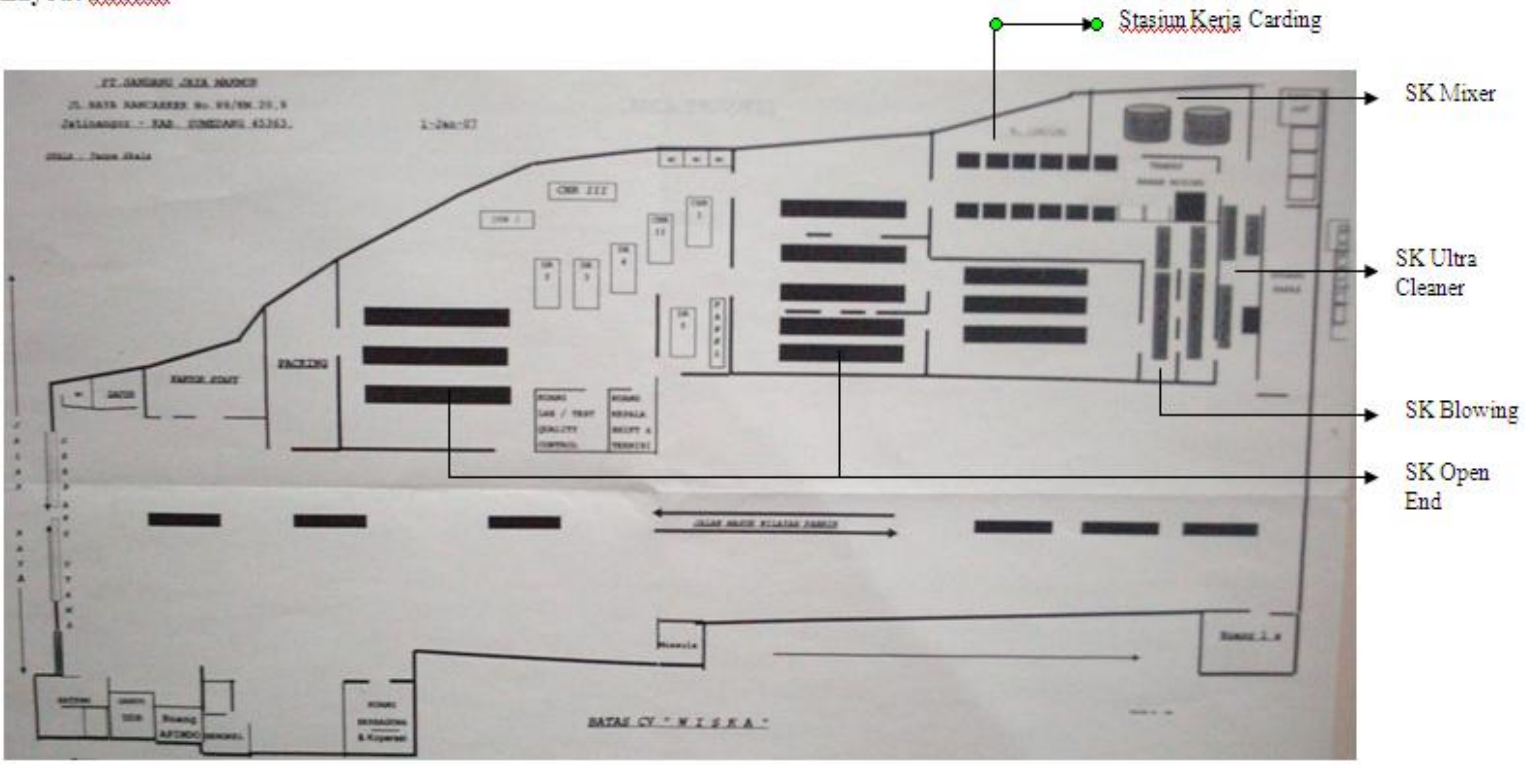
LAMPIRAN 1

Layout Pabrik

Layout Pabrik



Sumber : PT. Sandang Jaya Makmur, 2008.

LAMPIRAN 2

Spesifikasi Mesin Carding

- Spesifikasi Mesin Carding
- Spesifikasi Komponen Mesin Carding (FA201)
- Spesifikasi Belt Mesin Carding
- Spesifikasi Bearing Mesin Carding
- Spesifikasi Simbol Part Mesin
- Spesifikasi Komponen Elektrik Mesin Carding

- **Spesifikasi Mesin Carding**

No	Item	Specification	Notes
1	Hand of machine	Right hand	Facing the doffer its main driving pulley is on the right hand side
2	Cylinder width	1028 mm	width of cylinder
3	Lap	max diameter ø 550 mm	
4	Max	FA 172 A no reusable cotton waste	
5	Saltable for staple length	22-76 mm	
6	Length of the working surface of feed plate	28;30;32;46;68 mm	Five kinds. One is selected by the user
7	Diameter of feed roller	ø 70 mm	
8	Linear pressure of feed roller	3.32 - 55.9 N/cm	
9	Carding segments below the licker - in	Length 1022 mm	One group
		Width 70 mm	
		Gap between two teeth 3.2 mm	
		Tooth pitch 5 mm	
10	Working diameter of licker - in	ø 250 mm	Groove root diameter of naked roller ø 239 mm
11	Licker - in speed	930 r/miin (for cotton)	Belt pully's diameter is 209 mm
		800 r/min (for man - made fiber)	Belt pully's diameter is 224 mm
12	Working diameter of cylinder	ø1289 - ø1290 mm	ø1284 (bare)
13	Cylinder speed	360 r/min (for cotton)	Motor pully's ø136 mm
		330 r/min (for man - made fiber)	Motor pully's ø125mm
14	Working width of flat	22 mm	
15	Number of working flats / total no.of flats	41 / 106	
16	Flat speed	140.8; 184.1; 240.7	for cotton
		341.9 mm/min	
		72.3; 90.8	for chemical
		129.1 mm/min	
17	Working diameter of doffer	ø706 mm	ø698 mm (bare)
18	Doffer speed	18.9 - 36 r/min	
	Working frequency of doffer motor	30.5 - 58 Hz	
19	Doffer speed for piecing	6.2 ~ 9 r/min	
	Doffer motor's frequency for piecing	10.0 ~ 14.5 Hz	
20	Web stripping type	Three roller stripping	
21	Delivery type of the sliver	Front calender roll, or autoleveller (fit with chute)	
22	Delivery speed of the sliver	57.7 - 121.2 m/min	Working speed of doffer
23	Pre - carding segment	3 for front stationary flats	
		3 for back stationary flats	
24	Diameter of cleaning roller	ø86 mm	ø48 mm (bare) mounting of straight wirw flexible clothing no. 32 (width 19 mm)
25	Cleaning roller speed	2340 r/min	
26	Cylinder and doffer stripping method	By stripping roller on machine	
27	Working diameter of stripping roller	ø140 - 180 mm	
28	Coiler type	Rotating type coiler with general base plate, its diameter is in series to fit the can	
29	Can diameter	ø600 mm	
	height	900 mm, 1100 mm	one is to be selected by user
30	Total draft	67.5 - 120.5	

No	Item	Specification	Notes
31	Total installed power	6.67 kW	
32	Standard on motor about whole machine		
	Main motor FO2 - 72 - 49	3.3 kw; 1460 r/min	Driving cylinder, licker - in, flat
	Doffer motor FO3PS 132A - 4	1440 r/min	Driving doffer, roller, stripping roller, front calender, coiler and feed chute
	Motor for over card suction FO3 - 31C - 2F	2.0 kw; 2800 r/min	For four over card suction point
	Motor for cleaning roller FW 11 - 4	0.37 kw; 1400 r/min	double shaft
33	Sliver count	3.5 ~ 6.5 ktex	
34	Type of safety cover	Fully - enclosed	One is selected by user
		Semi - enclosed	
35	Suction points	Over card, licker - in, doffer, clearer roller, flat strips.	Exhausted by blower fan of single filter chamber
		Under card, front and back zone beneath card	
36	Suction air volume and pressure	(1) Outlet of blower fan of filter chamber, exhausted air volume 1800 m3/h	
		Static pressure 49 ~98 Pa	
		(2) Opening sucked intermittently from over card and under card, sucked air volume 2000 m3/h	
		Static pressure 1863 Pa	
37	Automatic stop motion devices	Layer overthick, licker - in, speed down, fiber accumulation, broken sliver, clogging tube and electric automatic stop	
38	Production rate	up to 40 kg/h	
39	Space requirement	Length 3523 x width 2096 mm	
40	Machine weight	Approx. 4500 kg	

- **Spesifikasi Komponen Mesin Carding (FA201)**

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
Wear Parts			
FA201 - 0405	Friction liner	8	
FA201 - 0509	Flat belt	2	(4 x 50 x 3930)
FA201 - 3319	Flat	10	
FA201 - 3715	Worm	2	
FA201 - 3716	Bevel gear	2	
FA201 - 3724	Flat belt for driving flat	2	(3 x 40 x 1600)
FA201 - 3737	Bevel gear	2	
FA201 - 3739	Worm	2	
FA201 - 3750	Bearing	2	
FA201 - 4203	Driving gear	2	
FA201 - 4204	Roller gear	2	
FA201 - 4538	Gear	2	
FA201 - 4539	Gear	2	
FA201 - 4637	Gear	2	
FA201 - 4638	Gear	2	
FA201 - 4671	Scraper	10	
AI86F - 6125	Worm	2	
AI86F - 6126	Worm wheel	2	
AI86F - 6218	Helical gear	2	
AI86F - 6221	Gear	2	
AI86F - 6259	Helical gear	2	
Circulative parts clutch			
FA201 - 0400	Parts of centrifugal friction	1 set	
QFT204 - 0000(A/B)	Carding segment unit	1	A. for cotton
			B. for chemical fiber optional
	Feed roller feed plate baffle	1 set	Assembly select one set of them according to user's order for supply
FA201 - 1200 - 1	Supporting plate unit	1 set	For cotton or 38 mm chemical fiber. Belong to feed unit set
FA201 - 1200 - 4	Feed roller unit	(1)	
FA201 - 1201	Feed plate (32 mm)	(1)	
FA201 - 1211	Feed plate leg (Left 1)	(1)	
FA201 - 1214	Feed plate leg (Right 1)	(1)	
FA201 - 1242	Bearing retaining plate (1)	(2)	
FA201 - 1200 - 1	Supporting plate unit	(1)	For cotton. Belong to feed unit set
FA201 - 1200 - 4	Feed roller unit	(1)	
FA201 - 1202	Feed plate (30 mm)	(1)	
FA201 - 1212	Feed plate leg (Left 2)	(1)	
FA201 - 1215	Feed plate leg (Right 2)	(1)	
FA201 - 1243	Bearing retaining plate (2)	(2)	
FA201 - 1200 - 1	Supporting plate unit	(1)	For cotton. Belong to feed unit set
FA201 - 1200 - 4	Feed roller unit	(1)	
FA201 - 1203	Feed plate (28 mm)	(1)	
FA201 - 1213	Feed plate leg (Left 3)	(1)	
FA201 - 1216	Feed plate leg (Right 3)	(1)	
FA201 - 1244	Bearing retaining plate (3)	(2)	
FA201 - 1200 - 1	Supporting plate unit	(1)	For 51 mm chemical fiber. Belong to feed unit set
FA201 - 1200 - 4	Feed roller unit	(1)	
FA201 - 1204	Feed plate (46 mm)	(1)	
FA201 - 1212	Feed plate leg (Left 2)	(1)	
FA201 - 1215	Feed plate leg (Right 2)	(1)	
FA201 - 1245	Bearing retaining plate (4)	(2)	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
FA201 - 1200 - 1	Supporting plate unit	(1)	For 65 mm chemical fiber. Belong to feed unit set
FA201 - 1200 - 4	Feed roller unit	(1)	
FA201 - 1205	Feed plate (60 mm)	(1)	
FA201 - 1212	Feed plate leg (Left 2)	(1)	
FA201 - 1215	Feed plate leg (Right 2)	(1)	
FA201 - 1246	Bearing retaining plate (5)	(2)	
FA201 - 1206	Supporting plate	(1)	Belong to -1200 - 1
FA201 - 1207	Baffle	(2)	
FA201 - 1237	Feed roller	(1)	Belong to - 1200 - 4
FA201 - 1250	Feed roller end piece	(1)	
FA201 - 1251	Feed roller end piece	(1)	
FA201 - 1238	Feed roller bearing outer sleeve	(2)	Belong to feed unit set
FA201 - 1241	Bearing retaining seat	(2)	
FA201 - 1248	Feed roller bearing cap	(2)	
FA201 - 1249	Feed roller bearing inner sleeve	(2)	
GB5783	Bolt M10 x 25	(4)	Belong to feed unit set
GB899	Stud M10 x 30	(4)	
GB70	Screw M8 x 20	(6)	
GB819	Screw M6 x 12	(13)	
GB6170	Nut M10	(4)	
GB97.1	Washer 10	(8)	
GB117	Pin A5 x 25	(2)	
GB290 - 64	Bearing 945 / 35	(2)	
GB1152 - 79	Grease cup M6	(2)	
Driving box for flat		1 set	Assembly
FA201 - 3706	Bearing cap	(1)	
FA201 - 3707A	Shaft	(1)	
FA201 - 3708	Change gear box	(1)	
FA201 - 3709A	Change gear box cover	(1)	
FA201 - 3715	Worm	(1)	
FA201 - 3716	Bevel gear	(1)	
FA201 - 3717	Cap	(1)	
FA201 - 3728	Box cover	(1)	
FA201 - 3729	End cap	(1)	
FA201 - 3730	Nut	(1)	
FA201 - 3737	Bevel gear	(1)	
FA201 - 3738	Flat driving mandrol	(1)	
FA201 - 3739	Worm	(1)	
FA201 - 3740	Change gear (18T)	(1)	
FA201 - 3741	Bearing cap	(1)	
FA201 - 3745	Oil seal gasket	(1)	
FA201 - 3746	Oil seal gasket	(1)	
FA201 - 3747	Clutch	(1)	
FA201 - 3748	Handle wheel	(1)	
FA201 - 3749	Spring	(1)	
FA201 - 3750	Bearing	(1)	
FA201 - 3756	Thin Collar	(1)	
FA201 - 3757	Thick Collar	(1)	
FA201 - 3758	Worm gear shaft	(1)	
FA201 - 3759	Flat drive gear box boby	(1)	
FA201 - 3760	Change gear (21T)	(1)	
FA201 - 3761	Change gear (26T)	(1)	
FA201 - 3762	Change gear (30T)	(2)	
FA201 - 3763	Change gear (34T)	(1)	
FA201 - 3764	Change gear (39T)	(1)	
FA201 - 3765	Change gear (42T)	(1)	
FA201 - 3766	End cap	1 set	
FA201 - 3767	Sleeve	(1)	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
FA201 - 3768	Cap	(1)	
FA201 - 3770	Collar	(1)	
GB5783	Sleeve	(1)	
GB5783	Bolt M5 x 16	(1)	
GB5783	Bolt M6 x 16	(4)	
GB5783	Bolt M6 x 20	(3)	
GB5783	Bolt M10 x 25	(1)	
GB5783	Bolt M10 x 35	(1)	
GB77	Screw M8 x 10	(2)	
GB819	Screw M5 x 12	(1)	
GB819	Screw M6 x 10	(3)	
GB819	Screw M6 x 30	(3)	
GB822	Screw M5 x 8	(3)	
GB822	Screw M6 x 12	(6)	
GB812	Nut M20 x 1.5	(1)	
GB93	Washer 5	(1)	
GB97.1	Washer 6	(4)	
GB97.1	Washer 10	(2)	
GB117	Pin A5 x 40	(1)	
GB1096 - 76	Key 8 x 32	(2)	
GB1096 - 76	Key 8 x 35	(1)	
GB891	Stop washer B22	(1)	
GB893.1	Stop washer B42	(1)	
GB894.1	Stop washer B25	(1)	
FZ/T92010 - 91	Felt packing ring 40	(1)	
FZ/T92008 - 91	Washer 10	(2)	
FZ/T92009 - 91	Oil drain plug M10 x 1	(4)	
GB1152 - 73	Grease cup M6	(1)	
GB1160.2	Oil mark A20	(2)	
FZ/T92050 - 95	Powder matallurgy bearing (brass 25 x 25)	(1)	
GB276 - 89	Bearing 204	(1)	
GB276 - 89	Bearing 205	(1)	
GB292 - 83	Bearing 46205	(1)	
GB301 - 84	Bearing 8205	(1)	
Spareparts			
FA201 - 0100 - 14	Magnet unit	(10)	
FA201 - 0162	Magnetic iron	(10)	Belong to 0100 - 14
FA201 - 0163	Magnetic iron cover	(10)	Belong to 0100 - 14
FA201 - 0100 - 46	Pneumatic rot unit	(2)	For sealed safety cover
FA201 - 0164	Spring	10	
AI86G - 1100 - 1A	Licker - in roller undercasing unit	1	
AI86G - 1101 - 1A	Licker - in roller undercasing	(1)	Belong to AI86G - 1100 - 1A
AI86G - 1102 - 1A	Licker - in roller end place	(2)	
AI86F - 1115	Movable brocket for mote knife	(1)	
AI86F - 1116	Movable brocket for mote knife	(1)	
AI86F - 1119	mote knife	1	
FA201 - 3200 - 8A	mote knife unit	1	Belong to - 3200 - 8A
FA201 - 3241A	mote knife	1	
FA201 - 3242	Cotton washer	1	
FA201 - 3243	Connecting plate (1)	1	
FA201 - 3244	Connecting plate (2)	1	
FA201 - 1100 - 1A	Licker - in roller unit	1	Belong to - 1100 - 1A
FA201 - 1101	Licker - in roller body	1	
FA201 - 1102	Licker - in roller end piece	2	
FA201 - 1103	Insent plate for licker - in roller	2	
FA201 - 1104	Licker - in roller shaft	1	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
FA201 - 1105	Balance iron piece (thick 110 mm)	enough	Belong to - 1100 - 1A
FA201 - 1106	Balance iron piece (thick 12 mm)	enough	
FA201 - 1107	Balance iron piece (thick 15 mm)	enough	
FA201 - 1122	Bolt	4	
GB5783	Bolt M12 x 25	enough	
GB5783	Bolt M12 x 40	enough	
GB70	Screw M8 x 20	(8)	
GB70	Screw M10 x 30	(8)	
GB55 40 Cr	Nut M16	(4)	
GB93	Washer 8	(8)	
GB93	Washer 12	enough	
GB93	Washer 16	(4)	
GB5783	Bolt M12 x 20	enough	
GB5783	Bolt M12 x 30	enough	
FA201 - 1108	Inner bearing sleeve	2	
FA201 - 1119	Licker - in roller bearing adjusting bolt	2	
FA201 - 1200 - 2	Limit switch unit (Left)	1	
FA201 - 1200 - 3	Limit switch unit (Right)	1	
FA201 - 1232	Switch pressed rod	(2)	Belong to - 1200 - 2; - 3
FA201 - 1233	Switch seat (Left)	(1)	Belong to - 1200 - 2
FA201 - 1234	Compression spring	2	Belong to - 1200 - 2; - 3
FA201 - 1235	Switch piece	2	Belong to - 1200 - 2; - 3
FA201 - 1236	Little cover (Left)	1	Belong to - 1200 - 2
FA201 - 1239	Switch seat (Right)	1	Belong to - 1200 - 3
FA201 - 1240	Little cover (Right)	1	
GB822	Screw M4 x 8	2	Belong to - 1200 - 2; - 3
GB6170	Nut M4	2	
GB93	Washer 4	2	
GB97.1	Washer 4	2	
GB119	Pin D3 x 16	2	
FA201 - 1226	Compression spring	2	
FA201 - 1227	Loasing arm	2	
FA201 - 1241	Bearing retaining seat	2	
FA201 - 1242	Bearing retaining	2	
FA201 - 1246	Plate (1~5)	2	For 1201 - 1205, supply in order
FA201 - 1300 - 1	Knob unit	3	
FA201 - 1311	Knob	3	Belong to - 1200 - 1
FA201 - 1312	Stud	3	
FA201 - 2215	Flat head bolt	5	
FA201 - 2216	Flat head bolt	5	
FA201 - 2217	Flat head bolt	5	
FA201 - 2218	Flat head bolt	15	
FA201 - 2219	Flat head bolt	15	
FA201 - 2220	Flat head bolt	5	
FA201 - 2221	Balance weight (1)	10	
FA201 - 2222	Balance weight (2)	10	
FA201 - 2226	Fixing bolt	4	
FA201 - 2300 - 1A	Cylinder undercasing unit (back)	1	
FA201 - 2300 - 2	Cylinder undercasing unit (back)	1	
FA201 - 2300 - 3	Narrow sheet unit for sylinder undercasing	(2)	Belong to - 2300 - 1; - 2
FA201 - 2308	Inclined dustbar for sylinder undercasing	(12)	Belong to - 2300 - 1

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
FA201 - 2309	Straight dustbar for sylinder undercasing	(36)	Belong to - 2300 - 1; - 2
FA201 - 2310	Inclined dustbar for sylinder undercasing	(1)	Belong - 2300 - 1
FA201 - 2311A	Back cylinder undercasing side plate	(2)	
FA201 - 2312A	Iron sheet of cylinder undercasing (back)	(1)	
FA201 - 2313	Side plate for cylinder undercasing (front)	(2)	Belong - 2300 - 2
FA201 - 2314	Iron sheet of cylinder undercasing (front)	(1)	
FA201 - 2315	Narrow sheet of cylinder undercasing	(2)	Belong - 2300 - 3
FA201 - 2316	Reinforcing iron plate	(4)	
FA201 - 2301	Cylinder undercasing bracket seat	1	
FA201 - 2302	Cylinder undercasing bracket seat	1	
FA201 - 2304	Pin	2	
FA201 - 2306	Eccentric sleeve seat (1)	1	
FA201 - 2307	Eccentric sleeve seat (2)	1	
FA201 - 3100 - 1A	Rear fixed flat unit	3	
AFF01 - 00 (1)	Rear fixed flat wire clothing	(3)	Belong to - 3100 - 1A
FA201 - 3123A	Rear fixed flat	(3)	
FA201 - 3137	Clamping sheet	(6)	
FA201 - 3143	Sealed plate	(6)	
FA201 - 3100 - 3	Back sheet unit (upper)	(1)	
FA201 - 3107A	Back sheet (upper)	(1)	Belong to - 3100 - 3
FA201 - 3100 - 4	Back sheet unit (lower)	(1)	
FA201 - 3108A	Back sheet (upper)	(1)	Belong to - 3100 - 4
FA201 - 3145	Back sheet strengthen plate (upper)	(2)	
FA201 - 3106	Adjusting stud	2	
FA201 - 3117A	Fulcrum bracket sor flexible bend	1	
FA201 - 3119	Adjusting screw	1	
FA201 - 3120	Flexible bend adjust screw	1	
FA201 - 3124	Flexible bend bracket	1	
FA201 - 3127	Adjusting stud	2	
FA201 - 3129	Adjusting stand for back concentric bend	1	
FA201 - 3131	Pad plate (1) $\delta = 0.05$	20	
FA201 - 3132	Pad plate (2) $\delta = 0.08$	20	
FA201 - 3133	Pad plate (3) $\delta = 0.1$	20	
FA201 - 3134	Pad plate (4) $\delta = 0.5$	20	
FA201 - 3135	Pad plate (5) $\delta = 0.2$	20	
FA201 - 3200 - 2	Front sheet unit	1	
FA201 - 3200 - 1	Cylinder stripping door unit	(1)	Belong to - 3200 - 2
FA201 - 3206	Cylinder stripping door	(1)	Belong to - 3200 - 1
FA201 - 3207	Cylinder stripping arm (Right)	(1)	
FA201 - 3208	Cylinder stripping arm (Left)	(1)	
FA201 - 3222	Top feather - edge sheet	(1)	Belong to - 3200 - 2
FA201 - 1300 - 1	Knob unit	(1)	Belong to - 3200 - 1
FA201 - 1311	Knob	(1)	
FA201 - 1312	Stud	(1)	
GB867	Rivet 5 x 26	(4)	
FA201 - 3200 - 3	Knob unit	1	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
FA201 - 3232	Knob	1	Belong to - 3100 - 3
GB6170	Nut M5	1	
FA201 - 2300 - 5A	Front fixed flat unit	3	
AFF01 - 00 (3)	Front fixed flat wire	3	Belong to - 3100 - 5A
FA201 - 3227A	Front fixed flat	3	
FA201 - 3137	Clamping sheet	6	
FA201 - 3143	Sealed plate	6	
FA201 - 3200 - 7	Front sheet unit (lower)	1	Belong to - 3100 - 7
FA201 - 3205A	Front sheet (lower)	1	
FA201 - 3240	Front sheet strengthen plate	1	
FA201 - 3210A	Pin shaft	1	
FA201 - 3225	Square neck adjusting bolt	2	
FA201 - 3229	Pin bracket for stripping door	1	
FA201 - 3230	Spring	1	
FA201 - 3231A	Shaft sleeve	1	
FA201 - 3300 - 1	Flat chain unit	2	
FA201 - 3315	Link for flat chain	(424)	Belong to - 3100 - 1
FA201 - 3316	Chain sleeve	(212)	
GB894.1	Stop washer 14	(424)	
FA201 - 3317	Flat screw (Left)	50	
FA201 - 3318	Flat screw (Right)	50	
FA201 - 3319A	Flat	50	
FA201 - 3600 - 1	Flat end cleaning brush unit	2	
FA201 - 3608	Cleaning brush	(2)	Belong to - 3600 - 1
FA201 - 3609	Cleaning brush hair	enough	
FA201 - 3610	Cleaning brush hair	enough	
FA201 - 3611	Cleaning brush hair	enough	
FA201 - 3612	Cleaning brush hair	enough	
FA201 - 3616	Graphite piece	10	
FA201 - 3617	Graphite box frame	2	
FA201 - 3700 - 1	Stripping comb arm unit (Right)	2	
FA201 - 3700 - 2	Stripping comb arm unit (Left)	2	
FA201 - 3735	Stripping comb rocking arm head	(2)	Belong to - 3700 - 1; -2
FA201 - 3736	Stripping comb rocking arm lever (Right)	(1)	Belong to - 3700 - 1
FA201 - 3752	Stripping comb rocking arm lever (Left)	(1)	Belong to - 3700 - 2
GB119	Pin C3 x 40	(2)	Belong to - 3700 - 1; -2
FA201 - 3734	Upper stripping comb	1	
FA201 - 3749	Spring	1	
FA201 - 3800 - 1	Flat stripping brush unit	1	
FA201 - 3805	Flat stripping brush shaft	(1)	Belong to - 3800 - 1
FA201 - 3815	Flat stripping brush unit wood rod	(2)	
FA201 - 3816	Flat stripping brush unit wood rod	(8)	
FA201 - 3817	Flat stripping brush unit long hair	enough	
FA201 - 3818	Flat stripping brush unit short hair	enough	
FA201 - 3819	Shape nail	(660)	
FA201 - 3830	Washer	(2)	
FA201 - 3833	Pin	(18)	
GB812	Nut M24 x 1.5	(2)	
FA201 - 3801A	Flat stripping brush pulley	1	
FA201 - 3824	Comb wire needle	5	
FA201 - 4105	Bearing sleeve	2	
FA201 - 4108	Doffer gear	1	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
FA201 - 4127	Stud	2	
FA201 - 4128	Bevel gear (42T)	1	
FA201 - 4130	Sleeve	1	
FA201 - 4132	Doffer shaft hand wheel	1	
FA201 - 4153	Gear (58T)	1	
FA201 - 4159	Adjusting washer	4	
FA201 - 4234	21T draft gear	1	
FA201 - 4235	20T draft gear	1	
FA201 - 4236	19T draft gear	1	
FA201 - 4301	Bottom calender gear	1	
FA201 - 4302	Top calender gear	1	
FA201 - 4303	Big calender	2	
FA201 - 4308	Big calender trumpet	1	
FA201 - 4405	Safety leaning roller	1	
FA201 - 4406	Pressing plate	4	
FA201 - 4408	Wire cloth of the cleaner roller	2 set	
FA201 - 4517	Change gear (30T)	1	
FA201 - 4600 - B	Stripping roller unit	1	For cotton
FA201 - 4601 - B	End piece (1)	1	Belong to - 4600 - 1B for cotton
FA201 - 4602	Stripping roller body	1	
FA201 - 4603 - B	End piece (2)	1	
FA201 - 4600 - 2A	Bottom squeegee roller unit	1	
FA201 - 4604A	End piece (3)	1	Belong to - 4600 - 2B for cotton
FA201 - 4605A	Bottom squeegee body	1	
FA201 - 4606A	End piece (4)	1	
FA201 - 4600 - 3A	Top squeegee roller unit	1	
FA201 - 4607A	End piece (5)	1	Belong to - 4600 - 3A for cotton
FA201 - 4608A	Top squeegee roller body	1	
FA201 - 4609A	End piece (6)	1	
FA201 - 4600 - 4A	Stripping roller unit	1	For chemical fiber
FA201 - 4602	Stripping roller body	1	Belong to - 4600 - 4A
FA201 - 4673A	End piece (1)	1	Belong to - 4600 - 4A for chemical fiber
FA201 - 4674A	End piece (2)	1	
FA201 - 4600 - 5	Bottom squeegee roller unit	1	For chemical fiber
FA201 - 4605A	Bottom squeegee roller body	1	Belong to - 4600 - 5 for chemical fiber
FA201 - 4675	End piece (3)	1	
FA201 - 4676	End piece (4)	1	
FA201 - 4600 - 6	Top squeegee roller unit	1	For chemical fiber
FA201 - 4608A	Top squeegee roller body	1	Belong to - 4600 - 6 for chemical fiber
FA201 - 4677	End piece (5)	1	
FA201 - 4678	End piece (6)	1	
FA201 - 4619	Tension spring	2	
FA201 - 4644	Spring pillar	2	
FA201 - 4645	Compession spring	2	
FA201 - 4646	Pressing cup	2	
FA201 - 4706	ø70 blast tube	1	800 mm long
FA201 - 4708	ø80 blast tube	1	1200 mm long
FA201 - 4711	ø80 blast tube	1	1000 mm long
FA201 - 4723	ø80 blast tube	1	400 mm long
FA201 - 47201	Buffer	2	
FA201 - 47232	Adjusting washer	5	Belong to - 4700 - 1C
FA201 - 47233	Screw	1	
FA201 - 6149	30T carrier gear	1	
FA201 - 6263	Pin	3	
FA201 - 6268	Tension spring	1	
Q/QD J010805 - 91	Adjusting washer 12 x 22	2	
Q/QD J010805 - 91	Adjusting washer 25 x 32	10	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
Q/QD J010805 - 91	Adjusting washer 30 x 40	10	
GB1171 - 74	V - belt A - 900	1	
GB1171 - 74	V - belt A - 1120	1	For can in height 900 mm
GB1171 - 74	V - belt A - 1600	1	
GB1171 - 74	V - belt O - 1250	1	
GB1171 - 74	V - belt O - 1250	2	For can in height 1100 mm
GB1171 - 74	V - belt O - 1700	2	
GB1152 - 79	Grease cup M6	10	
GB1152 - 79	Grease cup M8 x 1	3	
GB1155 - 74	Grease cup (ø5 steel ball high level > 0.8)	1	
GB1160.2	Oil mark A20	2	
FZ/T92010 - 91	Felt packing ring 18	1	
FZ/T92010 - 91	Felt packing ring 20	1	
FZ/T92010 - 91	Felt packing ring 22	1	
FZ/T92010 - 91	Felt packing ring 25	2	
FZ/T92010 - 91	Felt packing ring 28	1	
FZ/T92010 - 91	Felt packing ring 30	5	
FZ/T92010 - 91	Felt packing ring 32	2	
FZ/T92010 - 91	Felt packing ring 35	1	
FZ/T92010 - 91	Felt packing ring 40	2	
FZ/T92010 - 91	Felt packing ring 45	1	
FZ/T92010 - 91	Felt packing ring 48	1	
FZ/T92010 - 91	Felt packing ring 50	1	
FZ/T92010 - 91	Felt packing ring 55	1	
FZ/T92010 - 91	Felt packing ring 60	1	
FZ/T92010 - 91	Felt packing ring 65	1	
FZ/T92010 - 91	Felt packing ring 85	1	
FZ/T92005 - 91	Bush for oil plug 10	1	
FZ/T92009 - 91	Oil pulg M10 x 1	2	
FZ/T92050 - 91	Power metallurgy bearing 25 x 25 Cu	1	
GB276 - 89	Rolling bearing 18	2	
GB276 - 89	Rolling bearing 102	1	
GB276 - 89	Rolling bearing 103	2	
GB276 - 89	Rolling bearing 104	4	
GB276 - 89	Rolling bearing 105	2	
GB276 - 89	Rolling bearing 111	1	
GB276 - 89	Rolling bearing 112	1	
GB276 - 89	Rolling bearing 130	1	
GB276 - 89	Rolling bearing 202	1	
GB276 - 89	Rolling bearing 204	2	
GB276 - 89	Rolling bearing 205	4	
GB276 - 89	Rolling bearing 206	1	
GB276 - 89	Rolling bearing 207	1	
GB276 - 89	Rolling bearing 60018	2	
GB281- 84	Rolling bearing 1204	1	
GB281- 84	Rolling bearing 1205	3	
GB281- 84	Rolling bearing 1505	1	
GB281- 84	Rolling bearing 1510	1	
GB286- 64	Rolling bearing 3508	1	
GB286- 64	Rolling bearing 2E3613	2	
GB290- 64	Rolling bearing 942/20	1	
GB290- 64	Rolling bearing 943/20	1	
GB290- 64	Rolling bearing 943/35	1	
GB292- 83	Rolling bearing 46103	1	
GB292- 83	Rolling bearing 45205	1	
GB301- 84	Rolling bearing 8122	1	
GB301- 84	Rolling bearing 8205	1	

Part No	Name	No.of cards equipped 10 no.of spare parts	Note
GB301- 84	Rolling bearing 7941/10	1	
GB301- 84	Rolling bearing 7941/14	1	
GB301- 84	Rolling bearing 7941/12	1	
GB301- 84	Rolling bearing 7941/15	1	
GB301- 84	Rolling bearing 7941/30	2	
GB301- 84	Rolling bearing 7941/20	1	
GB301- 84	Rolling bearing 7941/25	1	
KIBEA	Vertical rolling bearing of short leg 9Q 505	2	

- **Spesifikasi Belt Mesin Carding**

Name	Specification	Q/set	Note
Flat belt	Strengthen nylon belt 4 x 50 x 3930 (calculated inner legth) (actual inner length should be obtained by deducting the decrenebt of 1 % from calculated inner length)	1	Used for driving cylinder
Flat belt	Nylon belt 3 x 40 x 1600	1	Used for driving flat
V - belt	A - 1120	1	Used for driving clearer roller
V - belt	A - 1600	1	Used for driving coiler
V - belt	A - 1700	2	Used for driving doffer
V - belt	O - 1250	3	1 piece used for driving spiral brush; 2 piece used for driving coiler suitable for can in height 900 mm
V - belt	O - 1700	2	Used for driving coiler suitable for can in height 1100 mm
V - belt	A - 900	1	Used for driving coiler

- **Spesifikasi Bearing Mesin Carding**

Standard Symbol	Type	Q / set	Used in part
GB276 - 89	18	6	FA201 - 0100 - 4700C; AI86F - 6200
GB276 - 89	102	4/6	FA201 - 6100A 4 is for can in height 900 mm
			FA201 - 6100A 6 is for can in height 1100 mm
GB276 - 89	103	6	FA201 - 6100A; AI86F - 6200
GB276 - 89	104	10	FA201 - 6100A; AI86F - 6200
GB276 - 89	0105	4	FA201 - 4300A
GB276 - 89	111	2	FA201 - 0400
GB276 - 89	112	1	FA201 - 6100A
GB276 - 89	130	1	AI86F - 6200
GB276 - 89	202	1	FA201 - 3800
GB276 - 89	204	6	FA201 - 3700; -3800; -6100A
GB276 - 89	205	9	FA201 - 3700; -4100; -4500B
GB276 - 89	206	2	FA201 - 4500B
GB276 - 89	207	2	FA201 - 0500
GB278 - 89	60018	2	FA201 - 3700
GB281 - 84	1204	2	FA201 - 4400
GB281 - 84	1205	8	FA201 - 3700; -4600B or -4500C
GB281 - 84	1505	2	FA201 - 1300
GB281 - 84	1510	2	FA201 - 4100
GB286 - 64	3508	2	FA201 - 1100A
GB286 - 64	2E3613	2	FA201 - 2200A
GB290 - 64	942/20	2	FA201 - 4300A
GB290 - 64	943/20	2	FA201 - 1200
GB290 - 64	943/35	2	FA201 - 1200 or FA201 - 1400
GB292 - 83	46103	2	FA201 - 6100A
GB292 - 83	46205	1	FA201 - 3700
GB301 - 84	8205	1	FA201 - 3700
GB301 - 84	8122	1	FA201 - 6100A
	7941/10	1	FA201 - 3700
	7941/14	3	FA201 - 3700
	7942/12	4	FA201 - 3600
	7942/15	2	FA201 - 3700
	7942/30	6	FA201 - 3300; -3500; -3600
	7943/20	2	FA201 - 3700
	7943/25	1	FA201 - 3700
KIBZA	90505	2	FA201 - 4300A

- **Spesifikasi Simbol Part Mesin Carding**

Symbol	Name	Specification	Remark
FA201 - 1201	Feed plate (1)	Length of the working surface 32 mm	For cotton of 38 mm for chemical fiber
FA201 - 1202	Feed plate (2)	Length of the working surface 30 mm	For cotton
FA201 - 1203	Feed plate (3)	Length of the working surface 28 mm	For cotton
FA201 - 1204	Feed plate (4)	Length of the working surface 46 mm	For 51 - 60 mm medium length fiber
FA201 - 1205	Feed plate (5)	Length of the working surface 60 mm	For 61 - 76 mm medium length fiber
FA201 - 1242	Bearing fixing plate (1)		Fit for FA201 - 1201
FA201 - 1243	Bearing fixing plate (2)		Fit for FA201 - 1202
FA201 - 1244	Bearing fixing plate (3)		Fit for FA201 - 1203
FA201 - 1245	Bearing fixing plate (4)		Fit for FA201 - 1204
FA201 - 1246	Bearing fixing plate (5)		Fit for FA201 - 1205
FA201 - 1211	Feed plat leg (L1)		Fit for FA201 - 1201
FA201 - 1212	Feed plat leg (L2)		Fit for FA201 - 1202; - 1204; -1205
FA201 - 1213	Feed plat leg (L3)		Fit for FA201 - 1203
FA201 - 1214	Feed plat leg (R1)		Fit for FA201 - 1201
FA201 - 1215	Feed plat leg (R2)		Fit for FA201 - 1202; - 1204; -1205
FA201 - 1216	Feed plat leg (R3)		Fit for FA201 - 1203
FA201 - 0100	Safety cover unit (right)	Semi - enclosed	
FA201 - 0200	Safety cover unit (left)		
FA201 - 0100A	Right - side safety cover and top cover unit	Fully - enclosed	
FA201 - 0200A	Left - side safety cover		
FA201 - 609 - 6100A	Column unit	Fit for can in height 900 mm	One is to be selected by user
FA201 - 611 - 6100A	Column unit	Fit for can in height 1100 mm	

- **Spesifikasi Komponen Elektrik Mesin Carding**

Symbol	Name	Q	Q/set	Note
8212E	Inverter	1	1	
LR2 - D1306N	Thermal Relay	1	1	1 - 1.6 A
LR2 - D1310N	Thermal Relay	1	1	4 - 6 A
LR2 - D1312N	Thermal Relay	1	1	5.5 - 8A
RL1 - 60	Fuse Link	3	3	
am1	Fuse Link	3	5	
am1	Fuse Link	3	5	
am1	Fuse Link	3	3	
QD12 - 5	Lamp	4	10	
YT701 - 5W	Signal Lamp	1	1	
YT701 - 511D	Signal Lamp	1	1	
CA2 - DN31M7N - LA1 - DN11C	Relay	1	1	
CA2 - DN31M7N	Relay	1	1	
HH53 - TP511X	Relay	2	2	~ 12 V
LC1 - D0910M7N - LA1 - DN11C	AC Contactor	1	1	
LC1 - D1210M7N - LA1 - DN11C	AC Contactor	1	1	
LC1 - D1810M7N - LA1 - DN11C	AC Contactor	2	2	
TSCF - 5S 12V	Time Relay	1	1	
FW 11 - 4 0.37kW	Motor	1	1	
FO3 - 31C - 2f 2kW	Motor	1	1	
FO2 - 72 - 4g 3.3kW	Motor	1	1	
FO3PS132A - 4 1.5kW	Motor	1	1	
KWX - 1	Micro Switch	1	5	
83 106 - M2	Micro Switch	1	5	
D97 - 4 - G 1/2"	Cable Sealed Joint	3	1	
D97 - 4 - 30	Cable Sealed Joint	1	1	
5.574.0002	Link	3.5	4	
307.0011	Connecting Sleeve	38	30	
574.0011	Plug	38	30	
(GD2 - CH050) GU41 - FDC - JAA	Photoelectric	1	1	
GY70 (GD - AT3W)	Photoelectric	1	1	
XB2 - BA42C	Button	3	3	
XB2 - BA31C	Button	3	3	
XB2 - BD21C - ZB2 - BE102C	Button	1	1	
XB2 - BA31C	Button	1	1	
ZB2 - BE102C	Button	2	2	
JBK3 - 250 380V	Control Transformer	1	1	220V 180VA 12V 70VA

LAMPIRAN 3

Data Kegagalan Pada Stasiun Kerja Carding

- Data Kerusakan Mesin Carding
- Data Kecelakaan Kerja
- Data Kegagalan Lainnya

- **Data Kerusakan Mesin Carding**

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
5	Motor cylinder rusak	Motor Cylinder	19-Dec-05	13:30	19-Dec-05	17:00
6	Licker - in macet	Licker - in	29-Dec-05	3:15	29-Dec-05	10:00
10	Inverter rusak	Panel	27-Jan-06	8:00	27-Jan-06	9:30
7	Start tidak jalan	Panel	7-Feb-06	10:30	7-Feb-06	13:00
7	Pulley coiler atas lepas	Coiler	10-Feb-06	2:30	10-Feb-06	6:00
6	Garnet licker - in cacat	Licker - in	16-Mar-06	13:15	17-Mar-06	18:00
3	Contactor doffer tidak berfungsi	Panel	29-Mar-06	20:30	30-Mar-06	7:00
4	Motor cylinder rusak	Motor Cylinder	27-Apr-06	9:30	27-Apr-06	11:00
1	Combtoplet tidak jalan (Combbox pulley toplet tidak jalan)	Toplet	28-Apr-06	1:30	28-Apr-06	9:30
6	Inverter rusak	Panel	3-May-06	13:00	3-May-06	14:45
7	Sensor doffer tidak aktif	Sensor Doffer	7-May-06	2:30	9-May-06	13:30
4	Motor cylinder rusak	Motor Cylinder	13-May-06	11:30	13-May-06	13:00
11	Cylinder macet	Cylinder	16-May-06	2:30	16-May-06	3:15
3	Inverter rusak	Panel	19-May-06	3:00	20-May-06	7:00
3	Sensor feedroller tidak berfungsi (sinyal hijau menyala terus)	Sensor Feedroller	4-Jun-06	15:45	4-Jun-06	16:00
4	Sensor doffer tidak aktif	Sensor Doffer	9-Jun-06	1:00	9-Jun-06	1:30
11	Toplet kotor	Toplet	14-Jun-06	7:00	15-Jun-06	15:00
12	Toplet kotor	Toplet	17-Jun-06	10:30	18-Jun-06	17:00
7	Metalic cylinder cacat	Cylinder	18-Jun-06	11:45	20-Jun-06	17:00
7	Metallic doffer cacat (sliver "nyetrip")	Doffer	18-Jun-06	11:45	18-Jun-06	19:00
4	Sensor doffer tidak aktif	Sensor Doffer	18-Jun-06	23:30	19-Jun-06	0:15
3	Sensor doffer tidak aktif	Sensor Doffer	19-Jun-06	2:00	19-Jun-06	2:30
6	Sensor doffer tidak aktif	Sensor Doffer	19-Jun-06	2:00	19-Jun-06	2:45
11	Sensor doffer tidak aktif	Sensor Doffer	19-Jun-06	2:00	19-Jun-06	3:00
6	Sensor doffer tidak aktif	Sensor Doffer	20-Jun-06	1:00	20-Jun-06	1:30
4	Sensor doffer tidak aktif	Sensor Doffer	24-Jun-06	1:00	24-Jun-06	1:30
10	Gigi doffer macet	Doffer	25-Jun-06	7:00	25-Jun-06	10:00
5	Brush doffer rusak (diganti yang baru)	Doffer	25-Jun-06	18:00	26-Jun-06	7:30
2	Cylinder macet	Cylinder	26-Jun-06	4:00	26-Jun-06	5:00
7	Start tidak jalan	Panel	5-Jul-06	23:00	6-Jul-06	9:30
6	Sensor doffer tidak aktif	Sensor Doffer	6-Jul-06	22:25	6-Jul-06	23:00
7	Sensor doffer tidak aktif	Sensor Doffer	15-Jul-06	10:00	15-Jul-06	10:30
7	Inverter rusak	Panel	17-Jul-06	11:00	17-Jul-06	13:00
5	Sensor doffer tidak aktif	Sensor Doffer	12-Aug-06	1:30	12-Aug-06	2:00
7	Motor blower terbakar	Blower	20-Aug-06	6:45	20-Aug-06	11:15
8	Motor blower terbakar	Blower	20-Aug-06	6:45	20-Aug-06	11:15
9	Motor blower terbakar	Blower	20-Aug-06	6:45	20-Aug-06	11:15
10	Motor blower terbakar	Blower	20-Aug-06	6:45	20-Aug-06	11:15
11	Motor blower terbakar	Blower	20-Aug-06	6:45	20-Aug-06	11:15
12	Motor blower terbakar	Blower	20-Aug-06	6:45	20-Aug-06	11:15
12	Pulley doffer pecah	Doffer	3-Sep-06	2:30	5-Sep-06	13:00
11	Motor cylinder rusak	Motor Cylinder	7-Sep-06	0:45	7-Sep-06	11:00
1	Inverter rusak	Panel	10-Sep-06	7:30	10-Sep-06	9:15
7	Motor blower rusak	Blower	11-Sep-06	21:00	12-Sep-06	11:00
6	Belt pulley toplet putus	Toplet	21-Sep-06	21:30	22-Sep-06	8:00

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
3	Sensor doffer tidak aktif	Sensor Doffer	22-Sep-06	0:45	22-Sep-06	1:15
3	Cylinder macet	Cylinder	22-Sep-06	13:00	22-Sep-06	14:00
3	Licker - in macet	Licker - in	22-Sep-06	13:00	22-Sep-06	14:00
2	Start doffer macet	Panel	29-Nov-06	2:30	29-Nov-06	3:00
5	Start doffer macet	Panel	29-Nov-06	2:30	29-Nov-06	3:20
12	Cylinder macet	Cylinder	29-Nov-06	10:00	29-Nov-06	11:00
2	Sensor doffer tidak aktif	Sensor Doffer	8-Dec-06	6:00	8-Dec-06	7:00
1	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	10-Dec-06	17:00	10-Dec-06	17:20
3	Start doffer macet	Panel	16-Dec-06	20:30	16-Dec-06	21:15
2	Gigi coiler rusak	Coiler	17-Dec-06	12:00	17-Dec-06	14:30
3	Start doffer macet	Panel	21-Dec-06	3:00	21-Dec-06	4:30
10	Lampu sinyal rusak	Panel	21-Dec-06	13:45	21-Dec-06	15:00
5	Sensor doffer tidak aktif	Sensor Doffer	5-Jan-07	2:00	5-Jan-07	2:30
3	Sensor doffer tidak aktif	Sensor Doffer	19-Jan-07	3:00	19-Jan-07	3:45
9	Konsleting	Panel	28-Jan-07	11:30	28-Jan-07	13:30
3	Sensor doffer tidak aktif	Sensor Doffer	1-Feb-07	22:00	1-Feb-07	22:30
8	Pulley penggerak coiler lepas	Coiler	6-Feb-07	4:15	6-Feb-07	6:00
2	Sensor doffer tidak aktif	Sensor Doffer	13-Feb-07	0:15	13-Feb-07	1:00
4	Sensor doffer tidak aktif	Sensor Doffer	23-Feb-07	1:30	23-Feb-07	2:00
3	Cylinder macet	Cylinder	23-Feb-07	13:45	23-Feb-07	14:15
8	Sensor doffer tidak aktif	Sensor Doffer	25-Feb-07	23:30	26-Feb-07	0:15
2	Cylinder macet	Cylinder	27-Feb-07	10:30	27-Feb-07	11:15
4	Sensor doffer tidak aktif	Sensor Doffer	28-Feb-07	1:00	28-Feb-07	1:30
6	Sensor doffer tidak aktif	Sensor Doffer	1-Mar-07	0:30	1-Mar-07	1:15
5	Sensor doffer tidak aktif	Sensor Doffer	2-Mar-07	22:30	2-Mar-07	23:00
5	Jalur lamp sinyal konslet	Panel	5-Mar-07	0:00	5-Mar-07	7:00
4	Sensor doffer tidak aktif	Sensor Doffer	5-Mar-07	23:00	5-Mar-07	23:20
2	Layar LCD panel mati	Panel	7-Mar-07	7:00	7-Mar-07	11:00
4	Sensor doffer tidak aktif	Sensor Doffer	8-Mar-07	8:00	8-Mar-07	8:15
5	Sensor doffer tidak aktif	Sensor Doffer	8-Mar-07	23:30	9-Mar-07	0:00
2	Blower rusak	Blower	9-Mar-07	18:00	9-Mar-07	20:00
12	Cylinder macet	Cylinder	9-Mar-07	18:00	9-Mar-07	19:15
6	Start doffer macet	Panel	14-Mar-07	18:00	14-Mar-07	18:30
12	Cylinder macet	Cylinder	15-Mar-07	15:30	15-Mar-07	16:25
12	Cylinder macet	Cylinder	17-Mar-07	9:00	17-Mar-07	10:15
10	Cylinder macet	Cylinder	22-Mar-07	2:00	22-Mar-07	6:00
11	Penggerak combtoplet tidak jalan	Toplet	23-Mar-07	4:30	23-Mar-07	6:30
9	Kaca tutup blower pecah	Blower	23-Mar-07	9:30	23-Mar-07	10:30
12	Bricket penghantar doffer tidak jalan	Doffer	23-Mar-07	10:00	23-Mar-07	11:30
6	Sensor doffer tidak aktif	Sensor Doffer	24-Mar-07	0:30	24-Mar-07	9:45
12	Pulley coiler copot	Coiler	30-Mar-07	2:45	30-Mar-07	4:00
7	Combtoplet tidak jalan	Toplet	2-Apr-07	3:00	2-Apr-07	7:30
7	Sensor doffer tidak aktif	Sensor Doffer	2-Apr-07	8:00	2-Apr-07	8:15
8	Sensor doffer tidak aktif	Sensor Doffer	2-Apr-07	8:00	2-Apr-07	8:30
9	Sensor doffer tidak aktif	Sensor Doffer	2-Apr-07	8:00	2-Apr-07	8:45
7	As combtoplet patah	Toplet	3-Apr-07	0:30	3-Apr-07	8:00

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
1	Coiler bawah tidak jalan	Coiler	5-Apr-07	3:45	5-Apr-07	7:30
3	Bartoplet rusak	Toplet	11-Apr-07	8:00	12-Apr-07	12:00
11	Gigi doffer rusak	Doffer	11-Apr-07	19:00	12-Apr-07	9:00
11	Gigi doffer rusak	Doffer	12-Apr-07	16:00	12-Apr-07	18:30
1	Dudukan can tidak jalan	Coiler	12-Apr-07	19:30	12-Apr-07	20:45
7	Toplet rusak	Toplet	13-Apr-07	2:00	15-Apr-07	8:00
1	Start tidak jalan	Panel	14-Apr-07	2:45	14-Apr-07	6:00
12	Gigi doffer rusak	Doffer	14-Apr-07	7:15	14-Apr-07	9:30
2	Cylinder macet	Cylinder	16-Apr-07	23:30	17-Apr-07	0:30
2	Bartoplet rusak	Toplet	19-Apr-07	8:00	21-Apr-07	9:00
3	Start tidak jalan	Panel	21-Apr-07	0:00	21-Apr-07	1:00
3	Sensor doffer tidak aktif	Sensor Doffer	30-May-07	3:00	30-May-07	3:30
9	Panel off	Panel	30-May-07	20:00	31-May-07	13:00
7	Motor blower rusak	Blower	31-May-07	5:00	31-May-07	6:00
9	Motor blower rusak	Blower	1-Jun-07	5:00	1-Jun-07	6:30
6	Belt blower putus	Blower	9-Jun-07	15:20	9-Jun-07	16:30
5	Panel off	Panel	14-Jun-07	14:30	14-Jun-07	15:10
6	Inverter rusak	Panel	27-Jun-07	0:30	27-Jun-07	8:00
4	Metallic doffer cacat (sliver "nyetrip")	Doffer	27-Jun-07	13:30	27-Jun-07	18:00
8	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	29-Jun-07	16:30	29-Jun-07	16:45
4	Tombol doffer tidak jalan	Panel	2-Jul-07	4:45	2-Jul-07	6:00
2	Cylinder macet	Cylinder	2-Jul-07	17:30	2-Jul-07	18:10
2	Sensor doffer tidak aktif	Sensor Doffer	5-Jul-07	2:00	5-Jul-07	2:45
1	Metallic doffer cacat (sliver "nyetrip")	Doffer	5-Jul-07	7:00	5-Jul-07	12:00
9	Mesin bau hangus (motor cylinder terbakar)	Motor Cylinder	5-Jul-07	20:30	6-Jul-07	15:00
10	Baut combtoplet lepas	Toplet	12-Jul-07	20:15	12-Jul-07	22:00
4	Dudukan penyangga doffer copot	Doffer	13-Jul-07	20:00	14-Jul-07	10:00
8	Inverter rusak	Panel	15-Jul-07	15:45	17-Jul-07	16:00
5	As pulley licker - in longgar	Licker - in	16-Jul-07	11:00	16-Jul-07	12:30
2	Blower rusak	Blower	19-Jul-07	19:30	19-Jul-07	20:45
2	Sensor doffer tidak aktif	Sensor Doffer	20-Jul-07	7:30	20-Jul-07	13:15
10	Cylinder macet	Cylinder	28-Jul-07	11:00	28-Jul-07	11:40
2	Start tidak jalan	Panel	29-Jul-07	0:00	29-Jul-07	0:30
10	Kabel ke blower konslet	Panel	31-Jul-07	3:30	31-Jul-07	7:45
12	Metallic doffer cacat (sliver "nyetrip")	Doffer	31-Jul-07	15:30	31-Jul-07	19:00
2	Blower rusak	Blower	31-Jul-07	18:00	31-Jul-07	20:00
5	Cincin toplet bergeser	Toplet	7-Aug-07	11:00	7-Aug-07	12:00
2	Start doffer macet	Panel	14-Aug-07	0:00	14-Aug-07	0:20
3	Sensor doffer tidak aktif	Sensor Doffer	14-Aug-07	23:00	14-Aug-07	23:45
11	Cylinder macet	Cylinder	21-Aug-07	19:30	21-Aug-07	20:30
1	Combtoplet tidak jalan (Combbox pulley toplet tidak jalan)	Toplet	22-Aug-07	18:15	22-Aug-07	20:00
8	Pulley toplet "goplak"	Toplet	30-Aug-07	3:45	30-Aug-07	7:00
7	Motor blower rusak	Blower	5-Sep-07	16:30	5-Sep-07	17:30
8	Motor blower rusak	Blower	5-Sep-07	16:30	5-Sep-07	17:45
9	Motor blower rusak	Blower	5-Sep-07	16:30	5-Sep-07	18:15

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
10	Motor blower rusak	Blower	5-Sep-07	16:30	5-Sep-07	18:40
11	Motor blower rusak	Blower	5-Sep-07	16:30	5-Sep-07	19:10
12	Motor blower rusak	Blower	5-Sep-07	16:30	5-Sep-07	19:30
1	Jarak cylinder bergeser (Pinggiran cylinder keluar api)	Cylinder	9-Sep-07	1:30	9-Sep-07	6:00
3	Gigi doffer rusak	Doffer	9-Sep-07	12:00	9-Sep-07	14:00
4	Sensor doffer tidak aktif	Sensor Doffer	10-Sep-07	16:15	10-Sep-07	17:00
4	Metallic doffer cacat (sliver "nyetrip")	Doffer	11-Sep-07	9:30	11-Sep-07	17:00
11	Sensor doffer tidak aktif	Sensor Doffer	16-Sep-07	10:00	16-Sep-07	10:30
11	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	16-Sep-07	10:00	16-Sep-07	10:30
8	Jarak cylinder bergeser (Di samping cylinder keluar asap dari debu yang tebal)	Cylinder	16-Sep-07	12:15	16-Sep-07	14:00
7	Panel off	Panel	25-Sep-07	20:00	25-Sep-07	20:30
1	Bearing motor blower rusak	Blower	26-Sep-07	10:45	26-Sep-07	13:30
2	Bearing motor blower rusak	Blower	26-Sep-07	10:45	26-Sep-07	13:30
3	Bearing motor blower rusak	Blower	26-Sep-07	10:45	26-Sep-07	13:30
4	Bearing motor blower rusak	Blower	26-Sep-07	10:45	26-Sep-07	13:30
5	Bearing motor blower rusak	Blower	26-Sep-07	10:45	26-Sep-07	13:30
6	Bearing motor blower rusak	Blower	26-Sep-07	10:45	26-Sep-07	13:30
5	Inverter rusak	Panel	26-Sep-07	16:30	26-Sep-07	17:30
9	Toplet kotor	Toplet	28-Sep-07	7:00	28-Sep-07	11:00
9	Rantai toplet kendor	Toplet	4-Oct-07	1:30	4-Oct-07	6:30
6	Sensor doffer tidak aktif	Sensor Doffer	4-Oct-07	23:00	4-Oct-07	23:30
2	Cylinder macet	Cylinder	5-Oct-07	4:00	5-Oct-07	6:30
3	Van belt toplet rusak	Toplet	9-Oct-07	9:00	9-Oct-07	11:00
12	Blower rusak	Blower	28-Oct-07	7:45	28-Oct-07	10:00
8	Start tidak jalan	Panel	31-Oct-07	2:30	31-Oct-07	21:00
5	Pulley toplet macet	Toplet	1-Nov-07	19:45	1-Nov-07	21:00
8	Metallic doffer cacat (sliver "nyetrip")	Doffer	2-Nov-07	22:10	3-Nov-07	13:00
5	Mesin bau hangus (motor cylinder terbakar)	Motor Cylinder	4-Nov-07	21:15	4-Nov-07	23:00
7	Panel off	Panel	4-Nov-07	22:00	4-Nov-07	23:00
8	Panel off	Panel	4-Nov-07	22:00	4-Nov-07	23:00
9	Panel off	Panel	4-Nov-07	22:00	4-Nov-07	23:00
10	Panel off	Panel	4-Nov-07	22:00	4-Nov-07	23:00
11	Panel off	Panel	4-Nov-07	22:00	4-Nov-07	23:00
12	Panel off	Panel	4-Nov-07	22:00	4-Nov-07	23:00
5	Bricket mote knife patah dan mote knife cacat	Licker - in	5-Nov-07	7:30	5-Nov-07	11:00
5	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	5-Nov-07	16:15	5-Nov-07	16:30
3	Start tidak jalan	Panel	13-Nov-07	22:30	13-Nov-07	23:30
2	Cylinder macet	Cylinder	14-Nov-07	2:00	14-Nov-07	3:30
1	Bearing coiler rusak & gigi coiler rusak	Coiler	18-Nov-07	11:45	18-Nov-07	16:00
9	Motor cylinder rusak	Motor Cylinder	20-Nov-07	12:00	20-Nov-07	14:30
5	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	27-Nov-07	11:00	27-Nov-07	11:10
2	Cylinder macet	Cylinder	27-Nov-07	17:45	27-Nov-07	18:30

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
5	Sensor doffer tidak aktif	Sensor Doffer	28-Nov-07	10:00	28-Nov-07	11:00
2	Konsleting	Panel	29-Nov-07	23:00	30-Nov-07	0:30
3	Sensor doffer tidak aktif	Sensor Doffer	7-Dec-07	18:30	7-Dec-07	19:00
6	Motor cylinder rusak	Motor Cylinder	10-Dec-07	7:00	10-Dec-07	11:00
12	Metallic doffer cacat (sliver "nyetrip")	Doffer	12-Dec-07	22:15	13-Dec-07	9:30
4	Motor cylinder terbakar	Motor Cylinder	17-Dec-07	17:30	18-Dec-07	10:30
4	Cylinder macet	Cylinder	18-Dec-07	12:00	18-Dec-07	13:45
12	Gigi coiler rusak	Coiler	19-Dec-07	14:30	19-Dec-07	16:30
4	Cylinder keluar asap	Cylinder	19-Dec-07	20:30	21-Dec-07	8:30
3	Bearing motor blower rusak	Blower	22-Dec-07	10:30	23-Dec-07	10:00
12	Cylinder macet	Cylinder	22-Dec-07	23:30	23-Dec-07	0:10
3	Baut motor doffer ke mesin patah satu	Doffer	23-Dec-07	3:00	23-Dec-07	4:30
2	Motor blower terbakar	Blower	25-Dec-07	3:10	25-Dec-07	9:00
3	Bearing motor blower rusak	Blower	25-Dec-07	16:30	26-Dec-07	16:15
2	Jarak cylinder bergeser (Under casing ada percikan api)	Cylinder	26-Dec-07	3:00	26-Dec-07	10:00
7	Jarak licker - in bergeser (Ada kapas terbakar di under casing)	Cylinder	29-Dec-07	23:30	29-Dec-07	23:45
12	Cylinder macet	Cylinder	2-Jan-08	13:45	2-Jan-08	14:00
1	Metallic doffer putus	Doffer	9-Jan-08	4:30	11-Jan-08	10:00
12	Metallic cylinder putus	Cylinder	10-Jan-08	11:45	19-Jan-08	16:00
11	Inverter rusak	Panel	10-Jan-08	18:00	10-Jan-08	18:30
3	Sensor doffer tidak aktif	Sensor Doffer	12-Jan-08	10:00	12-Jan-08	10:30
8	Sensor doffer tidak aktif	Sensor Doffer	12-Jan-08	10:00	12-Jan-08	10:30
4	Brush doffer tidak jalan	Doffer	14-Jan-08	0:00	14-Jan-08	6:00
8	As gigi roller doffer aus	Doffer	15-Jan-08	0:00	15-Jan-08	9:00
10	Sensor doffer tidak aktif	Sensor Doffer	15-Jan-08	2:00	15-Jan-08	2:45
2	Cylinder macet	Cylinder	21-Jan-08	22:20	21-Jan-08	23:45
8	Kabel sensor doffer putus	Sensor Doffer	23-Jan-08	19:00	23-Jan-08	19:45
2	Garnet licker - in cacat	Licker - in	26-Jan-08	9:00	27-Jan-08	16:00
1	Gigi coiler rusak	Coiler	30-Jan-08	16:30	30-Jan-08	18:15
12	Jarak cylinder bergeser (Sisi cylinder ada percikan api)	Cylinder	1-Feb-08	9:30	1-Feb-08	11:30
6	Cylinder macet	Cylinder	2-Feb-08	23:15	3-Feb-08	0:00
4	Jarak cylinder bergeser (Licker - in keluar api ke samping cylinder)	Cylinder	4-Feb-08	4:15	4-Feb-08	8:15
10	Panel off	Panel	4-Feb-08	21:15	4-Feb-08	22:00
12	Pulley toplet macet	Toplet	5-Feb-08	2:15	5-Feb-08	4:15
12	Jarak cylinder bergeser (Pinggiran cylinder sebelah kiri keluar api)	Cylinder	6-Feb-08	18:00	6-Feb-08	19:00
1	Contactor doffer tidak berfungsi	Panel	8-Feb-08	10:30	8-Feb-08	12:00
1	Cylinder macet	Cylinder	8-Feb-08	13:10	8-Feb-08	14:00
1	Sensor doffer tidak aktif	Sensor Doffer	10-Feb-08	16:00	10-Feb-08	16:30
1	Cylinder macet	Cylinder	10-Feb-08	20:00	10-Feb-08	20:45
12	Gigi doffer lepas	Doffer	12-Feb-08	2:30	12-Feb-08	7:00
3	Sensor doffer tidak aktif	Sensor Doffer	13-Feb-08	2:45	13-Feb-08	3:20
4	Cylinder macet	Cylinder	13-Feb-08	18:00	13-Feb-08	18:45
2	Tombol doffer tidak normal	Panel	18-Feb-08	18:00	18-Feb-08	19:00

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
10	Cylinder macet	Cylinder	21-Feb-08	5:30	21-Feb-08	6:00
8	Licker - in macet	Licker - in	22-Feb-08	3:30	22-Feb-08	6:00
5	Coiler tidak jalan	Coiler	3-Mar-08	4:00	3-Mar-08	7:00
12	Sensor doffer tidak aktif	Sensor Doffer	3-Mar-08	8:00	3-Mar-08	8:30
9	Start cylinder mati terus	Panel	5-Mar-08	0:00	5-Mar-08	0:30
12	Cylinder macet	Cylinder	5-Mar-08	13:15	5-Mar-08	14:00
12	Sensor doffer tidak aktif	Sensor Doffer	5-Mar-08	13:15	6-Mar-08	9:45
12	Sensor doffer tidak aktif	Sensor Doffer	7-Mar-08	22:15	7-Mar-08	23:00
6	Panel off	Panel	18-Mar-08	23:15	19-Mar-08	2:00
7	Motor blower terbakar	Blower	24-Mar-08	13:50	24-Mar-08	15:45
8	Motor blower terbakar	Blower	24-Mar-08	13:50	24-Mar-08	15:45
9	Motor blower terbakar	Blower	24-Mar-08	13:50	24-Mar-08	15:45
10	Motor blower terbakar	Blower	24-Mar-08	13:50	24-Mar-08	15:45
11	Motor blower terbakar	Blower	24-Mar-08	13:50	24-Mar-08	15:45
12	Motor blower terbakar	Blower	24-Mar-08	13:50	24-Mar-08	15:45
11	Dudukan per pisau roll patah	Licker - in	28-Mar-08	11:00	28-Mar-08	13:00
6	Bearing motor blower rusak	Blower	28-Mar-08	19:30	29-Mar-08	11:00
2	Panel off	Panel	31-Mar-08	3:15	31-Mar-08	6:00
3	Sensor doffer tidak aktif	Sensor Doffer	31-Mar-08	4:45	31-Mar-08	8:45
2	Sensor doffer tidak aktif	Sensor Doffer	31-Mar-08	6:00	31-Mar-08	8:45
6	Sensor doffer tidak aktif	Sensor Doffer	31-Mar-08	6:00	31-Mar-08	8:45
7	Sensor doffer tidak aktif	Sensor Doffer	31-Mar-08	6:00	31-Mar-08	8:45
12	Sensor doffer tidak aktif	Sensor Doffer	31-Mar-08	6:00	31-Mar-08	8:45
2	Cylinder macet	Cylinder	31-Mar-08	18:30	31-Mar-08	19:00
6	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	1-Apr-08	19:00	1-Apr-08	19:15
2	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	1-Apr-08	22:45	1-Apr-08	22:55
9	Motor cylinder rusak	Motor Cylinder	2-Apr-08	2:00	2-Apr-08	8:45
6	Panel off	Panel	2-Apr-08	10:20	2-Apr-08	11:00
10	Motor cylinder rusak	Motor Cylinder	2-Apr-08	11:00	2-Apr-08	14:00
7	Combtoplet handle penggerak patah	Toplet	2-Apr-08	22:15	3-Apr-08	8:30
5	Panel off	Panel	3-Apr-08	12:30	3-Apr-08	13:15
2	Start tidak jalan	Panel	7-Apr-08	23:00	7-Apr-08	23:30
10	Inverter rusak	Panel	9-Apr-08	16:15	10-Apr-08	16:45
5	Cylinder macet	Cylinder	14-Apr-08	14:15	14-Apr-08	16:00
7	Sensor doffer tidak aktif	Sensor Doffer	21-Apr-08	23:30	22-Apr-08	9:30
12	Start tidak jalan	Panel	28-Apr-08	14:20	28-Apr-08	14:50
7	Pulley doffer brush longgar	Doffer	29-Apr-08	17:00	30-Apr-08	7:00
7	Switch sensor feedroller tidak aktif	Sensor Feedroller	1-May-08	12:45	1-May-08	13:00
7	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	2-May-08	7:30	2-May-08	8:00
10	Motor cylinder terbakar	Motor Cylinder	7-May-08	20:55	9-May-08	10:00
2	Jarak cylinder bergeser (Ada percikan api di under casing)	Cylinder	13-May-08	18:30	13-May-08	19:30
3	Kap doffer bergesekan dengan brush doffer	Doffer	14-May-08	3:00	14-May-08	6:00
3	Sensor doffer tidak aktif	Sensor Doffer	14-May-08	23:00	14-May-08	23:45

Mesin Carding	Keterangan kerusakan	Komponen	Waktu kerusakan		Selesai diperbaiki	
			Tanggal	Waktu	Tanggal	Waktu
6	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	Sensor Feedroller	15-May-08	21:45	15-May-08	22:10
12	Cylinder macet	Cylinder	16-May-08	2:00	16-May-08	9:00
12	Gigi doffer lepas	Doffer	16-May-08	2:00	16-May-08	9:00
7	Gigi coiler rusak	Coiler	21-May-08	15:30	21-May-08	17:00
7	Gigi coiler rusak	Coiler	21-May-08	20:00	22-May-08	6:30
12	Licker - in macet	Licker - in	22-May-08	11:00	22-May-08	16:00
2	Metallic cylinder putus	Cylinder	23-May-08	7:45	31-May-08	15:00
7	Jarak cylinder bergeser (Sisa kapas di under casing terbakar)	Cylinder	26-May-08	9:00	26-May-08	10:00
12	Brickat mote knife patah & Garnet licker - in cacat	Licker - in	28-May-08	7:45	29-May-08	11:15

- **Data Kecelakaan Kerja**

Tanggal	Yang Mengalami	Ringkasan Kejadian	Penanggulangan
28-May-07	Sdr. Luky (Operator)	Sekitar Pkl. 14.00 ketika sedang menjaga mesin Sdr. Luky menghampiri mesin carding no. 6 dan melihat adanya kotoran / debu maka Sdr. Luky membuka kap doffer dengan maksud akan mengambil kotoran tersebut dengan menggunakan jari telunjuk kanan. Tetapi tiba - tiba jari telunjuknya tersedot masuk ke dalam. Karena kaget, Sdr. Luky lalu menarik jarinya kembali. Jari telunjuknya mengalami luka yang agak parah.	Langsung dibawa ke RS. Santo Yusuf dan menurut pihak RS tangan Sdr. Luky harus dioperasi karena ada beberapa urat jari telunjuknya yang putus.
28-Dec-07	Sdr. Anto (Operator)	Sekitar Pkl. 16.15 Sdr. Anto membuka kap doffer depan mesin carding no. 4 dan tangan kanannya mengambil kapas dari sis doffer yang sedang jalan dan pada saat itu juga jari telunjuknya terkena sisi doffer tersebut.	Langsung dibawa ke Puskesmas Rancaekek lalu dialihkan ke RS. AMC, diantar oleh Pak Yadi (Pengawas). Akhirnya luka tersebut dijahit sebanyak 11 jahitan.
6-Jan-08	Pak Iwan (Pengawas)	Sekitar Pkl. 21.15 Pak Iwan sedang mengecek sensor doffer mesin carding no. 6 karena tidak aktif. Pak Iwan membuka kap doffer depan sementara tangan kanannya mengecek sensor doffer, tiba - tiba kap doffer itu jatuh sehingga jari telunjuk tangan kanannya terjepit oleh kap doffer tersebut.	Jari yang terjepit langsung dicuci dengan air hangat lalu diobati dengan Betadine dan dibalut.

- **Data Kegagalan Lainnya**

Tanggal	Keterangan	Waktu Kejadian
24-Nov-05	Beroperasi 4 unit karena 2 operator pulang	18:00 - 22:00
25-Nov-05	Beroperasi 3 unit karena operator belum masuk	19:00 - 22:00
1-Dec-05	Beroperasi 8 unit karena operator kurang (+ 1 op *blower*)	11:00 - 22:00
	Beroperasi 5 unit karena 1 operator kurang	18:00 - 22:00
3-Dec-05	*Sliver* menjuntai	Shift B
5-Dec-05	Beroperasi 6 unit karena operator hanya 2 orang	18:00 - 22:00
6-Dec-05	Beroperasi 4 unit karena operator hanya 2 orang	19:00 - 22:00
14-Dec-05	Beroperasi 8 unit karena 1 operator pulang	16:00 - 22:00
16-Dec-05	Beroperasi 6 unit karena operator hanya 2 orang	16:00 - 22:00
23-Dec-05	Aliran PLN Padam	20:00 - 20:10
26-Dec-05	Beroperasi 6 unit karena 1 operator pulang	16:00 - 22:00
28-Dec-05	*Sliver* menjuntai	Shift C
5-Jan-06	Beroperasi 6 unit karena operator hanya 2 orang	16:00 - 22:00
14-Jan-06	Ruangan banjir, operator langsung bersih - bersih	14:30
20-Jan-06	*Lap* habis	5:00 - 9:00
25-Jan-06	*Sliver* menjuntai	Shift B
26-Jan-06	*Sliver* menjuntai	Shift B
1-Feb-06	*Sliver* menjuntai	Shift A
10-Feb-06	*Sliver* menjuntai	Shift B
18-Feb-06	*Lap* habis	4:20 - 9:00
20-Feb-06	Aliran PLN Padam	13:40 - 14:10
23-Feb-06	*Lap* habis	4:45 - 8:00
24-Feb-06	*Lap* habis	4:15 - 9:00
24-Feb-06	Beroperasi 9 unit, persediaan *lap* kurang	Shift B
28-Feb-06	*Lap* habis	4:00 - 9:00
7-Mar-06	*Sliver* menjuntai	Shift B
8-Mar-06	*Sliver* menjuntai	Shift B
10-Mar-06	*Lap* habis	4:00 - 6:30
11-Mar-06	*Lap* habis	5:00 - 6:30
14-Mar-06	*Sliver* menjuntai	Shift A
15-Mar-06	*Sliver* menjuntai	Shift A
20-Mar-06	*Sliver* menjuntai	Shift C
23-Mar-06	*Sliver* menjuntai	Shift B
25-Mar-06	*Lap* habis	4:00 - 7:00
29-Mar-06	Aliran PLN Padam	11:00 - 11:30
30-Mar-06	*Lap* habis	4:30 - 8:00
31-Mar-06	*Lap* habis	4:30 - 9:00
4-Apr-06	*Lap* habis	4:30 - 9:00
6-Apr-06	*Lap* habis	3:00 - 9:30
8-Apr-06	*Lap* habis	4:45 - 9:00
9-Apr-06	*Sliver* menjuntai	Shift B
10-Apr-06	*Lap* habis	7:30 - 10:30
11-Apr-06	*Sliver* menjuntai	Shift C
	Lap habis	8:45 - 9:15
12-Apr-06	*Lap* habis	4:00 - 7:00
22-Apr-06	*Lap* habis	4:00 - 9:00
24-Apr-06	Aliran PLN Padam	18:00 - 18:25
25-Apr-06	*Sliver* menjuntai	Shift B
27-Apr-06	Aliran PLN Padam	15:00 - 15:15
28-Apr-06	Mesin mati karena kabel pusat terbakar	16:30 - 19:00
29-Apr-06	*Sliver* menjuntai	Shift B

Tanggal	Keterangan	Waktu Kejadian
1-May-06	Pemasangan Cr oleh PLN	14:30 - 16:00
2-May-06	*Sliver* menjuntai	Shift C
6-May-06	*Lap* habis	5:00 - 7:00
10-May-06	*Sliver* menjuntai	Shift A
11-May-06	*Lap* habis	5:00 - 9:00
15-May-06	*Lap* habis	4:00 - 10:00
20-May-06	Panel induk DDGR ada yang rusak	11:45 - 13:30
2-Jun-06	*Sliver* menjuntai	Shift B
5-Jun-06	*Lap* habis	5:00 - 9:00
6-Jun-06	*Lap* habis	4:40 - 7:00
9-Jun-06	*Lap* habis	4:45 - 7:00
10-Jun-06	*Lap* habis	3:30 - 8:00
13-Jun-06	Aliran listrik putus	16:45 - 17:15
14-Jun-06	*Lap* habis	4:00 - 7:00
15-Jun-06	*Lap* habis	4:00 - 8:00
19-Jun-06	Padam listrik induk 2 *phasse* (sekering putus)	14:40 - 15:45
25-Jun-06	*Lap* habis	15:45 - 20:00
26-Jun-06	*Lap* habis	4:00 - 7:30
27-Jun-06	*Lap* habis	4:30 - 9:00
1-Jul-06	Beroperasi 6 unit karena operator kurang	14:00 - 22:00
4-Jul-06	*Lap* habis	3:30 - 7:00
5-Jul-06	Beroperasi 10 unit karena operator kurang	14:00 - 22:00
	Sliver menjuntai	Shift C
15-Jul-06	*Lap* habis	4:50 - 7:00
17-Jul-06	*Lap* habis	3:30 - 7:00
19-Jul-06	Aliran PLN Padam	21:30 - 22:00
20-Jul-06	Beroperasi 8 unit karena operator kurang	14:00 - 22:00
23-Jul-06	Beroperasi 6 unit karena operator kurang	6:00 - 14:00
24-Jul-06	*Lap* habis	3:30 - 6:00
30-Jul-06	Beroperasi 5 unit karena operator kurang	19:00 - 22:00
31-Jul-06	*Lap* habis	4:00 - 8:00
1-Aug-06	*Lap* habis	3:15 - 8:00
3-Aug-06	*Lap* habis	4:00 - 7:00
4-Aug-06	*Lap* habis	3:30 - 6:00
8-Aug-06	*Lap* habis	5:00 - 9:00
14-Aug-06	*Lap* habis	3:50 - 8:00
29-Aug-06	*Lap* habis	3:30 - 7:45
30-Aug-06	*Lap* habis	5:00 - 8:45
1-Sep-06	*Lap* habis	4:30 - 8:00
2-Sep-06	*Sliver* menjuntai	Shift C
3-Sep-06	*Sliver* menjuntai	Shift B
5-Sep-06	*Lap* habis	5:00 - 9:00
6-Sep-06	*Lap* habis	4:30 - 8:45
7-Sep-06	*Sliver* menjuntai	Shift C
8-Sep-06	*Lap* habis	4:30 - 9:00
9-Sep-06	*Lap* habis	4:30 - 9:00
12-Sep-06	*Sliver* menjuntai	Shift B
16-Sep-06	*Stop* semua mesin (panel induk off)	15:00 - 15:45
25-Sep-06	*Stop* semua mesin (panel induk off)	8:30 - 8:45
26-Sep-06	*Lap* habis	2:30 - 6:00
29-Sep-06	*Lap* habis	3:30 - 6:00

Tanggal	Keterangan	Waktu Kejadian
5-Oct-06	*Sliver* menjuntai	Shift C
7-Oct-06	*Sliver* menjuntai	Shift C
8-Oct-06	*Sliver* menjuntai	Shift B
10-Oct-06	*Sliver* menjuntai	Shift B
11-Oct-06	*Sliver* menjuntai	Shift C
12-Oct-06	*Sliver* menjuntai	Shift C
13-Oct-06	*Sliver* menjuntai	Shift C
18-Oct-06	*Lap* habis	4:30 - 6:45
5-Dec-06	*Lap* habis	4:30 - 7:00
6-Dec-06	*Sliver* menjuntai	Shift B
	Ruangan bocor (hujan)	16:00 - 18:00
10-Dec-06	Beroperasi 10 unit karena operator kurang	14:00 - 22:00
11-Dec-06	Beroperasi 10 unit karena operator kurang	14:00 - 22:00
13-Dec-06	*Sliver* menjuntai	Shift B
14-Dec-06	*Sliver* menjuntai	Shift B
18-Dec-06	Beroperasi 8 unit karena operator kurang	16:00 - 22:00
20-Dec-06	Beroperasi 10 unit karena operator kurang	19:30 - 22:00
	Sliver menjuntai	Shift A
23-Dec-06	Beroperasi 10 unit karena operator kurang	20:00 - 22:00
25-Dec-06	*Sliver* menjuntai	Shift B
4-Jan-07	Beroperasi 8 unit karena operator kurang	14:00 - 19:00
6-Jan-07	*Lap* habis	3:15 - 7:00
11-Jan-07	*Lap* habis	5:00 - 6:45
12-Jan-07	*Lap* habis	3:30 - 7:00
22-Jan-07	*Sliver* menjuntai	Shift B
24-Jan-07	*Sliver* menjuntai	Shift A
27-Jan-07	*Lap* habis	4:00 - 7:00
30-Jan-07	*Sliver* menjuntai	Shift B
31-Jan-07	*Sliver* menjuntai	Shift A
1-Feb-07	*Sliver* menjuntai	Shift A
7-Feb-07	Padam listrik induk 2 *phasse* (sekering putus)	7:00 - 11:00
9-Feb-07	*Lap* habis	5:00 - 8:00
10-Feb-07	*Lap* habis	3:30 - 7:00
12-Feb-07	*Lap* habis	5:00 - 7:45
13-Feb-07	*Lap* habis	4:30 - 6:00
16-Feb-07	*Lap* habis	4:00 - 6:00
21-Feb-07	*Sliver* menjuntai	Shift B
22-Feb-07	*Sliver* menjuntai	Shift B
23-Feb-07	*Sliver* menjuntai	Shift A
27-Feb-07	*Sliver* menjuntai	Shift B
5-Mar-07	*Sliver* menjuntai	Shift C
7-Mar-07	*Sliver* menjuntai	Shift A
8-Mar-07	*Sliver* menjuntai	Shift A
10-Mar-07	*Sliver* menjuntai	Shift C
15-Mar-07	*Sliver* menjuntai	Shift B
16-Mar-07	*Sliver* menjuntai	Shift A
20-Mar-07	Beroperasi 6 unit karena operator hanya 2 orang	19:00 - 22:00
21-Mar-07	*Sliver* menjuntai	Shift B

Tanggal	Keterangan	Waktu Kejadian
6-Apr-07	*Lap* habis	4:00 - 7:00
13-Apr-07	*Lap* habis	5:00 - 7:15
14-Apr-07	*Lap* habis	5:00 - 7;15
16-Apr-07	Beroperasi 10 unit karena operator kurang	17:00 - 22:00
19-Apr-07	Beroperasi 10 unit karena operator kurang	19:00 - 22:00
23-Apr-07	*Sliver* menjuntai	Shift C
24-Apr-07	Pabrik banjir semua mesin mati	18:00
21-May-07	*Can* habis	1:00 - 5:00
29-May-07	Beroperasi 10 unit karena operator kurang	0:00 - 6:00
6-Jun-07	Beroperasi 10 unit karena operator kurang	18:00 - 22:00
13-Jun-07	Beroperasi 10 unit karena operator kurang	16:00 - 22:00
23-Jun-07	*Lap* habis	4:35 - 7:00
26-Jun-07	*Lap* habis	5:00 - 7:30
28-Jun-07	*Can* habis	4:30 - 7:00
30-Jun-07	*Lap* habis	4:30 - 7:00
3-Jul-07	*Lap* habis	5:00 - 7:00
4-Jul-07	*Lap* habis	4:50 - 6:45
	Beroperasi 10 unit karena operator kurang	19:00 - 22:00
12-Jul-07	Beroperasi 10 unit karena operator kurang	16:00 - 22:00
16-Jul-07	*Sliver* menjuntai	Shift A
24-Jul-07	*Lap* habis	5:00 - 7:00
	Beroperasi 10 unit karena operator kurang	18:00 - 22:00
28-Jul-07	Beroperasi 10 unit karena operator kurang	19:00 - 22:00
8-Aug-07	*Lap* habis	4:15 - 7:15
9-Aug-07	*Lap* habis	4:00 - 7:00
	Beroperasi 10 unit karena operator kurang	18:00 - 22:00
11-Aug-07	*Lap* habis	5:00 - 7:30
15-Aug-07	Beroperasi 8 unit karena operator kurang	17:00 - 22:00
19-Aug-07	*Lap* habis	5:00 - 8:00
21-Aug-07	*Lap* habis	5:00 - 8:00
24-Aug-07	*Lap* habis	5:00 - 7:00
27-Aug-07	Beroperasi 10 unit karena operator kurang	16:00 - 22:00
29-Aug-07	*Lap* habis	5:00 - 7:15
30-Aug-07	*Lap* habis	4:00 - 7:45
31-Aug-07	Beroperasi 10 unit karena operator kurang	19:00 - 22:00
1-Sep-07	*Lap* habis	4:00 - 7:00
3-Sep-07	*Lap* habis	3:45 - 6:00
4-Sep-07	*Lap* habis	4:45 - 6:00
12-Sep-07	*Sliver* menjuntai	Shift B
25-Sep-07	*Lap* habis	5:00 - 7:00
27-Sep-07	*Sliver* menjuntai	Shift A
28-Sep-07	*Sliver* menjuntai	Shift A
29-Sep-07	*Sliver* menjuntai	Shift A
1-Oct-07	*Sliver* menjuntai	Shift B
31-Oct-07	*Lap* habis	4:30 - 6:45
2-Nov-07	Aliran PLN Padam	2:45 - 5:50
4-Nov-07	*Sliver* menjuntai	Shift C
23-Nov-07	Aliran PLN Padam	16:15 - 16:45
16-Dec-07	*Sliver* menjuntai	Shift C
14-Feb-08	Beroperasi 10 unit karena operator kurang	16:00 - 22:00
16-Feb-08	Beroperasi 10 unit karena operator kurang	19:00 - 22:00
19-Feb-08	Beroperasi 10 unit karena operator kurang	16:00 - 22:00
27-Feb-08	*Lap* habis	5:00 - 8:00

Tanggal	Keterangan	Waktu Kejadian
6-Mar-08	Aliran PLN Padam	0:00 - 1:45
11-Mar-08	*Sliver* menjuntai	Shift B
13-Mar-08	*Sliver* menjuntai	Shift B
18-Mar-08	*Sliver* menjuntai	Shift A
19-Mar-08	Beroperasi 10 unit karena operator kurang & dialihkan	16:00 - 19:00
25-Mar-08	*Sliver* menjuntai	Shift B
14-Apr-08	Beroperasi 9 unit karena operator hanya 4 orang	18:00 - 22:00
23-Apr-08	*Sliver* menjuntai	Shift C
1-May-08	*Sliver* menjuntai	Shift C
2-May-08	*Sliver* menjuntai	Shift B
7-May-08	*Sliver* menjuntai	Shift B
8-May-08	*Sliver* menjuntai	Shift B
10-May-08	*Sliver* menjuntai	Shift B
15-May-08	*Sliver* menjuntai	Shift A
20-May-08	*Sliver* menjuntai	Shift C

- **Data Kecelakaan Kerja (lanjutan)**

Tanggal	Kejadian	Ringkasan Kejadian	Penanggulangan
20-Apr-07	Kebakaran Mesin Carding No. 3	Sekitar Pkl. 20.00 Sdr. Yayat membersihkan semua *carding* , dimulai dari carding no. 1 yaitu dengan pengambilan debu - debu di bawah kap (mesin dalam keadaan beroperasi). Sdr. Yayat sampai pada carding no. 10, ia mencium bau sangit, lalu segera memeriksa *carding* . Dari *carding* no. 3 muncul asap ternyata di dalam *carding* api sudah menyala.	Mematikan mesin, mengambil *fire extinguish* dan api langsung dimatikan. Pemadaman api dibantu oleh Sdr. Supriyadi. Lalu dilakukan pengecekan dan perbaikan mesin.
25-Dec-07	Kebakaran Mesin Carding No. 2	Sekitar Pkl. 0310 Sdr. Yayat (Pengawas) dan Sdr. Dede mengambil fire extinguish untuk memadamkan api pada carding no. 2, lalu saya (Iwan - Pengawas) ikut mengambil 1 tabung dan ramai - ramai memadamkan api.	Memadamkan api dengan 3 *fire extinguish* , tetapi yang berfungsi 1 tabung saja, yang 2 lagi tidak berfungsi (kosong dan rusak, tidak keluar / nyemprot). Lalu dilakukan pengecekan dan perbaikan mesin.
26-May-08	Kebakaran Mesin Carding No. 7	Sekitar Pkl. 09.00 Sdr. Supriyadi melihat mesin carding no. 7 megeluarkan asap.	Mesin dimatikan, debu dan kapas yang terbakar dikeluarkan dan dimatikan, disiram air. Lalu dilakukan pengecekan dan perbaikan mesin.

LAMPIRAN 4

Data Perhitungan

Time Between Failure (TBF)

Mesin Carding	Keterangan	Tanggal	Komponen	Waktu Kejadian	Dari jam 12 AM	Ke jam 12 PM	TBF
1	Bearing motor blower rusak	26-Sep-07	B	10:45		13.25	-
2	Blower rusak	9-Mar-07	B	18:00	18	6	-
2	Blower rusak	19-Jul-07	B	19:30	19.5	4.5	3169.5
2	Blower rusak	31-Jul-07	B	18:00	18	6	286.5
2	Bearing motor blower rusak	26-Sep-07	B	10:45	10.75	13.25	1360.75
2	Motor blower terbakar	25-Dec-07	B	3:10	3.1667	20.8333	2152.4167
3	Bearing motor blower rusak	26-Sep-07	B	10:45	10.75	13.25	-
3	Bearing motor blower rusak	22-Dec-07	B	10:30	10.5	13.5	2087.75
3	Bearing motor blower rusak	25-Dec-07	B	16:30	16.5	7.5	78
4	Bearing motor blower rusak	26-Sep-07	B	10:45	10.75	13.25	-
5	Bearing motor blower rusak	26-Sep-07	B	10:45	10.75	13.25	-
6	Belt blower putus	9-Jun-07	B	15:20	15.333	8.66667	-
6	Bearing motor blower rusak	26-Sep-07	B	10:45	10.75	13.25	2611.4167
6	Bearing motor blower rusak	28-Mar-08	B	19:30	19.5	4.5	4424.75
7	Motor blower terbakar	20-Aug-06	B	6:45	6.75	17.25	-
7	Motor blower rusak	11-Sep-06	B	21:00	21	3	542.25
7	Motor blower rusak	31-May-07	B	5:00	5	19	6272
7	Motor blower rusak	5-Sep-07	B	16:30	16.5	7.5	2339.5
7	Motor blower terbakar	24-Mar-08	B	13:50	13.833	10.1667	4821.3333
8	Motor blower terbakar	20-Aug-06	B	6:45	6.75	17.25	-
8	Motor blower rusak	5-Sep-07	B	16:30	16.5	7.5	9153.75
8	Motor blower terbakar	24-Mar-08	B	13:50	13.833	10.1667	4821.3333
9	Motor blower terbakar	20-Aug-06	B	6:45	6.75	17.25	-
9	Kaca tutup blower pecah	23-Mar-07	B	9:30	9.5	14.5	5162.75
9	Motor blower rusak	1-Jun-07	B	5:00	5	19	1675.5
9	Motor blower rusak	5-Sep-07	B	16:30	16.5	7.5	2315.5
9	Motor blower terbakar	24-Mar-08	B	13:50	13.833	10.1667	4821.3333
10	Motor blower terbakar	20-Aug-06	B	6:45	6.75	17.25	-
10	Motor blower rusak	5-Sep-07	B	16:30	16.5	7.5	9153.75
10	Motor blower terbakar	24-Mar-08	B	13:50	13.833	10.1667	4821.3333
11	Motor blower terbakar	20-Aug-06	B	6:45	6.75	17.25	-
11	Motor blower rusak	5-Sep-07	B	16:30	16.5	7.5	9153.75
11	Motor blower terbakar	24-Mar-08	B	13:50	13.833	10.1667	4821.3333
12	Motor blower terbakar	20-Aug-06	B	6:45	6.75	17.25	-
12	Motor blower rusak	5-Sep-07	B	16:30	16.5	7.5	9153.75
12	Blower rusak	28-Oct-07	B	7:45	7.75	16.25	1263.25
12	Motor blower terbakar	24-Mar-08	B	13:50	13.833		3558.0833
1	Coiler bawah tidak jalan	5-Apr-07	Co	3:45		20.25	-
1	Dudukan can tidak jalan	12-Apr-07	Co	19:30	19.5	4.5	183.75
1	Bearing coiler rusak & gigi coiler rusak	18-Nov-07	Co	11:45	11.75	12.25	5272.25
1	Gigi coiler rusak	30-Jan-08	Co	16:30	16.5	7.5	1756.75
2	Gigi coiler rusak	17-Dec-06	Co	12:00	12	12	-
5	Coiler tidak jalan	3-Mar-08	Co	4:00	4	20	-
7	Pulley coiler atas lepas	10-Feb-06	Co	2:30	2.5	21.5	-
7	Gigi coiler rusak	21-May-08	Co	15:30	15.5	8.5	19957
7	Gigi coiler rusak	21-May-08	Co	20:00	20	4	4.5
8	Pulley penggerak coiler lepas	6-Feb-07	Co	4:15	4.25	19.75	-
12	Pulley coiler copot	30-Mar-07	Co	2:45	2.75	21.25	-
12	Gigi coiler rusak	19-Dec-07	Co	14:30	14.5		6347.75
1	Jarak cylinder bergeser (Pinggiran cylinder keluar api)	9-Sep-07	Cy	1:30		22.5	-
1	Cylinder macet	8-Feb-08	Cy	13:10	13.167	10.8333	3659.6667
1	Cylinder macet	10-Feb-08	Cy	20:00	20	4	54.833333
2	Cylinder macet	26-Jun-06	Cy	4:00	4	20	-
2	Cylinder macet	27-Feb-07	Cy	10:30	10.5	13.5	5910.5
2	Cylinder macet	16-Apr-07	Cy	23:30	23.5	0.5	1165

Mesin Carding	Keterangan	Tanggal	Komponen	Waktu Kejadian	Dari jam 12 AM	Ke jam 12 PM	TBF
2	Cylinder macet	2-Jul-07	Cy	17:30	17.5	6.5	1842
2	Cylinder macet	5-Oct-07	Cy	4:00	4	20	2266.5
2	Cylinder macet	14-Nov-07	Cy	2:00	2	22	958
2	Cylinder macet	27-Nov-07	Cy	17:45	17.75	6.25	327.75
2	Jarak cylinder bergeser (Under casing ada percikan api)	26-Dec-07	Cy	3:00	3	21	681.25
2	Cylinder macet	21-Jan-08	Cy	22:20	22.333	1.66667	643.33333
2	Cylinder macet	31-Mar-08	Cy	18:30	18.5	5.5	1676.1667
2	Jarak cylinder bergeser (Ada percikan api di under casing)	13-May-08	Cy	18:30	18.5	5.5	1032
2	Metallic cylinder putus	23-May-08	Cy	7:45	7.75	16.25	229.25
3	Cylinder macet	22-Sep-06	Cy	13:00	13	11	-
3	Cylinder macet	23-Feb-07	Cy	13:45	13.75	10.25	3696.75
4	Cylinder macet	18-Dec-07	Cy	12:00	12	12	-
4	Cylinder keluar asap	19-Dec-07	Cy	20:30	20.5	3.5	32.5
4	Jarak cylinder bergeser (Licker - in keluar api ke samping cylinder)	4-Feb-08	Cy	4:15	4.25	19.75	1111.75
4	Cylinder macet	13-Feb-08	Cy	18:00	18	6	229.75
5	Cylinder macet	14-Apr-08	Cy	14:15	14.25	9.75	-
6	Cylinder macet	2-Feb-08	Cy	23:15	23.25	0.75	-
7	Metalic cylinder cacat	18-Jun-06	Cy	11:45	11.75	12.25	-
7	Jarak licker - in bergeser (Ada kapas terbakar di under casing)	29-Dec-07	Cy	23:30	23.5	0.5	13427.75
7	Jarak cylinder bergeser (Sisa kapas di under casing terbakar)	26-May-08	Cy	9:00	9	15	3561.5
8	Jarak cylinder bergeser (Di samping cylinder keluar asap dari debu yang tebal)	16-Sep-07	Cy	12:15	12.25	11.75	-
10	Cylinder macet	22-Mar-07	Cy	2:00	2	22	
10	Cylinder macet	28-Jul-07	Cy	11:00	11	13	3081
10	Cylinder macet	21-Feb-08	Cy	5:30	5.5	18.5	4986.5
11	Cylinder macet	16-May-06	Cy	2:30	2.5	21.5	-
11	Cylinder macet	21-Aug-07	Cy	19:30	19.5	4.5	11105
12	Cylinder macet	29-Nov-06	Cy	10:00	10	14	-
12	Cylinder macet	9-Mar-07	Cy	18:00	18	6	2408
12	Cylinder macet	15-Mar-07	Cy	15:30	15.5	8.5	141.5
12	Cylinder macet	17-Mar-07	Cy	9:00	9	15	41.5
12	Cylinder macet	22-Dec-07	Cy	23:30	23.5	0.5	6734.5
12	Cylinder macet	2-Jan-08	Cy	13:45	13.75	10.25	254.25
12	Metallic cylinder putus	10-Jan-08	Cy	11:45	11.75	12.25	190
12	Jarak cylinder bergeser (Sisi cylinder ada percikan api)	1-Feb-08	Cy	9:30	9.5	14.5	525.75
12	Jarak cylinder bergeser (Pinggiran cylinder sebelah kiri keluar api)	6-Feb-08	Cy	18:00	18	6	128.5
12	Cylinder macet	5-Mar-08	Cy	13:15	13.25	10.75	667.25
12	Cylinder macet	16-May-08	Cy	2:00	2		1716.75
4	Motor cylinder rusak	27-Apr-06	MC	9:30		14.5	-
4	Motor cylinder rusak	13-May-06	MC	11:30	11.5	12.5	386
4	Motor cylinder terbakar	17-Dec-07	MC	17:30	17.5	6.5	13998
5	Motor cylinder rusak	19-Dec-05	MC	13:30	13.5	10.5	-
5	Mesin bau hangus (motor cylinder terbakar)	4-Nov-07	MC	21:15	21.25	2.75	16447.75
6	Motor cylinder rusak	10-Dec-07	MC	7:00	7	17	-
9	Mesin bau hangus (motor cylinder terbakar)	5-Jul-07	MC	20:30	20.5	3.5	-
9	Motor cylinder rusak	20-Nov-07	MC	12:00	12	12	3303.5
9	Motor cylinder rusak	2-Apr-08	MC	2:00	2	22	3206

Mesin Carding	Keterangan	Tanggal	Komponen	Waktu Kejadian	Dari jam 12 AM	Ke jam 12 PM	TBF
10	Motor cylinder rusak	2-Apr-08	MC	11:00	11	13	-
10	Motor cylinder terbakar	7-May-08	MC	20:55	20.917	3.08333	849.91667
11	Motor cylinder rusak	7-Sep-06	MC	0:45	0.75		
1	Metallic doffer cacat (sliver "nyetrip")	5-Jul-07	D	7:00		17	-
1	Metallic doffer putus	9-Jan-08	D	4:30	4.5	19.5	4509.5
3	Gigi doffer rusak	9-Sep-07	D	12:00	12	12	-
3	Baut motor doffer ke mesin patah satu	23-Dec-07	D	3:00	3	21	2511
3	Kap doffer bergesekan dengan brush doffer	14-May-08	D	3:00	3	21	3432
4	Metallic doffer cacat (sliver "nyetrip")	27-Jun-07	D	13:30	13.5	10.5	-
4	Dudukan penyangga doffer copot	13-Jul-07	D	20:00	20	4	390.5
4	Metallic doffer cacat (sliver "nyetrip")	11-Sep-07	D	9:30	9.5	14.5	1429.5
4	Brush doffer tidak jalan	14-Jan-08	D	0:00	0	24	2990.5
5	Brush doffer rusak (diganti yang baru)	25-Jun-06	D	18:00	18	6	-
7	Metallic doffer cacat (sliver "nyetrip")	18-Jun-06	D	11:45	11.75	12.25	-
7	Pulley doffer brush longgar	29-Apr-08	D	17:00	17	7	16349.25
8	Metallic doffer cacat (sliver "nyetrip")	2-Nov-07	D	22:10	22.167	1.83333	-
8	As gigi roller doffer aus	15-Jan-08	D	0:00	0	24	1753.8333
10	Gigi doffer macet	25-Jun-06	D	7:00	7	17	-
11	Gigi doffer rusak	11-Apr-07	D	19:00	19	5	-
12	Pulley doffer pecah	3-Sep-06	D	2:30	2.5	21.5	-
12	Bricket penghantar doffer tidak jalan	23-Mar-07	D	10:00	10	14	4831.5
12	Gigi doffer rusak	14-Apr-07	D	7:15	7.25	16.75	525.25
12	Metallic doffer cacat (sliver "nyetrip")	31-Jul-07	D	15:30	15.5	8.5	2600.25
12	Metallic doffer cacat (sliver "nyetrip")	12-Dec-07	D	22:15	22.25	1.75	3222.75
12	Gigi doffer lepas	12-Feb-08	D	2:30	2.5	21.5	1468.25
12	Gigi doffer lepas	16-May-08	D	2:00	2		2255.5
2	Garnet licker - in cacat	26-Jan-08	L	9:00		15	-
3	Licker - in macet	22-Sep-06	L	13:00	13	11	-
5	As pulley licker - in longgar	16-Jul-07	L	11:00	11	13	-
5	Bricket mote knife patah dan mote knife cacat	5-Nov-07	L	7:30	7.5	16.5	2684.5
6	Licker - in macet	29-Dec-05	L	3:15	3.25	20.75	-
6	Garnet licker - in cacat	16-Mar-06	L	13:15	13.25	10.75	1858
8	Licker - in macet	22-Feb-08	L	3:30	3.5	20.5	-
11	Dudukan per pisau roll patah	28-Mar-08	L	11:00	11	13	-
12	Licker - in macet	22-May-08	L	11:00	11	13	-
12	Brickat mote knife patah & Garnet licker - in cacat	28-May-08	L	7:45	7.75		140.75
1	Inverter rusak	10-Sep-06	P	7:30		16.5	-
1	Start tidak jalan	14-Apr-07	P	2:45	2.75	21.25	5179.25
1	Start doffer tidak jalan	8-Feb-08	P	10:30	10.5	13.5	7207.75
2	Start doffer macet	29-Nov-06	P	2:30	2.5	21.5	-
2	Layar LCD panel mati	7-Mar-07	P	7:00	7	17	2356.5
2	Start tidak jalan	29-Jul-07	P	0:00	0	24	3449
2	Start doffer macet	14-Aug-07	P	0:00	0	24	384
2	Kabel sensor contact ke body	29-Nov-07	P	23:00	23	1	2591
2	Tombol doffer tidak normal	18-Feb-08	P	18:00	18	6	1939

Mesin Carding	Keterangan	Tanggal	Komponen	Waktu Kejadian	Dari jam 12 AM	Ke jam 12 PM	TBF
2	Panel off	31-Mar-08	P	3:15	3.25	20.75	993.25
2	Start tidak jalan	7-Apr-08	P	23:00	23	1	187.75
3	Start doffer tidak jalan	29-Mar-06	P	20:30	20.5	3.5	-
3	Inverter rusak	19-May-06	P	3:00	3	21	1206.5
3	Start doffer macet	16-Dec-06	P	20:30	20.5	3.5	5081.5
3	Start doffer macet	21-Dec-06	P	3:00	3	21	102.5
3	Start tidak jalan	21-Apr-07	P	0:00	0	24	2901
3	Start tidak jalan	13-Nov-07	P	22:30	22.5	1.5	4966.5
4	Tombol doffer tidak jalan	2-Jul-07	P	4:45	4.75	19.25	-
5	Start doffer macet	29-Nov-06	P	2:30	2.5	21.5	-
5	Jalur lamp sinyal konslet	5-Mar-07	P	0:00	0	24	2301.5
5	Panel off	14-Jun-07	P	14:30	14.5	9.5	2438.5
5	Inverter rusak	26-Sep-07	P	16:30	16.5	7.5	2498
5	Panel off	3-Apr-08	P	12:30	12.5	11.5	4556
6	Inverter rusak	3-May-06	P	13:00	13	11	-
6	Start doffer macet	14-Mar-07	P	18:00	18	6	7565
6	Inverter rusak	27-Jun-07	P	0:30	0.5	23.5	2502.5
6	Panel off	18-Mar-08	P	23:15	23.25	0.75	6382.75
6	Panel off	2-Apr-08	P	10:20	10.333	13.6667	347.08333
7	Start tidak jalan	7-Feb-06	P	10:30	10.5	13.5	-
7	Start tidak jalan	5-Jul-06	P	23:00	23	1	3564.5
7	Inverter rusak	17-Jul-06	P	11:00	11	13	276
7	Panel off	25-Sep-07	P	20:00	20	4	10449
7	Panel off	4-Nov-07	P	22:00	22	2	962
8	Inverter rusak	15-Jul-07	P	15:45	15.75	8.25	-
8	Start tidak jalan	31-Oct-07	P	2:30	2.5	21.5	2578.75
8	Panel off	4-Nov-07	P	22:00	22	2	115.5
9	Konsleting	28-Jan-07	P	11:30	11.5	12.5	-
9	Panel off	30-May-07	P	20:00	20	4	2936.5
9	Panel off	4-Nov-07	P	22:00	22	2	3794
9	Start cylinder mati terus	5-Mar-08	P	0:00	0	24	2906
10	Inverter rusak	27-Jan-06	P	8:00	8	16	-
10	Lampu sinyal rusak	21-Dec-06	P	13:45	13.75	10.25	7877.75
10	Kabel ke blower konslet	31-Jul-07	P	3:30	3.5	20.5	5317.75
10	Panel off	4-Nov-07	P	22:00	22	2	2322.5
10	Panel off	4-Feb-08	P	21:15	21.25	2.75	2207.25
10	Inverter rusak	9-Apr-08	P	16:15	16.25	7.75	1555
11	Panel off	4-Nov-07	P	22:00	22	2	-
11	Inverter rusak	10-Jan-08	P	18:00	18	6	1604
12	Panel off	4-Nov-07	P	22:00	22	2	-
12	Start tidak jalan	28-Apr-08	P	14:20	14.333		4216.3333
1	Sensor doffer tidak aktif	10-Feb-08	SD	16:00		8	-
2	Sensor doffer tidak aktif	8-Dec-06	SD	6:00	6	18	-
2	Sensor doffer tidak aktif	13-Feb-07	SD	0:15	0.25	23.75	1602.25
2	Sensor doffer tidak aktif	5-Jul-07	SD	2:00	2	22	3409.75
2	Sensor doffer tidak aktif	20-Jul-07	SD	7:30	7.5	16.5	365.5
2	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	6	18	6118.5
3	Sensor doffer tidak aktif	19-Jun-06	SD	2:00	2	22	-
3	Sensor doffer tidak aktif	22-Sep-06	SD	0:45	0.75	23.25	2278.75
3	Sensor doffer tidak aktif	19-Jan-07	SD	3:00	3	21	2858.25
3	Sensor doffer tidak aktif	1-Feb-07	SD	22:00	22	2	331
3	Sensor doffer tidak aktif	30-May-07	SD	3:00	3	21	2813
3	Sensor doffer tidak aktif	14-Aug-07	SD	23:00	23	1	1844
3	Sensor doffer tidak aktif	7-Dec-07	SD	18:30	18.5	5.5	2755.5
3	Sensor doffer tidak aktif	12-Jan-08	SD	10:00	10	14	855.5
3	Sensor doffer tidak aktif	13-Feb-08	SD	2:45	2.75	21.25	760.75
3	Sensor doffer tidak aktif	31-Mar-08	SD	4:45	4.75	19.25	1130

Mesin Carding	Keterangan	Tanggal	Komponen	Waktu Kejadian	Dari jam 12 AM	Ke jam 12 PM	TBF
3	Sensor doffer tidak aktif	14-May-08	SD	23:00	23	1	1074.25
4	Sensor doffer tidak aktif	9-Jun-06	SD	1:00	1	23	-
4	Sensor doffer tidak aktif	18-Jun-06	SD	23:30	23.5	0.5	238.5
4	Sensor doffer tidak aktif	24-Jun-06	SD	1:00	1	23	121.5
4	Sensor doffer tidak aktif	23-Feb-07	SD	1:30	1.5	22.5	5856.5
4	Sensor doffer tidak aktif	28-Feb-07	SD	1:00	1	23	119.5
4	Sensor doffer tidak aktif	5-Mar-07	SD	23:00	23	1	142
4	Sensor doffer tidak aktif	8-Mar-07	SD	8:00	8	16	57
4	Sensor doffer tidak aktif	10-Sep-07	SD	16:15	16.25	7.75	4472.25
5	Sensor doffer tidak aktif	19-Jun-06	SD	2:00	2	22	-
5	Sensor doffer tidak aktif	12-Aug-06	SD	1:30	1.5	22.5	1295.5
5	Sensor doffer tidak aktif	5-Jan-07	SD	2:00	2	22	3504.5
5	Sensor doffer tidak aktif	2-Mar-07	SD	22:30	22.5	1.5	1364.5
5	Sensor doffer tidak aktif	8-Mar-07	SD	23:30	23.5	0.5	145
5	Sensor doffer tidak aktif	28-Nov-07	SD	10:00	10	14	6346.5
6	Sensor doffer tidak aktif	20-Jun-06	SD	1:00	1	23	-
6	Sensor doffer tidak aktif	6-Jul-06	SD	22:25	22.417	1.58333	405.41667
6	Sensor doffer tidak aktif	1-Mar-07	SD	0:30	0.5	23.5	5690.0833
6	Sensor doffer tidak aktif	24-Mar-07	SD	0:30	0.5	23.5	552
6	Sensor doffer tidak aktif	4-Oct-07	SD	23:00	23	1	4678.5
6	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	6	18	4279
7	Sensor doffer tidak aktif	7-May-06	SD	2:30	2.5	21.5	-
7	Sensor doffer tidak aktif	15-Jul-06	SD	10:00	10	14	1663.5
7	Sensor doffer tidak aktif	2-Apr-07	SD	8:00	8	16	6262
7	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	6	18	8734
7	Sensor doffer tidak aktif	21-Apr-08	SD	23:30	23.5	0.5	521.5
8	Sensor doffer tidak aktif	25-Feb-07	SD	23:30	23.5	0.5	-
8	Sensor doffer tidak aktif	2-Apr-07	SD	8:00	8	16	848.5
8	Sensor doffer tidak aktif	12-Jan-08	SD	10:00	10	14	6842
8	Kabel sensor doffer putus	23-Jan-08	SD	19:00	19	5	273
9	Sensor doffer tidak aktif	2-Apr-07	SD	8:00	8	16	-
10	Sensor doffer tidak aktif	15-Jan-08	SD	2:00	2	22	-
11	Sensor doffer tidak aktif	19-Jun-06	SD	2:00	2	22	-
11	Sensor doffer tidak aktif	16-Jun-07	SD	10:00	10	14	8696
12	Sensor doffer tidak aktif	3-Mar-08	SD	8:00	8	16	-
12	Sensor doffer tidak aktif	5-Mar-08	SD	13:15	13.25	10.75	53.25
12	Sensor doffer tidak aktif	7-Mar-08	SD	22:15	22.25	1.75	57
12	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	6		559.75
1	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	10-Dec-06	SF	17:00		7	-
2	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	1-Apr-08	SF	22:45	22.75	1.25	-
3	Sensor feedroller tidak berfungsi (sinyal hijau menyala terus)	4-Jun-06	SF	15:45	15.75	8.25	-
5	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	5-Nov-07	SF	16:15	16.25	7.75	-
5	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	27-Nov-07	SF	11:00	11	13	522.75
6	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	1-Apr-08	SF	19:00	19	5	-
6	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	15-May-08	SF	21:45	21.75	2.25	1058.75
7	Switch sensor feedroller tidak aktif	1-May-08	SF	12:45	12.75	11.25	-
7	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	2-May-08	SF	7:30	7.5	16.5	18.75
8	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	29-Jun-07	SF	16:30	16.5	7.5	-

Mesin Carding	Keterangan	Tanggal	Komponen	Waktu Kejadian	Dari jam 12 AM	Ke jam 12 PM	TBF
11	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	16-Sep-07	SF	10:00	10		-
1	Combtoplet tidak jalan (Combbox pulley toplet tidak jalan)	28-Apr-06	T	1:30		22.5	-
1	Combtoplet tidak jalan (Combbox pulley toplet tidak jalan)	22-Aug-07	T	18:15	18.25	5.75	11560.75
2	Bartoplet rusak	19-Apr-07	T	8:00	8	16	-
3	Bartoplet rusak	11-Apr-07	T	8:00	8	16	-
3	Van belt toplet rusak	9-Oct-07	T	9:00	9	15	4345
5	Cincin toplet bergeser	7-Aug-07	T	11:00	11	13	-
5	Pulley toplet macet	1-Nov-07	T	19:45	19.75	4.25	2072.75
6	Belt pulley toplet putus	21-Sep-06	T	21:30	21.5	2.5	-
7	Combtoplet tidak jalan	2-Apr-07	T	3:00	3	21	-
7	As combtoplet patah	3-Apr-07	T	0:30	0.5	23.5	21.5
7	Toplet rusak	13-Apr-07	T	2:00	2	22	241.5
7	Combtoplet handle penggerak patah	2-Apr-08	T	22:15	22.25	1.75	8540.25
8	Pulley toplet "goplak"	30-Aug-07	T	3:45	3.75	20.25	-
9	Toplet kotor	28-Sep-07	T	7:00	7	17	-
9	Rantai toplet kendor	4-Oct-07	T	1:30	1.5	22.5	138.5
10	Baut combtoplet lepas	12-Jul-07	T	20:15	20.25	3.75	-
11	Toplet kotor	14-Jun-06	T	7:00	7	17	-
11	Penggerak combtoplet tidak jalan	23-Mar-07	T	4:30	4.5	19.5	6765.5
12	Toplet kotor	17-Jun-06	T	10:30	10.5	13.5	-
12	Pulley toplet macet	5-Feb-08	T	2:15	2.25		14343.75

Keterangan :

B : *Blower*

Co : *Coiler*

Cy : *Cylinder*

MC : Motor *Cylinder*

D : *Doffer*

L : *Licker – in*

P : Panel

SD : Sensor *Doffer*

SF : Sensor *Feedroller*

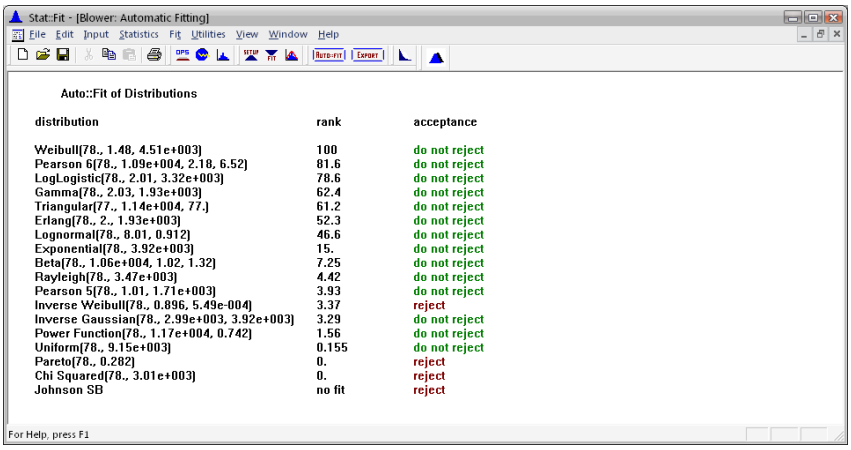
T : Toplet

LAMPIRAN 5

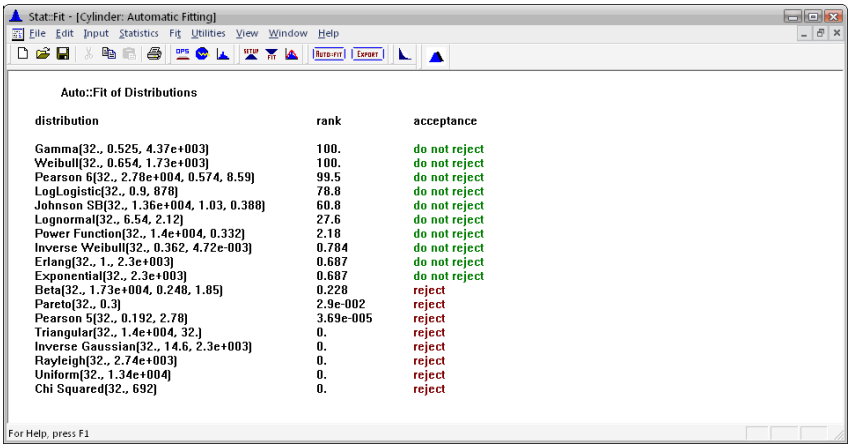
Hasil Penentuan Distribusi

dengan *Stat::Fit*

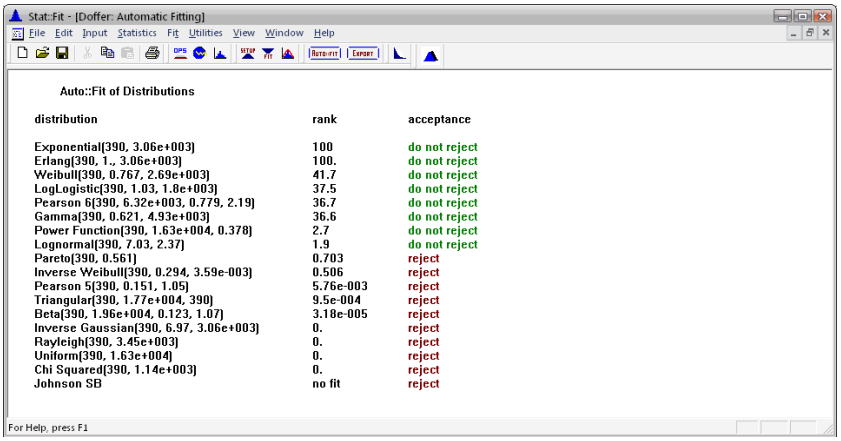
- Komponen *Blower*



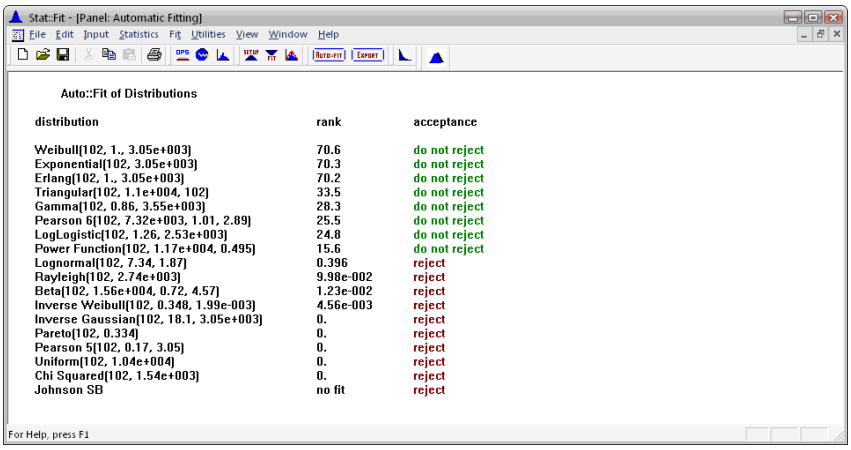
- Komponen *Cylinder*



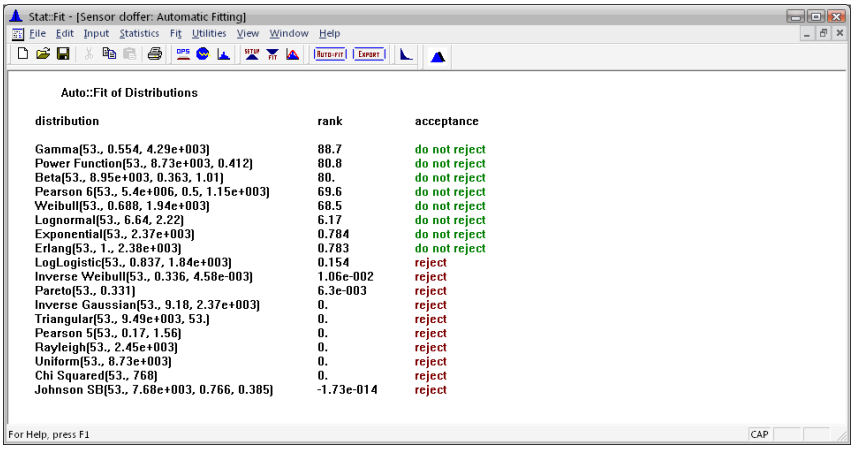
- Komponen *Doffer*



- Komponen *Panel*



- Komponen *Sensor doffer*



LAMPIRAN 6

Data Perhitungan *Downtime* dan *Mean Downtime*

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
1	Bearing motor blower rusak	26-Sep-07	B	10:45	26-Sep-07	13:30	13.25	13.5	2.75
2	Blower rusak	9-Mar-07	B	18:00	9-Mar-07	20:00	6	20	2
2	Blower rusak	19-Jul-07	B	19:30	19-Jul-07	20:45	4.5	20.75	1.25
2	Blower rusak	31-Jul-07	B	18:00	31-Jul-07	20:00	6	20	2
2	Bearing motor blower rusak	26-Sep-07	B	10:45	26-Sep-07	13:30	13.25	13.5	2.75
2	Motor blower terbakar	25-Dec-07	B	3:10	25-Dec-07	9:00	20.8333	9	5.8333333
3	Bearing motor blower rusak	26-Sep-07	B	10:45	26-Sep-07	13:30	13.25	13.5	2.75
3	Bearing motor blower rusak	22-Dec-07	B	10:30	23-Dec-07	10:00	13.5	10	23.5
3	Bearing motor blower rusak	25-Dec-07	B	16:30	26-Dec-07	16:15	7.5	16.25	23.75
4	Bearing motor blower rusak	26-Sep-07	B	10:45	26-Sep-07	13:30	13.25	13.5	2.75
5	Bearing motor blower rusak	26-Sep-07	B	10:45	26-Sep-07	13:30	13.25	13.5	2.75
6	Belt blower putus	9-Jun-07	B	15:20	9-Jun-07	16:30	8.66667	16.5	1.1666667
6	Bearing motor blower rusak	26-Sep-07	B	10:45	26-Sep-07	13:30	13.25	13.5	2.75
6	Bearing motor blower rusak	28-Mar-08	B	19:30	29-Mar-08	11:00	4.5	11	15.5
7	Motor blower terbakar	20-Aug-06	B	6:45	20-Aug-06	11:15	17.25	11.25	4.5
7	Motor blower rusak	11-Sep-06	B	21:00	12-Sep-06	11:00	3	11	14
7	Motor blower rusak	31-May-07	B	5:00	31-May-07	6:00	19	6	1
7	Motor blower rusak	5-Sep-07	B	16:30	5-Sep-07	17:30	7.5	17.5	1
7	Motor blower terbakar	24-Mar-08	B	13:50	24-Mar-08	15:45	10.1667	15.75	1.9166667
8	Motor blower terbakar	20-Aug-06	B	6:45	20-Aug-06	11:15	17.25	11.25	4.5
8	Motor blower rusak	5-Sep-07	B	16:30	5-Sep-07	17:45	7.5	17.75	1.25
8	Motor blower terbakar	24-Mar-08	B	13:50	24-Mar-08	15:45	10.1667	15.75	1.9166667
9	Motor blower terbakar	20-Aug-06	B	6:45	20-Aug-06	11:15	17.25	11.25	4.5
9	Kaca tutup blower pecah	23-Mar-07	B	9:30	23-Mar-07	10:30	14.5	10.5	1
9	Motor blower rusak	1-Jun-07	B	5:00	1-Jun-07	6:30	19	6.5	1.5
9	Motor blower rusak	5-Sep-07	B	16:30	5-Sep-07	18:15	7.5	18.25	1.75
9	Motor blower terbakar	24-Mar-08	B	13:50	24-Mar-08	15:45	10.1667	15.75	1.9166667
10	Motor blower terbakar	20-Aug-06	B	6:45	20-Aug-06	11:15	17.25	11.25	4.5
10	Motor blower rusak	5-Sep-07	B	16:30	5-Sep-07	18:40	7.5	18.66667	2.1666667
10	Motor blower terbakar	24-Mar-08	B	13:50	24-Mar-08	15:45	10.1667	15.75	1.9166667
11	Motor blower terbakar	20-Aug-06	B	6:45	20-Aug-06	11:15	17.25	11.25	4.5
11	Motor blower rusak	5-Sep-07	B	16:30	5-Sep-07	19:10	7.5	19.16667	2.6666667
11	Motor blower terbakar	24-Mar-08	B	13:50	24-Mar-08	15:45	10.1667	15.75	1.9166667
12	Motor blower terbakar	20-Aug-06	B	6:45	20-Aug-06	11:15	17.25	11.25	4.5
12	Motor blower rusak	5-Sep-07	B	16:30	5-Sep-07	19:30	7.5	19.5	3
12	Blower rusak	28-Oct-07	B	7:45	28-Oct-07	10:00	16.25	10	2.25
12	Motor blower terbakar	24-Mar-08	B	13:50	24-Mar-08	15:45	10.1667	15.75	1.9166667
Mean Downtime									4.3671171
1	Coiler bawah tidak jalan	5-Apr-07	Co	3:45	5-Apr-07	7:30	20.25	7.5	3.75
1	Dudukan can tidak jalan	12-Apr-07	Co	19:30	12-Apr-07	20:45	4.5	20.75	1.25
1	Bearing coiler rusak & gigi coiler rusak	18-Nov-07	Co	11:45	18-Nov-07	16:00	12.25	16	4.25
1	Gigi coiler rusak	30-Jan-08	Co	16:30	30-Jan-08	18:15	7.5	18.25	1.75
2	Gigi coiler rusak	17-Dec-06	Co	12:00	17-Dec-06	14:30	12	14.5	2.5
5	Coiler tidak jalan	3-Mar-08	Co	4:00	3-Mar-08	7:00	20	7	3
7	Pulley coiler atas lepas	10-Feb-06	Co	2:30	10-Feb-06	6:00	21.5	6	3.5
7	Gigi coiler rusak	21-May-08	Co	15:30	21-May-08	17:00	8.5	17	1.5
7	Gigi coiler rusak	21-May-08	Co	20:00	22-May-08	6:30	4	6.5	10.5
8	Pulley penggerak coiler lepas	6-Feb-07	Co	4:15	6-Feb-07	6:00	19.75	6	1.75
12	Pulley coiler copot	30-Mar-07	Co	2:45	30-Mar-07	4:00	21.25	4	1.25
12	Gigi coiler rusak	19-Dec-07	Co	14:30	19-Dec-07	16:30	9.5	16.5	2
Mean Downtime									3.0833333

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
1	Jarak cylinder bergeser (Pinggiran cylinder keluar api)	9-Sep-07	Cy	1:30	9-Sep-07	6:00	22.5	6	4.5
1	Cylinder macet	8-Feb-08	Cy	13:10	8-Feb-08	14:00	10.8333	14	0.8333333
1	Cylinder macet	10-Feb-08	Cy	20:00	10-Feb-08	20:45	4	20.75	0.75
2	Cylinder macet	26-Jun-06	Cy	4:00	26-Jun-06	5:00	20	5	1
2	Cylinder macet	27-Feb-07	Cy	10:30	27-Feb-07	11:15	13.5	11.25	0.75
2	Cylinder macet	16-Apr-07	Cy	23:30	17-Apr-07	0:30	0.5	0.5	1
2	Cylinder macet	2-Jul-07	Cy	17:30	2-Jul-07	18:10	6.5	18.16667	0.6666667
2	Cylinder macet	5-Oct-07	Cy	4:00	5-Oct-07	6:30	20	6.5	2.5
2	Cylinder macet	14-Nov-07	Cy	2:00	14-Nov-07	3:30	22	3.5	1.5
2	Cylinder macet	27-Nov-07	Cy	17:45	27-Nov-07	18:30	6.25	18.5	0.75
2	Jarak cylinder bergeser (Under casing ada percikan api)	26-Dec-07	Cy	3:00	26-Dec-07	10:00	21	10	7
2	Cylinder macet	21-Jan-08	Cy	22:20	21-Jan-08	23:45	1.66667	23.75	1.4166667
2	Cylinder macet	31-Mar-08	Cy	18:30	31-Mar-08	19:00	5.5	19	0.5
2	Jarak cylinder bergeser (Ada percikan api di under casing)	13-May-08	Cy	18:30	13-May-08	19:30	5.5	19.5	1
2	Metallic cylinder putus	23-May-08	Cy	7:45	31-May-08	15:00	16.25	15	199.25
3	Cylinder macet	22-Sep-06	Cy	13:00	22-Sep-06	14:00	11	14	1
3	Cylinder macet	23-Feb-07	Cy	13:45	23-Feb-07	14:15	10.25	14.25	0.5
4	Cylinder macet	18-Dec-07	Cy	12:00	18-Dec-07	13:45	12	13.75	1.75
4	Cylinder keluar asap	19-Dec-07	Cy	20:30	21-Dec-07	8:30	3.5	8.5	36
4	Jarak cylinder bergeser (Licker - in keluar api ke samping cylinder)	4-Feb-08	Cy	4:15	4-Feb-08	8:15	19.75	8.25	4
4	Cylinder macet	13-Feb-08	Cy	18:00	13-Feb-08	18:45	6	18.75	0.75
5	Cylinder macet	14-Apr-08	Cy	14:15	14-Apr-08	16:00	9.75	16	1.75
6	Cylinder macet	2-Feb-08	Cy	23:15	3-Feb-08	0:00	0.75	0	0.75
7	Metalic cylinder cacat	18-Jun-06	Cy	11:45	20-Jun-06	17:00	12.25	17	53.25
7	Jarak licker - in bergeser (Ada kapas terbakar di under casing)	29-Dec-07	Cy	23:30	29-Dec-07	23:45	0.5	23.75	0.25
7	Jarak cylinder bergeser (Sisa kapas di under casing terbakar)	26-May-08	Cy	9:00	26-May-08	10:00	15	10	1
8	Jarak cylinder bergeser (Di samping cylinder keluar asap dari debu yang tebal)	16-Sep-07	Cy	12:15	16-Sep-07	14:00	11.75	14	1.75
10	Cylinder macet	22-Mar-07	Cy	2:00	22-Mar-07	6:00	22	6	4
10	Cylinder macet	28-Jul-07	Cy	11:00	28-Jul-07	11:40	13	11.66667	0.6666667
10	Cylinder macet	21-Feb-08	Cy	5:30	21-Feb-08	6:00	18.5	6	0.5
11	Cylinder macet	16-May-06	Cy	2:30	16-May-06	3:15	21.5	3.25	0.75
11	Cylinder macet	21-Aug-07	Cy	19:30	21-Aug-07	20:30	4.5	20.5	1
12	Cylinder macet	29-Nov-06	Cy	10:00	29-Nov-06	11:00	14	11	1
12	Cylinder macet	9-Mar-07	Cy	18:00	9-Mar-07	19:15	6	19.25	1.25
12	Cylinder macet	15-Mar-07	Cy	15:30	15-Mar-07	16:25	8.5	16.41667	0.9166667
12	Cylinder macet	17-Mar-07	Cy	9:00	17-Mar-07	10:15	15	10.25	1.25
12	Cylinder macet	22-Dec-07	Cy	23:30	23-Dec-07	0:10	0.5	0.166667	0.6666667
12	Cylinder macet	2-Jan-08	Cy	13:45	2-Jan-08	14:00	10.25	14	0.25
12	Metallic cylinder putus	10-Jan-08	Cy	11:45	19-Jan-08	16:00	12.25	16	220.25
12	Jarak cylinder bergeser (Sisi cylinder ada percikan api)	1-Feb-08	Cy	9:30	1-Feb-08	11:30	14.5	11.5	2
12	Jarak cylinder bergeser (Pinggiran cylinder sebelah kiri keluar api)	6-Feb-08	Cy	18:00	6-Feb-08	19:00	6	19	1
12	Cylinder macet	5-Mar-08	Cy	13:15	5-Mar-08	14:00	10.75	14	0.75
12	Cylinder macet	16-May-08	Cy	2:00	16-May-08	9:00	22	9	7
Mean Downtime									13.242248

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
4	Motor cylinder rusak	27-Apr-06	MC	9:30	27-Apr-06	11:00	14.5	11	1.5
4	Motor cylinder rusak	13-May-06	MC	11:30	13-May-06	13:00	12.5	13	1.5
4	Motor cylinder terbakar	17-Dec-07	MC	17:30	18-Dec-07	10:30	6.5	10.5	17
5	Motor cylinder rusak	19-Dec-05	MC	13:30	19-Dec-05	17:00	10.5	17	3.5
5	Mesin bau hangus (motor cylinder terbakar)	4-Nov-07	MC	21:15	4-Nov-07	23:00	2.75	23	1.75
6	Motor cylinder rusak	10-Dec-07	MC	7:00	10-Dec-07	11:00	17	11	4
9	Mesin bau hangus (motor cylinder terbakar)	5-Jul-07	MC	20:30	6-Jul-07	15:00	3.5	15	18.5
9	Motor cylinder rusak	20-Nov-07	MC	12:00	20-Nov-07	14:30	12	14.5	2.5
9	Motor cylinder rusak	2-Apr-08	MC	2:00	2-Apr-08	8:45	22	8.75	6.75
10	Motor cylinder rusak	2-Apr-08	MC	11:00	2-Apr-08	14:00	13	14	3
10	Motor cylinder terbakar	7-May-08	MC	20:55	9-May-08	10:00	3.08333	10	37.083333
11	Motor cylinder rusak	7-Sep-06	MC	0:45	7-Sep-06	11:00	23.25	11	10.25
Mean Downtime									**8.9444444**
1	Metallic doffer cacat (sliver "nyetrip")	5-Jul-07	D	7:00	5-Jul-07	12:00	17	12	5
1	Metallic doffer putus	9-Jan-08	D	4:30	11-Jan-08	10:00	19.5	10	53.5
3	Gigi doffer rusak	9-Sep-07	D	12:00	9-Sep-07	14:00	12	14	2
3	Baut motor doffer ke mesin patah satu	23-Dec-07	D	3:00	23-Dec-07	4:30	21	4.5	1.5
3	Kap doffer bergesekan dengan brush doffer	14-May-08	D	3:00	14-May-08	6:00	21	6	3
4	Metallic doffer cacat (sliver "nyetrip")	27-Jun-07	D	13:30	27-Jun-07	18:00	10.5	18	4.5
4	Dudukan penyangga doffer copot	13-Jul-07	D	20:00	14-Jul-07	10:00	4	10	14
4	Metallic doffer cacat (sliver "nyetrip")	11-Sep-07	D	9:30	11-Sep-07	17:00	14.5	17	7.5
4	Brush doffer tidak jalan	14-Jan-08	D	0:00	14-Jan-08	6:00	24	6	6
5	Brush doffer rusak (diganti yang baru)	25-Jun-06	D	18:00	26-Jun-06	7:30	6	7.5	13.5
7	Metallic doffer cacat (sliver "nyetrip")	18-Jun-06	D	11:45	18-Jun-06	19:00	12.25	19	7.25
7	Pulley doffer brush longgar	29-Apr-08	D	17:00	30-Apr-08	7:00	7	7	14
8	Metallic doffer cacat (sliver "nyetrip")	2-Nov-07	D	22:10	3-Nov-07	13:00	1.83333	13	14.833333
8	As gigi roller doffer aus	15-Jan-08	D	0:00	15-Jan-08	9:00	24	9	9
10	Gigi doffer macet	25-Jun-06	D	7:00	25-Jun-06	10:00	17	10	3
11	Gigi doffer rusak	11-Apr-07	D	19:00	12-Apr-07	9:00	5	9	14
12	Pulley doffer pecah	3-Sep-06	D	2:30	5-Sep-06	13:00	21.5	13	58.5
12	Bricket penghantar doffer tidak jalan	23-Mar-07	D	10:00	23-Mar-07	11:30	14	11.5	1.5
12	Gigi doffer rusak	14-Apr-07	D	7:15	14-Apr-07	9:30	16.75	9.5	2.25
12	Metallic doffer cacat (sliver "nyetrip")	31-Jul-07	D	15:30	31-Jul-07	19:00	8.5	19	3.5
12	Metallic doffer cacat (sliver "nyetrip")	12-Dec-07	D	22:15	13-Dec-07	9:30	1.75	9.5	11.25
12	Gigi doffer lepas	12-Feb-08	D	2:30	12-Feb-08	7:00	21.5	7	4.5
12	Gigi doffer lepas	16-May-08	D	2:00	16-May-08	9:00	22	9	7
Mean Downtime									**11.351449**
2	Garnet licker - in cacat	26-Jan-08	L	9:00	27-Jan-08	16:00	15	16	31
3	Licker - in macet	22-Sep-06	L	13:00	22-Sep-06	14:00	11	14	1
5	As pulley licker - in longgar	16-Jul-07	L	11:00	16-Jul-07	12:30	13	12.5	1.5
5	Bricket mote knife patah dan mote knife cacat	5-Nov-07	L	7:30	5-Nov-07	11:00	16.5	11	3.5
6	Licker - in macet	29-Dec-05	L	3:15	29-Dec-05	10:00	20.75	10	6.75

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
6	Garnet licker - in cacat	16-Mar-06	L	13:15	17-Mar-06	18:00	10.75	18	28.75
8	Licker - in macet	22-Feb-08	L	3:30	22-Feb-08	6:00	20.5	6	2.5
11	Dudukan per pisau roll patah	28-Mar-08	L	11:00	28-Mar-08	13:00	13	13	2
12	Licker - in macet	22-May-08	L	11:00	22-May-08	16:00	13	16	5
12	Brickat mote knife patah & Garnet licker - in cacat	28-May-08	L	7:45	29-May-08	11:15	16.25	11.25	27.5
Mean Downtime									10.95
1	Inverter rusak	10-Sep-06	P	7:30	10-Sep-06	9:15	16.5	9.25	1.75
1	Start tidak jalan	14-Apr-07	P	2:45	14-Apr-07	6:00	21.25	6	3.25
1	Contactor doffer tidak berfungsi	8-Feb-08	P	10:30	8-Feb-08	12:00	13.5	12	1.5
2	Start doffer macet	29-Nov-06	P	2:30	29-Nov-06	3:00	21.5	3	0.5
2	Layar LCD panel mati	7-Mar-07	P	7:00	7-Mar-07	11:00	17	11	4
2	Start tidak jalan	29-Jul-07	P	0:00	29-Jul-07	0:30	24	0.5	0.5
2	Start doffer macet	14-Aug-07	P	0:00	14-Aug-07	0:20	24	0.333333	0.3333333
2	Konsleting	29-Nov-07	P	23:00	30-Nov-07	0:30	1	0.5	1.5
2	Tombol doffer tidak normal	18-Feb-08	P	18:00	18-Feb-08	19:00	6	19	1
2	Panel off	31-Mar-08	P	3:15	31-Mar-08	6:00	20.75	6	2.75
2	Start tidak jalan	7-Apr-08	P	23:00	7-Apr-08	23:30	1	23.5	0.5
3	Contactor doffer tidak berfungsi	29-Mar-06	P	20:30	30-Mar-06	7:00	3.5	7	10.5
3	Inverter rusak	19-May-06	P	3:00	20-May-06	7:00	21	7	28
3	Start doffer macet	16-Dec-06	P	20:30	16-Dec-06	21:15	3.5	21.25	0.75
3	Start doffer macet	21-Dec-06	P	3:00	21-Dec-06	4:30	21	4.5	1.5
3	Start tidak jalan	21-Apr-07	P	0:00	21-Apr-07	1:00	24	1	1
3	Start tidak jalan	13-Nov-07	P	22:30	13-Nov-07	23:30	1.5	23.5	1
4	Tombol doffer tidak jalan	2-Jul-07	P	4:45	2-Jul-07	6:00	19.25	6	1.25
5	Start doffer macet	29-Nov-06	P	2:30	29-Nov-06	3:20	21.5	3.333333	0.8333333
5	Jalur lamp sinyal konslet	5-Mar-07	P	0:00	5-Mar-07	7:00	24	7	7
5	Panel off	14-Jun-07	P	14:30	14-Jun-07	15:10	9.5	15.16667	0.6666667
5	Inverter rusak	26-Sep-07	P	16:30	26-Sep-07	17:30	7.5	17.5	1
5	Panel off	3-Apr-08	P	12:30	3-Apr-08	13:15	11.5	13.25	0.75
6	Inverter rusak	3-May-06	P	13:00	3-May-06	14:45	11	14.75	1.75
6	Start doffer macet	14-Mar-07	P	18:00	14-Mar-07	18:30	6	18.5	0.5
6	Inverter rusak	27-Jun-07	P	0:30	27-Jun-07	8:00	23.5	8	7.5
6	Panel off	18-Mar-08	P	23:15	19-Mar-08	2:00	0.75	2	2.75
6	Panel off	2-Apr-08	P	10:20	2-Apr-08	11:00	13.6667	11	0.6666667
7	Start tidak jalan	7-Feb-06	P	10:30	7-Feb-06	13:00	13.5	13	2.5
7	Start tidak jalan	5-Jul-06	P	23:00	6-Jul-06	9:30	1	9.5	10.5
7	Inverter rusak	17-Jul-06	P	11:00	17-Jul-06	13:00	13	13	2
7	Panel off	25-Sep-07	P	20:00	25-Sep-07	20:30	4	20.5	0.5
7	Panel off	4-Nov-07	P	22:00	4-Nov-07	23:00	2	23	1
8	Inverter rusak	15-Jul-07	P	15:45	17-Jul-07	16:00	8.25	16	48.25
8	Start tidak jalan	31-Oct-07	P	2:30	31-Oct-07	21:00	21.5	21	18.5
8	Panel off	4-Nov-07	P	22:00	4-Nov-07	23:00	2	23	1
9	Konsleting	28-Jan-07	P	11:30	28-Jan-07	13:30	12.5	13.5	2
9	Panel off	30-May-07	P	20:00	31-May-07	13:00	4	13	17
9	Panel off	4-Nov-07	P	22:00	4-Nov-07	23:00	2	23	1
9	Start cylinder mati terus	5-Mar-08	P	0:00	5-Mar-08	0:30	24	0.5	0.5
10	Inverter rusak	27-Jan-06	P	8:00	27-Jan-06	9:30	16	9.5	1.5
10	Lampu sinyal rusak	21-Dec-06	P	13:45	21-Dec-06	15:00	10.25	15	1.25
10	Kabel ke blower konslet	31-Jul-07	P	3:30	31-Jul-07	7:45	20.5	7.75	4.25
10	Panel off	4-Nov-07	P	22:00	4-Nov-07	23:00	2	23	1
10	Panel off	4-Feb-08	P	21:15	4-Feb-08	22:00	2.75	22	0.75
10	Inverter rusak	9-Apr-08	P	16:15	10-Apr-08	16:45	7.75	16.75	24.5
11	Panel off	4-Nov-07	P	22:00	4-Nov-07	23:00	2	23	1
11	Inverter rusak	10-Jan-08	P	18:00	10-Jan-08	18:30	6	18.5	0.5
12	Panel off	4-Nov-07	P	22:00	4-Nov-07	23:00	2	23	1
12	Start tidak jalan	28-Apr-08	P	14:20	28-Apr-08	14:50	9.66667	14.83333	0.5
Mean Downtime									4.52

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
2	Sensor doffer tidak aktif	8-Dec-06	SD	6:00	8-Dec-06	7:00	18	7	1
2	Sensor doffer tidak aktif	13-Feb-07	SD	0:15	13-Feb-07	1:00	23.75	1	0.75
2	Sensor doffer tidak aktif	5-Jul-07	SD	2:00	5-Jul-07	2:45	22	2.75	0.75
2	Sensor doffer tidak aktif	20-Jul-07	SD	7:30	20-Jul-07	13:15	16.5	13.25	5.75
2	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	31-Mar-08	8:45	18	8.75	2.75
3	Sensor doffer tidak aktif	19-Jun-06	SD	2:00	19-Jun-06	2:30	22	2.5	0.5
3	Sensor doffer tidak aktif	22-Sep-06	SD	0:45	22-Sep-06	1:15	23.25	1.25	0.5
3	Sensor doffer tidak aktif	19-Jan-07	SD	3:00	19-Jan-07	3:45	21	3.75	0.75
3	Sensor doffer tidak aktif	1-Feb-07	SD	22:00	1-Feb-07	22:30	2	22.5	0.5
3	Sensor doffer tidak aktif	30-May-07	SD	3:00	30-May-07	3:30	21	3.5	0.5
3	Sensor doffer tidak aktif	14-Aug-07	SD	23:00	14-Aug-07	23:45	1	23.75	0.75
3	Sensor doffer tidak aktif	7-Dec-07	SD	18:30	7-Dec-07	19:00	5.5	19	0.5
3	Sensor doffer tidak aktif	12-Jan-08	SD	10:00	12-Jan-08	10:30	14	10.5	0.5
3	Sensor doffer tidak aktif	13-Feb-08	SD	2:45	13-Feb-08	3:20	21.25	3.333333	0.5833333
3	Sensor doffer tidak aktif	31-Mar-08	SD	4:45	31-Mar-08	8:45	19.25	8.75	4
3	Sensor doffer tidak aktif	14-May-08	SD	23:00	14-May-08	23:45	1	23.75	0.75
4	Sensor doffer tidak aktif	9-Jun-06	SD	1:00	9-Jun-06	1:30	23	1.5	0.5
4	Sensor doffer tidak aktif	18-Jun-06	SD	23:30	19-Jun-06	0:15	0.5	0.25	0.75
4	Sensor doffer tidak aktif	24-Jun-06	SD	1:00	24-Jun-06	1:30	23	1.5	0.5
4	Sensor doffer tidak aktif	23-Feb-07	SD	1:30	23-Feb-07	2:00	22.5	2	0.5
4	Sensor doffer tidak aktif	28-Feb-07	SD	1:00	28-Feb-07	1:30	23	1.5	0.5
4	Sensor doffer tidak aktif	5-Mar-07	SD	23:00	5-Mar-07	23:20	1	23.33333	0.3333333
4	Sensor doffer tidak aktif	8-Mar-07	SD	8:00	8-Mar-07	8:15	16	8.25	0.25
4	Sensor doffer tidak aktif	10-Sep-07	SD	16:15	10-Sep-07	17:00	7.75	17	0.75
5	Sensor doffer tidak aktif	12-Aug-06	SD	1:30	12-Aug-06	2:00	22.5	2	0.5
5	Sensor doffer tidak aktif	5-Jan-07	SD	2:00	5-Jan-07	2:30	22	2.5	0.5
5	Sensor doffer tidak aktif	2-Mar-07	SD	22:30	2-Mar-07	23:00	1.5	23	0.5
5	Sensor doffer tidak aktif	8-Mar-07	SD	23:30	9-Mar-07	0:00	0.5	0	0.5
5	Sensor doffer tidak aktif	28-Nov-07	SD	10:00	28-Nov-07	11:00	14	11	1
6	Sensor doffer tidak aktif	19-Jun-06	SD	2:00	19-Jun-06	2:45	22	2.75	0.75
6	Sensor doffer tidak aktif	20-Jun-06	SD	1:00	20-Jun-06	1:30	23	1.5	0.5

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
6	Sensor doffer tidak aktif	6-Jul-06	SD	22:25	6-Jul-06	23:00	1.58333	23	0.5833333
6	Sensor doffer tidak aktif	1-Mar-07	SD	0:30	1-Mar-07	1:15	23.5	1.25	0.75
6	Sensor doffer tidak aktif	24-Mar-07	SD	0:30	24-Mar-07	9:45	23.5	9.75	9.25
6	Sensor doffer tidak aktif	4-Oct-07	SD	23:00	4-Oct-07	23:30	1	23.5	0.5
6	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	31-Mar-08	8:45	18	8.75	2.75
7	Sensor doffer tidak aktif	7-May-06	SD	2:30	9-May-06	13:30	21.5	13.5	59
7	Sensor doffer tidak aktif	15-Jul-06	SD	10:00	15-Jul-06	10:30	14	10.5	0.5
7	Sensor doffer tidak aktif	2-Apr-07	SD	8:00	2-Apr-07	8:15	16	8.25	0.25
7	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	31-Mar-08	8:45	18	8.75	2.75
7	Sensor doffer tidak aktif	21-Apr-08	SD	23:30	22-Apr-08	9:30	0.5	9.5	10
8	Sensor doffer tidak aktif	25-Feb-07	SD	23:30	26-Feb-07	0:15	0.5	0.25	0.75
8	Sensor doffer tidak aktif	2-Apr-07	SD	8:00	2-Apr-07	8:30	16	8.5	0.5
8	Sensor doffer tidak aktif	12-Jan-08	SD	10:00	12-Jan-08	10:30	14	10.5	0.5
8	Kabel sensor doffer putus	23-Jan-08	SD	19:00	23-Jan-08	19:45	5	19.75	0.75
9	Sensor doffer tidak aktif	2-Apr-07	SD	8:00	2-Apr-07	8:45	16	8.75	0.75
10	Sensor doffer tidak aktif	15-Jan-08	SD	2:00	15-Jan-08	2:45	22	2.75	0.75
11	Sensor doffer tidak aktif	19-Jun-06	SD	2:00	19-Jun-06	3:00	22	3	1
11	Sensor doffer tidak aktif	16-Jun-07	SD	10:00	16-Jun-07	10:30	14	10.5	0.5
12	Sensor doffer tidak aktif	3-Mar-08	SD	8:00	3-Mar-08	8:30	16	8.5	0.5
12	Sensor doffer tidak aktif	5-Mar-08	SD	13:15	6-Mar-08	9:45	10.75	9.75	20.5
12	Sensor doffer tidak aktif	7-Mar-08	SD	22:15	7-Mar-08	23:00	1.75	23	0.75
12	Sensor doffer tidak aktif	31-Mar-08	SD	6:00	31-Mar-08	8:45	18	8.75	2.75
Mean Downtime									2.745283
1	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	10-Dec-06	SF	17:00	10-Dec-06	17:20	7	17.33333	0.3333333
2	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	1-Apr-08	SF	22:45	1-Apr-08	22:55	1.25	22.91667	0.1666667
3	Sensor feedroller tidak berfungsi (sinyal hijau menyala terus)	4-Jun-06	SF	15:45	4-Jun-06	16:00	8.25	16	0.25
5	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	5-Nov-07	SF	16:15	5-Nov-07	16:30	7.75	16.5	0.25
5	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	27-Nov-07	SF	11:00	27-Nov-07	11:10	13	11.16667	0.1666667
6	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	1-Apr-08	SF	19:00	1-Apr-08	19:15	5	19.25	0.25

Mesin Carding	Keterangan	Tanggal	Komp.	Waktu Kejadian	Tanggal	Waktu Selesai Diperbaiki	Ke jam 12 PM	Dari jam 12 AM	DOWNTIME
6	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	15-May-08	SF	21:45	15-May-08	22:10	2.25	22.16667	0.4166667
7	Switch sensor feedroller tidak aktif	1-May-08	SF	12:45	1-May-08	13:00	11.25	13	0.25
7	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	2-May-08	SF	7:30	2-May-08	8:00	16.5	8	0.5
8	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	29-Jun-07	SF	16:30	29-Jun-07	16:45	7.5	16.75	0.25
11	Sensor feedroller tidak aktif (Lampu hijau menyala terus)	16-Sep-07	SF	10:00	16-Sep-07	10:30	14	10.5	0.5
Mean Downtime									0.3030303
1	Combtoplet tidak jalan (Combbox pulley toplet tidak jalan)	28-Apr-06	T	1:30	28-Apr-06	9:30	22.5	9.5	8
1	Combtoplet tidak jalan (Combbox pulley toplet tidak jalan)	22-Aug-07	T	18:15	22-Aug-07	20:00	5.75	20	1.75
2	Bartoplet rusak	19-Apr-07	T	8:00	21-Apr-07	9:00	16	9	49
3	Bartoplet rusak	11-Apr-07	T	8:00	12-Apr-07	12:00	16	12	28
3	Van belt toplet rusak	9-Oct-07	T	9:00	9-Oct-07	11:00	15	11	2
5	Cincin toplet bergeser	7-Aug-07	T	11:00	7-Aug-07	12:00	13	12	1
5	Pulley toplet macet	1-Nov-07	T	19:45	1-Nov-07	21:00	4.25	21	1.25
6	Belt pulley toplet putus	21-Sep-06	T	21:30	22-Sep-06	8:00	2.5	8	10.5
7	Combtoplet tidak jalan	2-Apr-07	T	3:00	2-Apr-07	7:30	21	7.5	4.5
7	As combtoplet patah	3-Apr-07	T	0:30	3-Apr-07	8:00	23.5	8	7.5
7	Toplet rusak	13-Apr-07	T	2:00	15-Apr-07	8:00	22	8	54
7	Combtoplet handle penggerak patah	2-Apr-08	T	22:15	3-Apr-08	8:30	1.75	8.5	10.25
8	Pulley toplet "goplak"	30-Aug-07	T	3:45	30-Aug-07	7:00	20.25	7	3.25
9	Toplet kotor	28-Sep-07	T	7:00	28-Sep-07	11:00	17	11	4
9	Rantai toplet kendor	4-Oct-07	T	1:30	4-Oct-07	6:30	22.5	6.5	5
10	Bant combtoplet lepas	12-Jul-07	T	20:15	12-Jul-07	22:00	3.75	22	1.75
11	Toplet kotor	14-Jun-06	T	7:00	15-Jun-06	15:00	17	15	32
11	Penggerak combtoplet tidak jalan	23-Mar-07	T	4:30	23-Mar-07	6:30	19.5	6.5	2
12	Toplet kotor	17-Jun-06	T	10:30	18-Jun-06	17:00	13.5	17	30.5
12	Pulley toplet macet	5-Feb-08	T	2:15	5-Feb-08	4:15	21.75	4.25	2
Mean Downtime									12.9125

Keterangan :

B : *Blower*

Co : *Coiler*

Cy : *Cylinder*

MC : Motor *Cylinder*

D : *Doffer*

L : *Licker – in*

P : Panel

SD : Sensor *Doffer*

SF : Sensor *Feedroller*

T : Toplet

LAMPIRAN 7

Tabel *Rating Severity*, *Occurrence* dan *Detection*

- **Tabel Rating Severity, Occurrence dan Detection**

Severity			Occurrence				Detection		
Effect	Criteria Severity	Rank	Probability of failure	Criteria Occurrence	Rank	Alternate criteria for occurrence	Detection	Criteia for Detection	Rank
Hazardous without warning	Very high severity : Affects operator, plant or maintenance personnel, safety and or effects non compliance with government regulations without warning	10	Failure occurs every hour	R(t) < 1 or some MTBF	10	1 in 1	Very low	Present design controls cannot detect potential cause or, no design control available	10
Hazardous with warning	High severity : Affects operator, plant or maintenance personnel, safety and or effects non compliance with government regulations with warning	9	Failure occurs every shift	R(t) = 5 %	9	1 in 8		Team's discretion depending on machine and situation	9
Very high	Downtime of 8+ hours or, the production of defective parts for over 2 hours	8	Failure occurs every day	R(t) = 20 %	8	1 in 24		Team's discretion depending on machine and situation	8
High	Downtime of 2-4 hours or, the production of defective parts for up to 2 hours	7	Failure occurs every week	R(t) = 37 %	7	1 in 80	Low	Machinery control will isolate the cause and failure mode after the failure has occurred, but will not prevent the failure from occurring	7
Moderate	Downtime of 60 - 120 min or, the production of defective parts for up to 60 min	6	Failure occurs every month	R(t) = 60 %	6	1 in 350		Team's discretion depending on machine and situation	6

Severity			Occurrance				Detection		
Effect	Criteria Severity	Rank	Probability of failure	Criteria Occurrence	Rank	Alternate criteria for occurrence	Detection	Criteia for Detection	Rank
Low	Downtime of 30 - 60 min or, the production of defective parts for up to 30 min	5	Failure occurs every 3 months	R(t) = 78 %	5	1 in 1000	Medium	Machinery controls will provide an indicator of imminent failure	5
Very low	Downtime of 15 - 30 min with no production of defect parts	4	Failure occurs every 6 months	R(t) = 85 %	4	1 in 2500		Team's discretion depending on machine and situation	4
Minor	Downtime up to 15 min with no production of defect parts	3	Failure occurs every year	R(t) = 90 %	3	1 in 5000	High	Machinery controls will prevent an imminent failure and isolate the cause	3
Very minor	Process parameter variability not within specification limits. Adjustments may be done during production. No downtime and no defect	2	Failure occurs every 2 years	R(t) = 95 %	2	1 in 10000		Team's discretion depending on machine and situation	2
None	Process parameter variability within specification limits. Adjustments may be performed during normal production.	1	Failure occurs every 5 years	R(t) = 98 %	1	1 in 25000	Very high	Machinery controls not required. Design controls almost every time will detect a potential cause and subsequent failure	1

Sumber : *Failure Mode and Effect Analysis : FMEA from Theory to Execution*, 2003.

KOMENTAR DOSEN PENGUJI

Nama Mahasiswa : Siska Herawati

NRP : 0423093

Judul Tugas Akhir : Analisis Pencegahan dan Penanggulangan Kegagalan Yang Vital Pada Stasiun Kerja Carding Dengan Menggunakan Konsep Reliability Centered Maintenance (RCM) (Studi Kasus Pada PT. Sandang Jaya Makmur, Sumedang)

Komentar-Komentar Dosen Penguji:

1. Sebaiknya penilaian yang dilakukan secara kualitatif didiskusikan dengan ahlinya.
2. Sebaiknya dilakukan perbandingan tindak pemeliharaan usulan dengan tindak pemeliharaan yang diusulkan dengan lebih mendetail.

DATA PENULIS

Nama	: Siska Herawati
Alamat di Bandung	: Jl. Kembar Timur VII No. 26, Bandung 40255
Alamat Asal	: Jl. Raya Rengasdengklok No. 39 Rengasdengklok – Karawang 41352
No Telp Bandung	: 022 5229078
No Telp Asal	: 0267 482180
No Handphone	: 08562104987
Alamat e-mail	: siska_herawati_87@yahoo.com
Pendidikan	: SMUK 3 BPK Penabur Bandung Jurusan Teknik Industri Universitas Kristen Maranatha
Nilai Tugas Akhir	: A
Tanggal USTA	: 22 Agustus 2008