	2420	4	2096	0.09	1.99	4	4	99.52
POTONG O 24.1	1210	2	964	0.09	1.88	2	2	94.16
POTONG O 24.2	1210	2	964	0.09	1.88	2	2	94.14
POTONG O 24	2420	4	1928	0.09	1.88	4	4	94.15
POTONG O 26	1210	2	1162	0.08	1.98	2	2	99.23
POTONG O 30	1210	2	1038	0.09	1.98	2	2	99.36
POTONG M 40	1210	2	990	0.10	1.98	2	2	99.43
PLONG.1	1210	1	62471	0.00	0.40	1	0	40.28
PLONG.2	1210	1	62472	0.00	0.40	1	0	40.27
PLONG.3	1210	1	62473	0.00	0.40	1	0	40.29
PLONG	3630	3	187416	0.00	0.40	3	0	40.28
PACK	1210	9	243126	0.00	6.61	9	9	73.47
PACKING.1	1210	1	40520	0.00	0.74	1	1	74.38
PACKING.2	1210	1	40520	0.00	0.74	1	1	74.40
PACKING.3	1210	1	40519	0.00	0.74	1	1	74.39
PACKING.4	1210	1	40519	0.00	0.74	1	1	74.43
PACKING.5	1210	1	40520	0.00	0.74	1	1	74.44
PACKING.6	1210	1	40519	0.00	0.74	1	1	74.38
PACKING	7260	6	243117	0.00	0.74	6	6	74.40
GUDANG BAHAN	1210	160000	336600	1.41	9460.57	19451	16791	5.91
INV ROLLAN 15	1210	1038	8667	1.90	328.20	595	66	31.62
INV ROLLAN 24	1210	801	9931	0.26	52.85	465	0	6.60
INV ROLLAN 26	1210	307	3185	3.07	193.94	234	231	63.17
INV ROLLAN 28	1210	27	1467	0.00	0.21	13	0	0.80
INV ROLLAN 30	1210	299	2888	3.16	181.05	270	268	60.55
INV ROLLAN 40	1210	60	1051	2.81	58.72	60	60	97.87
WIP PLONG	1210	4500	187416	0.00	21.72	303	0	0.48
WIP PACK	1210	4500	243136	0.00	28.22	204	10	0.63
IKAT	1210	4	243111	0.00	2.09	4	3	52.26

WIP IKAT	1210	4500	243111	0.00	0.05	2	0	0.00
GUDANG BARANG	1210	999999	16260	0.00	0	1	0	0.00
WIP KARUNG	1210	4500	243108	0.00	15.39	40	21	0.34
BHN BAKU 15	1210	1	8071	0.00	1	1	1	100.00
BHN BAKU 24	1210	1	9464	0.00	1	1	1	100.00
BHN BAKU 26	1210	1	3027	0.01	1	1	1	100.00
BHN BAKU 28	1210	1	1454	0.03	1	1	1	100.00
BHN BAKU 30	1210	1	2792	0.01	1	1	1	100.00
BHN BAKU 40	1210	1	1020	0.04	1	1	1	100.00
TEMPAT KARUNG	1210	999999	60000	18.49	22013.5	43866	43734	2.20
KARUNG HD 15	1210	1	3434	0.01	1	1	1	100.00
KARUNG HD 24	1210	1	5947	0.00	1	1	1	100.00
KARUNG HD 26	1210	1	2062	0.02	1	1	1	100.00
KARUNG HD 28	1210	1	1221	0.04	1	1	1	100.00
KARUNG HD 30	1210	1	2614	0.01	1	1	1	100.00
KARUNG HD 40	1210	1	988	0.05	1	1	1	100.00
ORDERAN	396	999999	0	0.00	0	0	0	0.00
PT 15	1210	1	8601	0.00	1	1	1	100.00
PT 24	1210	1	9931	0.00	0.23	1	0	23.19
PT 26	1210	1	2954	0.01	1	1	1	100.00
PT 28	1210	1	1467	0.00	0.03	1	0	3.75
PT 30	1210	1	2620	0.01	1	1	1	100.00
PT 40	1210	1	991	0.05	1	1	1	100.00

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	% Empty	% Partially Occupied	% Full	% Down
POTONG M 15.1	1210	0.81	0.00	99.19	0.00
POTONG M 15.2	1210	0.81	0.00	99.19	0.00
POTONG M 15.3	1210	0.81	0.00	99.19	0.00
POTONG M 15.4	1210	0.81	0.00	99.19	0.00
POTONG M 15	4840	0.81	0.00	99.19	0.00
POTONG M 24.1	1210	0.18	45.99	53.83	0.00
POTONG M 24.2	1210	0.18	45.98	53.84	0.00
POTONG M 24.3	1210	0.18	46.05	53.77	0.00
POTONG M 24.4	1210	0.18	46.07	53.75	0.00
POTONG M 24.5	1210	0.18	46.11	53.71	0.00
POTONG M 24.6	1210	0.18	46.13	53.69	0.00
POTONG M 24	7260	0.18	46.05	53.77	0.00
POTONG M 26	1210	0.64	0.00	99.36	0.00
POTONG M 28	1210	0.03	55.55	44.42	0.00
POTONG M 30	1210	0.70	0.00	99.30	0.00
POTONG O 15.1	1210	0.48	0.00	99.52	0.00
POTONG O 15.2	1210	0.48	0.00	99.52	0.00
POTONG O 15	2420	0.48	0.00	99.52	0.00
POTONG O 24.1	1210	0.11	11.46	88.43	0.00
POTONG O 24.2	1210	0.11	11.51	88.39	0.00
POTONG O 24	2420	0.11	11.49	88.41	0.00
POTONG O 26	1210	0.77	0.00	99.23	0.00
POTONG O 30	1210	0.64	0.00	99.36	0.00

POTONG M 40	1210	0.57	0.00	99.43	0.00
PACK	1210	21.55	10.06	68.40	0.00
Gudang Bahan	1210	0.00	100.00	0.00	0.00
INV ROLLAN 15	1210	0.00	100.00	0.00	0.00
INV ROLLAN 24	1210	76.88	23.12	0.00	0.00
INV ROLLAN 26	1210	0.00	100.00	0.00	0.00
INV ROLLAN 28	1210	96.55	3.45	0.00	0.00
INV ROLLAN 30	1210	0.00	100.00	0.00	0.00
INV ROLLAN 40	1210	0.00	39.02	60.98	0.00
WIP PLONG	1210	62.04	37.96	0.00	0.00
WIP PACK	1210	34.59	65.41	0.00	0.00
IKAT	1210	25.11	55.44	19.44	0.00
WIP IKAT	1210	95.18	4.82	0.00	0.00
GUDANG BARANG	1210	100.00	0.00	0.00	0.00
WIP KARUNG	1210	0.18	99.82	0.00	0.00
TEMPAT KARUNG	1210	0.00	100.00	0.00	0.00
ORDERAN	396	100.00	0.00	0.00	0.00

LOCATION STATES BY PERCENTAGE (Single Capacity/Tanks)

Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down
ROLLAN 15.1	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 15.2	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 15.3	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 15.4	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 15.5	1210	100.00	0.00	0.00	0.00	0.00	0.00

ROLLAN 15	6050	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 24.1	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 24.2	1210	99.96	0.00	0.04	0.00	0.00	0.00
ROLLAN 24.3	1210	99.96	0.00	0.04	0.00	0.00	0.00
ROLLAN 24.4	1210	99.96	0.00	0.04	0.00	0.00	0.00
ROLLAN 24.5	1210	99.94	0.00	0.06	0.00	0.00	0.00
ROLLAN 24.6	1210	99.94	0.00	0.06	0.00	0.00	0.00
ROLLAN 24	7260	99.96	0.00	0.04	0.00	0.00	0.00
ROLLAN 26.1	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 26.2	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 26	2420	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 28	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 30.1	1210	100.00	0.00	0.00	0.00	0.00	0.00
ROLLAN 30.2	1210	99.95	0.00	0.05	0.00	0.00	0.00
ROLLAN 30	2420	99.98	0.00	0.02	0.00	0.00	0.00
ROLLAN 40	1210	70.11	0.00	0.00	0.00	29.89	0.00
PLONG.1	1210	38.32	0.00	59.72	1.96	0.00	0.00
PLONG.2	1210	38.30	0.00	59.73	1.97	0.00	0.00
PLONG.3	1210	38.33	0.00	59.71	1.96	0.00	0.00
PLONG	3630	38.32	0.00	59.72	1.96	0.00	0.00
PACKING.1	1210	70.75	0.00	25.62	3.63	0.00	0.00
PACKING.2	1210	70.78	0.00	25.60	3.62	0.00	0.00
PACKING.3	1210	70.75	0.00	25.61	3.64	0.00	0.00
PACKING.4	1210	70.81	0.00	25.57	3.62	0.00	0.00
PACKING.5	1210	70.81	0.00	25.56	3.63	0.00	0.00
PACKING.6	1210	70.76	0.00	25.62	3.62	0.00	0.00
PACKING	7260	70.78	0.00	25.60	3.62	0.00	0.00
BHN BAKU 15	1210	0.00	0.00	0.00	0.00	100.00	0.00
BHN BAKU 24	1210	0.00	0.00	0.00	0.07	99.93	0.00

BHN BAKU 26	1210	0.00	0.00	0.00	0.00	100.00	0.00
BHN BAKU 28	1210	0.00	0.00	0.00	0.06	99.94	0.00
BHN BAKU 30	1210	0.00	0.00	0.00	0.08	99.92	0.00
BHN BAKU 40	1210	0.00	0.00	0.00	0.06	99.94	0.00
KARUNG HD 15	1210	14.19	0.00	0.00	85.81	0.00	0.00
KARUNG HD 24	1210	24.57	0.00	0.00	75.43	0.00	0.00
KARUNG HD 26	1210	8.52	0.00	0.00	91.48	0.00	0.00
KARUNG HD 28	1210	5.04	0.00	0.00	94.96	0.00	0.00
KARUNG HD 30	1210	10.80	0.00	0.00	89.20	0.00	0.00
KARUNG HD 40	1210	4.08	0.00	0.00	95.92	0.00	0.00
PT 15	1210	0.00	0.00	0.00	0.00	100.00	0.00
PT 24	1210	0.00	0.00	76.81	0.00	23.19	0.00
PT 26	1210	0.00	0.00	0.00	0.00	100.00	0.00
PT 28	1210	0.00	0.00	96.25	0.00	3.75	0.00
PT 30	1210	0.00	0.00	0.00	0.00	100.00	0.00
PT 40	1210	0.00	0.00	0.00	0.00	100.00	0.00

RESOURCES

Resource Name	Units	Scheduled Hours	Number Of Times Used	Average Days Per Usage	% Util
OP pack.1	1	1210	295784	0.00	72.92
OP pack.2	1	1210	295094	0.00	72.92
OP pack.3	1	1210	294329	0.00	72.92
OP pack.4	1	1210	295345	0.00	72.92



OP pack.5	1	1210	295148	0.00	72.92
OP pack.6	1	1210	294254	0.00	72.92
OP pack.7	1	1210	295139	0.00	72.92
OP pack.8	1	1210	294701	0.00	72.92
OP pack.9	1	1210	295076	0.00	72.92
OP pack.10	1	1210	295078	0.00	72.92
OP pack.11	1	1210	294649	0.00	72.92
OP pack.12	1	1210	295505	0.00	72.92
OP pack.13	1	1210	294162	0.00	72.92
OP pack.14	1	1210	295312	0.00	72.92
OP pack.15	1	1210	295047	0.00	72.92
OP pack.16	1	1210	294733	0.00	72.92
OP pack.17	1	1210	295100	0.00	72.92
OP pack.18	1	1210	294702	0.00	72.92
OP pack	18	21780	5.30	0.00	72.92

RESOURCE STATES BY PERCENTAGE

Resource Name	Scheduled Hours	% In Use	% Idle	% Down
OP pack.1	1210	72.92	27.08	0.00
OP pack.2	1210	72.92	27.08	0.00
OP pack.3	1210	72.92	27.08	0.00
OP pack.4	1210	72.92	27.08	0.00
OP pack.5	1210	72.92	27.08	0.00
OP pack.6	1210	72.92	27.08	0.00

OP pack.7	1210	72.92	27.08	0.00
OP pack.8	1210	72.92	27.08	0.00
OP pack.9	1210	72.92	27.08	0.00
OP pack.10	1210	72.92	27.08	0.00
OP pack.11	1210	72.92	27.08	0.00
OP pack.12	1210	72.92	27.08	0.00
OP pack.13	1210	72.92	27.08	0.00
OP pack.14	1210	72.92	27.08	0.00
OP pack.15	1210	72.92	27.08	0.00
OP pack.16	1210	72.92	27.08	0.00
OP pack.17	1210	72.92	27.08	0.00
OP pack.18	1210	72.92	27.08	0.00
OP pack	21780	72.92	27.08	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
-----	-----	-----
BIJI PLASTIK	GUDANG BAHAN	0
PEWARNA	GUDANG BAHAN	0
KARUNG 15	TEMPAT KARUNG	0
KARUNG 24	TEMPAT KARUNG	0
KARUNG 26	TEMPAT KARUNG	0
KARUNG 28	TEMPAT KARUNG	0
KARUNG 30	TEMPAT KARUNG	0
KARUNG 40	TEMPAT KARUNG	0

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Days In System	Average Days In Move Logic	Average Days Wait For Res, etc.	Average Days In Operation	Average Days Blocked
HD 15	103008	83	5.89	0.00	0.00	0.12	5.76
HD 24	89205	30	4.36	0.00	0.00	0.12	4.22
HD 26	20610	263	6.96	0.00	0.00	0.11	6.83
HD 28	7320	7	4.28	0.00	0.01	0.12	4.14
HD 30	13068	276	7.05	0.00	0.00	0.13	6.91
HD 40	9876	67	6.83	0.00	0.01	0.13	6.68
BIJI PLASTIK	293981	12036	1.15	0.00	0.00	0.00	1.15
PEWARNA	0	4778	-	-	-	-	-
PESANAN	0	0	-	-	-	-	-
KARUNG 15	3433	11567	22.53	0.00	0.01	0.00	22.52
KARUNG 24	5946	9054	16.96	0.00	0.00	0.00	16.95
KARUNG 26	2061	6939	22.51	0.00	0.02	0.00	22.48
KARUNG 28	1220	4780	23.22	0.00	0.03	0.00	23.18
KARUNG 30	2613	6387	20.99	0.00	0.01	0.00	20.97
KARUNG 40	987	5013	25.25	0.00	0.04	0.00	25.20

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
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HD 15	0.03	0.01	2.12	97.84
HD 24	0.05	0.03	2.97	96.95
HD 26	0.03	0.09	1.71	98.17
HD 28	0.06	0.40	2.83	96.72
HD 30	0.03	0.14	1.88	97.95
HD 40	0.03	0.15	2.01	97.81
BIJI PLASTIK	0.00	0.00	0.00	100.00
PEWARNA	-	-	-	-
PESANAN	-	-	-	-
KARUNG 15	0.00	0.06	0.01	99.93
KARUNG 24	0.00	0.04	0.01	99.95
KARUNG 26	0.00	0.10	0.01	99.89
KARUNG 28	0.00	0.17	0.01	99.82
KARUNG 30	0.00	0.08	0.01	99.91
KARUNG 40	0.00	0.19	0.01	99.80

VARIABLES

Variable Name	Total Changes	Average Days Per Change	Minimum Value	Maximum Value	Current Value	Average Value
RuleRoute 15	0	0.00	0	0	0	0
RuleRoute 24	0	0.00	0	0	0	0
RuleRoute 26	0	0.00	0	0	0	0
RuleRoute 28	0	0.00	0	0	0	0
RuleRoute 30	0	0.00	0	0	0	0
RuleRoute 40	0	0.00	0	0	0	0
Henti 15	0	0.00	0	0	0	0
Henti 24	0	0.00	0	0	0	0
Henti 26	0	0.00	0	0	0	0
Henti 28	0	0.00	0	0	0	0
Henti 30	0	0.00	0	0	0	0
Henti 40	0	0.00	0	0	0	0
PESANAN 15	0	0.00	0	0	0	0
PESANAN 24	0	0.00	0	0	0	0
PESANAN 26	0	0.00	0	0	0	0
PESANAN 28	0	0.00	0	0	0	0
PESANAN 30	0	0.00	0	0	0	0
PESANAN 40	0	0.00	0	0	0	0
BERHENTI	0	0.00	0	0	0	0
STOP 15	0	0.00	0	0	0	0
STOP 24	0	0.00	0	0	0	0
STOP 26	0	0.00	0	0	0	0
STOP 28	0	0.00	0	0	0	0

STOP 30	0	0.00	0	0	0	0
STOP 40	0	0.00	0	0	0	0
TOTAL PESANAN 15	0	0.00	0	0	0	0
TOTAL PESANAN 24	0	0.00	0	0	0	0
TOTAL PESANAN 26	0	0.00	0	0	0	0
TOTAL PESANAN 28	0	0.00	0	0	0	0
TOTAL PESANAN 30	0	0.00	0	0	0	0
TOTAL PESANAN 40	0	0.00	0	0	0	0
gudang 15	16260	0.00	0	1	0	0.28
gudang 24	16260	0.00	0	1	1	0.35
gudang 26	16260	0.00	0	1	0	0.10
gudang 28	16260	0.00	0	1	0	0.08
gudang 30	16260	0.00	0	1	0	0.12
gudang 40	16260	0.00	0	1	0	0.04

# **LAMPIRAN 9**

## **Dokumentasi Perusahaan**



**Gudang Bahan Baku**



**Mesin Rol (Tahap Peleburan dan Penarikan Plastik)**





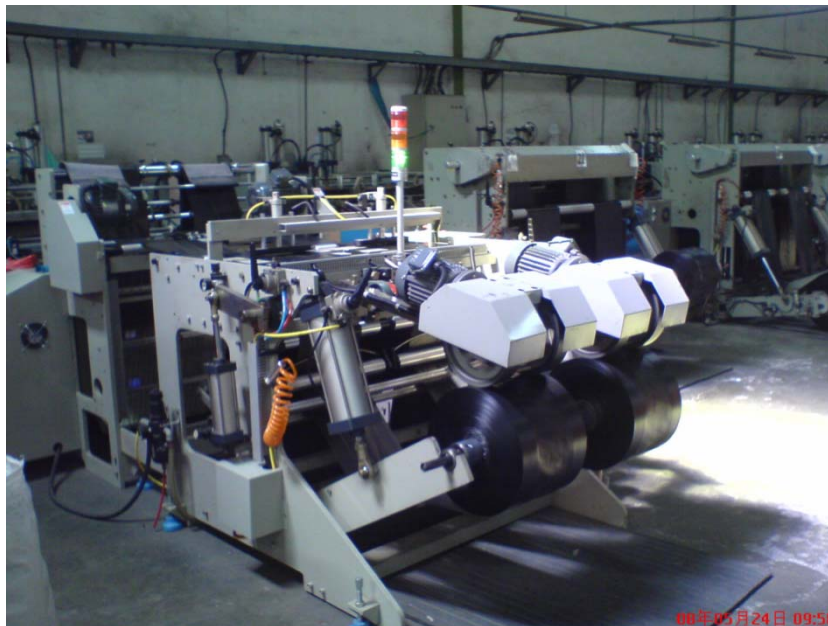
**Drum Tempat Biji Plastik** ←



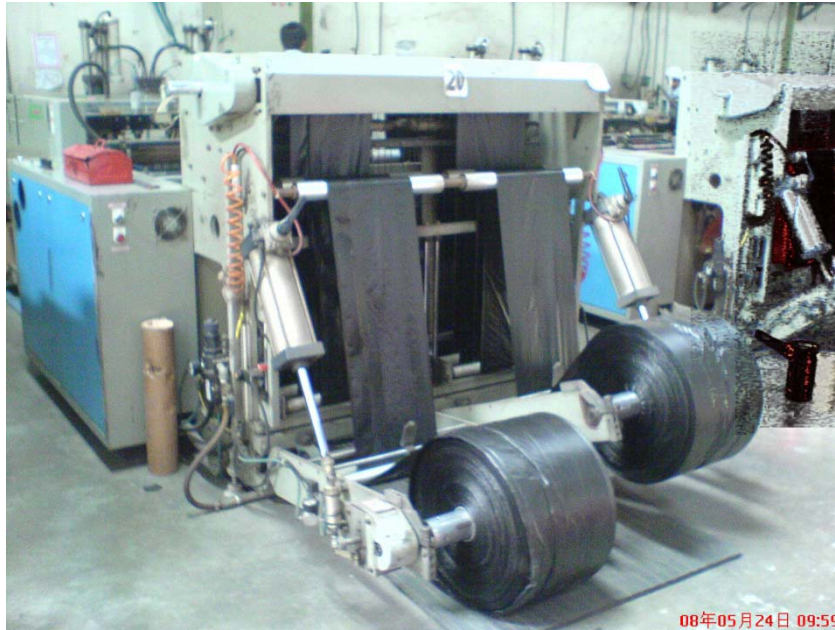
**Hasil dari Proses Mesin Rol**



**Persediaan Awal di Departemen Potong**



**Mesin Potong Otomatis dengan Kapasitas 2 unit**



**Mesin Potong Otomatis dengan Kapasitas 2 unit**



**Mesin Potong Manual**



**Proses Pengeplongan Kantong Kresek**



**Keadaan Proses Pembungkusan**



**Hasil dari Proses Packing**



**Hasil dari Proses Pengikatan**



**Kantung Kresek yang akan Dipacking Menggunakan Karung**



**Gudang Barang Jadi**



**Afal dari Proses Produksi**

# **LAMPIRAN 10**

## **Tabel Kurva Normal**



## Input Data

| LAPORAN TAHUNAN | STATISTIK | PROFIL PERUSAHAAN | HUBUNGAN INVESTOR | KARIR |

Bahasa Indonesia (Indonesia) ▼

Simulasi Rekening

### Simulasi Rekening

**Anda dapat melakukan simulasi tagihan rekening listrik disini!**

Tarif Tunggal

Pilih Golongan Tarif - Daya : P1-197000 ▼

Pilih Cara Perhitungan dan Masukkan Besaran :

Pemakaian kWh  [KWh]

**Atau**

Stand Meter   
Stand Meter Akhir [KWh]

## Hasil Perhitungan

| LAPORAN TAHUNAN | STATISTIK | PROFIL PERUSAHAAN | HUBUNGAN INVESTOR | KARIR |

Bahasa Indonesia (Indonesia) ▼

Simulasi Rekening

### Simulasi Rekening

**TDL 2003 (Bulan Juli - September)**

Pemakaian = 20 kWh Golongan = P1-197000

No.	Item	Perhitungan	Jumlah (Rupiah)
1.	Beban	$197000 / 1000 \times \text{Rp.}24,600.00$	Rp.4,846,200.
2.	Blok I : Tidak ada blok	$20 \text{ kWh} \times \text{Rp.}600.00$	Rp.12,000.00
3.	Blok II :		
4.	Blok III :		
Jumlah Rupiah Tagihan			Rp.4,858,200.

[Hitung Lagi](#)

Hasil Simulasi Periode Lain :

TDL April 2003 - Juni ▼ [Lihat](#)