# BAB 8
# PENUTUP

## 8.1 Kesimpulan

Pada penelitian ini dapat disimpulkan bahwa penambahan jumlah *workstation* pada *production line* yang mengalami jumlah permintaan melebihi kapasitas produksi normal akan menghasilkan penjadwalan yang efektif. Hasil penelitian ini membuktikan *production line* tidak mengalami jam lembur dan berdasarkan hasil analisis biaya membuktikan bahwa biaya operasional dengan menambahkan jumlah *workstation* jauh lebih rendah jika dibandingkan dengan biaya sebelum perbaikan yang masih menggunakan lembur untuk mengejar target produksi. Berdasarkan penggunaan metode *Capacity Requirement Planning* dan *Earliest Due Date* yang dapat mengurangi jam lembur pada waktu proses produksi seperti pada merk Poncho, AS COLOUR, dan CHAMPION.

## 8.2 Saran

Saran untuk perusahaan yaitu perusahaan dapat mempertimbangkan dan menyesuaikan perencanaan produksi dengan memperhitungkan setiap jumlah order yang diterima dan kapasitas produksi yang tersedia

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## LAMPIRAN

Lampiran 1. Gantt Chart Nautica Ross Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) |
|---|---|---|---|
| | | | Bulan 1 |
| | | | 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 |
| Nautica Ross | 1 s.d 4 | Menjahit layer depan dan belakang | |
| | 5 s.d 8 | Membuat rib leher | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | |
| | 17 s.d 20 | Menjahit samping baju | |
| | 21 s.d 24 | Hemming bagian tangan | |
| | 25 s.d 28 | Hemming bagian bawah | |
| | 29 s.d 30 | Menjahit label ke baju | |

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Nautica Ross | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 3. Gantt Chart IBKUL Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| IBKUL | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 4. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| IBKUL | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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Lampiran 5. Gantt Chart Original Penguin Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| Original Penguin | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 6. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Original Penguin | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 7. Gantt Chart AS COLOUR Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| AS COLOUR | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 8. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| AS COLOUR | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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Lampiran 9. Gantt Chart CHAMPION Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| CHAMPION | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 10. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| CHAMPION | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

UNIVERSITAS ATMA JAYA YOGYAKARTA

Lampiran 11. Gantt Chart QUINCE Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 | | | | |
| QUINCE | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 12. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| QUINCE | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

UNIVERSITAS ATMA JAYA YOGYAKARTA

Lampiran 13. Gantt Chart Poncho Sebelum Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| Poncho | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 14. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Poncho | 1 s.d 4 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5 s.d 8 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 12 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 13 s.d 16 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 17 s.d 20 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 21 s.d 24 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 28 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 29 s.d 30 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

UNIVERSITAS ATMA JAYA YOGYAKARTA

Lampiran 15. Gantt Chart Nautica Ross Setelah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) |
|---|---|---|---|
| | | | Bulan 1 |
| | | | 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 |
| Nautica Ross | 1 s.d 6 | Menjahit layer depan dan belakang | |
| | 7 s.d 10 | Membuat rib leher | |
| | 11 s.d 14 | Menjahit rib leher dengan layer baju | |
| | 15 s.d 19 | Menjahit lengan kanan kiri | |
| | 20 s.d 24 | Menjahit samping baju | |
| | 25 s.d 27 | Hemming bagian tangan | |
| | 28 s.d 31 | Hemming bagian bawah | |
| | 32 s.d 33 | Menjahit label ke baju | |

UNIVERSITAS ATMA JAYA YOGYAKARTA

Lampiran 16. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Nautica Ross | 1 s.d 6 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 7 s.d 10 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 11 s.d 14 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 15 s.d 19 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 20 s.d 24 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 27 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 28 s.d 31 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 32 s.d 33 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 17. Gantt Chartt IBKUL Setelah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| IBKUL | 1 s.d 6 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 7 s.d 10 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 11 s.d 14 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 15 s.d 19 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 20 s.d 24 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 27 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 28 s.d 31 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 32 s.d 33 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 18. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| IBKUL | 1 s.d 6 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 7 s.d 10 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 11 s.d 14 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 15 s.d 19 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 20 s.d 24 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 27 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 28 s.d 31 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 32 s.d 33 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 19. Gantt Chart Original Penguin Setelah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| Original Penguin | 1 s.d 6 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 7 s.d 10 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 11 s.d 14 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 15 s.d 19 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 20 s.d 24 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 27 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 28 s.d 31 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 32 s.d 33 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 20. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Original Penguin | 1 s.d 6 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 7 s.d 10 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 11 s.d 14 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 15 s.d 19 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 20 s.d 24 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 25 s.d 27 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 28 s.d 31 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 32 s.d 33 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 21. Gantt Chart AS COLOUR Setelah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) |
|---|---|---|---|
| | | | Bulan 1: 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 Bulan 2: 30 31 32 33 34 35 36 37 38 39 40 |
| AS COLOUR | 1 s.d 8 | Menjahit layer depan dan belakang | |
| | 9 s.d 13 | Membuat rib leher | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | |
| | 26 s.d 32 | Menjahit samping baju | |
| | 33 s.d 36 | Hemming bagian tangan | |
| | 37 s.d 41 | Hemming bagian bawah | |
| | 42 s.d 43 | Menjahit label ke baju | |

Lampiran 22. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| AS COLOUR | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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Lampiran 23. Gantt Chart CHAMPION Sesudah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| CHAMPION | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 24. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| CHAMPION | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 25. Gantt Chart QUINCE Setelah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | Bulan 2 | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| QUINCE | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 26. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| QUINCE | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

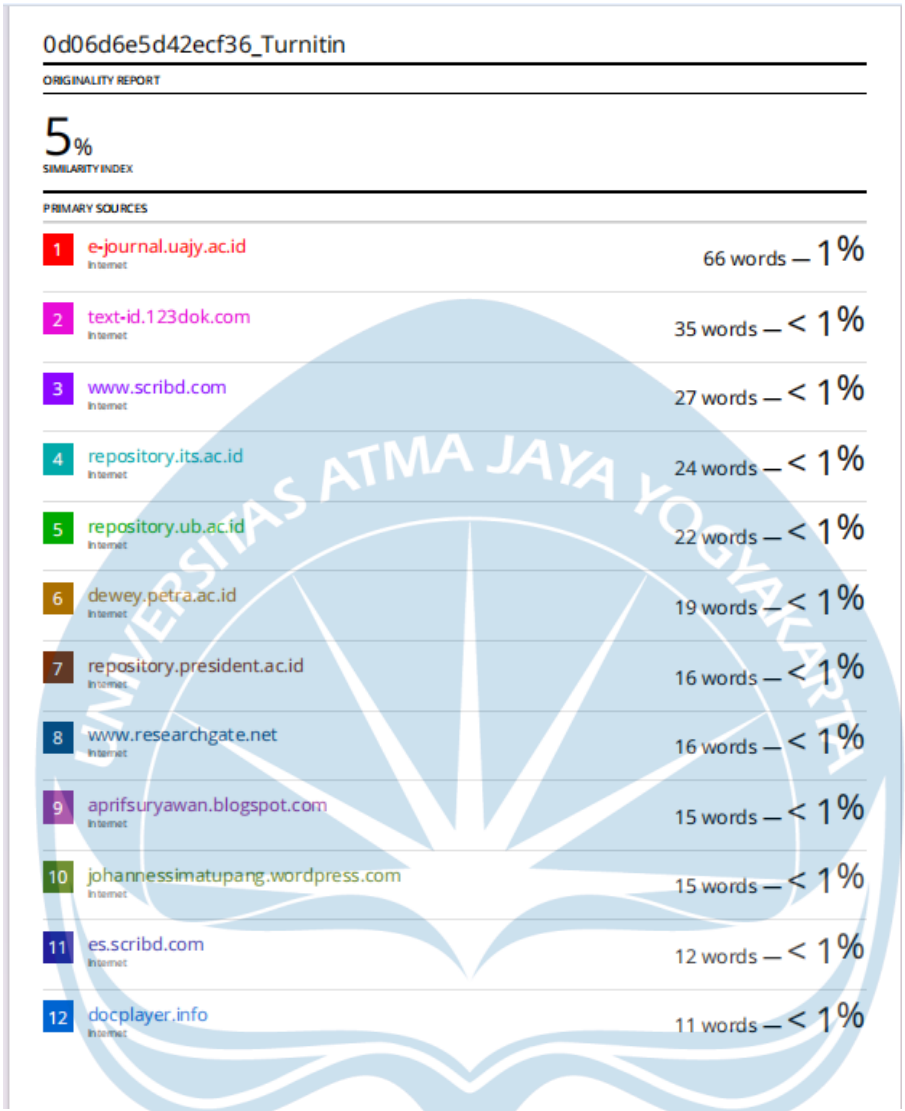
Lampiran 27. Gantt Chart Poncho Setelah Perbaikan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 1 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 | 18 | 19 | 20 | 21 | 22 | 23 | 24 | 25 | 26 | 27 | 28 | 29 | 30 | 31 | 32 | 33 | 34 | 35 | 36 | 37 | 38 | 39 | 40 |
| Poncho | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Lampiran 28. Lanjutan

| Production Line | Workstation | Deskripsi Pekerjaan | Waktu Produksi (Hari) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Bulan 3 | | | | | | | | | | | | | | | | | | | | | | Bulan 4 | | | | | | | | | | | | | | | | | | | | |
| | | | 41 | 42 | 43 | 44 | 45 | 46 | 47 | 48 | 49 | 50 | 51 | 52 | 53 | 54 | 55 | 56 | 57 | 58 | 59 | 60 | 61 | 62 | 63 | 64 | 65 | 66 | 67 | 68 | 69 | 70 | 71 | 72 | 73 | 74 | 75 | 76 | 77 | 78 | 79 | 80 |
| Poncho | 1 s.d 8 | Menjahit layer depan dan belakang | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 9 s.d 13 | Membuat rib leher | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 14 s.d 18 | Menjahit rib leher dengan layer baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 19 s.d 25 | Menjahit lengan kanan kiri | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 26 s.d 32 | Menjahit samping baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 33 s.d 36 | Hemming bagian tangan | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 37 s.d 41 | Hemming bagian bawah | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 42 s.d 43 | Menjahit label ke baju | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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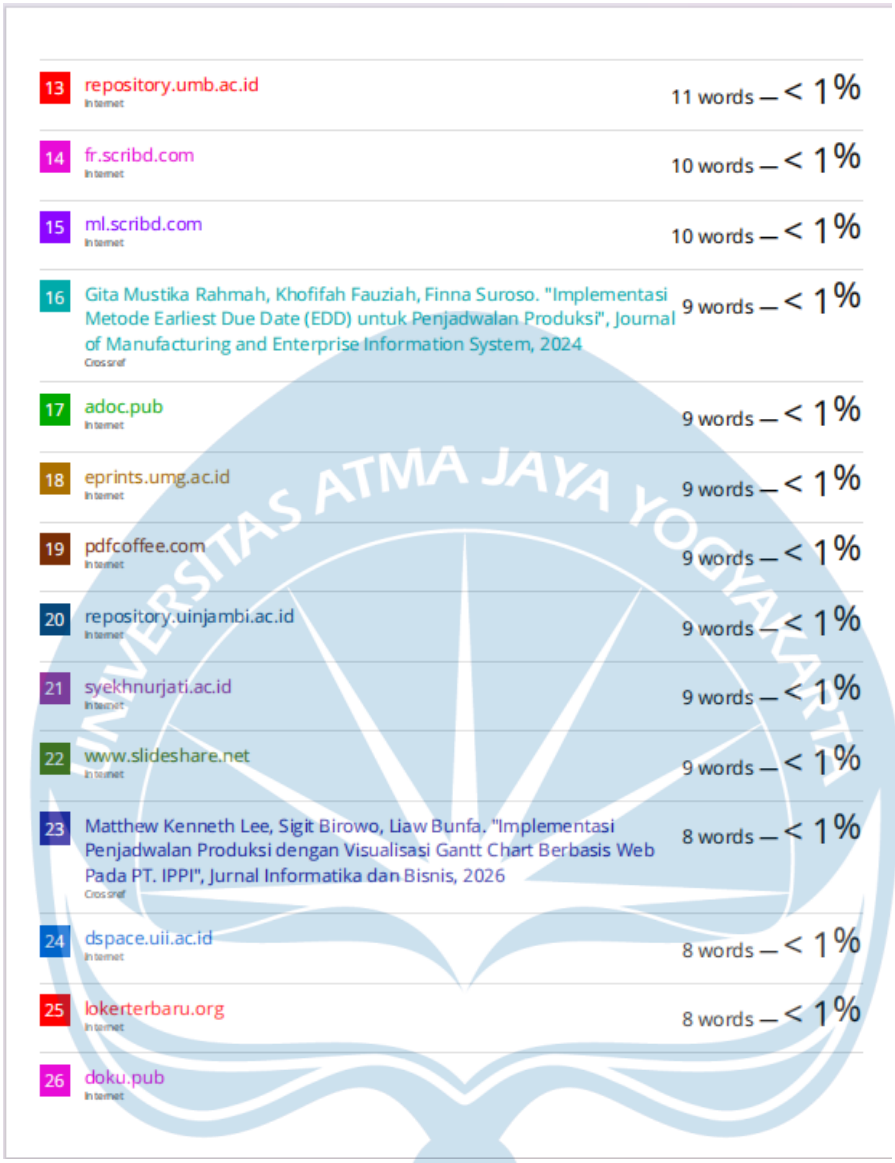
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