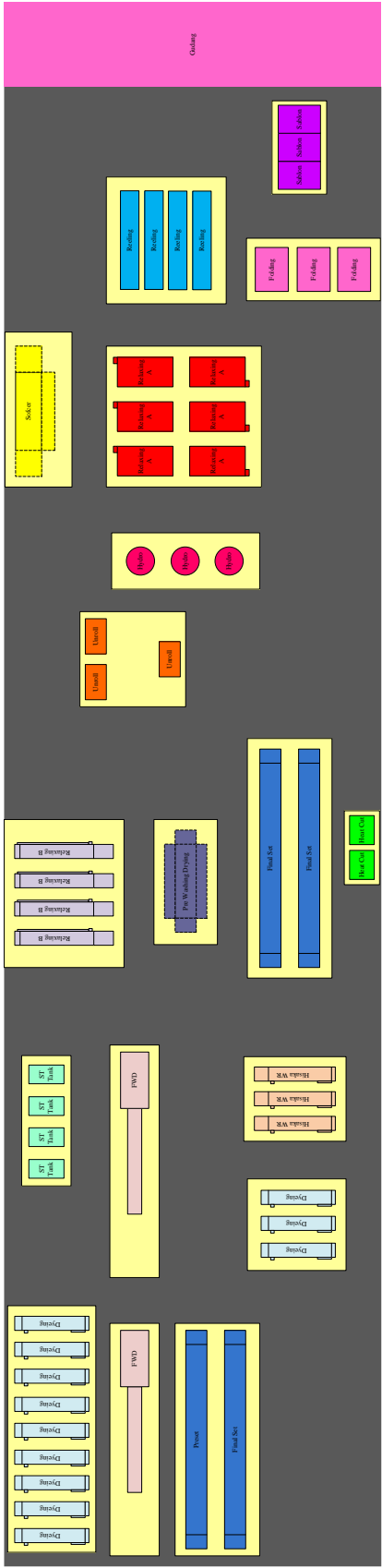


# **LAMPIRAN 1**

- **LAYOUT LANTAI PRODUKSI**



# **LAMPIRAN 2**

## **SKENARIO 1**

- **INPUT SIMULASI AKTUAL**
- **OUTPUT SIMULASI AKTUAL**

## • Input Promodel (Skenario 1)

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*
* Formatted Listing of Model:
* D:\Maranatha\Kuliah\TA\Laporan\Promodel\Aktual\Jmlah yg di produksi dr solver 1 tahun.MOD *
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Time Units:           Minutes
Distance Units:      Feet

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* Locations
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Name	Cap	Units	Stats	Rules	Cost
Gudang	inf	1	Time Series	Oldest, , First	
Reeling	1	4	Time Series	Oldest, , First	
Reeling.1	1	1	Time Series	Oldest, ,	
Reeling.2	1	1	Time Series	Oldest, ,	
Reeling.3	1	1	Time Series	Oldest, ,	
Reeling.4	1	1	Time Series	Oldest, ,	
Relaxing_A	1	6	Time Series	Oldest, , First	
Relaxing_A.1	1	1	Time Series	Oldest, ,	
Relaxing_A.2	1	1	Time Series	Oldest, ,	
Relaxing_A.3	1	1	Time Series	Oldest, ,	
Relaxing_A.4	1	1	Time Series	Oldest, ,	
Relaxing_A.5	1	1	Time Series	Oldest, ,	
Relaxing_A.6	1	1	Time Series	Oldest, ,	
Relaxing_B	1	4	Time Series	Oldest, , First	
Relaxing_B.1	1	1	Time Series	Oldest, ,	
Relaxing_B.2	1	1	Time Series	Oldest, ,	
Relaxing_B.3	1	1	Time Series	Oldest, ,	
Relaxing_B.4	1	1	Time Series	Oldest, ,	
Hydro	1	3	Time Series	Oldest, , First	
Hydro.1	1	1	Time Series	Oldest, ,	
Hydro.2	1	1	Time Series	Oldest, ,	
Hydro.3	1	1	Time Series	Oldest, ,	
Sofcer	1	1	Time Series	Oldest, ,	
Unroll	1	3	Time Series	Oldest, , First	
Unroll.1	1	1	Time Series	Oldest, ,	
Unroll.2	1	1	Time Series	Oldest, ,	
Unroll.3	1	1	Time Series	Oldest, ,	
Pre_Washing_Drying	1	1	Time Series	Oldest, ,	
Preset	1	1	Time Series	Oldest, ,	
Hisaka_WR	1	3	Time Series	Oldest, , First	
Hisaka_WR.1	1	1	Time Series	Oldest, ,	
Hisaka_WR.2	1	1	Time Series	Oldest, ,	
Hisaka_WR.3	1	1	Time Series	Oldest, ,	
ST_Tank	1	4	Time Series	Oldest, , First	
ST_Tank.1	1	1	Time Series	Oldest, ,	
ST_Tank.2	1	1	Time Series	Oldest, ,	
ST_Tank.3	1	1	Time Series	Oldest, ,	
ST_Tank.4	1	1	Time Series	Oldest, ,	
Dyeing_Colour	1	7	Time Series	Oldest, , First	
Dyeing_Colour.1	1	1	Time Series	Oldest, ,	
Dyeing_Colour.2	1	1	Time Series	Oldest, ,	
Dyeing_Colour.3	1	1	Time Series	Oldest, ,	
Dyeing_Colour.4	1	1	Time Series	Oldest, ,	
Dyeing_Colour.5	1	1	Time Series	Oldest, ,	
Dyeing_Colour.6	1	1	Time Series	Oldest, ,	
Dyeing_Colour.7	1	1	Time Series	Oldest, ,	
FWD	1	2	Time Series	Oldest, , First	
FWD.1	1	1	Time Series	Oldest, ,	
FWD.2	1	1	Time Series	Oldest, ,	
Final_Set	1	3	Time Series	Oldest, , First	
Final_Set.1	1	1	Time Series	Oldest, ,	
Final_Set.2	1	1	Time Series	Oldest, ,	
Final_Set.3	1	1	Time Series	Oldest, ,	
Heat_Cut	1	2	Time Series	Oldest, , First	
Heat_Cut.1	1	1	Time Series	Oldest, ,	
Heat_Cut.2	1	1	Time Series	Oldest, ,	
Folding	1	3	Time Series	Oldest, , First	
Folding.1	1	1	Time Series	Oldest, ,	
Folding.2	1	1	Time Series	Oldest, ,	
Folding.3	1	1	Time Series	Oldest, ,	
Sablon	1	3	Time Series	Oldest, , First	
Sablon.1	1	1	Time Series	Oldest, ,	
Sablon.2	1	1	Time Series	Oldest, ,	
Sablon.3	1	1	Time Series	Oldest, ,	
WIP_Reeling	21	1	Time Series	Oldest, , First	
WIP_Relaxing_A	6	1	Time Series	Oldest, , First	
WIP_Relaxing_B	14	1	Time Series	Oldest, , First	
WIP_Hydro	7	1	Time Series	Oldest, , First	
WIP_Sofcer	6	1	Time Series	Oldest, , First	
WIP_Unroll	3	1	Time Series	Oldest, , First	
WIP_Pre_Washing_Drying	4	1	Time Series	Oldest, , First	
WIP_Preset	8	1	Time Series	Oldest, , First	
WIP_Hisaka_WR	6	1	Time Series	Oldest, , First	
WIP_ST_Tank	8	1	Time Series	Oldest, , First	
WIP_Dyeing_Colour	7	1	Time Series	Oldest, , First	
WIP_FWD	18	1	Time Series	Oldest, , First	
WIP_Final_Set	24	1	Time Series	Oldest, , First	
WIP_Heat_Cut	4	1	Time Series	Oldest, , First	
WIP_Folding	3	1	Time Series	Oldest, , First	
Dyeing_Black	1	5	Time Series	Oldest, , First	
Dyeing_Black.1	1	1	Time Series	Oldest, ,	
Dyeing_Black.2	1	1	Time Series	Oldest, ,	
Dyeing_Black.3	1	1	Time Series	Oldest, ,	
Dyeing_Black.4	1	1	Time Series	Oldest, ,	
Dyeing_Black.5	1	1	Time Series	Oldest, ,	
WIP_Sablon	6	1	Time Series	Oldest, , First	
WIP_Dyeing_Black	5	1	Time Series	Oldest, , First	

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 \* Entities \*  
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Name	Speed (fpm)	Stats	Cost
Item_79	150	Time Series	
Item_106	150	Time Series	
Item_150	150	Time Series	
Item_60	150	Time Series	
Item_18	150	Time Series	
Item_72	150	Time Series	
Item_38	150	Time Series	
Item_97	150	Time Series	
Item_48	150	Time Series	
Item_81	150	Time Series	
Item_128	150	Time Series	
Item_51	150	Time Series	
Item_28	150	Time Series	
Item_93	150	Time Series	
Item_6	150	Time Series	
Item_126	150	Time Series	
Item_50	150	Time Series	
Item_73	150	Time Series	
Item_98	150	Time Series	
Item_91	150	Time Series	
Item_90	150	Time Series	
Item_147	150	Time Series	
Item_104	150	Time Series	
Item_43	150	Time Series	
Item_16	150	Time Series	
Item_130	150	Time Series	
Item_131	150	Time Series	
Item_45	150	Time Series	
work_order	150	Time Series	

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 \* Processing \*  
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Entity	Location	Process		Routing			
		Operation	Blk	Output	Destination	Rule	Move Logic
Item_79	Gudang		1	Item_79	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_Relaxing_B		1	Item_79	Relaxing_B	FIRST 1	
Item_79	Relaxing_B	WAIT U(120, 0)	1	Item_79	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Sofcer		1	Item_79	Sofcer	FIRST 1	
Item_79	Sofcer	WAIT U(20, 0)	1	Item_79	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Unroll		1	Item_79	Unroll	FIRST 1	
Item_79	Unroll	WAIT U(25, 0)	1	Item_79	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Pre_Washing_Drying		1	Item_79	Pre_Washing_Drying	FIRST 1	
Item_79	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_79	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Preset		1	Item_79	Preset	FIRST 1	
Item_79	Preset	WAIT U(45, 0)	1	Item_79	WIP_ST_Tank	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_ST_Tank		1	Item_79	ST_Tank	FIRST 1	
Item_79	ST_Tank	WAIT U(25, 0)	1	Item_79	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_Dyeing_Colour		1	Item_79	Dyeing_Colour	FIRST 1	
Item_79	Dyeing_Colour	WAIT U(150, 0)	1	Item_79	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_FWD		1	Item_79	FWD	FIRST 1	
Item_79	FWD	WAIT U(40, 0)	1	Item_79	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_79	WIP_Final_Set		1	Item_79	Final_Set	FIRST 1	
Item_79	Final_Set	WAIT U(35, 0)	1	Item_79	EXIT	FIRST 1	MOVE FOR 2 MIN
Item_106	Gudang		1	Item_106	WIP_Reeling	FIRST 1	MOVE FOR 3 MIN
Item_106	WIP_Reeling		1	Item_106	Reeling	FIRST 1	
Item_106	Reeling	WAIT U(25, 0)	1	Item_106	WIP_Relaxing_A	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Relaxing_A		1	Item_106	Relaxing_A	FIRST 1	
Item_106	Relaxing_A	WAIT U(120, 0)	1	Item_106	WIP_Hydro	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Hydro		1	Item_106	Hydro	FIRST 1	
Item_106	Hydro	WAIT U(35, 0)	1	Item_106	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Unroll		1	Item_106	Unroll	FIRST 1	
Item_106	Unroll	WAIT U(25, 0)	1	Item_106	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Pre_Washing_Drying		1	Item_106	Pre_Washing_Drying	FIRST 1	
Item_106	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_106	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Preset		1	Item_106	Preset	FIRST 1	
Item_106	Preset	WAIT U(45, 0)	1	Item_106	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_106	WIP_Hisaka_WR		1	Item_106	Hisaka_WR	FIRST 1	
Item_106	Hisaka_WR	WAIT U(120, 0)	1	Item_106	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_106	WIP_Dyeing_Colour		1	Item_106	Dyeing_Colour	FIRST 1	
Item_106	Dyeing_Colour	WAIT U(150, 0)	1	Item_106	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_106	WIP_FWD		1	Item_106	FWD	FIRST 1	
Item_106	FWD	WAIT U(40, 0)	1	Item_106	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_106	WIP_Final_Set		1	Item_106	Final_Set	FIRST 1	
Item_106	Final_Set	WAIT U(35, 0)	1	Item_106	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_150	Gudang		1	Item_150	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Relaxing_B		1	Item_150	Relaxing_B	FIRST 1	
Item_150	Relaxing_B	WAIT U(120, 0)	1	Item_150	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_150	WIP_Unroll		1	Item_150	Unroll	FIRST 1	
Item_150	Unroll	WAIT U(25, 0)	1	Item_150	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_150	WIP_Preset		1	Item_150	Preset	FIRST 1	
Item_150	Preset	WAIT U(45, 0)	1	Item_150	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Hisaka_WR		1	Item_150	Hisaka_WR	FIRST 1	
Item_150	Hisaka_WR	WAIT U(120, 0)	1	Item_150	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Dyeing_Colour		1	Item_150	Dyeing_Colour	FIRST 1	
Item_150	Dyeing_Colour	WAIT U(150, 0)	1	Item_150	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_FWD		1	Item_150	FWD	FIRST 1	
Item_150	FWD	WAIT U(40, 0)	1	Item_150	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_150	WIP_Final_Set		1	Item_150	Final_Set	FIRST 1	
Item_150	Final_Set	WAIT U(35, 0)	1	Item_150	WIP_Heat_Cut	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Heat_Cut		1	Item_150	Heat_Cut	FIRST 1	
Item_150	Heat_Cut	WAIT U(20, 0)	1	Item_150	WIP_Folding	FIRST 1	MOVE FOR 3 MIN
Item_150	WIP_Folding		1	Item_150	Folding	FIRST 1	
Item_150	Folding	WAIT U(45, 0)	1	Item_150	WIP_Sablon	FIRST 1	MOVE FOR 2 MIN
Item_150	WIP_Sablon		1	Item_150	Sablon	FIRST 1	
Item_150	Sablon	WAIT U(50, 0)	1	Item_150	EXIT	FIRST 1	MOVE FOR 5 MIN
Item_60	Gudang		1	Item_60	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_60	WIP_Relaxing_B		1	Item_60	Relaxing_B	FIRST 1	
Item_60	Relaxing_B	WAIT U(120, 0)	1	Item_60	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_60	WIP_Unroll		1	Item_60	Unroll	FIRST 1	
Item_60	Unroll	WAIT U(25, 0)	1	Item_60	WIP_Preset	FIRST 1	MOVE FOR 6 MIN

Item_60	WIP_Preset		1	Item_60	Preset	FIRST	1
Item_60	Preset	WAIT U(45, 0)	1	Item_60	WIP_Hisaka_WR	FIRST	1
Item_60	WIP_Hisaka_WR		1	Item_60	Hisaka_WR	FIRST	1
Item_60	Hisaka_WR	WAIT U(120, 0)	1	Item_60	WIP_Dyeing_Colour	FIRST	1
Item_60	WIP_Dyeing_Colour		1	Item_60	Dyeing_Colour	FIRST	1
Item_60	Dyeing_Colour	WAIT U(150, 0)	1	Item_60	WIP_FWD	FIRST	1
Item_60	WIP_FWD		1	Item_60	FWD	FIRST	1
Item_60	FWD	WAIT U(40, 0)	1	Item_60	WIP_Final_Set	FIRST	1
Item_60	WIP_Final_Set		1	Item_60	Final_Set	FIRST	1
Item_60	Final_Set	WAIT U(35, 0)	1	Item_60	EXIT	FIRST	1
Item_18	Gudang		1	Item_18	WIP_Relaxing_B	FIRST	1
Item_18	WIP_Relaxing_B		1	Item_18	Relaxing_B	FIRST	1
Item_18	Relaxing_B	WAIT U(120, 0)	1	Item_18	WIP_Unroll	FIRST	1
Item_18	WIP_Unroll		1	Item_18	Unroll	FIRST	1
Item_18	Unroll	WAIT U(25, 0)	1	Item_18	WIP_Pre_Washing_Drying	FIRST	1
Item_18	WIP_Pre_Washing_Drying		1	Item_18	Pre_Washing_Drying	FIRST	1
Item_18	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_18	WIP_Preset	FIRST	1
Item_18	WIP_Preset		1	Item_18	Preset	FIRST	1
Item_18	Preset	WAIT U(45, 0)	1	Item_18	WIP_Hisaka_WR	FIRST	1
Item_18	WIP_Hisaka_WR		1	Item_18	Hisaka_WR	FIRST	1
Item_18	Hisaka_WR	WAIT U(120, 0)	1	Item_18	WIP_Dyeing_Black	FIRST	1
Item_18	WIP_Dyeing_Black		1	Item_18	Dyeing_Black	FIRST	1
Item_18	Dyeing_Black	WAIT U(150, 0)	1	Item_18	WIP_FWD	FIRST	1
Item_18	WIP_FWD		1	Item_18	FWD	FIRST	1
Item_18	FWD	WAIT U(40, 0)	1	Item_18	WIP_Final_Set	FIRST	1
Item_18	WIP_Final_Set		1	Item_18	Final_Set	FIRST	1
Item_18	Final_Set	WAIT U(35, 0)	1	Item_18	WIP_Heat_Cut	FIRST	1
Item_18	WIP_Heat_Cut		1	Item_18	Heat_Cut	FIRST	1
Item_18	Heat_Cut	WAIT U(20, 0)	1	Item_18	WIP_Sablon	FIRST	1
Item_18	WIP_Sablon		1	Item_18	Sablon	FIRST	1
Item_18	Sablon	WAIT U(50, 0)	1	Item_18	EXIT	FIRST	1
Item_72	Gudang		1	Item_72	WIP_Reeling	FIRST	1
Item_72	WIP_Reeling		1	Item_72	Reeling	FIRST	1
Item_72	Reeling	WAIT U(25, 0)	1	Item_72	WIP_Relaxing_A	FIRST	1
Item_72	WIP_Relaxing_A		1	Item_72	Relaxing_A	FIRST	1
Item_72	Relaxing_A	WAIT U(120, 0)	1	Item_72	WIP_Hydro	FIRST	1
Item_72	WIP_Hydro		1	Item_72	Hydro	FIRST	1
Item_72	Hydro	WAIT U(35, 0)	1	Item_72	WIP_Unroll	FIRST	1
Item_72	WIP_Unroll		1	Item_72	Unroll	FIRST	1
Item_72	Unroll	WAIT U(25, 0)	1	Item_72	WIP_Preset	FIRST	1
Item_72	WIP_Preset		1	Item_72	Preset	FIRST	1
Item_72	Preset	WAIT U(45, 0)	1	Item_72	WIP_Hisaka_WR	FIRST	1
Item_72	WIP_Hisaka_WR		1	Item_72	Hisaka_WR	FIRST	1
Item_72	Hisaka_WR	WAIT U(120, 0)	1	Item_72	WIP_Dyeing_Colour	FIRST	1
Item_72	WIP_Dyeing_Colour		1	Item_72	Dyeing_Colour	FIRST	1
Item_72	Dyeing_Colour	WAIT U(150, 0)	1	Item_72	WIP_FWD	FIRST	1
Item_72	WIP_FWD		1	Item_72	FWD	FIRST	1
Item_72	FWD	WAIT U(40, 0)	1	Item_72	WIP_Final_Set	FIRST	1
Item_72	WIP_Final_Set		1	Item_72	Final_Set	FIRST	1
Item_72	Final_Set	WAIT U(35, 0)	1	Item_72	EXIT	FIRST	1
Item_38	Gudang		1	Item_38	WIP_Reeling	FIRST	1
Item_38	WIP_Reeling		1	Item_38	Reeling	FIRST	1
Item_38	Reeling	WAIT U(25, 0)	1	Item_38	WIP_Relaxing_A	FIRST	1
Item_38	WIP_Relaxing_A		1	Item_38	Relaxing_A	FIRST	1
Item_38	Relaxing_A	WAIT U(120, 0)	1	Item_38	WIP_Hydro	FIRST	1
Item_38	WIP_Hydro		1	Item_38	Hydro	FIRST	1
Item_38	Hydro	WAIT U(35, 0)	1	Item_38	WIP_Unroll	FIRST	1
Item_38	WIP_Unroll		1	Item_38	Unroll	FIRST	1
Item_38	Unroll	WAIT U(25, 0)	1	Item_38	WIP_Preset	FIRST	1
Item_38	WIP_Preset		1	Item_38	Preset	FIRST	1
Item_38	Preset	WAIT U(45, 0)	1	Item_38	WIP_ST_Tank	FIRST	1
Item_38	WIP_ST_Tank		1	Item_38	ST_Tank	FIRST	1
Item_38	ST_Tank	WAIT U(25, 0)	1	Item_38	WIP_Dyeing_Colour	FIRST	1
Item_38	WIP_Dyeing_Colour		1	Item_38	Dyeing_Colour	FIRST	1
Item_38	Dyeing_Colour	WAIT U(150, 0)	1	Item_38	WIP_FWD	FIRST	1
Item_38	WIP_FWD		1	Item_38	FWD	FIRST	1
Item_38	FWD	WAIT U(40, 0)	1	Item_38	WIP_Final_Set	FIRST	1
Item_38	WIP_Final_Set		1	Item_38	Final_Set	FIRST	1
Item_38	Final_Set	WAIT U(35, 0)	1	Item_38	EXIT	FIRST	1
Item_97	Gudang		1	Item_97	WIP_Reeling	FIRST	1
Item_97	WIP_Reeling		1	Item_97	Reeling	FIRST	1
Item_97	Reeling	WAIT U(25, 0)	1	Item_97	WIP_Relaxing_A	FIRST	1
Item_97	WIP_Relaxing_A		1	Item_97	Relaxing_A	FIRST	1
Item_97	Relaxing_A	WAIT U(120, 0)	1	Item_97	WIP_Hydro	FIRST	1
Item_97	WIP_Hydro		1	Item_97	Hydro	FIRST	1
Item_97	Hydro	WAIT U(35, 0)	1	Item_97	WIP_Unroll	FIRST	1
Item_97	WIP_Unroll		1	Item_97	Unroll	FIRST	1
Item_97	Unroll	WAIT U(25, 0)	1	Item_97	WIP_Pre_Washing_Drying	FIRST	1
Item_97	WIP_Pre_Washing_Drying		1	Item_97	Pre_Washing_Drying	FIRST	1
Item_97	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_97	WIP_Preset	FIRST	1
Item_97	WIP_Preset		1	Item_97	Preset	FIRST	1
Item_97	Preset	WAIT U(45, 0)	1	Item_97	WIP_Hisaka_WR	FIRST	1
Item_97	WIP_Hisaka_WR		1	Item_97	Hisaka_WR	FIRST	1
Item_97	Hisaka_WR	WAIT U(120, 0)	1	Item_97	WIP_Dyeing_Colour	FIRST	1
Item_97	WIP_Dyeing_Colour		1	Item_97	Dyeing_Colour	FIRST	1
Item_97	Dyeing_Colour	WAIT U(150, 0)	1	Item_97	WIP_FWD	FIRST	1
Item_97	WIP_FWD		1	Item_97	FWD	FIRST	1
Item_97	FWD	WAIT U(40, 0)	1	Item_97	WIP_Final_Set	FIRST	1
Item_97	WIP_Final_Set		1	Item_97	Final_Set	FIRST	1
Item_97	Final_Set	WAIT U(35, 0)	1	Item_97	EXIT	FIRST	1
Item_48	Gudang		1	Item_48	WIP_Relaxing_B	FIRST	1
Item_48	WIP_Relaxing_B		1	Item_48	Relaxing_B	FIRST	1
Item_48	Relaxing_B	WAIT U(120, 0)	1	Item_48	WIP_Unroll	FIRST	1
Item_48	WIP_Unroll		1	Item_48	Unroll	FIRST	1
Item_48	Unroll	WAIT U(25, 0)	1	Item_48	WIP_Pre_Washing_Drying	FIRST	1
Item_48	WIP_Pre_Washing_Drying		1	Item_48	Pre_Washing_Drying	FIRST	1
Item_48	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_48	WIP_Preset	FIRST	1
Item_48	WIP_Preset		1	Item_48	Preset	FIRST	1
Item_48	Preset	WAIT U(45, 0)	1	Item_48	WIP_Hisaka_WR	FIRST	1
Item_48	WIP_Hisaka_WR		1	Item_48	Hisaka_WR	FIRST	1
Item_48	Hisaka_WR	WAIT U(120, 0)	1	Item_48	WIP_Dyeing_Black	FIRST	1
Item_48	WIP_Dyeing_Black		1	Item_48	Dyeing_Black	FIRST	1
Item_48	Dyeing_Black	WAIT U(150, 0)	1	Item_48	WIP_FWD	FIRST	1
Item_48	WIP_FWD		1	Item_48	FWD	FIRST	1
Item_48	FWD	WAIT U(40, 0)	1	Item_48	WIP_Final_Set	FIRST	1
Item_48	WIP_Final_Set		1	Item_48	Final_Set	FIRST	1
Item_48	Final_Set	WAIT U(120, 0)	1	Item_48	WIP_Sablon	FIRST	1
Item_48	WIP_Sablon		1	Item_48	Sablon	FIRST	1
Item_48	Sablon	WAIT U(50, 0)	1	Item_48	EXIT	FIRST	1
Item_81	Gudang		1	Item_81	WIP_Relaxing_B	FIRST	1
Item_81	WIP_Relaxing_B		1	Item_81	Relaxing_B	FIRST	1
Item_81	Relaxing_B	WAIT U(120, 0)	1	Item_81	WIP_Unroll	FIRST	1
Item_81	WIP_Unroll		1	Item_81	Unroll	FIRST	1

Item_81	Unroll	WAIT U(25, 0)	1	Item_81	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_81	WIP_Pre_Washing_Drying		1	Item_81	Pre_Washing_Drying	FIRST 1		
Item_81	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_81	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_Preset		1	Item_81	Preset	FIRST 1		
Item_81	Preset	WAIT U(45, 0)	1	Item_81	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_Hisaka_WR		1	Item_81	Hisaka_WR	FIRST 1		
Item_81	Hisaka_WR	WAIT U(120, 0)	1	Item_81	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_Dyeing_Black		1	Item_81	Dyeing_Black	FIRST 1		
Item_81	Dyeing_Black	WAIT U(150, 0)	1	Item_81	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_FWD		1	Item_81	FWD	FIRST 1		
Item_81	FWD	WAIT U(40, 0)	1	Item_81	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_81	WIP_Final_Set		1	Item_81	Final_Set	FIRST 1		
Item_81	Final_Set	WAIT U(140, 0)	1	Item_81	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_128	Gudang		1	Item_128	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Relaxing_B		1	Item_128	Relaxing_B	FIRST 1		
Item_128	Relaxing_B	WAIT U(120, 0)	1	Item_128	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_128	WIP_Unroll		1	Item_128	Unroll	FIRST 1		
Item_128	Unroll	WAIT U(25, 0)	1	Item_128	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_128	WIP_Pre_Washing_Drying		1	Item_128	Pre_Washing_Drying	FIRST 1		
Item_128	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_128	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Preset		1	Item_128	Preset	FIRST 1		
Item_128	Preset	WAIT U(45, 0)	1	Item_128	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Hisaka_WR		1	Item_128	Hisaka_WR	FIRST 1		
Item_128	Hisaka_WR	WAIT U(120, 0)	1	Item_128	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Dyeing_Black		1	Item_128	Dyeing_Black	FIRST 1		
Item_128	Dyeing_Black	WAIT U(150, 0)	1	Item_128	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_FWD		1	Item_128	FWD	FIRST 1		
Item_128	FWD	WAIT U(40, 0)	1	Item_128	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_128	WIP_Final_Set		1	Item_128	Final_Set	FIRST 1		
Item_128	Final_Set	WAIT U(140, 0)	1	Item_128	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_51	Gudang		1	Item_51	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_51	WIP_Relaxing_B		1	Item_51	Relaxing_B	FIRST 1		
Item_51	Relaxing_B	WAIT U(120, 0)	1	Item_51	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_51	WIP_Sofcer		1	Item_51	Sofcer	FIRST 1		
Item_51	Sofcer	WAIT U(20, 0)	1	Item_51	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_51	WIP_Unroll		1	Item_51	Unroll	FIRST 1		
Item_51	Unroll	WAIT U(25, 0)	1	Item_51	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_51	WIP_Preset		1	Item_51	Preset	FIRST 1		
Item_51	Preset	WAIT U(45, 0)	1	Item_51	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_51	WIP_Hisaka_WR		1	Item_51	Hisaka_WR	FIRST 1		
Item_51	Hisaka_WR	WAIT U(120, 0)	1	Item_51	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_51	WIP_Dyeing_Colour		1	Item_51	Dyeing_Colour	FIRST 1		
Item_51	Dyeing_Colour	WAIT U(150, 0)	1	Item_51	WIP_Final_Set	FIRST 1	MOVE FOR	3 MIN
Item_51	WIP_Final_Set		1	Item_51	Final_Set	FIRST 1		
Item_51	Final_Set	WAIT U(35, 0)	1	Item_51	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_28	Gudang		1	Item_28	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_28	WIP_Reeling		1	Item_28	Reeling	FIRST 1		
Item_28	Reeling	WAIT U(25, 0)	1	Item_28	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Relaxing_A		1	Item_28	Relaxing_A	FIRST 1		
Item_28	Relaxing_A	WAIT U(120, 0)	1	Item_28	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Hydro		1	Item_28	Hydro	FIRST 1		
Item_28	Hydro	WAIT U(35, 0)	1	Item_28	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Unroll		1	Item_28	Unroll	FIRST 1		
Item_28	Unroll	WAIT U(25, 0)	1	Item_28	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Preset		1	Item_28	Preset	FIRST 1		
Item_28	Preset	WAIT U(45, 0)	1	Item_28	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_28	WIP_Hisaka_WR		1	Item_28	Hisaka_WR	FIRST 1		
Item_28	Hisaka_WR	WAIT U(120, 0)	1	Item_28	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_28	WIP_Dyeing_Colour		1	Item_28	Dyeing_Colour	FIRST 1		
Item_28	Dyeing_Colour	WAIT U(150, 0)	1	Item_28	WIP_Final_Set	FIRST 1	MOVE FOR	3 MIN
Item_28	WIP_Final_Set		1	Item_28	Final_Set	FIRST 1		
Item_28	Final_Set	WAIT U(120, 0)	1	Item_28	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_28	WIP_Heat_Cut		1	Item_28	Heat_Cut	FIRST 1		
Item_28	Heat_Cut	WAIT U(20, 0)	1	Item_28	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Sablon		1	Item_28	Sablon	FIRST 1		
Item_28	Sablon	WAIT U(50, 0)	1	Item_28	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_93	Gudang		1	Item_93	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_93	WIP_Reeling		1	Item_93	Reeling	FIRST 1		
Item_93	Reeling	WAIT U(25, 0)	1	Item_93	Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Relaxing_A		1	Item_93	Relaxing_A	FIRST 1		
Item_93	Relaxing_A	WAIT U(120, 0)	1	Item_93	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Hydro		1	Item_93	Hydro	FIRST 1		
Item_93	Hydro	WAIT U(35, 0)	1	Item_93	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Unroll		1	Item_93	Unroll	FIRST 1		
Item_93	Unroll	WAIT U(25, 0)	1	Item_93	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Preset		1	Item_93	Preset	FIRST 1		
Item_93	Preset	WAIT U(45, 0)	1	Item_93	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_Hisaka_WR		1	Item_93	Hisaka_WR	FIRST 1		
Item_93	Hisaka_WR	WAIT U(120, 0)	1	Item_93	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_Dyeing_Black		1	Item_93	Dyeing_Black	FIRST 1		
Item_93	Dyeing_Black	WAIT U(150, 0)	1	Item_93	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_FWD		1	Item_93	FWD	FIRST 1		
Item_93	FWD	WAIT U(40, 0)	1	Item_93	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_93	WIP_Final_Set		1	Item_93	Final_Set	FIRST 1		
Item_93	Final_Set	WAIT U(120, 0)	1	Item_93	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_Heat_Cut		1	Item_93	Heat_Cut	FIRST 1		
Item_93	Heat_Cut	WAIT U(20, 0)	1	Item_93	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Sablon		1	Item_93	Sablon	FIRST 1		
Item_93	Sablon	WAIT U(50, 0)	1	Item_93	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_6	Gudang		1	Item_6	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_Relaxing_B		1	Item_6	Relaxing_B	FIRST 1		
Item_6	Relaxing_B	WAIT U(120, 0)	1	Item_6	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_6	WIP_Sofcer		1	Item_6	Sofcer	FIRST 1		
Item_6	Sofcer	WAIT U(20, 0)	1	Item_6	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_6	WIP_Unroll		1	Item_6	Unroll	FIRST 1		
Item_6	Unroll	WAIT U(25, 0)	1	Item_6	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_6	WIP_Pre_Washing_Drying		1	Item_6	Pre_Washing_Drying	FIRST 1		
Item_6	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_6	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_6	WIP_Preset		1	Item_6	Preset	FIRST 1		
Item_6	Preset	WAIT U(45, 0)	1	Item_6	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_ST_Tank		1	Item_6	ST_Tank	FIRST 1		
Item_6	ST_Tank	WAIT U(25, 0)	1	Item_6	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_Dyeing_Black		1	Item_6	Dyeing_Black	FIRST 1		
Item_6	Dyeing_Black	WAIT U(150, 0)	1	Item_6	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_FWD		1	Item_6	FWD	FIRST 1		
Item_6	FWD	WAIT U(40, 0)	1	Item_6	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_6	WIP_Final_Set		1	Item_6	Final_Set	FIRST 1		
Item_6	Final_Set	WAIT U(120, 0)	1	Item_6	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_Sablon		1	Item_6	Sablon	FIRST 1		
Item_6	Sablon	WAIT U(50, 0)	1	Item_6	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_126	Gudang		1	Item_126	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_126	WIP_Reeling		1	Item_126	Reeling	FIRST 1		
Item_126	Reeling	WAIT U(25, 0)	1	Item_126	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN





Item_90	WIP_FWD		1	Item_90	FWD	FIRST	1
Item_90	FWD	WAIT U(40, 0)	1	Item_90	WIP_Final_Set	FIRST	1
Item_90	WIP_Final_Set		1	Item_90	Final_Set	FIRST	1
Item_90	Final_Set	WAIT U(35, 0)	1	Item_90	EXIT	FIRST	1
Item_147	Gudang		1	Item_147	WIP_Reeling	FIRST	1
Item_147	WIP_Reeling		1	Item_147	Reeling	FIRST	1
Item_147	Reeling	WAIT U(25, 0)	1	Item_147	WIP_Relaxing_A	FIRST	1
Item_147	WIP_Relaxing_A		1	Item_147	Relaxing_A	FIRST	1
Item_147	Relaxing_A	WAIT U(120, 0)	1	Item_147	WIP_Hydro	FIRST	1
Item_147	WIP_Hydro		1	Item_147	Hydro	FIRST	1
Item_147	Hydro	WAIT U(35, 0)	1	Item_147	WIP_Unroll	FIRST	1
Item_147	WIP_Unroll		1	Item_147	Unroll	FIRST	1
Item_147	Unroll	WAIT U(25, 0)	1	Item_147	WIP_Preset	FIRST	1
Item_147	WIP_Preset		1	Item_147	Preset	FIRST	1
Item_147	Preset	WAIT U(45, 0)	1	Item_147	WIP_ST_Tank	FIRST	1
Item_147	WIP_ST_Tank		1	Item_147	ST_Tank	FIRST	1
Item_147	ST_Tank	WAIT U(25, 0)	1	Item_147	WIP_Dyeing_Black	FIRST	1
Item_147	WIP_Dyeing_Black		1	Item_147	Dyeing_Black	FIRST	1
Item_147	Dyeing_Black	WAIT U(150, 0)	1	Item_147	WIP_FWD	FIRST	1
Item_147	WIP_FWD		1	Item_147	FWD	FIRST	1
Item_147	FWD	WAIT U(40, 0)	1	Item_147	WIP_Final_Set	FIRST	1
Item_147	WIP_Final_Set		1	Item_147	Final_Set	FIRST	1
Item_147	Final_Set	WAIT U(35, 0)	1	Item_147	EXIT	FIRST	1
Item_104	Gudang		1	Item_104	WIP_Relaxing_B	FIRST	1
Item_104	WIP_Relaxing_B		1	Item_104	Relaxing_B	FIRST	1
Item_104	Relaxing_B	WAIT U(120, 0)	1	Item_104	WIP_Unroll	FIRST	1
Item_104	WIP_Unroll		1	Item_104	Unroll	FIRST	1
Item_104	Unroll	WAIT U(25, 0)	1	Item_104	WIP_Preset	FIRST	1
Item_104	WIP_Preset		1	Item_104	Preset	FIRST	1
Item_104	Preset	WAIT U(45, 0)	1	Item_104	WIP_ST_Tank	FIRST	1
Item_104	WIP_ST_Tank		1	Item_104	ST_Tank	FIRST	1
Item_104	ST_Tank	WAIT U(25, 0)	1	Item_104	WIP_Dyeing_Colour	FIRST	1
Item_104	WIP_Dyeing_Colour		1	Item_104	Dyeing_Colour	FIRST	1
Item_104	Dyeing_Colour	WAIT U(150, 0)	1	Item_104	WIP_FWD	FIRST	1
Item_104	WIP_FWD		1	Item_104	FWD	FIRST	1
Item_104	FWD	WAIT U(40, 0)	1	Item_104	WIP_Final_Set	FIRST	1
Item_104	WIP_Final_Set		1	Item_104	Final_Set	FIRST	1
Item_104	Final_Set	WAIT U(120, 0)	1	Item_104	WIP_Sablon	FIRST	1
Item_104	WIP_Sablon		1	Item_104	Sablon	FIRST	1
Item_104	Sablon	WAIT U(50, 0)	1	Item_104	WIP_Relaxing_B	FIRST	1
Item_43	Gudang		1	Item_43	Relaxing_B	FIRST	1
Item_43	WIP_Relaxing_B		1	Item_43	Relaxing_B	FIRST	1
Item_43	Relaxing_B	WAIT U(120, 0)	1	Item_43	WIP_Sofcer	FIRST	1
Item_43	WIP_Sofcer		1	Item_43	Sofcer	FIRST	1
Item_43	Sofcer	WAIT U(20, 0)	1	Item_43	WIP_Unroll	FIRST	1
Item_43	WIP_Unroll		1	Item_43	Unroll	FIRST	1
Item_43	Unroll	WAIT U(25, 0)	1	Item_43	WIP_Preset	FIRST	1
Item_43	WIP_Preset		1	Item_43	Preset	FIRST	1
Item_43	Preset	WAIT U(45, 0)	1	Item_43	WIP_ST_Tank	FIRST	1
Item_43	WIP_ST_Tank		1	Item_43	ST_Tank	FIRST	1
Item_43	ST_Tank	WAIT U(25, 0)	1	Item_43	WIP_Dyeing_Black	FIRST	1
Item_43	WIP_Dyeing_Black		1	Item_43	Dyeing_Black	FIRST	1
Item_43	Dyeing_Black	WAIT U(150, 0)	1	Item_43	WIP_FWD	FIRST	1
Item_43	WIP_FWD		1	Item_43	FWD	FIRST	1
Item_43	FWD	WAIT U(40, 0)	1	Item_43	WIP_Final_Set	FIRST	1
Item_43	WIP_Final_Set		1	Item_43	Final_Set	FIRST	1
Item_43	Final_Set	WAIT U(140, 0)	1	Item_43	EXIT	FIRST	1
Item_16	Gudang		1	Item_16	WIP_Relaxing_B	FIRST	1
Item_16	WIP_Relaxing_B		1	Item_16	Relaxing_B	FIRST	1
Item_16	Relaxing_B	WAIT U(120, 0)	1	Item_16	WIP_Sofcer	FIRST	1
Item_16	WIP_Sofcer		1	Item_16	Sofcer	FIRST	1
Item_16	Sofcer	WAIT U(20, 0)	1	Item_16	WIP_Unroll	FIRST	1
Item_16	WIP_Unroll		1	Item_16	Unroll	FIRST	1
Item_16	Unroll	WAIT U(25, 0)	1	Item_16	WIP_Preset	FIRST	1
Item_16	WIP_Preset		1	Item_16	Preset	FIRST	1
Item_16	Preset	WAIT U(45, 0)	1	Item_16	WIP_Hisaka_WR	FIRST	1
Item_16	WIP_Hisaka_WR		1	Item_16	Hisaka_WR	FIRST	1
Item_16	Hisaka_WR	WAIT U(120, 0)	1	Item_16	WIP_Dyeing_Colour	FIRST	1
Item_16	WIP_Dyeing_Colour		1	Item_16	Dyeing_Colour	FIRST	1
Item_16	Dyeing_Colour	WAIT U(150, 0)	1	Item_16	WIP_FWD	FIRST	1
Item_16	WIP_FWD		1	Item_16	FWD	FIRST	1
Item_16	FWD	WAIT U(40, 0)	1	Item_16	WIP_Final_Set	FIRST	1
Item_16	WIP_Final_Set		1	Item_16	Final_Set	FIRST	1
Item_16	Final_Set	WAIT U(35, 0)	1	Item_16	EXIT	FIRST	1
Item_130	Gudang		1	Item_130	WIP_Reeling	FIRST	1
Item_130	WIP_Reeling		1	Item_130	Reeling	FIRST	1
Item_130	Reeling	WAIT U(25, 0)	1	Item_130	WIP_Relaxing_A	FIRST	1
Item_130	WIP_Relaxing_A		1	Item_130	Relaxing_A	FIRST	1
Item_130	Relaxing_A	WAIT U(120, 0)	1	Item_130	WIP_Hydro	FIRST	1
Item_130	WIP_Hydro		1	Item_130	Hydro	FIRST	1
Item_130	Hydro	WAIT U(35, 0)	1	Item_130	WIP_Unroll	FIRST	1
Item_130	WIP_Unroll		1	Item_130	Unroll	FIRST	1
Item_130	Unroll	WAIT U(25, 0)	1	Item_130	WIP_Preset	FIRST	1
Item_130	WIP_Preset		1	Item_130	Preset	FIRST	1
Item_130	Preset	WAIT U(45, 0)	1	Item_130	WIP_ST_Tank	FIRST	1
Item_130	WIP_ST_Tank		1	Item_130	ST_Tank	FIRST	1
Item_130	ST_Tank	WAIT U(25, 0)	1	Item_130	WIP_Dyeing_Black	FIRST	1
Item_130	WIP_Dyeing_Black		1	Item_130	Dyeing_Black	FIRST	1
Item_130	Dyeing_Black	WAIT U(150, 0)	1	Item_130	WIP_FWD	FIRST	1
Item_130	WIP_FWD		1	Item_130	FWD	FIRST	1
Item_130	FWD	WAIT U(40, 0)	1	Item_130	WIP_Final_Set	FIRST	1
Item_130	WIP_Final_Set		1	Item_130	Final_Set	FIRST	1
Item_130	Final_Set	WAIT U(35, 0)	1	Item_130	EXIT	FIRST	1
Item_131	Gudang		1	Item_131	WIP_Relaxing_B	FIRST	1
Item_131	WIP_Relaxing_B		1	Item_131	Relaxing_B	FIRST	1
Item_131	Relaxing_B	WAIT U(120, 0)	1	Item_131	WIP_Sofcer	FIRST	1
Item_131	WIP_Sofcer		1	Item_131	Sofcer	FIRST	1
Item_131	Sofcer	WAIT U(20, 0)	1	Item_131	WIP_Unroll	FIRST	1
Item_131	WIP_Unroll		1	Item_131	Unroll	FIRST	1
Item_131	Unroll	WAIT U(25, 0)	1	Item_131	WIP_Preset	FIRST	1
Item_131	WIP_Preset		1	Item_131	Preset	FIRST	1
Item_131	Preset	WAIT U(45, 0)	1	Item_131	WIP_Hisaka_WR	FIRST	1
Item_131	WIP_Hisaka_WR		1	Item_131	Hisaka_WR	FIRST	1
Item_131	Hisaka_WR	WAIT U(120, 0)	1	Item_131	WIP_Dyeing_Black	FIRST	1
Item_131	WIP_Dyeing_Black		1	Item_131	Dyeing_Black	FIRST	1
Item_131	Dyeing_Black	WAIT U(150, 0)	1	Item_131	WIP_FWD	FIRST	1
Item_131	WIP_FWD		1	Item_131	FWD	FIRST	1
Item_131	FWD	WAIT U(40, 0)	1	Item_131	WIP_Final_Set	FIRST	1
Item_131	WIP_Final_Set		1	Item_131	Final_Set	FIRST	1
Item_131	Final_Set	WAIT U(35, 0)	1	Item_131	EXIT	FIRST	1
Item_45	Gudang		1	Item_45	WIP_Reeling	FIRST	1
Item_45	WIP_Reeling		1	Item_45	Reeling	FIRST	1
Item_45	Reeling	WAIT U(25, 0)	1	Item_45	WIP_Relaxing_A	FIRST	1

Item_45	WIP_Relaxing_A		1	Item_45	Relaxing_A	FIRST	1
Item_45	Relaxing_A	WAIT U(120, 0)	1	Item_45	WIP_Hydro	FIRST	1 MOVE FOR 2 MIN
Item_45	WIP_Hydro		1	Item_45	Hydro	FIRST	1
Item_45	Hydro	WAIT U(35, 0)	1	Item_45	WIP_Unroll	FIRST	1 MOVE FOR 2 MIN
Item_45	WIP_Unroll		1	Item_45	Unroll	FIRST	1
Item_45	Unroll	WAIT U(25, 0)	1	Item_45	WIP_Preset	FIRST	1 MOVE FOR 2 MIN
Item_45	WIP_Preset		1	Item_45	Preset	FIRST	1
Item_45	PreSet	WAIT U(45, 0)	1	Item_45	WIP_ST_Tank	FIRST	1 MOVE FOR 5 MIN
Item_45	WIP_ST_Tank		1	Item_45	ST_Tank	FIRST	1
Item_45	ST_Tank	WAIT U(25, 0)	1	Item_45	WIP_Dyeing_Black	FIRST	1 MOVE FOR 5 MIN
Item_45	WIP_Dyeing_Black		1	Item_45	Dyeing_Black	FIRST	1
Item_45	Dyeing_Black	WAIT U(150, 0)	1	Item_45	WIP_FWD	FIRST	1 MOVE FOR 5 MIN
Item_45	WIP_FWD		1	Item_45	FWD	FIRST	1
Item_45	FWD	WAIT U(40, 0)	1	Item_45	WIP_Final_Set	FIRST	1 MOVE FOR 4 MIN
Item_45	WIP_Final_Set		1	Item_45	Final_Set	FIRST	1
Item_45	Final_Set	WAIT U(35, 0)	1	Item_45	EXIT	FIRST	1 MOVE FOR 10 MIN
work_order	Gudang		1	work_order	EXIT	FIRST	1

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 \* Arrivals \*  
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Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
work_order	Gudang	1		1		ORDER 3401 Item_79 ORDER 1531 Item_106 ORDER 1828 Item_150 ORDER 1381 Item_60 ORDER 1557 Item_18 ORDER 1277 Item_72 ORDER 917 Item_38 ORDER 439 Item_97 ORDER 377 Item_48 ORDER 501 Item_81  ORDER 450 Item_51 ORDER 112 Item_28 ORDER 290 Item_93 ORDER 412 Item_6 ORDER 284 Item_126 ORDER 726 Item_50 ORDER 212 Item_73 ORDER 145 Item_98 ORDER 234 Item_91 ORDER 301 Item_90 ORDER 67 Item_147 ORDER 92 Item_104 ORDER 218 Item_43 ORDER 228 Item_16 ORDER 131 Item_130 ORDER 130 Item_131 ORDER 190 Item_45

## • Output Promodel (Skenario 1)

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 General Report  
 Output from D:\Maranatha\Kuliah\TA\Laporan\Promodel\Aktual\Jmlah yg di produksi dr solver 1 tahun.MOD  
 Date: Jan/15/2013 Time: 11:49:24 PM  
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 Scenario : Normal Run  
 Replication : 1 of 1  
 Simulation Time : 13082.95  
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### LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Minutes Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
Gudang	13082.95	999999	17432	389495.42	8649.53	17396	0	0.86
Reeling.1	13082.95	1	1654	238.97	0.50	1	0	50.35
Reeling.2	13082.95	1	1654	239.03	0.50	1	0	50.37
Reeling.3	13082.95	1	1658	238.51	0.50	1	0	50.38
Reeling.4	13082.95	1	1656	238.77	0.50	1	0	50.37
Reeling	52331.8	4	6622	238.82	0.50	4	0	50.37
Relaxing A.1	13082.95	1	1104	358.57	0.50	1	0	50.43
Relaxing A.2	13082.95	1	1104	358.65	0.50	1	0	50.44
Relaxing A.3	13082.95	1	1104	358.69	0.50	1	0	50.45
Relaxing A.4	13082.95	1	1104	358.73	0.50	1	0	50.45
Relaxing A.5	13082.95	1	1103	358.79	0.50	1	0	50.42
Relaxing A.6	13082.95	1	1103	358.83	0.50	1	0	50.42
Relaxing A	78497.7	6	6622	358.71	0.50	6	0	50.43
Relaxing B.1	13082.95	1	2703	289.90	0.99	1	0	99.83
Relaxing B.2	13082.95	1	2702	289.96	0.99	1	0	99.81
Relaxing B.3	13082.95	1	2702	289.98	0.99	1	0	99.82
Relaxing B.4	13082.95	1	2702	289.99	0.99	1	0	99.82
Relaxing B	52331.8	4	10809	289.96	0.99	4	0	99.82
Hydro.1	13082.95	1	2208	179.62	0.50	1	0	50.52
Hydro.2	13082.95	1	2207	179.64	0.50	1	0	50.51
Hydro.3	13082.95	1	2207	179.66	0.50	1	0	50.51
Hydro	39248.85	3	6622	179.64	0.50	3	0	50.51
Sofcer	13082.95	1	5073	103.85	0.67	1	0	67.12
Unroll.1	13082.95	1	5817	134.78	0.99	1	0	99.88
Unroll.2	13082.95	1	5806	135.01	0.99	1	0	99.86
Unroll.3	13082.95	1	5808	134.98	0.99	1	0	99.87
Unroll	39248.85	3	17431	134.92	0.99	3	0	99.87
Pre Washing Drying	13082.95	1	8502	68.44	0.74	1	0	74.13
Preset	13082.95	1	17431	45.00	0.99	1	0	99.93
Hisaka WR.1	13082.95	1	3712	120.00	0.56	1	0	56.75
Hisaka WR.2	13082.95	1	3705	120.00	0.56	1	0	56.64
Hisaka WR.3	13082.95	1	3694	120.00	0.56	1	0	56.47
Hisaka WR	39248.85	3	11111	120.00	0.56	3	0	56.62
ST Tank.1	13082.95	1	6320	25.00	0.20	1	0	20.13
ST Tank.2	13082.95	1	0	0.00	0	0	0	0.00
ST Tank.3	13082.95	1	0	0.00	0	0	0	0.00
ST Tank.4	13082.95	1	0	0.00	0	0	0	0.00
ST Tank	52331.8	4	6320	25.00	0.05	1	0	5.03
Dyeing Colour.1	13082.95	1	3560	150.00	0.68	1	0	68.03
Dyeing Colour.2	13082.95	1	3336	150.00	0.63	1	0	63.75
Dyeing Colour.3	13082.95	1	3333	150.00	0.63	1	0	63.69
Dyeing Colour.4	13082.95	1	3312	150.00	0.63	1	0	63.29
Dyeing Colour.5	13082.95	1	15	150.00	0.00	1	0	0.29
Dyeing Colour.6	13082.95	1	2	150.00	0.00	1	0	0.04
Dyeing Colour.7	13082.95	1	0	0.00	0	0	0	0.00
Dyeing Colour	91580.65	7	13558	150.00	0.37	6	0	37.01
FWD.1	13082.95	1	15349	40.00	0.78	1	0	78.21
FWD.2	13082.95	1	1520	40.00	0.07	1	0	7.75
FWD	26165.9	2	16869	40.00	0.42	2	0	42.98
Final Set.1	13082.95	1	14128	40.86	0.73	1	0	73.56
Final Set.2	13082.95	1	2379	69.59	0.21	1	0	21.09
Final Set.3	13082.95	1	924	122.71	0.14	1	0	14.44
Final Set	39248.85	3	17431	49.12	0.36	3	0	36.36
Heat Cut.1	13082.95	1	3786	20.00	0.09	1	0	9.65
Heat Cut.2	13082.95	1	1	20.00	2.54	1	0	0.00
Heat Cut	26165.9	2	3787	20.00	0.04	2	0	4.82
Folding.1	13082.95	1	1828	45.00	0.10	1	0	10.48
Folding.2	13082.95	1	0	0.00	0	0	0	0.00
Folding.3	13082.95	1	0	0.00	0	0	0	0.00
Folding	39248.85	3	1828	45.00	0.03	1	0	3.49
Sablon.1	13082.95	1	3187	50.00	0.20	1	0	20.30
Sablon.2	13082.95	1	2707	50.00	0.17	1	0	17.24
Sablon.3	13082.95	1	18	50.00	0.00	1	0	0.11
Sablon	39248.85	3	5912	50.00	0.12	3	0	12.55
WIP Reeling	13082.95	21	6622	1248.46	10.53	21	0	50.15
WIP Relaxing A	13082.95	6	6332	356.39	2.87	6	0	47.91
WIP Relaxing B	13082.95	14	10809	1009.34	13.89	14	0	99.28
WIP Hydro	13082.95	7	6622	416.62	3.51	7	0	50.21
WIP Sofcer	13082.95	6	5073	618.77	3.99	6	0	66.65
WIP Unroll	13082.95	3	17431	132.84	2.94	3	0	98.33
WIP Pre Washing Drying	13082.95	4	8502	271.06	2.93	4	0	73.40
WIP Preset	13082.95	8	17431	355.69	7.89	8	0	98.73

WIP Hisaka WR	13082.95	6	11111	0.00	0	1	0	0.00
WIP ST Tank	13082.95	8	6320	0.00	0	1	0	0.00
WIP Dyeing Colour	13082.95	7	13558	0.00	0	1	0	0.00
WIP FWD	13082.95	18	16869	0.00	0	1	0	0.00
WIP Final Set	13082.95	24	17431	14.87	0.33	20	0	1.38
WIP Heat Cut	13082.95	4	3787	0.00	0	1	0	0.00
WIP Folding	13082.95	3	1828	0.00	0	1	0	0.00
Dyeing Black.1	13082.95	1	1037	150.00	0.19	1	0	19.82
Dyeing Black.2	13082.95	1	1024	150.00	0.19	1	0	19.57
Dyeing Black.3	13082.95	1	1018	150.00	0.19	1	0	19.45
Dyeing Black.4	13082.95	1	794	150.00	0.15	1	0	15.17
Dyeing Black.5	13082.95	1	0	0.00	0	0	0	0.00
Dyeing Black	65414.75	5	3873	150.00	0.14	4	0	14.80
WIP Sablon	13082.95	6	5912	0.00	0	1	0	0.00
WIP Dyeing Black	13082.95	5	3873	0.00	0	1	0	0.00

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	%			
		Empty	Partially Occupied	Full	Down
Gudang	13082.95	0.28	99.72	0.00	0.00
WIP Reeling	13082.95	49.65	2.67	47.68	0.00
WIP Relaxing A	13082.95	51.76	1.71	46.53	0.00
WIP Relaxing B	13082.95	0.20	6.94	92.86	0.00
WIP Hydro	13082.95	49.51	1.76	48.73	0.00
WIP Sofcer	13082.95	32.95	1.67	65.38	0.00
WIP Unroll	13082.95	0.16	4.50	95.34	0.00
WIP Pre Washing Drying	13082.95	25.95	2.39	71.66	0.00
WIP Preset	13082.95	0.10	8.25	91.65	0.00
WIP Hisaka WR	13082.95	100.00	0.00	0.00	0.00
WIP ST Tank	13082.95	100.00	0.00	0.00	0.00
WIP Dyeing Colour	13082.95	100.00	0.00	0.00	0.00
WIP FWD	13082.95	100.00	0.00	0.00	0.00
WIP Final Set	13082.95	95.71	4.29	0.00	0.00
WIP Heat Cut	13082.95	100.00	0.00	0.00	0.00
WIP Folding	13082.95	100.00	0.00	0.00	0.00
WIP Sablon	13082.95	100.00	0.00	0.00	0.00
WIP Dyeing Black	13082.95	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	
Reeling.1	13082.95	5.27	0.00	49.64	0.00	45.09	0.00	
Reeling.2	13082.95	5.27	0.00	49.63	0.00	45.10	0.00	
Reeling.3	13082.95	5.28	0.00	49.62	0.00	45.10	0.00	
Reeling.4	13082.95	5.27	0.00	49.63	0.00	45.10	0.00	
Reeling	52331.8	5.27	0.00	49.63	0.01	45.09	0.00	
Relaxing A.1	13082.95	16.88	0.00	49.57	0.00	33.55	0.00	
Relaxing A.2	13082.95	16.88	0.00	49.56	0.00	33.56	0.00	
Relaxing A.3	13082.95	16.88	0.00	49.55	0.00	33.57	0.00	
Relaxing A.4	13082.95	16.88	0.00	49.54	0.00	33.58	0.00	
Relaxing A.5	13082.95	16.86	0.00	49.58	0.01	33.55	0.00	
Relaxing A.6	13082.95	16.86	0.00	49.58	0.00	33.56	0.00	
Relaxing A	78497.7	16.87	0.00	49.57	0.00	33.56	0.00	
Relaxing B.1	13082.95	41.32	0.00	0.17	0.00	58.51	0.00	
Relaxing B.2	13082.95	41.31	0.00	0.19	0.00	58.50	0.00	
Relaxing B.3	13082.95	41.31	0.00	0.18	0.00	58.51	0.00	
Relaxing B.4	13082.95	41.31	0.00	0.17	0.00	58.52	0.00	
Relaxing B	52331.8	41.31	0.00	0.18	0.00	58.51	0.00	
Hydro.1	13082.95	9.84	0.00	49.48	0.00	40.68	0.00	
Hydro.2	13082.95	9.84	0.00	49.49	0.00	40.67	0.00	
Hydro.3	13082.95	9.84	0.00	49.49	0.00	40.67	0.00	
Hydro	39248.85	9.84	0.00	49.49	0.00	40.67	0.00	
Sofcer	13082.95	12.93	0.00	32.88	0.00	54.19	0.00	
Unroll.1	13082.95	18.53	0.00	0.12	0.00	81.35	0.00	
Unroll.2	13082.95	18.49	0.00	0.14	0.00	81.37	0.00	
Unroll.3	13082.95	18.50	0.00	0.13	0.00	81.37	0.00	
Unroll	39248.85	18.50	0.00	0.13	0.00	81.37	0.00	
Pre Washing Drying	13082.95	43.32	0.00	25.87	0.01	30.80	0.00	
Preset	13082.95	99.93	0.00	0.07	0.00	0.00	0.00	
Hisaka WR.1	13082.95	56.75	0.00	43.25	0.00	0.00	0.00	
Hisaka WR.2	13082.95	56.64	0.00	43.36	0.00	0.00	0.00	
Hisaka WR.3	13082.95	56.47	0.00	43.53	0.00	0.00	0.00	
Hisaka WR	39248.85	56.62	0.00	43.38	0.00	0.00	0.00	
ST Tank.1	13082.95	20.13	0.00	79.87	0.00	0.00	0.00	
ST Tank.2	13082.95	0.00	0.00	100.00	0.00	0.00	0.00	
ST Tank.3	13082.95	0.00	0.00	100.00	0.00	0.00	0.00	
ST Tank.4	13082.95	0.00	0.00	100.00	0.00	0.00	0.00	
ST Tank	52331.8	5.03	0.00	94.97	0.00	0.00	0.00	
Dyeing Colour.1	13082.95	68.03	0.00	31.97	0.00	0.00	0.00	
Dyeing Colour.2	13082.95	63.75	0.00	36.25	0.00	0.00	0.00	
Dyeing Colour.3	13082.95	63.69	0.00	36.31	0.00	0.00	0.00	
Dyeing Colour.4	13082.95	63.29	0.00	36.71	0.00	0.00	0.00	
Dyeing Colour.5	13082.95	0.29	0.00	99.71	0.00	0.00	0.00	
Dyeing Colour.6	13082.95	0.04	0.00	99.96	0.00	0.00	0.00	
Dyeing Colour.7	13082.95	0.00	0.00	100.00	0.00	0.00	0.00	
Dyeing Colour	91580.65	37.01	0.00	62.99	0.00	0.00	0.00	
FWD.1	13082.95	78.21	0.00	21.79	0.00	0.00	0.00	

FWD.2	13082.95	7.75	0.00	92.25	0.00	0.00	0.00
FWD	26165.9	42.98	0.00	57.02	0.00	0.00	0.00
Final Set.1	13082.95	73.56	0.00	26.44	0.00	0.00	0.00
Final Set.2	13082.95	21.09	0.00	78.91	0.00	0.00	0.00
Final Set.3	13082.95	14.44	0.00	85.56	0.00	0.00	0.00
Final Set	39248.85	36.36	0.00	63.64	0.00	0.00	0.00
Heat Cut.1	13082.95	9.65	0.00	90.35	0.00	0.00	0.00
Heat Cut.2	13082.95	0.00	0.00	100.00	0.00	0.00	0.00
Heat Cut	26165.9	4.82	0.00	95.18	0.00	0.00	0.00
Folding.1	13082.95	10.48	0.00	89.52	0.00	0.00	0.00
Folding.2	13082.95	0.00	0.00	100.00	0.00	0.00	0.00
Folding.3	13082.95	0.00	0.00	100.00	0.00	0.00	0.00
Folding	39248.85	3.49	0.00	96.51	0.00	0.00	0.00
Sablon.1	13082.95	20.30	0.00	79.70	0.00	0.00	0.00
Sablon.2	13082.95	17.24	0.00	82.76	0.00	0.00	0.00
Sablon.3	13082.95	0.11	0.00	99.89	0.00	0.00	0.00
Sablon	39248.85	12.55	0.00	87.45	0.00	0.00	0.00
Dyeing Black.1	13082.95	19.82	0.00	80.18	0.00	0.00	0.00
Dyeing Black.2	13082.95	19.57	0.00	80.43	0.00	0.00	0.00
Dyeing Black.3	13082.95	19.45	0.00	80.55	0.00	0.00	0.00
Dyeing Black.4	13082.95	15.17	0.00	84.83	0.00	0.00	0.00
Dyeing Black.5	13082.95	0.00	0.00	100.00	0.00	0.00	0.00
Dyeing Black	65414.75	14.80	0.00	85.20	0.00	0.00	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
work order	Gudang	0

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Minutes In System	Average Minutes In Move Logic	Average Minutes Wait For Res, etc.	Average Minutes In Operation	Average Minutes Blocked
Item 79	3401	0	278304.40	32.00	0.00	500.00	277772.40
Item 106	1531	0	46692.71	32.00	0.00	635.00	46025.71
Item 150	1828	0	492889.92	42.00	0.00	650.00	492197.92
Item 60	1381	0	564972.00	32.00	0.00	535.00	564405.00
Item 18	1557	0	631154.00	40.00	0.00	645.00	630469.00
Item 72	1277	0	130706.77	30.00	0.00	595.00	130081.77
Item 38	917	0	196432.01	30.00	0.00	500.00	195902.01
Item 97	439	0	237435.24	32.00	0.00	635.00	236768.24
Item 48	377	0	674732.00	38.00	0.00	710.00	673984.00
Item 81	501	0	694869.02	33.00	0.00	680.00	694156.02
Item 128	0	0	-	-	-	-	-
Item 51	450	0	715718.25	28.00	0.00	515.00	715175.25
Item 28	112	0	253862.10	31.00	0.00	710.00	253121.10
Item 93	290	0	265957.91	37.00	0.00	750.00	265170.91
Item 6	412	0	735191.49	41.00	0.00	635.00	734515.49
Item 126	284	0	283302.59	37.00	0.00	685.00	282580.59
Item 50	726	0	313456.44	35.00	0.00	730.00	312691.44
Item 73	212	0	341362.00	30.00	0.00	500.00	340832.00
Item 98	145	0	352072.00	30.00	0.00	500.00	351542.00
Item 91	234	0	749631.61	39.00	0.00	510.00	749082.61
Item 90	301	0	365451.95	30.00	0.00	500.00	364921.95
Item 147	67	0	376492.22	30.00	0.00	500.00	375962.22
Item 104	92	0	757030.53	37.00	0.00	575.00	756418.53
Item 43	218	0	764173.67	34.00	0.00	565.00	763574.67
Item 16	228	0	774025.88	34.00	0.00	555.00	773436.88
Item 130	131	0	382431.88	30.00	0.00	500.00	381901.88
Item 131	130	0	782074.50	34.00	0.00	555.00	781485.50
Item 45	190	0	392062.07	30.00	0.00	500.00	391532.07
work order	1	0	0.00	0.00	0.00	0.00	0.00

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
Item 79	0.01	0.00	0.18	99.81
Item 106	0.07	0.00	1.36	98.57
Item 150	0.01	0.00	0.13	99.86
Item 60	0.01	0.00	0.09	99.90
Item 18	0.01	0.00	0.10	99.89
Item 72	0.02	0.00	0.46	99.52
Item 38	0.02	0.00	0.25	99.73
Item 97	0.01	0.00	0.27	99.72
Item 48	0.01	0.00	0.11	99.89
Item 81	0.00	0.00	0.10	99.90
Item 128	-	-	-	-
Item 51	0.00	0.00	0.07	99.92
Item 28	0.01	0.00	0.28	99.71
Item 93	0.01	0.00	0.28	99.70
Item 6	0.01	0.00	0.09	99.91
Item 126	0.01	0.00	0.24	99.75
Item 50	0.01	0.00	0.23	99.76

Item 73	0.01	0.00	0.15	99.84
Item 98	0.01	0.00	0.14	99.85
Item 91	0.01	0.00	0.07	99.93
Item 90	0.01	0.00	0.14	99.85
Item 147	0.01	0.00	0.13	99.86
Item 104	0.00	0.00	0.08	99.92
Item 43	0.00	0.00	0.07	99.92
Item 16	0.00	0.00	0.07	99.92
Item 130	0.01	0.00	0.13	99.86
Item 131	0.00	0.00	0.07	99.92
Item 45	0.01	0.00	0.13	99.86
work order	-	-	-	-

# **LAMPIRAN 3**

## **SKENARIO 2**

- **INPUT SIMULASI AKTUAL**
- **OUTPUT SIMULASI AKTUAL**

## ● Input Promodel (Skenario 2)

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* Formatted Listing of Model:
* D:\Maranatha\Kuliah\TA\Laporan\Promodel\Aktual\2. Jmlah produksi full, 15 bulan.MOD *
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Time Units:           Minutes
Distance Units:      Feet

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*                               Locations
*                               *
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Name	Cap	Units	Stats	Rules	Cost
Gudang	inf	1	Time Series	Oldest, , First	
Reeling	1	4	Time Series	Oldest, , First	
Reeling.1	1	1	Time Series	Oldest, ,	
Reeling.2	1	1	Time Series	Oldest, ,	
Reeling.3	1	1	Time Series	Oldest, ,	
Reeling.4	1	1	Time Series	Oldest, ,	
Relaxing_A	1	6	Time Series	Oldest, , First	
Relaxing_A.1	1	1	Time Series	Oldest, ,	
Relaxing_A.2	1	1	Time Series	Oldest, ,	
Relaxing_A.3	1	1	Time Series	Oldest, ,	
Relaxing_A.4	1	1	Time Series	Oldest, ,	
Relaxing_A.5	1	1	Time Series	Oldest, ,	
Relaxing_A.6	1	1	Time Series	Oldest, ,	
Relaxing_B	1	4	Time Series	Oldest, , First	
Relaxing_B.1	1	1	Time Series	Oldest, ,	
Relaxing_B.2	1	1	Time Series	Oldest, ,	
Relaxing_B.3	1	1	Time Series	Oldest, ,	
Relaxing_B.4	1	1	Time Series	Oldest, ,	
Hydro	1	3	Time Series	Oldest, , First	
Hydro.1	1	1	Time Series	Oldest, ,	
Hydro.2	1	1	Time Series	Oldest, ,	
Hydro.3	1	1	Time Series	Oldest, ,	
Sofcer	1	1	Time Series	Oldest, ,	
Unroll	1	3	Time Series	Oldest, , First	
Unroll.1	1	1	Time Series	Oldest, ,	
Unroll.2	1	1	Time Series	Oldest, ,	
Unroll.3	1	1	Time Series	Oldest, ,	
Pre_Washing_Drying	1	1	Time Series	Oldest, ,	
Preset	1	1	Time Series	Oldest, ,	
Hisaka_WR	1	3	Time Series	Oldest, , First	
Hisaka_WR.1	1	1	Time Series	Oldest, ,	
Hisaka_WR.2	1	1	Time Series	Oldest, ,	
Hisaka_WR.3	1	1	Time Series	Oldest, ,	
ST_Tank	1	4	Time Series	Oldest, , First	
ST_Tank.1	1	1	Time Series	Oldest, ,	
ST_Tank.2	1	1	Time Series	Oldest, ,	
ST_Tank.3	1	1	Time Series	Oldest, ,	
ST_Tank.4	1	1	Time Series	Oldest, ,	
Dyeing_Colour	1	7	Time Series	Oldest, , First	
Dyeing_Colour.1	1	1	Time Series	Oldest, ,	
Dyeing_Colour.2	1	1	Time Series	Oldest, ,	
Dyeing_Colour.3	1	1	Time Series	Oldest, ,	
Dyeing_Colour.4	1	1	Time Series	Oldest, ,	
Dyeing_Colour.5	1	1	Time Series	Oldest, ,	
Dyeing_Colour.6	1	1	Time Series	Oldest, ,	
Dyeing_Colour.7	1	1	Time Series	Oldest, ,	
FWD	1	2	Time Series	Oldest, , First	
FWD.1	1	1	Time Series	Oldest, ,	
FWD.2	1	1	Time Series	Oldest, ,	
Final_Set	1	3	Time Series	Oldest, , First	
Final_Set.1	1	1	Time Series	Oldest, ,	
Final_Set.2	1	1	Time Series	Oldest, ,	
Final_Set.3	1	1	Time Series	Oldest, ,	
Heat_Cut	1	2	Time Series	Oldest, , First	
Heat_Cut.1	1	1	Time Series	Oldest, ,	
Heat_Cut.2	1	1	Time Series	Oldest, ,	
Folding	1	3	Time Series	Oldest, , First	
Folding.1	1	1	Time Series	Oldest, ,	
Folding.2	1	1	Time Series	Oldest, ,	
Folding.3	1	1	Time Series	Oldest, ,	
Sablon	1	3	Time Series	Oldest, , First	
Sablon.1	1	1	Time Series	Oldest, ,	
Sablon.2	1	1	Time Series	Oldest, ,	
Sablon.3	1	1	Time Series	Oldest, ,	
WIP_Reeling	21	1	Time Series	Oldest, , First	
WIP_Relaxing_A	6	1	Time Series	Oldest, , First	
WIP_Relaxing_B	14	1	Time Series	Oldest, , First	
WIP_Hydro	7	1	Time Series	Oldest, , First	
WIP_Sofcer	6	1	Time Series	Oldest, , First	
WIP_Unroll	3	1	Time Series	Oldest, , First	
WIP_Pre_Washing_Drying	4	1	Time Series	Oldest, , First	
WIP_Preset	8	1	Time Series	Oldest, , First	
WIP_Hisaka_WR	6	1	Time Series	Oldest, , First	
WIP_ST_Tank	8	1	Time Series	Oldest, , First	
WIP_Dyeing_Colour	7	1	Time Series	Oldest, , First	
WIP_FWD	18	1	Time Series	Oldest, , First	
WIP_Final_Set	24	1	Time Series	Oldest, , First	
WIP_Heat_Cut	4	1	Time Series	Oldest, , First	
WIP_Folding	3	1	Time Series	Oldest, , First	
Dyeing_Black	1	5	Time Series	Oldest, , First	
Dyeing_Black.1	1	1	Time Series	Oldest, ,	
Dyeing_Black.2	1	1	Time Series	Oldest, ,	
Dyeing_Black.3	1	1	Time Series	Oldest, ,	
Dyeing_Black.4	1	1	Time Series	Oldest, ,	
Dyeing_Black.5	1	1	Time Series	Oldest, ,	
WIP_Sablon	6	1	Time Series	Oldest, , First	
WIP_Dyeing_Black	5	1	Time Series	Oldest, , First	



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 \* Entities \*  
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Name	Speed (fpm)	Stats	Cost
Item_79	150	Time Series	
Item_106	150	Time Series	
Item_150	150	Time Series	
Item_60	150	Time Series	
Item_18	150	Time Series	
Item_72	150	Time Series	
Item_38	150	Time Series	
Item_97	150	Time Series	
Item_48	150	Time Series	
Item_81	150	Time Series	
Item_128	150	Time Series	
Item_51	150	Time Series	
Item_28	150	Time Series	
Item_93	150	Time Series	
Item_6	150	Time Series	
Item_126	150	Time Series	
Item_50	150	Time Series	
Item_73	150	Time Series	
Item_98	150	Time Series	
Item_91	150	Time Series	
Item_90	150	Time Series	
Item_147	150	Time Series	
Item_104	150	Time Series	
Item_43	150	Time Series	
Item_16	150	Time Series	
Item_130	150	Time Series	
Item_131	150	Time Series	
Item_45	150	Time Series	
work_order	150	Time Series	

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 \* Processing \*  
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Entity	Location	Process	Routing				
			Blk	Output	Destination	Rule	Move Logic
Item_79	Gudang		1	Item_79	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_Relaxing_B		1	Item_79	Relaxing_B	FIRST 1	
Item_79	Relaxing_B	WAIT U(120, 0)	1	Item_79	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Sofcer		1	Item_79	Sofcer	FIRST 1	
Item_79	Sofcer	WAIT U(20, 0)	1	Item_79	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Unroll		1	Item_79	Unroll	FIRST 1	
Item_79	Unroll	WAIT U(25, 0)	1	Item_79	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Pre_Washing_Drying		1	Item_79	Pre_Washing_Drying	FIRST 1	
Item_79	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_79	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_79	WIP_Preset		1	Item_79	Preset	FIRST 1	
Item_79	Preset	WAIT U(45, 0)	1	Item_79	WIP_ST_Tank	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_ST_Tank		1	Item_79	ST_Tank	FIRST 1	
Item_79	ST_Tank	WAIT U(25, 0)	1	Item_79	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_Dyeing_Colour		1	Item_79	Dyeing_Colour	FIRST 1	
Item_79	Dyeing_Colour	WAIT U(150, 0)	1	Item_79	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_79	WIP_FWD		1	Item_79	FWD	FIRST 1	
Item_79	FWD	WAIT U(40, 0)	1	Item_79	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_79	WIP_Final_Set		1	Item_79	Final_Set	FIRST 1	
Item_79	Final_Set	WAIT U(35, 0)	1	Item_79	EXIT	FIRST 1	MOVE FOR 2 MIN
Item_106	Gudang		1	Item_106	WIP_Reeling	FIRST 1	MOVE FOR 3 MIN
Item_106	WIP_Reeling		1	Item_106	Reeling	FIRST 1	
Item_106	Reeling	WAIT U(25, 0)	1	Item_106	WIP_Relaxing_A	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Relaxing_A		1	Item_106	Relaxing_A	FIRST 1	
Item_106	Relaxing_A	WAIT U(120, 0)	1	Item_106	WIP_Hydro	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Hydro		1	Item_106	Hydro	FIRST 1	
Item_106	Hydro	WAIT U(35, 0)	1	Item_106	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Unroll		1	Item_106	Unroll	FIRST 1	
Item_106	Unroll	WAIT U(25, 0)	1	Item_106	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Pre_Washing_Drying		1	Item_106	Pre_Washing_Drying	FIRST 1	
Item_106	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_106	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_106	WIP_Preset		1	Item_106	Preset	FIRST 1	
Item_106	Preset	WAIT U(45, 0)	1	Item_106	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_106	WIP_Hisaka_WR		1	Item_106	Hisaka_WR	FIRST 1	
Item_106	Hisaka_WR	WAIT U(120, 0)	1	Item_106	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_106	WIP_Dyeing_Colour		1	Item_106	Dyeing_Colour	FIRST 1	
Item_106	Dyeing_Colour	WAIT U(150, 0)	1	Item_106	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_106	WIP_FWD		1	Item_106	FWD	FIRST 1	
Item_106	FWD	WAIT U(40, 0)	1	Item_106	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_106	WIP_Final_Set		1	Item_106	Final_Set	FIRST 1	
Item_106	Final_Set	WAIT U(35, 0)	1	Item_106	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_150	Gudang		1	Item_150	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Relaxing_B		1	Item_150	Relaxing_B	FIRST 1	
Item_150	Relaxing_B	WAIT U(120, 0)	1	Item_150	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_150	WIP_Unroll		1	Item_150	Unroll	FIRST 1	
Item_150	Unroll	WAIT U(25, 0)	1	Item_150	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_150	WIP_Preset		1	Item_150	Preset	FIRST 1	
Item_150	Preset	WAIT U(45, 0)	1	Item_150	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Hisaka_WR		1	Item_150	Hisaka_WR	FIRST 1	
Item_150	Hisaka_WR	WAIT U(120, 0)	1	Item_150	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Dyeing_Colour		1	Item_150	Dyeing_Colour	FIRST 1	
Item_150	Dyeing_Colour	WAIT U(150, 0)	1	Item_150	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_FWD		1	Item_150	FWD	FIRST 1	
Item_150	FWD	WAIT U(40, 0)	1	Item_150	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_150	WIP_Final_Set		1	Item_150	Final_Set	FIRST 1	
Item_150	Final_Set	WAIT U(35, 0)	1	Item_150	WIP_Heat_Cut	FIRST 1	MOVE FOR 5 MIN
Item_150	WIP_Heat_Cut		1	Item_150	Heat_Cut	FIRST 1	
Item_150	Heat_Cut	WAIT U(20, 0)	1	Item_150	WIP_Folding	FIRST 1	MOVE FOR 3 MIN
Item_150	WIP_Folding		1	Item_150	Folding	FIRST 1	
Item_150	Folding	WAIT U(45, 0)	1	Item_150	WIP_Sablon	FIRST 1	MOVE FOR 2 MIN
Item_150	WIP_Sablon		1	Item_150	Sablon	FIRST 1	
Item_150	Sablon	WAIT U(50, 0)	1	Item_150	EXIT	FIRST 1	MOVE FOR 5 MIN
Item_60	Gudang		1	Item_60	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_60	WIP_Relaxing_B		1	Item_60	Relaxing_B	FIRST 1	
Item_60	Relaxing_B	WAIT U(120, 0)	1	Item_60	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_60	WIP_Unroll		1	Item_60	Unroll	FIRST 1	
Item_60	Unroll	WAIT U(25, 0)	1	Item_60	WIP_Preset	FIRST 1	MOVE FOR 6 MIN

Item_60	WIP_Preset		1	Item_60	Preset	FIRST	1
Item_60	Preset	WAIT U(45, 0)	1	Item_60	WIP_Hisaka_WR	FIRST	1
Item_60	WIP_Hisaka_WR		1	Item_60	Hisaka_WR	FIRST	1
Item_60	Hisaka_WR	WAIT U(120, 0)	1	Item_60	WIP_Dyeing_Colour	FIRST	1
Item_60	WIP_Dyeing_Colour		1	Item_60	Dyeing_Colour	FIRST	1
Item_60	Dyeing_Colour	WAIT U(150, 0)	1	Item_60	WIP_FWD	FIRST	1
Item_60	WIP_FWD		1	Item_60	FWD	FIRST	1
Item_60	FWD	WAIT U(40, 0)	1	Item_60	WIP_Final_Set	FIRST	1
Item_60	WIP_Final_Set		1	Item_60	Final_Set	FIRST	1
Item_60	Final_Set	WAIT U(35, 0)	1	Item_60	EXIT	FIRST	1
Item_18	Gudang		1	Item_18	WIP_Relaxing_B	FIRST	1
Item_18	WIP_Relaxing_B		1	Item_18	Relaxing_B	FIRST	1
Item_18	Relaxing_B	WAIT U(120, 0)	1	Item_18	WIP_Unroll	FIRST	1
Item_18	WIP_Unroll		1	Item_18	Unroll	FIRST	1
Item_18	Unroll	WAIT U(25, 0)	1	Item_18	WIP_Pre_Washing_Drying	FIRST	1
Item_18	WIP_Pre_Washing_Drying		1	Item_18	Pre_Washing_Drying	FIRST	1
Item_18	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_18	WIP_Preset	FIRST	1
Item_18	WIP_Preset		1	Item_18	Preset	FIRST	1
Item_18	Preset	WAIT U(45, 0)	1	Item_18	WIP_Hisaka_WR	FIRST	1
Item_18	WIP_Hisaka_WR		1	Item_18	Hisaka_WR	FIRST	1
Item_18	Hisaka_WR	WAIT U(120, 0)	1	Item_18	WIP_Dyeing_Black	FIRST	1
Item_18	WIP_Dyeing_Black		1	Item_18	Dyeing_Black	FIRST	1
Item_18	Dyeing_Black	WAIT U(150, 0)	1	Item_18	WIP_FWD	FIRST	1
Item_18	WIP_FWD		1	Item_18	FWD	FIRST	1
Item_18	FWD	WAIT U(40, 0)	1	Item_18	WIP_Final_Set	FIRST	1
Item_18	WIP_Final_Set		1	Item_18	Final_Set	FIRST	1
Item_18	Final_Set	WAIT U(35, 0)	1	Item_18	WIP_Heat_Cut	FIRST	1
Item_18	WIP_Heat_Cut		1	Item_18	Heat_Cut	FIRST	1
Item_18	Heat_Cut	WAIT U(20, 0)	1	Item_18	WIP_Sablon	FIRST	1
Item_18	WIP_Sablon		1	Item_18	Sablon	FIRST	1
Item_18	Sablon	WAIT U(50, 0)	1	Item_18	EXIT	FIRST	1
Item_72	Gudang		1	Item_72	WIP_Reeling	FIRST	1
Item_72	WIP_Reeling		1	Item_72	Reeling	FIRST	1
Item_72	Reeling	WAIT U(25, 0)	1	Item_72	WIP_Relaxing_A	FIRST	1
Item_72	WIP_Relaxing_A		1	Item_72	Relaxing_A	FIRST	1
Item_72	Relaxing_A	WAIT U(120, 0)	1	Item_72	WIP_Hydro	FIRST	1
Item_72	WIP_Hydro		1	Item_72	Hydro	FIRST	1
Item_72	Hydro	WAIT U(35, 0)	1	Item_72	WIP_Unroll	FIRST	1
Item_72	WIP_Unroll		1	Item_72	Unroll	FIRST	1
Item_72	Unroll	WAIT U(25, 0)	1	Item_72	WIP_Preset	FIRST	1
Item_72	WIP_Preset		1	Item_72	Preset	FIRST	1
Item_72	Preset	WAIT U(45, 0)	1	Item_72	WIP_Hisaka_WR	FIRST	1
Item_72	WIP_Hisaka_WR		1	Item_72	Hisaka_WR	FIRST	1
Item_72	Hisaka_WR	WAIT U(120, 0)	1	Item_72	WIP_Dyeing_Colour	FIRST	1
Item_72	WIP_Dyeing_Colour		1	Item_72	Dyeing_Colour	FIRST	1
Item_72	Dyeing_Colour	WAIT U(150, 0)	1	Item_72	WIP_FWD	FIRST	1
Item_72	WIP_FWD		1	Item_72	FWD	FIRST	1
Item_72	FWD	WAIT U(40, 0)	1	Item_72	WIP_Final_Set	FIRST	1
Item_72	WIP_Final_Set		1	Item_72	Final_Set	FIRST	1
Item_72	Final_Set	WAIT U(35, 0)	1	Item_72	EXIT	FIRST	1
Item_38	Gudang		1	Item_38	WIP_Reeling	FIRST	1
Item_38	WIP_Reeling		1	Item_38	Reeling	FIRST	1
Item_38	Reeling	WAIT U(25, 0)	1	Item_38	WIP_Relaxing_A	FIRST	1
Item_38	WIP_Relaxing_A		1	Item_38	Relaxing_A	FIRST	1
Item_38	Relaxing_A	WAIT U(120, 0)	1	Item_38	WIP_Hydro	FIRST	1
Item_38	WIP_Hydro		1	Item_38	Hydro	FIRST	1
Item_38	Hydro	WAIT U(35, 0)	1	Item_38	WIP_Unroll	FIRST	1
Item_38	WIP_Unroll		1	Item_38	Unroll	FIRST	1
Item_38	Unroll	WAIT U(25, 0)	1	Item_38	WIP_Preset	FIRST	1
Item_38	WIP_Preset		1	Item_38	Preset	FIRST	1
Item_38	Preset	WAIT U(45, 0)	1	Item_38	WIP_ST_Tank	FIRST	1
Item_38	WIP_ST_Tank		1	Item_38	ST_Tank	FIRST	1
Item_38	ST_Tank	WAIT U(25, 0)	1	Item_38	WIP_Dyeing_Colour	FIRST	1
Item_38	WIP_Dyeing_Colour		1	Item_38	Dyeing_Colour	FIRST	1
Item_38	Dyeing_Colour	WAIT U(150, 0)	1	Item_38	WIP_FWD	FIRST	1
Item_38	WIP_FWD		1	Item_38	FWD	FIRST	1
Item_38	FWD	WAIT U(40, 0)	1	Item_38	WIP_Final_Set	FIRST	1
Item_38	WIP_Final_Set		1	Item_38	Final_Set	FIRST	1
Item_38	Final_Set	WAIT U(35, 0)	1	Item_38	EXIT	FIRST	1
Item_97	Gudang		1	Item_97	WIP_Reeling	FIRST	1
Item_97	WIP_Reeling		1	Item_97	Reeling	FIRST	1
Item_97	Reeling	WAIT U(25, 0)	1	Item_97	WIP_Relaxing_A	FIRST	1
Item_97	WIP_Relaxing_A		1	Item_97	Relaxing_A	FIRST	1
Item_97	Relaxing_A	WAIT U(120, 0)	1	Item_97	WIP_Hydro	FIRST	1
Item_97	WIP_Hydro		1	Item_97	Hydro	FIRST	1
Item_97	Hydro	WAIT U(35, 0)	1	Item_97	WIP_Unroll	FIRST	1
Item_97	WIP_Unroll		1	Item_97	Unroll	FIRST	1
Item_97	Unroll	WAIT U(25, 0)	1	Item_97	WIP_Pre_Washing_Drying	FIRST	1
Item_97	WIP_Pre_Washing_Drying		1	Item_97	Pre_Washing_Drying	FIRST	1
Item_97	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_97	WIP_Preset	FIRST	1
Item_97	WIP_Preset		1	Item_97	Preset	FIRST	1
Item_97	Preset	WAIT U(45, 0)	1	Item_97	WIP_Hisaka_WR	FIRST	1
Item_97	WIP_Hisaka_WR		1	Item_97	Hisaka_WR	FIRST	1
Item_97	Hisaka_WR	WAIT U(120, 0)	1	Item_97	WIP_Dyeing_Colour	FIRST	1
Item_97	WIP_Dyeing_Colour		1	Item_97	Dyeing_Colour	FIRST	1
Item_97	Dyeing_Colour	WAIT U(150, 0)	1	Item_97	WIP_FWD	FIRST	1
Item_97	WIP_FWD		1	Item_97	FWD	FIRST	1
Item_97	FWD	WAIT U(40, 0)	1	Item_97	WIP_Final_Set	FIRST	1
Item_97	WIP_Final_Set		1	Item_97	Final_Set	FIRST	1
Item_97	Final_Set	WAIT U(35, 0)	1	Item_97	EXIT	FIRST	1
Item_48	Gudang		1	Item_48	WIP_Relaxing_B	FIRST	1
Item_48	WIP_Relaxing_B		1	Item_48	Relaxing_B	FIRST	1
Item_48	Relaxing_B	WAIT U(120, 0)	1	Item_48	WIP_Unroll	FIRST	1
Item_48	WIP_Unroll		1	Item_48	Unroll	FIRST	1
Item_48	Unroll	WAIT U(25, 0)	1	Item_48	WIP_Pre_Washing_Drying	FIRST	1
Item_48	WIP_Pre_Washing_Drying		1	Item_48	Pre_Washing_Drying	FIRST	1
Item_48	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_48	WIP_Preset	FIRST	1
Item_48	WIP_Preset		1	Item_48	Preset	FIRST	1
Item_48	Preset	WAIT U(45, 0)	1	Item_48	WIP_Hisaka_WR	FIRST	1
Item_48	WIP_Hisaka_WR		1	Item_48	Hisaka_WR	FIRST	1
Item_48	Hisaka_WR	WAIT U(120, 0)	1	Item_48	WIP_Dyeing_Black	FIRST	1
Item_48	WIP_Dyeing_Black		1	Item_48	Dyeing_Black	FIRST	1
Item_48	Dyeing_Black	WAIT U(150, 0)	1	Item_48	WIP_FWD	FIRST	1
Item_48	WIP_FWD		1	Item_48	FWD	FIRST	1
Item_48	FWD	WAIT U(40, 0)	1	Item_48	WIP_Final_Set	FIRST	1
Item_48	WIP_Final_Set		1	Item_48	Final_Set	FIRST	1
Item_48	Final_Set	WAIT U(120, 0)	1	Item_48	WIP_Sablon	FIRST	1
Item_48	WIP_Sablon		1	Item_48	Sablon	FIRST	1
Item_48	Sablon	WAIT U(50, 0)	1	Item_48	EXIT	FIRST	1
Item_81	Gudang		1	Item_81	WIP_Relaxing_B	FIRST	1
Item_81	WIP_Relaxing_B		1	Item_81	Relaxing_B	FIRST	1
Item_81	Relaxing_B	WAIT U(120, 0)	1	Item_81	WIP_Unroll	FIRST	1
Item_81	WIP_Unroll		1	Item_81	Unroll	FIRST	1

Item_81	Unroll	WAIT U(25, 0)	1	Item_81	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_81	WIP_Pre_Washing_Drying		1	Item_81	Pre_Washing_Drying	FIRST 1		
Item_81	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_81	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_Preset		1	Item_81	Preset	FIRST 1		
Item_81	Preset	WAIT U(45, 0)	1	Item_81	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_Hisaka_WR		1	Item_81	Hisaka_WR	FIRST 1		
Item_81	Hisaka_WR	WAIT U(120, 0)	1	Item_81	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_Dyeing_Black		1	Item_81	Dyeing_Black	FIRST 1		
Item_81	Dyeing_Black	WAIT U(150, 0)	1	Item_81	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_81	WIP_FWD		1	Item_81	FWD	FIRST 1		
Item_81	FWD	WAIT U(40, 0)	1	Item_81	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_81	WIP_Final_Set		1	Item_81	Final_Set	FIRST 1		
Item_81	Final_Set	WAIT U(140, 0)	1	Item_81	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_128	Gudang		1	Item_128	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Relaxing_B		1	Item_128	Relaxing_B	FIRST 1		
Item_128	Relaxing_B	WAIT U(120, 0)	1	Item_128	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_128	WIP_Unroll		1	Item_128	Unroll	FIRST 1		
Item_128	Unroll	WAIT U(25, 0)	1	Item_128	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_128	WIP_Pre_Washing_Drying		1	Item_128	Pre_Washing_Drying	FIRST 1		
Item_128	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_128	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Preset		1	Item_128	Preset	FIRST 1		
Item_128	Preset	WAIT U(45, 0)	1	Item_128	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Hisaka_WR		1	Item_128	Hisaka_WR	FIRST 1		
Item_128	Hisaka_WR	WAIT U(120, 0)	1	Item_128	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_Dyeing_Black		1	Item_128	Dyeing_Black	FIRST 1		
Item_128	Dyeing_Black	WAIT U(150, 0)	1	Item_128	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_128	WIP_FWD		1	Item_128	FWD	FIRST 1		
Item_128	FWD	WAIT U(40, 0)	1	Item_128	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_128	WIP_Final_Set		1	Item_128	Final_Set	FIRST 1		
Item_128	Final_Set	WAIT U(140, 0)	1	Item_128	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_51	Gudang		1	Item_51	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_51	WIP_Relaxing_B		1	Item_51	Relaxing_B	FIRST 1		
Item_51	Relaxing_B	WAIT U(120, 0)	1	Item_51	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_51	WIP_Sofcer		1	Item_51	Sofcer	FIRST 1		
Item_51	Sofcer	WAIT U(20, 0)	1	Item_51	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_51	WIP_Unroll		1	Item_51	Unroll	FIRST 1		
Item_51	Unroll	WAIT U(25, 0)	1	Item_51	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_51	WIP_Preset		1	Item_51	Preset	FIRST 1		
Item_51	Preset	WAIT U(45, 0)	1	Item_51	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_51	WIP_Hisaka_WR		1	Item_51	Hisaka_WR	FIRST 1		
Item_51	Hisaka_WR	WAIT U(120, 0)	1	Item_51	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_51	WIP_Dyeing_Colour		1	Item_51	Dyeing_Colour	FIRST 1		
Item_51	Dyeing_Colour	WAIT U(150, 0)	1	Item_51	WIP_Final_Set	FIRST 1	MOVE FOR	3 MIN
Item_51	WIP_Final_Set		1	Item_51	Final_Set	FIRST 1		
Item_51	Final_Set	WAIT U(35, 0)	1	Item_51	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_28	Gudang		1	Item_28	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_28	WIP_Reeling		1	Item_28	Reeling	FIRST 1		
Item_28	Reeling	WAIT U(25, 0)	1	Item_28	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Relaxing_A		1	Item_28	Relaxing_A	FIRST 1		
Item_28	Relaxing_A	WAIT U(120, 0)	1	Item_28	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Hydro		1	Item_28	Hydro	FIRST 1		
Item_28	Hydro	WAIT U(35, 0)	1	Item_28	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Unroll		1	Item_28	Unroll	FIRST 1		
Item_28	Unroll	WAIT U(25, 0)	1	Item_28	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Preset		1	Item_28	Preset	FIRST 1		
Item_28	Preset	WAIT U(45, 0)	1	Item_28	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_28	WIP_Hisaka_WR		1	Item_28	Hisaka_WR	FIRST 1		
Item_28	Hisaka_WR	WAIT U(120, 0)	1	Item_28	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_28	WIP_Dyeing_Colour		1	Item_28	Dyeing_Colour	FIRST 1		
Item_28	Dyeing_Colour	WAIT U(150, 0)	1	Item_28	WIP_Final_Set	FIRST 1	MOVE FOR	3 MIN
Item_28	WIP_Final_Set		1	Item_28	Final_Set	FIRST 1		
Item_28	Final_Set	WAIT U(120, 0)	1	Item_28	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_28	WIP_Heat_Cut		1	Item_28	Heat_Cut	FIRST 1		
Item_28	Heat_Cut	WAIT U(20, 0)	1	Item_28	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_28	WIP_Sablon		1	Item_28	Sablon	FIRST 1		
Item_28	Sablon	WAIT U(50, 0)	1	Item_28	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_93	Gudang		1	Item_93	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_93	WIP_Reeling		1	Item_93	Reeling	FIRST 1		
Item_93	Reeling	WAIT U(25, 0)	1	Item_93	Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Relaxing_A		1	Item_93	Relaxing_A	FIRST 1		
Item_93	Relaxing_A	WAIT U(120, 0)	1	Item_93	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Hydro		1	Item_93	Hydro	FIRST 1		
Item_93	Hydro	WAIT U(35, 0)	1	Item_93	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Unroll		1	Item_93	Unroll	FIRST 1		
Item_93	Unroll	WAIT U(25, 0)	1	Item_93	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Preset		1	Item_93	Preset	FIRST 1		
Item_93	Preset	WAIT U(45, 0)	1	Item_93	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_Hisaka_WR		1	Item_93	Hisaka_WR	FIRST 1		
Item_93	Hisaka_WR	WAIT U(120, 0)	1	Item_93	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_Dyeing_Black		1	Item_93	Dyeing_Black	FIRST 1		
Item_93	Dyeing_Black	WAIT U(150, 0)	1	Item_93	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_FWD		1	Item_93	FWD	FIRST 1		
Item_93	FWD	WAIT U(40, 0)	1	Item_93	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_93	WIP_Final_Set		1	Item_93	Final_Set	FIRST 1		
Item_93	Final_Set	WAIT U(120, 0)	1	Item_93	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_93	WIP_Heat_Cut		1	Item_93	Heat_Cut	FIRST 1		
Item_93	Heat_Cut	WAIT U(20, 0)	1	Item_93	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_93	WIP_Sablon		1	Item_93	Sablon	FIRST 1		
Item_93	Sablon	WAIT U(50, 0)	1	Item_93	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_6	Gudang		1	Item_6	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_Relaxing_B		1	Item_6	Relaxing_B	FIRST 1		
Item_6	Relaxing_B	WAIT U(120, 0)	1	Item_6	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_6	WIP_Sofcer		1	Item_6	Sofcer	FIRST 1		
Item_6	Sofcer	WAIT U(20, 0)	1	Item_6	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_6	WIP_Unroll		1	Item_6	Unroll	FIRST 1		
Item_6	Unroll	WAIT U(25, 0)	1	Item_6	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_6	WIP_Pre_Washing_Drying		1	Item_6	Pre_Washing_Drying	FIRST 1		
Item_6	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_6	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_6	WIP_Preset		1	Item_6	Preset	FIRST 1		
Item_6	Preset	WAIT U(45, 0)	1	Item_6	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_ST_Tank		1	Item_6	ST_Tank	FIRST 1		
Item_6	ST_Tank	WAIT U(25, 0)	1	Item_6	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_Dyeing_Black		1	Item_6	Dyeing_Black	FIRST 1		
Item_6	Dyeing_Black	WAIT U(150, 0)	1	Item_6	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_FWD		1	Item_6	FWD	FIRST 1		
Item_6	FWD	WAIT U(40, 0)	1	Item_6	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_6	WIP_Final_Set		1	Item_6	Final_Set	FIRST 1		
Item_6	Final_Set	WAIT U(120, 0)	1	Item_6	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_6	WIP_Sablon		1	Item_6	Sablon	FIRST 1		
Item_6	Sablon	WAIT U(50, 0)	1	Item_6	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_126	Gudang		1	Item_126	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_126	WIP_Reeling		1	Item_126	Reeling	FIRST 1		
Item_126	Reeling	WAIT U(25, 0)	1	Item_126	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN



Item_90	WIP_FWD		1	Item_90	FWD	FIRST	1
Item_90	FWD	WAIT U(40, 0)	1	Item_90	WIP_Final_Set	FIRST	1
Item_90	WIP_Final_Set		1	Item_90	Final_Set	FIRST	1
Item_90	Final_Set	WAIT U(35, 0)	1	Item_90	EXIT	FIRST	1
Item_147	Gudang		1	Item_147	WIP_Reeling	FIRST	1
Item_147	WIP_Reeling		1	Item_147	Reeling	FIRST	1
Item_147	Reeling	WAIT U(25, 0)	1	Item_147	WIP_Relaxing_A	FIRST	1
Item_147	WIP_Relaxing_A		1	Item_147	Relaxing_A	FIRST	1
Item_147	Relaxing_A	WAIT U(120, 0)	1	Item_147	WIP_Hydro	FIRST	1
Item_147	WIP_Hydro		1	Item_147	Hydro	FIRST	1
Item_147	Hydro	WAIT U(35, 0)	1	Item_147	WIP_Unroll	FIRST	1
Item_147	WIP_Unroll		1	Item_147	Unroll	FIRST	1
Item_147	Unroll	WAIT U(25, 0)	1	Item_147	WIP_Preset	FIRST	1
Item_147	WIP_Preset		1	Item_147	Preset	FIRST	1
Item_147	Preset	WAIT U(45, 0)	1	Item_147	WIP_ST_Tank	FIRST	1
Item_147	WIP_ST_Tank		1	Item_147	ST_Tank	FIRST	1
Item_147	ST_Tank	WAIT U(25, 0)	1	Item_147	WIP_Dyeing_Black	FIRST	1
Item_147	WIP_Dyeing_Black		1	Item_147	Dyeing_Black	FIRST	1
Item_147	Dyeing_Black	WAIT U(150, 0)	1	Item_147	WIP_FWD	FIRST	1
Item_147	WIP_FWD		1	Item_147	FWD	FIRST	1
Item_147	FWD	WAIT U(40, 0)	1	Item_147	WIP_Final_Set	FIRST	1
Item_147	WIP_Final_Set		1	Item_147	Final_Set	FIRST	1
Item_147	Final_Set	WAIT U(35, 0)	1	Item_147	EXIT	FIRST	1
Item_104	Gudang		1	Item_104	WIP_Relaxing_B	FIRST	1
Item_104	WIP_Relaxing_B		1	Item_104	Relaxing_B	FIRST	1
Item_104	Relaxing_B	WAIT U(120, 0)	1	Item_104	WIP_Unroll	FIRST	1
Item_104	WIP_Unroll		1	Item_104	Unroll	FIRST	1
Item_104	Unroll	WAIT U(25, 0)	1	Item_104	WIP_Preset	FIRST	1
Item_104	WIP_Preset		1	Item_104	Preset	FIRST	1
Item_104	Preset	WAIT U(45, 0)	1	Item_104	WIP_ST_Tank	FIRST	1
Item_104	WIP_ST_Tank		1	Item_104	ST_Tank	FIRST	1
Item_104	ST_Tank	WAIT U(25, 0)	1	Item_104	WIP_Dyeing_Colour	FIRST	1
Item_104	WIP_Dyeing_Colour		1	Item_104	Dyeing_Colour	FIRST	1
Item_104	Dyeing_Colour	WAIT U(150, 0)	1	Item_104	WIP_FWD	FIRST	1
Item_104	WIP_FWD		1	Item_104	FWD	FIRST	1
Item_104	FWD	WAIT U(40, 0)	1	Item_104	WIP_Final_Set	FIRST	1
Item_104	WIP_Final_Set		1	Item_104	Final_Set	FIRST	1
Item_104	Final_Set	WAIT U(120, 0)	1	Item_104	WIP_Sablon	FIRST	1
Item_104	WIP_Sablon		1	Item_104	Sablon	FIRST	1
Item_104	Sablon	WAIT U(50, 0)	1	Item_104	WIP_Relaxing_B	FIRST	1
Item_43	Gudang		1	Item_43	Relaxing_B	FIRST	1
Item_43	WIP_Relaxing_B		1	Item_43	Relaxing_B	FIRST	1
Item_43	Relaxing_B	WAIT U(120, 0)	1	Item_43	WIP_Sofcer	FIRST	1
Item_43	WIP_Sofcer		1	Item_43	Sofcer	FIRST	1
Item_43	Sofcer	WAIT U(20, 0)	1	Item_43	WIP_Unroll	FIRST	1
Item_43	WIP_Unroll		1	Item_43	Unroll	FIRST	1
Item_43	Unroll	WAIT U(25, 0)	1	Item_43	WIP_Preset	FIRST	1
Item_43	WIP_Preset		1	Item_43	Preset	FIRST	1
Item_43	Preset	WAIT U(45, 0)	1	Item_43	WIP_ST_Tank	FIRST	1
Item_43	WIP_ST_Tank		1	Item_43	ST_Tank	FIRST	1
Item_43	ST_Tank	WAIT U(25, 0)	1	Item_43	WIP_Dyeing_Black	FIRST	1
Item_43	WIP_Dyeing_Black		1	Item_43	Dyeing_Black	FIRST	1
Item_43	Dyeing_Black	WAIT U(150, 0)	1	Item_43	WIP_FWD	FIRST	1
Item_43	WIP_FWD		1	Item_43	FWD	FIRST	1
Item_43	FWD	WAIT U(40, 0)	1	Item_43	WIP_Final_Set	FIRST	1
Item_43	WIP_Final_Set		1	Item_43	Final_Set	FIRST	1
Item_43	Final_Set	WAIT U(140, 0)	1	Item_43	EXIT	FIRST	1
Item_16	Gudang		1	Item_16	WIP_Relaxing_B	FIRST	1
Item_16	WIP_Relaxing_B		1	Item_16	Relaxing_B	FIRST	1
Item_16	Relaxing_B	WAIT U(120, 0)	1	Item_16	WIP_Sofcer	FIRST	1
Item_16	WIP_Sofcer		1	Item_16	Sofcer	FIRST	1
Item_16	Sofcer	WAIT U(20, 0)	1	Item_16	WIP_Unroll	FIRST	1
Item_16	WIP_Unroll		1	Item_16	Unroll	FIRST	1
Item_16	Unroll	WAIT U(25, 0)	1	Item_16	WIP_Preset	FIRST	1
Item_16	WIP_Preset		1	Item_16	Preset	FIRST	1
Item_16	Preset	WAIT U(45, 0)	1	Item_16	WIP_Hisaka_WR	FIRST	1
Item_16	WIP_Hisaka_WR		1	Item_16	Hisaka_WR	FIRST	1
Item_16	Hisaka_WR	WAIT U(120, 0)	1	Item_16	WIP_Dyeing_Colour	FIRST	1
Item_16	WIP_Dyeing_Colour		1	Item_16	Dyeing_Colour	FIRST	1
Item_16	Dyeing_Colour	WAIT U(150, 0)	1	Item_16	WIP_FWD	FIRST	1
Item_16	WIP_FWD		1	Item_16	FWD	FIRST	1
Item_16	FWD	WAIT U(40, 0)	1	Item_16	WIP_Final_Set	FIRST	1
Item_16	WIP_Final_Set		1	Item_16	Final_Set	FIRST	1
Item_16	Final_Set	WAIT U(35, 0)	1	Item_16	EXIT	FIRST	1
Item_130	Gudang		1	Item_130	WIP_Reeling	FIRST	1
Item_130	WIP_Reeling		1	Item_130	Reeling	FIRST	1
Item_130	Reeling	WAIT U(25, 0)	1	Item_130	WIP_Relaxing_A	FIRST	1
Item_130	WIP_Relaxing_A		1	Item_130	Relaxing_A	FIRST	1
Item_130	Relaxing_A	WAIT U(120, 0)	1	Item_130	WIP_Hydro	FIRST	1
Item_130	WIP_Hydro		1	Item_130	Hydro	FIRST	1
Item_130	Hydro	WAIT U(35, 0)	1	Item_130	WIP_Unroll	FIRST	1
Item_130	WIP_Unroll		1	Item_130	Unroll	FIRST	1
Item_130	Unroll	WAIT U(25, 0)	1	Item_130	WIP_Preset	FIRST	1
Item_130	WIP_Preset		1	Item_130	Preset	FIRST	1
Item_130	Preset	WAIT U(45, 0)	1	Item_130	WIP_ST_Tank	FIRST	1
Item_130	WIP_ST_Tank		1	Item_130	ST_Tank	FIRST	1
Item_130	ST_Tank	WAIT U(25, 0)	1	Item_130	WIP_Dyeing_Black	FIRST	1
Item_130	WIP_Dyeing_Black		1	Item_130	Dyeing_Black	FIRST	1
Item_130	Dyeing_Black	WAIT U(150, 0)	1	Item_130	WIP_FWD	FIRST	1
Item_130	WIP_FWD		1	Item_130	FWD	FIRST	1
Item_130	FWD	WAIT U(40, 0)	1	Item_130	WIP_Final_Set	FIRST	1
Item_130	WIP_Final_Set		1	Item_130	Final_Set	FIRST	1
Item_130	Final_Set	WAIT U(35, 0)	1	Item_130	EXIT	FIRST	1
Item_131	Gudang		1	Item_131	WIP_Relaxing_B	FIRST	1
Item_131	WIP_Relaxing_B		1	Item_131	Relaxing_B	FIRST	1
Item_131	Relaxing_B	WAIT U(120, 0)	1	Item_131	WIP_Sofcer	FIRST	1
Item_131	WIP_Sofcer		1	Item_131	Sofcer	FIRST	1
Item_131	Sofcer	WAIT U(20, 0)	1	Item_131	WIP_Unroll	FIRST	1
Item_131	WIP_Unroll		1	Item_131	Unroll	FIRST	1
Item_131	Unroll	WAIT U(25, 0)	1	Item_131	WIP_Preset	FIRST	1
Item_131	WIP_Preset		1	Item_131	Preset	FIRST	1
Item_131	Preset	WAIT U(45, 0)	1	Item_131	WIP_Hisaka_WR	FIRST	1
Item_131	WIP_Hisaka_WR		1	Item_131	Hisaka_WR	FIRST	1
Item_131	Hisaka_WR	WAIT U(120, 0)	1	Item_131	WIP_Dyeing_Black	FIRST	1
Item_131	WIP_Dyeing_Black		1	Item_131	Dyeing_Black	FIRST	1
Item_131	Dyeing_Black	WAIT U(150, 0)	1	Item_131	WIP_FWD	FIRST	1
Item_131	WIP_FWD		1	Item_131	FWD	FIRST	1
Item_131	FWD	WAIT U(40, 0)	1	Item_131	WIP_Final_Set	FIRST	1
Item_131	WIP_Final_Set		1	Item_131	Final_Set	FIRST	1
Item_131	Final_Set	WAIT U(35, 0)	1	Item_131	EXIT	FIRST	1
Item_45	Gudang		1	Item_45	WIP_Reeling	FIRST	1
Item_45	WIP_Reeling		1	Item_45	Reeling	FIRST	1
Item_45	Reeling	WAIT U(25, 0)	1	Item_45	WIP_Relaxing_A	FIRST	1

Item_45	WIP_Relaxing_A		1	Item_45	Relaxing_A	FIRST	1
Item_45	Relaxing_A	WAIT U(120, 0)	1	Item_45	WIP_Hydro	FIRST	1 MOVE FOR 2 MIN
Item_45	WIP_Hydro		1	Item_45	Hydro	FIRST	1
Item_45	Hydro	WAIT U(35, 0)	1	Item_45	WIP_Unroll	FIRST	1 MOVE FOR 2 MIN
Item_45	WIP_Unroll		1	Item_45	Unroll	FIRST	1
Item_45	Unroll	WAIT U(25, 0)	1	Item_45	WIP_Preset	FIRST	1 MOVE FOR 2 MIN
Item_45	WIP_Preset		1	Item_45	Preset	FIRST	1
Item_45	PreSet	WAIT U(45, 0)	1	Item_45	WIP_ST_Tank	FIRST	1 MOVE FOR 5 MIN
Item_45	WIP_ST_Tank		1	Item_45	ST_Tank	FIRST	1
Item_45	ST_Tank	WAIT U(25, 0)	1	Item_45	WIP_Dyeing_Black	FIRST	1 MOVE FOR 5 MIN
Item_45	WIP_Dyeing_Black		1	Item_45	Dyeing_Black	FIRST	1
Item_45	Dyeing_Black	WAIT U(150, 0)	1	Item_45	WIP_FWD	FIRST	1 MOVE FOR 5 MIN
Item_45	WIP_FWD		1	Item_45	FWD	FIRST	1
Item_45	FWD	WAIT U(40, 0)	1	Item_45	WIP_Final_Set	FIRST	1 MOVE FOR 4 MIN
Item_45	WIP_Final_Set		1	Item_45	Final_Set	FIRST	1
Item_45	Final_Set	WAIT U(35, 0)	1	Item_45	EXIT	FIRST	1 MOVE FOR 10 MIN
work_order	Gudang		1	work_order	EXIT	FIRST	1

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\* Arrivals \*  
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Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
work_order	Gudang	1		1		ORDER 3401 Item_79 ORDER 1531 Item_106 ORDER 1828 Item_150 ORDER 1381 Item_60 ORDER 1557 Item_18 ORDER 1277 Item_72 ORDER 917 Item_38 ORDER 439 Item_97 ORDER 377 Item_48 ORDER 501 Item_81 ORDER 1248 Item_128 ORDER 450 Item_51 ORDER 112 Item_28 ORDER 290 Item_93 ORDER 412 Item_6 ORDER 284 Item_126 ORDER 726 Item_50 ORDER 212 Item_73 ORDER 145 Item_98 ORDER 234 Item_91 ORDER 591 Item_90 ORDER 67 Item_147 ORDER 92 Item_104 ORDER 218 Item_43 ORDER 228 Item_16 ORDER 131 Item_130 ORDER 130 Item_131 ORDER 190 Item_45

## ● Output Promodel (Skenario 2)

General Report

Output from D:\Maranatha\Kuliah\TA\Laporan\Promodel\Aktual\2. Jmlah produksi full, 15 bulan.MOD

Date: Jan/16/2013 Time: 12:07:10 AM

Scenario : Normal Run

Replication : 1 of 1

Simulation Time : 14241.51

### LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Minutes Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
Gudang	14241.51	999999	18970	424179.68	9416.94	18934	0	0.94
Reeling.1	14241.51	1	1727	239.03	0.48	1	0	48.31
Reeling.2	14241.51	1	1727	239.06	0.48	1	0	48.32
Reeling.3	14241.51	1	1730	238.57	0.48	1	0	48.30
Reeling.4	14241.51	1	1728	238.82	0.48	1	0	48.30
Reeling	56966.06	4	6912	238.87	0.48	4	0	48.31
Relaxing A.1	14241.51	1	1152	358.63	0.48	1	0	48.35
Relaxing A.2	14241.51	1	1152	358.71	0.48	1	0	48.36
Relaxing A.3	14241.51	1	1152	358.75	0.48	1	0	48.37
Relaxing A.4	14241.51	1	1152	358.78	0.48	1	0	48.37
Relaxing A.5	14241.51	1	1152	358.84	0.48	1	0	48.38
Relaxing A.6	14241.51	1	1152	358.88	0.48	1	0	48.38
Relaxing A	85449.1	6	6912	358.76	0.48	6	0	48.37
Relaxing B.1	14241.51	1	3015	282.96	0.99	1	0	99.84
Relaxing B.2	14241.51	1	3014	283.01	0.99	1	0	99.83
Relaxing B.3	14241.51	1	3014	283.02	0.99	1	0	99.83
Relaxing B.4	14241.51	1	3014	283.04	0.99	1	0	99.84
Relaxing B	56966.06	4	12057	283.01	0.99	4	0	99.83
Hydro.1	14241.51	1	2304	179.63	0.48	1	0	48.44
Hydro.2	14241.51	1	2304	179.65	0.48	1	0	48.44
Hydro.3	14241.51	1	2304	179.67	0.48	1	0	48.45
Hydro	42724.55	3	6912	179.65	0.48	3	0	48.44
Sofcer	14241.51	1	5073	106.43	0.63	1	0	63.19
Unroll.1	14241.51	1	6326	134.92	0.99	1	0	99.89
Unroll.2	14241.51	1	6327	134.90	0.99	1	0	99.89
Unroll.3	14241.51	1	6316	135.11	0.99	1	0	99.87
Unroll	42724.55	3	18969	134.98	0.99	3	0	99.88
Pre Washing Drying	14241.51	1	9750	66.80	0.76	1	0	76.23
Preset	14241.51	1	18969	45.01	0.99	1	0	99.93
Hisaka WR.1	14241.51	1	4128	120.55	0.58	1	0	58.24
Hisaka WR.2	14241.51	1	4121	120.55	0.58	1	0	58.14
Hisaka WR.3	14241.51	1	4110	120.56	0.57	1	0	57.99
Hisaka WR	42724.55	3	12359	120.55	0.58	3	0	58.12
ST Tank.1	14241.51	1	6610	25.00	0.19	1	0	19.34
ST Tank.2	14241.51	1	0	0.00	0	0	0	0.00
ST Tank.3	14241.51	1	0	0.00	0	0	0	0.00
ST Tank.4	14241.51	1	0	0.00	0	0	0	0.00
ST Tank	56966.06	4	6610	25.00	0.04	1	0	4.83
Dyeing Colour.1	14241.51	1	3625	150.35	0.63	1	0	63.79
Dyeing Colour.2	14241.51	1	3402	150.37	0.59	1	0	59.87
Dyeing Colour.3	14241.51	1	3398	150.38	0.59	1	0	59.80
Dyeing Colour.4	14241.51	1	3383	150.36	0.59	1	0	59.53
Dyeing Colour.5	14241.51	1	24	198.54	0.00	1	0	0.56
Dyeing Colour.6	14241.51	1	9	267.22	0.00	1	0	0.28
Dyeing Colour.7	14241.51	1	7	290.71	0.00	1	0	0.24
Dyeing Colour	99690.61	7	13848	150.60	0.34	7	0	34.87
FWD.1	14241.51	1	16350	41.80	0.79	1	0	79.99
FWD.2	14241.51	1	2057	54.37	0.13	1	0	13.09
FWD	28483.03	2	18407	43.21	0.46	2	0	46.54
Final Set.1	14241.51	1	14792	43.57	0.75	1	0	75.43
Final Set.2	14241.51	1	2819	79.61	0.26	1	0	26.27
Final Set.3	14241.51	1	1358	126.84	0.20	1	0	20.16
Final Set	42724.55	3	18969	54.89	0.40	3	0	40.62
Heat Cut.1	14241.51	1	3786	20.00	0.08	1	0	8.86
Heat Cut.2	14241.51	1	1	20.00	2.34	1	0	0.00
Heat Cut	28483.03	2	3787	20.00	0.04	2	0	4.43
Folding.1	14241.51	1	1828	45.00	0.09	1	0	9.63
Folding.2	14241.51	1	0	0.00	0	0	0	0.00
Folding.3	14241.51	1	0	0.00	0	0	0	0.00
Folding	42724.55	3	1828	45.00	0.03	1	0	3.21
Sablon.1	14241.51	1	3187	50.00	0.18	1	0	18.65
Sablon.2	14241.51	1	2707	50.00	0.15	1	0	15.84
Sablon.3	14241.51	1	18	50.00	0.00	1	0	0.11
Sablon	42724.55	3	5912	50.00	0.11	3	0	11.53
WIP Reeling	14241.51	21	6912	1248.82	10.10	21	0	48.10
WIP Relaxing A	14241.51	6	6622	356.46	2.76	6	0	46.04
WIP Relaxing B	14241.51	14	12057	985.07	13.89	14	0	99.28
WIP Hydro	14241.51	7	6912	416.67	3.37	7	0	48.15
WIP Sofcer	14241.51	6	5073	634.28	3.76	6	0	62.76
WIP Unroll	14241.51	3	18969	132.90	2.95	3	0	98.35
WIP Pre Washing Drying	14241.51	4	9750	264.63	3.01	4	0	75.49
WIP Preset	14241.51	8	18969	355.81	7.89	8	0	98.73
WIP Hisaka WR	14241.51	6	12359	6.30	0.09	6	0	1.52
WIP ST Tank	14241.51	8	6610	0.00	0	1	0	0.00
WIP Dyeing Colour	14241.51	7	13848	0.24	0.00	5	0	0.06

WIP FWD	14241.51	18	18407	37.13	0.79	18	0	4.44
WIP Final Set	14241.51	24	18969	86.88	1.92	24	0	8.04
WIP Heat Cut	14241.51	4	3787	0.00	0	1	0	0.00
WIP Folding	14241.51	3	1828	0.00	0	1	0	0.00
Dyeing Black.1	14241.51	1	1319	157.21	0.24	1	0	24.27
Dyeing Black.2	14241.51	1	1311	157.31	0.24	1	0	24.14
Dyeing Black.3	14241.51	1	1305	157.16	0.24	1	0	24.00
Dyeing Black.4	14241.51	1	1081	158.70	0.20	1	0	20.08
Dyeing Black.5	14241.51	1	105	240.22	0.02	1	0	2.95
Dyeing Black	71207.58	5	5121	159.24	0.19	5	0	19.09
WIP Sablon	14241.51	6	5912	0.00	0	1	0	0.00
WIP Dyeing Black	14241.51	5	5121	18.94	0.11	5	0	2.27

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	% Empty	% Partially Occupied	% Full	% Down
Gudang	14241.51	0.25	99.75	0.00	0.00
WIP Reeling	14241.51	51.71	2.55	45.74	0.00
WIP Relaxing A	14241.51	53.65	1.64	44.71	0.00
WIP Relaxing B	14241.51	0.18	7.11	92.71	0.00
WIP Hydro	14241.51	51.59	1.68	46.73	0.00
WIP Sofcer	14241.51	36.87	1.53	61.60	0.00
WIP Unroll	14241.51	0.15	4.49	95.36	0.00
WIP Pre Washing Drying	14241.51	23.84	2.49	73.68	0.00
WIP Preset	14241.51	0.09	8.38	91.53	0.00
WIP Hisaka WR	14241.51	97.99	1.05	0.96	0.00
WIP ST Tank	14241.51	100.00	0.00	0.00	0.00
WIP Dyeing Colour	14241.51	99.84	0.16	0.00	0.00
WIP FWD	14241.51	94.22	2.96	2.83	0.00
WIP Final Set	14241.51	89.17	5.26	5.58	0.00
WIP Heat Cut	14241.51	100.00	0.00	0.00	0.00
WIP Folding	14241.51	100.00	0.00	0.00	0.00
WIP Sablon	14241.51	100.00	0.00	0.00	0.00
WIP Dyeing Black	14241.51	97.32	0.91	1.77	0.00

LOCATION STATES BY PERCENTAGE (Single Capacity/Tanks)

Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down
Reeling.1	14241.51	5.05	0.00	51.69	0.00	43.26	0.00
Reeling.2	14241.51	5.05	0.00	51.68	0.01	43.26	0.00
Reeling.3	14241.51	5.06	0.00	51.70	0.00	43.24	0.00
Reeling.4	14241.51	5.06	0.00	51.70	0.00	43.24	0.00
Reeling	56966.06	5.06	0.00	51.69	0.00	43.25	0.00
Relaxing A.1	14241.51	16.18	0.00	51.65	0.00	32.17	0.00
Relaxing A.2	14241.51	16.18	0.00	51.64	0.00	32.18	0.00
Relaxing A.3	14241.51	16.18	0.00	51.63	0.00	32.19	0.00
Relaxing A.4	14241.51	16.18	0.00	51.63	0.00	32.19	0.00
Relaxing A.5	14241.51	16.18	0.00	51.62	0.00	32.20	0.00
Relaxing A.6	14241.51	16.18	0.00	51.61	0.00	32.21	0.00
Relaxing A	85449.1	16.18	0.00	51.63	0.00	32.19	0.00
Relaxing B.1	14241.51	42.34	0.00	0.16	0.00	57.50	0.00
Relaxing B.2	14241.51	42.33	0.00	0.17	0.00	57.50	0.00
Relaxing B.3	14241.51	42.33	0.00	0.17	0.00	57.50	0.00
Relaxing B.4	14241.51	42.33	0.00	0.16	0.00	57.51	0.00
Relaxing B	56966.06	42.33	0.00	0.17	0.00	57.50	0.00
Hydro.1	14241.51	9.44	0.00	51.56	0.00	39.00	0.00
Hydro.2	14241.51	9.44	0.00	51.56	0.00	39.00	0.00
Hydro.3	14241.51	9.44	0.00	51.55	0.00	39.01	0.00
Hydro	42724.55	9.44	0.00	51.56	0.00	39.00	0.00
Sofcer	14241.51	11.87	0.00	36.81	0.01	51.31	0.00
Unroll.1	14241.51	18.51	0.00	0.11	0.00	81.38	0.00
Unroll.2	14241.51	18.51	0.00	0.11	0.00	81.38	0.00
Unroll.3	14241.51	18.48	0.00	0.12	0.00	81.40	0.00
Unroll	42724.55	18.50	0.00	0.12	0.00	81.38	0.00
Pre Washing Drying	14241.51	45.64	0.00	23.77	0.00	30.59	0.00
Preset	14241.51	99.90	0.00	0.06	0.00	0.04	0.00
Hisaka WR.1	14241.51	57.97	0.00	41.76	0.00	0.27	0.00
Hisaka WR.2	14241.51	57.87	0.00	41.86	0.00	0.27	0.00
Hisaka WR.3	14241.51	57.72	0.00	42.01	0.00	0.27	0.00
Hisaka WR	42724.55	57.85	0.00	41.88	0.00	0.27	0.00
ST Tank.1	14241.51	19.34	0.00	80.66	0.00	0.00	0.00
ST Tank.2	14241.51	0.00	0.00	100.00	0.00	0.00	0.00
ST Tank.3	14241.51	0.00	0.00	100.00	0.00	0.00	0.00
ST Tank.4	14241.51	0.00	0.00	100.00	0.00	0.00	0.00
ST Tank	56966.06	4.83	0.00	95.17	0.00	0.00	0.00
Dyeing Colour.1	14241.51	63.63	0.00	36.21	0.01	0.15	0.00
Dyeing Colour.2	14241.51	59.72	0.00	40.13	0.00	0.15	0.00
Dyeing Colour.3	14241.51	59.65	0.00	40.20	0.00	0.15	0.00
Dyeing Colour.4	14241.51	59.39	0.00	40.46	0.00	0.15	0.00
Dyeing Colour.5	14241.51	0.42	0.00	99.44	0.00	0.14	0.00
Dyeing Colour.6	14241.51	0.16	0.00	99.72	0.00	0.12	0.00
Dyeing Colour.7	14241.51	0.12	0.00	99.76	0.00	0.12	0.00
Dyeing Colour	99690.61	34.73	0.00	65.13	0.00	0.14	0.00
FWD.1	14241.51	76.54	0.00	20.00	0.00	3.46	0.00
FWD.2	14241.51	9.63	0.00	86.91	0.00	3.46	0.00
FWD	28483.03	43.08	0.00	53.46	0.00	3.46	0.00
Final Set.1	14241.51	75.43	0.00	24.57	0.00	0.00	0.00



Final Set.2	14241.51	26.27	0.00	73.73	0.00	0.00	0.00
Final Set.3	14241.51	20.16	0.00	79.84	0.00	0.00	0.00
Final Set	42724.55	40.62	0.00	59.38	0.00	0.00	0.00
Heat Cut.1	14241.51	8.86	0.00	91.14	0.00	0.00	0.00
Heat Cut.2	14241.51	0.00	0.00	100.00	0.00	0.00	0.00
Heat Cut	28483.03	4.43	0.00	95.57	0.00	0.00	0.00
Folding.1	14241.51	9.63	0.00	90.37	0.00	0.00	0.00
Folding.2	14241.51	0.00	0.00	100.00	0.00	0.00	0.00
Folding.3	14241.51	0.00	0.00	100.00	0.00	0.00	0.00
Folding	42724.55	3.21	0.00	96.79	0.00	0.00	0.00
Sablon.1	14241.51	18.65	0.00	81.35	0.00	0.00	0.00
Sablon.2	14241.51	15.84	0.00	84.16	0.00	0.00	0.00
Sablon.3	14241.51	0.11	0.00	99.89	0.00	0.00	0.00
Sablon	42724.55	11.53	0.00	88.47	0.00	0.00	0.00
Dyeing Black.1	14241.51	23.15	0.00	75.73	0.01	1.11	0.00
Dyeing Black.2	14241.51	23.01	0.00	75.86	0.01	1.12	0.00
Dyeing Black.3	14241.51	22.91	0.00	76.00	0.00	1.09	0.00
Dyeing Black.4	14241.51	18.98	0.00	79.92	0.00	1.10	0.00
Dyeing Black.5	14241.51	1.84	0.00	97.05	0.00	1.11	0.00
Dyeing Black	71207.58	17.98	0.00	80.91	0.00	1.11	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
work order	Gudang	0

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Minutes In System	Average Minutes In Move Logic	Average Minutes Wait For Res, etc.	Average Minutes In Operation	Average Minutes Blocked
Item 79	3401	0	282704.93	32.00	0.00	500.00	282172.93
Item 106	1531	0	46692.71	32.00	0.00	635.00	46025.71
Item 150	1828	0	505939.92	42.00	0.00	650.00	505247.92
Item 60	1381	0	578022.00	32.00	0.00	535.00	577455.00
Item 18	1557	0	644204.00	40.00	0.00	645.00	643519.00
Item 72	1277	0	130706.77	30.00	0.00	595.00	130081.77
Item 38	917	0	196432.01	30.00	0.00	500.00	195902.01
Item 97	439	0	237435.24	32.00	0.00	635.00	236768.24
Item 48	377	0	687782.00	38.00	0.00	710.00	687034.00
Item 81	501	0	707917.00	33.00	0.00	680.00	707204.00
Item 128	1248	0	748736.96	33.00	0.00	680.00	748023.96
Item 51	450	0	785346.06	28.00	0.00	515.00	784803.06
Item 28	112	0	253862.10	31.00	0.00	710.00	253121.10
Item 93	290	0	265957.91	37.00	0.00	750.00	265170.91
Item 6	412	0	804705.49	41.00	0.00	635.00	804029.49
Item 126	284	0	283302.59	37.00	0.00	685.00	282580.59
Item 50	726	0	313456.44	35.00	0.00	730.00	312691.44
Item 73	212	0	341362.00	30.00	0.00	500.00	340832.00
Item 98	145	0	352072.00	30.00	0.00	500.00	351542.00
Item 91	234	0	819145.61	39.00	0.00	510.00	818596.61
Item 90	591	0	374152.00	30.00	0.00	500.00	373622.00
Item 147	67	0	393891.77	30.00	0.00	500.00	393361.77
Item 104	92	0	826544.53	37.00	0.00	575.00	825932.53
Item 43	218	0	833687.67	34.00	0.00	565.00	833088.67
Item 16	228	0	843539.88	34.00	0.00	555.00	842950.88
Item 130	131	0	399832.11	30.00	0.00	500.00	399302.11
Item 131	130	0	851588.50	34.00	0.00	555.00	850999.50
Item 45	190	0	409461.92	30.00	0.00	500.00	408931.92
work order	1	0	0.00	0.00	0.00	0.00	0.00

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
Item 79	0.01	0.00	0.18	99.81
Item 106	0.07	0.00	1.36	98.57
Item 150	0.01	0.00	0.13	99.86
Item 60	0.01	0.00	0.09	99.90
Item 18	0.01	0.00	0.10	99.89
Item 72	0.02	0.00	0.46	99.52
Item 38	0.02	0.00	0.25	99.73
Item 97	0.01	0.00	0.27	99.72
Item 48	0.01	0.00	0.10	99.89
Item 81	0.00	0.00	0.10	99.90
Item 128	0.00	0.00	0.09	99.90
Item 51	0.00	0.00	0.07	99.93
Item 28	0.01	0.00	0.28	99.71
Item 93	0.01	0.00	0.28	99.70
Item 6	0.01	0.00	0.08	99.92
Item 126	0.01	0.00	0.24	99.75
Item 50	0.01	0.00	0.23	99.76
Item 73	0.01	0.00	0.15	99.84
Item 98	0.01	0.00	0.14	99.85
Item 91	0.00	0.00	0.06	99.93

Item 90	0.01	0.00	0.13	99.86
Item 147	0.01	0.00	0.13	99.87
Item 104	0.00	0.00	0.07	99.93
Item 43	0.00	0.00	0.07	99.93
Item 16	0.00	0.00	0.07	99.93
Item 130	0.01	0.00	0.13	99.87
Item 131	0.00	0.00	0.07	99.93
Item 45	0.01	0.00	0.12	99.87
work order	-	-	-	-

# **LAMPIRAN 4**

## **SKENARIO 3**

- **INPUT SIMULASI USULAN**
- **OUTPUT SIMULASI USULAN**

## • Input Promodel (Skenario 3)

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Time Units:           Minutes
Distance Units:      Feet
Initialization Logic: DYNPLOT "WIPFinalSet"

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* Locations
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Name	Cap	Units	Stats	Rules	Cost
Gudang	inf	1		Time Series Oldest, , First	
Reeling	1	4		Time Series Oldest, , First	
Reeling.1	1	1		Time Series Oldest, ,	
Reeling.2	1	1		Time Series Oldest, ,	
Reeling.3	1	1		Time Series Oldest, ,	
Reeling.4	1	1		Time Series Oldest, ,	
Relaxing_A	1	6		Time Series Oldest, , First	
Relaxing_A.1	1	1		Time Series Oldest, ,	
Relaxing_A.2	1	1		Time Series Oldest, ,	
Relaxing_A.3	1	1		Time Series Oldest, ,	
Relaxing_A.4	1	1		Time Series Oldest, ,	
Relaxing_A.5	1	1		Time Series Oldest, ,	
Relaxing_A.6	1	1		Time Series Oldest, ,	
Relaxing_B	1	4		Time Series Oldest, , First	
Relaxing_B.1	1	1		Time Series Oldest, ,	
Relaxing_B.2	1	1		Time Series Oldest, ,	
Relaxing_B.3	1	1		Time Series Oldest, ,	
Relaxing_B.4	1	1		Time Series Oldest, ,	
Hydro	1	3		Time Series Oldest, , First	
Hydro.1	1	1		Time Series Oldest, ,	
Hydro.2	1	1		Time Series Oldest, ,	
Hydro.3	1	1		Time Series Oldest, ,	
Sofcer	1	1		Time Series Oldest, ,	
Unroll	1	3		Time Series Oldest, , First	
Unroll.1	1	1		Time Series Oldest, ,	
Unroll.2	1	1		Time Series Oldest, ,	
Unroll.3	1	1		Time Series Oldest, ,	
Pre_Washing_Drying	1	1		Time Series Oldest, ,	
Preset	1	2		Time Series Oldest, , First	
Preset.1	1	1		Time Series Oldest, ,	
Preset.2	1	1		Time Series Oldest, ,	
Hisaka_WR	1	3		Time Series Oldest, , First	
Hisaka_WR.1	1	1		Time Series Oldest, ,	
Hisaka_WR.2	1	1		Time Series Oldest, ,	
Hisaka_WR.3	1	1		Time Series Oldest, ,	
ST_Tank	1	4		Time Series Oldest, , First	
ST_Tank.1	1	1		Time Series Oldest, ,	
ST_Tank.2	1	1		Time Series Oldest, ,	
ST_Tank.3	1	1		Time Series Oldest, ,	
ST_Tank.4	1	1		Time Series Oldest, ,	
Dyeing_Colour	1	7		Time Series Oldest, , First	
Dyeing_Colour.1	1	1		Time Series Oldest, ,	
Dyeing_Colour.2	1	1		Time Series Oldest, ,	
Dyeing_Colour.3	1	1		Time Series Oldest, ,	
Dyeing_Colour.4	1	1		Time Series Oldest, ,	
Dyeing_Colour.5	1	1		Time Series Oldest, ,	
Dyeing_Colour.6	1	1		Time Series Oldest, ,	
Dyeing_Colour.7	1	1		Time Series Oldest, ,	
FWD	1	2		Time Series Oldest, , First	
FWD.1	1	1		Time Series Oldest, ,	
FWD.2	1	1		Time Series Oldest, ,	
Final_Set	1	2		Time Series Oldest, , First	
Final_Set.1	1	1		Time Series Oldest, ,	
Final_Set.2	1	1		Time Series Oldest, ,	
Heat_Cut	1	2		Time Series Oldest, , First	
Heat_Cut.1	1	1		Time Series Oldest, ,	
Heat_Cut.2	1	1		Time Series Oldest, ,	
Folding	1	3		Time Series Oldest, , First	
Folding.1	1	1		Time Series Oldest, ,	
Folding.2	1	1		Time Series Oldest, ,	
Folding.3	1	1		Time Series Oldest, ,	
Sablon	1	3		Time Series Oldest, , First	
Sablon.1	1	1		Time Series Oldest, ,	
Sablon.2	1	1		Time Series Oldest, ,	
Sablon.3	1	1		Time Series Oldest, ,	
WIP_Reeling	21	1		Time Series Oldest, , First	
WIP_Relaxing_A	6	1		Time Series Oldest, , First	
WIP_Relaxing_B	14	1		Time Series Oldest, , First	
WIP_Hydro	7	1		Time Series Oldest, , First	
WIP_Sofcer	6	1		Time Series Oldest, , First	
WIP_Unroll	3	1		Time Series Oldest, , First	
WIP_Pre_Washing_Drying	4	1		Time Series Oldest, , First	
WIP_Preset	8	1		Time Series Oldest, , First	
WIP_Hisaka_WR	6	1		Time Series Oldest, , First	
WIP_ST_Tank	8	1		Time Series Oldest, , First	
WIP_Dyeing_Colour	7	1		Time Series Oldest, , First	
WIP_FWD	18	1		Time Series Oldest, , First	
WIP_Final_Set	24	1		Time Series Oldest, , First	
WIP_Heat_Cut	4	1		Time Series Oldest, , First	
WIP_Folding	3	1		Time Series Oldest, , First	
Dyeing_Black	1	5		Time Series Oldest, , First	
Dyeing_Black.1	1	1		Time Series Oldest, ,	
Dyeing_Black.2	1	1		Time Series Oldest, ,	
Dyeing_Black.3	1	1		Time Series Oldest, ,	
Dyeing_Black.4	1	1		Time Series Oldest, ,	
Dyeing_Black.5	1	1		Time Series Oldest, ,	
WIP_Sablon	6	1		Time Series Oldest, , First	
WIP_Dyeing_Black	5	1		Time Series Oldest, , First	



Item_106	Preset	WAIT U(45, 0)	1	Item_106	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
ALL	WIP_Hisaka_WR		1	Item_106	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_106	Hisaka_WR	WAIT U(120, 0)	1	ALL	Hisaka WR	FIRST 1		
Item_106	Dyeing_Colour	WAIT U(150, 0)	1	Item_106	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_106	FWD	WAIT U(40, 0)	1	Item_106	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_106	Final_Set	WAIT U(35, 0)	1	Item_106	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_150	Persiapan2		1	Item_106	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_150	Relaxing_B	WAIT U(120, 0)	1	Item_150	WIP_Relaxing_B	FIRST 1		
Item_150	Unroll	WAIT U(25, 0)	1	Item_150	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_150	Preset	WAIT U(45, 0)	1	Item_150	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_150	Hisaka_WR	WAIT U(120, 0)	1	Item_150	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_150	Dyeing_Colour	WAIT U(150, 0)	1	Item_150	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_150	FWD	WAIT U(40, 0)	1	Item_150	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_150	Final_Set	WAIT U(35, 0)	1	Item_150	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
ALL	WIP_Heat_Cut		1	Item_150	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_150	Heat_Cut	WAIT U(20, 0)	1	ALL	Heat Cut	FIRST 1		
ALL	WIP_Folding		1	Item_150	WIP_Folding	FIRST 1	MOVE FOR	3 MIN
Item_150	Folding	WAIT U(45, 0)	1	ALL	Folding	FIRST 1		
ALL	WIP_Sablon		1	Item_150	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_150	Sablon	WAIT U(50, 0)	1	ALL	Sablon	FIRST 1		
Item_60	Persiapan2		1	Item_150	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_60	Relaxing_B	WAIT U(120, 0)	1	Item_60	WIP_Relaxing_B	FIRST 1		
Item_60	Unroll	WAIT U(25, 0)	1	Item_60	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_60	Preset	WAIT U(45, 0)	1	Item_60	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_60	Hisaka_WR	WAIT U(120, 0)	1	Item_60	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_60	Dyeing_Colour	WAIT U(150, 0)	1	Item_60	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_60	FWD	WAIT U(40, 0)	1	Item_60	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_60	Final_Set	WAIT U(35, 0)	1	Item_60	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_18	Persiapan2		1	Item_60	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_18	Relaxing_B	WAIT U(120, 0)	1	Item_18	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_18	Unroll	WAIT U(25, 0)	1	Item_18	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_18	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_18	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_18	Preset	WAIT U(45, 0)	1	Item_18	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_18	Hisaka_WR	WAIT U(120, 0)	1	Item_18	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
ALL	WIP_Dyeing_Black		1	Item_18	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_18	Dyeing_Black	WAIT U(150, 0)	1	ALL	Dyeing Black	FIRST 1		
Item_18	FWD	WAIT U(40, 0)	1	Item_18	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_18	Final_Set	WAIT U(35, 0)	1	Item_18	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_18	Heat_Cut	WAIT U(20, 0)	1	Item_18	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_18	Sablon	WAIT U(50, 0)	1	Item_18	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_72	Persiapan1		1	Item_18	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_72	Reeling	WAIT U(25, 0)	1	Item_72	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_72	Relaxing_A	WAIT U(120, 0)	1	Item_72	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_72	Hydro	WAIT U(35, 0)	1	Item_72	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_72	Unroll	WAIT U(25, 0)	1	Item_72	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_72	Preset	WAIT U(45, 0)	1	Item_72	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_72	Hisaka_WR	WAIT U(120, 0)	1	Item_72	WIP_Hisaka WR	FIRST 1	MOVE FOR	5 MIN
Item_72	Dyeing_Colour	WAIT U(150, 0)	1	Item_72	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_72	FWD	WAIT U(40, 0)	1	Item_72	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_72	Final_Set	WAIT U(35, 0)	1	Item_72	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_38	Persiapan1		1	Item_72	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_38	Reeling	WAIT U(25, 0)	1	Item_38	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_38	Relaxing_A	WAIT U(120, 0)	1	Item_38	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_38	Hydro	WAIT U(35, 0)	1	Item_38	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_38	Unroll	WAIT U(25, 0)	1	Item_38	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_38	Preset	WAIT U(45, 0)	1	Item_38	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_38	ST_Tank	WAIT U(25, 0)	1	Item_38	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_38	Dyeing_Colour	WAIT U(150, 0)	1	Item_38	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_38	FWD	WAIT U(40, 0)	1	Item_38	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_38	Final_Set	WAIT U(35, 0)	1	Item_38	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_97	Persiapan1		1	Item_38	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_97	Reeling	WAIT U(25, 0)	1	Item_97	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_97	Relaxing_A	WAIT U(120, 0)	1	Item_97	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_97	Hydro	WAIT U(35, 0)	1	Item_97	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_97	Unroll	WAIT U(25, 0)	1	Item_97	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_97	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_97	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN

Item_97	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_97	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_97	Preset	WAIT U(45, 0)	1	Item_97	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_97	Hisaka_WR	WAIT U(120, 0)	1	Item_97	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_97	Dyeing_Colour	WAIT U(150, 0)	1	Item_97	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_97	FWD	WAIT U(40, 0)	1	Item_97	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_97	Final_Set	WAIT U(35, 0)	1	Item_97	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_48	Persiapan2	WAIT U(120, 0)	1	Item_48	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_48	Relaxing_B	WAIT U(120, 0)	1	Item_48	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_48	Unroll	WAIT U(25, 0)	1	Item_48	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_48	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_48	WIP_Preset	FIRST 1	MOVE FOR 5 MIN
Item_48	Preset	WAIT U(45, 0)	1	Item_48	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_48	Hisaka_WR	WAIT U(120, 0)	1	Item_48	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_48	Dyeing_Black	WAIT U(150, 0)	1	Item_48	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_48	FWD	WAIT U(40, 0)	1	Item_48	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_48	Final_Set	WAIT U(140, 0)	1	Item_48	WIP_Sablon	FIRST 1	MOVE FOR 5 MIN
Item_48	Sablon	WAIT U(50, 0)	1	Item_48	EXIT	FIRST 1	MOVE FOR 5 MIN
Item_81	Persiapan2	WAIT U(120, 0)	1	Item_81	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_81	Relaxing_B	WAIT U(120, 0)	1	Item_81	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_81	Unroll	WAIT U(25, 0)	1	Item_81	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_81	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_81	WIP_Preset	FIRST 1	MOVE FOR 5 MIN
Item_81	Preset	WAIT U(45, 0)	1	Item_81	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_81	Hisaka_WR	WAIT U(120, 0)	1	Item_81	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_81	Dyeing_Black	WAIT U(150, 0)	1	Item_81	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_81	FWD	WAIT U(40, 0)	1	Item_81	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_81	Final_Set	WAIT U(140, 0)	1	Item_81	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_128	Persiapan1	WAIT U(120, 0)	1	Item_128	WIP_Reeling	FIRST 1	MOVE FOR 5 MIN
Item_128	Reeling	WAIT U(25, 0)	1	Item_128	WIP_Relaxing_A	FIRST 1	MOVE FOR 2 MIN
Item_128	Relaxing_A	WAIT U(120, 0)	1	Item_128	WIP_Hydro	FIRST 1	MOVE FOR 2 MIN
Item_128	Hydro	WAIT U(35, 0)	1	Item_128	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_128	Unroll	WAIT U(25, 0)	1	Item_128	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_128	Preset	WAIT U(45, 0)	1	Item_128	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_128	Hisaka_WR	WAIT U(120, 0)	1	Item_128	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_128	Dyeing_Black	WAIT U(150, 0)	1	Item_128	WIP_Final_Set	FIRST 1	MOVE FOR 5 MIN
Item_128	Final_Set	WAIT U(140, 0)	1	Item_128	WIP_Heat_Cut	FIRST 1	MOVE FOR 2 MIN
Item_128	Heat_Cut	WAIT U(20, 0)	1	Item_128	WIP_Sablon	FIRST 1	MOVE FOR 4 MIN
Item_128	Sablon	WAIT U(50, 0)	1	Item_128	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_51	Persiapan2	WAIT U(120, 0)	1	Item_51	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_51	Relaxing_B	WAIT U(120, 0)	1	Item_51	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_51	Unroll	WAIT U(25, 0)	1	Item_51	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_51	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_51	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_51	Preset	WAIT U(45, 0)	1	Item_51	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_51	Hisaka_WR	WAIT U(120, 0)	1	Item_51	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_51	Dyeing_Colour	WAIT U(150, 0)	1	Item_51	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_51	FWD	WAIT U(40, 0)	1	Item_51	WIP_Final_Set	FIRST 1	MOVE FOR 5 MIN
Item_51	Final_Set	WAIT U(35, 0)	1	Item_51	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_28	Persiapan2	WAIT U(120, 0)	1	Item_28	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_28	Relaxing_B	WAIT U(120, 0)	1	Item_28	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_28	Sofcer	WAIT U(20, 0)	1	Item_28	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_28	Unroll	WAIT U(25, 0)	1	Item_28	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_28	Preset	WAIT U(45, 0)	1	Item_28	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_28	Hisaka_WR	WAIT U(120, 0)	1	Item_28	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_28	Dyeing_Colour	WAIT U(150, 0)	1	Item_28	WIP_Final_Set	FIRST 1	MOVE FOR 3 MIN
Item_28	Final_Set	WAIT U(120, 0)	1	Item_28	EXIT	FIRST 1	MOVE FOR 5 MIN
Item_93	Persiapan1	WAIT U(120, 0)	1	Item_93	WIP_Reeling	FIRST 1	MOVE FOR 3 MIN
Item_93	Reeling	WAIT U(25, 0)	1	Item_93	Relaxing_A	FIRST 1	MOVE FOR 2 MIN
Item_93	Relaxing_A	WAIT U(120, 0)	1	Item_93	WIP_Hydro	FIRST 1	MOVE FOR 2 MIN
Item_93	Hydro	WAIT U(35, 0)	1	Item_93	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_93	Unroll	WAIT U(25, 0)	1	Item_93	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_93	Preset	WAIT U(45, 0)	1	Item_93	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_93	Hisaka_WR	WAIT U(120, 0)	1	Item_93	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_93	Dyeing_Black	WAIT U(150, 0)	1	Item_93	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_93	FWD	WAIT U(40, 0)	1	Item_93	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_93	Final_Set	WAIT U(120, 0)	1	Item_93	WIP_Heat_Cut	FIRST 1	MOVE FOR 5 MIN
Item_93	Heat_Cut	WAIT U(20, 0)	1	Item_93	WIP_Sablon	FIRST 1	MOVE FOR 2 MIN
Item_93	Sablon	WAIT U(50, 0)	1	Item_93	EXIT	FIRST 1	MOVE FOR 5 MIN
Item_6	Persiapan2	WAIT U(120, 0)	1	Item_6	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_6	Relaxing_B	WAIT U(120, 0)	1				

Item_6	Sofcer	WAIT U(20, 0)	1	Item_6	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_6	Unroll	WAIT U(25, 0)	1	Item_6	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_6	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_6	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_6	Preset	WAIT U(45, 0)	1	Item_6	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_6	ST_Tank	WAIT U(25, 0)	1	Item_6	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_6	Dyeing_Black	WAIT U(150, 0)	1	Item_6	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_6	FWD	WAIT U(40, 0)	1	Item_6	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_6	Final_Set	WAIT U(120, 0)	1	Item_6	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_6	Sablon	WAIT U(50, 0)	1	Item_6	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_126	Persiapan2	WAIT U(50, 0)	1	Item_126	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_126	Relaxing_B	WAIT U(120, 0)	1	Item_126	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_126	Sofcer	WAIT U(20, 0)	1	Item_126	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_126	Unroll	WAIT U(25, 0)	1	Item_126	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_126	Preset	WAIT U(45, 0)	1	Item_126	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_126	ST_Tank	WAIT U(25, 0)	1	Item_126	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_126	Dyeing_Colour	WAIT U(150, 0)	1	Item_126	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_126	FWD	WAIT U(40, 0)	1	Item_126	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_126	Final_Set	WAIT U(120, 0)	1	Item_126	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_50	Persiapan1	WAIT U(35, 0)	1	Item_50	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_50	Reeling	WAIT U(25, 0)	1	Item_50	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_50	Relaxing_A	WAIT U(120, 0)	1	Item_50	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_50	Hydro	WAIT U(35, 0)	1	Item_50	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_50	Unroll	WAIT U(25, 0)	1	Item_50	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_50	Preset	WAIT U(45, 0)	1	Item_50	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_50	ST_Tank	WAIT U(25, 0)	1	Item_50	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_50	Dyeing_Colour	WAIT U(150, 0)	1	Item_50	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_50	FWD	WAIT U(40, 0)	1	Item_50	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_50	Final_Set	WAIT U(120, 0)	1	Item_50	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_73	Persiapan1	WAIT U(35, 0)	1	Item_73	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_73	Reeling	WAIT U(25, 0)	1	Item_73	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_73	Relaxing_A	WAIT U(120, 0)	1	Item_73	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_73	Hydro	WAIT U(35, 0)	1	Item_73	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_73	Unroll	WAIT U(25, 0)	1	Item_73	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_73	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_73	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_73	Preset	WAIT U(45, 0)	1	Item_73	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_73	Hisaka_WR	WAIT U(120, 0)	1	Item_73	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_73	Dyeing_Colour	WAIT U(150, 0)	1	Item_73	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_73	FWD	WAIT U(40, 0)	1	Item_73	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_73	Final_Set	WAIT U(120, 0)	1	Item_73	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_73	WIP_Sablon	WAIT U(35, 0)	1	Item_73	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_98	Sablon	WAIT U(50, 0)	1	Item_98	Sablon	FIRST 1	MOVE FOR	10 MIN
Item_98	Persiapan1	WAIT U(25, 0)	1	Item_98	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_98	Reeling	WAIT U(25, 0)	1	Item_98	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_98	Relaxing_A	WAIT U(120, 0)	1	Item_98	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_98	Hydro	WAIT U(35, 0)	1	Item_98	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_98	Unroll	WAIT U(25, 0)	1	Item_98	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_98	Preset	WAIT U(45, 0)	1	Item_98	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_98	ST_Tank	WAIT U(25, 0)	1	Item_98	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_98	Dyeing_Colour	WAIT U(150, 0)	1	Item_98	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_98	FWD	WAIT U(40, 0)	1	Item_98	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_98	Final_Set	WAIT U(120, 0)	1	Item_98	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_91	Persiapan1	WAIT U(35, 0)	1	Item_91	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_91	Reeling	WAIT U(25, 0)	1	Item_91	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_91	Relaxing_A	WAIT U(120, 0)	1	Item_91	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_91	Hydro	WAIT U(35, 0)	1	Item_91	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_91	Unroll	WAIT U(25, 0)	1	Item_91	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_91	Preset	WAIT U(45, 0)	1	Item_91	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_91	ST_Tank	WAIT U(25, 0)	1	Item_91	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_91	Dyeing_Colour	WAIT U(150, 0)	1	Item_91	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_91	FWD	WAIT U(40, 0)	1	Item_91	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_91	FWD	WAIT U(40, 0)	1	Item_91	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN



Item_91	Final_Set	WAIT U(35, 0)	1	Item_91	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_90	Persiapan1		1	Item_90	WIP_Reeling	FIRST 1	MOVE FOR 3 MIN
Item_90	WIP_Reeling		1	Item_90	Reeling	FIRST 1	
Item_90	Relaxing_A	WAIT U(25, 0)	1	Item_90	WIP_Relaxing_A	FIRST 1	MOVE FOR 2 MIN
Item_90	Hydro	WAIT U(120, 0)	1	Item_90	WIP_Hydro	FIRST 1	MOVE FOR 2 MIN
Item_90	Unroll	WAIT U(25, 0)	1	Item_90	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_90	Preset	WAIT U(45, 0)	1	Item_90	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_90	ST_Tank	WAIT U(25, 0)	1	Item_90	WIP_ST_Tank	FIRST 1	MOVE FOR 5 MIN
Item_90	Dyeing_Colour	WAIT U(150, 0)	1	Item_90	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_90	FWD	WAIT U(40, 0)	1	Item_90	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_90	Final_Set	WAIT U(40, 0)	1	Item_90	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_147	Persiapan2	WAIT U(35, 0)	1	Item_90	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_147	Relaxing_B	WAIT U(120, 0)	1	Item_147	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_147	Sofcer	WAIT U(20, 0)	1	Item_147	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_147	Unroll	WAIT U(25, 0)	1	Item_147	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_147	Preset	WAIT U(45, 0)	1	Item_147	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_147	ST_Tank	WAIT U(25, 0)	1	Item_147	WIP_ST_Tank	FIRST 1	MOVE FOR 5 MIN
Item_147	Dyeing_Black	WAIT U(150, 0)	1	Item_147	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_147	FWD	WAIT U(40, 0)	1	Item_147	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_147	Final_Set	WAIT U(40, 0)	1	Item_147	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_147	Sablon	WAIT U(35, 0)	1	Item_147	WIP_Sablon	FIRST 1	MOVE FOR 5 MIN
Item_104	Persiapan2		1	Item_147	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_104	Relaxing_B	WAIT U(120, 0)	1	Item_104	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_104	Sofcer	WAIT U(20, 0)	1	Item_104	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_104	Unroll	WAIT U(25, 0)	1	Item_104	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_104	Preset	WAIT U(45, 0)	1	Item_104	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_104	Hisaka_WR	WAIT U(120, 0)	1	Item_104	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_104	Dyeing_Colour	WAIT U(150, 0)	1	Item_104	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_104	FWD	WAIT U(40, 0)	1	Item_104	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_104	Final_Set	WAIT U(40, 0)	1	Item_104	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_43	Persiapan1	WAIT U(120, 0)	1	Item_104	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_43	Reeling	WAIT U(25, 0)	1	Item_43	WIP_Reeling	FIRST 1	MOVE FOR 3 MIN
Item_43	Relaxing_A	WAIT U(120, 0)	1	Item_43	WIP_Relaxing_A	FIRST 1	MOVE FOR 2 MIN
Item_43	Hydro	WAIT U(35, 0)	1	Item_43	WIP_Hydro	FIRST 1	MOVE FOR 2 MIN
Item_43	Unroll	WAIT U(25, 0)	1	Item_43	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_43	Preset	WAIT U(45, 0)	1	Item_43	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_43	Hisaka_WR	WAIT U(120, 0)	1	Item_43	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_43	Dyeing_Black	WAIT U(150, 0)	1	Item_43	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_43	FWD	WAIT U(40, 0)	1	Item_43	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_43	Final_Set	WAIT U(140, 0)	1	Item_43	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_43	Sablon	WAIT U(50, 0)	1	Item_43	WIP_Sablon	FIRST 1	MOVE FOR 5 MIN
Item_16	Persiapan2	WAIT U(35, 0)	1	Item_43	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_16	Relaxing_B	WAIT U(120, 0)	1	Item_16	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_16	Sofcer	WAIT U(20, 0)	1	Item_16	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_16	Unroll	WAIT U(25, 0)	1	Item_16	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_16	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_16	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR 2 MIN
Item_16	Preset	WAIT U(45, 0)	1	Item_16	WIP_Preset	FIRST 1	MOVE FOR 2 MIN
Item_16	ST_Tank	WAIT U(25, 0)	1	Item_16	WIP_ST_Tank	FIRST 1	MOVE FOR 5 MIN
Item_16	Dyeing_Colour	WAIT U(150, 0)	1	Item_16	WIP_Dyeing_Colour	FIRST 1	MOVE FOR 5 MIN
Item_16	FWD	WAIT U(40, 0)	1	Item_16	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_16	Final_Set	WAIT U(40, 0)	1	Item_16	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_130	Persiapan2	WAIT U(35, 0)	1	Item_16	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_130	Relaxing_B	WAIT U(120, 0)	1	Item_130	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_130	Sofcer	WAIT U(20, 0)	1	Item_130	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_130	Unroll	WAIT U(25, 0)	1	Item_130	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN
Item_130	Preset	WAIT U(45, 0)	1	Item_130	WIP_Preset	FIRST 1	MOVE FOR 6 MIN
Item_130	Hisaka_WR	WAIT U(120, 0)	1	Item_130	WIP_Hisaka_WR	FIRST 1	MOVE FOR 5 MIN
Item_130	Dyeing_Black	WAIT U(150, 0)	1	Item_130	WIP_Dyeing_Black	FIRST 1	MOVE FOR 5 MIN
Item_130	FWD	WAIT U(40, 0)	1	Item_130	WIP_FWD	FIRST 1	MOVE FOR 5 MIN
Item_130	Final_Set	WAIT U(40, 0)	1	Item_130	WIP_Final_Set	FIRST 1	MOVE FOR 4 MIN
Item_130	Persiapan2	WAIT U(35, 0)	1	Item_130	EXIT	FIRST 1	MOVE FOR 10 MIN
Item_131	Relaxing_B	WAIT U(120, 0)	1	Item_131	WIP_Relaxing_B	FIRST 1	MOVE FOR 5 MIN
Item_131	Sofcer	WAIT U(20, 0)	1	Item_131	WIP_Sofcer	FIRST 1	MOVE FOR 2 MIN
Item_131	Unroll	WAIT U(25, 0)	1	Item_131	WIP_Unroll	FIRST 1	MOVE FOR 2 MIN

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Item_131  Preset                WAIT U(45, 0)                1  Item_131  WIP_Preset                FIRST 1  MOVE FOR 6 MIN

Item_131  Hisaka_WR             WAIT U(120, 0)              1  Item_131  WIP_Hisaka_WR                FIRST 1  MOVE FOR 5 MIN
Item_131  Dyeing_Black              WAIT U(150, 0)              1  Item_131  WIP_Dyeing_Black            FIRST 1  MOVE FOR 5 MIN
Item_131  FWD                          WAIT U(40, 0)                1  Item_131  WIP_FWD                      FIRST 1  MOVE FOR 5 MIN
Item_131  Final_Set                    WAIT U(40, 0)                1  Item_131  WIP_Final_Set                FIRST 1  MOVE FOR 4 MIN
Item_45   Persiapan1                  WAIT U(35, 0)                1  Item_45   EXIT                          FIRST 1  MOVE FOR 10 MIN
Item_45   Reeling                      WAIT U(25, 0)                1  Item_45   WIP_Reeling                   FIRST 1  MOVE FOR 3 MIN

Item_45   Relaxing_A                  WAIT U(120, 0)              1  Item_45   WIP_Relaxing_A                FIRST 1  MOVE FOR 2 MIN

Item_45   Hydro                        WAIT U(35, 0)                1  Item_45   WIP_Hydro                     FIRST 1  MOVE FOR 2 MIN

Item_45   Unroll                       WAIT U(25, 0)                1  Item_45   WIP_Unroll                    FIRST 1  MOVE FOR 2 MIN

Item_45   Preset                       WAIT U(45, 0)                1  Item_45   WIP_Preset                    FIRST 1  MOVE FOR 2 MIN

Item_45   ST_Tank                      WAIT U(25, 0)                1  Item_45   WIP_ST_Tank                   FIRST 1  MOVE FOR 5 MIN
Item_45   Dyeing_Black                WAIT U(150, 0)              1  Item_45   WIP_Dyeing_Black            FIRST 1  MOVE FOR 5 MIN
Item_45   FWD                          WAIT U(40, 0)                1  Item_45   WIP_FWD                      FIRST 1  MOVE FOR 5 MIN
Item_45   Final_Set                    WAIT U(40, 0)                1  Item_45   WIP_Final_Set                FIRST 1  MOVE FOR 4 MIN
work_order Gudang                1  work_order Persiapan1          FIRST 1
work_order Persiapan1            1  work_order EXIT                FIRST 1

```

```

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

```

```

Entity      Location Qty each  First Time Occurrences Frequency  Logic
-----
work_order  Gudang      1                1

```

Kategori Item=2  
 ORDER 3401 Item\_79  
 ORDER 1828 Item\_150  
 ORDER 1381 Item\_60  
 ORDER 1557 Item\_18  
 ORDER 377 Item\_48  
 ORDER 501 Item\_81  
 ORDER 450 Item\_51  
 ORDER 112 Item\_28  
 ORDER 412 Item\_6  
 ORDER 284 Item\_126  
 ORDER 67 Item\_147  
 ORDER 92 Item\_104  
 ORDER 228 Item\_16  
 ORDER 131 Item\_130  
 ORDER 130 Item\_131

Kategori Item=1  
 ORDER 1531 Item\_106  
 ORDER 1277 Item\_72  
 ORDER 917 Item\_38  
 ORDER 439 Item\_97  
 ORDER 1248 Item\_128  
 ORDER 290 Item\_93

ORDER 726 Item\_50  
 ORDER 212 Item\_73  
 ORDER 145 Item\_98  
 ORDER 234 Item\_91  
 ORDER 591 Item\_90

ORDER 218 Item\_43  
 ORDER 190 Item\_45

```

*****
*                               Attributes                               *
*****

```

```

ID          Type          Classification
-----
Kategori_Item Integer      Entity

```

```

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

```

```

ID          Type          Initial value Stats
-----
jumlah_buffer Real          0              Time Series
Status_Send1 Integer        1              Time Series
Status_Send2 Integer        0              Time Series
wipFS       Integer        0              Time Series

```

```

*****
*                               Macros                                   *
*****

```

```

ID          Text
-----
buf_final_set 16

```

## ● Output Promodel (Skenario 3)

General Report

Output from D:\Maranatha\Kuliah\TA\Laporan\Promodel\Usulan\Modiff all kond awal WIP asli.MOD

Date: Jan/15/2013 Time: 10:25:03 PM

Scenario : Normal Run

Replication : 1 of 1

Simulation Time : 12683.48

### LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Minutes Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
Gudang	12683.48	999999	18970	360441.02	8984.87	18922	0	0.90
Reeling.1	12683.48	1	2003	201.15	0.52	1	0	52.95
Reeling.2	12683.48	1	2003	201.16	0.52	1	0	52.95
Reeling.3	12683.48	1	2007	200.80	0.52	1	0	52.96
Reeling.4	12683.48	1	2005	200.98	0.52	1	0	52.95
Reeling	50733.93	4	8018	201.02	0.52	4	0	52.95
Relaxing A.1	12683.48	1	1337	301.57	0.52	1	0	52.98
Relaxing A.2	12683.48	1	1337	301.60	0.52	1	0	52.99
Relaxing A.3	12683.48	1	1336	301.71	0.52	1	0	52.97
Relaxing A.4	12683.48	1	1336	301.72	0.52	1	0	52.97
Relaxing A.5	12683.48	1	1336	301.74	0.52	1	0	52.97
Relaxing A.6	12683.48	1	1336	301.76	0.52	1	0	52.98
Relaxing A	76100.9	6	8018	301.68	0.52	6	0	52.98
Relaxing B.1	12683.48	1	2738	277.36	0.99	1	0	99.79
Relaxing B.2	12683.48	1	2738	277.37	0.99	1	0	99.80
Relaxing B.3	12683.48	1	2737	277.45	0.99	1	0	99.79
Relaxing B.4	12683.48	1	2738	277.39	0.99	1	0	99.80
Relaxing B	50733.93	4	10951	277.39	0.99	4	0	99.79
Hydro.1	12683.48	1	2673	150.93	0.53	1	0	53.01
Hydro.2	12683.48	1	2673	150.93	0.53	1	0	53.02
Hydro.3	12683.48	1	2672	150.97	0.53	1	0	53.01
Hydro	38050.45	3	8018	150.94	0.53	3	0	53.01
Sofcer	12683.48	1	4857	100.83	0.64	1	0	64.36
Unroll.1	12683.48	1	6443	117.35	0.99	1	0	99.36
Unroll.2	12683.48	1	6310	119.25	0.98	1	0	98.88
Unroll.3	12683.48	1	6216	120.65	0.98	1	0	98.55
Unroll	38050.45	3	18969	119.06	0.98	3	0	98.93
Pre Washing Drying	12683.48	1	9108	66.46	0.79	1	0	79.54
Preset.1	12683.48	1	9487	73.13	0.91	1	0	91.17
Preset.2	12683.48	1	9482	73.16	0.91	1	0	91.16
Preset	25366.96	2	18969	73.14	0.91	2	0	91.16
Hisaka WR.1	12683.48	1	3928	140.66	0.72	1	0	72.61
Hisaka WR.2	12683.48	1	3926	140.72	0.72	1	0	72.60
Hisaka WR.3	12683.48	1	3920	140.65	0.72	1	0	72.45
Hisaka WR	38050.45	3	11774	140.68	0.72	3	0	72.55
ST Tank.1	12683.48	1	4499	42.04	0.24	1	0	24.86
ST Tank.2	12683.48	1	1781	67.52	0.15	1	0	15.80
ST Tank.3	12683.48	1	459	189.25	0.11	1	0	11.41
ST Tank.4	12683.48	1	456	190.05	0.11	1	0	11.39
ST Tank	50733.93	4	7195	67.12	0.15	4	0	15.87
Dyeing Colour.1	12683.48	1	3177	165.80	0.69	1	0	69.22
Dyeing Colour.2	12683.48	1	2859	166.93	0.62	1	0	62.71
Dyeing Colour.3	12683.48	1	2726	165.88	0.59	1	0	59.42
Dyeing Colour.4	12683.48	1	2668	164.15	0.57	1	0	57.55
Dyeing Colour.5	12683.48	1	967	187.93	0.23	1	0	23.88
Dyeing Colour.6	12683.48	1	876	192.11	0.22	1	0	22.11
Dyeing Colour.7	12683.48	1	575	214.32	0.16	1	0	16.19
Dyeing Colour	88784.38	7	13848	170.95	0.44	7	0	44.44
FWD.1	12683.48	1	10866	55.64	0.79	1	0	79.45
FWD.2	12683.48	1	6743	61.96	0.54	1	0	54.91
FWD	25366.96	2	17609	58.06	0.67	2	0	67.18
Final Set.1	12683.48	1	11458	51.80	0.77	1	0	77.99
Final Set.2	12683.48	1	7511	60.60	0.59	1	0	59.82
Final Set	25366.96	2	18969	55.28	0.68	2	0	68.91
Heat Cut.1	12683.48	1	4814	20.00	0.12	1	0	12.65
Heat Cut.2	12683.48	1	109	20.00	0.00	1	0	0.29
Heat Cut	25366.96	2	4923	20.00	0.06	2	0	6.47
Folding.1	12683.48	1	1219	45.00	0.07	1	0	7.21
Folding.2	12683.48	1	609	45.00	0.03	1	0	3.60
Folding.3	12683.48	1	0	0.00	0	0	0	0.00
Folding	38050.45	3	1828	45.00	0.03	2	0	3.60
Sablon.1	12683.48	1	3565	49.06	0.22	1	0	22.98
Sablon.2	12683.48	1	2618	50.00	0.17	1	0	17.20
Sablon.3	12683.48	1	26	50.00	0.00	1	0	0.17
Sablon	38050.45	3	6209	49.46	0.13	3	0	13.45
WIP Reeling	12683.48	21	8018	1051.66	11.08	21	0	52.76
WIP Relaxing A	12683.48	6	7728	296.34	3.00	6	0	50.16
WIP Relaxing B	12683.48	14	10951	968.44	13.93	14	0	99.54
WIP Hydro	12683.48	7	8018	349.83	3.68	7	0	52.65
WIP Sofcer	12683.48	6	4857	591.72	3.77	6	0	62.94
WIP Unroll	12683.48	3	18969	116.30	2.89	3	0	96.63
WIP Pre Washing Drying	12683.48	4	9108	263.26	3.15	4	0	78.77
WIP Preset	12683.48	8	18969	249.48	6.21	8	0	77.73
WIP Hisaka WR	12683.48	6	11774	232.27	3.59	6	0	59.89
WIP ST Tank	12683.48	8	7195	91.48	0.86	8	0	10.81

WIP Dyeing Colour	12683.48	7	13848	33.10	0.60	7	0	8.61
WIP FWD	12683.48	18	17609	180.97	4.18	18	0	23.26
WIP Final Set	12683.48	24	18969	351.92	8.77	24	0	36.55
WIP Heat Cut	12683.48	4	4923	0.00	0	1	0	0.00
WIP Folding	12683.48	3	1828	0.00	0	1	0	0.00
Dyeing Black.1	12683.48	1	1118	255.88	0.37	1	0	37.59
Dyeing Black.2	12683.48	1	1117	256.42	0.37	1	0	37.64
Dyeing Black.3	12683.48	1	1114	256.30	0.37	1	0	37.52
Dyeing Black.4	12683.48	1	1095	258.36	0.37	1	0	37.17
Dyeing Black.5	12683.48	1	677	325.71	0.28	1	0	28.98
Dyeing Black	63417.41	5	5121	265.85	0.35	5	0	35.78
WIP Sablon	12683.48	6	6209	0.00	1.97	1	0	0.00
WIP Dyeing Black	12683.48	5	5121	197.19	1.32	5	0	26.54
Persiapan1	12683.48	1	8019	50.16	0.52	1	0	52.86
Pintu Gudang1	12683.48	1	8019	50.15	0.52	1	0	52.85
Pintu Gudang2	12683.48	1	10951	69.28	0.99	1	0	99.70
Persiapan2	12683.48	1	10951	69.28	0.99	1	0	99.71

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	%   %			
		% Empty	% Partially Occupied	% Full	% Down
Gudang	12683.48	0.30	99.70	0.00	0.00
WIP Reeling	12683.48	47.06	2.96	49.98	0.00
WIP Relaxing A	12683.48	49.45	2.13	48.42	0.00
WIP Relaxing B	12683.48	0.22	2.91	96.87	0.00
WIP Hydro	12683.48	47.00	2.22	50.78	0.00
WIP Sofcer	12683.48	36.58	1.76	61.66	0.00
WIP Unroll	12683.48	1.60	5.16	93.24	0.00
WIP Pre Washing Drying	12683.48	20.53	2.60	76.87	0.00
WIP Preset	12683.48	20.51	11.35	68.14	0.00
WIP Hisaka WR	12683.48	38.62	7.24	54.15	0.00
WIP ST Tank	12683.48	88.74	1.95	9.30	0.00
WIP Dyeing Colour	12683.48	90.74	1.91	7.35	0.00
WIP FWD	12683.48	75.35	4.34	20.32	0.00
WIP Final Set	12683.48	61.94	5.64	32.43	0.00
WIP Heat Cut	12683.48	100.00	0.00	0.00	0.00
WIP Folding	12683.48	100.00	0.00	0.00	0.00
WIP Sablon	12683.48	100.00	0.00	0.00	0.00
WIP Dyeing Black	12683.48	72.75	2.56	24.69	0.00

LOCATION STATES BY PERCENTAGE (Single Capacity/Tanks)

Location Name	Scheduled Hours	%   %   %   %   %						
		% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down	
Reeling.1	12683.48	6.58	0.00	47.05	0.00	46.37	0.00	
Reeling.2	12683.48	6.58	0.00	47.05	0.00	46.37	0.00	
Reeling.3	12683.48	6.59	0.00	47.04	0.01	46.36	0.00	
Reeling.4	12683.48	6.59	0.00	47.05	0.00	46.36	0.00	
Reeling	50733.93	6.59	0.00	47.04	0.00	46.37	0.00	
Relaxing A.1	12683.48	21.08	0.00	47.02	0.00	31.90	0.00	
Relaxing A.2	12683.48	21.08	0.00	47.01	0.00	31.91	0.00	
Relaxing A.3	12683.48	21.07	0.00	47.03	0.00	31.90	0.00	
Relaxing A.4	12683.48	21.07	0.00	47.03	0.00	31.90	0.00	
Relaxing A.5	12683.48	21.07	0.00	47.02	0.00	31.91	0.00	
Relaxing A.6	12683.48	21.07	0.00	47.02	0.00	31.91	0.00	
Relaxing A	76100.9	21.07	0.00	47.02	0.01	31.90	0.00	
Relaxing B.1	12683.48	43.17	0.00	0.21	0.00	56.62	0.00	
Relaxing B.2	12683.48	43.17	0.00	0.20	0.01	56.62	0.00	
Relaxing B.3	12683.48	43.16	0.00	0.21	0.00	56.63	0.00	
Relaxing B.4	12683.48	43.17	0.00	0.20	0.00	56.63	0.00	
Relaxing B	50733.93	43.17	0.00	0.21	0.00	56.62	0.00	
Hydro.1	12683.48	12.29	0.00	46.99	0.00	40.72	0.00	
Hydro.2	12683.48	12.29	0.00	46.98	0.01	40.72	0.00	
Hydro.3	12683.48	12.29	0.00	46.99	0.00	40.72	0.00	
Hydro	38050.45	12.29	0.00	46.99	0.00	40.72	0.00	
Sofcer	12683.48	12.76	0.00	35.64	0.01	51.59	0.00	
Unroll.1	12683.48	21.17	0.00	0.64	0.00	78.19	0.00	
Unroll.2	12683.48	20.73	0.00	1.12	0.00	78.15	0.00	
Unroll.3	12683.48	20.42	0.00	1.45	0.00	78.13	0.00	
Unroll	38050.45	20.77	0.00	1.07	0.00	78.16	0.00	
Pre Washing Drying	12683.48	47.87	0.00	20.46	0.00	31.67	0.00	
Preset.1	12683.48	56.10	0.00	8.83	0.00	35.07	0.00	
Preset.2	12683.48	56.07	0.00	8.84	0.00	35.09	0.00	
Preset	25366.96	56.08	0.00	8.84	0.00	35.08	0.00	
Hisaka WR.1	12683.48	61.94	0.00	27.39	0.00	10.67	0.00	
Hisaka WR.2	12683.48	61.91	0.00	27.40	0.00	10.69	0.00	
Hisaka WR.3	12683.48	61.81	0.00	27.55	0.00	10.64	0.00	
Hisaka WR	38050.45	61.89	0.00	27.44	0.00	10.67	0.00	
ST Tank.1	12683.48	14.78	0.00	75.14	0.00	10.08	0.00	
ST Tank.2	12683.48	5.85	0.00	84.20	0.00	9.95	0.00	
ST Tank.3	12683.48	1.51	0.00	88.58	0.00	9.91	0.00	
ST Tank.4	12683.48	1.50	0.00	88.61	0.00	9.89	0.00	
ST Tank	50733.93	5.91	0.00	84.13	0.00	9.96	0.00	
Dyeing Colour.1	12683.48	62.62	0.00	30.78	0.00	6.60	0.00	
Dyeing Colour.2	12683.48	56.35	0.00	37.29	0.00	6.36	0.00	
Dyeing Colour.3	12683.48	53.73	0.00	40.58	0.00	5.69	0.00	
Dyeing Colour.4	12683.48	52.59	0.00	42.45	0.00	4.96	0.00	
Dyeing Colour.5	12683.48	19.06	0.00	76.12	0.00	4.82	0.00	

Dyeing Colour.6	12683.48	17.27	0.00	77.88	0.00	4.85	0.00
Dyeing Colour.7	12683.48	11.33	0.00	83.81	0.00	4.86	0.00
Dyeing Colour	88784.38	38.99	0.00	55.56	0.00	5.45	0.00
FWD.1	12683.48	57.11	0.00	20.55	0.00	22.34	0.00
FWD.2	12683.48	35.44	0.00	45.09	0.01	19.46	0.00
FWD	25366.96	46.28	0.00	32.82	0.00	20.90	0.00
Final Set.1	12683.48	77.99	0.00	22.01	0.00	0.00	0.00
Final Set.2	12683.48	59.82	0.00	40.18	0.00	0.00	0.00
Final Set	25366.96	68.91	0.00	31.09	0.00	0.00	0.00
Heat Cut.1	12683.48	12.65	0.00	87.35	0.00	0.00	0.00
Heat Cut.2	12683.48	0.29	0.00	99.71	0.00	0.00	0.00
Heat Cut	25366.96	6.47	0.00	93.53	0.00	0.00	0.00
Folding.1	12683.48	7.21	0.00	92.79	0.00	0.00	0.00
Folding.2	12683.48	3.60	0.00	96.40	0.00	0.00	0.00
Folding.3	12683.48	0.00	0.00	100.00	0.00	0.00	0.00
Folding	38050.45	3.60	0.00	96.40	0.00	0.00	0.00
Sablon.1	12683.48	22.98	0.00	77.02	0.00	0.00	0.00
Sablon.2	12683.48	17.20	0.00	82.80	0.00	0.00	0.00
Sablon.3	12683.48	0.17	0.00	99.83	0.00	0.00	0.00
Sablon	38050.45	13.45	0.00	86.55	0.00	0.00	0.00
Dyeing Black.1	12683.48	22.04	0.00	62.40	0.00	15.56	0.00
Dyeing Black.2	12683.48	22.02	0.00	62.36	0.00	15.62	0.00
Dyeing Black.3	12683.48	21.96	0.00	62.48	0.00	15.56	0.00
Dyeing Black.4	12683.48	21.58	0.00	62.83	0.00	15.59	0.00
Dyeing Black.5	12683.48	13.34	0.00	71.02	0.01	15.63	0.00
Dyeing Black	63417.41	20.19	0.00	64.22	0.00	15.59	0.00
Persiapan1	12683.48	0.00	0.00	47.14	0.00	52.86	0.00
Pintu Gudang1	12683.48	0.00	0.00	47.15	0.00	52.85	0.00
Pintu Gudang2	12683.48	0.00	0.00	0.30	0.00	99.70	0.00
Persiapan2	12683.48	0.00	0.00	0.29	0.00	99.71	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
work order	Gudang	0

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Minutes In System	Average Minutes In Move Logic	Average Minutes Wait For Res, etc.	Average Minutes In Operation	Average Minutes Blocked
Item 79	3401	0	245879.40	27.00	0.00	500.00	245352.40
Item 106	1531	0	41609.20	29.00	0.00	635.00	40945.20
Item 150	1828	0	468410.01	37.00	0.00	650.00	467723.01
Item 60	1381	0	532465.00	27.00	0.00	535.00	531903.00
Item 18	1557	0	591302.00	40.00	0.00	645.00	590617.00
Item 72	1277	0	107896.34	30.00	0.00	595.00	107271.34
Item 38	917	0	146865.36	30.00	0.00	500.00	146335.36
Item 97	439	0	172432.79	32.00	0.00	635.00	171765.79
Item 48	377	0	635685.05	33.00	0.00	730.00	634922.05
Item 81	501	0	666366.14	33.00	0.00	680.00	665653.14
Item 128	1248	0	231565.78	38.00	0.00	730.00	230797.78
Item 51	450	0	690792.38	31.00	0.00	575.00	690186.38
Item 28	112	0	702765.03	24.00	0.00	600.00	702141.03
Item 93	290	0	288635.44	37.00	0.00	750.00	287848.44
Item 6	412	0	718537.07	41.00	0.00	635.00	717861.07
Item 126	284	0	733337.25	34.00	0.00	460.00	732843.25
Item 50	726	0	321933.23	30.00	0.00	585.00	321318.23
Item 73	212	0	349522.90	37.00	0.00	685.00	348800.90
Item 98	145	0	356411.44	30.00	0.00	500.00	355881.44
Item 91	234	0	362096.66	34.00	0.00	500.00	361562.66
Item 90	591	0	374471.66	30.00	0.00	500.00	373941.66
Item 147	67	0	737596.00	39.00	0.00	460.00	737097.00
Item 104	92	0	741514.93	34.00	0.00	640.00	740840.93
Item 43	218	0	391885.45	39.00	0.00	750.00	391096.45
Item 16	228	0	746857.16	32.00	0.00	500.00	746325.16
Item 130	131	0	753223.65	34.00	0.00	555.00	752634.65
Item 131	130	0	758443.22	34.00	0.00	555.00	757854.22
Item 45	190	0	402262.58	30.00	0.00	500.00	401732.58
work order	1	0	0.00	0.00	0.00	0.00	0.00
Rest reeling	0	0	-	-	-	-	-

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
Item 79	0.01	0.00	0.20	99.79
Item 106	0.07	0.00	1.53	98.40
Item 150	0.01	0.00	0.14	99.85
Item 60	0.01	0.00	0.10	99.89
Item 18	0.01	0.00	0.11	99.88
Item 72	0.03	0.00	0.55	99.42
Item 38	0.02	0.00	0.34	99.64
Item 97	0.02	0.00	0.37	99.61
Item 48	0.01	0.00	0.11	99.88

Item 81	0.00	0.00	0.10	99.89
Item 128	0.02	0.00	0.32	99.67
Item 51	0.00	0.00	0.08	99.91
Item 28	0.00	0.00	0.09	99.91
Item 93	0.01	0.00	0.26	99.73
Item 6	0.01	0.00	0.09	99.91
Item 126	0.00	0.00	0.06	99.93
Item 50	0.01	0.00	0.18	99.81
Item 73	0.01	0.00	0.20	99.79
Item 98	0.01	0.00	0.14	99.85
Item 91	0.01	0.00	0.14	99.85
Item 90	0.01	0.00	0.13	99.86
Item 147	0.01	0.00	0.06	99.93
Item 104	0.00	0.00	0.09	99.91
Item 43	0.01	0.00	0.19	99.80
Item 16	0.00	0.00	0.07	99.93
Item 130	0.00	0.00	0.07	99.92
Item 131	0.00	0.00	0.07	99.92
Item 45	0.01	0.00	0.12	99.87
work order	-	-	-	-
Rest reeling	-	-	-	-

VARIABLES

Variable Name	Total Changes	Average		Minimum Value	Maximum Value	Current Value	Average Value
		Minutes Per Change					
jumlah buffer	0	0.00		0	0	0	0
Status Send1	0	0.00		1	1	1	1
Status Send2	0	0.00		0	0	0	0
wipFS	0	0.00		0	0	0	0

# **LAMPIRAN 5**

## **SKENARIO 4**

- **INPUT SIMULASI USULAN**
- **OUTPUT SIMULASI USULAN**

## • Input Promodel (Skenario 4)

```

*****
*
* Formatted Listing of Model:
*
* D:\Maranatha\Kuliah\TA\Laporan\Promodel\Usulan\Modiff all usulan preset WIP asli last.MOD *
*
*****

```

```

Time Units:           Minutes
Distance Units:      Feet
Initialization Logic: DYNPLOT "WIPFinalSet"

```

```

*****
* Locations
*
*****

```

Name	Cap	Units	Stats	Rules	Cost
Gudang	inf	1		Time Series Oldest, , First	
Reeling	1	4		Time Series Oldest, , First	
Reeling.1	1	1		Time Series Oldest, ,	
Reeling.2	1	1		Time Series Oldest, ,	
Reeling.3	1	1		Time Series Oldest, ,	
Reeling.4	1	1		Time Series Oldest, ,	
Relaxing_A	1	6		Time Series Oldest, , First	
Relaxing_A.1	1	1		Time Series Oldest, ,	
Relaxing_A.2	1	1		Time Series Oldest, ,	
Relaxing_A.3	1	1		Time Series Oldest, ,	
Relaxing_A.4	1	1		Time Series Oldest, ,	
Relaxing_A.5	1	1		Time Series Oldest, ,	
Relaxing_A.6	1	1		Time Series Oldest, ,	
Relaxing_B	1	4		Time Series Oldest, , First	
Relaxing_B.1	1	1		Time Series Oldest, ,	
Relaxing_B.2	1	1		Time Series Oldest, ,	
Relaxing_B.3	1	1		Time Series Oldest, ,	
Relaxing_B.4	1	1		Time Series Oldest, ,	
Hydro	1	3		Time Series Oldest, , First	
Hydro.1	1	1		Time Series Oldest, ,	
Hydro.2	1	1		Time Series Oldest, ,	
Hydro.3	1	1		Time Series Oldest, ,	
Sofcer	1	1		Time Series Oldest, ,	
Unroll	1	3		Time Series Oldest, , First	
Unroll.1	1	1		Time Series Oldest, ,	
Unroll.2	1	1		Time Series Oldest, ,	
Unroll.3	1	1		Time Series Oldest, ,	
Pre_Washing_Drying	1	1		Time Series Oldest, ,	
Preset	1	2		Time Series Oldest, , First	
Preset.1	1	1		Time Series Oldest, ,	
Preset.2	1	1		Time Series Oldest, ,	
Hisaka_WR	1	3		Time Series Oldest, , First	
Hisaka_WR.1	1	1		Time Series Oldest, ,	
Hisaka_WR.2	1	1		Time Series Oldest, ,	
Hisaka_WR.3	1	1		Time Series Oldest, ,	
ST_Tank	1	4		Time Series Oldest, , First	
ST_Tank.1	1	1		Time Series Oldest, ,	
ST_Tank.2	1	1		Time Series Oldest, ,	
ST_Tank.3	1	1		Time Series Oldest, ,	
ST_Tank.4	1	1		Time Series Oldest, ,	
Dyeing_Colour	1	7		Time Series Oldest, , First	
Dyeing_Colour.1	1	1		Time Series Oldest, ,	
Dyeing_Colour.2	1	1		Time Series Oldest, ,	
Dyeing_Colour.3	1	1		Time Series Oldest, ,	
Dyeing_Colour.4	1	1		Time Series Oldest, ,	
Dyeing_Colour.5	1	1		Time Series Oldest, ,	
Dyeing_Colour.6	1	1		Time Series Oldest, ,	
Dyeing_Colour.7	1	1		Time Series Oldest, ,	
FWD	1	2		Time Series Oldest, , First	
FWD.1	1	1		Time Series Oldest, ,	
FWD.2	1	1		Time Series Oldest, ,	
Final_Set	1	2		Time Series Oldest, , First	
Final_Set.1	1	1		Time Series Oldest, ,	
Final_Set.2	1	1		Time Series Oldest, ,	
Heat_Cut	1	2		Time Series Oldest, , First	
Heat_Cut.1	1	1		Time Series Oldest, ,	
Heat_Cut.2	1	1		Time Series Oldest, ,	
Folding	1	3		Time Series Oldest, , First	
Folding.1	1	1		Time Series Oldest, ,	
Folding.2	1	1		Time Series Oldest, ,	
Folding.3	1	1		Time Series Oldest, ,	
Sablon	1	3		Time Series Oldest, , First	
Sablon.1	1	1		Time Series Oldest, ,	
Sablon.2	1	1		Time Series Oldest, ,	
Sablon.3	1	1		Time Series Oldest, ,	
WIP_Reeling	21	1		Time Series Oldest, , First	
WIP_Relaxing_A	6	1		Time Series Oldest, , First	
WIP_Relaxing_B	14	1		Time Series Oldest, , First	
WIP_Hydro	7	1		Time Series Oldest, , First	
WIP_Sofcer	6	1		Time Series Oldest, , First	
WIP_Unroll	3	1		Time Series Oldest, , First	
WIP_Pre_Washing_Drying	4	1		Time Series Oldest, , First	
WIP_Preset	42	1		Time Series Oldest, , First	
WIP_Hisaka_WR	6	1		Time Series Oldest, , First	
WIP_ST_Tank	8	1		Time Series Oldest, , First	
WIP_Dyeing_Colour	28	1		Time Series Oldest, , First	
WIP_FWD	18	1		Time Series Oldest, , First	
WIP_Final_Set	42	1		Time Series Oldest, , First	
WIP_Heat_Cut	4	1		Time Series Oldest, , First	
WIP_Folding	3	1		Time Series Oldest, , First	
Dyeing_Black	1	5		Time Series Oldest, , First	
Dyeing_Black.1	1	1		Time Series Oldest, ,	
Dyeing_Black.2	1	1		Time Series Oldest, ,	
Dyeing_Black.3	1	1		Time Series Oldest, ,	
Dyeing_Black.4	1	1		Time Series Oldest, ,	
Dyeing_Black.5	1	1		Time Series Oldest, ,	
WIP_Sablon	6	1		Time Series Oldest, , First	
WIP_Dyeing_Black	20	1		Time Series Oldest, , First	





283 AND Status\_Send1=0 THEN

Persiapan2  
Persiapan1  
Persiapan1  
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Persiapan2  
Persiapan2  
Persiapan1

Item\_79 Preset

ALL WIP\_ST\_Tank  
Item\_79 ST\_Tank  
ALL WIP\_Dyeing\_Colour  
Item\_79 Dyeing\_Colour  
ALL WIP\_FWD  
Item\_79 FWD  
ALL WIP\_Final\_Set

ENTITY() = Item\_43 THEN

jumlah\_buffer - 140

jumlah\_buffer - 35

Item\_79 Final\_Set  
Item\_106 Persiapan1  
ALL WIP\_Reeling  
Item\_106 Reeling  
ALL WIP\_Relaxing\_A  
Item\_106 Relaxing\_A

WAIT U(45, 0)

1 Item\_79 WIP\_ST\_Tank  
1 ALL ST\_Tank  
WAIT U(25, 0) 1 Item\_79 WIP\_Dyeing\_Colour  
1 ALL Dyeing\_Colour  
WAIT U(150, 0) 1 Item\_79 WIP\_FWD  
1 ALL FWD  
WAIT U(40, 0) 1 Item\_79 WIP\_Final\_Set

INC wipFS

IF ENTITY() = Item\_81 OR ENTITY() = Item\_128 OR ENTITY() = Item\_93 OR ENTITY() = Item\_6 OR

{  
jumlah\_buffer = jumlah\_buffer + 140  
}  
Else  
{  
jumlah\_buffer = jumlah\_buffer + 35  
}

1 ALL Final\_Set

ENTITY() = Item\_128 OR ENTITY() = Item\_93 OR ENTITY() = Item\_6 OR ENTITY() = Item\_43 THEN

WAIT U(35, 0) 1 Item\_79 EXIT  
1 Item\_106 WIP\_Reeling  
1 ALL Reeling  
WAIT U(25, 0)  
1 Item\_106 WIP\_Relaxing\_A  
1 ALL Relaxing\_A  
WAIT U(120, 0)

IF jumlah\_buffer\_preset <=

{  
SEND 1 Item\_6 TO Persiapan2  
SEND 1 Item\_126 TO  
SEND 1 Item\_50 TO  
SEND 1 Item\_73 TO  
SEND 1 Item\_98 TO  
SEND 1 Item\_91 TO  
SEND 1 Item\_90 TO  
SEND 1 Item\_147 TO  
SEND 1 Item\_104 TO  
SEND 1 Item\_43 TO  
SEND 1 Item\_16 TO  
SEND 1 Item\_130 TO  
SEND 1 Item\_131 TO  
SEND 1 Item\_45 TO  
SEND 1 Item\_79 TO  
SEND 1 Item\_106 TO  
SEND 1 Item\_150 TO  
SEND 1 Item\_60 TO  
SEND 1 Item\_18 TO  
SEND 1 Item\_72 TO  
SEND 1 Item\_38 TO  
SEND 1 Item\_97 TO  
SEND 1 Item\_48 TO  
SEND 1 Item\_81 TO  
SEND 1 Item\_128 TO  
SEND 1 Item\_51 TO  
SEND 1 Item\_28 TO  
SEND 1 Item\_93 TO  
Status\_Send1 = 1  
Status\_Send2 = 1  
}

FIRST 1 MOVE FOR 5 MIN  
FIRST 1  
FIRST 1 MOVE FOR 5 MIN  
FIRST 1  
FIRST 1 MOVE FOR 5 MIN  
FIRST 1  
FIRST 1 MOVE FOR 4 MIN

FIRST 1 DEC wipFS

IF ENTITY() = Item\_81 OR

{  
jumlah\_buffer =  
}  
Else  
{  
jumlah\_buffer =  
}

FIRST 1 MOVE FOR 2 MIN  
FIRST 1  
FIRST 1  
FIRST 1 MOVE FOR 2 MIN  
FIRST 1

ALL	WIP_Hydro		1	Item_106	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
			1	ALL	Hydro	FIRST 1		
Item_106	Hydro	WAIT U(35, 0)						
Item_106	Unroll	WAIT U(25, 0)	1	Item_106	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_106	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_106	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_106	Preset	WAIT U(45, 0)	1	Item_106	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
ALL	WIP_Hisaka_WR		1	Item_106	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_106	Hisaka_WR	WAIT U(120, 0)	1	ALL	Hisaka_WR	FIRST 1		
Item_106	Dyeing_Colour	WAIT U(150, 0)	1	Item_106	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_106	FWD	WAIT U(40, 0)	1	Item_106	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_106	Final_Set	WAIT U(40, 0)	1	Item_106	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_150	Persiapan2	WAIT U(35, 0)	1	Item_106	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_150	Relaxing_B	WAIT U(120, 0)	1	Item_150	WIP_Relaxing_B	FIRST 1		
Item_150	Unroll	WAIT U(25, 0)	1	Item_150	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_150	Preset	WAIT U(45, 0)	1	Item_150	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_150	Hisaka_WR	WAIT U(120, 0)	1	Item_150	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_150	Dyeing_Colour	WAIT U(150, 0)	1	Item_150	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_150	FWD	WAIT U(40, 0)	1	Item_150	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_150	Final_Set	WAIT U(40, 0)	1	Item_150	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_150	WIP_Heat_Cut	WAIT U(35, 0)	1	Item_150	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_150	Heat_Cut	WAIT U(20, 0)	1	ALL	Heat_Cut	FIRST 1		
Item_150	WIP_Folding	WAIT U(45, 0)	1	Item_150	WIP_Folding	FIRST 1	MOVE FOR	3 MIN
Item_150	Folding	WAIT U(45, 0)	1	ALL	Folding	FIRST 1		
Item_150	WIP_Sablon	WAIT U(50, 0)	1	Item_150	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_150	Sablon	WAIT U(50, 0)	1	ALL	Sablon	FIRST 1		
Item_60	Persiapan2	WAIT U(35, 0)	1	Item_150	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_60	Relaxing_B	WAIT U(120, 0)	1	Item_60	WIP_Relaxing_B	FIRST 1		
Item_60	Unroll	WAIT U(25, 0)	1	Item_60	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_60	Preset	WAIT U(45, 0)	1	Item_60	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_60	Hisaka_WR	WAIT U(120, 0)	1	Item_60	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_60	Dyeing_Colour	WAIT U(150, 0)	1	Item_60	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_60	FWD	WAIT U(40, 0)	1	Item_60	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_60	Final_Set	WAIT U(40, 0)	1	Item_60	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_60	Persiapan2	WAIT U(35, 0)	1	Item_60	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_18	Relaxing_B	WAIT U(120, 0)	1	Item_18	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_18	Unroll	WAIT U(25, 0)	1	Item_18	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_18	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_18	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_18	Preset	WAIT U(45, 0)	1	Item_18	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_18	Hisaka_WR	WAIT U(120, 0)	1	Item_18	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
ALL	WIP_Dyeing_Black		1	Item_18	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_18	Dyeing_Black	WAIT U(150, 0)	1	ALL	Dyeing_Black	FIRST 1		
Item_18	FWD	WAIT U(40, 0)	1	Item_18	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_18	Final_Set	WAIT U(35, 0)	1	Item_18	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_18	Heat_Cut	WAIT U(20, 0)	1	Item_18	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_18	Sablon	WAIT U(50, 0)	1	Item_18	WIP_Sablon	FIRST 1	MOVE FOR	2 MIN
Item_72	Persiapan1	WAIT U(35, 0)	1	Item_18	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_72	Reeling	WAIT U(25, 0)	1	Item_72	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_72	Relaxing_A	WAIT U(120, 0)	1	Item_72	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_72	Hydro	WAIT U(35, 0)	1	Item_72	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_72	Unroll	WAIT U(25, 0)	1	Item_72	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_72	Preset	WAIT U(45, 0)	1	Item_72	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_72	Hisaka_WR	WAIT U(120, 0)	1	Item_72	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_72	Dyeing_Colour	WAIT U(150, 0)	1	Item_72	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_72	FWD	WAIT U(40, 0)	1	Item_72	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_72	Final_Set	WAIT U(40, 0)	1	Item_72	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_38	Persiapan1	WAIT U(35, 0)	1	Item_72	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_38	Reeling	WAIT U(25, 0)	1	Item_38	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_38	Relaxing_A	WAIT U(120, 0)	1	Item_38	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_38	Hydro	WAIT U(35, 0)	1	Item_38	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_38	Unroll	WAIT U(25, 0)	1	Item_38	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_38	Preset	WAIT U(45, 0)	1	Item_38	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_38	ST_Tank	WAIT U(25, 0)	1	Item_38	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_38	Dyeing_Colour	WAIT U(150, 0)	1	Item_38	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_38	FWD	WAIT U(40, 0)	1	Item_38	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_38	Final_Set	WAIT U(40, 0)	1	Item_38	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_97	Persiapan1	WAIT U(35, 0)	1	Item_38	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_97	Reeling	WAIT U(25, 0)	1	Item_97	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN

Item_97	Relaxing_A	WAIT U(120, 0)	1	Item_97	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_97	Hydro	WAIT U(35, 0)	1	Item_97	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_97	Unroll	WAIT U(25, 0)	1	Item_97	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_97	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_97	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_97	Preset	WAIT U(45, 0)	1	Item_97	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_97	Hisaka_WR	WAIT U(120, 0)	1	Item_97	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_97	Dyeing_Colour	WAIT U(150, 0)	1	Item_97	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_97	FWD	WAIT U(40, 0)	1	Item_97	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_97	Final_Set	WAIT U(35, 0)	1	Item_97	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_48	Persiapan2	WAIT U(120, 0)	1	Item_48	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_48	Relaxing_B	WAIT U(120, 0)	1	Item_48	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_48	Unroll	WAIT U(25, 0)	1	Item_48	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_48	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_48	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_48	Preset	WAIT U(45, 0)	1	Item_48	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_48	Hisaka_WR	WAIT U(120, 0)	1	Item_48	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_48	Dyeing_Black	WAIT U(150, 0)	1	Item_48	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_48	FWD	WAIT U(40, 0)	1	Item_48	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_48	Final_Set	WAIT U(140, 0)	1	Item_48	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_48	Sablon	WAIT U(140, 0)	1	Item_48	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_48	Persiapan2	WAIT U(150, 0)	1	Item_48	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_81	Relaxing_B	WAIT U(120, 0)	1	Item_81	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_81	Unroll	WAIT U(25, 0)	1	Item_81	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_81	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_81	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_81	Preset	WAIT U(45, 0)	1	Item_81	WIP_Preset	FIRST 1	MOVE FOR	5 MIN
Item_81	Hisaka_WR	WAIT U(120, 0)	1	Item_81	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_81	Dyeing_Black	WAIT U(150, 0)	1	Item_81	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_81	FWD	WAIT U(40, 0)	1	Item_81	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_81	Final_Set	WAIT U(140, 0)	1	Item_81	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_81	Persiapan1	WAIT U(140, 0)	1	Item_81	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_128	Reeling	WAIT U(25, 0)	1	Item_128	WIP_Reeling	FIRST 1	MOVE FOR	5 MIN
Item_128	Relaxing_A	WAIT U(120, 0)	1	Item_128	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_128	Hydro	WAIT U(35, 0)	1	Item_128	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_128	Unroll	WAIT U(25, 0)	1	Item_128	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_128	Preset	WAIT U(45, 0)	1	Item_128	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_128	Hisaka_WR	WAIT U(120, 0)	1	Item_128	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_128	Dyeing_Black	WAIT U(150, 0)	1	Item_128	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_128	Final_Set	WAIT U(140, 0)	1	Item_128	WIP_Final_Set	FIRST 1	MOVE FOR	5 MIN
Item_128	Heat_Cut	WAIT U(20, 0)	1	Item_128	WIP_Heat_Cut	FIRST 1	MOVE FOR	2 MIN
Item_128	Sablon	WAIT U(20, 0)	1	Item_128	WIP_Sablon	FIRST 1	MOVE FOR	4 MIN
Item_128	Persiapan2	WAIT U(50, 0)	1	Item_128	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_51	Relaxing_B	WAIT U(120, 0)	1	Item_51	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_51	Unroll	WAIT U(25, 0)	1	Item_51	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_51	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_51	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_51	Preset	WAIT U(45, 0)	1	Item_51	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_51	Hisaka_WR	WAIT U(120, 0)	1	Item_51	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_51	Dyeing_Colour	WAIT U(150, 0)	1	Item_51	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_51	FWD	WAIT U(40, 0)	1	Item_51	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_51	Final_Set	WAIT U(35, 0)	1	Item_51	WIP_Final_Set	FIRST 1	MOVE FOR	5 MIN
Item_28	Persiapan2	WAIT U(120, 0)	1	Item_28	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_28	Relaxing_B	WAIT U(120, 0)	1	Item_28	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_28	Sofcer	WAIT U(20, 0)	1	Item_28	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_28	Unroll	WAIT U(25, 0)	1	Item_28	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_28	Preset	WAIT U(45, 0)	1	Item_28	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_28	Hisaka_WR	WAIT U(120, 0)	1	Item_28	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_28	Dyeing_Colour	WAIT U(150, 0)	1	Item_28	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_28	Final_Set	WAIT U(120, 0)	1	Item_28	WIP_Final_Set	FIRST 1	MOVE FOR	3 MIN
Item_93	Persiapan1	WAIT U(120, 0)	1	Item_93	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_93	Reeling	WAIT U(25, 0)	1	Item_93	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_93	Relaxing_A	WAIT U(120, 0)	1	Item_93	Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_93	Hydro	WAIT U(35, 0)	1	Item_93	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_93	Unroll	WAIT U(25, 0)	1	Item_93	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_93	Preset	WAIT U(45, 0)	1	Item_93	WIP_Preset	FIRST 1	MOVE FOR	2 MIN

Item_93	Hisaka_WR	WAIT U(120, 0)	1	Item_93	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_93	Dyeing_Black	WAIT U(150, 0)	1	Item_93	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_93	FWD	WAIT U(40, 0)	1	Item_93	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_93	Final_Set	WAIT U(120, 0)	1	Item_93	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_93	Heat_Cut	WAIT U(20, 0)	1	Item_93	WIP_Heat_Cut	FIRST 1	MOVE FOR	5 MIN
Item_93	Sablon	WAIT U(50, 0)	1	Item_93	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_6	Persiapan2		1	Item_6	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_6	Relaxing_B	WAIT U(120, 0)	1	Item_6	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_6	Sofcer	WAIT U(20, 0)	1	Item_6	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_6	Unroll	WAIT U(25, 0)	1	Item_6	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_6	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_6	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_6	Preset	WAIT U(45, 0)	1	Item_6	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_6	ST_Tank	WAIT U(25, 0)	1	Item_6	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_6	Dyeing_Black	WAIT U(150, 0)	1	Item_6	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_6	FWD	WAIT U(40, 0)	1	Item_6	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_6	Final_Set	WAIT U(120, 0)	1	Item_6	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_6	Sablon	WAIT U(50, 0)	1	Item_6	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_126	Persiapan2		1	Item_126	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_126	Relaxing_B	WAIT U(120, 0)	1	Item_126	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_126	Sofcer	WAIT U(20, 0)	1	Item_126	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_126	Unroll	WAIT U(25, 0)	1	Item_126	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_126	Preset	WAIT U(45, 0)	1	Item_126	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_126	ST_Tank	WAIT U(25, 0)	1	Item_126	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_126	Dyeing_Colour	WAIT U(150, 0)	1	Item_126	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_126	FWD	WAIT U(40, 0)	1	Item_126	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_126	Final_Set	WAIT U(35, 0)	1	Item_126	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_50	Persiapan1		1	Item_50	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_50	Reeling	WAIT U(25, 0)	1	Item_50	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_50	Relaxing_A	WAIT U(120, 0)	1	Item_50	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_50	Hydro	WAIT U(35, 0)	1	Item_50	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_50	Unroll	WAIT U(25, 0)	1	Item_50	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_50	Preset	WAIT U(45, 0)	1	Item_50	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_50	ST_Tank	WAIT U(25, 0)	1	Item_50	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_50	Dyeing_Colour	WAIT U(150, 0)	1	Item_50	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_50	FWD	WAIT U(40, 0)	1	Item_50	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_50	Final_Set	WAIT U(120, 0)	1	Item_50	EXIT	FIRST 1	MOVE FOR	5 MIN
Item_73	Persiapan1		1	Item_73	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_73	Reeling	WAIT U(25, 0)	1	Item_73	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_73	Relaxing_A	WAIT U(120, 0)	1	Item_73	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_73	Hydro	WAIT U(35, 0)	1	Item_73	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_73	Unroll	WAIT U(25, 0)	1	Item_73	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_73	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_73	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_73	Preset	WAIT U(45, 0)	1	Item_73	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_73	Hisaka_WR	WAIT U(120, 0)	1	Item_73	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_73	Dyeing_Colour	WAIT U(150, 0)	1	Item_73	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_73	FWD	WAIT U(40, 0)	1	Item_73	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_73	Final_Set	WAIT U(35, 0)	1	Item_73	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_73	WIP_Sablon		1	Item_73	Sablon	FIRST 1	MOVE FOR	5 MIN
Item_73	Sablon	WAIT U(50, 0)	1	Item_73	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_98	Persiapan1		1	Item_98	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_98	Reeling	WAIT U(25, 0)	1	Item_98	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_98	Relaxing_A	WAIT U(120, 0)	1	Item_98	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_98	Hydro	WAIT U(35, 0)	1	Item_98	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_98	Unroll	WAIT U(25, 0)	1	Item_98	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_98	Preset	WAIT U(45, 0)	1	Item_98	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_98	ST_Tank	WAIT U(25, 0)	1	Item_98	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_98	Dyeing_Colour	WAIT U(150, 0)	1	Item_98	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_98	FWD	WAIT U(40, 0)	1	Item_98	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_98	Final_Set	WAIT U(35, 0)	1	Item_98	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_91	Persiapan1		1	Item_91	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_91	Reeling	WAIT U(25, 0)	1	Item_91	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_91	Relaxing_A	WAIT U(120, 0)	1	Item_91	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_91	Hydro	WAIT U(35, 0)	1	Item_91	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN

Item_91	Unroll	WAIT U(25, 0)	1	Item_91	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_91	Preset	WAIT U(45, 0)	1	Item_91	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_91	ST_Tank	WAIT U(25, 0)	1	Item_91	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_91	Dyeing_Colour	WAIT U(150, 0)	1	Item_91	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_91	FWD	WAIT U(40, 0)	1	Item_91	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_91	Final_Set	WAIT U(35, 0)	1	Item_91	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_90	Persiapan1	WAIT U(35, 0)	1	Item_91	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_90	WIP Reeling		1	Item_90	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_90	Reeling	WAIT U(25, 0)	1	Item_90	Reeling	FIRST 1		
Item_90	Relaxing_A	WAIT U(120, 0)	1	Item_90	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_90	Hydro	WAIT U(35, 0)	1	Item_90	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_90	Unroll	WAIT U(25, 0)	1	Item_90	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_90	Preset	WAIT U(45, 0)	1	Item_90	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_90	ST_Tank	WAIT U(25, 0)	1	Item_90	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_90	Dyeing_Colour	WAIT U(150, 0)	1	Item_90	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_90	FWD	WAIT U(40, 0)	1	Item_90	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_90	Final_Set	WAIT U(35, 0)	1	Item_90	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_147	Persiapan2	WAIT U(35, 0)	1	Item_90	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_147	Relaxing_B	WAIT U(120, 0)	1	Item_147	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_147	Sofcer	WAIT U(20, 0)	1	Item_147	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_147	Unroll	WAIT U(25, 0)	1	Item_147	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_147	Preset	WAIT U(45, 0)	1	Item_147	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_147	ST_Tank	WAIT U(25, 0)	1	Item_147	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_147	Dyeing_Black	WAIT U(150, 0)	1	Item_147	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_147	FWD	WAIT U(40, 0)	1	Item_147	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_147	Final_Set	WAIT U(35, 0)	1	Item_147	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_147	Sablon	WAIT U(35, 0)	1	Item_147	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_104	Persiapan2	WAIT U(35, 0)	1	Item_147	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_104	Relaxing_B	WAIT U(120, 0)	1	Item_104	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_104	Sofcer	WAIT U(20, 0)	1	Item_104	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_104	Unroll	WAIT U(25, 0)	1	Item_104	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_104	Preset	WAIT U(45, 0)	1	Item_104	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_104	Hisaka_WR	WAIT U(120, 0)	1	Item_104	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_104	Dyeing_Colour	WAIT U(150, 0)	1	Item_104	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_104	FWD	WAIT U(40, 0)	1	Item_104	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_104	Final_Set	WAIT U(120, 0)	1	Item_104	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_43	Persiapan1	WAIT U(35, 0)	1	Item_104	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_43	Reeling	WAIT U(25, 0)	1	Item_43	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_43	Relaxing_A	WAIT U(120, 0)	1	Item_43	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_43	Hydro	WAIT U(35, 0)	1	Item_43	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_43	Unroll	WAIT U(25, 0)	1	Item_43	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_43	Preset	WAIT U(45, 0)	1	Item_43	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_43	Hisaka_WR	WAIT U(120, 0)	1	Item_43	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_43	Dyeing_Black	WAIT U(150, 0)	1	Item_43	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_43	FWD	WAIT U(40, 0)	1	Item_43	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_43	Final_Set	WAIT U(140, 0)	1	Item_43	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_43	Sablon	WAIT U(50, 0)	1	Item_43	WIP_Sablon	FIRST 1	MOVE FOR	5 MIN
Item_16	Persiapan2	WAIT U(35, 0)	1	Item_43	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_16	Relaxing_B	WAIT U(120, 0)	1	Item_16	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_16	Sofcer	WAIT U(20, 0)	1	Item_16	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_16	Unroll	WAIT U(25, 0)	1	Item_16	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_16	Pre_Washing_Drying	WAIT U(40, 0)	1	Item_16	WIP_Pre_Washing_Drying	FIRST 1	MOVE FOR	2 MIN
Item_16	Preset	WAIT U(45, 0)	1	Item_16	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_16	ST_Tank	WAIT U(25, 0)	1	Item_16	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_16	Dyeing_Colour	WAIT U(150, 0)	1	Item_16	WIP_Dyeing_Colour	FIRST 1	MOVE FOR	5 MIN
Item_16	FWD	WAIT U(40, 0)	1	Item_16	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_16	Final_Set	WAIT U(35, 0)	1	Item_16	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_130	Persiapan2	WAIT U(35, 0)	1	Item_16	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_130	Relaxing_B	WAIT U(120, 0)	1	Item_130	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_130	Sofcer	WAIT U(20, 0)	1	Item_130	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_130	Unroll	WAIT U(25, 0)	1	Item_130	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_130	Preset	WAIT U(45, 0)	1	Item_130	WIP_Preset	FIRST 1	MOVE FOR	6 MIN

Item_130	Hisaka_WR	WAIT U(120, 0)	1	Item_130	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_130	Dyeing_Black	WAIT U(150, 0)	1	Item_130	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_130	FWD	WAIT U(40, 0)	1	Item_130	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_130	Final_Set	WAIT U(35, 0)	1	Item_130	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_131	Persiapan2		1	Item_130	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_131	Relaxing_B	WAIT U(120, 0)	1	Item_131	WIP_Relaxing_B	FIRST 1	MOVE FOR	5 MIN
Item_131	Sofcer	WAIT U(20, 0)	1	Item_131	WIP_Sofcer	FIRST 1	MOVE FOR	2 MIN
Item_131	Unroll	WAIT U(25, 0)	1	Item_131	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_131	Preset	WAIT U(45, 0)	1	Item_131	WIP_Preset	FIRST 1	MOVE FOR	6 MIN
Item_131	Hisaka_WR	WAIT U(120, 0)	1	Item_131	WIP_Hisaka_WR	FIRST 1	MOVE FOR	5 MIN
Item_131	Dyeing_Black	WAIT U(150, 0)	1	Item_131	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_131	FWD	WAIT U(40, 0)	1	Item_131	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_131	Final_Set	WAIT U(35, 0)	1	Item_131	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
Item_45	Persiapan1		1	Item_131	EXIT	FIRST 1	MOVE FOR	10 MIN
Item_45	Reeling	WAIT U(25, 0)	1	Item_45	WIP_Reeling	FIRST 1	MOVE FOR	3 MIN
Item_45	Relaxing_A	WAIT U(120, 0)	1	Item_45	WIP_Relaxing_A	FIRST 1	MOVE FOR	2 MIN
Item_45	Hydro	WAIT U(35, 0)	1	Item_45	WIP_Hydro	FIRST 1	MOVE FOR	2 MIN
Item_45	Unroll	WAIT U(25, 0)	1	Item_45	WIP_Unroll	FIRST 1	MOVE FOR	2 MIN
Item_45	Preset	WAIT U(45, 0)	1	Item_45	WIP_Preset	FIRST 1	MOVE FOR	2 MIN
Item_45	ST_Tank	WAIT U(25, 0)	1	Item_45	WIP_ST_Tank	FIRST 1	MOVE FOR	5 MIN
Item_45	Dyeing_Black	WAIT U(150, 0)	1	Item_45	WIP_Dyeing_Black	FIRST 1	MOVE FOR	5 MIN
Item_45	FWD	WAIT U(40, 0)	1	Item_45	WIP_FWD	FIRST 1	MOVE FOR	5 MIN
Item_45	Final_Set	WAIT U(35, 0)	1	Item_45	WIP_Final_Set	FIRST 1	MOVE FOR	4 MIN
work_order	Gudang		1	work_order	EXIT	FIRST 1	MOVE FOR	10 MIN
work_order	Persiapan1		1	work_order	EXIT	FIRST 1	MOVE FOR	10 MIN

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

Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
work_order	Gudang	1		1		

Kategori\_Item=2  
 ORDER 3401 Item\_79  
 ORDER 1828 Item\_150  
 ORDER 412 Item\_6  
 ORDER 1381 Item\_60  
 ORDER 284 Item\_126  
 ORDER 1557 Item\_18  
 ORDER 377 Item\_48  
 ORDER 67 Item\_147  
 ORDER 501 Item\_81  
 ORDER 228 Item\_16  
 ORDER 450 Item\_51  
 ORDER 112 Item\_28  
 ORDER 92 Item\_104  
 ORDER 131 Item\_130  
 ORDER 130 Item\_131

Kategori\_Item=1  
 ORDER 917 Item\_38  
 ORDER 1531 Item\_106  
 ORDER 726 Item\_50  
 ORDER 1277 Item\_72  
 ORDER 145 Item\_98  
 ORDER 439 Item\_97  
 ORDER 234 Item\_91  
 ORDER 1248 Item\_128  
 ORDER 591 Item\_90

ORDER 290 Item\_93  
 ORDER 190 Item\_45  
 ORDER 212 Item\_73  
 ORDER 218 Item\_43

\*\*\*\*\*  
 \* Attributes \*  
 \*\*\*\*\*

ID	Type	Classification
Kategori_Item	Integer	Entity

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

ID	Type	Initial value	Stats
jumlah_buffer	Real	0	Time Series
Status_Send1	Integer	1	Time Series
Status_Send2	Integer	1	Time Series
wipFS	Integer	0	Time Series
jumlah_buffer_preset	Real	0	Time Series

```
*****  
*                               Macros                               *  
*****
```

```
ID          Text  
-----  
buf_final_set 16
```



## ● Output Promodel (Skenario 4)

General Report

Output from D:\Maranatha\Kuliah\TA\Laporan\Promodel\Usulan\Modiff all usulan preset WIP asli last.MOD  
Date: Jan/17/2013 Time: 01:09:17 AM

Scenario : Normal Run  
Replication : 1 of 1  
Simulation Time : 11876.38

### LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Minutes Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
Gudang	11876.38	999999	18970	329202.75	8763.86	18926	0	0.88
Reeling.1	11876.38	1	2034	120.15	0.34	1	0	34.30
Reeling.2	11876.38	1	2008	120.60	0.33	1	0	33.99
Reeling.3	11876.38	1	2002	122.18	0.34	1	0	34.33
Reeling.4	11876.38	1	1974	122.62	0.33	1	0	33.97
Reeling	47505.53	4	8018	121.38	0.34	4	0	34.15
Relaxing A.1	11876.38	1	1373	199.92	0.38	1	0	38.52
Relaxing A.2	11876.38	1	1348	200.68	0.37	1	0	37.96
Relaxing A.3	11876.38	1	1346	203.26	0.38	1	0	38.39
Relaxing A.4	11876.38	1	1319	202.72	0.37	1	0	37.52
Relaxing A.5	11876.38	1	1317	203.77	0.37	1	0	37.66
Relaxing A.6	11876.38	1	1315	205.92	0.38	1	0	38.00
Relaxing A	71258.3	6	8018	202.69	0.38	6	0	38.01
Relaxing B.1	11876.38	1	2753	191.14	0.73	1	0	73.85
Relaxing B.2	11876.38	1	2749	193.29	0.74	1	0	74.57
Relaxing B.3	11876.38	1	2725	195.84	0.74	1	0	74.90
Relaxing B.4	11876.38	1	2724	197.77	0.75	1	0	75.60
Relaxing B	47505.53	4	10951	194.50	0.74	4	0	74.73
Hydro.1	11876.38	1	2692	102.22	0.38	1	0	38.62
Hydro.2	11876.38	1	2665	103.79	0.38	1	0	38.82
Hydro.3	11876.38	1	2661	106.51	0.39	1	0	39.78
Hydro	35629.15	3	8018	104.17	0.39	3	0	39.07
Sofcer	11876.38	1	4857	63.89	0.43	1	0	43.55
Unroll.1	11876.38	1	7041	75.03	0.74	1	0	74.15
Unroll.2	11876.38	1	6215	81.49	0.71	1	0	71.08
Unroll.3	11876.38	1	5713	86.34	0.69	1	0	69.22
Unroll	35629.15	3	18969	80.55	0.71	3	0	71.48
Pre Washing Drying	11876.38	1	9108	49.92	0.63	1	0	63.81
Preset.1	11876.38	1	9511	65.86	0.87	1	0	87.91
Preset.2	11876.38	1	9458	66.21	0.87	1	0	87.89
Preset	23752.76	2	18969	66.03	0.87	2	0	87.90
Hisaka WR.1	11876.38	1	3972	132.25	0.73	1	0	73.72
Hisaka WR.2	11876.38	1	3937	132.47	0.73	1	0	73.19
Hisaka WR.3	11876.38	1	3865	132.59	0.71	1	0	71.92
Hisaka WR	35629.15	3	11774	132.44	0.72	3	0	72.94
ST Tank.1	11876.38	1	4013	56.63	0.31	1	0	31.90
ST Tank.2	11876.38	1	2114	84.84	0.25	1	0	25.17
ST Tank.3	11876.38	1	537	259.70	0.19	1	0	19.57
ST Tank.4	11876.38	1	531	260.97	0.19	1	0	19.45
ST Tank	47505.53	4	7195	95.16	0.24	4	0	24.02
Dyeing Colour.1	11876.38	1	2611	195.19	0.71	1	0	71.52
Dyeing Colour.2	11876.38	1	2586	195.55	0.70	1	0	70.97
Dyeing Colour.3	11876.38	1	2556	195.93	0.70	1	0	70.28
Dyeing Colour.4	11876.38	1	2372	199.59	0.66	1	0	66.44
Dyeing Colour.5	11876.38	1	1605	222.57	0.50	1	0	50.13
Dyeing Colour.6	11876.38	1	1121	253.60	0.39	1	0	39.90
Dyeing Colour.7	11876.38	1	997	265.30	0.37	1	0	37.12
Dyeing Colour	83134.68	7	13848	209.10	0.58	7	0	58.05
FWD.1	11876.38	1	10929	56.54	0.86	1	0	86.72
FWD.2	11876.38	1	6680	67.04	0.62	1	0	62.85
FWD	23752.76	2	17609	60.52	0.74	2	0	74.79
Final Set.1	11876.38	1	11539	51.66	0.83	1	0	83.67
Final Set.2	11876.38	1	7430	60.90	0.63	1	0	63.51
Final Set	23752.76	2	18969	55.28	0.73	2	0	73.59
Heat Cut.1	11876.38	1	4248	20.00	0.11	1	0	11.92
Heat Cut.2	11876.38	1	675	20.00	0.01	1	0	1.89
Heat Cut	23752.76	2	4923	20.00	0.06	2	0	6.91
Folding.1	11876.38	1	837	45.00	0.05	1	0	5.29
Folding.2	11876.38	1	603	45.00	0.03	1	0	3.81
Folding.3	11876.38	1	388	45.00	0.02	1	0	2.45
Folding	35629.15	3	1828	45.00	0.03	3	0	3.85
Sablon.1	11876.38	1	3207	49.22	0.22	1	0	22.15
Sablon.2	11876.38	1	2558	49.74	0.17	1	0	17.86
Sablon.3	11876.38	1	444	49.54	0.03	1	0	3.09
Sablon	35629.15	3	6209	49.46	0.14	3	0	14.37
WIP Reeling	11876.38	21	8018	554.18	6.23	21	0	29.69
WIP Relaxing A	11876.38	6	7728	187.53	2.03	6	0	33.90
WIP Relaxing B	11876.38	14	10951	593.08	9.11	14	0	65.10
WIP Hydro	11876.38	7	8018	187.98	2.11	7	0	30.22
WIP Sofcer	11876.38	6	4857	324.00	2.20	6	0	36.81
WIP Unroll	11876.38	3	18969	69.98	1.86	3	0	62.10
WIP Pre Washing Drying	11876.38	4	9108	189.73	2.42	4	0	60.63
WIP Preset	11876.38	42	18969	794.66	21.15	42	0	50.37
WIP Hisaka WR	11876.38	6	11774	160.16	2.64	6	0	44.11
WIP ST Tank	11876.38	8	7195	137.48	1.38	8	0	17.35

WIP Dyeing Colour	11876.38	28	13848	307.80	5.98	28	0	21.36
WIP FWD	11876.38	18	17609	260.53	6.43	18	0	35.77
WIP Final Set	11876.38	42	18969	638.96	17.00	42	0	40.50
WIP Heat Cut	11876.38	4	4923	0.00	0	1	0	0.00
WIP Folding	11876.38	3	1828	0.07	0.00	1	0	0.01
Dyeing Black.1	11876.38	1	1167	240.15	0.39	1	0	39.33
Dyeing Black.2	11876.38	1	1150	242.00	0.39	1	0	39.06
Dyeing Black.3	11876.38	1	1129	243.72	0.38	1	0	38.61
Dyeing Black.4	11876.38	1	1087	247.69	0.37	1	0	37.78
Dyeing Black.5	11876.38	1	588	329.37	0.27	1	0	27.18
Dyeing Black	59381.91	5	5121	253.19	0.36	5	0	36.39
WIP Sablon	11876.38	6	6209	0.01	0.00	2	0	0.00
WIP Dyeing Black	11876.38	20	5121	572.61	4.11	20	0	20.58
Persiapan1	11876.38	1	8019	23.91	0.26	1	0	26.91
Pintu Gudang1	11876.38	1	8019	52.34	0.58	1	0	58.90
Pintu Gudang2	11876.38	1	10951	64.73	0.99	1	0	99.49
Persiapan2	11876.38	1	10951	38.13	0.58	1	0	58.61

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	% Empty	% Partially Occupied	% Full	% Down
Gudang	11876.38	0.52	99.48	0.00	0.00
WIP Reeling	11876.38	66.80	6.99	26.21	0.00
WIP Relaxing A	11876.38	64.75	3.25	32.00	0.00
WIP Relaxing B	11876.38	27.74	15.85	56.41	0.00
WIP Hydro	11876.38	64.94	8.76	26.31	0.00
WIP Sofcer	11876.38	58.50	8.86	32.64	0.00
WIP Unroll	11876.38	33.60	8.98	57.42	0.00
WIP Pre Washing Drying	11876.38	36.81	6.34	56.85	0.00
WIP Preset	11876.38	29.61	45.27	25.12	0.00
WIP Hisaka WR	11876.38	51.93	11.21	36.86	0.00
WIP ST Tank	11876.38	81.09	4.28	14.63	0.00
WIP Dyeing Colour	11876.38	71.72	11.89	16.39	0.00
WIP FWD	11876.38	58.96	10.70	30.34	0.00
WIP Final Set	11876.38	55.59	11.71	32.70	0.00
WIP Heat Cut	11876.38	100.00	0.00	0.00	0.00
WIP Folding	11876.38	99.98	0.02	0.00	0.00
WIP Sablon	11876.38	99.99	0.01	0.00	0.00
WIP Dyeing Black	11876.38	74.64	10.47	14.89	0.00

LOCATION STATES BY PERCENTAGE (Single Capacity/Tanks)

Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down
Reeling.1	11876.38	7.14	0.00	65.70	0.00	27.16	0.00
Reeling.2	11876.38	7.04	0.00	66.01	0.01	26.94	0.00
Reeling.3	11876.38	7.02	0.00	65.67	0.01	27.30	0.00
Reeling.4	11876.38	6.93	0.00	66.03	0.00	27.04	0.00
Reeling	47505.53	7.03	0.00	65.85	0.01	27.11	0.00
Relaxing A.1	11876.38	23.12	0.00	61.48	0.00	15.40	0.00
Relaxing A.2	11876.38	22.70	0.00	62.04	0.00	15.26	0.00
Relaxing A.3	11876.38	22.67	0.00	61.60	0.00	15.73	0.00
Relaxing A.4	11876.38	22.21	0.00	62.48	0.00	15.31	0.00
Relaxing A.5	11876.38	22.18	0.00	62.34	0.00	15.48	0.00
Relaxing A.6	11876.38	22.14	0.00	62.00	0.00	15.86	0.00
Relaxing A	71258.3	22.50	0.00	61.99	0.00	15.51	0.00
Relaxing B.1	11876.38	46.36	0.00	26.15	0.00	27.49	0.00
Relaxing B.2	11876.38	46.29	0.00	25.43	0.00	28.28	0.00
Relaxing B.3	11876.38	45.89	0.00	25.10	0.00	29.01	0.00
Relaxing B.4	11876.38	45.87	0.00	24.40	0.00	29.73	0.00
Relaxing B	47505.53	46.10	0.00	25.27	0.01	28.62	0.00
Hydro.1	11876.38	13.22	0.00	61.38	0.00	25.40	0.00
Hydro.2	11876.38	13.09	0.00	61.18	0.00	25.73	0.00
Hydro.3	11876.38	13.07	0.00	60.22	0.00	26.71	0.00
Hydro	35629.15	13.13	0.00	60.93	0.00	25.94	0.00
Sofcer	11876.38	13.63	0.00	56.45	0.00	29.92	0.00
Unroll.1	11876.38	24.70	0.00	25.85	0.01	49.44	0.00
Unroll.2	11876.38	21.80	0.00	28.92	0.01	49.27	0.00
Unroll.3	11876.38	20.04	0.00	30.78	0.00	49.18	0.00
Unroll	35629.15	22.18	0.00	28.52	0.00	49.30	0.00
Pre Washing Drying	11876.38	51.13	0.00	36.19	0.00	12.68	0.00
Preset.1	11876.38	60.06	0.00	12.09	0.00	27.85	0.00
Preset.2	11876.38	59.73	0.00	12.11	0.00	28.16	0.00
Preset	23752.76	59.90	0.00	12.10	0.00	28.00	0.00
Hisaka WR.1	11876.38	66.89	0.00	26.28	0.00	6.83	0.00
Hisaka WR.2	11876.38	66.30	0.00	26.81	0.00	6.89	0.00
Hisaka WR.3	11876.38	65.09	0.00	28.08	0.00	6.83	0.00
Hisaka WR	35629.15	66.09	0.00	27.06	0.00	6.85	0.00
ST Tank.1	11876.38	14.08	0.00	68.10	0.00	17.82	0.00
ST Tank.2	11876.38	7.42	0.00	74.83	0.00	17.75	0.00
ST Tank.3	11876.38	1.88	0.00	80.43	0.00	17.69	0.00
ST Tank.4	11876.38	1.86	0.00	80.55	0.01	17.58	0.00
ST Tank	47505.53	6.31	0.00	75.98	0.00	17.71	0.00
Dyeing Colour.1	11876.38	54.96	0.00	28.48	0.00	16.56	0.00
Dyeing Colour.2	11876.38	54.44	0.00	29.03	0.00	16.53	0.00
Dyeing Colour.3	11876.38	53.80	0.00	29.72	0.00	16.48	0.00
Dyeing Colour.4	11876.38	49.93	0.00	33.56	0.00	16.51	0.00
Dyeing Colour.5	11876.38	33.79	0.00	49.86	0.00	16.35	0.00

Dyeing Colour.6	11876.38	23.60	0.00	60.10	0.00	16.30	0.00
Dyeing Colour.7	11876.38	20.99	0.00	62.88	0.00	16.13	0.00
Dyeing Colour	83134.68	41.64	0.00	41.95	0.00	16.41	0.00
FWD.1	11876.38	61.35	0.00	13.28	0.00	25.37	0.00
FWD.2	11876.38	37.50	0.00	37.14	0.00	25.36	0.00
FWD	23752.76	49.42	0.00	25.21	0.01	25.36	0.00
Final Set.1	11876.38	83.67	0.00	16.33	0.00	0.00	0.00
Final Set.2	11876.38	63.51	0.00	36.49	0.00	0.00	0.00
Final Set	23752.76	73.59	0.00	26.41	0.00	0.00	0.00
Heat Cut.1	11876.38	11.92	0.00	88.08	0.00	0.00	0.00
Heat Cut.2	11876.38	1.89	0.00	98.11	0.00	0.00	0.00
Heat Cut	23752.76	6.91	0.00	93.09	0.00	0.00	0.00
Folding.1	11876.38	5.29	0.00	94.71	0.00	0.00	0.00
Folding.2	11876.38	3.81	0.00	96.19	0.00	0.00	0.00
Folding.3	11876.38	2.45	0.00	97.55	0.00	0.00	0.00
Folding	35629.15	3.85	0.00	96.15	0.00	0.00	0.00
Sablon.1	11876.38	22.15	0.00	77.85	0.00	0.00	0.00
Sablon.2	11876.38	17.86	0.00	82.14	0.00	0.00	0.00
Sablon.3	11876.38	3.09	0.00	96.91	0.00	0.00	0.00
Sablon	35629.15	14.37	0.00	85.63	0.00	0.00	0.00
Dyeing Black.1	11876.38	24.57	0.00	60.67	0.00	14.76	0.00
Dyeing Black.2	11876.38	24.21	0.00	60.94	0.00	14.85	0.00
Dyeing Black.3	11876.38	23.77	0.00	61.38	0.00	14.85	0.00
Dyeing Black.4	11876.38	22.88	0.00	62.22	0.00	14.90	0.00
Dyeing Black.5	11876.38	12.38	0.00	72.82	0.00	14.80	0.00
Dyeing Black	59381.91	21.56	0.00	63.61	0.00	14.83	0.00
Persiapan1	11876.38	0.00	0.00	73.09	0.00	26.91	0.00
Pintu Gudang1	11876.38	0.00	0.00	41.10	32.08	26.82	0.00
Pintu Gudang2	11876.38	0.00	0.00	0.51	41.25	58.24	0.00
Persiapan2	11876.38	0.00	0.00	41.39	0.00	58.61	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
work order	Gudang	0

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Minutes In System	Average Minutes In Move Logic	Average Minutes Wait For Res, etc.	Average Minutes In Operation	Average Minutes Blocked
Item 79	3401	0	171798.54	27.00	0.00	500.00	171271.54
Item 106	1531	0	74956.88	29.00	0.00	635.00	74292.88
Item 150	1828	0	418426.89	37.00	0.00	650.00	417739.89
Item 60	1381	0	512619.76	27.00	0.00	535.00	512057.76
Item 18	1557	0	578956.00	40.00	0.00	645.00	578271.00
Item 72	1277	0	190540.17	30.00	0.00	595.00	189915.17
Item 38	917	0	17153.39	30.00	0.00	500.00	16623.39
Item 97	439	0	232470.51	32.00	0.00	635.00	231803.51
Item 48	377	0	623347.95	33.00	0.00	730.00	622584.95
Item 81	501	0	655213.16	33.00	0.00	680.00	654500.16
Item 128	1248	0	301277.21	38.00	0.00	730.00	300509.21
Item 51	450	0	684477.65	31.00	0.00	575.00	683871.65
Item 28	112	0	696624.25	24.00	0.00	600.00	696000.25
Item 93	290	0	383216.16	37.00	0.00	750.00	382429.16
Item 6	412	0	477280.69	41.00	0.00	635.00	476604.69
Item 126	284	0	543463.47	34.00	0.00	460.00	542969.47
Item 50	726	0	140930.61	30.00	0.00	585.00	140315.61
Item 73	212	0	403716.81	37.00	0.00	685.00	402994.81
Item 98	145	0	218909.48	30.00	0.00	500.00	218379.48
Item 91	234	0	247580.89	34.00	0.00	500.00	247046.89
Item 90	591	0	362223.70	30.00	0.00	500.00	361693.70
Item 147	67	0	636869.00	39.00	0.00	460.00	636370.00
Item 104	92	0	702753.00	34.00	0.00	640.00	702079.00
Item 43	218	0	418463.46	39.00	0.00	750.00	417674.46
Item 16	228	0	674466.10	32.00	0.00	500.00	673934.10
Item 130	131	0	706616.18	34.00	0.00	555.00	706027.18
Item 131	130	0	710010.96	34.00	0.00	555.00	709421.96
Item 45	190	0	395751.89	30.00	0.00	500.00	395221.89
work order	1	0	0.00	0.00	0.00	0.00	0.00
Rest reeling	0	0	-	-	-	-	-

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked
Item 79	0.02	0.00	0.29	99.69
Item 106	0.04	0.00	0.85	99.11
Item 150	0.01	0.00	0.16	99.84
Item 60	0.01	0.00	0.10	99.89
Item 18	0.01	0.00	0.11	99.88
Item 72	0.02	0.00	0.31	99.67
Item 38	0.17	0.00	2.91	96.91
Item 97	0.01	0.00	0.27	99.71
Item 48	0.01	0.00	0.12	99.88

Item 81	0.01	0.00	0.10	99.89
Item 128	0.01	0.00	0.24	99.75
Item 51	0.00	0.00	0.08	99.91
Item 28	0.00	0.00	0.09	99.91
Item 93	0.01	0.00	0.20	99.79
Item 6	0.01	0.00	0.13	99.86
Item 126	0.01	0.00	0.08	99.91
Item 50	0.02	0.00	0.42	99.56
Item 73	0.01	0.00	0.17	99.82
Item 98	0.01	0.00	0.23	99.76
Item 91	0.01	0.00	0.20	99.78
Item 90	0.01	0.00	0.14	99.85
Item 147	0.01	0.00	0.07	99.92
Item 104	0.00	0.00	0.09	99.90
Item 43	0.01	0.00	0.18	99.81
Item 16	0.00	0.00	0.07	99.92
Item 130	0.00	0.00	0.08	99.92
Item 131	0.00	0.00	0.08	99.92
Item 45	0.01	0.00	0.13	99.87
work order	-	-	-	-
Rest reeling	-	-	-	-

VARIABLES

Variable Name	Total Changes	Average Minutes Per Change	Minimum Value	Maximum Value	Current Value	Average Value
jumlah buffer	37938	18.78	0	5880	0	1419.96
Status Send1	166	4287.00	0	1	1	0.53
Status Send2	166	4287.00	0	1	1	0.53
wipFS	37938	18.78	0	42	0	17.00
jumlah buffer preset	37938	18.76	0	1890	0	951.93