

LAMPIRAN

Lampiran 1 Perhitungan Kebutuhan Jumlah Mesin

1. Perhitungan Kapasitas dan Jumlah Mesin Sepatu Velcro

a) Tongue (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-5	154	0%	154	10	90%	8	0.06
O-6	154	0%	154	25	90%	8	0.15
O-7	154	0%	154	45	90%	8	0.27
O-8	154	0%	154	70	90%	8	0.42

b) Heel Collar (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-10	156	0%	156	20	90%	8	0.12
O-11	156	0%	156	40	90%	8	0.24
O-12	156	0%	156	65	90%	8	0.39
O-13	154	1%	156	70	90%	8	0.42

c) Heel Counter (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-14	156	0%	156	20	90%	8	0.12
O-15	156	0%	156	30	90%	8	0.18
O-16	156	0%	156	45	90%	8	0.27
O-17	154	1%	156	50	90%	8	0.30

d) Eyestay (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-21	158	0%	158	20	90%	8	0.12
O-22	158	0%	158	30	90%	8	0.18
O-23	158	0%	158	50	90%	8	0.30
O-24	156	1%	158	60	90%	8	0.36
O-25	154	1%	156	88	90%	8	0.52
O-26	154	0%	154	60	90%	8	0.36

e) Velcro (4)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-27	311	0%	311	20	90%	8	0.24
O-28	311	0%	311	40	90%	8	0.48
O-29	311	0%	311	60	90%	8	0.72
O-30	308	1%	311	60	90%	8	0.72
O-31	308	0%	308	70	90%	8	0.83

f) Toe-Cap (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-34	154	0%	154	10	90%	8	0.06
O-35	154	0%	154	25	90%	8	0.15
O-36	154	0%	154	30	90%	8	0.18

g) Outsole (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-38	154	0%	154	8	90%	8	0.05
O-39	154	0%	154	50	90%	8	0.30
O-40	154	0%	154	30	90%	8	0.18

h) Insole (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-42	156	0%	156	10	90%	8	0.06
O-43	156	0%	156	30	90%	8	0.18
O-44	156	0%	156	50	90%	8	0.30
O-45	154	1%	156	55	90%	8	0.33

2. Perhitungan Kapasitas dan Jumlah Mesin Sepatu Tali

a) Tongue (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-5	154	0%	154	10	90%	8	0.06
O-6	154	0%	154	25	90%	8	0.15
O-7	154	0%	154	45	90%	8	0.27

O-8	154	0%	154	70	90%	8	0.42
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b) Heel Collar (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-10	156	0%	156	20	90%	8	0.12
O-11	156	0%	156	40	90%	8	0.24
O-12	156	0%	156	65	90%	8	0.39
O-13	154	1%	156	70	90%	8	0.42

c) Heel Counter (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-14	156	0%	156	20	90%	8	0.12
O-15	156	0%	156	30	90%	8	0.18
O-16	156	0%	156	45	90%	8	0.27
O-17	154	1%	156	50	90%	8	0.30

d) Eyestay (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-21	158	0%	158	20	90%	8	0.12
O-22	158	0%	158	30	90%	8	0.18
O-23	158	0%	158	50	90%	8	0.30
O-24	156	1%	158	60	90%	8	0.36
O-25	154	1%	156	80	90%	8	0.48

e) Toe-Cap (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-34	154	0%	154	10	90%	8	0.06
O-35	154	0%	154	25	90%	8	0.15
O-36	154	0%	154	30	90%	8	0.18

f) Outsole (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-38	154	0%	154	8	90%	8	0.05

O-39	154	0%	154	50	90%	8	0.30
O-40	154	0%	154	30	90%	8	0.18

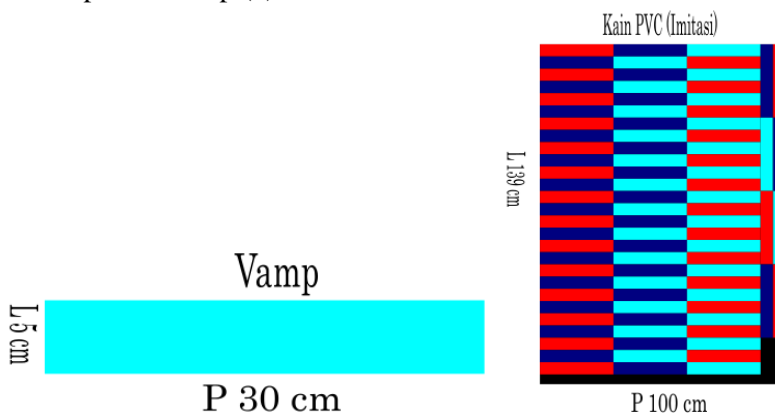
g) Insole (2)

Operasi	Pg (Unit)	p (Unit)	P (Unit)	T (Detik)	E	D (Jam)	N (Unit)
O-42	156	0%	156	10	90%	8	0.06
O-43	156	0%	156	30	90%	8	0.18
O-44	156	0%	156	50	90%	8	0.30
O-45	154	1%	156	55	90%	8	0.33

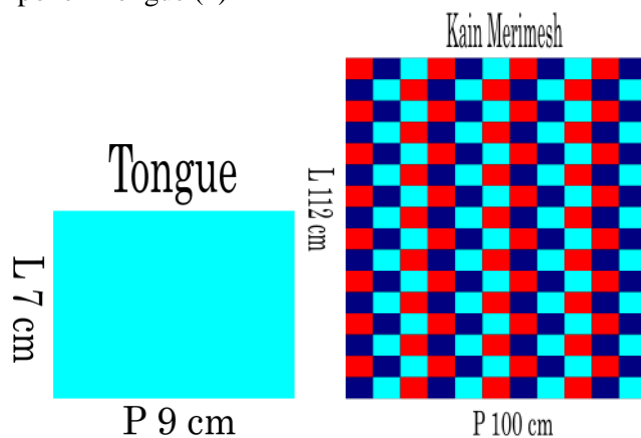
Lampiran 2 Simulasi Kebutuhan Bahan Baku

1. Simulasi Bahan Baku Sepatu Velcro dan Sepatu Tali Uk. 34

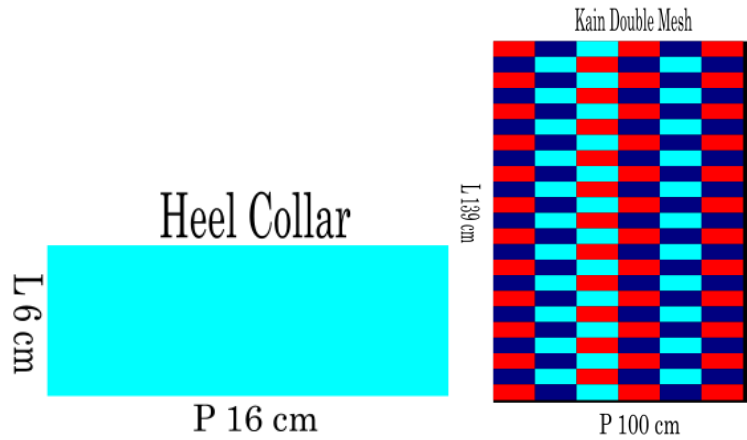
a) Komponen Vamp (2)



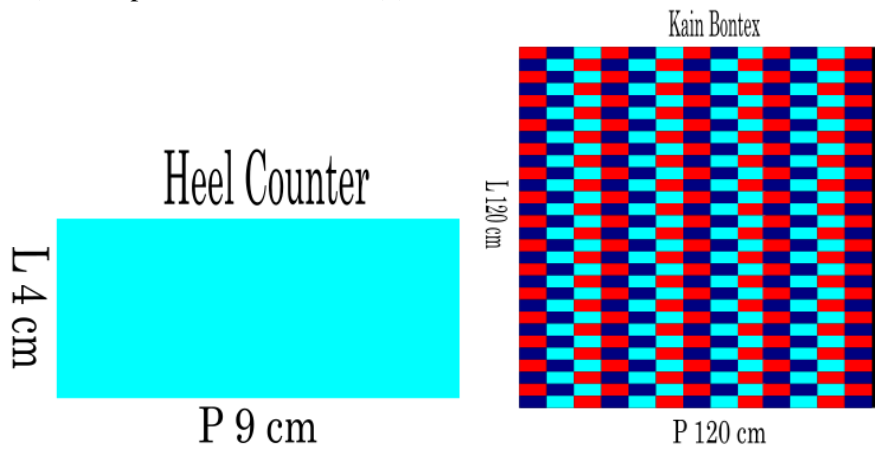
b) Komponen Tongue (2)



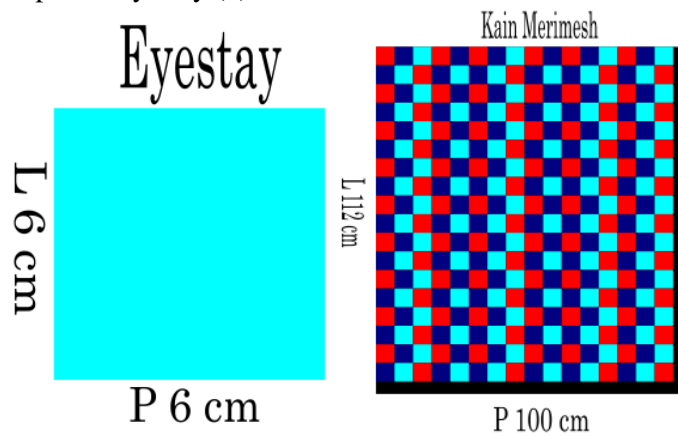
c) Komponen Heel Collar (2)



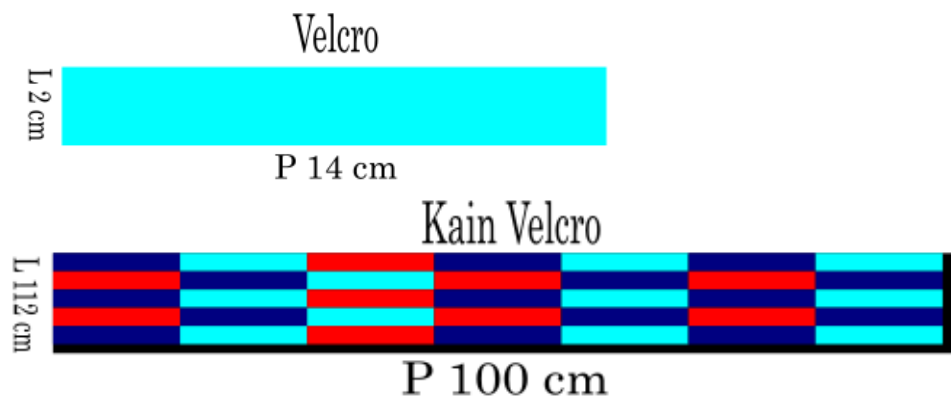
d) Komponen Heel Counter (2)



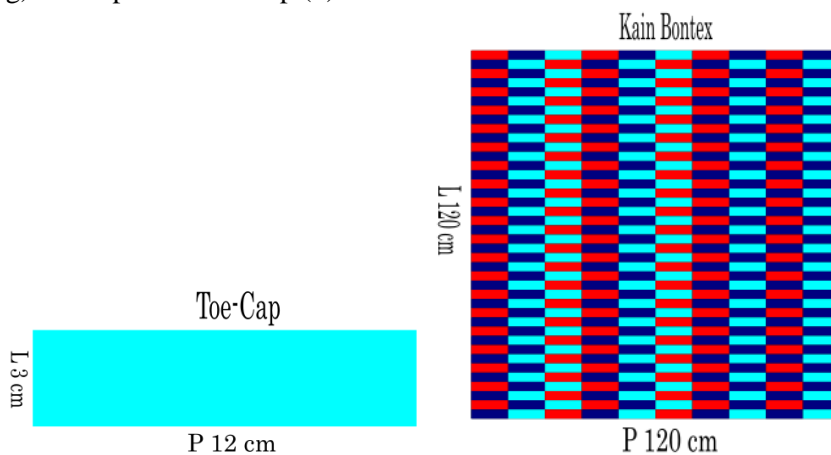
e) Komponen Eyestay (2)



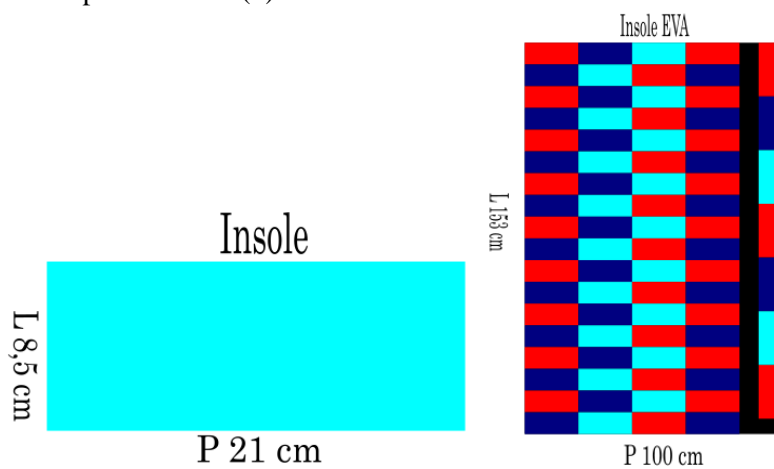
f) Komponen Velcro (4)



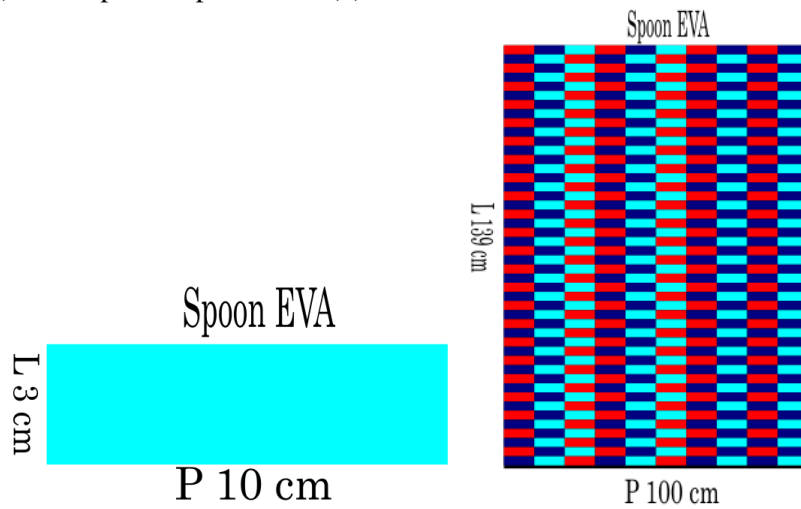
g) Komponen Toe-Cap (2)



h) Komponen Insole (2)

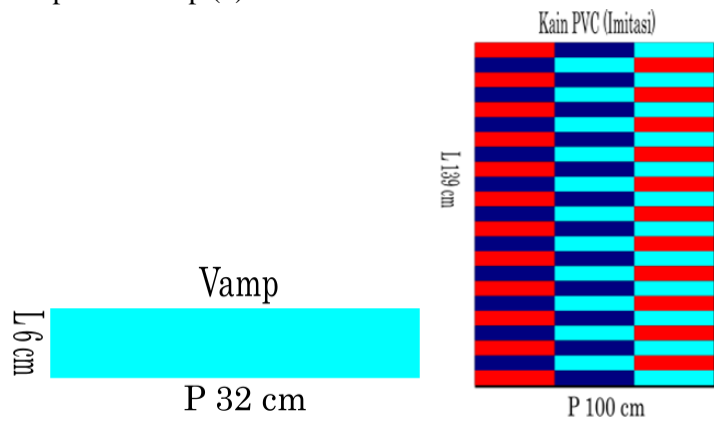


i) Komponen Spoon EVA (2)

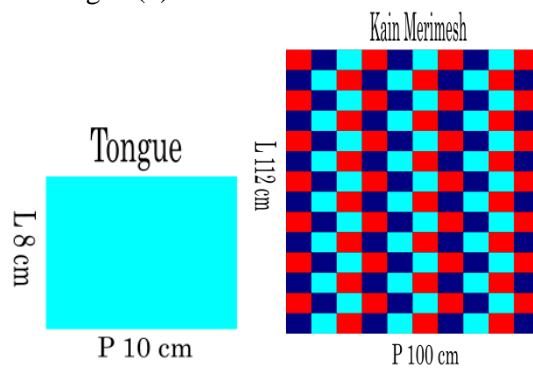


2. Simulasi Bahan Baku Sepatu Velcro dan Sepatu Tali Uk. 35

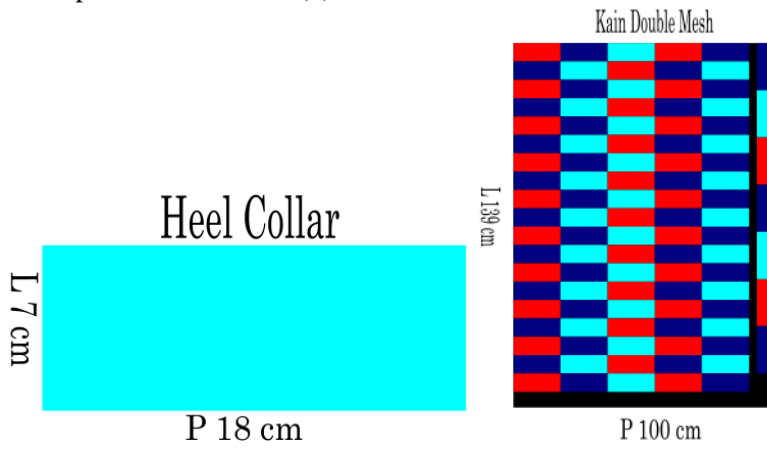
a) Komponen Vamp (2)



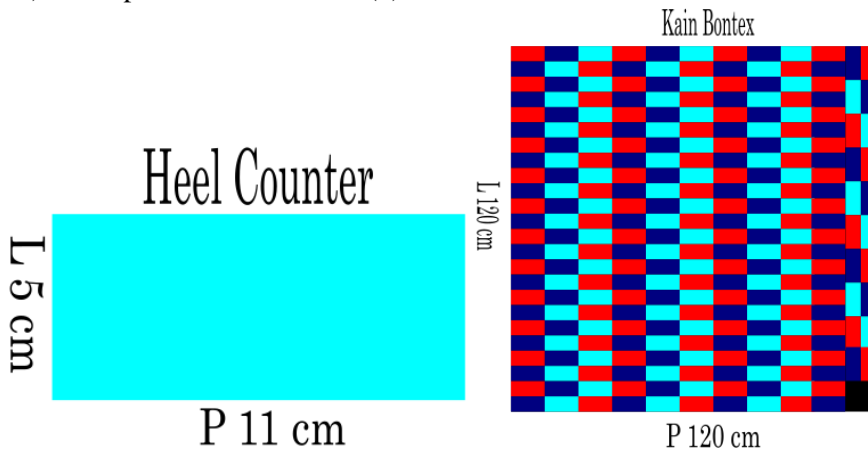
b) Komponen Tongue (2)



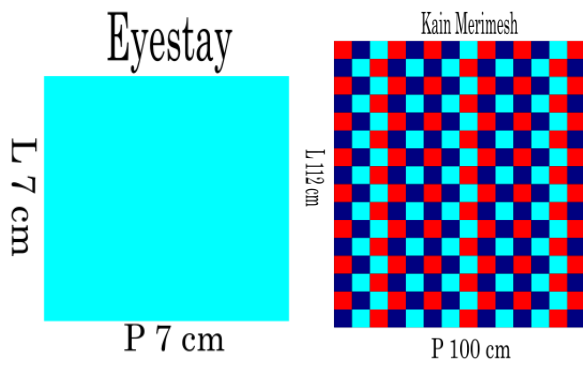
c) Komponen Heel Collar (2)



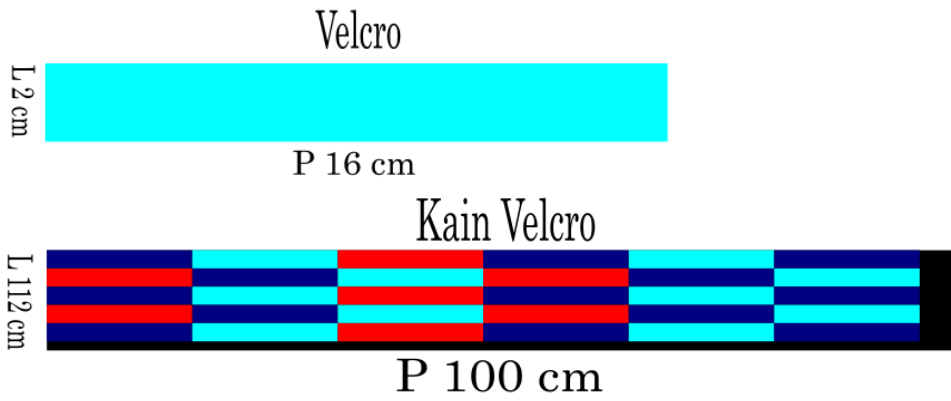
d) Komponen Heel Counter (2)



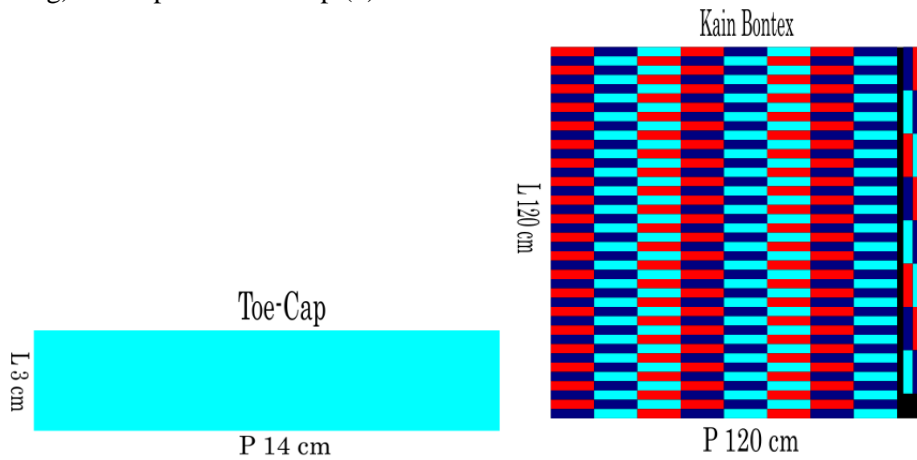
e) Komponen Eyestay (2)



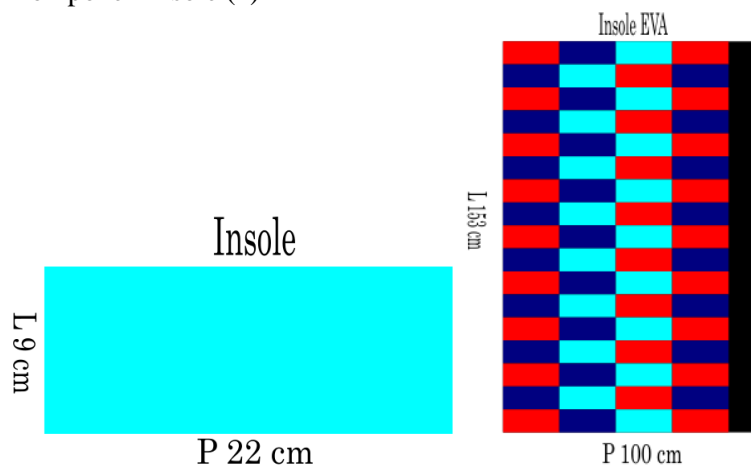
f) Komponen Velcro (4)



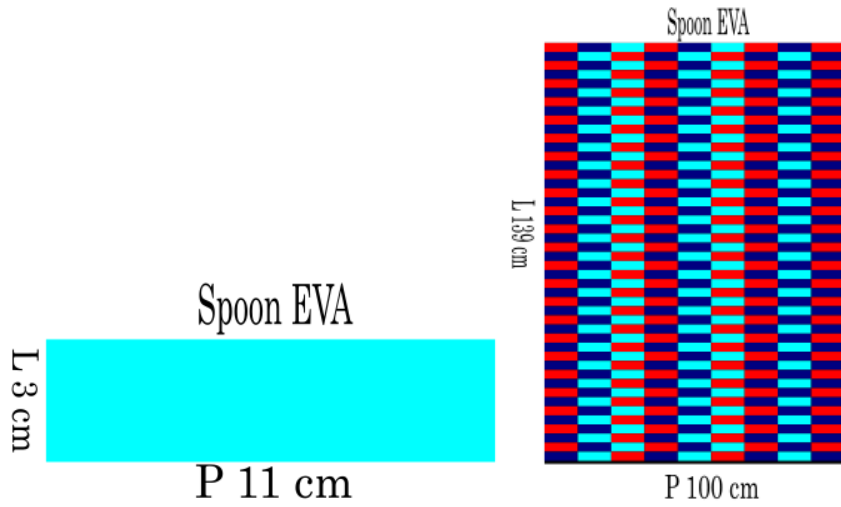
g) Komponen Toe-Cap (2)



h) Komponen Insole (2)

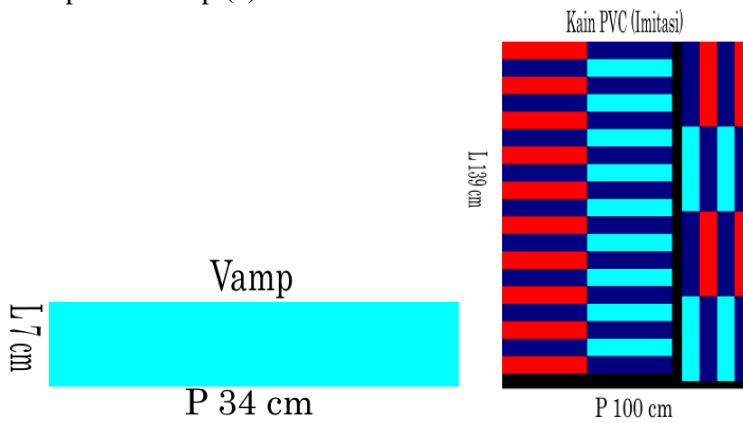


i) Komponen Spoon EVA (2)

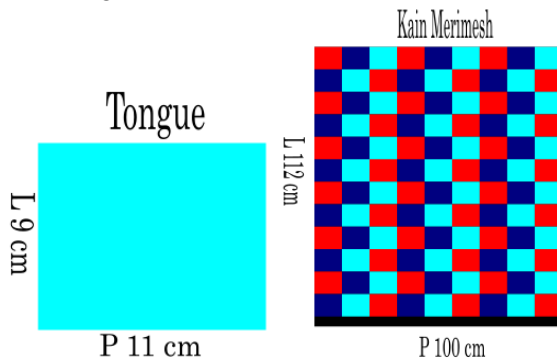


3. Simulasi Bahan Baku Sepatu Velcro dan Sepatu Tali Uk. 36

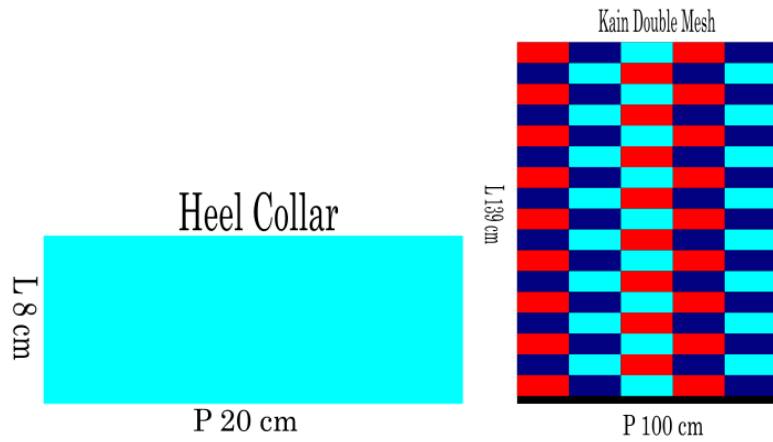
a) Komponen Vamp (2)



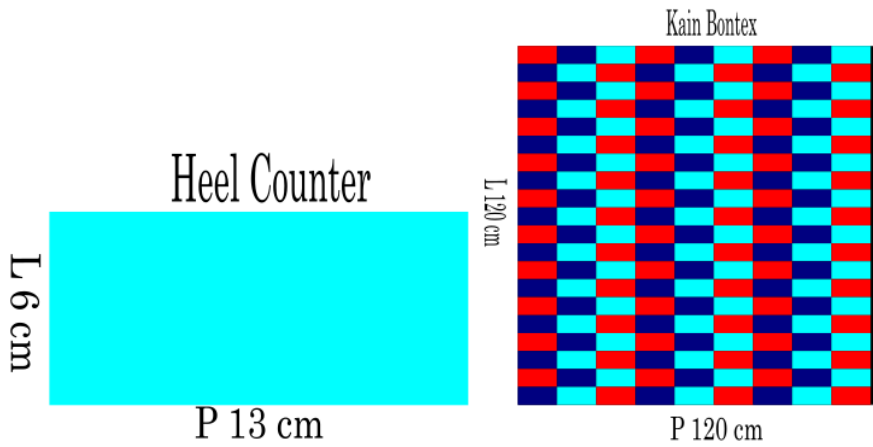
b) Komponen Tongue (2)



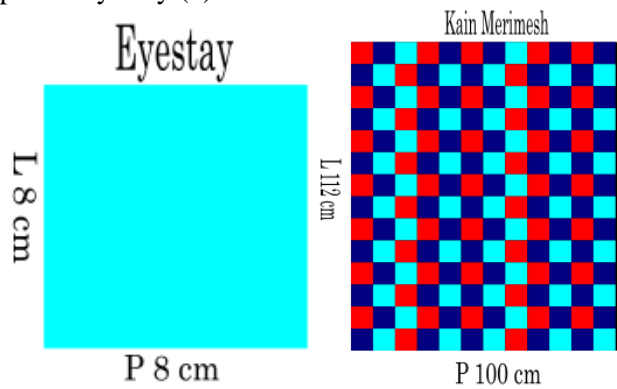
c) Komponen Heel Collar (2)



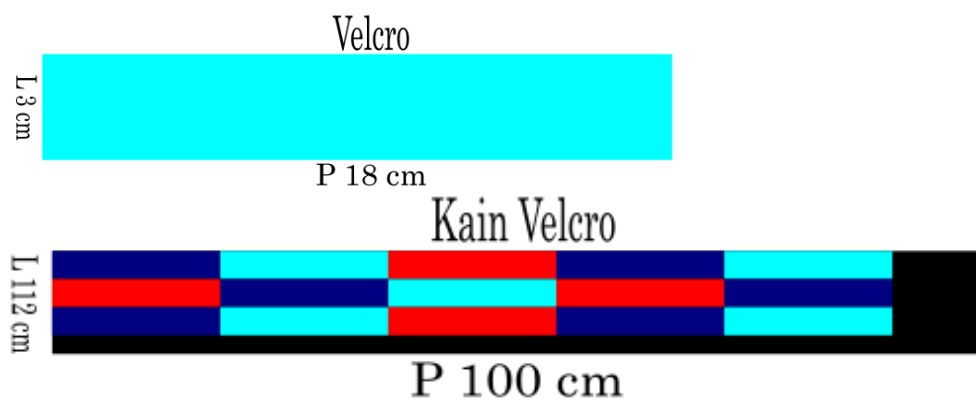
d) Komponen Heel Counter (2)



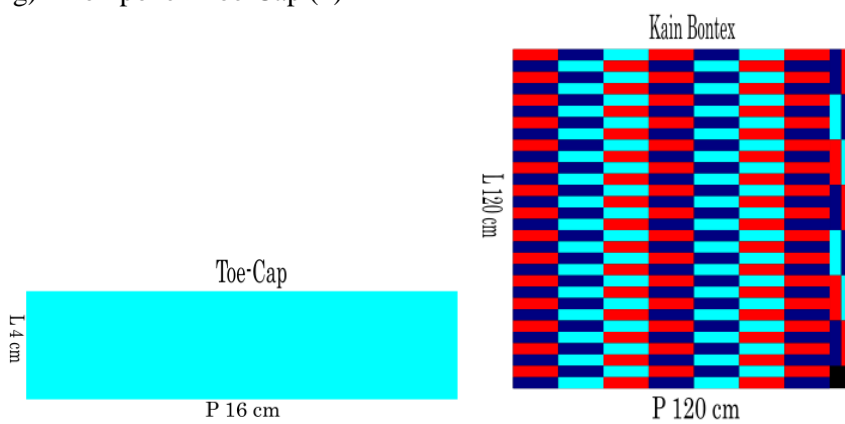
e) Komponen Eyestay (2)



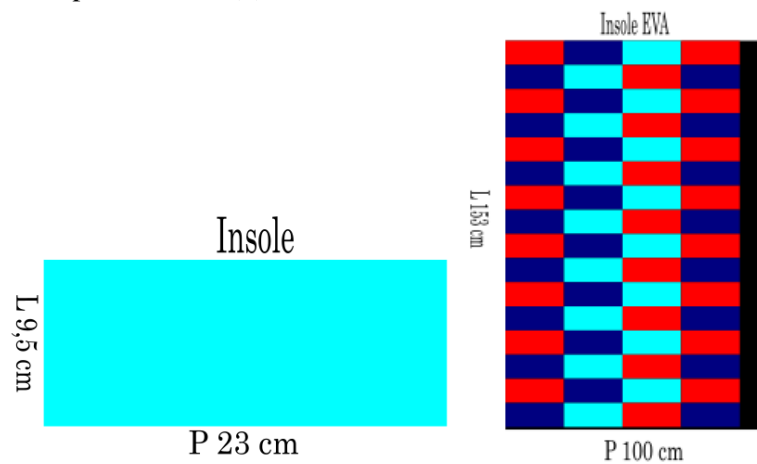
f) Komponen Velcro (4)



g) Komponen Toe-Cap (2)



h) Komponen Insole (2)



i) **Komponen Spoon EVA (2)**