

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan

Supplier	Jenis	Kode	Keadaan			
			Baik	Sobek	Kotor	Sobek dan Kotor
SMB	M125/100	1002/3/4			√	
SMB	M125/120	1003/3/4		√		
SMB	M125/155	1004/3/4	√			
SMB	M125/115	1005/3/4		√		
SMB	M125/130	1006/3/4		√		
SMB	M125/135	1007/3/4	√			
SMB	M125/170	1008/3/4		√		
SMB	M125/170	1009/3/4		√		
Jaker	M125/140	1010/3/4				√
Jaker	M125/140	1011/3/4		√		
Jaker	M125/140	1012/3/4		√		
Jaker	M125/140	1013/3/4	√			
Jaker	M125/155	1014/3/4	√			
SMB	M125/155	1015/3/4	√			
SMB	M125/155	1016/3/4	√			
SMB	M125/155	1017/3/4				√
SMB	M125/155	1018/3/4	√			
SMB	M125/160	1019/3/4		√		
SMB	M125/160	1020/3/4		√		
SMB	M125/160	1021/3/4	√			
SMB	M125/160	1022/3/4				√
SMB	M125/160	1023/3/4		√		
SMB	M125/160	1024/3/4		√		
SMB	M125/160	1025/3/4		√		
SMB	M125/160	1026/3/4			√	
SMB	M125/160	1027/3/4		√		
SMB	M125/160	1028/3/4	√			
SMB	M125/160	1029/3/4	√			
SMB	M125/160	1030/3/4				√
Jaker	M125/225	1031/3/4	√			
Jaker	M125/190	1032/3/4	√			
Jaker	M125/190	1033/3/4	√			
Jaker	M125/205	1033/3/4		√		
Jaker	M125/220	1034/3/4	√			
Jaker	M125/230	1035/3/4				√
Jaker	M125/225	1036/3/4			√	

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

Jaker	M125/225	1037/3/4	√			
Jaker	M125/225	1038/3/4	√			
SMB	M125/145	1062/3/4			√	
SMB	M125/145	1063/3/4	√			
SMB	M125/145	1064/3/4		√		
SMB	M125/145	1065/3/4		√		
SMB	M125/145	1066/3/4	√			
SMB	M125/145	1067/3/4				√
SMB	M125/145	1068/3/4		√		
SMB	M125/145	1069/3/4				√
SMB	M125/145	1070/3/4			√	
SMB	M125/145	1071/3/4		√		
SMB	M125/145	1072/3/4		√		
SMB	M125/145	1073/3/4	√			
SMB	M125/145	1074/3/4		√		
SMB	M125/145	1075/3/4	√			
SMB	M125/145	1076/3/4		√		
SMB	M125/120	1077/3/4	√			
SMB	M125/140	1078/3/4		√		
SMB	M125/140	1079/3/4		√		
SMB	M125/145	1080/3/4		√		
SMB	M125/145	1081/3/4	√			
SMB	M125/145	1082/3/4				√
SMB	M125/145	1083/3/4				√
SMB	M125/160	1084/3/4	√			
SMB	M125/120	1085/3/4	√			
SMB	M125/120	1086/3/4	√			
SMB	M125/120	1087/3/4		√		
SMB	M125/120	1088/3/4		√		
SMB	M125/150	1089/3/4	√			
SMB	M125/150	1090/3/4	√			
SMB	M125/150	1091/3/4	√			
SMB	M125/150	1092/3/4			√	
SMB	M125/130	1093/3/4		√		
SMB	M125/130	1094/3/4		√		
SMB	M125/130	1095/3/4		√		
SMB	M125/130	1096/3/4		√		
SMB	M125/130	1097/3/4				√

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

SMB	M125/130	1098/3/4				√
SMB	M125/140	1099/3/4		√		
SMB	M125/145	1100/3/4	√			
SMB	M150/120	128/4/4	√			
SMB	M150/120	129/4/4		√		
SMB	M150/120	130/4/4	√			
SMB	M150/120	131/4/4	√			
SMB	M150/150	132/4/4	√			
SMB	M150/150	133/4/4	√			
SMB	M150/150	134/4/4	√			
SMB	M150/150	135/4/4		√		
SMB	M125/160	136/4/4		√		
SMB	M125/160	137/4/4	√			
SMB	M125/160	138/4/4	√			
SMB	M125/160	139/4/4		√		
SMB	M125/160	140/4/4				√
SMB	M125/160	141/4/4			√	
SMB	M125/160	142/4/4	√			
SMB	M125/160	143/4/4	√			
SMB	M125/120	144/4/4	√			
SMB	M125/120	145/4/4	√			
SMB	M125/120	146/4/4		√		
SMB	M125/120	147/4/4	√			
SMB	M125/120	148/4/4	√			
SMB	M125/120	149/4/4	√			
SMB	M125/120	150/4/4			√	
SMB	M125/120	151/4/4	√			
SMB	M125/120	152/4/4				√
SMB	M125/95	153/4/4	√			
SMB	M125/95	154/4/4	√			
SMB	M125/95	155/4/4	√			
SMB	M125/95	156/4/4		√		
SMB	M150/120	157/4/4	√			
SMB	M150/120	158/4/4	√			
SMB	M150/120	159/4/4		√		
SMB	M150/120	160/4/4		√		
SMB	M150/120	161/4/4		√		
SMB	M150/120	162/4/4		√		
SMB	M150/125	163/4/4		√		

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

SMB	M125/150	164/4/4	√			
SMB	M125/150	165/4/4	√			
SMB	M125/150	166/4/4		√		
SMB	M125/150	167/4/4		√		
SMB	M125/150	168/4/4	√			
SMB	M125/95	169/4/4	√			
SMB	M125/95	170/4/4	√			
SMB	M125/95	171/4/4	√			
SMB	M125/110	172/4/4		√		
SMB	M125/110	173/4/4	√			
SMB	M125/110	174/4/4		√		
SMB	M125/110	175/4/4		√		
SMB	M125/110	176/4/4	√			
SMB	M125/115	177/4/4	√			
SMB	M125/115	178/4/4	√			
SMB	M125/160	179/4/4		√		
SMB	M125/160	180/4/4	√			
SMB	M150/125	181/4/4	√			
SMB	M125/120	182/4/4	√			
SMB	M150/125	183/4/4	√			
SMB	M150/125	184/4/4	√			
SMB	M125/120	185/4/4	√			
SMB	M125/120	186/4/4		√		
SMB	M125/120	187/4/4	√			
SMB	M150/125	188/4/4	√			
SMB	M125/155	189/4/4			√	
SMB	M125/170	190/4/4	√			
SMB	M125/170	191/4/4	√			
SMB	M125/170	192/4/4		√		
SMB	M125/170	193/4/4		√		
SMB	M125/170	194/4/4	√			
SMB	M125/170	195/4/4	√			
SMB	M125/135	196/4/4		√		
SMB	M125/135	197/4/4				√
SMB	M125/135	198/4/4		√		
SMB	M125/150	199/4/4	√			
SMB	M125/150	200/4/4		√		
SMB	M125/150	201/4/4		√		
SMB	M125/160	202/4/4		√		

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

SMB	M125/160	203/4/4	√			
SMB	M125/125	204/4/4		√		
SMB	M125/125	205/4/4		√		
SMB	M125/125	206/4/4	√			
SMB	M125/125	207/4/4		√		
SMB	M125/125	208/4/4		√		
SMB	M125/125	209/4/4		√		
SMB	M125/125	210/4/4		√		
SMB	M125/125	211/4/4	√			
SMB	M125/100	212/4/4		√		
SMB	M125/100	213/4/4		√		
SMB	M125/100	214/4/4	√			
SMB	M125/180	215/4/4		√		
SMB	M125/180	216/4/4	√			
SMB	M125/180	217/4/4		√		
SMB	M125/180	218/4/4	√			
SMB	M125/180	219/4/4	√			
SMB	M125/180	220/4/4	√			
SMB	M125/135	221/4/4		√		
SMB	M125/135	222/4/4	√			
SMB	M125/135	223/4/4		√		
SMB	M125/135	224/4/4	√			
SMB	M125/135	225/4/4		√		
SMB	M125/135	226/4/4	√			
SMB	M125/135	227/4/4	√			
SMB	M125/160	228/4/4	√			
SMB	M150/105	229/4/4		√		
SMB	M150/105	230/4/4		√		
SMB	M150/105	231/4/4	√			
SMB	M150/105	232/4/4	√			
SMB	M150/105	233/4/4	√			
SMB	M150/105	234/4/4		√		
SMB	M150/105	235/4/4	√			
SMB	M150/105	236/4/4	√			
SMB	M150/105	237/4/4	√			
SMB	M150/105	238/4/4	√			
SMB	M150/105	239/4/4		√		
SMB	M150/105	240/4/4	√			
SMB	M150/105	241/4/4		√		

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

SMB	M150/105	242/4/4	√			
SMB	M150/105	243/4/4	√			
SMB	M150/105	244/4/4	√			
SMB	M125/125	249/4/4	√			
SMB	M125/125	250/4/4		√		
SMB	M125/125	251/4/4	√			
SMB	M125/130	252/4/4		√		
SMB	M125/130	253/4/4		√		
SMB	M125/125	254/4/4		√		
SMB	M125/115	255/4/4		√		
SMB	M125/115	256/4/4	√			
SMB	M125/115	257/4/4		√		
SMB	M125/115	258/4/4		√		
SMB	M125/115	259/4/4	√			
SMB	M125/115	260/4/4		√		
SMB	M125/105	261/4/4	√			
SMB	M125/105	262/4/4	√			
SMB	M125/105	263/4/4		√		
SMB	M125/100	264/4/4	√			
SMB	M125/100	265/4/4	√			
SMB	M125/100	266/4/4				√
SMB	M125/100	267/4/4	√			
SMB	M125/120	268/4/4	√			
SMB	M125/120	269/4/4	√			
SMB	M125/120	270/4/4	√			
SMB	M125/120	271/4/4		√		
SMB	M125/120	272/4/4	√			
SMB	M125/120	273/4/4		√		
SMB	M125/160	274/4/4	√			
SMB	M125/160	275/4/4			√	
SMB	M125/180	276/4/4			√	
SMB	M125/100	277/4/4		√		
SMB	M125/100	278/4/4		√		
SMB	M125/100	279/4/4		√		
SMB	M125/100	280/4/4	√			
SMB	M125/100	281/4/4	√			
SMB	M125/155	283/4/4	√			
SMB	M125/140	284/4/4		√		
SMB	M125/140	285/4/4	√			

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

SMB	M125/100	287/4/4	√			
SMB	M125/100	288/4/4	√			
SMB	M125/100	289/4/4	√			
SMB	M125/100	290/4/4				√
SMB	M125/100	292/4/4	√			
SMB	M125/100	293/4/4	√			
SMB	M125/100	294/4/4	√			
SMB	M125/120	295/4/4	√			
SMB	M125/120	296/4/4	√			
SMB	M125/105	297/4/4		√		
SMB	M125/105	298/4/4	√			
SMB	M125/135	299/4/4	√			
SMB	M125/135	300/4/4	√			
SMB	M125/160	301/4/4	√			
SMB	M125/160	302/4/4	√			
SMB	M125/160	303/4/4		√		
SMB	BK200/130	016/4/4		√		
SMB	BK200/135	017/4/4	√			
SMB	BK125/135	018/4/4		√		
SMB	BK125/95	019/4/4		√		
SMB	BK125/145	020/4/4		√		
SMB	BK150/95	021/4/4		√		
SMB	BK150/110	022/4/4		√		
SMB	BK150/140	023/4/4		√		
SMB	BK150/155	024/4/4		√		
SMB	BK150/155	025/4/4		√		
SMB	BK150/110	026/4/4		√		
SMB	BK150/110	027/4/4				√
SMB	BK150/140	028/4/4				√
SMB	BK150/150	029/4/4		√		
SMB	BK200/85	030/4/4		√		
SMB	BK200/110	031/4/4		√		
SMB	BK200/110	032/4/4		√		
SMB	BK200/115	033/4/4		√		
SMB	BK200/110	034/4/4	√			
SMB	BK200/125	035/4/4		√		
SMB	BK200/150	036/4/4		√		
SMB	BK200/115	037/4/4	√			
SMB	BK200/105	043/4/4		√		

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

SMB	BK200/90	044/4/4	√			
SMB	BK200/105	045/4/4	√			
SMB	BK200/105	046/4/4		√		
SMB	BK200/105	047/4/4	√			
SMB	BK200/105	048/4/4		√		
SMB	BK200/105	049/4/4	√			
SMB	BK200/125	050/4/4		√		
SMB	BK200/140	051/4/4		√		
SMB	BK125/95	052/4/4		√		
SMB	BK125/95	053/4/4		√		
SMB	BK125/125	054/4/4		√		
SMB	BK200/120	055/4/4		√		
SMB	BK125/145	056/4/4		√		
SMB	BK200/120	057/4/4		√		
SMB	BK200/140	058/4/4		√		
SMB	BK200/140	059/4/4		√		
SMB	BK125/95	060/4/4		√		
SMB	BK125/95	061/4/4		√		
SMB	BK125/100	062/4/4	√			
SMB	BK200/95	063/4/4	√			
SMB	BK200/140	064/4/4	√			
SMB	BK125/105	065/4/4	√			
SMB	BK125/105	066/4/4		√		
SMB	BK125/105	067/4/4		√		
SMB	BK125/105	068/4/4	√			
SMB	BK125/120	069/4/4		√		
SMB	BK150/140	070/4/4		√		
SMB	BK150/140	071/4/4	√			
SMB	BK150/140	072/4/4		√		
SMB	BK150/140	073/4/4		√		
SMB	BK200/85	074/4/4		√		
SMB	BK125/105	075/4/4		√		
SMB	BK125/145	076/4/4		√		
SMB	BK150/120	077/4/4		√		
SMB	BK150/155	078/4/4		√		
Jaker	K150/150	004/4/4	√			
Jaker	K150/150	005/4/4	√			
Jaker	K150/120	009/4/4		√		
Jaker	K150/140	010/4/4		√		

Lampiran 1: Tabel Keadaan Rol Kertas Sebelum Perbaikan (sambungan)

Total	143	136	11	18
Jumlah Rol	308			

Lampiran 2: Tabel Jenis Kecacatan Rol Sebelum Perbaikan

Jenis	Kode	Jenis Kecacatan			
		Capit Forklift	Potongan Terlalu Dalam	Pengungkit Besi	Tertabrak / Jatuh
M125/120	1003/3/4	√			
M125/115	1005/3/4	√			
M125/130	1006/3/4	√			
M125/170	1008/3/4	√			
M125/170	1009/3/4	√			
M125/140	1011/3/4	√			
M125/140	1012/3/4	√			
M125/160	1019/3/4	√			
M125/160	1020/3/4	√			
M125/160	1023/3/4	√			
M125/160	1024/3/4	√			
M125/160	1025/3/4	√			
M125/160	1027/3/4	√			
M125/205	1033/3/4	√			
M125/145	1064/3/4		√		
M125/145	1065/3/4		√		
M125/145	1068/3/4	√			
M125/145	1071/3/4		√		
M125/145	1072/3/4	√			
M125/145	1074/3/4		√		
M125/145	1076/3/4	√			
M125/140	1078/3/4	√			
M125/140	1079/3/4		√		
M125/145	1080/3/4		√		
M125/120	1087/3/4	√			
M125/120	1088/3/4	√			
M125/130	1093/3/4		√		
M125/130	1094/3/4	√			
M125/130	1095/3/4	√			
M125/130	1096/3/4	√			
M125/140	1099/3/4		√		
M150/120	129/4/4	√			
M150/150	135/4/4	√			
M125/160	136/4/4		√		
M125/160	139/4/4	√			
M125/120	146/4/4		√		
M125/95	156/4/4				√
M150/120	159/4/4			√	
M150/120	160/4/4			√	
M150/120	161/4/4			√	
M150/120	162/4/4			√	
M150/125	163/4/4			√	

Lampiran 2: Tabel Jenis Kecacatan Rol Sebelum Perbaikan (sambungan)

M125/150	166/4/4			√	
M125/150	167/4/4	√			
M125/110	172/4/4	√			
M125/110	174/4/4	√			
M125/110	175/4/4	√			
M125/160	179/4/4		√		
M125/120	186/4/4	√			
M125/170	192/4/4	√			
M125/170	193/4/4			√	
M125/135	196/4/4	√			
M125/135	198/4/4	√			
M125/150	200/4/4		√		
M125/150	201/4/4	√			
M125/160	202/4/4			√	
M125/125	204/4/4		√		
M125/125	205/4/4	√			
M125/125	207/4/4		√		
M125/125	208/4/4		√		
M125/125	209/4/4	√			
M125/125	210/4/4	√			
M125/100	212/4/4			√	
M125/100	213/4/4		√		
M125/180	215/4/4	√			
M125/180	217/4/4	√			
M125/135	221/4/4	√			
M125/135	223/4/4	√			
M125/135	225/4/4	√			
M150/105	229/4/4		√		
M150/105	230/4/4	√			
M150/105	234/4/4	√			
M150/105	239/4/4	√			
M150/105	241/4/4	√			
M125/125	250/4/4	√			
M125/130	252/4/4	√			
M125/130	253/4/4	√			
M125/125	254/4/4				√
M125/115	255/4/4	√			
M125/115	257/4/4	√			
M125/115	258/4/4			√	
M125/115	260/4/4				√
M125/105	263/4/4				√
M125/120	271/4/4			√	
M125/120	273/4/4	√			
M125/100	277/4/4		√		
M125/100	278/4/4	√			

Lampiran 2: Tabel Jenis Kecacatan Rol Sebelum Perbaikan (sambungan)

M125/100	279/4/4	√			
M125/140	284/4/4				√
M125/105	297/4/4	√			
M125/160	303/4/4				√
BK200/130	016/4/4	√			
BK125/135	018/4/4	√			
BK125/95	019/4/4	√			
BK125/145	020/4/4				√
BK150/95	021/4/4			√	
BK150/110	022/4/4	√			
BK150/140	023/4/4	√			
BK150/155	024/4/4	√			
BK150/155	025/4/4			√	
BK150/110	026/4/4	√			
BK150/150	029/4/4				√
BK200/85	030/4/4				√
BK200/110	031/4/4	√			
BK200/110	032/4/4	√			
BK200/115	033/4/4				√
BK200/125	035/4/4				√
BK200/150	036/4/4			√	
BK200/105	043/4/4				√
BK200/105	046/4/4	√			
BK200/105	048/4/4	√			
BK200/125	050/4/4				√
BK200/140	051/4/4		√		
BK125/95	052/4/4			√	
BK125/95	053/4/4	√			
BK125/125	054/4/4			√	
BK200/120	055/4/4				√
BK125/145	056/4/4	√			
BK200/120	057/4/4				√
BK200/140	058/4/4	√			
BK200/140	059/4/4	√			
BK125/95	060/4/4	√			
BK125/95	061/4/4	√			
BK125/105	066/4/4				√
BK125/105	068/4/4				√
BK125/120	069/4/4			√	
BK150/140	070/4/4	√			
BK150/140	072/4/4				√
BK150/140	073/4/4				√
BK200/85	074/4/4	√			
BK125/105	075/4/4			√	
BK125/145	076/4/4				√

Lampiran 2: Tabel Jenis Kecacatan Rol Sebelum Perbaikan (sambungan)

BK150/120	077/4/4	√			
BK150/155	078/4/4				√
K150/120	009/4/4	√			
K150/140	010/4/4				√

Total	77	19	18	22
Sampel	136			

Lampiran 3: Tabel Biaya Kecacatan Sebelum Perbaikan

Kode	Gramatur Rol	Lebar Rol (cm)	Diameter Rol (cm)	Kesalahan LKM (lembar)	Biaya Kecacatan
1003/3/4	125	120	803	5	56,732
1005/3/4	125	115	858	4	46,474
1006/3/4	125	130	977	3	44,866
1008/3/4	125	170	579	3	34,770
1009/3/4	125	170	881	4	70,542
1012/3/4	125	140	976	3	48,268
1023/3/4	125	160	1200	3	67,824
1025/3/4	125	160	1147	4	86,438
1027/3/4	125	160	1151	5	108,424
1033/3/4	125	205	1359	4	131,218
1064/3/4	125	145	1178	3	60,339
1065/3/4	125	145	1513	3	77,498
1071/3/4	125	145	1409	4	96,228
1074/3/4	125	145	903	3	46,253
1076/3/4	125	145	1211	3	62,029
1078/3/4	125	140	1178	5	97,097
1079/3/4	125	140	1230	3	60,830
1080/3/4	125	145	1088	3	55,729
1087/3/4	125	120	1352	4	76,415
1088/3/4	125	120	1257	4	71,046
1093/3/4	125	130	1178	5	90,161
1096/3/4	125	130	1157	3	53,132
1099/3/4	125	140	1002	4	66,072
135/4/4	150	150	1126	3	71,597
136/4/4	125	160	1030	3	58,216
146/4/4	125	120	931	3	39,465
156/4/4	125	95	665	8	59,511
167/4/4	125	150	1075	4	75,949
172/4/4	125	110	794	3	30,853
174/4/4	125	110	783	3	30,425
175/4/4	125	110	765	4	39,635
179/4/4	125	160	1047	3	59,176
186/4/4	125	120	872	4	49,285
192/4/4	125	170	1140	6	136,920
196/4/4	125	135	1016	3	48,452
198/4/4	125	135	1026	4	65,238

Lampiran 3: Tabel Biaya Kecacatan Sebelum Perbaikan (sambungan)

200/4/4	125	150	1208	3	64,009
201/4/4	125	150	1147	4	81,036
204/4/4	125	125	909	3	40,138
205/4/4	125	125	881	4	51,869
207/4/4	125	125	841	3	37,135
208/4/4	125	125	909	3	40,138
209/4/4	125	125	886	3	39,122
210/4/4	125	125	911	11	147,497
213/4/4	125	100	699	3	24,692
215/4/4	125	180	1298	3	82,533
217/4/4	125	180	1249	3	79,418
221/4/4	125	135	926	4	58,880
223/4/4	125	135	983	3	46,878
225/4/4	125	135	1035	3	49,358
229/4/4	150	105	774	3	34,450
230/4/4	150	105	761	3	33,872
234/4/4	150	105	728	4	43,204
239/4/4	150	105	700	3	31,157
241/4/4	150	105	696	4	41,305
250/4/4	125	125	912	3	40,271
252/4/4	125	130	893	3	41,009
253/4/4	125	130	784	3	36,003
254/4/4	125	125	852	4	50,162
255/4/4	125	115	833	3	33,840
257/4/4	125	115	779	4	42,195
260/4/4	125	115	837	5	56,670
263/4/4	125	105	725	5	44,819
273/4/4	125	120	871	3	36,922
277/4/4	125	100	681	3	24,056
278/4/4	125	100	728	3	25,717
284/4/4	125	140	994	6	98,317
303/4/4	125	160	1208	3	68,276
016/4/4	200	130	1097	3	80,603
018/4/4	125	135	1145	3	54,604
019/4/4	125	95	1218	5	68,124
020/4/4	125	145	1215	15	311,169
022/4/4	150	110	892	5	69,322
023/4/4	150	140	1086	5	107,416
024/4/4	150	155	1275	3	83,773

Lampiran 3: Tabel Biaya Kecacatan Sebelum Perbaikan (sambungan)

026/4/4	150	110	856	3	39,914
029/4/4	150	150	1273	3	80,944
030/4/4	200	85	619	3	29,738
031/4/4	200	110	863	3	53,654
032/4/4	200	110	878	4	72,783
033/4/4	200	115	1050	3	68,248
035/4/4	200	125	996	15	351,837
043/4/4	200	105	828	3	49,138
046/4/4	200	105	885	3	52,521
048/4/4	200	105	944	4	74,697
050/4/4	200	125	977	4	92,033
051/4/4	200	140	1117	3	88,386
055/4/4	200	120	1228	4	111,050
056/4/4	125	145	1230	3	63,002
060/4/4	125	95	807	3	27,082
066/4/4	125	105	866	3	32,121
067/4/4	125	105	849	3	31,490
072/4/4	150	140	1153	4	91,235
073/4/4	150	140	1267	3	75,191
074/4/4	200	85	616	4	39,458
076/4/4	125	145	1219	3	62,439
078/4/4	150	155	1366	3	89,752
009/4/4	150	120	1040	4	70,537
010/4/4	150	140	1139	3	67,595
Total	99 Rol			384	6,587,908

Lampiran 4: Tabel Keadaan Rol Kertas Sesudah Perbaikan

Supplier	Jenis	Kode	Keadaan			
			Baik	Sobek	Kotor	Sobek dan Kotor
Pakerin	M125/145	227/6/4	√			
	M125/145	228/6/4	√			
	M125/145	229/6/4	√			
	M125/145	230/6/4	√			
	M150/140	231/6/4	√			
	M150/140	232/6/4		√		
	M150/140	233/6/4	√			
	M150/140	234/6/4	√			
SMB	M125/175	253/6/4	√			
	M125/175	254/6/4	√			
	M125/175	255/6/4	√			
	M125/175	256/6/4	√			
	M125/175	257/6/4	√			
	M125/175	258/6/4	√			
	M125/175	259/6/4	√			
	M112/150	260/6/4	√			
	M112/150	261/6/4	√			
	M112/170	262/6/4	√			
	M112/170	263/6/4	√			
	M112/170	264/6/4	√			
	M112/170	265/6/4	√			
	M112/170	266/6/4		√		
	M112/170	267/6/4	√			
	M112/170	268/6/4	√			
	M125/125	269/6/4	√			
	M125/125	270/6/4	√			
	M125/125	271/6/4	√			
	M125/125	272/6/4	√			
	M125/125	273/6/4	√			
	M125/125	274/6/4	√			
	M125/125	275/6/4	√			
	M125/95	276/6/4	√			
	M125/95	277/6/4	√			
	M125/95	278/6/4	√			
	M125/95	279/6/4	√			
	M125/95	280/6/4		√		

Lampiran 4: Tabel Keadaan Rol Kertas Sesudah Perbaikan (sambungan)

	M125/95	281/6/4	√			
	M125/125	283/6/4	√			
	M125/125	284/6/4	√			
	M125/125	285/6/4	√			
	M125/125	286/6/4	√			
	M125/125	287/6/4	√			
	M125/125	288/6/4	√			
	M125/125	289/6/4	√			
	M125/125	290/6/4	√			
	M125/95	291/6/4	√			
	M125/95	292/6/4	√			
	M125/95	293/6/4	√			
	M125/95	294/6/4	√			
Jaker	M112/240	295/6/4	√			
	M125/185	296/6/4	√			
	M125/185	297/6/4		√		
	M125/200	298/6/4	√			
	M125/200	299/6/4	√			
	M125/230	300/6/4	√			
	M125/105	301/6/4	√			
	M125/120	302/6/4	√			
	M125/140	303/6/4	√			
	M150/235	305/6/4	√			
	M150/245	306/6/4	√			
	M150/250	307/6/4	√			
	M125/235	308/6/4	√			
	M150/235	310/6/4	√			
	M150/235	311/6/4		√		
SMB	M125/240	312/6/4		√		
	M125/235	314/6/4	√			
	M112/150	317/6/4	√			
	M112/150	318/6/4	√			
	M112/150	319/6/4	√			
	M112/150	320/6/4	√			
	M112/170	321/6/4	√			
	M112/170	322/6/4	√			
	M112/170	323/6/4	√			
	M112/150	348/6/4	√			
	M112/150	349/6/4	√			

Lampiran 4: Tabel Keadaan Rol Kertas Sesudah Perbaikan (sambungan)

	M125/105	350/6/4		√		
	M125/105	351/6/4	√			
	M125/105	352/6/4	√			
	M125/105	353/6/4	√			
	M125/115	354/6/4	√			
	M125/115	355/6/4	√			
	M125/115	356/6/4	√			
	M125/115	357/6/4	√			
	M125/135	358/6/4	√			
	M125/135	359/6/4	√			
	M125/175	380/6/4	√			
	M125/175	381/6/4	√			
	M125/175	382/6/4	√			
	M125/175	383/6/4	√			
	M125/150	384/6/4	√			
	M125/150	385/6/4	√			
	M125/150	386/6/4	√			
	M125/115	387/6/4	√			
	M125/115	388/6/4	√			
	M125/125	389/6/4	√			
	M125/125	390/6/4	√			
	M125/170	391/6/4	√			
	M125/170	392/6/4	√			
	M125/170	393/6/4	√			
	M125/170	394/6/4	√			
	M125/170	395/6/4	√			
	M125/170	396/6/4	√			
	M125/170	397/6/4	√			
	M125/170	398/6/4	√			
	M125/170	399/6/4	√			
	M125/170	400/6/4	√			
Jaker	M125/190	401/6/4	√			
	M125/195	402/6/4	√			
	M125/195	403/6/4	√			
	M150/235	404/6/4	√			
	M125/245	406/6/4	√			
	M150/245	407/6/4	√			
Pakerin	KB150/145	121/6/4		√		
	KB150/145	122/6/4		√		

Lampiran 4: Tabel Keadaan Rol Kertas Sesudah Perbaikan (sambungan)

	KB150/145	123/6/4	√			
	KB150/145	124/6/4	√			
	KB150/145	125/6/4	√			
	KB150/145	126/6/4		√		
	KB200/105	127/6/1		√		
	KB200/105	128/6/4	√			
	KB200/105	129/6/4	√			
	KB200/105	130/6/4	√			
	KB200/140	131/6/4	√			
	KB200/140	132/6/4		√		
	KB200/140	133/6/4	√			
	KB200/140	134/6/4	√			
	KB200/140	135/6/4	√			
	KB200/140	136/6/4	√			
	KB200/140	137/6/4	√			
	KB200/140	138/6/4	√			
	KB200/140	139/6/4	√			
Jaker	KB150/165	140/6/4	√			
	KB150/165	141/6/4	√			
	KB150/165	142/6/4		√		
	KB150/130	143/6/4	√			
	KB150/130	144/6/4		√		
	KB150/155	145/6/4		√		
	KB150/165	146/6/4	√			
	KB150/165	147/6/4		√		
	KB150/120	148/6/4		√		
SMB	KB125/105	149/6/4	√			
	KB125/105	150/6/4		√		
	KB125/105	151/6/4	√			
	KB125/105	152/6/4	√			
	KB125/105	153/6/4		√		
	KB125/105	154/6/4	√			
	KB125/105	155/6/4		√		
	KB125/105	156/6/4	√			
	KB125/105	157/6/4	√			
	KB125/105	158/6/4		√		
	KB125/105	159/6/4	√			
	KB150/120	160/6/4		√		
	KB150/130	161/6/4		√		

Lampiran 4: Tabel Keadaan Rol Kertas Sesudah Perbaikan (sambungan)

	KB150/140	162//6/4	√			
	KB150/140	163/6/4		√		
	KB125/105	190/6/4	√			
	KB125/140	191/6/4	√			
	KB125/140	192/6/4		√		
	KB125/140	193/6/4	√			
	KB125/140	194/6/4		√		
	KB150/105	195/6/4	√			
	KB150/120	196/6/4	√			
	KB150/120	197/6/4	√			
	KB150/140	198/6/4		√		
Pakerin	KB150/120	199/6/4	√			
	KB150/120	200/6/4	√			
	KB150/120	201/6/4	√			
	KB150/120	202/6/4	√			
	KB150/130	203/6/4	√			
	KB150/130	204/6/4	√			
	KB150/130	205/6/4		√		
	KB150/130	206/6/4	√			
	KB150/130	207/6/4	√			
	KB200/105	208/6/4				
	KB200/105	209/6/4	√			
	KB200/105	210/6/4	√			
	KB200/105	211/6/4		√		
	KB200/105	212/6/4	√			
	KB200/140	213/6/4	√			
	KB200/140	214/6/4	√			
	KB200/140	215/6/4	√			
	KB200/140	216/6/4		√		
	KB200/140	217/6/4	√			
	KB200/140	218/6/4	√			
	KB200/140	219/6/4	√			
	KB200/140	220/6/4	√			
	KB200/140	221/6/4		√		
	K200/155	063/6/4	√			
	K150/140	064/6/4	√			
	K150/140	065/6/4	√			
	K150/140	066/6/4	√			
	K150/140	067/6/4		√		

Lampiran 4: Tabel Keadaan Rol Kertas Sesudah Perbaikan (sambungan)

	K150/140	068/6/4	√			
	K150/140	069/6/4	√			
	K150/140	070/6/4	√			
	Total		162	32	0	0
	Total Sampel		194			

Lampiran 5: Tabel Jenis Kecacatan Rol Sesudah Perbaikan

Jenis	Kode	Jenis Kecacatan		
		Capit Forklift	Potongan Terlalu Dalam	Tertabrak
M150/140	232/6/4	√		
M112/170	266/6/4			√
M125/240	312/6/4	√		
KB150/145	122/6/4	√		
KB200/140	132/6/4	√		
KB150/165	142/6/4		√	
KB150/165	147/6/4	√		
KB150/120	148/6/4		√	
KB150/120	160/6/4	√		
KB200/140	221/6/4			√
K150/140	067/6/4	√		
Total		7	2	2

Lampiran 6: Tabel Biaya Kecacatan Rol Sesudah Perbaikan

Kode	Gramatur Rol	Lebar Rol (cm)	Diameter Rol (cm)	Kesalahan LKM (lembar)	Biaya Kecacatan
232/6/4	150	140	1147	4	90,760
266/6/4	112	170	1359	6	146,248
312/6/4	125	240	1409	5	199,092
122/6/4	150	145	931	4	76,299
132/6/4	200	140	1075	4	113,417
142/6/4	150	165	1026	3	71,762
147/6/4	150	165	926	3	64,768
148/6/4	150	120	909	4	61,652
160/6/4	150	120	1157	3	58,854
221/6/4	200	140	977	8	206,155
067/6/4	150	140	1267	3	75,191
Total	11			47	1,164,197

Lampiran 7: Tabel Kecacatan *Corrugating*

OPI	Order	Jenis Kecacatan (lembar)								Jml. Cacat	Total Hasil	% Cacat
		Melintir	Meringis	Mengelupas	Gel.Pecah	Basah	Sobek (nekok)	Ukuran T. Sama	Creasing T. Ada			
0868V	30000	8	113	295	42			75		533	30573	1.74%
0869V	60000		125	232	72					429	60486	0.71%
1305V	10200		58	47				12		117	10389	1.13%
1324V	1000		4	24	5			4		37	1036	3.57%
1347V	1000			44	12					56	1070	5.23%
1317V	300	5		21	14			4		44	356	12.36%
1095V	48000		66	188				32	152	438	48452	0.90%
1055V	4515		34	97						131	4655	2.81%
1178V	12500		17	115				12		144	12660	1.14%
0987V	8500		19	173	12					204	8716	2.34%
0571I	12050	7	18	54	15	4		9		107	12229	0.87%
0579I	5250		11	27	23	12				73	5370	1.36%
0606I	3185		7	26						33	3291	1.00%
0686I	2630		8	41	5			6		60	2736	2.19%
0872V	20650		76	118	57	12		44		307	21102	1.45%
0873V	30000		88	189	79	12		70		438	30584	1.43%
0870V	50000	9	72	587	146	4		150		968	51132	1.89%
0207I	9000	6	26	37	29			57		155	9186	1.69%
0203I	12600	5	25	18	10	8		24		90	12735	0.71%

Lampiran 7: Tabel Kecacatan *Corrugating* (sambungan)

1256V	10500		5	41	21	5				72	10611	0.68%
0691I	2625		57	35	32			24		148	2781	5.32%
contoh	20			23						23	52	44.23%
1336V	3750		12	45	5		2	21		85	3870	2.20%
0726I	550	2	14	22	30					68	615	11.06%
1089V	12000	32	62	117	34			24		269	12705	2.12%
1326V	5000			18	12			12		42	5060	0.83%
1327V	5000	4	9	58	13	7				91	5144	1.77%
1255V	3150		23	33	0	2				58	3266	1.78%
0873V	50000	33	113	214	92					452	51030	0.89%
0694I	5250	18	29	81	4			12		144	5385	2.67%
0724I	11000		92	188	25		5	44		354	11400	3.11%
1393V	20400	40	112	157			11	24		344	20816	1.65%
0237V	9092	12	31	66		5	8			122	9220	1.32%
0238V	9092		12	40		7				59	9328	0.63%
4624V	30040	80	96	415	111					702	31000	2.26%
0134V	12627		114	219	66			18		417	13068	3.19%
1401V	2100			79				12		91	2256	4.03%
0734I	2625			36				9		45	2733	1.65%
0761I	3060	12		64	15			8		99	3196	3.10%
0687I	5100		54	47					46	147	5310	2.77%
0688I	5100		2	7	18					27	5331	0.51%

Lampiran 7: Tabel Kecacatan *Corrugating* (sambungan)

1351V	25200			108	36			15		159	25764	0.62%
1332V	2100		10	116	33			21		180	2343	7.68%
1333V	2010			28			12			40	2103	1.90%
0622I	30000	22		117	67			12		218	30285	0.72%
0738I	2625		79	66	14	5	3	18		185	2868	6.45%
0762I	3060			32	8			6		46	3182	1.45%
1346V	10000			45				18		63	10204	0.62%
0725I	11000			52	18		6		48	124	11134	1.11%
0778I	816		17	28					12	57	905	6.30%
1409V	25500		76	178	12				22	288	25828	1.12%
1454V	1380			148			12			160	1600	10.00%
1433V	2840	12	20	28	16					76	2928	2.60%
1432V	2100			12						12	2144	0.56%
1430V	3892			64	40					104	4012	2.59%
1429V	5780	8	12	26						46	5852	0.79%
Total		315	1818	5386	1243	83	59	797	280	9981	672087	

Lampiran 8: Tabel Biaya Kecacatan *Corrugating*

OPI	Order	J. Cacat Total (lembar)	Berat Total (kg)	Jenis Kecacatan			Jumlah Tiga Kecacatan	Berat Tiga Kecacatan	Biaya Rp. 3000/kg (Rp)
				Meringis	Mengelupas	Gel.Pecah			
0868V	30000	533	109	113	295	42	450	92	276.079
0869V	60000	429	96	125	232	72	429	96	288.000
1305V	10200	117	65	58	47		105	58	175.000
1324V	1000	37	21	4	24	5	33	19	56.189
1347V	1000	56	42		44	12	56	42	126.000
1317V	300	44	30		21	14	35	24	71.591
1095V	48000	438	107	66	188		254	62	186.151
1055V	4515	131	52	34	97		131	52	156.000
1178V	12500	144	59	17	115		132	54	162.250
0987V	8500	204	79	19	173	12	204	79	237.000
0571I	12050	107	64	18	54	15	87	52	156.112
0579I	5250	73	44	11	27	23	61	37	110.301
0606I	3185	33	45	7	26		33	45	135.000
0686I	2630	60	35	8	41	5	54	32	94.500
0872V	20650	307	93	76	118	57	251	76	228.107
0873V	30000	438	121	88	189	79	356	98	295.041
0870V	50000	968	208	72	587	146	805	173	518.926
0207I	9000	155	54	26	37	29	92	32	96.155

Lampiran 8: Tabel Biaya Kecacatan *Corrugating* (sambungan)

0203I	12600	90	41	25	18	10	53	24	72.433
1256V	10500	72	33	5	41	21	67	31	92.125
0691I	2625	148	14	57	35	32	124	12	35.189
contoh	20	23	14		23		23	14	42.000
1336V	3750	85	30	12	45	5	62	22	65.647
0726I	550	68	122	14	22	30	66	118	355.235
1089V	12000	269	121	62	117	34	213	96	287.431
1326V	5000	42	27		18	12	30	19	57.857
1327V	5000	91	52	9	58	13	80	46	137.143
1255V	3150	58	45	23	33	0	56	43	130.345
0873V	50000	452	206	113	214	92	419	191	572.881
0694I	5250	144	42	29	81	4	114	33	99.750
0724I	11000	354	92	92	188	25	305	79	237.797
1393V	20400	344	160	112	157		269	125	375.349
0237V	9092	122	47	31	66		97	37	112.107
0238V	9092	59	36	12	40		52	32	95.186
4624V	30040	702	247	96	415	111	622	219	656.556
0134V	12627	417	148	114	219	66	399	142	424.835
1401V	2100	91	82		79		79	71	213.560
0734I	2625	45	19		36		36	15	45.600
0761I	3060	99	71		64	15	79	57	169.970
0687I	5100	147	67	54	47		101	46	138.102

Lampiran 8: Tabel Biaya Kecacatan *Corrugating* (sambungan)

0688I	5100	27	24	2	7	18	27	24	72.000
1351V	25200	159	81		108	36	144	73	220.075
1332V	2100	180	82	10	116	33	159	72	217.300
1333V	2010	40	28		28		28	20	58.800
0622I	30000	218	78		117	67	184	66	197.505
0738I	2625	185	67	79	66	14	159	58	172.751
0762I	3060	46	59		32	8	40	51	153.913
1346V	10000	63	50		45		45	36	107.143
0725I	11000	124	33		52	18	70	19	55.887
0778I	816	57	115	17	28		45	91	272.368
1409V	25500	288	60	76	178	12	266	55	166.250
1454V	1380	160	49		148		148	45	135.975
1433V	2840	76	20	20	28	16	64	17	50.526
1432V	2100	12	9		12		12	9	27.000
1430V	3892	104	27		64	40	104	27	81.000
1429V	5780	46	15	12	26		38	12	37.174
Total	657764	9981	3837				8447	3270	9.811.167

Lampiran 9: Tabel *Waste Trim* dan *Waste Produksi Corrugating*

OPI	Lbr Rol (m)	Pnj Sheet (m)	Lbr Sheet (m)	Jml Out	Jml Pot	Jns	Gram/ m2	Luas Trim (m2)	Total Trim (g)	Total Trim (kg)	Trim Total (%)	Cacat Total (kg)	Cacat Total (%)	Trim+ Cacat (kg)	Trim+ Cacat (%)	Total Hasil (kg)
0868V	1.35	1.102	0.440	3	2011	BF	407.0	0.033	27063	27	0.4%	109	1.8%	136	2.3%	6034
0869V	1.35	1.102	0.440	3	3979	BF	407.0	0.033	53539	54	0.4%	96	0.8%	150	1.3%	11937
1305V	1.55	1.440	0.505	3	1184	BF	470.0	0.050	28039	28	0.8%	65	1.8%	93	2.6%	3551
1324V	1.55	1.804	0.746	2	160	CF	457.5	0.105	7659	8	2.4%	21	6.6%	29	9.0%	320
1347V	1.55	1.804	0.746	2	321	CF	457.5	0.105	15342	15	2.4%	42	6.6%	57	8.9%	641
1317V	1.40	1.352	0.690	2	95	BF	570.0	0.027	1457	1	0.8%	30	15.9%	31	16.6%	189
1095V	1.40	1.362	0.345	4	2869	CF	519.0	0.027	40557	41	0.4%	107	0.9%	148	1.3%	11475
1055V	1.30	0.620	1.280	1	1736	BF	480.0	0.012	10333	10	0.6%	52	3.0%	62	3.6%	1736
1178V	1.30	1.260	0.630	2	2312	BF	460.0	0.050	53590	54	1.2%	59	1.3%	113	2.4%	4623
0987V	1.30	0.614	1.279	1	3217	BF	470.0	0.013	19496	19	0.6%	79	2.5%	98	3.1%	3217
0571I	1.30	0.620	1.280	1	4464	BF	460.0	0.012	25463	25	0.6%	64	1.4%	89	2.0%	4464
0579I	1.30	0.620	1.280	1	1961	BF	460.0	0.012	11186	11	0.6%	44	2.2%	55	2.8%	1961
0606I	1.20	0.710	1.155	1	1403	BF	520.0	0.032	23309	23	1.7%	45	3.2%	68	4.9%	1403
0686I	1.20	1.244	0.589	2	446	BF	445.0	0.027	5432	5	0.6%	35	3.9%	40	4.5%	892
0872V	0.90	1.170	0.441	2	2178	BF	400.0	0.021	18343	18	0.4%	93	2.1%	111	2.6%	4355
0873V	0.90	1.170	0.441	2	3157	BF	400.0	0.021	26590	27	0.4%	121	1.9%	148	2.3%	6313
0870V	0.90	1.102	0.440	2	4959	BF	400.0	0.022	43714	44	0.4%	208	2.1%	252	2.5%	9917
0207I	1.45	1.274	0.466	3	916	BF	504.0	0.066	30595	31	1.1%	54	2.0%	85	3.1%	2749
0203I	1.45	1.274	0.466	3	1270	BF	504.0	0.066	42415	42	1.1%	41	1.1%	83	2.2%	3811

Lampiran 9: Tabel *Waste Trim* dan *Waste Produksi Corrugating* (sambungan)

1256V	1.45	1.268	0.468	3	1058	BF	504.0	0.058	31093	31	1.0%	33	1.0%	64	2.0%	3173
0691I	1.45	0.804	0.473	3	166	BF	470.0	0.025	1941	2	0.4%	14	2.8%	16	3.2%	497
contoh	1.45	1.600	1.420	1	61	BF	520.0	0.048	1523	2	2.5%	14	23.0%	16	25.4%	61
1336V	1.45	1.176	0.473	3	319	BF	445.0	0.036	5181	5	0.5%	30	3.1%	35	3.7%	958
0726I	1.45	1.600	1.400	1	1071	BC	777.5	0.080	66616	67	6.2%	122	11.4%	189	17.6%	1071
1089V	1.05	1.362	0.345	3	1003	CF	482.5	0.020	9887	10	0.3%	121	4.0%	131	4.3%	3009
1326V	1.00	1.538	0.478	2	1124	CF	619.0	0.068	47062	47	2.1%	27	1.2%	74	3.3%	2247
1327V	1.00	1.538	0.478	2	1143	CF	619.0	0.068	47858	48	2.1%	52	2.3%	100	4.4%	2285
1255V	1.00	1.230	0.980	1	1850	BF	470.0	0.025	21390	21	1.2%	45	2.4%	66	3.6%	1850
0873V	0.90	1.170	0.441	2	5266	BF	400.0	0.021	44361	44	0.4%	206	2.0%	250	2.4%	10532
0694I	1.75	1.230	0.563	3	553	BF	470.0	0.075	19513	20	1.2%	42	2.5%	62	3.7%	1660
0724I	1.75	1.292	0.423	4	693	BF	435.0	0.075	22590	23	0.8%	92	3.3%	115	4.1%	2772
1393V	1.75	1.237	0.433	4	2028	BC	727.5	0.022	32847	33	0.4%	160	2.0%	193	2.4%	8111
0237V	1.75	1.108	0.433	4	832	BC	752.5	0.020	12490	12	0.4%	47	1.4%	59	1.8%	3329
0238V	1.75	1.108	0.433	4	842	BC	752.5	0.020	12637	13	0.4%	36	1.1%	49	1.4%	3368
4624V	1.75	1.294	0.429	4	2130	BF	495.0	0.044	46376	46	0.5%	247	2.9%	293	3.4%	8518
0134V	1.55	1.345	0.497	3	1467	BF	504.0	0.079	58686	59	1.3%	148	3.4%	207	4.7%	4402
1401V	1.50	1.316	0.740	2	664	BF	604.0	0.026	10548	11	0.8%	82	6.2%	93	7.0%	1327
0734I	1.50	0.836	0.494	3	215	BF	570.0	0.015	1841	2	0.3%	19	3.0%	21	3.2%	644
0761I	1.50	1.990	0.727	2	1029	BF	445.0	0.092	41917	42	2.0%	71	3.4%	113	5.5%	2058
0687I	1.50	1.296	0.488	3	564	CF	519.0	0.047	13665	14	0.8%	67	4.0%	81	4.8%	1693
0688I	1.50	1.296	0.488	3	566	CF	519.0	0.047	13713	14	0.8%	24	1.4%	38	2.2%	1699

Lampiran 9: Tabel *Waste Trim* dan *Waste Produksi Corrugating* (sambungan)

1351V	1.45	1.302	0.469	3	2643	CF	519.0	0.056	76807	77	1.0%	81	1.0%	158	2.0%	7930
1332V	1.45	1.442	0.469	3	262	BF	504.0	0.062	8198	8	1.0%	82	10.4%	90	11.5%	787
1333V	1.45	1.442	0.469	3	236	BF	504.0	0.062	7365	7	1.0%	28	4.0%	35	5.0%	707
0622I	1.45	1.274	0.466	3	2991	BF	504.0	0.066	99855	100	1.1%	78	0.9%	178	2.0%	8972
0738I	1.45	1.302	0.476	3	284	BF	479.0	0.029	3892	4	0.5%	67	7.9%	71	8.3%	851
0762I	1.45	1.960	0.716	2	994	BF	445.0	0.035	15598	16	0.8%	59	3.0%	75	3.8%	1987
1346V	1.10	1.278	0.522	2	1715	CF	519.0	0.072	63702	64	1.9%	50	1.5%	114	3.3%	3430
0725I	1.10	1.114	0.526	2	1410	BF	432.0	0.053	32559	33	1.2%	33	1.2%	66	2.3%	2819
0778I	1.10	2.250	1.100	1	1656	BC	752.5	0.000	0	0	0.0%	115	6.9%	115	6.9%	1656
1409V	1.70	1.062	0.420	4	1172	BF	407.0	0.021	10134	10	0.2%	60	1.3%	70	1.5%	4689
1454V	1.65	1.156	0.407	4	89	BF	470.0	0.025	1058	1	0.3%	49	13.8%	50	14.1%	354
1433V	1.65	1.156	0.407	4	162	BF	470.0	0.025	1936	2	0.3%	20	3.1%	22	3.4%	648
1432V	1.65	1.156	0.407	4	119	BF	470.0	0.025	1416	1	0.3%	9	1.9%	10	2.2%	474
1430V	1.65	1.156	0.407	4	222	BF	470.0	0.025	2654	3	0.3%	27	3.0%	30	3.3%	888
1429V	1.65	1.156	0.407	4	324	BF	470.0	0.025	3867	4	0.3%	15	1.2%	19	1.5%	1294
Total										1377	1.0%	3837	3.7%	5214	4.7%	182338

Lampiran 10: Tabel Kecacatan Bagian Flexo A

OPI	R	Jenis Kecacatan										Jumlah Cacat	Total Hasil	% Cacat
		Sobek	Sheet Rusak	Creasing T. Tepat (pecah)	Printing Jembret	Warna T. Sama	Printing Kabur (hilang)	Printing T. Tepat (lari)	Printing Terbalik	Printing, Slotter Miring	Slotter T. Tepat (lari)			
00081V	B	1								2	5	8	3135	0.26%
00131V	B			1			6					7	10190	0.07%
00091V	B									2	4	6	7520	0.08%
00054V	B							2				2	1575	0.13%
02274H	B	9			2			3		3		17	15280	0.11%
00020I	A							5				5	4993	0.10%
00019I	A						2					2	4930	0.04%
00151V	A	9								10	6	25	1515	1.65%
00048I	A	6					1				1	8	375	2.13%
00103I	A	10	1							14		25	6990	0.36%
00194V	A	4						2				6	1550	0.39%
00177V	A							29				29	7700	0.38%
00310V	A	1								1	2	4	5693	0.07%
00351V	B				5		3				30	38	7345	0.52%
00211I	B										14	14	6040	0.23%
04610U	B							5			4	9	4887	0.18%
04609U	B						4	1			2	7	1000	0.70%
00369V	B	8						14			2	24	15730	0.15%

Lampiran 10: Tabel Kecacatan Bagian Flexo A (sambungan)

00352V	B						19			3		22	1250	1.76%
00352V	A						5	4		4	191	204	13830	1.48%
00380V	A										3	3	1096	0.27%
00379V	A	1									1	2	1048	0.19%
00110I	A							1			1	2	2573	0.08%
00234I	A	1					1	2				4	150	2.67%
00105I	A	3						3			5	11	2094	0.53%
00488V	A	8						2				10	10325	0.10%
02582H	A							3		1		4	4250	0.09%
02590H	A	1								1		2	4336	0.05%
00508V	A	1						7				8	9500	0.08%
00553V	A	7						9				16	895	1.79%
00230I	A							1				1	2573	0.04%
00229I	A						1					1	3233	0.03%
00465V	A							2			2	4	1575	0.25%
04611U	A	2						1		12		15	10030	0.15%
00516V	A							4		2		6	800	0.75%
00265I	B	8						2				10	2565	0.39%
00266I	B							6				6	1650	0.36%
00267I	B	3						5				8	530	1.51%
00576V	B							1				1	120	0.83%
00544V	B						1	1				2	3993	0.05%

Lampiran 10: Tabel Kecacatan Bagian Flexo A (sambungan)

00311I	B							6			9	15	1545	0.97%
02527H	B	7						8			3	18	2535	0.71%
04633U	A							4				4	6995	0.06%
00139I	A							8			20	28	11530	0.24%
01405V	B							2	1		10	13	8380	0.16%
00938V	B	2						20				22	10190	0.22%
00939V	B		1					3				4	10113	0.04%
00773I	B		12				4					16	6400	0.25%
01449V	B											0	3593	0.00%
01205V	B	4								3	3	10	19455	0.05%
00784I	B								1		6	7	2620	0.27%
00785I	B										4	4	2622	0.15%
00237I	B			1							3	4	2495	0.16%
00591I	B	5					20	10				35	3855	0.91%
00585I	B	9	8				103					120	3855	3.11%
01331V	B	1	5					3				9	5850	0.15%
01441V	B	1									4	5	3040	0.16%
01228V	B	4	4					2		2	3	15	19621	0.08%
01440V	B							4				4	3113	0.13%
00835I	B		3					5	1			9	6550	0.14%
00843I	A							4				4	2410	0.17%
01228V	A		4			26		3		2	33	68	29920	0.23%

Lampiran 10: Tabel Kecacatan Bagian Flexo A (sambungan)

00838I	A										3	3	660	0.45%
00842I	A	1						1			2	4	5515	0.07%
01376V	A									2	3	5	5990	0.08%
00450I	A										4	4	4195	0.10%
00794I	A										5	5	1458	0.34%
00794I	A										3	3	1458	0.21%
00740I	A										4	4	3460	0.12%
Total		117	38	2	7	26	170	198	3	64	395	1020	374287	
% Cacat		11.5%	3.7%	0.2%	0.7%	2.5%	16.7%	19.4%	0.3%	6.3%	38.7%			0.45%
% Total		0.031%	0.010%	0.001%	0.002%	0.007%	0.045%	0.053%	0.001%	0.017%	0.106%	0.273%		

Lampiran 11: Tabel Kecacatan Bagian Flexo B

OPI	R	Jenis Kecacatan										Jumlah Cacat	Total Hasil	% Cacat
		Sobek	Sheet Rusak	Creasing T. Tepat (pecah)	Printing Jembret	Warna T. Sama	Printing Kabur (hilang)	Printing T. Tepat (lari)	Printing Terbalik	Printing, Slotter Miring	Slotter T. Tepat (lari)			
00089I	B	1						1				2	10190	0.02%
00064I	B	1					1	6			2	10	5800	0.17%
00108I	B	1			1			11				13	10190	0.13%
00119V	B					4	1					5	3140	0.16%
02225H	A			1	2			1				4	19110	0.02%
00074I	A			11								11	15720	0.07%
04067U	A							3				3	5000	0.06%
00157V	A									1	1	2	5030	0.04%
00087I	A	2								1	16	19	15375	0.12%
00166V	A							5				5	3555	0.14%
00267V	A				1			3				4	1648	0.24%
00099I	A						1	1				2	2840	0.07%
00009I	A	1					99	1			1	102	1940	5.26%
02488H	A							3				3	8385	0.04%
04209U	A							3			4	7	14980	0.05%
00286V	B										2	2	21400	0.01%
02561H	B	3					4	14			10	31	10490	0.30%
00159I	B	13						9				22	5429	0.41%

Lampiran 11: Tabel Kecacatan Bagian Flexo B (sambungan)

00391V	A									24	21	45	2440	1.84%
00390V	A	1						4				5	4950	0.10%
00152I	A										6	6	10140	0.06%
00257I	A							3				3	10170	0.03%
00274I	A	1						2			6	9	10030	0.09%
02506H	A						6	3				9	2615	0.34%
02502H	A										5	5	2618	0.19%
00161I	A						3	2				5	5240	0.10%
00153I	A									2		2	10030	0.02%
02540H	A	12						3				15	4188	0.36%
00260I	B							3			2	5	1048	0.48%
00259I	B							2			3	5	1000	0.50%
00299V	B							1				1	1050	0.10%
00301I	B							1			1	2	5248	0.04%
00277I	B							6			4	10	2428	0.41%
00506V	B							4			5	9	15130	0.06%
00388V	B	13						17				30	20980	0.14%
00548V	B							12			6	18	4070	0.44%
00525V	B					5	5	3				13	19500	0.07%
02227H	B							7			3	10	20385	0.05%
00131I	B							7		17	7	31	15295	0.20%
00088I	B							3		7		10	15740	0.06%

Lampiran 11: Tabel Kecacatan Bagian Flexo B (sambungan)

00989V	B	3						18	2			23	8480	0.27%
01370V	B		8			18		3	3	2		34	7745	0.44%
01284V	B	4								13	19	36	7335	0.49%
01318V	B							18		22		40	4720	0.85%
00596I	B							3				3	1845	0.16%
01355V	B							7		2	12	21	39000	0.05%
00805I	B	5	10			10	38	10		25	10	108	24850	0.43%
00571I	B	7						7				14	8730	0.16%
00582I	B	2						4				6	5240	0.11%
01357V	B		4					4		4	20	32	19970	0.16%
01356V	B							2		7	23	32	32970	0.10%
01358V	B									3	8	11	5100	0.22%
00844I	A					6	11					17	6685	0.25%
00845I	A	1	2				2	18				23	8450	0.27%
00462V	A							2		1	4	7	4250	0.16%
01202V	A									1	3	4	6100	0.07%
01287V	A	3	2					12		18	57	92	25790	0.36%
01461V	A							4	2			6	5780	0.10%
01461V	A									4	11	15	7790	0.19%
01539V	A							4				4	1914	0.21%
00883I	A							3		2		5	1635	0.31%
01540V	A	1						5				6	2390	0.25%

Lampiran 11: Tabel Kecacatan Bagian Flexo B (sambungan)

Total	75	26	12	4	37	166	279	7	156	272	1034	581286	
% Cacat	7.3%	2.5%	1.2%	0.4%	3.6%	16.1%	27.0%	0.7%	15.1%	26.3%			0.30%
% Total	0.013%	0.004%	0.002%	0.001%	0.006%	0.029%	0.048%	0.001%	0.027%	0.047%	0.178%		

Lampiran 12: Tabel Kecacatan Bagian Flexo C

OPI	R	Jenis Kecacatan									Jumlah Cacat	Total Hasil	% Cacat
		Sobek	Sheet Rusak	Printing Jembret	Warna T. Sama	Printing Kabur (hilang)	Printing T. Tepat (lari)	Printing Terbalik	Printing, Slotter Miring	Slotter T. Tepat (lari)			
04603U	B	5		8			8			12	33	43455	0.08%
04310U	B			2			2			2	6	7150	0.08%
03760U	B						3				3	10010	0.03%
04447U	B								3	6	9	9785	0.09%
00170V	B			1	2				1		4	7600	0.05%
00125I	A						3		1	4	8	20860	0.04%
00140V	A			1							1	8035	0.01%
00120I	A			11			1		17		29	5250	0.55%
00171V	A			2							2	5000	0.04%
00173V	A					29					29	24200	0.12%
04310U	A						1		1		2	36600	0.01%
04317U	A	1					3				4	32450	0.01%
00109I	A			2		6	4			2	14	5060	0.28%
04593U	A						1			1	2	5060	0.04%
04312U	B						6			8	14	70800	0.02%
00190I	B						1			1	2	5250	0.04%
04591U	A			1		2	4				7	10020	0.07%
00421V	A	5					1			2	8	14935	0.05%
00332V	A	6		2		14				25	47	41900	0.11%
00533V	A		5								5	8380	0.06%
04226U	A						5		2	12	19	44000	0.04%
00342V	B			2			6			13	21	19200	0.11%
00340V	B						2			7	9	11750	0.08%

Lampiran 12: Tabel Kecacatan Bagian Flexo C (sambungan)

00331V	B						9			2	11	3600	0.31%
04230U	B			8							8	10015	0.08%
04218U	B						25			24	49	23350	0.21%
00289I	B						2				2	1000	0.20%
00273I	B					3	5				8	2600	0.31%
00009V	B						3				3	10100	0.03%
00268V	B						3			3	6	9600	0.06%
00392V	B						2		2	7	11	34600	0.03%
04620U	A						6			3	9	10375	0.09%
00412V	B	4		4		3	3		3	6	23	10500	0.22%
01294V	B		4	13				3	15	98	133	40100	0.33%
00706I	B		1						2	4	7	26300	0.03%
01469V	B						1			4	5	6830	0.07%
01420V	B						3		2	31	36	25924	0.14%
01356V	B	2				5	19			21	47	25915	0.18%
00877V	B			7			10			13	30	47950	0.06%
00497V	B		2	6			12		13	22	55	49300	0.11%
01493V	A				13		3		5	50	71	32700	0.22%
01246V	A			4			6		7	8	25	9265	0.27%
00927V	A			4			13		5	16	38	5200	0.73%
00808I	A			7			16		2	8	33	5555	0.59%
00413V	A			4			21			24	49	48900	0.10%
00737I	A	2					4			56	62	7500	0.83%
01581V	A		1	6			15				22	25460	0.09%
Total		25	13	95	15	62	232	3	81	495	1021	919389	
% Cacat		2.4%	1.3%	9.3%	1.5%	6.1%	22.7%	0.3%	7.9%	48.5%			0.16%
% Total		0.003%	0.001%	0.010%	0.002%	0.007%	0.025%	0.000%	0.009%	0.054%	0.111%		

Lampiran 13: Tabel Kecacatan Bagian *Glue A*

OPI	Jenis Kecacatan		Jumlah Cacat	Jumlah Cacat (%)	Hasil
	Sobek Mesin	Sheet Pecah			
1474V	20		20	1.67%	1200
1383V	10		10	0.16%	6400
1383V	15		15	0.09%	17100
0845I	41		41	2.48%	1650
0843I	14		14	0.65%	2150
1462V	3		3	0.07%	4530
1400V	3		3	0.06%	5275
0839I	24		24	1.94%	1240
0859I			0	0.00%	400
0859I	5		5	0.27%	1820
0847I	14		14	0.51%	2720
1365V	5	4	9	1.50%	600
0841I	52		52	0.76%	6885
1584V	64		64	0.57%	11261
1443V	11		11	0.19%	5700
1443V	9		9	0.20%	4400
1299V	26		26	0.31%	8350
1583V	28		28	0.41%	6850
1665V	147		147	1.02%	14400
1665V	25		25	0.81%	3100
1665V	36		36	0.72%	5000
1666V	28		28	0.23%	12000
1752V	6		6	0.39%	1530
1753V	2	8	10	0.64%	1573
1642V	18		18	0.90%	2000
Total	606	12	618	0.66%	128134

Lampiran 14: Tabel Kecacatan Bagian *Glue* B

OPI	Jenis Kecacatan		Jumlah Cacat	Jumlah Cacat (%)	Hasil
	Sobek Mesin	Sheet Pecah			
0842I	21		21	0.56%	3760
0413V	30		30	0.63%	4800
1363V	31	28	59	0.36%	16500
1364V	43		43	0.50%	8550
0873V	8		8	0.05%	16680
1581V	18		18	0.35%	5150
0860I	30		30	0.49%	6100
1365V	105		105	0.22%	47100
1388V	22		22	0.13%	17060
0862I	14		14	0.27%	5140
0861I	22		22	0.44%	4980
0863I	21		21	0.45%	4680
1579V	45		45	0.55%	8240
1552V	35		35	0.36%	9600
0929I	77		77	0.29%	26650
1600V	22	2	24	0.20%	11900
0927I	9		9	0.16%	5600
1601V	104		104	0.26%	40125
1601V	18		18	0.24%	7650
1602V	121	18	139	0.41%	34275
1583V	4		4	0.29%	1375
1628V	51		51	0.28%	18000
1637V	36		36	0.80%	4480
0934I	87		87	0.24%	36000
1276V	33		33	1.03%	3200
1138V	68		68	0.49%	13880
1705V	20		20	0.26%	7565
1629V	47		47	0.51%	9200
1200V	55		55	0.21%	26420
1273V	10		10	0.17%	5980
1743V	31	12	43	0.65%	6600
1561V	20		20	0.14%	14475
Total	1258	60	1318	0.37%	431715

Lampiran 15: Tabel Kecacatan Bagian *Glue C*

OPI	Jenis Kecacatan		Jumlah Cacat	Jumlah Cacat (%)	Hasil
	Sobek Mesin	Sheet Pecah			
1356V	51	54	105	0.97%	10850
0844I	66		66	0.83%	8000
0496V	21		21	0.16%	13480
0840I	35		35	0.58%	6000
1287V	34		34	0.33%	10400
0873V	19		19	0.11%	18000
1365V	52	12	64	0.53%	12000
0291V	35		35	0.20%	17600
1388V	185		185	1.22%	15160
0929I	44		44	0.29%	15000
1678V	2		2	0.04%	5156
1677V	13		13	0.27%	4880
1676V	15		15	0.33%	4500
1600V	86	41	127	0.85%	15000
1601V	23	48	71	1.06%	6725
1602V	82	32	114	0.82%	13950
1445V	32		32	0.21%	15220
1445V	30	10	40	0.61%	6520
1141V	28		28	0.36%	7680
1610V	79		79	0.33%	24000
1140V	20		20	0.22%	9120
Total	952	197	1149	0.49%	239241

Lampiran 16: Tabel Kecacatan Bagian *Stitching*

No.OPI	Jenis Kecacatan		Jumlah Cacat	Jumlah Cacat (%)	Hasil
	Salah Stitching	Stitching Sobek			
0807I		55	55	0.37%	14920
1065I		23	23	0.08%	29900
1066I	12	30	42	0.20%	21320
1213I	5	11	16	0.31%	5236
1749V	10		10	0.26%	3892
0983I	7	12	19	0.40%	4800
1864V	15	16	31	0.20%	15500
0958I	13	62	75	0.30%	24986
1807V	9	19	28	0.24%	11440
1525V	6	3	9	0.09%	10440
1870V	25	83	108	0.22%	49560
1302I	3	3	6	0.28%	2133
1872V		3	3	0.03%	10249
1262I	15		15	0.48%	3115
1261I		7	7	0.22%	3188
1938V	23	29	52	0.17%	31229
1882V	8	26	34	1.17%	2912
1942V	6	29	35	0.34%	10211
1800V	21	38	59	1.19%	4974
1969V		20	20	0.66%	3034
01314I		12	12	0.70%	1704
1116I		37	37	1.05%	3517
1294I		20	20	0.75%	2650
1292I		25	25	0.24%	10263
1925V	13	21	34	0.07%	50380
1198V	20	78	98	0.66%	14800
1964V		74	74	0.29%	25900
1751V		25	25	0.46%	5479
1929V	18	15	33	0.33%	9965
0959I		12	12	0.08%	15393
01304I		20	20	0.95%	2110
1196V	20		20	0.06%	34650
1255I		13	13	0.12%	10560
1968V		4	4	0.64%	625
1325I		15	15	0.15%	10075
1952V	12	28	40	0.27%	14930

Lampiran 16: Tabel Kecacatan Bagian *Stitching* (sambungan)

1865V	14	35	49	0.31%	15700
1226I	8	7	15	0.15%	10190
1369I		5	5	0.10%	4987
1950V		20	20	0.05%	36560
1951V	13	59	72	0.23%	31229
1924V	18	68	86	0.17%	49980
1349I	3	5	8	0.77%	1036
1320I		7	7	0.65%	1084
1350I		4	4	0.39%	1036
1321I		5	5	0.53%	936
1258I	5		5	0.10%	5200
1257I		9	9	0.17%	5235
2008V		6	6	0.59%	1010
0910V	5	12	17	0.43%	3960
1285V	15		15	0.05%	29829
2075V	8		8	0.23%	3479
1194V	8	29	37	0.24%	15460
1354I	9		9	0.34%	2636
	367	1139	1506	0.36%	695587

Lampiran 17: Form Kontrol Kecacatan Bagian Penerimaan Rol Kertas

FORM KONTROL KECACATAN ROL KERTAS Tanggal : Pengontrol : Sopir Forklift :													
No.	Supplier	Gramatur / Lebar	Kode Rol	Diameter	Jumlah Jenis Kecacatan						Total Cacat	Total Cacat (kg)	Ket.
					Sobek				Kotor	Lain- lain			
					Capit Forklift	Potongan Terlalu Dalam	Pengungkit Besi	Tertabrak (jatuh)					
1													
2													
3													
4													
5													
6													
7													
dst.													
Mengetahui : Kepala Logistik													

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Lampiran 18: Form Kontrol Kecacatan Bagian Corrugating

FORM KONTROL KECACATAN HASIL PRODUKSI MESIN CORRUGATING H200 Tanggal : Pengontrol : Regu :															
No.	OPI	Nama Produk	Plan	Hasil	Jumlah Jenis Kecacatan									Total Cacat	Ket.
					Melintir	Meringis	Mengelupas	Gel.Pecah	Basah	Sobek (nekok)	Ukuran T. Sama	Creasing T. Ada	Lain- lain		
1															
2															
3															
dst.															
Mengetahui : Kepala Regu															

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Lampiran 19: Form Kontrol Kecacatan Bagian Flexo

FORM KONTROL KECACATAN HASIL PRODUKSI MESIN FLEXO A / B / C Tanggal : Pengontrol : Regu :																	
No.	OPI	Nama Produk	Plan	Hasil	Jumlah Jenis Kecacatan											Total Cacat	Ket.
					Sobek	Sheet Rusak	Creasing Pecah	Printing Jembret	Warna T. Sama	Printing Kabur	Printing Lari	Printing Terbalik	Printing, Slotter Miring	Slotter Lari	Lain- lain		
1																	
2																	
dst.																	
Mengetahui : Kepala Regu Kepala Mesin																	

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Lampiran 20: Form Kontrol Kecacatan Bagian Glue

FORM KONTROL KECACATAN HASIL PRODUKSI MESIN GLUE A / B / C Tanggal : Pengontrol : Regu :															
No.	OPI	Nama Produk	Plan	Hasil	Jumlah Kecacatan									Total Cacat	Ket.
					Sobek Mesin	Sobek Jatuh	Sobek Palet	Mengelupas	Sloter Lari	Printing Lari	Printing Jembret	Meringis/ Melintir	Lain-lain		
1															
2															
3															
dst.															
Mengetahui : Kepala Regu Kepala Mesin															

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Lampiran 21: Form Kontrol Kecacatan Bagian *Stitching*

FORM KONTROL KECACATAN HASIL PRODUKSI MESIN STITCHING Tanggal : Pengontrol : Regu :																
No.	OPI	Nama Produk	Plan	Hasil	Jumlah Kecacatan										Total Cacat	Ket.
					Salah Stitching	Sobek Stitching	Sobek Jatuh	Sobek Palet	Mengelupas	Sloter Lari	Printing Lari	Printing Jembret	Meringis/ Melintir	Lain lain		
1																
2																
3																
dst.																
Mengetahui : Kepala Regu Kepala Mesin																

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