

LAMPIRAN

Lampiran 1 : Dokumentasi Perusahaan

Mesin *Carding*



Sliver Carding



Lampiran 2 : Data Jumlah Kecacatan Sliver Periode April 2021

Contoh perhitungan persentase kecacatan mesin 1 pada *shift* pagi tanggal 1:

d : Jumlah cacat per mesin

n : Jumlah sampel per mesin

$$\begin{aligned} p &= \frac{d}{n} \times 100\% \\ &= \frac{1}{12} \times 100\% \\ &= 8\% \end{aligned}$$

Contoh perhitungan persentase kecacatan mesin 1 pada *shift* pagi selama satu bulan:

$\sum d$: Akumulasi jumlah cacat per mesin satu bulan

$\sum n$: Akumulasi jumlah sampel per mesin satu bulan

$$\begin{aligned} p &= \frac{\sum d}{\sum n} \\ &= \frac{31}{348} \times 100\% \\ &= 9\% \end{aligned}$$

Data dan persentase Kecacatan Sliver *Shift* Pagi

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
1	Cotton Polyester (30/70)	Sliver Terlalu Tebal	Pagi 1	0	0	1	0	0	0	0	1	0	0	0	0	1	
			Pagi 2	0	0	0	1	0	0	0	0	0	1	0	1	0	
		Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	0	1	0	0	0	0	0
			Pagi 2	0	0	0	0	1	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Pagi 1	1	0	0	0	0	1	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	0	0	1	0	0	0
			Pagi 2	0	0	0	1	0	0	1	0	0	0	0	0	0	0
		Total				1	1	1	2	1	1	2	1	1	1	1	1
		P				8%	8%	8%	17%	8%	8%	17%	8%	8%	8%	8%	8%
2	Cotton Polyester (30/70)	Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	0	0	0	0	1	0		
			Pagi 2	0	0	0	0	0	1	0	0	1	0	0	0		
		Sliver Terlalu Tipis	Pagi 1	1	0	0	0	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	1	
		Sliver Bergelombang	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	0	
			Pagi 2	1	0	0	0	0	1	0	0	0	0	0	0	0	
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	1	1	0	0	0	0	0	
			Pagi 2	0	0	0	1	0	0	0	0	0	1	0	0	0	
		Total				2	0	1	1	0	2	1	1	1	1	1	
		P				17%	0%	8%	8%	0%	17%	8%	8%	8%	8%	8%	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
3		Sliver Terlalu Tebal	Pagi 1	1	0	0	0	0	0	0	0	1	1	0	0		
			Pagi 2	0	0	1	0	1	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	1	0	0	0	0	0	
		Sliver Bergelombang	Pagi 1	0	0	0	1	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	1	0	0	0	0	0	0	
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	1	0	0	0	0	0	
		Total			1	1	1	1	1	1	1	2	0	1	1	0	0
		P			8%	8%	8%	8%	8%	8%	17%	0%	8%	8%	0%	0%	
4		Sliver Terlalu Tebal	Pagi 1	1	1	0	0	0	0	0	0	0	0	1	0		
			Pagi 2	0	0	0	1	0	1	0	0	0	0	0	0		
		Sliver Terlalu Tipis	Pagi 1	0	0	1	0	1	0	0	0	0	1	0	0		
			Pagi 2	0	0	0	0	0	0	0	0	1	0	0	1		
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	1	0	0	0	0		
			Pagi 2	0	1	0	0	0	0	0	0	0	1	0	1	0	
		Sliver Kotor	Pagi 1	0	0	1	0	0	1	0	0	0	0	0	0		
			Pagi 2	1	0	0	0	0	0	0	0	0	1	0	0	1	
		Total			2	2	2	1	1	2	1	1	2	1	2	2	
		P			17%	17%	17%	8%	8%	17%	8%	8%	17%	8%	17%	17%	
5		Sliver Terlalu Tebal	Pagi 1	1	0	0	0	0	0	0	0	0	0	0			
			Pagi 2	0	0	0	1	0	0	0	0	1	0	0	0		

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin														
				1	2	3	4	5	6	7	8	9	10	11	12			
6	Cotton Polyester (20/80)	Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0			
			Pagi 2	0	0	0	0	1	0	0	0	1	0	0	0			
		Sliver Bergelombang	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0	0		
			Pagi 2	0	0	0	0	1	0	0	0	0	0	0	0	0		
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	1	0	0	0	0		
			Pagi 2	0	0	0	0	0	0	0	1	0	0	0	0	1		
		Total			1	2	0	1	2	0	1	1	2	0	0	1		
		P			8%	17%	0%	8%	17%	0%	8%	8%	17%	0%	0%	8%		
		7	Cotton Polyester (20/80)	Sliver Terlalu Tebal	Pagi 1	1	1	0	1	0	0	0	0	0	1	0	0	
					Pagi 2	0	0	0	0	0	1	1	0	1	0	0	0	
				Sliver Terlalu Tipis	Pagi 1	0	0	0	0	1	0	0	0	0	0	1	0	
					Pagi 2	0	0	0	0	0	0	0	0	1	0	0	1	0
				Sliver Bergelombang	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	0
					Pagi 2	0	0	0	0	1	0	0	0	0	0	1	0	0
Sliver Kotor	Pagi 1			1	1	0	0	0	0	0	0	0	0	0	1	0		
	Pagi 2			0	0	0	0	0	0	0	0	1	0	0	0	0		
Total			2	2	1	1	2	1	1	1	2	1	2	3	0			
P			17%	17%	8%	8%	17%	8%	8%	17%	8%	17%	25%	0				
7	Cotton Polyester (20/80)	Sliver Terlalu Tebal	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0			
			Pagi 2	0	0	0	0	1	0	0	1	0	0	0	1			
		Sliver Terlalu Tipis	Pagi 1	1	0	0	1	0	0	1	0	0	0	0	0			
			Pagi 2	0	0	0	0	0	0	0	0	1	1	0	0			

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin														
				1	2	3	4	5	6	7	8	9	10	11	12			
		Sliver Bergelombang	Pagi 1	1	0	0	0	0	0	0	0	0	0	0	0			
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0			
		Sliver Kotor	Pagi 1	0	0	0	0	1	0	0	0	0	0	0	0	1		
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0		
		Total			2	0	1	1	2	0	1	1	1	1	0	2		
		P			17%	0%	8%	8%	17%	0%	8%	8%	8%	8%	0%	17%		
		8		Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	0	1	1	0	0	0	
					Pagi 2	1	0	0	0	1	0	0	0	0	0	0	0	
				Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0	1
					Pagi 2	0	0	0	0	0	0	0	1	0	0	0	0	0
				Sliver Bergelombang	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	0
					Pagi 2	0	0	0	0	1	0	0	0	0	0	0	0	0
				Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	1	0
Pagi 2	0				0	0	1	0	0	0	0	0	1	0	0	0		
Total				1	1	1	1	2	0	1	1	2	0	1	1			
P				8%	8%	8%	8%	17%	0%	8%	8%	17%	0%	8%	8%			
9		Sliver Terlalu Tebal	Pagi 1	0	0	1	0	1	0	0	0	0	0	0	0			
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0			
		Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0	0		
			Pagi 2	0	0	0	1	0	1	0	0	0	0	0	0	0		
		Sliver Bergelombang	Pagi 1	1	0	0	0	0	0	0	0	1	0	0	0	0		
			Pagi 2	0	0	0	0	0	0	0	1	0	1	0	0	0		

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
		Sliver Kotor	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	0	1	0	0	0	
		Total			1	1	2	1	1	1	1	1	2	0	0	0
		P			8%	8%	17%	8%	8%	8%	8%	8%	17%	0%	0%	0%
		10	Cotton Polyester (40/60)	Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	0	0	1	0	0
Pagi 2	0				1	0	0	0	0	1	0	0	0	1	1	
Sliver Terlalu Tipis	Pagi 1			0	0	0	0	1	1	0	0	0	0	0	0	0
	Pagi 2			0	0	1	0	0	0	0	0	0	0	0	0	0
Sliver Bergelombang	Pagi 1			0	1	0	0	0	0	0	0	0	0	0	0	0
	Pagi 2			0	0	0	1	0	0	0	0	0	0	0	0	0
Sliver Kotor	Pagi 1			0	0	0	0	0	0	1	0	0	0	1	0	0
	Pagi 2			0	0	0	0	0	0	0	0	0	0	0	0	1
Total				0	2	1	1	1	1	2	0	1	0	2	2	
P				0	17%	8%	8%	8%	8%	17%	0%	8%	0%	17%	17%	
11	Cotton Polyester (40/60)	Sliver Terlalu Tebal	Pagi 1	0	0	1	0	0	1	0	1	0	0	0	0	
			Pagi 2	1	0	0	0	0	0	0	0	1	0	1	0	
		Sliver Terlalu Tipis	Pagi 1	0	0	1	0	0	0	0	0	0	1	0	0	0
			Pagi 2	1	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	1
		Sliver Kotor	Pagi 1	0	1	0	0	1	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	1	1	0	0	0

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
12		Total		2	1	2	0	1	1	0	1	2	2	1	1	
		P		17%	8%	17%	0%	8%	8%	0%	8%	17%	17%	8%	8%	
		Sliver Terlalu Tebal	Pagi 1	1	0	0	1	0	1	1	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	1	0	0	0	0	0
			Pagi 2	0	0	0	0	1	0	1	0	0	0	0	0	0
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	0	0	1	1	0	0
			Pagi 2	0	0	0	1	0	0	0	0	0	0	0	0	0
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	0	1
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0
Total		1	1	0	2	1	1	2	1	0	1	1	1	1		
P		8%	8%	0%	17%	8%	8%	17%	8%	0%	8%	8%	8%	8%		
13	Polyester Rayon (65/35)	Sliver Terlalu Tebal	Pagi 1	0	0	0	1	0	1	0	1	0	0	0	0	
			Pagi 2	0	1	0	0	0	0	0	0	1	0	0	0	
		Sliver Terlalu Tipis	Pagi 1	0	0	1	0	1	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Pagi 1	1	0	0	0	0	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	1
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	1	0	0	0	0
			Pagi 2	0	1	0	0	0	0	0	0	0	0	0	0	1
		Total		1	2	1	1	1	1	0	1	2	0	0	0	2
		P		8%	17%	8%	8%	8%	8%	0%	8%	17%	0%	0%	0%	17%

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
14		Sliver Terlalu Tebal	Pagi 1	1	1	0	0	0	1	0	0	1	0	0	0	
			Pagi 2	0	0	0	1	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	1	0	0	0	0	0	0	0
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	0	1	0	1	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	1	
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	1	0	0	0	0	0	
			Pagi 2	0	0	0	0	1	0	0	0	0	0	0	0	
		Total		1	1	1	1	1	2	1	0	2	0	1	1	
		P		8%	8%	8%	8%	8%	17%	8%	0%	17%	0%	8%	8%	
15		Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	1	0	0	0	1		
			Pagi 2	0	1	0	1	1	0	0	0	0	0	0		
		Sliver Terlalu Tipis	Pagi 1	0	0	0	0	0	0	0	0	0	1	0	0	
			Pagi 2	0	0	0	0	0	0	1	1	0	0	0	0	
		Sliver Bergelombang	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Kotor	Pagi 1	0	0	0	1	0	0	0	0	0	0	1	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Total		0	1	1	2	1	0	2	1	0	1	1	1	
		P		0%	8%	8%	17%	8%	0%	17%	8%	0%	8%	8%	8%	
16		Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	1	0	0	0	0	0		
			Pagi 2	1	1	0	0	0	0	0	1	0	1	0	1	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
		Sliver Kotor	Pagi 1	1	0	0	0	0	0	0	0	0	0	1	0		
			Pagi 2	0	0	0	0	0	0	0	0	0	0	1	0		
		Total			2	1	1	0	1	1	1	0	0	1	2	1	
		P			17%	8%	8%	0%	8%	8%	8%	0%	0%	8%	17%	8%	
21	Polyester Rayon (20/30)	Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	0	1	0	0	1	0	0	
			Pagi 2	0	0	1	0	0	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	1	0	0	0	0	0	0	
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	0	0	1	0	0	0	
			Pagi 2	0	0	0	0	1	0	0	0	0	0	0	0	0	
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	1	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	1	0	
Total			0	0	1	0	1	1	1	0	1	1	2	0			
P			0%	0%	8%	0%	8%	8%	8%	0%	8%	8%	17%	0%			
22		Polyester Rayon (20/30)	Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	0	0	0	0	1	0	
				Pagi 2	1	0	1	1	0	0	0	0	0	0	0	0	
			Sliver Terlalu Tipis	Pagi 1	0	0	0	0	1	0	0	0	0	0	0	0	1
				Pagi 2	0	0	0	0	0	0	0	0	0	1	0	0	0
	Sliver Bergelombang		Pagi 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	1	0	0	0	0	0	0	0	0	0	
	Sliver Kotor		Pagi 1	0	0	0	0	0	0	0	1	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	0	1	0	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
23		Total		1	0	1	2	1	0	1	1	1	0	1	1	
		P		8%	0%	8%	17%	8%	0%	8%	8%	8%	0%	8%	8%	
		Sliver Terlalu Tebal	Pagi 1	0	0	0	1	0	1	0	0	0	0	0	0	1
			Pagi 2	1	1	0	0	0	0	0	0	0	1	0	0	0
		Sliver Terlalu Tipis	Pagi 1	0	0	0	0	0	1	0	0	0	0	0	1	0
			Pagi 2	0	0	1	0	0	1	0	0	0	0	0	0	0
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	1	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Kotor	Pagi 1	0	0	1	0	0	0	0	1	0	0	0	0	0
			Pagi 2	0	0	0	0	1	0	0	1	0	0	0	0	0
Total		1	1	2	1	1	3	0	2	1	0	2	1			
P		8%	8%	17%	8%	8%	25%	0%	17%	8%	0%	17%	8%			
24	Polyester (100)	Sliver Terlalu Tebal	Pagi 1	0	0	0	0	0	0	0	0	0	1	0	0	
			Pagi 2	0	0	1	0	0	0	1	0	0	0	0	0	
		Sliver Terlalu Tipis	Pagi 1	0	0	0	0	0	1	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	1	0	
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	1	0	0	1	0	0	
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Kotor	Pagi 1	0	0	0	1	0	0	0	0	0	0	0	0	
			Pagi 2	0	0	0	0	0	1	0	0	0	0	1	0	
		Total		0	0	1	1	0	2	2	0	0	2	2	0	
		P		0%	0%	8%	8%	0%	17%	17%	0%	0%	17%	17%	0%	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
25		Sliver Terlalu Tebal	Pagi 1	1	0	0	1	0	0	0	0	1	1	0	0	
			Pagi 2	0	0	0	0	0	0	0	1	0	0	0	0	0
		Sliver Terlalu Tipis	Pagi 1	0	0	0	0	0	0	1	0	0	0	0	0	0
			Pagi 2	1	0	0	0	0	0	0	1	0	0	0	1	0
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	1	0	0	0	0
		Sliver Kotor	Pagi 1	0	0	1	0	0	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Total			2	0	1	1	0	1	2	1	1	1	1	0
		P			17%	0%	8%	8%	0%	8%	17%	8%	8%	8%	8%	0%
26	Cotton (100)	Sliver Terlalu Tebal	Pagi 1	1	0	1	0	0	0	0	0	0	0	1	0	
			Pagi 2	0	0	0	1	1	0	0	1	0	0	0	0	
		Sliver Terlalu Tipis	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0	1
			Pagi 2	0	0	0	0	0	0	1	0	0	0	1	0	0
		Sliver Bergelombang	Pagi 1	0	1	0	0	0	0	0	0	0	0	0	0	0
			Pagi 2	0	0	0	0	0	1	0	1	0	0	0	0	0
		Sliver Kotor	Pagi 1	0	0	0	0	0	0	0	0	0	0	1	0	0
			Pagi 2	0	0	0	0	0	0	0	0	1	0	0	0	0
		Total			1	2	1	1	2	1	1	2	0	2	1	1
		P			8%	17%	8%	8%	17%	8%	8%	17%	0%	17%	8%	8%
27		Sliver Terlalu Tebal	Pagi 1	0	0	0	1	0	0	0	1	0	0	0	0	
			Pagi 2	1	1	0	0	0	1	0	0	0	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
		Sliver Bergelombang	Pagi 1	0	0	0	0	0	0	0	1	0	0	0	0	
			Pagi 2	0	0	0	0	1	0	0	0	0	1	0	0	
		Sliver Kotor	Pagi 1	0	1	0	1	0	0	1	0	0	0	0	0	1
			Pagi 2	0	0	0	0	0	0	0	0	0	0	1	0	0
		Total	0	2	1	2	1	0	2	1	0	4	1	1		
		P	0%	17%	8%	17%	8%	0%	17%	8%	0%	33%	8%	8%		
Jumlah Kecacatan Per Mesin				31	33	29	34	29	29	33	29	29	29	32	29	
Persentase Kecacatan Per Mesin				9%	9%	8%	10%	8%	8%	9%	8%	8%	8%	9%	8%	

Data dan persentase Kecacatan Sliver *Shift Siang*

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin											
				1	2	3	4	5	6	7	8	9	10	11	12
1	Cotton Polyester (30/70)	Sliver Terlalu Tebal	Siang 1	0	0	0	0	0	0	0	0	1	0	0	0
			Siang 2	0	0	1	0	0	1	1	0	0	0	0	0
		Sliver Terlalu Tipis	Siang 1	0	0	0	1	0	0	0	0	0	0	0	0
			Siang 2	0	0	0	0	0	1	0	0	0	0	0	0
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Kotor	Siang 1	0	0	1	0	0	0	0	0	1	1	0	0
			Siang 2	0	0	0	0	1	0	0	0	0	0	0	0

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
2		Total		0	0	2	1	1	2	1	0	2	1	0	0	
		P		0%	0%	17%	8%	8%	17%	8%	0%	17%	8%	0%	0%	
		Sliver Terlalu Tebal	Siang 1	0	1	0	0	0	0	0	0	0	0	0	0	0
			Siang 2	0	0	0	1	0	0	0	0	0	0	1	0	0
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	1	0	0	0	0	0
			Siang 2	0	1	0	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Siang 1	1	0	0	0	0	0	0	0	0	1	0	0	0
			Siang 2	0	0	0	1	1	0	0	0	0	0	0	0	0
		Sliver Kotor	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	0
			Siang 2	0	0	0	0	0	0	1	0	0	0	0	0	1
Total		1	2	0	2	1	0	1	1	0	2	0	1			
P		8%	17%	0%	17%	8%	0%	8%	8%	0%	17%	0%	8%			
3		Sliver Terlalu Tebal	Siang 1	0	0	0	0	0	1	0	0	0	1	0		
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	1	0	0	0	0	0	0	0	
			Siang 2	0	0	0	0	0	0	1	0	0	0	0	1	
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	0	1	0	0	0	
			Siang 2	0	0	1	0	0	0	0	0	0	0	0	0	
		Sliver Kotor	Siang 1	0	0	0	0	0	0	1	0	0	0	0	1	
			Siang 2	1	0	0	0	0	0	0	0	0	0	0	0	
		Total		1	0	1	0	1	1	2	0	1	0	1	2	
		P		8%	0%	8%	0%	8%	8%	17%	0%	8%	0%	8%	17%	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin														
				1	2	3	4	5	6	7	8	9	10	11	12			
		Sliver Kotor	Siang 1	0	0	0	0	0	0	0	0	1	0	0	0	0		
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0	1	
		Total		0	1	2	0	0	0	2	1	2	0	0	0	1		
		P		0%	8%	17%	0%	0%	0%	17%	8%	17%	0%	0%	0%	8%		
		11		Sliver Terlalu Tebal	Siang 1	1	0	0	0	0	0	0	0	1	0	1	0	
					Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0
				Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	0	0	0	0	1	0
					Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0
				Sliver Bergelombang	Siang 1	0	0	0	0	1	0	0	1	0	0	0	0	0
					Siang 2	0	0	1	0	1	0	0	0	0	0	0	0	0
Sliver Kotor	Siang 1			0	0	0	0	0	0	0	0	1	1	0	0			
	Siang 2			0	0	0	0	0	0	0	0	0	0	0	0	0		
Total				1	0	1	0	2	0	0	1	2	1	2	0			
P				8%	0%	8%	0%	17%	0%	0%	8%	17%	8%	17%	0%			
12		Sliver Terlalu Tebal	Siang 1	0	0	0	0	0	0	0	0	0	0	1	0			
			Siang 2	0	1	1	0	0	0	0	0	0	0	0	0	0		
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	0	0	1	1	0			
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0			
		Sliver Bergelombang	Siang 1	0	0	0	0	0	1	0	0	0	0	0	0			
			Siang 2	1	0	0	0	0	0	0	0	0	0	0	0			
		Sliver Kotor	Siang 1	0	0	0	1	0	0	0	0	0	0	0	0			
			Siang 2	0	0	0	1	0	0	0	1	0	0	0	0			

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
		Total		1	1	1	2	0	1	0	1	0	1	2	0	
		P		8%	8%	8%	17%	0%	8%	0%	8%	0%	8%	17%	0%	
13	<i>Polyester Rayon (65/35)</i>	Sliver Terlalu Tebal	Siang 1	0	0	0	0	0	0	0	0	0	1	1	0	
			Siang 2	0	0	0	1	0	1	1	0	0	0	0	0	0
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	0
			Siang 2	0	1	0	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	0	0	0	1	0	0
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Kotor	Siang 1	0	0	0	0	0	0	1	0	0	0	0	0	0
			Siang 2	0	0	0	1	0	0	0	0	0	0	0	0	0
		Total		0	1	0	2	0	1	2	0	0	2	1	0	
		P		0%	8%	0%	17%	0%	8%	17%	0%	0%	17%	8%	0%	
14		<i>Polyester Rayon (65/35)</i>	Sliver Terlalu Tebal	Siang 1	0	0	0	0	1	0	0	0	0	0	0	
				Siang 2	0	0	0	0	0	0	0	0	0	0	0	0
			Sliver Terlalu Tipis	Siang 1	0	0	1	0	0	0	0	0	1	0	0	0
				Siang 2	0	0	0	0	0	1	0	0	1	0	0	0
			Sliver Bergelombang	Siang 1	0	1	0	0	0	0	0	0	0	0	0	0
				Siang 2	0	0	0	1	0	0	0	0	0	1	0	0
			Sliver Kotor	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0
				Siang 2	0	0	0	0	0	0	0	0	0	1	0	0
	Total			0	1	1	1	1	1	0	0	2	2	0	0	
	P			0%	8%	8%	8%	8%	8%	0%	0%	17%	17%	0%	0%	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin											
				1	2	3	4	5	6	7	8	9	10	11	12
15		Sliver Terlalu Tebal	Siang 1	0	0	0	0	1	0	0	0	0	0	0	0
			Siang 2	0	1	0	0	0	0	0	0	0	0	0	0
		Sliver Terlalu Tipis	Siang 1	0	0	0	1	0	0	0	1	0	0	0	0
			Siang 2	0	0	0	0	0	0	1	0	0	0	0	0
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	0	1	0	0	0
			Siang 2	0	0	0	0	1	0	0	0	0	0	0	1
		Sliver Kotor	Siang 1	1	0	0	0	0	0	0	0	0	0	1	0
			Siang 2	0	0	0	0	0	0	1	0	0	0	0	0
		Total		1	1	0	1	2	0	2	1	1	0	1	1
		P		8%	8%	0%	8%	17%	0%	17%	8%	8%	0%	8%	8%
16		Sliver Terlalu Tebal	Siang 1	0	0	0	0	1	0	0	1	0	0	0	
			Siang 2	0	0	1	0	0	0	0	0	0	0	0	1
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	1	0	0	1	0
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	1	0	0	0	0
			Siang 2	0	0	0	0	0	1	0	0	0	0	0	0
		Sliver Kotor	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0
			Siang 2	0	0	0	0	0	0	0	0	0	1	0	0
		Total		0	0	1	0	1	1	0	3	0	1	1	1
		P		0%	0%	8%	0%	8%	8%	0%	25%	0%	8%	8%	8%
17		Sliver Terlalu Tebal	Siang 1	0	1	0	0	0	0	1	0	0	0	0	
			Siang 2	0	0	0	0	0	0	1	0	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
		Total		1	1	2	0	1	1	0	0	2	0	1	1		
		P		8%	8%	17%	0%	8%	8%	0%	0%	17%	0%	8%	8%		
24	Polyester (100)	Sliver Terlalu Tebal	Siang 1	0	1	1	0	0	0	0	1	0	0	0	0		
			Siang 2	0	1	0	0	0	1	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Siang 2	0	0	0	0	1	0	0	0	0	1	0	0	0	
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Siang 2	0	0	1	0	0	0	0	1	0	0	0	0	0	
		Sliver Kotor	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	1	
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0	
				Total		0	2	2	0	1	1	0	2	0	1	0	1
				P		0%	17%	17%	0%	8%	8%	0%	17%	0%	8%	0%	8%
25	Polyester (100)	Sliver Terlalu Tebal	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0		
			Siang 2	0	1	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	0	0	0	0	1	0	0	0	
			Siang 2	0	0	0	0	0	1	0	0	0	0	0	0	0	
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Kotor	Siang 1	0	0	1	0	0	0	0	1	0	0	0	0	1	
			Siang 2	0	0	0	0	0	0	0	1	0	0	0	0	0	
				Total		0	1	1	0	0	1	0	2	0	1	0	1
				P		0%	8%	8%	0%	0%	8%	0%	17%	0%	8%	0%	8%

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
29		Sliver Terlalu Tipis	Siang 1	1	0	0	0	0	0	0	0	0	0	0	0	0
			Siang 2	1	0	0	0	0	0	0	0	0	0	0	1	0
		Sliver Bergelombang	Siang 1	0	0	0	0	0	1	0	0	0	0	0	0	0
			Siang 2	0	0	0	0	0	1	0	0	0	0	0	0	0
		Sliver Kotor	Siang 1	0	0	1	0	0	0	0	1	1	0	0	0	0
			Siang 2	0	0	0	0	1	0	0	0	0	0	0	0	0
		Total			2	0	1	0	1	3	0	1	1	0	1	0
		P			17%	0%	8%	0%	8%	25%	0%	8%	8%	0%	8%	0%
		Sliver Terlalu Tebal	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	1
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Terlalu Tipis	Siang 1	0	0	0	0	0	1	0	0	0	0	0	0	0
			Siang 2	1	0	0	1	0	1	0	0	0	0	0	0	0
		Sliver Bergelombang	Siang 1	0	0	0	0	0	0	1	0	0	0	0	0	0
			Siang 2	0	0	0	0	0	0	0	0	0	0	0	0	0
Sliver Kotor	Siang 1	0	0	0	0	0	0	0	0	0	0	0	0	1		
	Siang 2	0	0	0	0	0	0	0	0	0	1	1	0	0		
Total			1	0	0	1	0	2	1	0	1	1	0	2		
P			8%	0%	0%	8%	0%	17%	8%	0%	8%	8%	0%	17%		
Jumlah Kecacatan Per Mesin				22	25	25	22	24	23	23	22	24	23	22	23	
Persentase Kecacatan Per Mesin				6%	7%	7%	6%	7%	7%	7%	6%	7%	7%	6%	7%	

Data dan persentase Kecacatan Sliver *Shift* Malam

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
1	Cotton Polyester (30/70)	Sliver Terlalu Tebal	Malam 1	0	2	0	0	0	0	0	0	1	1	0	0		
			Malam 2	0	0	0	1	0	0	2	0	0	0	0	0		
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	1	0	0	0	0	0	0	1	2	
			Malam 2	1	0	0	0	1	0	0	1	0	0	0	0	0	
		Sliver Bergelombang	Malam 1	0	0	1	0	0	0	0	0	0	0	0	1	0	
			Malam 2	0	0	0	0	0	0	1	0	0	0	0	0	0	
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	1	0	0	0	0	0	
			Malam 2	0	1	1	0	0	0	0	0	0	0	0	0	0	
		Total				1	3	2	1	2	0	3	2	1	1	2	2
		P				8%	25%	17%	8%	17%	0%	25%	17%	8%	8%	17%	17%
2		Cotton Polyester (30/70)	Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	2	0	0	1	0	1	0	
				Malam 2	0	1	0	0	0	1	0	0	0	0	0	0	
			Sliver Terlalu Tipis	Malam 1	0	0	2	0	0	0	0	0	0	0	0	0	0
				Malam 2	0	0	1	0	0	0	0	0	0	1	0	0	
			Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	1	0	0	0	
				Malam 2	1	0	0	0	1	0	0	0	0	1	0	0	
			Sliver Kotor	Malam 1	1	0	0	0	0	0	1	0	0	0	0	0	
				Malam 2	0	0	0	0	0	0	1	0	0	0	0	1	
	Total				2	1	3	0	1	3	2	0	2	2	1	1	
	P				17%	8%	25%	0%	8%	25%	17%	0%	17%	17%	8%	8%	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
3		Sliver Terlalu Tebal	Malam 1	0	1	0	0	0	0	0	0	0	0	1	0	
			Malam 2	0	0	0	0	1	0	0	0	1	0	0	0	
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	1	0	0	0	0	0	0	0
			Malam 2	0	0	1	0	1	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	2
			Malam 2	0	0	0	1	0	0	0	0	1	1	0	0	
		Sliver Kotor	Malam 1	2	0	0	1	0	0	0	0	0	0	1	0	
			Malam 2	0	0	0	0	0	0	1	2	0	0	0	0	
Total			2	1	1	2	2	1	1	2	2	1	2	2		
P			17%	8%	8%	17%	17%	8%	8%	17%	17%	8%	17%	17%		
4		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	2	0	0	0	0	1	0	
			Malam 2	0	1	0	0	0	0	0	1	0	0	1	0	
		Sliver Terlalu Tipis	Malam 1	0	0	1	0	0	0	0	0	1	0	0	0	
			Malam 2	0	0	0	2	0	0	1	0	0	1	0	0	
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	1	0	0	0	1	0	0	0	0	0	0	0	
		Sliver Kotor	Malam 1	0	1	0	0	0	0	0	0	0	0	1	0	
			Malam 2	0	1	0	0	0	0	0	0	0	0	0	1	
Total			1	3	1	2	1	2	1	1	1	1	3	1		
P			8%	25%	8%	17%	8%	17%	8%	8%	8%	8%	25%	8%		
5		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	0	1	0	2	0	
			Malam 2	0	3	0	0	0	1	0	0	0	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
		Sliver Terlalu Tipis	Malam 1	0	0	2	0	0	0	0	0	0	0	0	0		
			Malam 2	0	0	0	0	0	0	0	0	1	0	1	0	0	
		Sliver Bergelombang	Malam 1	1	0	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	1	
		Sliver Kotor	Malam 1	0	0	0	2	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	1	0	1	0	0	0	0	0	0	
		Total				1	3	2	2	1	1	1	1	1	1	2	1
		P				8%	25%	17%	17%	8%	8%	8%	8%	8%	8%	17%	8%
		6	Cotton Polyester (20/80)	Sliver Terlalu Tebal	Malam 1	2	0	0	0	0	0	0	0	0	0	0	1
					Malam 2	0	0	0	0	0	2	0	0	1	0	0	0
Sliver Terlalu Tipis	Malam 1			0	2	0	0	0	0	0	0	0	1	0	0	0	
	Malam 2			0	0	0	0	2	0	0	0	0	0	0	0	0	
Sliver Bergelombang	Malam 1			0	0	0	1	0	0	0	1	0	0	0	0	0	
	Malam 2			0	0	0	0	0	0	0	0	0	0	1	0	0	
Sliver Kotor	Malam 1			0	0	1	0	0	0	0	0	0	0	0	0	0	
	Malam 2			0	0	0	0	0	0	2	0	0	0	0	0	0	
Total				2	2	1	1	2	2	2	1	1	1	1	1		
P				17%	17%	8%	8%	17%	17%	17%	8%	8%	8%	8%	8%		
7		Sliver Terlalu Tebal	Malam 1	0	0	1	0	0	0	0	0	0	1	0	2		
			Malam 2	0	0	1	0	0	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Malam 1	2	0	0	0	0	1	0	0	0	0	0	0	0	
			Malam 2	0	1	0	0	0	0	0	0	0	1	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
		Sliver Bergelombang	Malam 1	0	0	0	1	0	0	2	0	0	0	0	0		
			Malam 2	0	0	0	0	0	0	0	0	0	0	1	0		
		Sliver Kotor	Malam 1	0	0	0	0	0	0	2	1	0	0	1	0		
			Malam 2	0	0	0	0	1	0	0	0	0	0	0	0		
		Total				2	1	2	1	1	1	4	1	1	1	2	2
		P				17%	8%	17%	8%	8%	8%	33%	8%	8%	8%	17%	17%
		8		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	1	1	2	0	0
Malam 2	0				3	0	0	1	0	0	0	0	0	0	0	0	
Sliver Terlalu Tipis	Malam 1			0	0	0	0	0	2	0	0	0	0	0	0	0	
	Malam 2			0	0	0	0	0	0	0	0	0	0	1	1		
Sliver Bergelombang	Malam 1			1	0	1	1	0	0	0	0	0	0	0	0	0	
	Malam 2			0	0	0	0	0	0	1	0	0	0	0	0	0	
Sliver Kotor	Malam 1			2	0	0	0	0	0	0	0	0	0	0	0	0	
	Malam 2	0	0	0	0	0	0	0	0	1	0	0	0	2			
Total				3	3	1	1	1	2	1	1	2	2	1	3		
P				25%	25%	8%	8%	8%	17%	8%	8%	17%	17%	8%	25%		
9		Sliver Terlalu Tebal	Malam 1	0	0	2	0	0	0	0	0	0	1	0	0		
			Malam 2	0	1	0	0	0	0	1	0	0	0	0	0		
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	1	0	0	0	0		
			Malam 2	2	0	0	1	1	0	0	0	0	1	0	0		
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	1	0		
Malam 2	0		0	0	0	0	0	0	0	1	0	0	0				

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
		Total		2	1	2	2	2	1	1	2	1	1	1	2		
		P		17%	8%	17%	17%	17%	8%	8%	17%	8%	8%	8%	17%		
12		Sliver Terlalu Tebal	Malam 1	0	1	1	0	0	0	0	0	0	0	0	0	1	
			Malam 2	0	0	0	0	0	0	0	1	0	0	0	0	0	0
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	0	0	0	2	0	0	0
			Malam 2	1	0	0	0	2	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Malam 1	0	0	0	1	0	0	0	0	0	0	0	0	0	0
			Malam 2	0	0	0	0	0	1	0	1	1	1	0	0	0	0
		Sliver Kotor	Malam 1	0	0	0	0	1	0	0	0	0	0	0	2	0	0
			Malam 2	0	0	0	0	0	0	1	0	0	0	0	0	0	0
				Total		1	1	1	1	3	1	2	1	1	2	2	1
		P		8%	8%	8%	8%	25%	8%	17%	8%	8%	17%	17%	8%		
13	Polyester Rayon (65/35)	Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	1	0	0	1	0		
			Malam 2	1	0	0	1	0	0	0	0	0	0	0	0	0	
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	1	0	0	0	0	2	0	0	
			Malam 2	0	0	1	0	0	0	0	0	0	0	0	0	1	
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	1	0	1	0	0	0	0	
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	1	0	
		Sliver Kotor	Malam 1	0	1	0	0	1	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	2	
				Total		1	1	1	1	1	1	1	1	1	2	2	3
		P		8%	8%	8%	8%	8%	8%	8%	8%	8%	17%	17%	25%		

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin											
				1	2	3	4	5	6	7	8	9	10	11	12
14		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	0	0	0	0	1
			Malam 2	2	0	2	0	0	1	0	0	1	0	0	0
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	1	0	0	0	0	0
			Malam 2	0	1	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	1	1	0
			Malam 2	0	0	0	1	0	0	0	0	0	0	0	0
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	1	0	0	0	0
			Malam 2	0	0	0	0	1	0	0	0	0	0	0	0
Total				2	1	2	1	1	1	1	1	1	1	1	
P				17%	8%	17%	8%	8%	8%	8%	8%	8%	8%	8%	
15		Sliver Terlalu Tebal	Malam 1	2	0	1	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	1	1	0	0	1	0	0	
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	0	0	0	0	1
			Malam 2	0	1	0	1	0	0	0	0	0	1	0	0
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0
			Malam 2	0	0	0	0	0	0	1	1	0	0	0	0
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	0	0	0	1	0
			Malam 2	0	0	0	0	2	0	0	0	0	0	1	0
Total				2	1	1	1	3	1	1	1	1	2	1	
P				17%	8%	8%	8%	25%	8%	8%	8%	8%	17%	8%	
16		Sliver Terlalu Tebal	Malam 1	1	0	0	0	0	0	0	1	1	0	0	
			Malam 2	0	0	1	0	0	0	1	0	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
		Sliver Terlalu Tipis	Malam 1	0	2	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	1	0	0	0	0	0	0	2	0	
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	1
			Malam 2	0	0	0	0	1	0	0	1	0	0	0	0	0
		Sliver Kotor	Malam 1	1	0	0	0	0	0	0	0	0	0	0	0	0
			Malam 2	0	0	0	0	0	1	1	0	0	0	0	0	0
		Total			2	2	1	1	1	1	2	1	1	1	2	1
		P			17%	17%	8%	8%	8%	8%	17%	8%	8%	8%	17%	8%
17	Polyester Rayon (50/50)	Sliver Terlalu Tebal	Malam 1	1	0	0	1	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	1	0	0	0	0	1	0	0	
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	1	0	0	0	0	1
			Malam 2	0	1	0	0	0	1	0	0	0	0	0	0	0
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	1	0	0	0	0	0	0
			Malam 2	0	0	2	0	0	0	0	0	1	0	1	0	0
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	2	0	0	0	0	0
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	0
Total			1	1	2	1	1	1	1	3	1	1	1	1		
P			8%	8%	17%	8%	8%	8%	8%	25%	8%	8%	8%	8%		
18		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	1	0	1	0		
			Malam 2	1	2	0	0	2	0	0	1	0	0	0	0	
		Sliver Terlalu Tipis	Malam 1	0	0	1	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	1	0	0	1	0	0	0	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin														
				1	2	3	4	5	6	7	8	9	10	11	12			
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	1	0	0			
			Malam 2	0	0	0	1	0	0	1	0	0	0	0	0			
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	1		
			Malam 2	0	0	0	0	0	0	0	0	0	1	0	0	1		
		Total			1	2	2	1	2	1	1	1	2	1	1	2		
		P			8%	17%	17%	8%	17%	8%	8%	8%	17%	8%	8%	17%		
		19		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	1	0	0	0	1	0	1	
					Malam 2	0	1	2	0	0	1	0	0	0	0	0	0	
				Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	0	1	1	0	0	0
					Malam 2	0	0	0	1	0	0	0	0	0	0	0	0	0
Sliver Bergelombang	Malam 1			1	0	0	0	1	0	0	0	0	0	0	0	0		
	Malam 2			0	0	0	0	0	0	0	0	0	0	0	0	0		
Sliver Kotor	Malam 1			0	0	0	0	0	0	2	0	0	0	2	0	0		
	Malam 2			0	0	0	0	0	0	1	0	0	0	0	0	0		
Total				1	1	2	1	1	2	3	1	1	1	2	1			
P				8%	8%	17%	8%	8%	17%	25%	8%	8%	8%	17%	8%			
20		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	1	0	0	0	0			
			Malam 2	0	2	0	0	0	0	0	0	0	0	0	0			
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	2	0	0	0	0	0	0	0	1		
			Malam 2	1	0	1	0	0	0	1	1	0	0	0	0	0		
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	0		
			Malam 2	0	0	0	0	0	0	0	0	0	0	1	1	0		

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
		Sliver Kotor	Malam 1	0	0	0	1	0	1	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Total	1	2	1	1	2	1	1	2	0	1	1	1		
		P	8%	17%	8%	8%	17%	8%	8%	17%	0%	8%	8%	8%		
21	Polyester Rayon (20/80)	Sliver Terlalu Tebal	Malam 1	1	0	0	0	0	0	0	0	2	0	1	0	
			Malam 2	0	0	1	1	0	0	0	0	0	0	0	0	1
		Sliver Terlalu Tipis	Malam 1	1	1	0	0	0	0	0	0	0	0	0	0	0
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	0
		Sliver Bergelombang	Malam 1	0	0	0	0	0	1	1	0	0	0	0	0	0
			Malam 2	0	0	0	0	0	0	0	0	0	0	2	0	0
		Sliver Kotor	Malam 1	0	0	0	0	1	0	0	1	0	0	0	0	0
			Malam 2	0	0	1	0	0	0	0	0	0	0	0	0	0
Total	2	1	2	1	1	1	1	1	1	2	2	1	1			
P	17%	8%	17%	8%	8%	8%	8%	8%	8%	17%	17%	8%	8%			
22	Polyester Rayon (20/80)	Sliver Terlalu Tebal	Malam 1	0	1	0	0	0	0	0	1	0	0	0	0	
			Malam 2	0	0	0	1	0	0	0	1	0	0	0	2	
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	1	0	0	1	0	0	
			Malam 2	2	0	0	0	1	0	0	0	0	0	0	0	
		Sliver Bergelombang	Malam 1	0	0	1	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Kotor	Malam 1	0	0	0	0	0	2	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	0	0	0	1	0	1	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
23		Total		2	1	1	1	1	2	1	2	1	1	1	2	
		P		17%	8%	8%	8%	8%	17%	8%	17%	8%	8%	8%	17%	
		Sliver Terlalu	Malam 1	0	0	0	0	0	0	0	0	1	0	0	0	0
		Tebal	Malam 2	0	1	1	0	0	0	0	0	0	0	0	0	0
		Sliver Terlalu	Malam 1	0	0	0	0	0	0	0	0	1	0	0	0	0
		Tipis	Malam 2	1	0	0	0	1	0	0	0	1	0	1	0	0
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	1	1
			Malam 2	0	0	0	0	0	1	0	0	0	0	0	0	0
		Sliver Kotor	Malam 1	0	0	0	1	0	0	0	0	0	0	0	0	0
			Malam 2	0	0	0	0	0	0	0	1	0	1	0	0	0
	Total		1	1	1	1	1	1	1	3	1	1	1	1		
	P		8%	8%	8%	8%	8%	8%	8%	25%	8%	8%	8%	8%		
24	Polyester (100)	Sliver Terlalu	Malam 1	1	0	0	0	1	0	0	0	0	0	0	0	
		Tebal	Malam 2	0	0	0	2	0	0	0	0	3	0	1	0	
		Sliver Terlalu	Malam 1	0	0	0	0	0	0	1	0	0	0	0	0	
		Tipis	Malam 2	0	1	0	0	0	0	1	0	0	0	0	0	
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	1	0	0	0	0	0	0	
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	1	0	0	0	1	
			Malam 2	0	0	1	0	0	0	0	0	0	1	0	1	
			Total		1	1	1	2	1	1	2	1	3	1	1	2
			P		8%	8%	8%	17%	8%	8%	17%	8%	25%	8%	8%	17%

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin												
				1	2	3	4	5	6	7	8	9	10	11	12	
25		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	0	0	0	0	1	0	0	
			Malam 2	0	1	0	0	2	0	0	1	0	0	0	0	0
		Sliver Terlalu Tipis	Malam 1	1	0	1	0	0	0	0	0	0	0	0	0	1
			Malam 2	1	0	0	0	0	0	1	0	0	0	0	0	1
		Sliver Bergelombang	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	0
			Malam 2	0	0	0	1	0	1	0	0	2	0	0	0	0
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	0	0	0	1	0	0
			Malam 2	0	0	0	0	0	0	0	0	0	0	1	0	0
Total				2	1	1	1	2	1	1	1	2	1	2	2	
P				17%	8%	8%	8%	17%	8%	8%	8%	17%	8%	17%	17%	
26	Cotton (100)	Sliver Terlalu Tebal	Malam 1	0	0	0	3	0	0	0	1	0	0	0	0	
			Malam 2	0	2	0	0	0	0	0	0	0	1	0	1	
		Sliver Terlalu Tipis	Malam 1	1	0	0	0	0	0	0	0	1	0	0	0	0
			Malam 2	0	0	0	0	1	0	2	0	0	0	2	0	
		Sliver Bergelombang	Malam 1	0	0	1	0	0	1	0	0	0	1	0	0	0
			Malam 2	0	0	0	0	0	0	0	0	0	0	0	0	
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	0	1	0	0	0	0
			Malam 2	0	0	0	0	0	0	1	0	0	0	0	1	
Total				1	2	1	3	1	1	3	1	2	2	2	2	
P				8%	17%	8%	25%	8%	8%	25%	8%	17%	17%	17%	17%	
27		Sliver Terlalu Tebal	Malam 1	0	0	0	0	0	1	0	0	0	0	0	0	
			Malam 2	0	0	0	2	0	1	0	1	0	2	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin													
				1	2	3	4	5	6	7	8	9	10	11	12		
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0		
			Malam 2	0	0	0	0	0	0	0	0	0	1	0	1	1	
		Sliver Bergelombang	Malam 1	1	0	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	1	0	1	0	0	0	0	0	0	
		Sliver Kotor	Malam 1	0	1	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	1	1	0	0	0	0	0	0	0	2	0	0	
		Total				1	2	1	2	1	2	1	1	1	4	1	1
		P				8%	17%	8%	17%	8%	17%	8%	8%	8%	33%	8%	8%
		28		Sliver Terlalu Tebal	Malam 1	0	0	0	3	0	0	0	0	0	0	0	0
					Malam 2	0	0	0	0	0	1	0	2	2	1	0	0
Sliver Terlalu Tipis	Malam 1			0	0	0	0	0	1	0	1	0	0	0	0	0	
	Malam 2			0	0	0	1	0	0	0	0	0	2	0	0		
Sliver Bergelombang	Malam 1			0	0	0	0	0	0	0	0	0	0	0	0	0	
	Malam 2			0	0	0	0	0	0	0	0	0	0	0	0	1	
Sliver Kotor	Malam 1			0	1	1	0	0	0	0	0	0	0	0	1	0	
	Malam 2			0	0	0	0	0	0	0	0	0	0	0	0	0	
Total				0	1	1	4	0	2	0	3	2	3	1	1		
P				0%	8%	8%	33%	0%	17%	0%	25%	17%	25%	8%	8%		
29		Sliver Terlalu Tebal	Malam 1	2	0	1	0	0	0	0	0	1	0	0	0		
			Malam 2	0	0	0	0	0	0	0	1	1	0	0	0	1	
		Sliver Terlalu Tipis	Malam 1	0	0	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	1	0	1	1	0	0	0	1	2	0	0	0	

Tanggal	Jenis Benang	Jenis Kecacatan	Shift	Mesin											
				1	2	3	4	5	6	7	8	9	10	11	12
		Sliver	Malam 1	0	0	0	0	0	0	1	0	0	0	0	
		Bergelombang	Malam 2	0	0	0	0	0	0	1	0	0	1	1	
		Sliver Kotor	Malam 1	0	0	0	0	0	0	0	0	0	0	0	
			Malam 2	0	0	0	0	0	2	0	0	0	0	0	
		Total		2	1	1	1	1	2	3	2	3	1	1	
		P		17%	8%	8%	8%	8%	17%	25%	17%	25%	8%	8%	
Jumlah Kecacatan Per Mesin				43	45	41	40	39	39	44	40	41	41	43	
Persentase Kecacatan Per Mesin				12%	13%	12%	11%	11%	11%	13%	11%	12%	12%	12%	