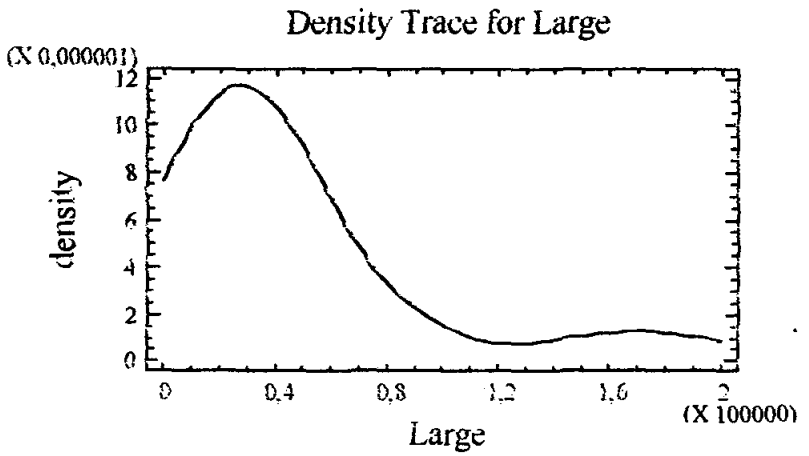
Lampiran 1: Hasil distribusi fitting



Analysis Summary

Data variable: Large

37 values ranging from 360,0 to 192000,0

Fitted Weibull distribution:
shape = 1,09025
scale = 47991,9

The StatAdvisor

This analysis shows the results of fitting a Weibull distribution to the data on Large. The estimated parameters of the fitted distribution are shown above. You can test whether the Weibull distribution fits the data adequately by selecting Goodness-of-Fit Tests from the list of Tabular Options. You can also assess visually how well the Weibull distribution fits by selecting Frequency Histogram from the list of Graphical Options. Other options within the procedure allow you to compute and display tail areas and critical values for the distribution. To select a different distribution, press the alternate mouse button and select Analysis Options.

Goodness-of-Fit Tests for Large

Chi-Square Test

	Lower Limit	Upper Limit	Observed Frequency	Expected Frequency	Chi-Square
	at or below	7554,83	2	4,63	1,49
	7554,83	15274,3	4	4,63	0,08
	15274,3	22961,0	9	4,63	4,14
	22961,0	34219,6	7	4,63	1,22
	34219,6	47049,0	3	4,63	0,57
	47049,0	64621,1	5	4,63	0,03
	64621,1	93732,4	3	4,63	0,57
above	93732,4		4	4,63	0,08

Chi-Square = 8,18919 with 5 d.f. P-Value = 0,146113

Estimated Kolmogorov statistic DPLUS = 0,115328
Estimated Kolmogorov statistic DMINUS = 0,149111
Estimated overall statistic DN = 0,149111
Approximate P-Value = 0,397297

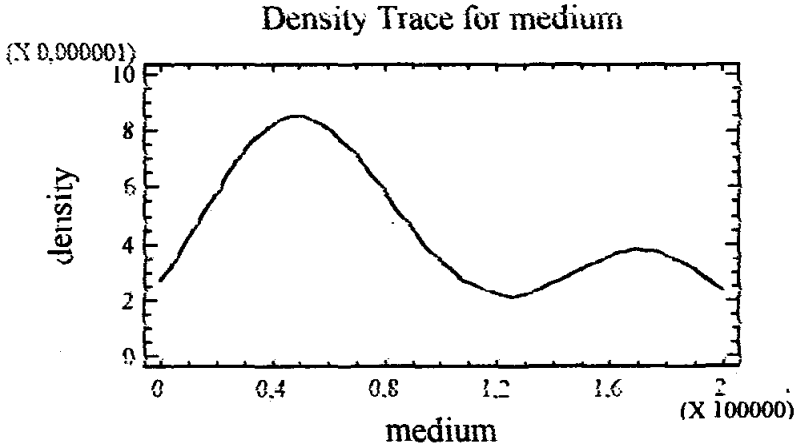
EDF Statistic	Value	Modified Form	P-Value
Kolmogorov-Smirnov D	0,149111	0,907006	<0.01*
Anderson-Darling A^2	0,984092	1,01645	<0.05*

***Indicates that the P-Value has been compared to tables of critical values specially constructed for fitting the currently selected distribution. Other P-values are based on general tables and may be very conservative.**

The StatAdvisor

This pane shows the results of tests run to determine whether Large can be adequately modeled by a Weibull distribution. The chi-square test divides the range of Large into nonoverlapping intervals and compares the number of observations in each class to the number expected based on the fitted distribution. The Kolmogorov-Smirnov test computes the maximum distance between the cumulative distribution of Large and the CDF of the fitted Weibull distribution. In this case, the maximum distance is 0,149111. The other EDF statistics compare the empirical distribution function to the fitted CDF in different ways.

Since the smallest P-value amongst the tests performed is less than 0.01, we can accept the idea that Large comes from a Weibull distribution with 99% confidence.



Analysis Summary

Data variable: medium

95 values ranging from 7200,0 to 194800,0

Fitted Erlang distribution:
shape = 2,0
scale = 0,0000236602

The StatAdvisor

This analysis shows the results of fitting a Erlang distribution to the data on medium. The estimated parameters of the fitted distribution are shown above. You can test whether the Erlang distribution fits the data adequately by selecting Goodness-of-Fit Tests from the list of Tabular Options. You can also assess visually how well the Erlang distribution fits by selecting Frequency Histogram from the list of Graphical Options. Other options within the procedure allow you to compute and display tail areas and critical values for the distribution. To select a different distribution, press the alternate mouse button and select Analysis Options.

Goodness-of-Fit Tests for medium

Chi-Square Test

Lower Limit	Upper Limit	Observed Frequency	Expected Frequency	Chi-Square
at or below	20163,7	4	7,08	1,34
20163,7	30897,9	10	7,08	1,20
30897,9	40628,6	7	7,08	0,00
40628,6	50246,3	13	7,08	4,94
50246,3	60215,5	7	7,08	0,00
60215,5	70935,6	4	7,08	1,34
70935,6	82881,7	9	7,08	0,52
82881,7	96756,8	4	7,08	1,34
96756,8	113805,0	2	7,08	3,65
113805,0	136736,0	3	7,08	2,35
136736,0	174031,0	12	7,08	8,41
above	174031,0	0	5,76	5,76

Chi-Square = 25,8682 with 9 d.f. P-Value = 0,00214691

Estimated Kolmogorov statistic DPLUS = 0,106926
Estimated Kolmogorov statistic DMINUS = 0,103153
Estimated overall statistic DN = 0,106926
Approximate P-Value = 0,296781

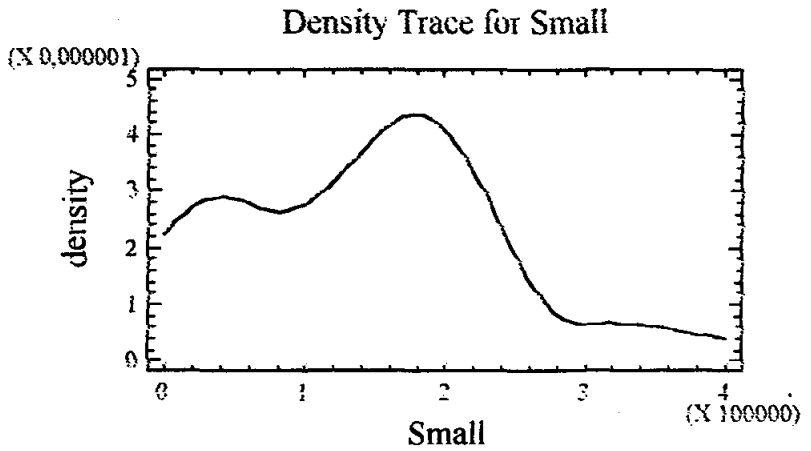
EDF Statistic	Value	Modified Form	P-Value
Kolmogorov-Smirnov D	0,106926	0,999919	>0.10
Anderson-Darling A^2	1,42921	1,42921	>0.10

***Indicates that the P-Value has been compared to tables of critical values specially constructed for fitting the currently selected distribution.**
Other P-values are based on general tables and may be very conservative.

The StatAdvisor

This pane shows the results of tests run to determine whether medium can be adequately modeled by a Erlang distribution. The chi-square test divides the range of medium into nonoverlapping intervals and compares the number of observations in each class to the number expected based on the fitted distribution. The Kolmogorov-Smirnov test computes the maximum distance between the cumulative distribution of medium and the CDF of the fitted Erlang distribution. In this case, the maximum distance is 0,106926. The other EDF statistics compare the empirical distribution function to the fitted CDF in different ways.

Since the smallest P-value amongst the tests performed is less than 0.01, we can accept the idea that medium comes from a Erlang distribution with 99% confidence.



Analysis Summary

Data variable: Small

17 values ranging from 24000,0 to 364800,0

Fitted exponential distribution:
mean = 143549,0

The StatAdvisor

This analysis shows the results of fitting an exponential distribution to the data on Small. The estimated parameters of the fitted distribution are shown above. You can test whether the exponential distribution fits the data adequately by selecting Goodness-of-Fit Tests from the list of Tabular Options. You can also assess visually how well the exponential distribution fits by selecting Frequency Histogram from the list of Graphical Options. Other options within the procedure allow you to compute and display tail areas and critical values for the distribution. To select a different distribution, press the alternate mouse button and select Analysis Options.

Goodness-of-Fit Tests for Small

Chi-Square Test

	Lower Limit	Upper Limit	Observed Frequency	Expected Frequency	Chi-Square
	at or below	26171,9	2	2,83	0,25
	26171,9	58203,8	4	2,83	0,48
	58203,9	99500,1	0	2,83	2,83
	99500,1	157704,0	1	2,83	1,19
	157704,0	257204,0	9	2,83	9,42
above		257204,0	2	2,83	0,25

Chi-Square = 14,4118 with 4 d.f. P-Value = 0,00609046

Estimated Kolmogorov statistic DPLUS = 0,163001
Estimated Kolmogorov statistic DMINUS = 0,288176
Estimated overall statistic DN = 0,288176
Approximate P-Value = 0,118802

EDF Statistic	Value	Modified Form	P-Value
Kolmogorov-Smirnov D	0,288176	1,24506	<0.05*
Anderson-Darling A^2	1,42442	1,47469	0,0340*

*Indicates that the P-Value has been compared to tables of critical values specially constructed for fitting the currently selected distribution. Other P-values are based on general tables and may be very conservative.

The StatAdvisor

This pane shows the results of tests run to determine whether Small can be adequately modeled by an exponential distribution. The chi-square test divides the range of Small into nonoverlapping intervals and compares the number of observations in each class to the number expected based on the fitted distribution. The Kolmogorov-Smirnov test computes the maximum distance between the cumulative distribution of Small and the CDF of the fitted exponential distribution. In this case, the maximum distance is 0,288176. The other EDF statistics compare the empirical distribution function to the fitted CDF in different ways.

Since the smallest P-value amongst the tests performed is less than 0.01, we can accept the idea that Small comes from an exponential distribution with 99% confidence.

Lampiran 2: Perhitungan Matriks Insidensial terhadap kuantitas

Bobot pada matriks ini dihitung melalui banyaknya sarung tangan yang dipindahkan pada tiap kali *firing* sehingga:

T1→ T2 mempunyai bobot 1 karena pemindahan sebanyak 1 karung sarung tangan berisi 60 dzp dan tidak ada perubahan kuantitas disini.

T2→ T3-T8 pemasangan pada mesing sebanyak 43 dzp sehingga bila dihitung bobotnya:

N= 43/60 = 0.717

T3-T8→ T9 tidak mengalami perubahan, atau bobot dapat dianggap sebagai 1 karena proses ini hanya bersifat sebagai transfer saja menuju buffer

T9→T10 mengalami perpindahan sebanyak 30 dzp menuju mesin buffer setter sehingga bobotnya berubah menjadi:

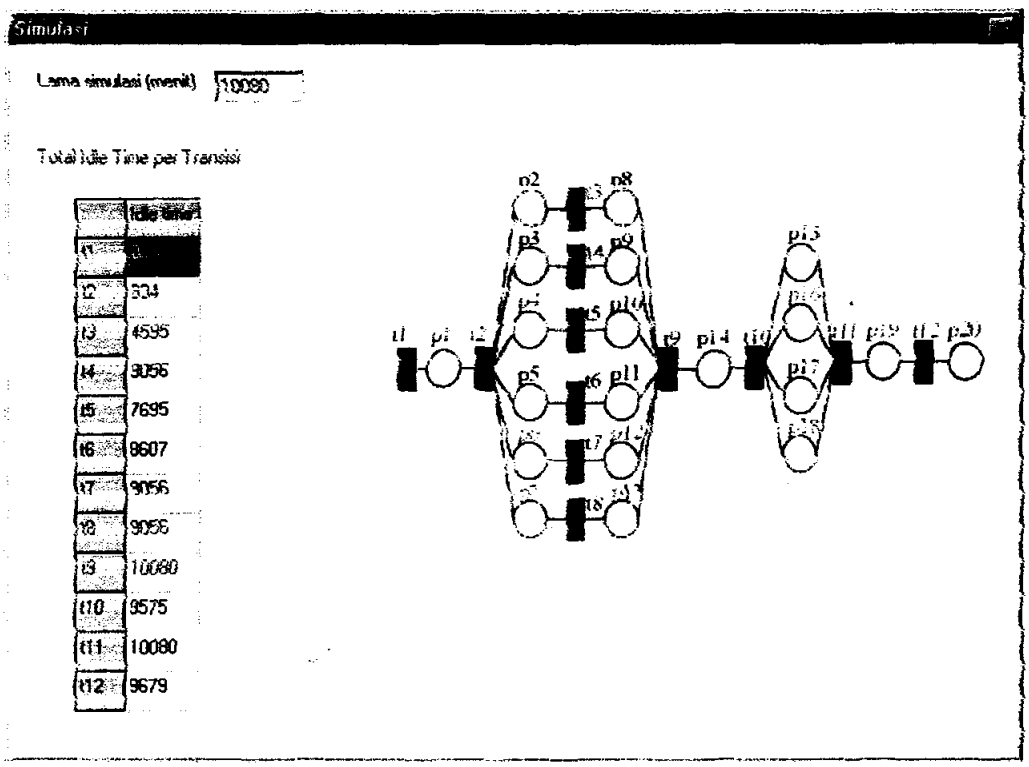
N= 30/60 = 0.5

T10→ T11 mengalami perpindahan dari buffer setter menuju mesin setter sebanyak 24 dzp sehingga bobotnya:

N= 24/60 = 0.4

T11→ T12 sarung tangan yang sudah dipacking dari setter menuju operator mempunyai bobot 1 karena tidak ada perubahan kuantitas selama proses disini.

Lampiran 3: Tampilan dan Bahasa Pemrograman Jaringan Petri dengan Borland Delphi



```
unit Engine;

interface

uses
  Windows, Messages, SysUtils, Classes, Graphics, Controls, Forms,
Dialogs,
  jpeg, ExtCtrls, StdCtrls, Grids;

type
  TForm1 = class(TForm)
    Image1: TImage;
    Label1: TLabel;
    Edit1: TEdit;
    StringGrid1: TStringGrid;
    Label2: TLabel;
    procedure Edit1KeyDown(Sender: TObject; var Key: Word;
      Shift: TShiftState);
    procedure FormActivate(Sender: TObject);
  private
    { Private declarations }
  public
    { Public declarations }
  end;

var
  Form1: TForm1;
  buffer: Array[1..20,1..3] of Integer;
  Idle: Array[1..12,1..300000] of Integer;
  Counter: Array[1..12] of Integer;
  Time: Integer;
  Proses: Array[1..7] of Integer;
  FlagM9, FlagL9, FlagS9: Boolean;
  Flag111, Flag112, Flag113, Flag114: Boolean;

Const Items = 30;  // Jumlah item dalam 1 karung

implementation

{$R *.DFM}

Procedure Inisiallisasi;
Var Count1, Count2: Integer;
begin
  // Reset buffer
  For Count1 := 1 to 20 do
    For Count2 := 1 to 3 do
      Buffer[Count1,Count2] := 0;

  // Reset Idle time dan counter untuk masing-masing transisi
  For Count1 := 1 to 12 do
  begin
    Counter[Count1] := 1;
    For Count2 := 1 to 300000 do
      Idle[Count1,Count2] := 0;
  End;
```

```
  // Reset Process time untuk masing-masing mesin
  For Count1 := 1 to 7 do
  begin
    Proses[Count1] := 0;
  End;

  // Reset Waktu mulai
  Time := 0;

  // Reset flag proses
  FlagM3 := False;
  FlagL3 := False;
  FlagS3 := False;
  Flag111 := False;
  Flag112 := False;
  Flag113 := False;
  Flag114 := False;
End;

Procedure Transisi1;
Var Barang: Integer;
begin
  Time := Time + 1;
  Randomize;
  Barang := Random(3);
  If Barang = 0 then
    // Buffer medium
    Buffer[1,1] := Buffer[1,1] + 2*Items
  Else
  If Barang = 1 then
    // Buffer large
    Buffer[1,2] := Buffer[1,2] + 2*Items
  Else
  //Buffer small
  Buffer[1,3] := Buffer[1,3] + 2*Items;
End;

Procedure Transisi2;
begin
  If (Buffer[1,1]>=2*Items) and ((Buffer[2,1]<43) or
(Buffer[3,1]<43) or (Buffer[6,1]<43) or (Buffer[7,1]<43)) then
  begin
    If Buffer[2,1]<43 then
    begin
      Buffer[2,1] := Buffer[2,1] + 2*Items;
      Buffer[1,1] := Buffer[1,1] - 2*Items;
    End
    Else
    If Buffer[3,1]<43 then
    begin
      Buffer[3,1] := Buffer[3,1] + 2*Items;
      Buffer[1,1] := Buffer[1,1] - 2*Items;
    End
    Else
    If Buffer[6,1]<43 then
```

```
    begin
      Buffer[6,1] := Buffer[6,1] + 2*Items;
      Buffer[1,1] := Buffer[1,1] - 2*Items;
    End
    Else
    If Buffer[7,1]<43 then
    begin
      Buffer[7,1] := Buffer[7,1] + 2*Items;
      Buffer[1,1] := Buffer[1,1] - 2*Items;
    End;
    If Idle[2,Counter[2]]>0 then
      Counter[2] := Counter[2] + 1;
  End
  Else
  If (Buffer[1,2]>=2*Items) and (Buffer[4,2]<43) then
  begin
    Buffer[4,2] := Buffer[4,2] + 2*Items;
    Buffer[1,2] := Buffer[1,2] - 2*Items;
    If Idle[2,Counter[2]]>0 then
      Counter[2] := Counter[2] + 3;
  End
  Else
  If (Buffer[1,3]>=2*Items) and (Buffer[5,3]<43) then
  begin
    Buffer[5,3] := Buffer[5,3] + 2*Items;
    Buffer[1,3] := Buffer[1,3] - 2*Items;
    If Idle[2,Counter[2]]>0 then
      Counter[2] := Counter[2] + 1;
  End
  Else
    Idle[2,Counter[2]] := Idle[2,Counter[2]] + 1;
End;

Procedure Transisi3;
begin
  If (Buffer[2,1]>=43) and (Buffer[8,1]=0) then
  begin
    Buffer[8,1] := Buffer[8,1] + 43;
    Buffer[2,1] := Buffer[2,1] - 43;
    If Idle[3,Counter[3]]>0 then
      Counter[3] := Counter[3] + 1;
  End
  Else
    Idle[3,Counter[3]] := Idle[3,Counter[3]] + 1;
End;

Procedure Transisi4;
begin
  If (Buffer[3,1]>=43) and (Buffer[9,1]=0) then
  begin
    Buffer[9,1] := Buffer[9,1] + 43;
    Buffer[3,1] := Buffer[3,1] - 43;
    If Idle[4,Counter[4]]>0 then
      Counter[4] := Counter[4] + 1;
  End
  Else
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```
    Idle[4,Counter[4]] := Idle[4,Counter[4]] + 1;
End;

Procedure Transisi5;
begin
  If (Buffer[4,2]>=43) and (Buffer[10,2]=0) then
  begin
    Buffer[10,2] := Buffer[10,2] + 43;
    Buffer[4,2] := Buffer[4,2] - 43;
    If Idle[5,Counter[5]]>0 then
      Counter[5] := Counter[5] + 1;
  End
  Else
    Idle[5,Counter[5]] := Idle[5,Counter[5]] + 1;
End;

Procedure Transisi6;
begin
  If (Buffer[5,3]>=43) and (Buffer[11,3]=0) then
  begin
    Buffer[11,3] := Buffer[11,3] + 43;
    Buffer[5,3] := Buffer[5,3] - 43;
    If Idle[6,Counter[6]]>0 then
      Counter[6] := Counter[6] + 1;
  End
  Else
    Idle[6,Counter[6]] := Idle[6,Counter[6]] + 1;
End;

Procedure Transisi7;
begin
  If (Buffer[6,1]>=43) and (Buffer[12,1]=0) then
  begin
    Buffer[12,1] := Buffer[12,1] + 43;
    Buffer[6,1] := Buffer[6,1] - 43;
    If Idle[7,Counter[7]]>0 then
      Counter[7] := Counter[7] + 1;
  End
  Else
    Idle[7,Counter[7]] := Idle[7,Counter[7]] + 1;
End;

Procedure Transisi8;
begin
  If (Buffer[7,1]>=43) and (Buffer[13,1]=0) then
  begin
    Buffer[13,1] := Buffer[13,1] + 43;
    Buffer[7,1] := Buffer[7,1] - 43;
    If Idle[8,Counter[8]]>0 then
      Counter[8] := Counter[8] + 1;
  End
  Else
    Idle[8,Counter[8]] := Idle[8,Counter[8]] + 1;
End;

Procedure Transisi9;
```

```
begin
  If Buffer[8,1]>=43 then
  begin
    FlagM8 := True;
    If Proses[1]>=190 then
    begin
      FlagM8 := False;
      Buffer[14,1] := Buffer[14,1] + 4*43;
      Buffer[8,1] := Buffer[8,1] - 43;
      Buffer[9,1] := Buffer[9,1] - 43;
      Buffer[12,1] := Buffer[12,1] - 43;
      Buffer[13,1] := Buffer[13,1] - 43;
      If Idle[8,Counter[8]]>0 then
        Counter[8] := Counter[8] + 1;
    End;
  End;
  If Buffer[10,2]>=43 then
  begin
    FlagL8 := True;
    If Proses[2]>=226 then
    begin
      FlagL8 := False;
      Buffer[14,2] := Buffer[14,2] + 43;
      Buffer[10,2] := Buffer[10,2] - 43;
      If Idle[8,Counter[8]]>0 then
        Counter[8] := Counter[8] + 1;
    End;
  End;
  If Buffer[11,3]>=43 then
  begin
    FlagS8 := True;
    If Proses[3]>=170 then
    begin
      FlagS8 := False;
      Buffer[14,3] := Buffer[14,3] + 43;
      Buffer[11,3] := Buffer[11,3] - 43;
      If Idle[8,Counter[8]]>0 then
        Counter[8] := Counter[8] + 1;
    End;
  End;
  If (Buffer[8,1]=0) and (Buffer[10,2]=0) and (Buffer[11,3]=0) or
    (Proses[1]<190) or (Proses[2]<226) or (Proses[3]<170) then
  begin
    Idle[8,Counter[8]] := Idle[8,Counter[8]] + 1;
    If (Buffer[8,1]>0) and (Proses[1]<190) then
      Proses[1] := Proses[1] + 1;
    If (Buffer[10,2]>0) and (Proses[2]<226) then
      Proses[2] := Proses[2] + 1;
    If (Buffer[11,3]>0) and (Proses[3]<170) then
      Proses[3] := Proses[3] + 1;
  End;
End;

Procedure Transisi10;
begin
```

```
  If ((Buffer[14,1]>24) or (Buffer[14,2]>24) or (Buffer[14,3]>24))
and
    (((Buffer[15,1]=0) and (Buffer[15,2]=0) and (Buffer[15,3]=0))
or
    ((Buffer[16,1]=0) and (Buffer[16,2]=0) and (Buffer[16,3]=0))
or
    ((Buffer[17,1]=0) and (Buffer[17,2]=0) and (Buffer[17,3]=0))
or
    ((Buffer[18,1]=0) and (Buffer[18,2]=0) and (Buffer[18,3]=0)))
then
  begin
    If (Buffer[15,1]=0) and (Buffer[15,2]=0) and (Buffer[15,3]=0)
then
    begin
      If Buffer[14,1]>=24 then
      begin
        Buffer[15,1] := Buffer[15,1] + 24;
        Buffer[14,1] := Buffer[14,1] - 24;
        If Idle[10,Counter[10]]>0 then
          Counter[10] := Counter[10] + 1;
      End
      Else
      If Buffer[14,2]>=24 then
      begin
        Buffer[15,2] := Buffer[15,2] + 24;
        Buffer[14,2] := Buffer[14,2] - 24;
        If Idle[10,Counter[10]]>0 then
          Counter[10] := Counter[10] + 1;
      End
      Else
      If Buffer[14,3]>=24 then
      begin
        Buffer[15,3] := Buffer[15,3] + 24;
        Buffer[14,3] := Buffer[14,3] - 24;
        If Idle[10,Counter[10]]>0 then
          Counter[10] := Counter[10] + 1;
      End;
    End
    Else
    If (Buffer[16,1]=0) and (Buffer[16,2]=0) and (Buffer[16,3]=0)
then
    begin
      If Buffer[14,1]>=24 then
      begin
        Buffer[16,1] := Buffer[16,1] + 24;
        Buffer[14,1] := Buffer[14,1] - 24;
        If Idle[10,Counter[10]]>0 then
          Counter[10] := Counter[10] + 1;
      End
      Else
      If Buffer[14,2]>=24 then
      begin
        Buffer[16,2] := Buffer[16,2] + 24;
        Buffer[14,2] := Buffer[14,2] - 24;
        If Idle[10,Counter[10]]>0 then
          Counter[10] := Counter[10] + 1;
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        End
        Else
        If Buffer[14,3]>=24 then
        begin
          Buffer[10,3] := Buffer[10,3] + 24;
          Buffer[14,3] := Buffer[14,3] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
        End;
      End
      Else
      If (Buffer[17,1]=0) and (Buffer[17,2]=0) and (Buffer[17,3]=0)
then
      begin
        If Buffer[14,1]>=24 then
        begin
          Buffer[17,1] := Buffer[17,1] + 24;
          Buffer[14,1] := Buffer[14,1] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
        End
        Else
        If Buffer[14,2]>=24 then
        begin
          Buffer[17,2] := Buffer[17,2] + 24;
          Buffer[14,2] := Buffer[14,2] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
        End
        Else
        If Buffer[14,3]>=24 then
        begin
          Buffer[17,3] := Buffer[17,3] + 24;
          Buffer[14,3] := Buffer[14,3] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
        End;
      End
      Else
      If (Buffer[18,1]=0) and (Buffer[18,2]=0) and (Buffer[18,3]=0)
then
      begin
        If Buffer[14,1]>=24 then
        begin
          Buffer[18,1] := Buffer[18,1] + 24;
          Buffer[14,1] := Buffer[14,1] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
        End
        Else
        If Buffer[14,2]>=24 then
        begin
          Buffer[18,2] := Buffer[18,2] + 24;
          Buffer[14,2] := Buffer[14,2] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
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        End
        Else
        If Buffer[14,3]>=24 then
        begin
          Buffer[18,3] := Buffer[18,3] + 24;
          Buffer[14,3] := Buffer[14,3] - 24;
          If Idle[10,Counter[10]]>0 then
            Counter[10] := Counter[10] + 1;
        End;
      End;
    End
    Else
      Idle[10,Counter[10]] := Idle[10,Counter[10]] + 1;
End;

Procedure Transis111;
begin
  If (Buffer[15,1]>=24) or (Buffer[15,2]>=24) or
(Buffer[15,3]>=24) then
  begin
    Flag111 := True;
    If Proses[4]>=388 then
    begin
      Flag111 := False;
      If Buffer[15,1]>=24 then
      begin
        Buffer[19,1] := Buffer[19,1] + 24;
        Buffer[15,1] := Buffer[15,1] - 24;
      End
      Else
      If Buffer[15,2]>=24 then
      begin
        Buffer[19,2] := Buffer[19,2] + 24;
        Buffer[15,2] := Buffer[15,2] - 24;
      End
      Else
      If Buffer[15,3]>=24 then
      begin
        Buffer[19,3] := Buffer[19,3] + 24;
        Buffer[15,3] := Buffer[15,3] - 24;
      End;
      If Idle[11,Counter[11]]>0 then
        Counter[11] := Counter[11] + 1;
    End;
  End;

  If (Buffer[16,1]>=24) or (Buffer[16,2]>=24) or
(Buffer[16,3]>=24) then
  begin
    Flag112 := True;
    If Proses[5]>=388 then
    begin
      Flag112 := False;
      If Buffer[16,1]>=24 then
      begin
        Buffer[19,1] := Buffer[19,1] + 24;
```

```
        Buffer[16,1] := Buffer[16,1] - 24;
      End
      Else
      If Buffer[16,2]>=24 then
      begin
        Buffer[19,2] := Buffer[19,2] + 24;
        Buffer[16,2] := Buffer[16,2] - 24;
      End
      Else
      If Buffer[16,3]>=24 then
      begin
        Buffer[19,3] := Buffer[19,3] + 24;
        Buffer[16,3] := Buffer[16,3] - 24;
      End;
      If Idle[11,Counter[11]]>0 then
        Counter[11] := Counter[11] + 1;
    End;
  End;

  If (Buffer[17,1]>=24) or (Buffer[17,2]>=24) or
(Buffer[17,3]>=24) then
  begin
    Flag113 := True;
    If Proses[6]>=388 then
    begin
      Flag113 := False;
      If Buffer[17,1]>=24 then
      begin
        Buffer[19,1] := Buffer[19,1] + 24;
        Buffer[17,1] := Buffer[17,1] - 24;
      End
      Else
      If Buffer[17,2]>=24 then
      begin
        Buffer[19,2] := Buffer[19,2] + 24;
        Buffer[17,2] := Buffer[17,2] - 24;
      End
      Else
      If Buffer[17,3]>=24 then
      begin
        Buffer[19,3] := Buffer[19,3] + 24;
        Buffer[17,3] := Buffer[17,3] - 24;
      End;
      If Idle[11,Counter[11]]>0 then
        Counter[11] := Counter[11] + 1;
    End;
  End;

  If (Buffer[18,1]>=24) or (Buffer[18,2]>=24) or
(Buffer[18,3]>=24) then
  begin
    Flag114 := True;
    If Proses[7]>=388 then
    begin
      Flag114 := False;
      If Buffer[18,1]>=24 then
```

```
      begin
        Buffer[19,1] := Buffer[19,1] + 24;
        Buffer[18,1] := Buffer[18,1] - 24;
      End
      Else
      If Buffer[18,2]>=24 then
      begin
        Buffer[19,2] := Buffer[19,2] + 24;
        Buffer[18,2] := Buffer[18,2] - 24;
      End
      Else
      If Buffer[18,3]>=24 then
      begin
        Buffer[19,3] := Buffer[19,3] + 24;
        Buffer[18,3] := Buffer[18,3] - 24;
      End;
      If Idle[11,Counter[11]]>0 then
        Counter[11] := Counter[11] + 1;
    End;
  End;

  If ((Buffer[15,1]=0) and (Buffer[15,2]=0) and (Buffer[15,3]=0)
and
     (Buffer[16,1]=0) and (Buffer[16,2]=0) and (Buffer[16,3]=0)
and
     (Buffer[17,1]=0) and (Buffer[17,2]=0) and (Buffer[17,3]=0)
and
     (Buffer[18,1]=0) and (Buffer[18,2]=0) and (Buffer[18,3]=0))
or
     (Proses[4]<388) or (Proses[5]<388) or (Proses[6]<388) or
(Proses[7]<388) then
  begin
    Idle[11,Counter[11]] := Idle[11,Counter[11]] + 1;
    If ((Buffer[15,1]>0) or (Buffer[15,2]>0) or (Buffer[15,3]>0))
and (Proses[4]<388) then
      Proses[4] := Proses[4] + 1;
    If ((Buffer[16,1]>0) or (Buffer[16,2]>0) or (Buffer[16,3]>0))
and (Proses[5]<388) then
      Proses[5] := Proses[5] + 1;
    If ((Buffer[17,1]>0) or (Buffer[17,2]>0) or (Buffer[17,3]>0))
and (Proses[6]<388) then
      Proses[6] := Proses[6] + 1;
    If ((Buffer[18,1]>0) or (Buffer[18,2]>0) or (Buffer[18,3]>0))
and (Proses[7]<388) then
      Proses[7] := Proses[7] + 1;
  End;
End;

Procedure Transisi12;
begin
  If (Buffer[19,1]>=60) or (Buffer[19,2]>=60) or
(Buffer[19,3]>=60) then
  begin
    If Buffer[19,1]>=60 then
    begin
      Buffer[20,1] := Buffer[20,1] + 60;
```

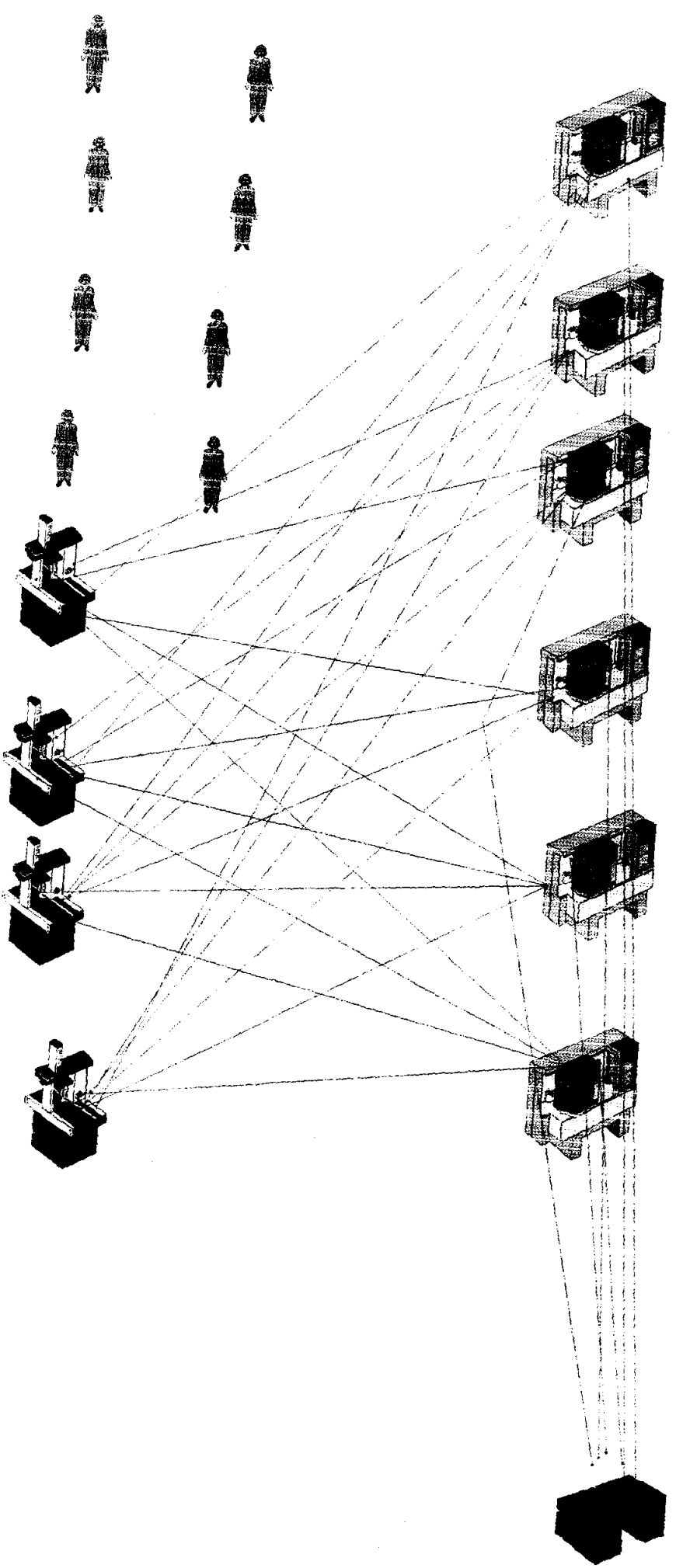
```
      Buffer[19,1] := Buffer[19,1] - 60;
    End
    Else
    If Buffer[19,2]>=60 then
    begin
      Buffer[20,2] := Buffer[20,2] + 60;
      Buffer[19,2] := Buffer[19,2] - 60;
    End
    Else
    If Buffer[19,3]>=60 then
    begin
      Buffer[20,3] := Buffer[20,3] + 60;
      Buffer[19,3] := Buffer[19,3] - 60;
    End;
    If Idle[12,Counter[12]]>0 then
      Counter[12] := Counter[12] + 1;
  End
  Else
    Idle[12,Counter[12]] := Idle[12,Counter[12]] + 1;
End;

procedure TForm1.Edit1KeyDown(Sender: TObject; var Key: Word;
  Shift: TShiftState);
Var LamaSimulasi, Simulasi: Integer;
    Lapor: Array[1..12] of Integer;
    LastCount: Integer;
    LastCount2: Integer;
begin
  If Key=13 then
  begin
    If Edit1.Text <> '' then
    begin
      Inisialisasi;
      Simulasi := 0;
      LamaSimulasi := StrToInt(Edit1.Text);
      While Simulasi<LamaSimulasi do
      begin
        Transisi1;
        Transisi2;
        Transisi3;
        Transisi4;
        Transisi5;
        Transisi6;
        Transisi7;
        Transisi8;
        Transisi9;
        Transisi10;
        Transisi11;
        Transisi12;
        Simulasi := Simulasi + 1;
      End;
      For LastCount := 1 to 12 do
        Lapor[LastCount] := 0;
      For LastCount := 1 to 12 do
        For LastCount2 := 1 to Counter[LastCount] do
```

```
          Lapor[LastCount] := Lapor[LastCount] +
Idle[LastCount,LastCount2];
      For LastCount := 1 to 12 do
         StringGrid1.Cells[1,LastCount] :=
IntToStr(Lapor[LastCount]);
    End;
  End;
end;

procedure TForm1.FormActivate(Sender: TObject);
Var Count: Integer;
begin
  Randomize;
  StringGrid1.Cells[1,0] := 'Idle time';
  For Count := 1 to 12 do
    StringGrid1.Cells[0,Count] := 't'+IntToStr(Count);
end;

end.
```



Formatted Listing of Model:
C:\My Documents\TA\modeltarev-1.MOD

Time Units: Minutes
Distance Units: Meters

Locations

Name	Cap	Units	Stats	Rules	Cost
MESIN_DOTTING_M1	86	1	Time Series	Oldest, ,	
MESIN_DOTTING_M2	86	1	Time Series	Oldest, ,	
MESIN_DOTTING_L	86	1	Time Series	Oldest, ,	
MESIN_DOTTING_S	86	1	Time Series	Oldest, ,	
MESIN_DOTTING_M3	86	1	Time Series	Oldest, ,	
MESIN_DOTTING_M4	86	1	Time Series	Oldest, ,	
SETTER_1	130	1	Time Series	Oldest, ,	
SETTER_2	130	1	Time Series	Oldest, ,	
SETTER_3	130	1	Time Series	Oldest, ,	
SETTER_4	130	1	Time Series	Oldest, ,	
Operator	100	1	Time Series	Oldest, ,	
Operator2	100	1	Time Series	Oldest, ,	
Operator3	100	1	Time Series	Oldest, ,	
Operator4	100	1	Time Series	Oldest, ,	
Operator5	100	1	Time Series	Oldest, ,	
Operator6	100	1	Time Series	Oldest, ,	
Operator7	100	1	Time Series	Oldest, ,	
Operator8	100	1	Time Series	Oldest, ,	
BUFFER_STOCK	720	1	Time Series	Oldest, ,	

Entities

Name	Speed (mpm)	Stats	Cost
SARUNG_TANGAN_S	150	Time Series	
SARUNG_TANGAN_M	150	Time Series	
SARUNG_TANGAN_L	150	Time Series	

Path Networks

Name	Type	T/S	From	To	BI	Dist/Time	Speed Factor
Net1	Passing	Speed & Distance	N1	N2	Bi	3.9	1
			N3	N4	Bi	7.8	1
			N5	N6	Bi	11.7	1
			N7	N8	Bi	15.6	1
			N9	N10	Bi	19.5	1
			N11	N12	Bi	23.4	1
			N13	N14	Bi	5.4	1
			N13	N15	Bi	5.3	1
			N13	N16	Bi	5.4	1
			N13	N17	Bi	5.5	1
			N18	N19	Bi	7.1	1
			N18	N20	Bi	7.2	1
			N18	N21	Bi	7.3	1
			N18	N22	Bi	7.4	1
			N23	N19	Bi	10.1	1
			N23	N24	Bi	10.27	1
			N23	N25	Bi	11.1	1
			N26	N27	Bi	14.3	1
			N26	N24	Bi	14.1	1
			N28	N21	Bi	14.3	1
			N29	N30	Bi	14.4	1
			N31	N32	Bi	17.5	1
			N31	N33	Bi	17.1	1
			N31	N34	Bi	17.4	1
			N31	N35	Bi	17.3	1
			N36	N37	Bi	21.6	1
			N38	N39	Bi	21.5	1
			N40	N24	Bi	21.8	1
			N38	N41	Bi	22	1

N42 N21 Bi 10.4 1

Interfaces

Net	Node	Location
Net1	N1	BUFFER_STOCK
	N2	MESIN_DOTTING_M1
	N4	MESIN_DOTTING_M2
	N6	MESIN_DOTTING_L
	N8	MESIN_DOTTING_S
	N10	MESIN_DOTTING_M3
	N12	MESIN_DOTTING_M4
	N14	SETTER_1
	N15	SETTER_2
	N16	SETTER_3
	N17	SETTER_4
	N14	Operator
	N15	Operator2
	N16	Operator3
	N17	Operator4
	N14	Operator5
	N15	Operator6
	N16	Operator7
	N17	Operator8

Processing

		Process			Routing		
Entity	Location	Operation	Blk	Output	Destination	Rule	Move Logi
SARUNG_TANGAN_S	BUFFER_STOCK						
		ACCUM 86					
			1	SARUNG_TANGAN_S	MESIN_DOTTING_S	FIRST 1	

```
SARUNG_TANGAN_S MESIN_DOTTING_S  WAIT 0.033 accum 24
                                                    1   SARUNG_TANGAN_S SETTER_1          0.250000 1
                                                        SARUNG_TANGAN_S SETTER_2          0.250000
                                                        SARUNG_TANGAN_S SETTER_3          0.250000
                                                        SARUNG_TANGAN_S SETTER_4          0.250000
SARUNG_TANGAN_S SETTER_1         WAIT .1346         1   SARUNG_TANGAN_S Operator          0.125000 1
                                                        SARUNG_TANGAN_S Operator2         0.125000
                                                        SARUNG_TANGAN_S Operator3         0.125000
                                                        SARUNG_TANGAN_S Operator4         0.125000
                                                        SARUNG_TANGAN_S Operator5         0.125000
                                                        SARUNG_TANGAN_S Operator6         0.125000
                                                        SARUNG_TANGAN_S Operator7         0.125000
                                                        SARUNG_TANGAN_S Operator8         0.125000
SARUNG_TANGAN_S SETTER_2         WAIT .1346         1   SARUNG_TANGAN_S Operator          0.125000 1
                                                        SARUNG_TANGAN_S Operator2         0.125000
                                                        SARUNG_TANGAN_S Operator3         0.125000
                                                        SARUNG_TANGAN_S Operator4         0.125000
                                                        SARUNG_TANGAN_S Operator5         0.125000
                                                        SARUNG_TANGAN_S Operator6         0.125000
                                                        SARUNG_TANGAN_S Operator7         0.125000
                                                        SARUNG_TANGAN_S Operator8         0.125000
SARUNG_TANGAN_S SETTER_3         WAIT .1346         1   SARUNG_TANGAN_S Operator          0.125000 1
                                                        SARUNG_TANGAN_S Operator2         0.125000
                                                        SARUNG_TANGAN_S Operator3         0.125000
                                                        SARUNG_TANGAN_S Operator4         0.125000
                                                        SARUNG_TANGAN_S Operator5         0.125000
                                                        SARUNG_TANGAN_S Operator6         0.125000
                                                        SARUNG_TANGAN_S Operator7         0.125000
                                                        SARUNG_TANGAN_S Operator8         0.125000
SARUNG_TANGAN_S SETTER_4         wait .1346         1   SARUNG_TANGAN_S Operator          0.125000 1
                                                        SARUNG_TANGAN_S Operator2         0.125000
                                                        SARUNG_TANGAN_S Operator3         0.125000
                                                        SARUNG_TANGAN_S Operator4         0.125000
                                                        SARUNG_TANGAN_S Operator5         0.125000
                                                        SARUNG_TANGAN_S Operator6         0.125000
                                                        SARUNG_TANGAN_S Operator7         0.125000
                                                        SARUNG_TANGAN_S Operator8         0.125000
SARUNG_TANGAN_S Operator         WAIT .175          1   SARUNG_TANGAN_1 EXIT              FIRST 1
SARUNG_TANGAN_S Operator2        wait .175          1   SARUNG_TANGAN_S EXIT              FIRST 1
SARUNG_TANGAN_S Operator3        wait .175          1   SARUNG_TANGAN_S EXIT              FIRST 1
SARUNG_TANGAN_S Operator4        wait .175          1   SARUNG_TANGAN_S Operator5         FIRST 1
SARUNG_TANGAN_S Operator5        wait .175          1   SARUNG_TANGAN_S EXIT              FIRST 1
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SARUNG_TANGAN_S Operator6          wait .175              1    SARUNG_TANGAN_S EXIT                FIRST 1
SARUNG_TANGAN_S Operator7          wait .175              1    SARUNG_TANGAN_S EXIT                FIRST 1
SARUNG_TANGAN_S Operator8          wait .175              1    SARUNG_TANGAN_S EXIT                FIRST 1
SARUNG_TANGAN_M BUFFER_STOCK       accum 86

                                                          1    SARUNG_TANGAN_M MESIN_DOTTING_M1    0.250000 1
                                                               SARUNG_TANGAN_M MESIN_DOTTING_M3    0.250000
                                                               SARUNG_TANGAN_M MESIN_DOTTING_M2    0.250000
                                                               SARUNG_TANGAN_M MESIN_DOTTING_M4    0.250000
SARUNG_TANGAN_M MESIN_DOTTING_M1 wait .0368 accum 24
                                                          1    SARUNG_TANGAN_M SETTER_1            0.250000 1
                                                               SARUNG_TANGAN_M SETTER_2            0.250000
                                                               SARUNG_TANGAN_M SETTER_3            0.250000
                                                               SARUNG_TANGAN_M SETTER_4            0.250000
SARUNG_TANGAN_M MESIN_DOTTING_M2 wait .0368 accum 24
                                                          1    SARUNG_TANGAN_M SETTER_1            0.250000 1
                                                               SARUNG_TANGAN_M SETTER_2            0.250000
                                                               SARUNG_TANGAN_M SETTER_3            0.250000
                                                               SARUNG_TANGAN_M SETTER_4            0.250000
SARUNG_TANGAN_M MESIN_DOTTING_M3 wait .0368 accum 24
                                                          1    SARUNG_TANGAN_M SETTER_1            0.250000 1
                                                               SARUNG_TANGAN_M SETTER_2            0.250000
                                                               SARUNG_TANGAN_M SETTER_3            0.250000
                                                               SARUNG_TANGAN_M SETTER_4            0.250000
SARUNG_TANGAN_M MESIN_DOTTING_M4 wait .0368 accum 24
                                                          1    SARUNG_TANGAN_M SETTER_1            0.250000 1
                                                               SARUNG_TANGAN_M SETTER_2            0.250000
                                                               SARUNG_TANGAN_M SETTER_3            0.250000
                                                               SARUNG_TANGAN_M SETTER_4            0.250000
SARUNG_TANGAN_M SETTER_1           wait .1346             1    SARUNG_TANGAN_M Operator            0.125000 1
                                                               SARUNG_TANGAN_M Operator2           0.125000
                                                               SARUNG_TANGAN_M Operator3           0.125000
                                                               SARUNG_TANGAN_M Operator4           0.125000
                                                               SARUNG_TANGAN_M Operator5           0.125000
                                                               SARUNG_TANGAN_M Operator6           0.125000
                                                               SARUNG_TANGAN_M Operator7           0.125000
                                                               SARUNG_TANGAN_M Operator8           0.125000
SARUNG_TANGAN_M SETTER_2           wait .1346             1    SARUNG_TANGAN_M Operator            0.125000 1
                                                               SARUNG_TANGAN_M Operator2           0.125000
                                                               SARUNG_TANGAN_M Operator3           0.125000
                                                               SARUNG_TANGAN_M Operator4           0.125000
                                                               SARUNG_TANGAN_M Operator5           0.125000
```

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                                                    SARUNG_TANGAN_M Operator6          0.125000
                                                    SARUNG_TANGAN_M Operator7          0.125000
                                                    SARUNG_TANGAN_M Operator8          0.125000
SARUNG_TANGAN_M SETTER_3          wait .1346    1   SARUNG_TANGAN_M Operator           0.125000  1
                                                    SARUNG_TANGAN_M Operator2          0.125000
                                                    SARUNG_TANGAN_M Operator3          0.125000
                                                    SARUNG_TANGAN_M Operator4          0.125000
                                                    SARUNG_TANGAN_M Operator5          0.125000
                                                    SARUNG_TANGAN_M Operator6          0.125000
                                                    SARUNG_TANGAN_M Operator7          0.125000
                                                    SARUNG_TANGAN_M Operator8          0.125000
SARUNG_TANGAN_M SETTER_4          wait .1346    1   SARUNG_TANGAN_M Operator           0.125000  1
                                                    SARUNG_TANGAN_M Operator2          0.125000
                                                    SARUNG_TANGAN_M Operator3          0.125000
                                                    SARUNG_TANGAN_M Operator4          0.125000
                                                    SARUNG_TANGAN_M Operator5          0.125000
                                                    SARUNG_TANGAN_M Operator6          0.125000
                                                    SARUNG_TANGAN_M Operator7          0.125000
                                                    SARUNG_TANGAN_M Operator8          0.125000
SARUNG_TANGAN_M Operator          wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator2         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator3         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator4         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator5         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator6         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator7         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_M Operator8         wait .175     1   SARUNG_TANGAN_M EXIT               FIRST 1
SARUNG_TANGAN_I BUFFER_STOCK

                                  ACCUM 86
                                                1   SARUNG_TANGAN_I MESIN_DOTTING_I    FIRST 1
SARUNG_TANGAN_I MESIN_DOTTING_I   wait .0475 accum 24
                                                1   SARUNG_TANGAN_I SETTER_1           0.250000  1
                                                    SARUNG_TANGAN_I SETTER_2           0.250000
                                                    SARUNG_TANGAN_I SETTER_3           0.250000
                                                    SARUNG_TANGAN_I SETTER_4           0.250000
SARUNG_TANGAN_I SETTER_1          wait .1346    1   SARUNG_TANGAN_I Operator           0.125000  1
                                                    SARUNG_TANGAN_I Operator2          0.125000
                                                    SARUNG_TANGAN_I Operator3          0.125000
                                                    SARUNG_TANGAN_I Operator4          0.125000
                                                    SARUNG_TANGAN_I Operator5          0.125000
```

				SARUNG_TANGAN_L Operator6	0.125000
				SARUNG_TANGAN_L Operator7	0.125000
				SARUNG_TANGAN_L Operator8	0.125000
SARUNG_TANGAN_L SETTER_2	wait .1346	1	SARUNG_TANGAN_L Operator	0.125000	1
			SARUNG_TANGAN_L Operator2	0.125000	
			SARUNG_TANGAN_L Operator3	0.125000	
			SARUNG_TANGAN_L Operator4	0.125000	
			SARUNG_TANGAN_L Operator5	0.125000	
			SARUNG_TANGAN_L Operator6	0.125000	
			SARUNG_TANGAN_L Operator7	0.125000	
			SARUNG_TANGAN_L Operator8	0.125000	
SARUNG_TANGAN_L SETTER_3	wait .1346	1	SARUNG_TANGAN_L Operator	0.125000	1
			SARUNG_TANGAN_L Operator2	0.125000	
			SARUNG_TANGAN_L Operator3	0.125000	
			SARUNG_TANGAN_L Operator4	0.125000	
			SARUNG_TANGAN_L Operator5	0.125000	
			SARUNG_TANGAN_L Operator6	0.125000	
			SARUNG_TANGAN_L Operator7	0.125000	
			SARUNG_TANGAN_L Operator8	0.125000	
SARUNG_TANGAN_L SETTER_4	wait .1346	1	SARUNG_TANGAN_L Operator	0.125000	1
			SARUNG_TANGAN_L Operator2	0.125000	
			SARUNG_TANGAN_L Operator3	0.125000	
			SARUNG_TANGAN_L Operator4	0.125000	
			SARUNG_TANGAN_L Operator5	0.125000	
			SARUNG_TANGAN_L Operator6	0.125000	
			SARUNG_TANGAN_L Operator7	0.125000	
			SARUNG_TANGAN_L Operator8	0.125000	
SARUNG_TANGAN_L Operator	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator2	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator3	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator4	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator5	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator6	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator7	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	
SARUNG_TANGAN_L Operator8	wait .1346	1	SARUNG_TANGAN_L EXIT	FIRST 1	

****

* Arrivals *

****

Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic

SARUNG_TANGAN_S	BUFFER_STOCK	60	inf	1	SEND E(143548.0)	SARUNG_TANGAN_S TO
SARUNG_TANGAN_M	BUFFER_STOCK	60	inf	1	SEND ER(84530.3, 2.0)	SARUNG_TANGAN
SARUNG_TANGAN_L	MESIN_DOTTING_L	60	inf	1	SEND W(1.09025, 47891.8)	SARUNG_TAN

Shift Assigments

Locations	Resources	Shift Files	Priorities	Disable Logic
MESIN_DOTTING_L		C:\My Documents\DEFINESHIFT.sft (0	99,99,99,99	No
MESIN_DOTTING_M1				
MESIN_DOTTING_M2				
MESIN_DOTTING_M3				
MESIN_DOTTING_M4				
MESIN_DOTTING_S				
Operator				
Operator2				
Operator3				
Operator4				
Operator5				
Operator6				
Operator7				
Operator8				
SETTER_1				
SETTER_2				
SETTER_3				
SETTER_4				

External Files

****

ID	Type	File Name	Prompt
(null)	Shift	C:\My Documents\DEFINESHIFT.sft	

General Report
Output from C:\My Documents\TA\modeltarev-1.MOD
Date: Jan/04/2001 Time: 04:33:09 AM

Scenario : Normal Run
Replication : 1 of 1
Simulation Time : 168 hr

LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Minutes Per Entry	Average Contents	Maximum Contents	Current Contents	% Util
MESIN DOTTING M1	168	86	3821	16.095736	6.10137	67	5	7.09
MESIN DOTTING M2	168	86	3932	52.670562	20.5457	72	20	23.89
MESIN DOTTING L	168	86	12618	16.778908	21.0036	86	18	24.42
MESIN DOTTING S	168	86	20551	5.499337	11.212	86	7	13.04
MESIN DOTTING M3	168	86	3953	44.759149	17.5529	71	17	20.41
MESIN DOTTING M4	168	86	3860	53.161004	20.3573	73	20	23.67
SETTER 1	134.2166667	130	12334	4.537605	6.94981	130	0	5.35
SETTER 2	134.2166667	130	12135	4.556991	6.86689	130	0	5.28
SETTER 3	134.2166667	130	12176	4.556428	6.88924	130	0	5.30
SETTER 4	134.2166667	130	12003	4.570447	6.81225	130	0	5.24
Operator	134.2166667	100	6198	4.200000	3.23253	100	0	3.23
Operator2	134.2166667	100	6077	4.200000	3.16943	99	0	3.17
Operator3	134.2166667	100	6000	4.200000	3.12927	100	0	3.13
Operator4	134.2166667	100	6108	6.129071	4.64875	100	0	4.65
Operator5	134.2166667	100	8670	4.200000	4.52179	100	0	4.52
Operator6	134.2166667	100	5999	4.200000	3.12875	100	0	3.13
Operator7	134.2166667	100	6015	4.200000	3.13709	100	0	3.14
Operator8	134.2166667	100	6140	4.200000	3.20228	100	0	3.20
BUFFER STOCK	168	720	49455	146.006693	716.345	720	720	99.49

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location	Scheduled	%	Partially	%	|	%

Name	Hours	Empty	Occupied	Full	Down
MESIN DOTTING M1	168	0.02	99.98	0.00	0.00
MESIN DOTTING M2	168	0.02	99.98	0.00	0.00
MESIN DOTTING L	168	0.03	96.08	3.89	0.00
MESIN DOTTING S	168	0.02	94.69	5.29	0.00
MESIN DOTTING M3	168	0.02	99.98	0.00	0.00
MESIN DOTTING M4	168	0.05	99.95	0.00	0.00
SETTER 1	134.2166667	93.93	0.89	5.18	0.00
SETTER 2	134.2166667	93.93	1.25	4.82	0.00
SETTER 3	134.2166667	93.93	1.35	4.72	0.00
SETTER 4	134.2166667	93.93	1.66	4.41	0.00
Operator	134.2166667	95.44	4.54	0.02	0.00
Operator2	134.2166667	95.44	4.56	0.00	0.00
Operator3	134.2166667	95.44	4.56	0.00	0.00
Operator4	134.2166667	94.65	2.28	3.07	0.00
Operator5	134.2166667	95.29	0.32	4.39	0.00
Operator6	134.2166667	95.44	4.52	0.03	0.00
Operator7	134.2166667	95.44	4.55	0.01	0.00
Operator8	134.2166667	95.44	4.52	0.04	0.00
BUFFER STOCK	168	0.01	3.41	96.58	0.00

FAILED ARRIVALS

Entity Name	Location Name	Total Failed
SARUNG TANGAN S	BUFFER STOCK	583677
SARUNG TANGAN M	BUFFER STOCK	589157
SARUNG TANGAN L	BUFFER STOCK	592111

ENTITY ACTIVITY

Entity Name	Total Exits	Current Quantity In System	Average Minutes In System	Average Minutes In Move Logic	Average Minutes Wait For Res, etc.	Average Minutes In Operation	Average Minutes Blocked
SARUNG TANGAN S	17948	579	20.707059	0.000000	0.937241	8.061830	11.707988
SARUNG TANGAN M	15504	139	12.918755	0.000000	2.122485	7.467000	3.329271