



**FORM
KERJA**

Dokumen : PWI-IE-LEAN-F-001
No Dokumen

Judul : LINE BALANCING
Nama Dokumen

Halaman : 1 / 5

Tanggal Efektif : 6 July 2022

Revisi :

R.Tanggal :

Ver : 3.2



Model

PS-GS 327 Kids
(CBW,CGP,CGW,CNW)

Date

11-Dec-23

Part	Description	Unit	Dev Stage	Update			Remarks
				01	02	03	
CUTTING	Man Power	#		3			x2 shift
	Product by Hr.	Pairs		48			
	PPH	#		16.0			
	Line balance	%		52.85%			
	No of Cell	#		1			
	Takt Time	Sec		75.0			
	TCT	Sec		118.9			
	Pitch time	Sec		48.6			
PREPARATION	Man Power	#		25			x2 shift
	Product by Hr.	Pairs		48			
	PPH	#		1.9			
	Line balance	%		57.67%			
	No of Cell	#		1			
	Takt Time	Sec		75.0			
	TCT	Sec		1081.4			
	Pitch time	Sec		72.7			
STITCHING	Man Power	#		43			
	Product by Hr.	Pairs		96			
	PPH	#		2.2			
	Line balance	%		75.11%			
	No of Cell	#		1			
	Takt Time	Sec		37.5			
	TCT	Sec		1211.1			
	Pitch time	Sec		35.3			
ASSEMBLY	Man Power	#		40			
	Product by Hr.	Pairs		96			
	PPH	#		2.4			
	Line balance	%		72.5%			
	No of Cell	#		1			
	Takt Time	Sec		37.5			
	TCT	Sec		1086.9			
	Pitch time	Sec		37.1			
TOTAL	Man Power	#		139			
	Product by Hr.	Pairs		96			
	PPH	#		0.69			
	Line balance	%		67.11%			
	Takt Time	Sec		37.5			
	TCT	Sec		3498.3			
	Pitch time	Sec		36.3			



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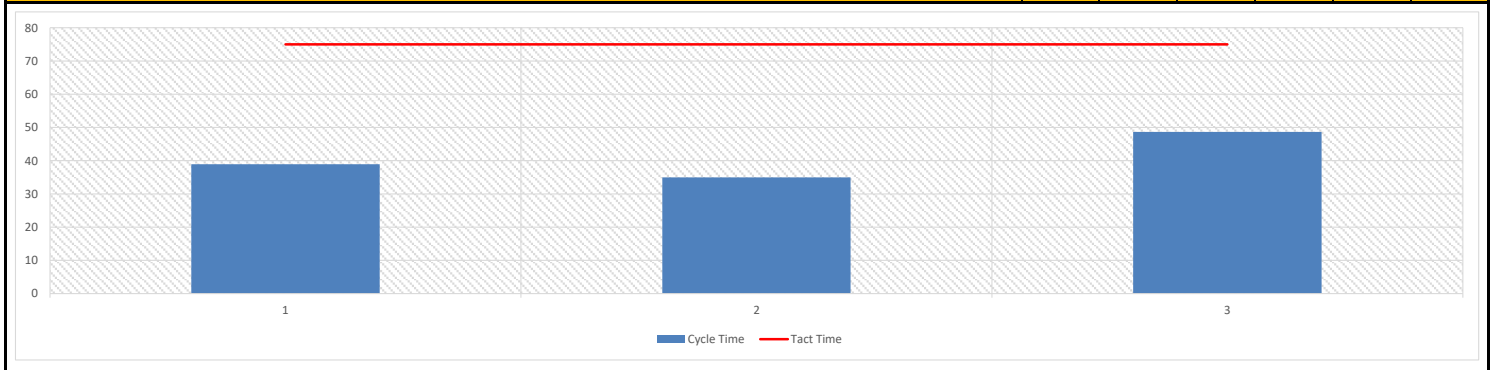
Halaman : 2 / 5
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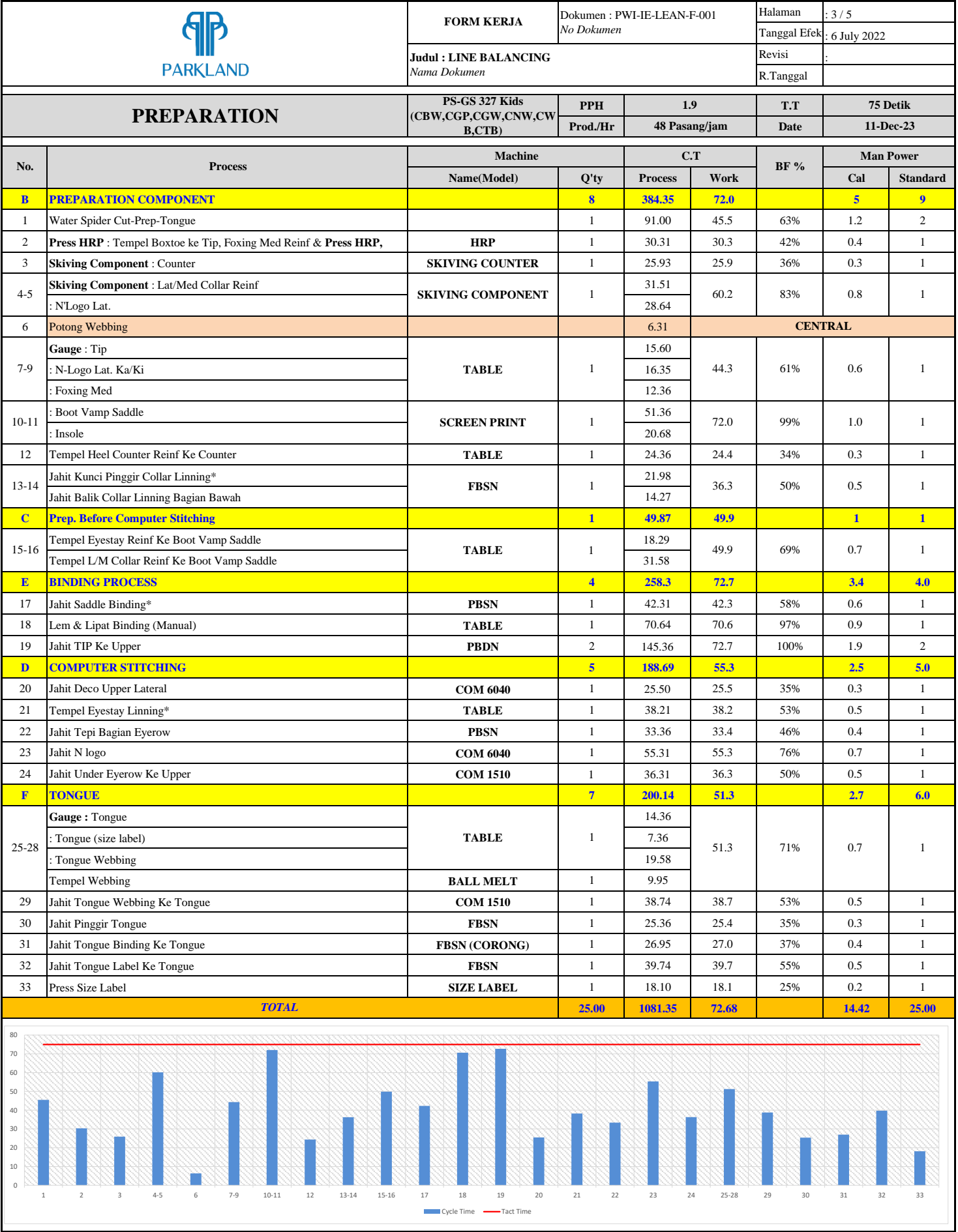
Judul : LINE BALANCING
Nama Dokumen

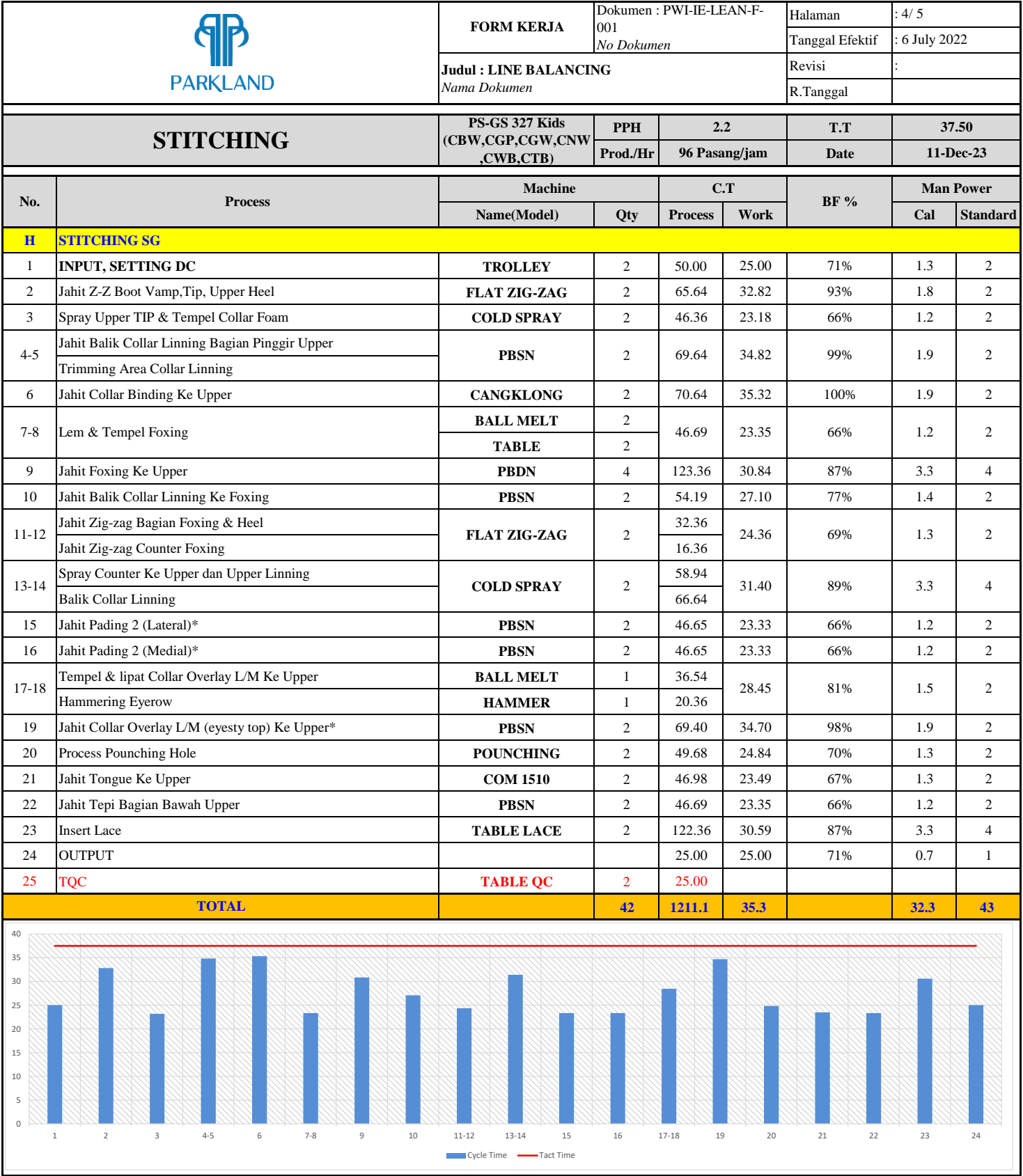
CUTTING

PS-GS 327 Kids (CBW,CGP,CGW,CNW,CWB, PPH 16.0 T.T 75 Detik
Prod./Hr 48 Pasang/jam Date 11-Dec-23

No.	Process	Material	Pcs/dies	Pcs/pair	Layer	Machine		C.T		BF %	Man Power	
						Name(Model)	Q'ty	Process	Work		Cal	Standard
A	CUTTING TRAVELING						3.00	118.92	48.6		1.6	3
1	Tip	VIDAN SUEDE,1.1MM,110CM + MEK	1	2	4	TRAVELLING	1	6.96	38.9	80%	0.5	1.0
	Collar Overlay Lat/Med.	VIDAN SUEDE,1.1MM,110CM + MEK	1	4	4			9.53				
	Under Eyestay Lat/Med.	VIDAN SUEDE,1.1MM,110CM + MEK	1	4	4			9.53				
	Foxing	VIDAN SUEDE,1.1MM,110CM + MEK	1	2	4			5.96				
	Boot Vamp & Saddle	LJ-B2572B-EPM5, 44IN + LJ-B1150B-	1	2	4			6.96				
2	Tongue	LJ-B2572B-EPM5, 44IN + K329, 4MM	1	2	4	TRAVELLING	1	6.96	35.0	72%	0.5	1.0
	Collar Lining	TSCC-155-EPM5, 44IN + K329, 4MM,	1	2	4			6.96				
	Boxtoe	TEXON UNO, 0.4MM	1	2	8			3.81				
	Eyestay Reinf	SUPER LIGHT SL380, 0.6MM, 54IN	1	2	8			4.31				
	Eyestay Lining	TCP-2600-12/POLYPAG IL EPM 5, 4	1	2	8			5.96				
	Collar Foam	K50, 4MM, 44IN	1	2	4			6.96				
3	Med. Collar Reinf	EVA 25+/-3C 2MM, 44IN	1	2	4	TRAVELLING	1	5.96	48.6	100%	0.6	1.0
	Lat. Collar Reinf	EVA 25+/-3C 2MM, 44IN	1	2	4			5.96				
	Heel Counter	TENOFLEX C36, 1.15MM	1	2	2			10.25				
	Hel Counter Reinf.	0.6MM TAIBRELLE, 44IN	1	2	8			3.63				
	N'Logo (Lat. Side)	NB-GREEN, 1.4MM, 54IN + TCCP-552	2	2	2			6.96				
	Stroble	DOUBLE TEX 25 ECO,0.9MM, 44IN	1	2	2			12.25				
	Foxing Med. Reinf	DPP16/160 DT66 BLK, 44IN	1	2	8			3.63				
TOTAL							3	118.92	48.6		1.59	3









NEW BALANCE
PS-GS 327
(CBW, CGP, CGW, CNW, CWB, CTB)
2 SHIFT CUT-PREP (96prs)

