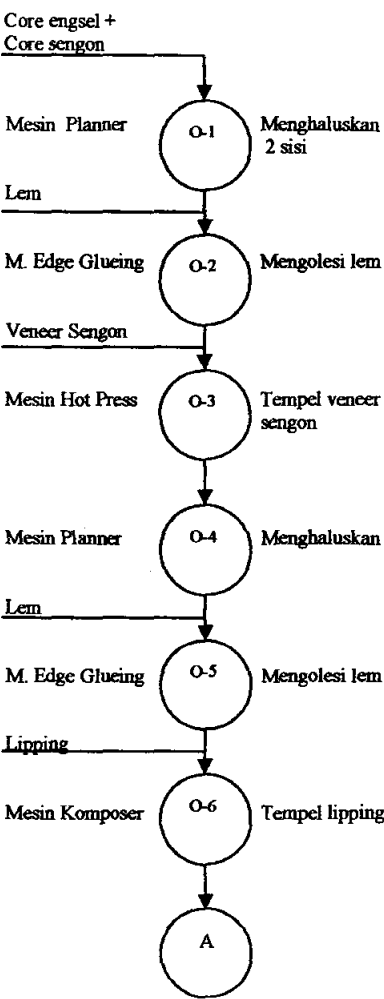


LAMPIRAN

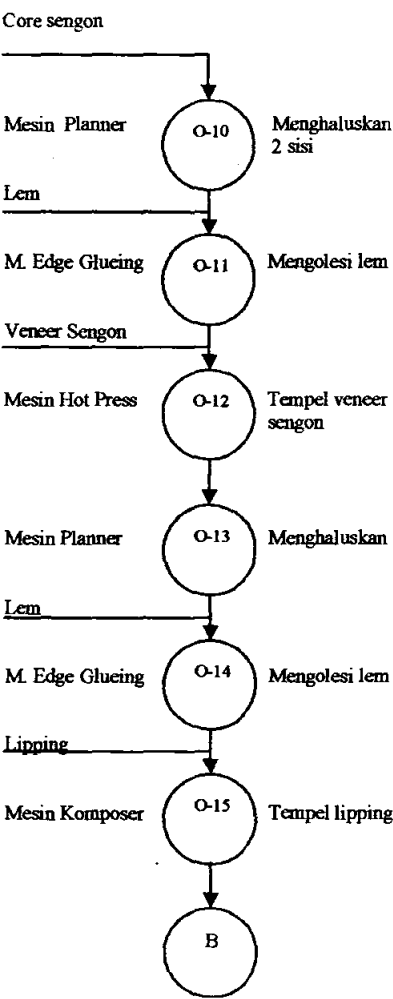
Peta Proses Operasi

Halaman : 1 dari 3
Nama Obyek : Produksi pintu Tulus Door (ED-01)
No. Peta : 1
Dipetakan oleh : Fendy
Tanggal dipetakan : 10 Juli 2004

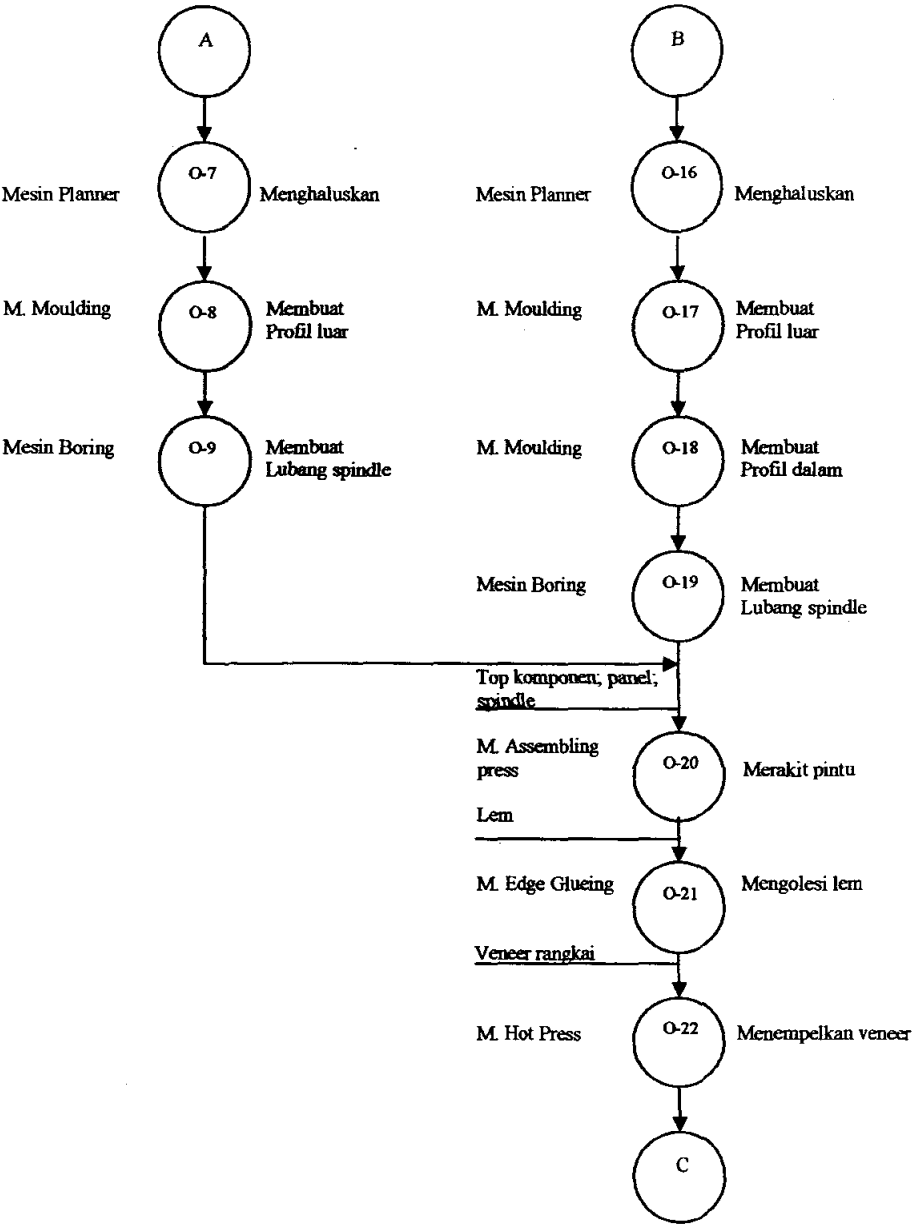
STILE B (Bagian samping kanan & kiri) (2)



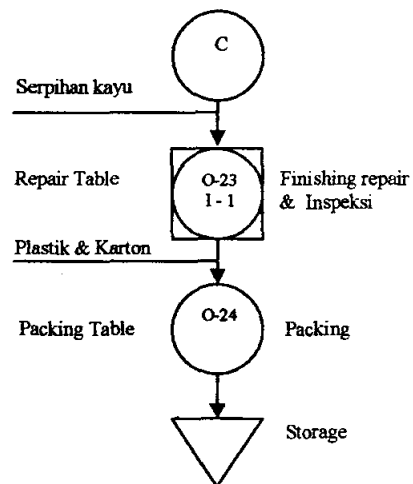
KOMPONEN A (Middle & bottom) (2)



Halaman : 2 dari 3
Nama Obyek : Produksi pintu Tulus Door (ED-01)
No. Peta : 1
Dipetakan oleh : Fendy
Tanggal dipetakan : 10 Juli 2004

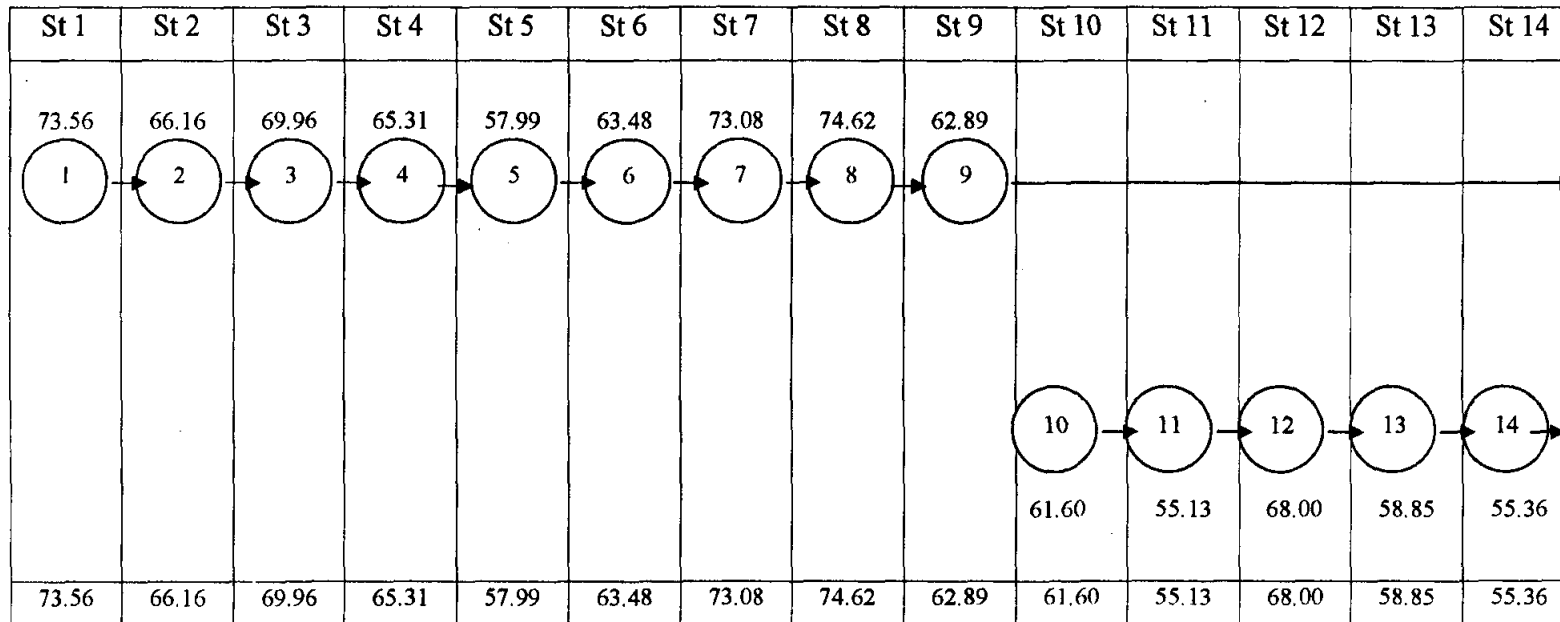


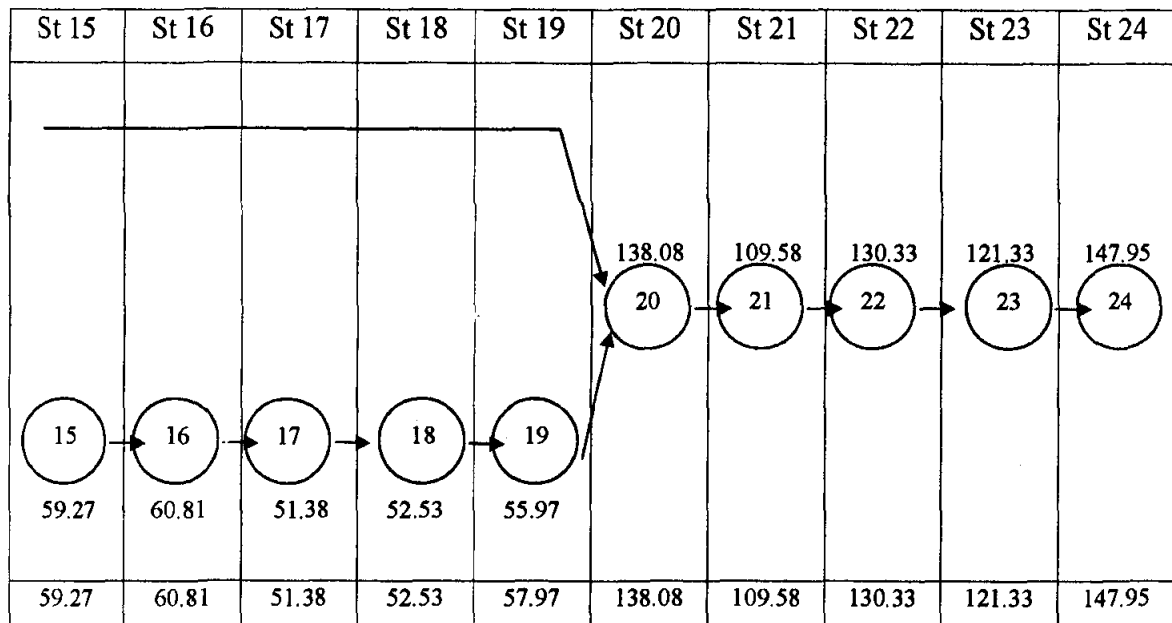
Halaman : 3 dari 3
Nama Obyek : Produksi pintu Tulus Door (ED-01)
No. Peta : 1
Dipetakan oleh : Fendy
Tanggal dipetakan : 10 Juli 2004



LAMPIRAN B

PRECEDENCE DIAGRAM





LAMPIRAN C

DATA WAKTU TIAP STASIUN (DETIK)

St 1	St 2	St 3	St 4	St 5	St 6	St 7	St 8
75.66	63.02	70.20	68.77	55.26	61.70	78.07	78.74
73.27	61.96	68.51	67.76	59.94	61.63	70.60	75.94
72.42	68.48	70.99	65.39	54.03	66.19	72.14	68.83
73.48	66.94	67.79	68.58	58.80	64.49	86.06	73.35
73.31	68.00	73.37	65.11	57.52	61.54	67.52	73.03
72.28	67.91	68.78	64.68	59.79	66.32	74.69	72.64
71.76	62.57	71.54	66.05	55.50	63.39	71.29	75.83
72.71	70.99	70.46	64.74	60.02	65.03	70.96	74.05
73.68	67.65	71.24	67.63	56.21	62.04	72.81	77.16
76.43	65.94	68.43	63.56	58.08	60.22	68.80	71.58
72.47	67.26	68.76	64.13	56.63	66.71	78.69	73.50
76.10	69.04	68.28	64.55	55.83	62.27	71.13	78.00
75.12	65.62	68.37	62.30	59.20	55.79	72.45	71.14
73.30	65.17	69.78	64.65	56.06	69.24	67.79	72.48
77.47	65.21	71.83	63.36	61.15	63.93	74.86	79.84
70.29	64.61	67.71	64.16	58.60	58.62	72.31	72.88
73.36	64.79	69.37	67.33	58.60	61.12	74.50	80.62
71.03	67.68	72.16	64.30	59.68	66.87	71.68	74.52
75.98	66.39	72.05	65.45	60.00	67.17	72.10	74.67
71.04	63.95	69.50	63.63	58.90	65.38	73.31	73.62

St 9	St 10	St 11	St 12	St 13	St 14	St 15	St 16
65.46	60.20	51.14	64.92	56.88	59.62	63.51	57.19
62.86	57.40	54.14	63.66	62.08	57.87	62.11	63.37
62.94	60.61	53.25	65.76	63.31	52.59	65.73	62.11
62.78	64.95	56.49	65.19	61.38	56.31	61.12	64.60
64.47	60.69	55.68	70.36	61.09	56.24	56.03	59.84
65.31	56.75	57.90	69.07	60.61	52.23	42.95	57.19
62.01	64.33	53.85	67.05	67.69	55.90	58.73	63.76
60.13	64.13	53.81	72.94	56.09	56.52	60.79	58.19
66.46	58.35	56.23	70.68	53.29	53.25	61.54	59.37
64.29	63.89	57.32	65.80	60.15	53.19	64.32	63.23
60.20	63.78	54.91	68.45	53.08	55.06	64.36	57.82
62.48	62.42	56.81	70.20	62.48	58.07	57.18	57.38
58.99	60.34	53.43	65.50	63.31	57.53	53.19	59.87
60.75	62.59	56.41	72.38	58.62	53.97	57.37	63.64
64.52	61.59	54.72	69.49	59.13	57.74	52.53	66.39
60.57	64.17	57.21	72.08	57.13	45.06	62.67	59.02
66.31	60.91	53.88	64.41	56.19	59.84	65.20	57.25
62.26	62.35	55.17	66.78	57.66	52.28	50.98	62.96
64.45	61.32	55.26	71.31	51.45	58.00	58.94	65.31
60.58	61.27	54.96	63.99	55.46	55.15	62.79	57.76

St 17	St 18	St 19	St 20	St 21	St 22	St 23	St 24
51.17	51.58	54.42	150.35	120.98	128.32	120.06	158.01
55.00	50.12	53.97	136.32	117.98	134.02	124.71	157.42
50.49	53.84	55.20	147.07	119.66	132.10	118.72	143.27
55.06	52.55	56.39	126.58	120.67	127.93	111.17	147.72
53.58	51.38	57.94	133.97	123.47	128.67	115.57	142.99
51.71	51.81	56.11	132.29	115.26	127.04	109.21	159.01
53.38	54.41	58.24	138.75	121.38	128.61	122.61	139.63
52.66	54.24	58.13	142.48	126.26	124.44	113.54	137.47
46.14	47.76	55.08	126.90	123.02	128.56	126.02	158.98
49.73	50.82	60.75	147.23	115.58	130.03	133.87	145.87
48.03	53.06	55.88	137.06	114.14	126.38	123.26	151.68
49.83	54.91	54.95	128.40	116.53	134.89	121.12	146.53
54.11	54.14	55.49	142.30	120.01	128.86	124.56	150.37
47.92	53.48	52.67	147.47	122.99	129.90	118.80	144.34
51.54	51.36	53.76	135.75	120.97	133.91	119.68	150.07
50.20	52.73	55.87	142.06	122.74	132.68	128.74	129.70
48.59	54.04	58.07	135.78	118.23	134.86	130.94	140.53
51.94	51.80	56.54	137.21	121.05	132.04	119.64	148.60
54.38	53.39	56.49	132.78	114.45	123.61	114.70	149.99
52.10	52.77	53.37	140.83	116.15	124.31	129.76	156.84

LAMPIRAN D

Distribusi Waktu Tiap Stasiun Kerja (Output Minitab)

Distribusi waktu operasi stasiun 1

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.240
Lognormal base e	0.978
Exponential	8.709
Normal	1.000

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	73.4613	0.5319	72.4261	74.511
Lognormal base e	73.5573	0.4301	72.7192	74.405
Exponential	73.5574	16.4479	47.4561	114.015
Normal	73.5574	0.4317	72.7113	74.404

Distribusi waktu operasi stasiun 2

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.782
Lognormal base e	0.700
Exponential	8.585
Normal	0.692

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	66.0592	0.5935	64.9062	67.233
Lognormal base e	66.1591	0.5049	65.1768	67.156
Exponential	66.1591	14.7936	42.6830	102.547
Normal	66.1591	0.5042	65.1709	67.147

Distribusi waktu operasi stasiun 3

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.065
Lognormal base e	0.968
Exponential	8.746
Normal	0.977

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	69.8730	0.4497	68.9971	70.760
Lognormal base e	69.9557	0.3621	69.2497	70.669
Exponential	69.9558	15.6426	45.1325	108.432
Normal	69.9558	0.3635	69.2433	70.668

Distribusi waktu operasi stasiun 4

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.538
Lognormal base e	1.185
Exponential	8.702
Normal	1.223

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	65.2018	0.5055	64.2186	66.200
Lognormal base e	65.3070	0.3939	64.5396	66.084
Exponential	65.3071	14.6031	42.1334	101.227
Normal	65.3071	0.3965	64.5299	66.084

Distribusi waktu operasi stasiun 5

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.896
Lognormal base e	1.073
Exponential	8.602
Normal	1.052

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	57.9984	0.4481	57.1267	58.8833
Lognormal base e	57.9907	0.4352	57.1438	58.8500
Exponential	57.9905	12.9671	37.4130	89.8858
Normal	57.9905	0.4321	57.1437	58.8373

Distribusi waktu operasi stasiun 6

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.780
Lognormal base e	0.803
Exponential	-8.364
Normal	0.781

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	63.4480	0.7599	61.9760	64.9549	
Lognormal base e	63.4831	0.7250	62.0779	64.9201	
Exponential	63.4823	14.1951	40.9561	98.3982	
Normal	63.4823	0.7148	62.0814	64.8832	

Distribusi waktu operasi stasiun 7

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	2.192
Lognormal base e	1.311
Exponential	8.345
Normal	1.442

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	72.5422	1.3473	69.9490	75.232	
Lognormal base e	73.0846	0.8794	71.3812	74.829	
Exponential	73.0872	16.3428	47.1527	113.286	
Normal	73.0872	0.9116	71.3006	74.874	

Distribusi waktu operasi stasiun 8

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.252
Lognormal base e	0.904
Exponential	8.516
Normal	0.944

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	74.4648	0.8171	72.8803	76.084	
Lognormal base e	74.6210	0.6572	73.3440	75.920	
Exponential	74.6212	16.6858	48.1424	115.664	
Normal	74.6212	0.6607	73.3263	75.916	

Distribusi waktu operasi stasiun 9

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.908
Lognormal base e	0.891
Exponential	8.575
Normal	0.888

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	62.8531	0.5428	61.7982	63.9260
Lognormal base e	62.8916	0.4833	61.9514	63.8460
Exponential	62.8915	14.0630	40.5749	97.4825
Normal	62.8915	0.4826	61.9457	63.8373

Distribusi waktu operasi stasiun 10

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.877
Lognormal base e	0.929
Exponential	8.561
Normal	0.904

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	61.6086	0.5188	60.6001	62.6339
Lognormal base e	61.6018	0.5096	60.6109	62.6088
Exponential	61.6015	13.7745	39.7426	95.4829
Normal	61.6015	0.5041	60.6134	62.5896

Distribusi waktu operasi stasiun 11

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.824
Lognormal base e	0.756
Exponential	8.673
Normal	0.751

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	55.1029	0.3979	54.3285	55.8883
Lognormal base e	55.1285	0.3668	54.4144	55.8521
Exponential	55.1284	12.3271	35.5665	85.4496
Normal	55.1284	0.3644	54.4142	55.8426

Distribusi waktu operasi stasiun 12

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.031
Lognormal base e	1.031
Exponential	8.418
Normal	1.035

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	67.9514	0.7530	66.4914	69.443
Lognormal base e	68.0005	0.6625	66.7144	69.311
Exponential	68.0006	15.2054	43.8711	105.402
Normal	68.0006	0.6634	66.7004	69.301

Distribusi waktu operasi stasiun 13

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.808
Lognormal base e	0.702
Exponential	8.086
Normal	0.695

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	58.6954	1.0285	56.7138	60.7462
Lognormal base e	58.8540	0.8846	57.1456	60.6136
Exponential	58.8538	13.1601	37.9700	91.2240
Normal	58.8538	0.8823	57.1246	60.5831

Distribusi waktu operasi stasiun 14

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.799
Lognormal base e	1.143
Exponential	8.318
Normal	1.026

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	55.3691	0.6753	54.0613	56.7085
Lognormal base e	55.3253	0.7716	53.8336	56.8584
Exponential	55.3220	12.3704	35.6914	85.7496
Normal	55.3220	0.7362	53.8790	56.7650

Distribusi waktu operasi stasiun 15

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.834
Lognormal base e	1.311
Exponential	7.819
Normal	1.133

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	59.2743	1.0837	57.1879	61.4369
Lognormal base e	59.1166	1.3480	56.5327	61.8187
Exponential	59.1017	13.2155	38.1299	91.6083
Normal	59.1017	1.2503	56.6512	61.5522

Distribusi waktu operasi stasiun 16

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.257
Lognormal base e	1.322
Exponential	8.323
Normal	1.324

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	60.7441	0.7847	59.2253	62.3018
Lognormal base e	60.8127	0.6755	59.5032	62.1512
Exponential	60.8130	13.5982	39.2339	94.2608
Normal	60.8130	0.6785	59.4832	62.1428

Distribusi waktu operasi stasiun 17

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.727
Lognormal base e	0.736
Exponential	8.378
Normal	0.719

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	51.3675	0.5824	50.2386	52.5217
Lognormal base e	51.3774	0.5539	50.3032	52.4744
Exponential	51.3770	11.4882	33.1462	79.6348
Normal	51.3770	0.5484	50.3020	52.4519

Distribusi waktu operasi stasiun 18

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.727
Lognormal base e	0.919
Exponential	8.658
Normal	0.881

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	52.5318	0.3620	51.8270	53.2461
Lognormal base e	52.5091	0.3836	51.7626	53.2663
Exponential	52.5087	11.7413	33.8764	81.3891
Normal	52.5087	0.3770	51.7698	53.2477

Distribusi waktu operasi stasiun 19

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	1.180
Lognormal base e	0.778
Exponential	8.592
Normal	0.804

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	55.8081	0.5585	54.7241	56.9134
Lognormal base e	55.9656	0.4250	55.1388	56.8049
Exponential	55.9658	12.5143	36.1067	86.7475
Normal	55.9658	0.4280	55.1269	56.8046

Distribusi waktu operasi stasiun 20

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.923
Lognormal base e	0.936
Exponential	8.707
Normal	0.930

Table of MTTF

Distribution	Mean	Standard Error	95% Normal Lower	CI Upper
Weibull	138.075	0.8531	136.413	139.757
Lognormal base e	138.079	0.7981	136.523	139.652
Exponential	138.079	30.8753	89.082	214.023
Normal	138.079	0.7954	136.520	139.638

Distribusi waktu operasi stasiun 21

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.832
Lognormal base e	0.903
Exponential	8.678
Normal	0.889

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	119.468	0.8527	117.808	121.151	
Lognormal base e	119.576	0.7424	118.129	121.039	
Exponential	119.575	26.7379	77.145	185.343	
Normal	119.575	0.7413	118.122	121.028	

Distribusi waktu operasi stasiun 22

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.842
Lognormal base e	1.582
Exponential	8.887
Normal	1.532

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	130.331	0.4337	129.484	131.184	
Lognormal base e	130.248	0.5337	129.207	131.299	
Exponential	130.248	29.1244	84.031	201.886	
Normal	130.248	0.5256	129.218	131.278	

Distribusi waktu operasi stasiun 23

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.823
Lognormal base e	0.977
Exponential	8.543
Normal	0.951

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	121.323	1.0545	119.274	123.408	
Lognormal base e	121.332	1.0034	119.382	123.315	
Exponential	121.332	27.1306	78.278	188.066	
Normal	121.332	0.9966	119.379	123.285	

Distribusi waktu operasi stasiun 24

Distribution ID Plot

Goodness of Fit

Distribution	Anderson-Darling (adj)
Weibull	0.845
Lognormal base e	0.865
Exponential	8.608
Normal	0.849

Table of MTTF

Distribution	Mean	Standard Error	95% Lower	Normal Upper	CI
Weibull	147.947	1.1712	145.669		150.260
Lognormal base e	147.951	1.1395	145.735		150.202
Exponential	147.951	33.0828	95.452		229.325
Normal	147.951	1.1275	145.741		150.161

LAMPIRAN E

DATA WAKTU TRANSPORTASI OPERATOR (MENIT)

St1	St2	St3	St4	St5	St6	St7	St8
8.50	7.89	8.79	8.49	8.63	8.63	8.54	8.29
8.15	8.47	8.11	8.58	8.52	8.85	8.38	8.20
8.36	8.67	8.56	9.00	8.12	8.24	8.65	7.89
8.13	8.69	8.80	8.46	8.55	8.88	8.82	7.91
8.57	8.01	9.01	8.67	8.31	9.15	8.25	7.81
7.64	8.17	8.90	8.69	9.01	8.21	8.96	8.18
8.71	8.28	8.69	9.04	8.05	8.87	8.65	7.77
8.71	8.26	8.55	8.87	8.91	8.24	8.81	8.49
8.84	8.49	8.77	8.44	8.36	8.48	8.17	8.32
8.15	8.34	8.64	8.98	8.29	8.70	8.82	7.99
8.81	8.54	8.62	8.57	8.97	9.00	8.26	8.16
8.80	8.15	8.93	9.42	8.56	8.73	8.89	8.10
9.07	8.15	8.54	8.13	8.63	9.17	8.88	8.16
8.39	8.38	8.47	8.62	8.48	8.48	8.90	8.14
7.94	8.34	9.25	9.38	8.64	9.17	8.73	7.74
8.54	8.98	8.90	8.60	8.43	8.52	8.58	8.09
8.99	8.86	8.70	8.63	8.34	8.50	8.13	8.03
8.82	8.15	9.27	8.41	8.47	8.31	8.78	8.29
8.74	8.14	8.82	8.81	8.28	9.10	8.86	8.38
9.05	7.77	8.91	9.24	8.33	8.88	8.76	7.97

St9	St10	St11	St12	St13	St14	St15	St16
8.60	6.86	6.72	6.39	6.92	6.29	6.71	6.67
8.04	6.44	6.78	6.35	6.64	6.44	6.14	6.50
8.38	6.67	6.69	6.34	6.82	6.41	6.18	6.94
8.68	6.87	6.70	6.28	7.05	6.59	6.53	6.80
8.50	6.20	6.40	6.17	6.59	6.37	6.42	6.78
8.96	7.08	6.94	6.17	6.75	6.32	6.37	7.10
8.93	6.44	6.19	6.26	6.21	6.02	5.72	6.29
7.77	6.80	6.87	6.09	7.17	5.88	6.18	7.21
8.91	6.70	6.50	5.98	6.43	6.04	6.10	6.99
9.14	6.89	6.98	6.05	6.82	5.88	7.06	6.65
9.00	6.62	6.83	6.25	6.56	6.28	6.18	6.74
8.96	6.64	6.38	5.56	6.86	6.38	6.53	6.60
8.86	6.36	6.64	6.76	6.38	6.85	6.77	6.97
8.54	7.14	6.23	6.68	6.94	6.74	6.47	6.62
8.56	6.47	6.66	6.29	6.61	6.94	6.21	7.36
8.60	5.92	6.82	6.57	6.45	6.31	6.03	6.90
9.20	6.35	6.53	6.73	6.21	5.83	6.39	6.67
8.85	6.25	6.82	6.58	7.09	6.25	6.10	6.66
8.49	7.16	6.29	6.42	6.86	6.99	6.84	6.70
8.53	6.80	6.96	6.39	6.38	6.07	5.89	6.43

St17	St18	St19	St20	St21	St22	St23	St24
6.61	6.94	6.84	8.94	9.82	10.02	8.95	9.32
6.73	6.68	7.11	9.45	10.07	9.53	9.02	9.22
5.97	6.46	6.38	9.17	9.77	9.12	9.22	9.06
6.79	6.84	6.88	9.51	9.40	8.92	9.00	9.40
6.11	6.33	6.59	9.44	9.98	8.70	9.49	8.90
6.44	7.21	6.24	9.36	10.42	9.41	9.41	9.38
6.36	6.98	6.41	8.82	10.15	10.09	9.65	9.71
6.98	6.99	6.19	9.14	9.82	9.14	9.28	8.82
6.67	6.73	6.54	9.16	9.74	9.34	9.46	8.66
5.92	6.82	6.73	8.75	10.14	9.00	9.13	9.18
6.33	6.72	6.18	8.86	9.64	9.42	8.85	9.21
6.07	6.64	5.82	8.58	9.62	9.15	8.86	9.47
6.53	6.33	6.94	9.44	9.73	9.22	9.37	9.01
6.27	6.95	6.80	9.19	9.51	8.88	9.34	9.65
6.79	6.53	6.56	8.93	9.93	8.78	9.63	8.51
7.02	6.94	6.78	8.54	9.33	9.19	8.92	9.08
6.17	6.41	6.24	9.05	9.84	8.76	9.78	9.29
6.18	6.78	6.87	8.88	10.37	9.17	9.38	8.94
6.68	6.45	6.97	9.21	9.53	8.90	8.68	8.99
6.63	7.02	5.67	9.13	9.30	9.15	9.86	9.52

```

*****
*
*           Formatted Listing of Model:
*           D:\Fendy\Skripsi1\Skripsiku\MODEL AWAL.MOD
*
*****

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Time Units:           Seconds
Distance Units:       Meters

```

```

*****
*           Locations
*
*****

```

Name	Cap	Units	Stats	Rules	Cost
Planer_A	1	1	Time Series Oldest,		
Core_sengon_A_storage	500	1	Time Series Oldest,		
Buffer_10_11	20	1	Time Series Oldest,		
Edge_Glueing_A	1	1	Time Series Oldest,		
Lem_A_storage	500	1	Time Series Oldest,		
Buffer_11_12	20	1	Time Series Oldest,		
Hot_Press_A	1	1	Time Series Oldest,		
Veneer_sengon_A_storage	500	1	Time Series Oldest,		
Buffer_12_13	20	1	Time Series Oldest,		
Planer_A_2	1	1	Time Series Oldest,		
Edge_Glueing_A_2	1	1	Time Series Oldest,		
Buffer_13_14	20	1	Time Series Oldest,		
Lem_A_storage_2	500	1	Time Series Oldest,		
Komposer_A	1	1	Time Series Oldest,		
Buffer_14_15	20	1	Time Series Oldest,		
Lipping_A_storage	500	1	Time Series Oldest,		
Buffer_15_16	20	1	Time Series Oldest,		
Planer_A_3	1	1	Time Series Oldest,		
Buffer_16_17	20	1	Time Series Oldest,		
Moulding_A	1	1	Time Series Oldest,		
Buffer_17_18	20	1	Time Series Oldest,		
Moulding_A_2	1	1	Time Series Oldest,		
Buffer_18_19	20	1	Time Series Oldest,		
Boring_A	1	1	Time Series Oldest,		
Buffer_19_20	10	1	Time Series Oldest,		
Assembling_press	2	1	Time Series Oldest,	First	
Buffer_20_21	10	1	Time Series Oldest,		
Edge_Glueing_pintu	1	1	Time Series Oldest,		
Buffer_21_22	10	1	Time Series Oldest,		
Hot_press_pintu	1	1	Time Series Oldest,		
Veneer_rangka1_storage	250	1	Time Series Oldest,		
Buffer_22_23	10	1	Time Series Oldest,		
Repair_inspeksi_table	1	1	Time Series Oldest,		

LAMPIRAN F

Serpihan_kayu_storage	250	1	Time Series Oldest,	,
Buffer_23_24	10	1	Time Series Oldest,	,
Packing_table	1	1	Time Series Oldest,	,
Boring_B	1	1	Time Series Oldest,	,
Buffer_9_20	10	1	Time Series Oldest,	,
Buffer_8_9	20	1	Time Series Oldest,	,
Moulding_B	1	1	Time Series Oldest,	,
Buffer_7_8	20	1	Time Series Oldest,	,
Planer_B_3	1	1	Time Series Oldest,	,
Buffer_6_7	20	1	Time Series Oldest,	,
Komposer_B	1	1	Time Series Oldest,	,
Lipping_B_storage	500	1	Time Series Oldest,	,
Edge_glueing_B_2	1	1	Time Series Oldest,	,
Buffer_5_6	20	1	Time Series Oldest,	,
Lem_B_Storage_2	500	1	Time Series Oldest,	,
Buffer_4_5	20	1	Time Series Oldest,	,
Planer_B_2	1	1	Time Series Oldest,	,
Buffer_3_4	20	1	Time Series Oldest,	,
Hot_press_B	1	1	Time Series Oldest,	,
Veneer_sengon_B_storage	500	1	Time Series Oldest,	,
Buffer_2_3	20	1	Time Series Oldest,	,
Edge_glueing_B	1	1	Time Series Oldest,	,
Lem_B_storage	500	1	Time Series Oldest,	,
Buffer_1_2	20	1	Time Series Oldest,	,
Planer_B	1	1	Time Series Oldest,	,
Core_engsel_dan_sengon_storage	500	1	Time Series Oldest,	,
Lem_pintu_storage	250	1	Time Series Oldest,	,
karton_dan_plastik_storage	250	1	Time Series Oldest,	,
Komponen_panel_spindle_storage	250	1	Time Series Oldest,	,
Buffer_Akhir	250	1	Time Series Oldest,	,

 * Entities *

Name	Speed (mpm)	Stats	Cost
Core_engsel_core_sengon	50	Time Series	
Lem_B_1	50	Time Series	
Veneer_sengon_B	50	Time Series	
Lem_B_2	50	Time Series	
Lipping_B	50	Time Series	
Core_sengon_A	50	Time Series	
Lem_A_1	50	Time Series	
Lem_A_2	50	Time Series	
Lem_pintu	50	Time Series	
veneer_sengon_A	50	Time Series	
Lipping_A	50	Time Series	
Veneer_rangkai	50	Time Series	

Serpihan_kayu	50	Time Series
Komponen_A	50	Time Series
Stile_B	50	Time Series
Pintu	50	Time Series
sepasang_komponen_A	50	Time Series
sepasang_stile_B	50	Time Series
Karton_dan_plastik	50	Time Series
Komponen_panel_spindle	50	Time Series
Pintu_slap_jual	50	Time Series

 * Path Networks *

Name	Type	T/S	From	To	BI	Dist/Time	Speed Factor
Net_st10	Non-Passing Time		N1	N2	Bi	3.32	
			N1	N3	Bi	3.32	
Net_st11	Non-Passing Time		N1	N2	Bi	3.32	
			N2	N3	Bi	3.32	
Net_st12	Non-Passing Time		N1	N2	Bi	3.16	
			N2	N3	Bi	3.16	
Net_st13	Non-Passing Time		N1	N2	Bi	3.34	
			N2	N3	Bi	3.34	
Net_st14	Non-Passing Time		N1	N2	Bi	3.17	
			N2	N3	Bi	3.17	
Net_st15	Non-Passing Time		N1	N2	Bi	3.15	
			N2	N3	Bi	3.15	
Net_st16	Non-Passing Time		N1	N2	Bi	3.39	
			N2	N3	Bi	3.39	
Net_st17	Non-Passing Time		N1	N2	Bi	3.23	
			N2	N3	Bi	3.23	
Net_st18	Non-Passing Time		N1	N2	Bi	3.37	
			N2	N3	Bi	3.37	
Net_st19	Non-Passing Time		N1	N2	Bi	3.27	
			N2	N3	Bi	3.27	
Net_st1	Non-Passing Time		N1	N2	Bi	4.27	
			N1	N3	Bi	4.27	
Net_st2	Non-Passing Time		N1	N2	Bi	4.17	
			N2	N3	Bi	4.17	
Net_st3	Non-Passing Time		N1	N2	Bi	4.38	
			N2	N3	Bi	4.38	
Net_st4	Non-Passing Time		N1	N2	Bi	4.38	
			N2	N3	Bi	4.38	
Net_st5	Non-Passing Time		N1	N2	Bi	4.25	
			N2	N3	Bi	4.25	
Net_st6	Non-Passing Time		N1	N2	Bi	4.35	
			N2	N3	Bi	4.35	
Net_st7	Non-Passing Time		N1	N2	Bi	4.32	

Net_st8 Non-Passing Time	N2	N3	B1	4.32
	N1	N2	B1	4.05
Net_st9 Non-Passing Time	N2	N3	B1	4.05
	N1	N2	B1	4.34
Net_st20 Non-Passing Time	N2	N3	B1	4.34
	N1	N2	B1	4.54
Net_st21 Non-Passing Time	N2	N3	B1	4.54
	N4	N2	B1	4.54
Net_st22 Non-Passing Time	N1	N2	B1	4.90
	N2	N3	B1	4.90
Net_st23 Non-Passing Time	N1	N2	B1	4.60
	N2	N3	B1	4.60
Net_st24 Non-Passing Time	N1	N2	B1	4.63
	N2	N3	B1	4.63
Net_st24 Non-Passing Time	N1	N2	B1	4.58
	N2	N3	B1	4.58

 * Interfaces *

Net	Node	Location
Net_st10	N1	Planer_A
	N2	Buffer_10_11
	N3	Core_sengon_A_storage
Net_st11	N1	Buffer_10_11
	N2	Edge_Glueing_A
	N3	Buffer_11_12
Net_st12	N1	Buffer_11_12
	N2	Hot_Press_A
	N3	Buffer_12_13
Net_st13	N1	Buffer_12_13
	N2	Planer_A_2
	N3	Buffer_13_14
Net_st14	N1	Buffer_13_14
	N2	Edge_Glueing_A_2
	N3	Buffer_14_15
Net_st15	N1	Buffer_14_15
	N2	Komposer_A
	N3	Buffer_15_16
Net_st16	N1	Buffer_15_16
	N2	Planer_A_3
	N3	Buffer_16_17
Net_st17	N1	Buffer_16_17
	N2	Moulding_A
	N3	Buffer_17_18
Net_st18	N1	Buffer_17_18
	N2	Moulding_A_2

Net_st19	N3	Buffer_18_19
	N1	Buffer_18_19
	N2	Boring_A
Net_st1	N3	Buffer_19_20
	N1	Planer_B
	N2	Buffer_1_2
Net_st2	N3	Core_engsel_dan_sengon_storage
	N1	Buffer_1_2
	N2	Edge_glueing_B
Net_st3	N3	Buffer_2_3
	N1	Buffer_2_3
	N2	Hot_press_B
Net_st4	N3	Buffer_3_4
	N1	Buffer_3_4
	N2	Planer_B_2
Net_st5	N3	Buffer_4_5
	N1	Buffer_4_5
	N2	Edge_glueing_B_2
Net_st6	N3	Buffer_5_6
	N1	Buffer_5_6
	N2	Komposer_B
Net_st7	N3	Buffer_6_7
	N1	Buffer_6_7
	N2	Planer_B_3
Net_st8	N3	Buffer_7_8
	N1	Buffer_7_8
	N2	Moulding_B
Net_st9	N3	Buffer_8_9
	N1	Buffer_8_9
	N2	Boring_B
Net_st20	N3	Buffer_9_20
	N1	Buffer_19_20
	N2	Assembling_press
Net_st21	N3	Buffer_20_21
	N4	Buffer_9_20
	N1	Buffer_20_21
Net_st22	N2	Edge_Glueing_pintu
	N3	Buffer_21_22
	N1	Buffer_21_22
Net_st23	N2	Hot_press_pintu
	N3	Buffer_22_23
	N1	Buffer_22_23
Net_st24	N2	Repair_inspeksi_table
	N3	Buffer_23_24
	N1	Buffer_23_24
	N2	Packing_table
	N3	Buffer_Akhir

Resources

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*****
Name      Units Stats  Res  Ent  Search Path  Motion  Cost
-----
Operator_st10 1  By Unit  Closest Oldest Net_st10 Empty: 50 mpm
                  Home: N1 Full: 50 mpm

Operator_st11 1  By Unit  Closest Oldest Net_st11 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st12 1  By Unit  Closest Oldest Net_st12 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st13 1  By Unit  Closest Oldest Net_st13 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st14 1  By Unit  Closest Oldest Net_st14 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st15 1  By Unit  Closest Oldest Net_st15 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st16 1  By Unit  Closest Oldest Net_st16 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st17 1  By Unit  Closest Oldest Net_st17 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st18 1  By Unit  Closest Oldest Net_st18 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st19 1  By Unit  Closest Oldest Net_st19 Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st1 1  By Unit  Closest Oldest Net_st1  Empty: 50 mpm
                  Home: N1 Full: 50 mpm

Operator_st2 1  By Unit  Closest Oldest Net_st2  Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st3 1  By Unit  Closest Oldest Net_st3  Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st4 1  By Unit  Closest Oldest Net_st4  Empty: 50 mpm
                  Home: N2 Full: 50 mpm

Operator_st5 1  By Unit  Closest Oldest Net_st5  Empty: 50 mpm
                  Home: N2 Full: 50 mpm
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Operator_st6	1	By Unit	Closest	Oldest	Net_st6 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st7	1	By Unit	Closest	Oldest	Net_st7 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st8	1	By Unit	Closest	Oldest	Net_st8 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st9	1	By Unit	Closest	Oldest	Net_st9 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st20	1	By Unit	Closest	Oldest	Net_st20 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st21	1	By Unit	Closest	Oldest	Net_st21 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st22	1	By Unit	Closest	Oldest	Net_st22 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st23	1	By Unit	Closest	Oldest	Net_st23 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st24	1	By Unit	Closest	Oldest	Net_st24 Home: N2 (Return)	Empty: 50 mpm Full: 50 mpm

 * Processing *

Process			Routing				
Entity	Location	Operation	Blk	Output	Destination	Rule	Move Logic
Core_engsel_core_sengon	Core_engsel_dan_sengon_storage		1	Core_engsel_core_sengon	Planer_B	FIRST 1	MOVE WITH Operator_st1 THEN FREE
Core_engsel_core_sengon	Planer_B	get Operator_st1 WAIT L(73.5573, 1.9807) free Operator_st1	1	Stile_B	Buffer_1_2	FIRST 1	MOVE WITH Operator_st1 THEN FREE
Stile_B	Buffer_1_2		1	Stile_B	Edge_glueing_B	FIRST 1	MOVE WITH Operator_st2 THEN FREE
Lem_B_1	Lem_B_storage		1	Lem_B_1	Edge_glueing_B	JOIN 1	
Stile_F	Edge_glueing_B	JOIN 1 Lem_B_1 get Operator_st2					

		free Operator_st8			
		1	Stile_B	Buffer_8_9	FIRST 1 MOVE WITH Operator_st8 THEN FREE
Stile_B	Buffer_8_9	1	Stile_B	Boring_B	FIRST 1 MOVE WITH Operator_st9 THEN FREE
Stile_B	Boring_B	get Operator_st9			
		WAIT N(62.8915, 2.2141)			
		free Operator_st9			
		1	Stile_B	Buffer_9_20	FIRST 1 MOVE WITH Operator_st9 THEN FREE
Core_sengon_A	Core_sengon_A_storage	1	Core_sengon_A	Planer_A	FIRST 1 MOVE WITH Operator_st10 THEN
FREE					
Core_sengon_A	Planer_A	GET Operator_st10			
		WAIT N(61.6015, 2.3132)			
		FREE Operator_st10			
		1	Komponen_A	Buffer_10_11	FIRST 1 MOVE WITH Operator_st10 THEN
FREE					
Komponen_A	Buffer_10_11	1	Komponen_A	Edge_Glueing_A	FIRST 1 MOVE WITH Operator_st11 THEN
FREE					
Lem_A_1	Lem_A_storage	1	Lem_A_1	Edge_Glueing_A	JOIN 1
Komponen_A	Edge_Glueing_A	JOIN 1 Lem_A_1			
		get Operator_st11			
		WAIT N(55.1284, 1.6720)			
		free Operator_st11			
		1	Komponen_A	Buffer_11_12	FIRST 1 MOVE WITH Operator_st11 THEN
FREE					
Komponen_A	Buffer_11_12	1	Komponen_A	Hot_Press_A	FIRST 1 MOVE WITH Operator_st12 THEN
FREE					
veneer_sengon_A	Veneer_sengon_A_storage	1	veneer_sengon_A	Hot_Press_A	JOIN 1
Komponen_A	Hot_Press_A	JOIN 1 veneer_sengon_A			
		get Operator_st12			
		WAIT L(68.0005, 3.0438)			
		free Operator_st12			
		1	Komponen_A	Buffer_12_13	FIRST 1 MOVE WITH Operator_st12 THEN
FREE					
Komponen_A	Buffer_12_13	1	Komponen_A	Planer_A_2	FIRST 1 MOVE WITH Operator_st13 THEN
FREE					
Komponen_A	Planer_A_2	get Operator_st13			
		WAIT N(58.8538, 4.0483)			
		free Operator_st13			

FREE		1	Komponen_A	Buffer_13_14	FIRST 1 MOVE WITH Operator_st13 THEN
Komponen_A FREE	Buffer_13_14	1	Komponen_A	Edge_Glueing_A_2	FIRST 1 MOVE WITH Operator_st14 THEN
Lem_A_2 Komponen_A	Lem_A_storage_2 Edge_Glueing_A_2	1	Lem_A_2	Edge_Glueing_A_2	JOIN 1
					JOIN 1 Lem_A_2 get Operator_st14 WAIT W(22.628, 56.710) free Operator_st14
FREE		1	Komponen_A	Buffer_14_15	FIRST 1 MOVE WITH Operator_st14 THEN
Komponen_A FREE	Buffer_14_15	1	Komponen_A	Komposer_A	FIRST 1 MOVE WITH Operator_st15 THEN
Lipping_A Komponen_A	Lipping_A_storage Komposer_A	1	Lipping_A	Komposer_A	JOIN 1
					JOIN 1 Lipping_A get Operator_st15 WAIT W(14.9216, 61.393) free Operator_st15
FREE		1	Komponen_A	Buffer_15_16	FIRST 1 MOVE WITH Operator_st15 THEN
Komponen_A FREE	Buffer_15_16	1	Komponen_A	Planer_A_3	FIRST 1 MOVE WITH Operator_st16 THEN
Komponen_A	Planer_A_3				get Operator_st16 WAIT L(60.8127, 3.1131) free Operator_st16
FREE		1	Komponen_A	Buffer_16_17	FIRST 1 MOVE WITH Operator_st16 THEN
Komponen_A FREE	Buffer_16_17	1	Komponen_A	Moulding_A	FIRST 1 MOVE WITH Operator_st17 THEN
Komponen_A	Moulding_A				get Operator_st17 WAIT N(51.3770, 2.5164) free Operator_st17
FREE		1	Komponen_A	Buffer_17_18	FIRST 1 MOVE WITH Operator_st17 THEN
Komponen_A FREE	Buffer_17_18	1	Komponen_A	Moulding_A_2	FIRST 1 MOVE WITH Operator_st18 THEN
Komponen_A	Moulding_A_2				get Operator_st18 WAIT W(40.692, 53.256) free Operator_st18

FREE			1	Komponen_A	Buffer_18_19	FIRST 1 MOVE WITH Operator_st18 THEN
Komponen_A FREE	Buffer_18_19		1	Komponen_A	Boring_A	FIRST 1 MOVE WITH Operator_st19 THEN
Komponen_A	Boring_A	get Operator_st19 WAIT L(55.9656, 1.9637) free Operator_st19				
FREE			1	Komponen_A	Buffer_19_20	FIRST 1 MOVE WITH Operator_st19 THEN
Komponen_A FREE	Buffer_19_20	COMBINE 2	1	sepasang_komponen_A	Assembling_press	FIRST 1 MOVE WITH Operator_st20 THEN
Stile_B	Buffer_9_20	COMBINE 2				
FREE			1	sepasang_stile_B	Assembling_press	FIRST 1 MOVE WITH Operator_st20 THEN
ALL	Assembling_press	COMBINE 2 GET Operator_st20 WAIT N(138.079, 6.9183) FREE Operator_st20				
FREE			1	Pintu	Buffer_20_21	FIRST 1 MOVE WITH Operator_st20 THEN
Pintu	Buffer_20_21		1	Pintu	Edge_Glueing_pintu	FIRST 1 MOVE WITH Operator_st21 THEN FREE
Lem_pintu Pintu	Lem_pintu_storage Edge_Glueing_pintu	JOIN 1 Lem_pintu get Operator_st21 WAIT N(109.575, 3.4015) free Operator_st21	1	Lem_pintu	Edge_Glueing_pintu	JOIN 1
FREE			1	Pintu	Buffer_21_22	FIRST 1 MOVE WITH Operator_st21 THEN
Pintu FREE	Buffer_21_22		1	Pintu	Hot_press_pintu	FIRST 1 MOVE WITH Operator_st22 THEN
Veneer_rangkai Pintu	Veneer_rangkai_storage Hot_press_pintu	JOIN 1 Veneer_rangkai get Operator_st22 WAIT W(42.146, 131.21) free Operator_st22	1	Veneer_rangkai	Hot_press_pintu	JOIN 1

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FREE                                1  Pintu                                Buffer_22_23                FIRST 1  MOVE WITH Operator_st22 THEN

Pintu                                Buffer_22_23                1  Pintu                                Repair_inspeksi_table FIRST 1  MOVE WITH Operator_st23 THEN
FREE

Serpihan_kayu                        Serpihan_kayu_storage      1  Serpihan_kayu                Repair_inspeksi_table JOIN 1
Pintu                                Repair_inspeksi_table      JOIN 1 Serpihan_kayu
                                get Operator_st23
                                WAIT N(121.332, 6.6225)
                                free Operator_st23

FREE                                1  Pintu                                Buffer_23_24                FIRST 1  MOVE WITH Operator_st23 THEN

Pintu                                Buffer_23_24                1  Pintu                                Packing_table                FIRST 1  MOVE WITH Operator_st24 THEN
FREE

Karton_dan_plastik                  karton_dan_plastik_storage  1  Karton_dan_plastik            Packing_table                JOIN 1
Pintu                                Packing_table              JOIN 1 Karton_dan_plastik
                                get Operator_st24
                                WAIT N(147.951, 7.8668)
                                free Operator_st24

FREE                                1  Pintu                                Buffer_Akhir                FIRST 1  MOVE WITH Operator_st24 THEN

Pintu                                Buffer_Akhir                1  Pintu_siap_jual              EXIT                          FIRST 1

```

```

*****
*                               Arrivals                               *
*****

```

Entity	Location	Qty each	First	Time	Occurrences	Frequency	Logic
Core_engsel_core_sengon	Core_engsel_dan_sengon_storage	500	0		inf	86400	
Lem_B_1	Lem_B_storage	500	0		inf	86400	
Veneer_sengon_B	Veneer_sengon_B_storage	500	0		inf	86400	
Lem_B_2	Lem_B_Storage_2	500	0		inf	86400	
Lipping_B	Lipping_B_storage	500	0		inf	86400	
Core_sengon_A	Core_sengon_A_storage	500	0		inf	86400	
Lem_A_1	Lem_A_storage	500	0		inf	86400	
veneer_sengon_A	Veneer_sengon_A_storage	500	0		inf	86400	
Lem_A_2	Lem_A_storage_2	500	0		inf	86400	
Lipping_A	Lipping_A_storage	500	0		inf	86400	
Lem_pintu	Lem_pintu_storage	250	0		inf	86400	
Veneer_rangkai	Veneer_rangkai_storage	250	0		inf	86400	
Serpihan_kayu	Serpihan_kayu_storage	250	0		inf	86400	
Karton_dan_plastik	karton_dan_plastik_storage	250	0		inf	86400	

```

*****
*                               Shift Assignments                               *
*****

```

Locations	Resources	Shift Files	Priorities	Disable Logic
	Operator_st10	D:\Fendy\Skripsi\Skripsiku\jam	99,99,99,99	No
	Operator_st19			
	Operator_st1			
	Operator_st2			
	Operator_st3			
	Operator_st4			
	Operator_st5			
	Operator_st6			
	Operator_st7			
	Operator_st8			
	Operator_st9			
	Operator_st11			
	Operator_st20			
	Operator_st21			
	Operator_st22			
	Operator_st23			
	Operator_st24			
	Operator_st12			
	Operator_st13			
	Operator_st14			
	Operator_st15			
	Operator_st16			
	Operator_st17			
	Operator_st18			

```

*****
*                               External Files                               *
*****

```

ID	Type	File Name	Prompt
{null}	Shift	D:\Fendy\Skripsi\Skripsiku\jam kerja.sft	

General Report

Output from D:\Fendy\Skripsi\Skripsiku\MODEL AWAL.MOD

Date: Nov/29/2004 Time: 10:39:09 PM

Scenario : Normal Run
Replication : Average
Period : Final Report (0 sec to 9 hr Elapsed: 9 hr)
Simulation Time : 9 hr

LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Seconds Per Entry	Average Contents	Maximum Contents	Current Contents	% Util	
Planer A	9	1	379.4	70.068541	0.820474	1	0.85	82.05	(Average)
Planer A	0	0	0.598243	2.964365	0.0342863	0	0.366348	3.43	(Std. Dev.)
Core sengon A storage	9	500	500	20093.603520	310.086	500	120.6	62.02	(Average)
Core sengon A storage	0	0	0	25.185252	0.388661	0	0.598243	0.08	(Std. Dev.)
Buffer 10 11	9	20	378.5	8.173222	0.0954954	1	0.15	0.48	(Average)
Buffer 10 11	0	0	0.606977	2.917775	0.0341699	0	0.366348	0.17	(Std. Dev.)
Edge Glueing A	9	1	378.35	63.190611	0.737892	1	0.75	73.79	(Average)
Edge Glueing A	0	0	0.587143	3.483217	0.0404372	0	0.444262	4.04	(Std. Dev.)
Lem A storage	9	500	500	20161.139400	311.129	500	121.65	62.23	(Average)
Lem A storage	0	0	0	25.173310	0.388477	0	0.587143	0.08	(Std. Dev.)
Buffer 11 12	9	20	377.5	814.584995	9.49111	19.45	19.05	47.46	(Average)
Buffer 11 12	0	0	0.512989	50.939109	0.597027	0.686333	0.686333	2.99	(Std. Dev.)
Hot Press A	9	1	358.4	77.016567	0.851913	1	0.85	85.19	(Average)
Hot Press A	0	0	0.820783	3.141161	0.0342434	0	0.366348	3.42	(Std. Dev.)
Veneer sengon A storage	9	500	500	20828.848140	321.433	500	141.6	64.29	(Average)
Veneer sengon A storage	0	0	0	29.707962	0.458456	0	0.820783	0.09	(Std. Dev.)
Buffer 12 13	9	20	357.55	8.432524	0.0930713	1	0.1	0.47	(Average)
Buffer 12 13	0	0	0.686333	3.108733	0.0343856	0	0.307794	0.17	(Std. Dev.)
Planer A 2	9	1	357.25	67.407457	0.74323	1	0.55	74.32	(Average)
Planer A 2	0	0	0.910465	3.717744	0.0406784	0	0.510418	4.07	(Std. Dev.)
Edge Glueing A 2	9	1	356.55	64.918062	0.714392	1	0.85	71.44	(Average)
Edge Glueing A 2	0	0	0.686333	2.295898	0.0251076	0	0.366348	2.51	(Std. Dev.)
Buffer 13 14	9	20	356.65	6.541125	0.0720083	1	0.1	0.36	(Average)
Buffer 13 14	0	0	0.67082	2.254160	0.0248533	0	0.307794	0.12	(Std. Dev.)
Lem A storage 2	9	500	500	20952.336240	323.339	500	143.45	64.67	(Average)
Lem A storage 2	0	0	0	29.871277	0.460976	0	0.686333	0.09	(Std. Dev.)
Komposer A	9	1	355.7	66.757598	0.732914	1	0.85	73.29	(Average)

Komposer A	0	0	0.656947	4.473855	0.0494627	0	0.366348	4.95	(Std. Dev.)
Buffer 14 15	9	20	355.7	6.762090	0.074237	1	0	0.37	(Average)
Buffer 14 15	0	0	0.656947	0.097156	0.00108653	0	0	0.01	(Std. Dev.)
Lipping A storage	9	500	500	21007.707780	324.193	500	144.3	64.84	(Average)
Lipping A storage	0	0	0	30.143440	0.465177	0	0.656947	0.09	(Std. Dev.)
Buffer 15 16	9	20	354.85	11.278318	0.123497	1	0.1	0.62	(Average)
Buffer 15 16	0	0	0.74516	3.778924	0.0412612	0	0.307794	0.21	(Std. Dev.)
Planer A 3	9	1	354.7	69.888627	0.765113	1	0.8	76.51	(Average)
Planer A 3	0	0	0.656947	3.154263	0.0346593	0	0.410391	3.47	(Std. Dev.)
Buffer 16 17	9	20	353.8	7.010842	0.0765472	1	0	0.38	(Average)
Buffer 16 17	0	0	0.695852	3.133932	0.0341739	0	0	0.17	(Std. Dev.)
Moulding A	9	1	353.75	58.918315	0.643295	1	0.75	64.33	(Average)
Moulding A	0	0	0.71635	4.520539	0.0495357	0	0.444262	4.95	(Std. Dev.)
Buffer 17 18	9	20	352.95	7.749259	0.0844176	1	0.05	0.42	(Average)
Buffer 17 18	0	0	0.759155	2.278066	0.0248232	0	0.223607	0.12	(Std. Dev.)
Moulding A 2	9	1	352.85	59.640102	0.649507	1	0.65	64.95	(Average)
Moulding A 2	0	0	0.67082	4.845087	0.0527909	0	0.48936	5.28	(Std. Dev.)
Buffer 18 19	9	20	352.15	7.112943	0.0773204	1	0	0.39	(Average)
Buffer 18 19	0	0	0.875094	3.155290	0.0343509	0	0	0.17	(Std. Dev.)
Boring A	9	1	352.05	63.591728	0.690911	1	0.7	69.09	(Average)
Boring A	0	0	0.887041	4.554083	0.0486933	0	0.470162	4.87	(Std. Dev.)
Buffer 19 20	9	10	351.35	114.479455	1.24141	3.9	1.35	12.41	(Average)
Buffer 19 20	0	0	0.875094	9.680134	0.104801	0.307794	0.875094	1.05	(Std. Dev.)
Assembling press	9	2	327.95	161.654229	1.63624	2	1.85	81.81	(Average)
Assembling press	0	0	0.223607	6.558421	0.066202	0	0.48936	3.31	(Std. Dev.)
Buffer 20 21	9	10	163	10.673926	0.0536991	1	0	0.54	(Average)
Buffer 20 21	0	0	0	4.934440	0.0248245	0	0	0.25	(Std. Dev.)
Edge Glueing pintu	9	1	163	129.276258	0.650371	1	0.65	65.04	(Average)
Edge Glueing pintu	0	0	0	6.863617	0.0345299	0	0.48936	3.45	(Std. Dev.)
Buffer 21 22	9	10	162.3	9.607027	0.0481241	1	0.15	0.48	(Average)
Buffer 21 22	0	0	0.470162	0.042001	0.000249836	0	0.366348	0.00	(Std. Dev.)
Hot press pintu	9	1	162.15	150.286117	0.75213	1	0.8	75.21	(Average)
Hot press pintu	0	0	0.366348	4.986773	0.0250963	0	0.410391	2.51	(Std. Dev.)
Veneer rangkai storage	9	250	250	22287.641400	171.973	250	87.85	68.79	(Average)
Veneer rangkai storage	0	0	0	15.909664	0.12276	0	0.366348	0.05	(Std. Dev.)
Buffer 22 23	9	10	161.35	9.612236	0.0478685	1	0	0.48	(Average)
Buffer 22 23	0	0	0.48936	0.044799	0.000298112	0	0	0.00	(Std. Dev.)
Repair inspeksi table	9	1	161.35	137.732887	0.685891	1	0.7	68.59	(Average)
Repair inspeksi table	0	0	0.48936	10.055289	0.0499766	0	0.470162	5.00	(Std. Dev.)
Serpihan kayu storage	9	250	250	22397.517000	172.82	250	88.65	69.13	(Average)
Serpihan kayu storage	0	0	0	17.142713	0.132274	0	0.48936	0.05	(Std. Dev.)
Buffer 23 24	9	10	160.6	22.440043	0.111258	1	0.15	1.11	(Average)
Buffer 23 24	0	0	0.502625	6.270022	0.0312244	0	0.366348	0.31	(Std. Dev.)
Packing table	9	1	160.45	168.756483	0.835683	1	0.8	83.57	(Average)
Packing table	0	0	0.510418	5.087312	0.0244973	0	0.410391	2.45	(Std. Dev.)

Boring B	9	1	307.7	72.200084	0.685656	1	0.55	68.57	(Average)
Boring B	0	0	0.656947	4.848757	0.045765	0	0.510418	4.58	(Std. Dev.)
Buffer 9 20	9	10	307.1	122.643549	1.16241	3.1	1.2	11.62	(Average)
Buffer 9 20	0	0	0.640723	9.780436	0.0920657	0.307794	0.615587	0.92	(Std. Dev.)
Buffer 8 9	9	20	307.9	8.969370	0.0852204	1	0.15	0.43	(Average)
Buffer 8 9	0	0	0.640723	2.621040	0.0247807	0	0.366348	0.12	(Std. Dev.)
Moulding B	9	1	308.7	85.641083	0.815978	1	0.75	81.60	(Average)
Moulding B	0	0	0.656947	2.565305	0.0247486	0	0.444262	2.47	(Std. Dev.)
Buffer 7 8	9	20	312.55	193.445529	1.86629	4.45	3.8	9.33	(Average)
Buffer 7 8	0	0	0.510418	40.291150	0.389571	0.759155	0.894427	1.95	(Std. Dev.)
Planer B 3	9	1	313.5	84.428429	0.816921	1	0.8	81.69	(Average)
Planer B 3	0	0	0.512989	0.276101	0.00236691	0	0.410391	0.24	(Std. Dev.)
Buffer 6 7	9	20	313.9	31.300617	0.303289	1.2	0.4	1.52	(Average)
Buffer 6 7	0	0	0.552506	10.481438	0.101681	0.410391	0.502625	0.51	(Std. Dev.)
Komposer B	9	1	314.65	70.807746	0.687635	1	0.7	68.76	(Average)
Komposer B	0	0	0.48936	5.564817	0.0539437	0	0.470162	5.39	(Std. Dev.)
Lipping B storage	9	500	500	22344.523860	344.823	500	185.35	68.96	(Average)
Lipping B storage	0	0	0	16.151332	0.249249	0	0.48936	0.05	(Std. Dev.)
Edge glueing B 2	9	1	315.4	66.470883	0.647047	1	0.7	64.70	(Average)
Edge glueing B 2	0	0	0.502625	5.111178	0.0495377	0	0.470162	4.95	(Std. Dev.)
Buffer 5 6	9	20	314.7	10.195698	0.0990463	1	0	0.50	(Average)
Buffer 5 6	0	0	0.470162	4.187166	0.0407426	0	0	0.20	(Std. Dev.)
Lem B Storage 2	9	500	500	22290.890280	343.995	500	184.6	68.80	(Average)
Lem B Storage 2	0	0	0	15.396410	0.237599	0	0.502625	0.05	(Std. Dev.)
Buffer 4 5	9	20	315.5	8.385928	0.0816593	1	0.05	0.41	(Average)
Buffer 4 5	0	0	0.512989	0.003392	0.000129476	0	0.223607	0.00	(Std. Dev.)
Planer B 2	9	1	316.25	76.599208	0.747669	1	0.6	74.77	(Average)
Planer B 2	0	0	0.444262	0.106081	0.00130652	0	0.502625	0.13	(Std. Dev.)
Buffer 3 4	9	20	316.45	8.394976	0.0819935	1	0.1	0.41	(Average)
Buffer 3 4	0	0	0.510418	0.007473	0.000147449	0	0.307794	0.00	(Std. Dev.)
Hot press B	9	1	317.2	81.293683	0.795874	1	0.75	79.59	(Average)
Hot press B	0	0	0.523148	0.114005	0.00104918	0	0.444262	0.10	(Std. Dev.)
Veneer sengon B storage	9	500	500	22169.648400	342.124	500	182.8	68.42	(Average)
Veneer sengon B storage	0	0	0	15.497462	0.239158	0	0.523148	0.05	(Std. Dev.)
Buffer 2 3	9	20	317.4	8.978253	0.0879537	1	0.15	0.44	(Average)
Buffer 2 3	0	0	0.502625	0.068023	0.000690616	0	0.366348	0.00	(Std. Dev.)
Edge glueing B	9	1	318.2	77.421717	0.760356	1	0.75	76.04	(Average)
Edge glueing B	0	0	0.523148	0.141118	0.00121965	0	0.444262	0.12	(Std. Dev.)
Lem B storage	9	500	500	22109.346720	341.194	500	181.8	68.24	(Average)
Lem B storage	0	0	0	15.537725	0.23978	0	0.523148	0.05	(Std. Dev.)
Buffer 1 2	9	20	318.3	8.392560	0.0824491	1	0.1	0.41	(Average)
Buffer 1 2	0	0	0.470162	0.009785	0.000119844	0	0.307794	0.00	(Std. Dev.)
Planer B	9	1	319.2	84.727791	0.834723	1	0.8	83.47	(Average)
Planer B	0	0	0.523148	0.162557	0.000240439	0	0.410391	0.02	(Std. Dev.)
Core engsel dan sengon storage	9	500	500	22041.885840	340.153	500	180.8	68.03	(Average)

Core engsel dan sengon storage	0	0	0	15.538693	0.239795	0	0.523148	0.05	(Std. Dev.)
Lem pintu storage	9	250	250	22190.886480	171.226	250	87	68.49	(Average)
Lem pintu storage	0	0	0	18.453490	0.142388	0	0	0.06	(Std. Dev.)
karton dan plastik storage	9	250	250	22506.992520	173.665	250	89.55	69.47	(Average)
karton dan plastik storage	0	0	0	19.999400	0.154316	0	0.510418	0.06	(Std. Dev.)
Komponen panel spindle storage	9	250	0	0.000000	0	0	0	0.00	(Average)
Komponen panel spindle storage	0	0	0	0.000000	0	0	0	0.00	(Std. Dev.)
Buffer Akhir	9	250	159.5	0.000000	0	1	0	0.00	(Average)
Buffer Akhir	0	0	0.512989	0.000000	0	0	0	0.00	(Std. Dev.)

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	% Empty	% Partially Occupied	% Full	% Down	
Core sengon A storage	9	0.00	99.99	0.01	0.00	(Average)
Core sengon A storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Buffer 10 11	9	90.45	9.55	0.00	0.00	(Average)
Buffer 10 11	0	3.42	3.42	0.00	0.00	(Std. Dev.)
Lem A storage	9	0.00	99.75	0.25	0.00	(Average)
Lem A storage	0	0.00	0.01	0.01	0.00	(Std. Dev.)
Buffer 11 12	9	2.74	96.30	0.97	0.00	(Average)
Buffer 11 12	0	0.44	1.43	1.40	0.00	(Std. Dev.)
Veneer sengon A storage	9	0.00	99.56	0.44	0.00	(Average)
Veneer sengon A storage	0	0.00	0.01	0.01	0.00	(Std. Dev.)
Buffer 12 13	9	90.69	9.31	0.00	0.00	(Average)
Buffer 12 13	0	3.44	3.44	0.00	0.00	(Std. Dev.)
Buffer 13 14	9	92.80	7.20	0.00	0.00	(Average)
Buffer 13 14	0	2.49	2.49	0.00	0.00	(Std. Dev.)
Lem A storage 2	9	0.00	99.10	0.90	0.00	(Average)
Lem A storage 2	0	0.00	0.02	0.02	0.00	(Std. Dev.)
Buffer 14 15	9	92.58	7.42	0.00	0.00	(Average)
Buffer 14 15	0	0.11	0.11	0.00	0.00	(Std. Dev.)
Lipping A storage	9	0.00	98.90	1.10	0.00	(Average)
Lipping A storage	0	0.00	0.02	0.02	0.00	(Std. Dev.)
Buffer 15 16	9	87.65	12.35	0.00	0.00	(Average)
Buffer 15 16	0	4.13	4.13	0.00	0.00	(Std. Dev.)
Buffer 16 17	9	92.35	7.65	0.00	0.00	(Average)
Buffer 16 17	0	3.42	3.42	0.00	0.00	(Std. Dev.)
Buffer 17 18	9	91.56	8.44	0.00	0.00	(Average)
Buffer 17 18	0	2.48	2.48	0.00	0.00	(Std. Dev.)
Buffer 18 19	9	92.27	7.73	0.00	0.00	(Average)
Buffer 18 19	0	3.44	3.44	0.00	0.00	(Std. Dev.)

Buffer 19 20	9	19.89	80.11	0.00	0.00	(Average)
Buffer 19 20	0	1.96	4.96	0.00	0.00	(Std. Dev.)
Assembling press	9	12.67	11.04	76.29	0.00	(Average)
Assembling press	0	2.48	5.34	5.48	0.00	(Std. Dev.)
Buffer 20 21	9	94.63	5.37	0.00	0.00	(Average)
Buffer 20 21	0	2.48	2.48	0.00	0.00	(Std. Dev.)
Buffer 21 22	9	95.19	4.81	0.00	0.00	(Average)
Buffer 21 22	0	0.02	0.02	0.00	0.00	(Std. Dev.)
Veneer rangkai storage	9	0.00	96.51	3.49	0.00	(Average)
Veneer rangkai storage	0	0.00	0.03	0.03	0.00	(Std. Dev.)
Buffer 22 23	9	95.21	4.79	0.00	0.00	(Average)
Buffer 22 23	0	0.03	0.03	0.00	0.00	(Std. Dev.)
Serpihan kayu storage	9	0.00	96.07	3.93	0.00	(Average)
Serpihan kayu storage	0	0.00	0.03	0.03	0.00	(Std. Dev.)
Buffer 23 24	9	88.87	11.13	0.00	0.00	(Average)
Buffer 23 24	0	3.12	3.12	0.00	0.00	(Std. Dev.)
Buffer 9 20	9	23.36	76.64	0.00	0.00	(Average)
Buffer 9 20	0	4.83	4.83	0.00	0.00	(Std. Dev.)
Buffer 8 9	9	91.48	8.52	0.00	0.00	(Average)
Buffer 8 9	0	2.48	2.48	0.00	0.00	(Std. Dev.)
Buffer 7 8	9	13.74	86.26	0.00	0.00	(Average)
Buffer 7 8	0	5.15	5.15	0.00	0.00	(Std. Dev.)
Buffer 6 7	9	69.68	30.32	0.00	0.00	(Average)
Buffer 6 7	0	10.16	10.16	0.00	0.00	(Std. Dev.)
Lipping B storage.	9	0.00	98.75	1.25	0.00	(Average)
Lipping B storage	0	0.00	0.02	0.02	0.00	(Std. Dev.)
Buffer 5 6	9	90.10	9.90	0.00	0.00	(Average)
Buffer 5 6	0	4.07	4.07	0.00	0.00	(Std. Dev.)
Lem B Storage 2	9	0.00	98.97	1.03	0.00	(Average)
Lem B Storage 2	0	0.00	0.01	0.01	0.00	(Std. Dev.)
Buffer 4 5	9	91.83	8.17	0.00	0.00	(Average)
Buffer 4 5	0	0.01	0.01	0.00	0.00	(Std. Dev.)
Buffer 3 4	9	91.80	8.20	0.00	0.00	(Average)
Buffer 3 4	0	0.01	0.01	0.00	0.00	(Std. Dev.)
Veneer sengon B storage	9	0.00	99.47	0.53	0.00	(Average)
Veneer sengon B storage	0	0.00	0.01	0.01	0.00	(Std. Dev.)
Buffer 2 3	9	91.20	8.80	0.00	0.00	(Average)
Buffer 2 3	0	0.07	0.07	0.00	0.00	(Std. Dev.)
Lem B storage	9	0.00	99.71	0.29	0.00	(Average)
Lem B storage	0	0.00	0.01	0.01	0.00	(Std. Dev.)
Buffer 1 2	9	91.76	8.24	0.00	0.00	(Average)
Buffer 1 2	0	0.01	0.01	0.00	0.00	(Std. Dev.)
Core engsel dan sengon storage	9	0.00	99.99	0.01	0.00	(Average)
Core engsel dan sengon storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem pintu storage	9	0.00	96.90	3.10	0.00	(Average)

Lem pintu storage	0	0.00	0.03	0.03	0.00	(Std. Dev.)
karton dan plastik storage	9	0.00	95.66	4.34	0.00	(Average)
karton dan plastik storage	0	0.00	0.04	0.04	0.00	(Std. Dev.)
Komponen panel spindle storage	9	100.00	0.00	0.00	0.00	(Average)
Komponen panel spindle storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Buffer Akhir	9	100.00	0.00	0.00	0.00	(Average)
Buffer Akhir	0	0.00	0.00	0.00	0.00	(Std. Dev.)

LOCATION STATES BY PERCENTAGE (Single Capacity)

Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down
Planer A	9	72.05	0.00	17.95	10.00	0.00	0.00 (Average)
Planer A	0	0.03	0.00	3.43	3.42	0.00	0.00 (Std. Dev.)
Edge Glueing A	9	64.32	0.00	26.21	9.44	0.03	0.00 (Average)
Edge Glueing A	0	0.12	0.00	4.04	4.07	0.07	0.00 (Std. Dev.)
Hot Press A	9	75.19	0.00	14.81	10.00	0.00	0.00 (Average)
Hot Press A	0	0.03	0.00	3.42	3.42	0.00	0.00 (Std. Dev.)
Planer A 2	9	64.88	0.00	25.68	9.44	0.00	0.00 (Average)
Planer A 2	0	0.24	0.00	4.07	4.07	0.00	0.00 (Std. Dev.)
Edge Glueing A 2	9	60.88	0.00	28.56	10.56	0.00	0.00 (Average)
Edge Glueing A 2	0	0.20	0.00	2.51	2.48	0.00	0.00 (Std. Dev.)
Komposer A	9	64.96	0.00	26.71	8.33	0.00	0.00 (Average)
Komposer A	0	0.27	0.00	4.95	4.94	0.00	0.00 (Std. Dev.)
Planer A 3	9	66.51	0.00	23.49	10.00	0.00	0.00 (Average)
Planer A 3	0	0.26	0.00	3.47	3.42	0.00	0.00 (Std. Dev.)
Moulding A	9	56.00	0.00	35.67	8.33	0.00	0.00 (Average)
Moulding A	0	0.26	0.00	4.95	4.94	0.00	0.00 (Std. Dev.)
Moulding A 2	9	57.17	0.00	35.05	7.78	0.00	0.00 (Average)
Moulding A 2	0	0.16	0.00	5.28	5.22	0.00	0.00 (Std. Dev.)
Boring A	9	60.76	0.00	30.91	8.33	0.00	0.00 (Average)
Boring A	0	0.17	0.00	4.87	4.94	0.00	0.00 (Std. Dev.)
Edge Glueing pintu	9	55.04	0.00	34.96	10.00	0.00	0.00 (Average)
Edge Glueing pintu	0	0.15	0.00	3.45	3.42	0.00	0.00 (Std. Dev.)
Hot press pintu	9	64.66	0.00	24.79	10.56	0.00	0.00 (Average)
Hot press pintu	0	0.16	0.00	2.51	2.48	0.00	0.00 (Std. Dev.)
Repair inspeksi table	9	60.26	0.00	31.41	8.33	0.00	0.00 (Average)
Repair inspeksi table	0	0.34	0.00	5.00	4.94	0.00	0.00 (Std. Dev.)
Packing table	9	73.01	0.00	16.43	10.56	0.00	0.00 (Average)
Packing table	0	0.29	0.00	2.45	2.48	0.00	0.00 (Std. Dev.)
Boring B	9	59.68	0.00	31.43	8.89	0.00	0.00 (Average)
Boring B	0	0.20	0.00	4.58	4.56	0.00	0.00 (Std. Dev.)
Moulding B	9	71.04	0.00	18.40	10.56	0.00	0.00 (Average)

Moulding B	0	0.05	0.00	2.47	2.48	0.00	0.00	(Std. Dev.)
Planer B 3	9	70.58	0.00	18.31	11.11	0.00	0.00	(Average)
Planer B 3	0	0.24	0.00	0.24	0.00	0.00	0.00	(Std. Dev.)
Komposer B	9	61.54	0.00	31.24	7.22	0.00	0.00	(Average)
Komposer B	0	0.16	0.00	5.39	5.44	0.00	0.00	(Std. Dev.)
Edge glueing B 2	9	56.37	0.00	35.30	8.33	0.00	0.00	(Average)
Edge glueing B 2	0	0.14	0.00	4.95	4.94	0.00	0.00	(Std. Dev.)
Planer B 2	9	63.66	0.00	25.23	11.11	0.00	0.00	(Average)
Planer B 2	0	0.13	0.00	0.13	0.00	0.00	0.00	(Std. Dev.)
Hot press B	9	68.48	0.00	20.41	11.11	0.00	0.00	(Average)
Hot press B	0	0.10	0.00	0.10	0.00	0.00	0.00	(Std. Dev.)
Edge glueing B	9	64.92	0.00	23.96	11.11	0.00	0.00	(Average)
Edge glueing B	0	0.12	0.00	0.12	0.00	0.00	0.00	(Std. Dev.)
Planer B	9	72.36	0.00	16.53	11.11	0.00	0.00	(Average)
Planer B	0	0.02	0.00	0.02	0.00	0.00	0.00	(Std. Dev.)

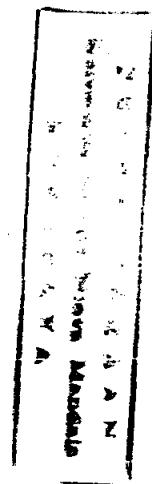
RESOURCES

Resource Name	Units	Scheduled Hours	Number Of Times Used	Average Seconds Per Usage	Average Seconds Travel To Use	Average Seconds Travel To Park	% Blocked In Travel	% Util	
Operator st10	1	8	1137.35	22.923363	2.398496	0.000000	0.00	100.00	(Average)
Operator st10	0	0	1.63111	0.036590	0.001126	0.000000	0.00	0.00	(Std. Dev.)
Operator st11	1	8	1134.3	20.771025	2.398228	0.000000	0.00	91.25	(Average)
Operator st11	0	0	1.55935	0.030994	0.001354	0.000000	0.00	0.15	(Std. Dev.)
Operator st12	1	8	1074.4	24.674296	1.998986	0.000000	0.00	99.51	(Average)
Operator st12	0	0	2.21003	0.054048	0.000761	0.000000	0.00	0.01	(Std. Dev.)
Operator st13	1	8	1071.4	22.019026	2.398741	0.000000	0.00	90.84	(Average)
Operator st13	0	0	2.21003	0.056844	0.001604	0.000000	0.00	0.29	(Std. Dev.)
Operator st14	1	8	1068.8	20.455689	1.998933	0.000000	0.00	83.33	(Average)
Operator st14	0	0	1.96281	0.050031	0.000693	0.000000	0.00	0.24	(Std. Dev.)
Operator st15	1	8	1066.25	21.737935	1.998781	0.000000	0.00	87.88	(Average)
Operator st15	0	0	1.99671	0.077165	0.000686	0.000000	0.00	0.32	(Std. Dev.)
Operator st16	1	8	1063.35	22.664668	2.398645	0.000000	0.00	92.54	(Average)
Operator st16	0	0	2.00722	0.072064	0.001009	0.000000	0.00	0.31	(Std. Dev.)
Operator st17	1	8	1060.55	19.106087	1.998775	0.000000	0.00	77.72	(Average)
Operator st17	0	0	2.11449	0.056407	0.000922	0.000000	0.00	0.32	(Std. Dev.)
Operator st18	1	8	1057.95	19.908420	2.398300	0.000000	0.00	81.94	(Average)
Operator st18	0	0	2.2589	0.038031	0.001245	0.000000	0.00	0.20	(Std. Dev.)
Operator st19	1	8	1055.55	20.648808	1.998863	0.000000	0.00	83.01	(Average)
Operator st19	0	0	2.54383	0.034496	0.001047	0.000000	0.00	0.22	(Std. Dev.)
Operator st1	1	8	956.8	27.302165	2.797942	0.000000	0.00	100.00	(Average)

Operator st1	0	0	1.43637	0.044897	0.001413	0.000000	0.00	0.00	(Std. Dev.)
Operator st2	1	8	953.85	24.852172	2.797788	0.000000	0.00	91.58	(Average)
Operator st2	0	0	1.42441	0.042636	0.001502	0.000000	0.00	0.15	(Std. Dev.)
Operator st3	1	8	950.9	26.130814	2.798339	0.000000	0.00	95.52	(Average)
Operator st3	0	0	1.33377	0.036055	0.001547	0.000000	0.00	0.13	(Std. Dev.)
Operator st4	1	8	948.25	24.548719	2.798428	0.000000	0.00	90.04	(Average)
Operator st4	0	0	1.20852	0.036802	0.001783	0.000000	0.00	0.16	(Std. Dev.)
Operator st5	1	8	945.55	22.115097	2.797969	0.000000	0.00	81.79	(Average)
Operator st5	0	0	1.31689	0.040549	0.001492	0.000000	0.00	0.18	(Std. Dev.)
Operator st6	1	8	943.3	23.936782	2.797922	0.000000	0.00	87.57	(Average)
Operator st6	0	0	1.30182	0.050172	0.001553	0.000000	0.00	0.19	(Std. Dev.)
Operator st7	1	8	939.7	27.134098	2.797829	0.000000	0.00	97.66	(Average)
Operator st7	0	0	1.38031	0.087636	0.001439	0.000000	0.00	0.27	(Std. Dev.)
Operator st8	1	8	925.4	27.672106	2.797969	0.000000	0.00	97.91	(Average)
Operator st8	0	0	1.78885	0.058900	0.001938	0.000000	0.00	0.05	(Std. Dev.)
Operator st9	1	8	922.6	23.756420	2.797356	0.000000	0.00	85.07	(Average)
Operator st9	0	0	1.81804	0.045735	0.002160	0.000000	0.00	0.26	(Std. Dev.)
Operator st20	1	8	654.95	38.041019	3.598031	0.000000	0.00	94.69	(Average)
Operator st20	0	0	0.510418	0.114533	0.001401	0.000000	0.00	0.27	(Std. Dev.)
Operator st21	1	8	488.35	39.712458	3.194433	0.000000	0.00	72.76	(Average)
Operator st21	0	0	0.48936	0.080380	0.003199	0.000000	0.00	0.17	(Std. Dev.)
Operator st22	1	8	485.65	46.333454	3.196131	0.000000	0.00	83.52	(Average)
Operator st22	0	0	1.08942	0.099929	0.002434	0.000000	0.00	0.20	(Std. Dev.)
Operator st23	1	8	483.35	43.588423	3.194702	0.000000	0.00	78.52	(Average)
Operator st23	0	0	1.30888	0.213658	0.003117	0.000000	0.00	0.39	(Std. Dev.)
Operator st24	1	8	480.55	52.424299	2.592729	4.720297	0.00	91.80	(Average)
Operator st24	0	0	1.39454	0.210144	0.083115	0.010845	0.00	0.46	(Std. Dev.)

RESOURCE STATES BY PERCENTAGE

Resource Name	Scheduled Hours	% In Use	% Travel To Use	% Travel To Park	% Idle	% Down	
Operator st10	8	90.53	9.47	0.00	0.00	0.00	(Average)
Operator st10	0	0.01	0.01	0.00	0.00	0.00	(Std. Dev.)
Operator st11	8	81.81	9.45	0.00	8.75	0.00	(Average)
Operator st11	0	0.14	0.01	0.00	0.15	0.00	(Std. Dev.)
Operator st12	8	92.05	7.46	0.00	0.49	0.00	(Average)
Operator st12	0	0.02	0.01	0.00	0.01	0.00	(Std. Dev.)
Operator st13	8	81.91	8.92	0.00	9.16	0.00	(Average)
Operator st13	0	0.28	0.02	0.00	0.29	0.00	(Std. Dev.)
Operator st14	8	75.91	7.42	0.00	16.67	0.00	(Average)
Operator st14	0	0.23	0.01	0.00	0.24	0.00	(Std. Dev.)



Operator st15	8	80.48	7.40	0.00	12.12	0.00	(Average)
Operator st15	0	0.31	0.01	0.00	0.32	0.00	(Std. Dev.)
Operator st16	8	83.68	8.86	0.00	7.46	0.00	(Average)
Operator st16	0	0.30	0.02	0.00	0.31	0.00	(Std. Dev.)
Operator st17	8	70.36	7.36	0.00	22.28	0.00	(Average)
Operator st17	0	0.31	0.01	0.00	0.32	0.00	(Std. Dev.)
Operator st18	8	73.13	8.81	0.00	18.06	0.00	(Average)
Operator st18	0	0.19	0.02	0.00	0.20	0.00	(Std. Dev.)
Operator st19	8	75.68	7.33	0.00	16.99	0.00	(Average)
Operator st19	0	0.21	0.02	0.00	0.22	0.00	(Std. Dev.)
Operator st1	8	90.70	9.30	0.00	0.00	0.00	(Average)
Operator st1	0	0.01	0.01	0.00	0.00	0.00	(Std. Dev.)
Operator st2	8	82.31	9.27	0.00	8.42	0.00	(Average)
Operator st2	0	0.14	0.01	0.00	0.15	0.00	(Std. Dev.)
Operator st3	8	86.28	9.24	0.00	4.48	0.00	(Average)
Operator st3	0	0.12	0.01	0.00	0.13	0.00	(Std. Dev.)
Operator st4	8	80.83	9.21	0.00	9.96	0.00	(Average)
Operator st4	0	0.15	0.01	0.00	0.16	0.00	(Std. Dev.)
Operator st5	8	72.61	9.19	0.00	18.21	0.00	(Average)
Operator st5	0	0.17	0.01	0.00	0.18	0.00	(Std. Dev.)
Operator st6	8	78.40	9.16	0.00	12.43	0.00	(Average)
Operator st6	0	0.19	0.01	0.00	0.19	0.00	(Std. Dev.)
Operator st7	8	88.53	9.13	0.00	2.34	0.00	(Average)
Operator st7	0	0.27	0.01	0.00	0.27	0.00	(Std. Dev.)
Operator st8	8	88.92	8.99	0.00	2.09	0.00	(Average)
Operator st8	0	0.05	0.02	0.00	0.05	0.00	(Std. Dev.)
Operator st9	8	76.10	8.96	0.00	14.93	0.00	(Average)
Operator st9	0	0.24	0.02	0.00	0.26	0.00	(Std. Dev.)
Operator st20	8	86.51	8.18	0.00	5.31	0.00	(Average)
Operator st20	0	0.27	0.00	0.00	0.27	0.00	(Std. Dev.)
Operator st21	8	67.34	5.42	0.00	27.24	0.00	(Average)
Operator st21	0	0.17	0.00	0.00	0.17	0.00	(Std. Dev.)
Operator st22	8	78.13	5.39	0.00	16.48	0.00	(Average)
Operator st22	0	0.19	0.01	0.00	0.20	0.00	(Std. Dev.)
Operator st23	8	73.15	5.36	0.00	21.48	0.00	(Average)
Operator st23	0	0.39	0.02	0.00	0.39	0.00	(Std. Dev.)
Operator st24	8	87.47	4.33	1.00	7.19	0.00	(Average)
Operator st24	0	0.34	0.14	0.14	0.34	0.00	(Std. Dev.)

NODE ENTRIES FOR Net_st10

Node	Total	Blocked
Name	Entries	Entries
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N1	757.8	0	(Average)
N1	1.19649	0	(Std. Dev.)
N2	378.5	0	(Average)
N2	0.606977	0	(Std. Dev.)
N3	379.4	0	(Average)
N3	0.598243	0	(Std. Dev.)

NODE ENTRIES FOR Net_st11

Node Name	Total Entries	Blocked Entries	
N1	378.35	0	(Average)
N1	0.587143	0	(Std. Dev.)
N2	755.7	0	(Average)
N2	1.17429	0	(Std. Dev.)
N3	377.5	0	(Average)
N3	0.512989	0	(Std. Dev.)

NODE ENTRIES FOR Net_st12

Node Name	Total Entries	Blocked Entries	
N1	358.45	0	(Average)
N1	0.759155	0	(Std. Dev.)
N2	715.9	0	(Average)
N2	1.48324	0	(Std. Dev.)
N3	357.55	0	(Average)
N3	0.686333	0	(Std. Dev.)

NODE ENTRIES FOR Net_st13

Node Name	Total Entries	Blocked Entries	
N1	357.45	0	(Average)
N1	0.759155	0	(Std. Dev.)
N2	713.7	0	(Average)
N2	1.62546	0	(Std. Dev.)
N3	356.65	0	(Average)
N3	0.67082	0	(Std. Dev.)

NODE ENTRIES FOR Net_st14

Node	Total	Blocked	
Name	Entries	Entries	
----	-----	-----	
N1	356.55	0	(Average)
N1	0.686333	0	(Std. Dev.)
N2	712.15	0	(Average)
N2	1.34849	0	(Std. Dev.)
N3	355.7	0	(Average)
N3	0.656947	0	(Std. Dev.)

NODE ENTRIES FOR Net_st15

Node	Total	Blocked	
Name	Entries	Entries	
----	-----	-----	
N1	355.7	0	(Average)
N1	0.656947	0	(Std. Dev.)
N2	710.4	0	(Average)
N2	1.31389	0	(Std. Dev.)
N3	354.85	0	(Average)
N3	0.74516	0	(Std. Dev.)

NODE ENTRIES FOR Net_st16

Node	Total	Blocked	
Name	Entries	Entries	
----	-----	-----	
N1	354.75	0	(Average)
N1	0.71635	0	(Std. Dev.)
N2	708.45	0	(Average)
N2	1.35627	0	(Std. Dev.)
N3	353.8	0	(Average)
N3	0.695852	0	(Std. Dev.)

NODE ENTRIES FOR Net_st17

Node	Total	Blocked	
Name	Entries	Entries	

N1	353.8	0	(Average)
N1	0.695852	0	(Std. Dev.)
N2	706.55	0	(Average)
N2	1.39454	0	(Std. Dev.)
N3	352.95	0	(Average)
N3	0.759155	0	(Std. Dev.)

NODE ENTRIES FOR Net_st18

Node Name	Total Entries	Blocked Entries	
N1	352.9	0	(Average)
N1	0.718185	0	(Std. Dev.)
N2	704.75	0	(Average)
N2	1.37171	0	(Std. Dev.)
N3	352.15	0	(Average)
N3	0.875094	0	(Std. Dev.)

NODE ENTRIES FOR Net_st19

Node Name	Total Entries	Blocked Entries	
N1	352.15	0	(Average)
N1	0.875094	0	(Std. Dev.)
N2	703.2	0	(Average)
N2	1.73509	0	(Std. Dev.)
N3	351.35	0	(Average)
N3	0.875094	0	(Std. Dev.)

NODE ENTRIES FOR Net_st1

Node Name	Total Entries	Blocked Entries	
N1	637.45	0	(Average)
N1	0.944513	0	(Std. Dev.)
N2	318.3	0	(Average)
N2	0.470162	0	(Std. Dev.)
N3	319.2	0	(Average)

N3 0.523148 0 (Std. Dev.)

NODE ENTRIES FOR Net_st2

Node Name	Total Entries	Blocked Entries	
N1	318.2	0	(Average)
N1	0.523148	0	(Std. Dev.)
N2	635.45	0	(Average)
N2	0.944513	0	(Std. Dev.)
N3	317.4	0	(Average)
N3	0.502625	0	(Std. Dev.)

NODE ENTRIES FOR Net_st3

Node Name	Total Entries	Blocked Entries	
N1	317.25	0	(Average)
N1	0.444262	0	(Std. Dev.)
N2	633.55	0	(Average)
N2	0.944513	0	(Std. Dev.)
N3	316.45	0	(Average)
N3	0.510418	0	(Std. Dev.)

NODE ENTRIES FOR Net_st4

Node Name	Total Entries	Blocked Entries	
N1	316.35	0	(Average)
N1	0.48936	0	(Std. Dev.)
N2	631.7	0	(Average)
N2	0.864505	0	(Std. Dev.)
N3	315.5	0	(Average)
N3	0.512989	0	(Std. Dev.)

NODE ENTRIES FOR Net_st5

Node	Total	Blocked
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N3	307.9	0	(Average)
N3	0.640723	0	(Std. Dev.)

NODE ENTRIES FOR Net_st9

Node Name	Total Entries	Blocked Entries	
N1	307.75	0	(Average)
N1	0.638666	0	(Std. Dev.)
N2	614.5	0	(Average)
N2	1.23544	0	(Std. Dev.)
N3	307.1	0	(Average)
N3	0.640723	0	(Std. Dev.)

NODE ENTRIES FOR Net_st20

Node Name	Total Entries	Blocked Entries	
N1	175	0	(Average)
N1	0	0	(Std. Dev.)
N2	490.95	0	(Average)
N2	0.223607	0	(Std. Dev.)
N3	163	0	(Average)
N3	0	0	(Std. Dev.)
N4	152.95	0	(Average)
N4	0.223607	0	(Std. Dev.)

NODE ENTRIES FOR Net_st21

Node Name	Total Entries	Blocked Entries	
N1	163	0	(Average)
N1	0	0	(Std. Dev.)
N2	325	0	(Average)
N2	0	0	(Std. Dev.)
N3	162.3	0	(Average)
N3	0.470162	0	(Std. Dev.)

NODE ENTRIES FOR Net_st22

Node Name	Total Entries	Blocked Entries	
N1	162.15	0	(Average)
N1	0.366348	0	(Std. Dev.)
N2	323.4	0	(Average)
N2	0.753937	0	(Std. Dev.)
N3	161.35	0	(Average)
N3	0.48936	0	(Std. Dev.)

NODE ENTRIES FOR Net_st23

Node Name	Total Entries	Blocked Entries	
N1	161.35	0	(Average)
N1	0.48936	0	(Std. Dev.)
N2	321.7	0	(Average)
N2	0.978721	0	(Std. Dev.)
N3	160.6	0	(Average)
N3	0.502625	0	(Std. Dev.)

NODE ENTRIES FOR Net_st24

Node Name	Total Entries	Blocked Entries	
N1	160.45	0	(Average)
N1	0.510418	0	(Std. Dev.)
N2	319.9	0	(Average)
N2	1.02084	0	(Std. Dev.)
N3	159.5	0	(Average)
N3	0.512989	0	(Std. Dev.)

FAILED ARRIVALS

Entity Name	Location Name	Total Failed	
Core engsel core sengon	Core engsel dan sengon storage	0	(Average)

Core engsel core sengan	Core engsel dan sengan storage	0	(Std. Dev.)
Lem B 1	Lem B storage	0	(Average)
Lem B 1	Lem B storage	0	(Std. Dev.)
Veneer sengan B	Veneer sengan B storage	0	(Average)
Veneer sengan B	Veneer sengan B storage	0	(Std. Dev.)
Lem B 2	Lem B Storage 2	0	(Average)
Lem B 2	Lem B Storage 2	0	(Std. Dev.)
Lipping B	Lipping B storage	0	(Average)
Lipping B	Lipping B storage	0	(Std. Dev.)
Core sengan A	Core sengan A storage	0	(Average)
Core sengan A	Core sengan A storage	0	(Std. Dev.)
Lem A 1	Lem A storage	0	(Average)
Lem A 1	Lem A storage	0	(Std. Dev.)
Lem A 2	Lem A storage 2	0	(Average)
Lem A 2	Lem A storage 2	0	(Std. Dev.)
Lem pintu	Lem pintu storage	0	(Average)
Lem pintu	Lem pintu storage	0	(Std. Dev.)
veneer sengan A	Veneer sengan A storage	0	(Average)
veneer sengan A	Veneer sengan A storage	0	(Std. Dev.)
Lipping A	Lipping A storage	0	(Average)
Lipping A	Lipping A storage	0	(Std. Dev.)
Veneer rangkai	Veneer rangkai storage	0	(Average)
Veneer rangkai	Veneer rangkai storage	0	(Std. Dev.)
Serpihan kayu	Serpihan kayu storage	0	(Average)
Serpihan kayu	Serpihan kayu storage	0	(Std. Dev.)
Karton dan plastik	karton dan plastik storage	0	(Average)
Karton dan plastik	karton dan plastik storage	0	(Std. Dev.)

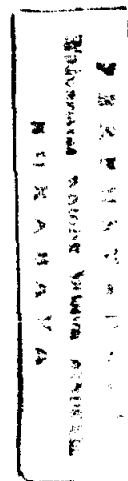
ENTITY ACTIVITY

Entity	Total	Current	Average	Average	Average	Average	Average	
Name	Exits	Quantity	Seconds	Seconds	Seconds	Seconds	Seconds	
		In System	In	In Move	Wait For	In	Blocked	
			System	Logic	Res, etc.	Operation		
Core engsel core sengan	0	181.6	-	-	-	-	-	(Average)
Core engsel core sengan	0	0.502625	-	-	-	-	-	(Std. Dev.)
Lem B 1	318.2	181.8	16229.880286	0.000000	0.000000	0.000000	16229.880286	(Average)
Lem B 1	0.523148	0.523148	21.746802	0.000000	0.000000	0.000000	21.746802	(Std. Dev.)
Veneer sengan B	317.2	182.8	16273.955618	0.000000	0.000000	0.000000	16273.955618	(Average)
Veneer sengan B	0.523148	0.523148	21.815402	0.000000	0.000000	0.000000	21.815402	(Std. Dev.)
Lem B 2	315.4	184.6	16374.128160	0.000000	0.000000	0.000000	16374.128160	(Average)
Lem B 2	0.502625	0.502625	22.167149	0.000000	0.000000	0.000000	22.167149	(Std. Dev.)
Lipping B	314.65	185.35	16421.162212	0.000000	0.000000	0.000000	16421.162212	(Average)

Lipping B	0.48936	0.48936	19.681835	0.000000	0.000000	0.000000	19.681835	(Std. Dev.)
Core sengan A	0	121.45	-	-	-	-	-	(Average)
Core sengan A	0	0.510418	-	-	-	-	-	(Std. Dev.)
Lem A 1	378.35	121.65	16226.007921	0.000000	0.000000	0.000000	16226.007921	(Average)
Lem A 1	0.587143	0.587143	20.998513	0.000000	0.000000	0.000000	20.998513	(Std. Dev.)
Lem A 2	356.55	143.45	16346.622659	0.000000	0.000000	0.000000	16346.622659	(Average)
Lem A 2	0.686333	0.686333	27.950962	0.000000	0.000000	0.000000	27.950962	(Std. Dev.)
Lem pintu	163	87	16741.850429	0.000000	0.000000	0.000000	16741.850429	(Average)
Lem pintu	0	0	28.302899	0.000000	0.000000	0.000000	28.302899	(Std. Dev.)
veneer sengan A	358.4	141.6	16257.192653	0.000000	0.000000	0.000000	16257.192653	(Average)
veneer sengan A	0.820783	0.820783	30.663703	0.000000	0.000000	0.000000	30.663703	(Std. Dev.)
Lipping A	355.7	144.3	16386.096379	0.000000	0.000000	0.000000	16386.096379	(Average)
Lipping A	0.656947	0.656947	29.384069	0.000000	0.000000	0.000000	29.384069	(Std. Dev.)
Veneer rangkai	162.15	87.85	16808.897214	0.000000	0.000000	0.000000	16808.897214	(Average)
Veneer rangkai	0.366348	0.366348	30.256995	0.000000	0.000000	0.000000	30.256995	(Std. Dev.)
Serpihan kayu	161.35	88.65	16901.805611	0.000000	0.000000	0.000000	16901.805611	(Average)
Serpihan kayu	0.48936	0.48936	33.304691	0.000000	0.000000	0.000000	33.304691	(Std. Dev.)
Komponen A	350.8	28.1	16592.789434	220.492572	59.129647	579.022661	15734.144553	(Average)
Komponen A	1.00525	0.788069	40.045341	13.978258	12.992893	0.399943	38.408208	(Std. Dev.)
Stile B	306.5	12.1	16634.525840	252.744448	61.731557	606.985880	15713.063955	(Average)
Stile B	0.888523	0.788069	36.050432	14.987292	13.336572	0.361673	31.999368	(Std. Dev.)
Pintu	0	3.55	-	-	-	-	-	(Average)
Pintu	0	0.510418	-	-	-	-	-	(Std. Dev.)
sepasang komponen A	174.95	0.5	87.676372	24.585326	14.026901	0.000000	49.064145	(Average)
sepasang komponen A	0.223607	0.512989	11.193607	7.561038	9.096443	0.000000	9.097038	(Std. Dev.)
sepasang stile B	152.95	0.6	82.700402	18.151491	7.343176	0.000000	57.205735	(Average)
sepasang stile B	0.223607	0.502625	12.313324	0.591298	7.276382	0.000000	10.916242	(Std. Dev.)
Karton dan plastik	160.45	89.55	16985.436466	0.000000	0.000000	0.000000	16985.436466	(Average)
Karton dan plastik	0.510418	0.510418	39.619113	0.000000	0.000000	0.000000	39.619113	(Std. Dev.)
Komponen panel spindle	0	0	-	-	-	-	-	(Average)
Komponen panel spindle	0	0	-	-	-	-	-	(Std. Dev.)
Pintu siap jual	159.5	0	835.306616	165.123829	12.410377	646.028717	11.743692	(Average)
Pintu siap jual	0.512989	0	12.026683	16.865876	11.517356	0.815481	6.049859	(Std. Dev.)

ENTITY STATES BY PERCENTAGE

Entity Name	In Move Logic	Wait For Res, etc.	In Operation	Blocked	
Core engsel core sengan	-	-	-	-	(Average)
Core engsel core sengan	-	-	-	-	(Std. Dev.)
Lem B 1	0.00	0.00	0.00	100.00	(Average)
Lem B 1	0.00	0.00	0.00	0.00	(Std. Dev.)



Veneer sengon B	0.00	0.00	0.00	100.00	(Average)
Veneer sengon B	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem B 2	0.00	0.00	0.00	100.00	(Average)
Lem B 2	0.00	0.00	0.00	0.00	(Std. Dev.)
Lipping B	0.00	0.00	0.00	100.00	(Average)
Lipping B	0.00	0.00	0.00	0.00	(Std. Dev.)
Core sengon A	-	-	-	-	(Average)
Core sengon A	-	-	-	-	(Std. Dev.)
Lem A 1	0.00	0.00	0.00	100.00	(Average)
Lem A 1	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem A 2	0.00	0.00	0.00	100.00	(Average)
Lem A 2	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem pintu	0.00	0.00	0.00	100.00	(Average)
Lem pintu	0.00	0.00	0.00	0.00	(Std. Dev.)
veneer sengon A	0.00	0.00	0.00	100.00	(Average)
veneer sengon A	0.00	0.00	0.00	0.00	(Std. Dev.)
Lipping A	0.00	0.00	0.00	100.00	(Average)
Lipping A	0.00	0.00	0.00	0.00	(Std. Dev.)
Veneer rangkai	0.00	0.00	0.00	100.00	(Average)
Veneer rangkai	0.00	0.00	0.00	0.00	(Std. Dev.)
Serpihan kayu	0.00	0.00	0.00	100.00	(Average)
Serpihan kayu	0.00	0.00	0.00	0.00	(Std. Dev.)
Komponen A	1.33	0.36	3.49	94.83	(Average)
Komponen A	0.08	0.08	0.01	0.04	(Std. Dev.)
Stile B	1.52	0.37	3.65	94.46	(Average)
Stile B	0.09	0.08	0.01	0.06	(Std. Dev.)
Pintu	-	-	-	-	(Average)
Pintu	-	-	-	-	(Std. Dev.)
sepasang komponen A	28.12	15.66	0.00	56.22	(Average)
sepasang komponen A	7.44	8.92	0.00	8.44	(Std. Dev.)
sepasang stile B	22.38	8.51	0.00	69.11	(Average)
sepasang stile B	3.13	6.97	0.00	6.75	(Std. Dev.)
Karton dan plastik	0.00	0.00	0.00	100.00	(Average)
Karton dan plastik	0.00	0.00	0.00	0.00	(Std. Dev.)
Komponen panel spindle	-	-	-	-	(Average)
Komponen panel spindle	-	-	-	-	(Std. Dev.)
Pintu siap jual	19.75	1.49	77.35	1.40	(Average)
Pintu siap jual	1.82	1.38	1.07	0.70	(Std. Dev.)

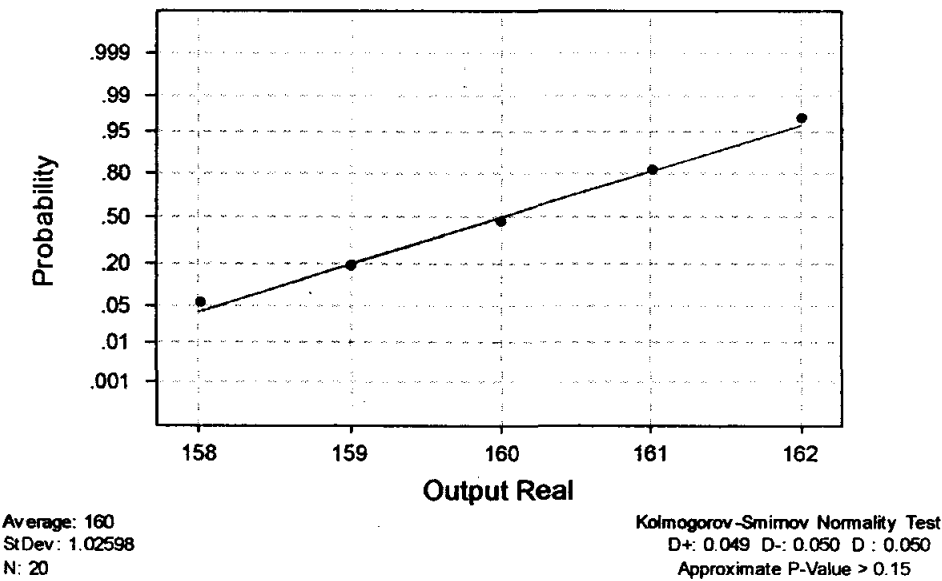
LAMPIRAN G

DATA OUTPUT SIMULASI DAN REAL

Ouput Simulasi	Output Real
159	158
159	160
160	159
160	160
160	161
159	161
160	158
160	160
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159	160
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159	159
159	160
160	162
159	160
160	161
159	161
160	160

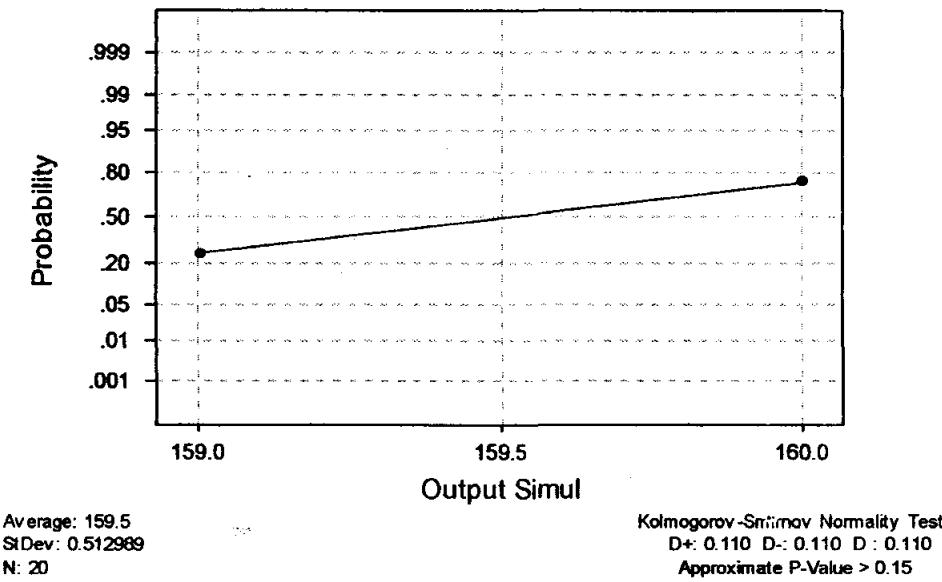
Normality Test (Data Real)

Normal Probability Plot

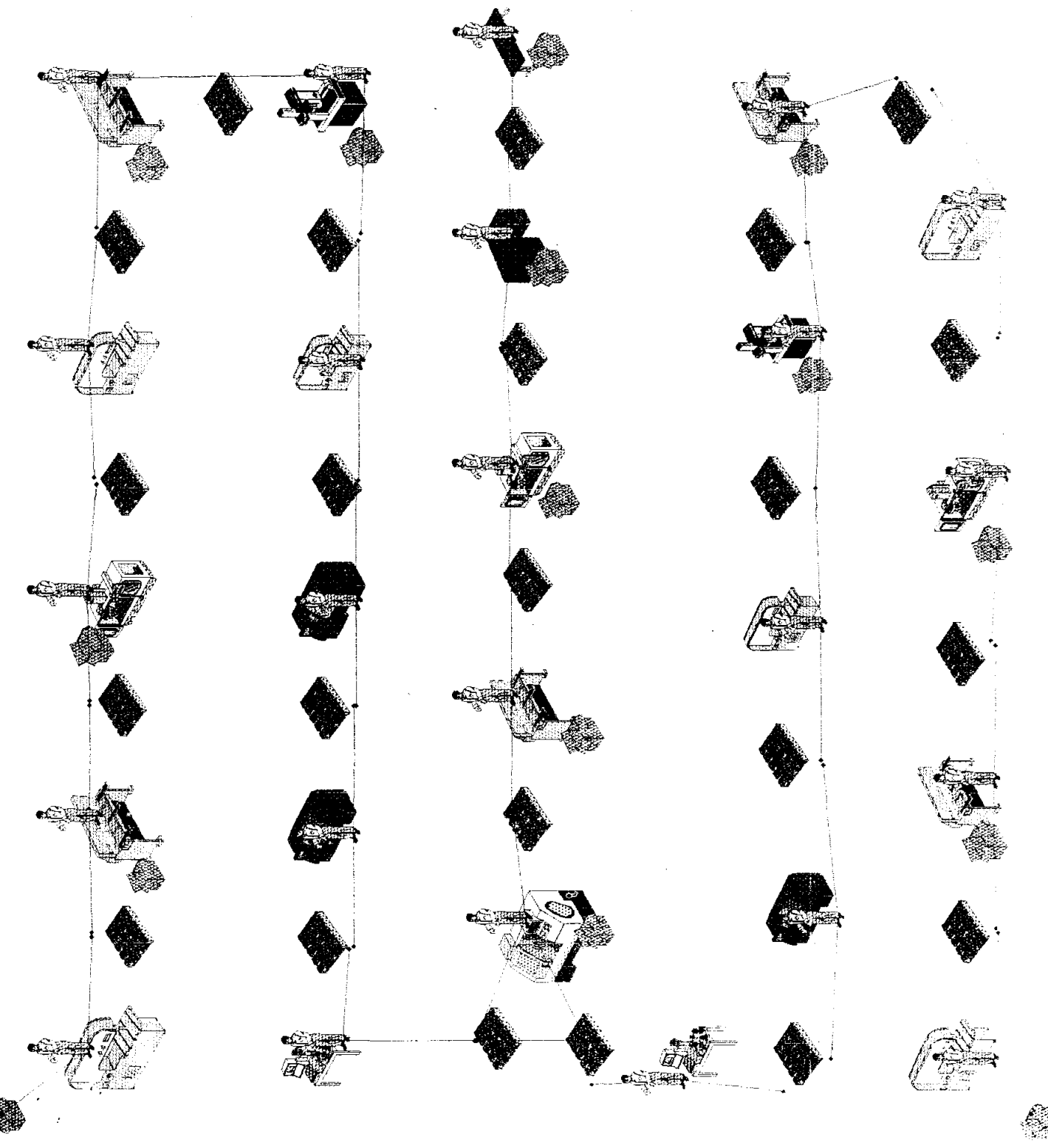


Normality Test (Data Simulasi)

Normal Probability Plot



LAMPIRAN I



Formatted Listing of Model:
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Time Units: Seconds
Distance Units: Meters

Locations

Name	Cap	Units	Stats	Rules	Cost
Planer_A	1	1	Time Series	Oldest, ,	
Core_sengon_A_storage	500	1	Time Series	Oldest, ,	
Buffer_10_11	1	1	Time Series	Oldest, ,	
Edge_Glueing_A	1	1	Time Series	Oldest, ,	
Lem_A_storage	500	1	Time Series	Oldest, ,	
Buffer_11_12	1	1	Time Series	Oldest, ,	
Hot_Press_A	1	1	Time Series	Oldest, ,	
Veneer_sengon_A_storage	500	1	Time Series	Oldest, ,	
Buffer_12_13	1	1	Time Series	Oldest, ,	
Planer_A_2	1	1	Time Series	Oldest, ,	
Edge_Glueing_A_2	1	1	Time Series	Oldest, ,	
Buffer_13_14	1	1	Time Series	Oldest, ,	
Lem_A_storage_2	500	1	Time Series	Oldest, ,	
Komposer_A	1	1	Time Series	Oldest, ,	
Buffer_14_15	1	1	Time Series	Oldest, ,	
Lipping_A_storage	500	1	Time Series	Oldest, ,	
Buffer_15_16	1	1	Time Series	Oldest, ,	
Planer_A_3	1	1	Time Series	Oldest, ,	
Buffer_16_17	1	1	Time Series	Oldest, ,	
Moulding_A	1	1	Time Series	Oldest, ,	
Buffer_17_18	1	1	Time Series	Oldest, ,	
Moulding_A_2	1	1	Time Series	Oldest, ,	
Buffer_18_19	1	1	Time Series	Oldest, ,	
Boring_A	1	1	Time Series	Oldest, ,	
Buffer_19_20	2	1	Time Series	Oldest, ,	
Assembling_press	2	1	Time Series	Oldest, , First	
Buffer_20_21	1	1	Time Series	Oldest, ,	
Edge_Glueing_pintu	1	1	Time Series	Oldest, ,	
Buffer_21_22	1	1	Time Series	Oldest, ,	
Hot_press_pintu	1	1	Time Series	Oldest, ,	
Veneer_rangkai_storage	250	1	Time Series	Oldest, ,	
Buffer_22_23	1	1	Time Series	Oldest, ,	
Repair_inspeksi_table	1	1	Time Series	Oldest, ,	
Serpihan_kayu_storage	250	1	Time Series	Oldest, ,	
Buffer_23_24	1	1	Time Series	Oldest, ,	

Packing_table	1	1	Time Series Oldest, ,
Boring_B	1	1	Time Series Oldest, ,
Buffer_9_20	2	1	Time Series Oldest, ,
Buffer_8_9	16	1	Time Series Oldest, ,
Moulding_B	1	1	Time Series Oldest, ,
Buffer_7_8	15	1	Time Series Oldest, ,
Planer_B_3	1	1	Time Series Oldest, ,
Buffer_6_7	1	1	Time Series Oldest, ,
Komposer_B	1	1	Time Series Oldest, ,
Lipping_B_storage	500	1	Time Series Oldest, ,
Edge_glueing_B_2	1	1	Time Series Oldest, ,
Buffer_5_6	1	1	Time Series Oldest, ,
Lem_B_Storage_2	500	1	Time Series Oldest, ,
Buffer_4_5	1	1	Time Series Oldest, ,
Planer_B_2	1	1	Time Series Oldest, ,
Buffer_3_4	10	1	Time Series Oldest, ,
Hot_press_B	1	1	Time Series Oldest, ,
Veneer_sengon_B_storage	500	1	Time Series Oldest, ,
Buffer_2_3	1	1	Time Series Oldest, ,
Edge_glueing_B	1	1	Time Series Oldest, ,
Lem_B_storage	500	1	Time Series Oldest, ,
Buffer_1_2	16	1	Time Series Oldest, ,
Planer_B	1	1	Time Series Oldest, ,
Core_engsel_dai_sengon_storage	500	1	Time Series Oldest, ,
Lem_pintu_storage	250	1	Time Series Oldest, ,
karton_dan_plastik_storage	250	1	Time Series Oldest, ,
Komponen_panel_spindle_storage	250	1	Time Series Oldest, ,
Buffer_Akhir	250	1	Time Series Oldest, ,

 * Entities *

Name	Speed (mpm)	Stats	Cost
Core_engsel_core_sengon	50	Time Series	
Lem_B_1	50	Time Series	
Veneer_sengon_B	50	Time Series	
Lem_B_2	50	Time Series	
Lipping_B	50	Time Series	
Core_sengon_A	50	Time Series	
Lem_A_1	50	Time Series	
Lem_A_2	50	Time Series	
Lem_pintu	50	Time Series	
veneer_sengon_A	50	Time Series	
Lipping_A	50	Time Series	
Veneer_fangkai	50	Time Series	
Serpihan_kayu	50	Time Series	
Komponen_A	50	Time Series	
Stile_B	50	Time Series	
Pintu	50	Time Series	

sepasang_komponen_A	50	Time Series
sepasang_stile_B	50	Time Series
Karton_dan_plastik	50	Time Series
Komponen_panel_spindle	50	Time Series
Pintu_siap_jual	50	Time Series

 * Path Networks *

Name	Type	T/S	From	To	BI	Dist/Time	Speed Factor
Net_st10	Non-Passing	Time	N1	N2	B1	3.32	
			N1	N3	B1	3.32	
Net_st11	Non-Passing	Time	N1	N2	B1	3.32	
			N2	N3	B1	3.32	
Net_st12	Non-Passing	Time	N1	N2	B1	3.16	
			N2	N3	B1	3.16	
Net_st13	Non-Passing	Time	N1	N2	B1	3.34	
			N2	N3	B1	3.34	
Net_st14	Non-Passing	Time	N1	N2	B1	3.17	
			N2	N3	B1	3.17	
Net_st15	Non-Passing	Time	N1	N2	B1	3.15	
			N2	N3	B1	3.15	
Net_st16	Non-Passing	Time	N1	N2	B1	3.39	
			N2	N3	B1	3.39	
Net_st17	Non-Passing	Time	N1	N2	B1	3.23	
			N2	N3	B1	3.23	
Net_st18	Non-Passing	Time	N1	N2	B1	3.37	
			N2	N3	B1	3.37	
Net_st19	Non-Passing	Time	N1	N2	B1	3.27	
			N2	N3	B1	3.27	
Net_st1	Non-Passing	Time	N1	N2	B1	4.27	
			N1	N3	B1	4.27	
Net_st2	Non-Passing	Time	N1	N2	B1	4.17	
			N2	N3	B1	4.17	
Net_st3	Non-Passing	Time	N1	N2	B1	4.38	
			N2	N3	B1	4.38	
Net_st4	Non-Passing	Time	N1	N2	B1	4.38	
			N2	N3	B1	4.38	
Net_st5	Non-Passing	Time	N1	N2	B1	4.25	
			N2	N3	B1	4.25	
Net_st6	Non-Passing	Time	N1	N2	B1	4.35	
			N2	N3	B1	4.35	
Net_st7	Non-Passing	Time	N1	N2	B1	4.32	
			N2	N3	B1	4.32	
Net_st8	Non-Passing	Time	N1	N2	B1	4.05	
			N2	N3	B1	4.05	
Net_st9	Non-Passing	Time	N1	N2	B1	4.34	
			N2	N3	B1	4.34	
Net_st20	Non-Passing	Time	N1	N2	B1	4.54	

	N2	N3	B1	4.54
	N4	N2	B1	4.54
Net_st21 Non-Passing Time	N1	N2	B1	4.90
	N2	N3	B1	4.90
Net_st22 Non-Passing Time	N1	N2	B1	4.60
	N2	N3	B1	4.60
Net_st23 Non-Passing Time	N1	N2	B1	4.63
	N2	N3	B1	4.63
Net_st24 Non-Passing Time	N1	N2	B1	4.58
	N2	N3	B1	4.58

 * Interfaces *

Net	Node	Location
Net_st10	N1	Planer_A
	N2	Buffer_10_11
	N3	Core_sengon_A_storage
Net_st11	N1	Buffer_10_11
	N2	Edge_Glueing_A
	N3	Buffer_11_12
Net_st12	N1	Buffer_11_12
	N2	Hot_Press_A
	N3	Buffer_12_13
Net_st13	N1	Buffer_12_13
	N2	Planer_A_2
	N3	Buffer_13_14
Net_st14	N1	Buffer_13_14
	N2	Edge_Glueing_A_2
	N3	Buffer_14_15
Net_st15	N1	Buffer_14_15
	N2	Komposer_A
	N3	Buffer_15_16
Net_st16	N1	Buffer_15_16
	N2	Planer_A_3
	N3	Buffer_16_17
Net_st17	N1	Buffer_16_17
	N2	Moulding_A
	N3	Buffer_17_18
Net_st18	N1	Buffer_17_18
	N2	Moulding_A_2
	N3	Buffer_18_19
Net_st19	N1	Buffer_18_19
	N2	Boring_A
	N3	Buffer_19_20
Net_st1	N1	Planer_B
	N2	Buffer_1_2
	N3	Core_engsel_dan_sengon_storage
Net_st2	N1	Buffer_1_2

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N2      Edge_glueing_B
N3      Buffer_2_3
Net_st3 N1      Buffer_2_3
N2      Hot_press_B
N3      Buffer_3_4
Net_st4 N1      Buffer_3_4
N2      Planer_B_2
N3      Buffer_4_5
Net_st5 N1      Buffer_4_5
N2      Edge_glueing_B_2
N3      Buffer_5_6
Net_st6 N1      Buffer_5_6
N2      Komposer_B
N3      Buffer_6_7
Net_st7 N1      Buffer_6_7
N2      Planer_B_3
N3      Buffer_7_8
Net_st8 N1      Buffer_7_8
N2      Moulding_B
N3      Buffer_8_9
Net_st9 N1      Buffer_8_9
N2      Boring_B
N3      Buffer_9_20
Net_st20 N1      Buffer_19_20
N2      Assembling_press
N3      Buffer_20_21
N4      Buffer_9_20
Net_st21 N1      Buffer_20_21
N2      Edge_Glueing_pintu
N3      Buffer_21_22
Net_st22 N1      Buffer_21_22
N2      Hot_press_pintu
N3      Buffer_22_23
Net_st23 N1      Buffer_22_23
N2      Repair_inspeksi_table
N3      Buffer_23_24
Net_st24 N1      Buffer_23_24
N2      Packing_table
N3      Buffer_Akhir

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*****
*                               *
*                               *
*****

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Name	Units	Stats	Res Search	Ent. Search	Path	Motion	Cost
Operator_st10	1	By Unit	Closest	Oldest	Net_st10 Home: N1	Empty: 50 mpm Full: 50 mpm	
Operator_st11	1	By Unit	Closest	Oldest	Net_st11	Empty: 50 mpm	

				Home: N2	Full: 50 mpm
Operator_st12	1	By Unit	Closest Oldest	Net_st12 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st13	1	By Unit	Closest Oldest	Net_st13 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st14	1	By Unit	Closest Oldest	Net_st14 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st15	1	By Unit	Closest Oldest	Net_st15 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st16	1	By Unit	Closest Oldest	Net_st16 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st17	1	By Unit	Closest Oldest	Net_st17 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st18	1	By Unit	Closest Oldest	Net_st18 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st19	1	By Unit	Closest Oldest	Net_st19 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st1	1	By Unit	Closest Oldest	Net_st1 Home: N1	Empty: 50 mpm Full: 50 mpm
Operator_st2	1	By Unit	Closest Oldest	Net_st2 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st3	1	By Unit	Closest Oldest	Net_st3 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st4	1	By Unit	Closest Oldest	Net_st4 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st5	1	By Unit	Closest Oldest	Net_st5 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st6	1	By Unit	Closest Oldest	Net_st6 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st7	1	By Unit	Closest Oldest	Net_st7 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st8	1	By Unit	Closest Oldest	Net_st8 Home: N2	Empty: 50 mpm Full: 50 mpm
Operator_st9	1	By Unit	Closest Oldest	Net_st9 Home: N2	Empty: 50 mpm Full: 50 mpm

Operator_st20	1	By Unit	Closest	Oldest	Net_st20	Empty: 50 mpm Home: N2 Full: 50 mpm
Operator_st21	1	By Unit	Closest	Oldest	Net_st21	Empty: 50 mpm Home: N2 Full: 50 mpm
Operator_st22	1	By Unit	Closest	Oldest	Net_st22	Empty: 50 mpm Home: N2 Full: 50 mpm
Operator_st23	1	By Unit	Closest	Oldest	Net_st23	Empty: 50 mpm Home: N2 Full: 50 mpm
Operator_st24	1	By Unit	Closest	Oldest	Net_st24	Empty: 50 mpm Home: N2 Full: 50 mpm (Return)

 * Processing *

Process			Routing				
Entity	Location	Operation	Blk	Output	Destination	Rule	Move Logic
Core_engsel_core_sengon	Core_engsel_dan_sengon_storage		1	Core_engsel_core_sengon	Planer_B	FIRST 1	MOVE WITH Operator_st1 THEN
FREE							
Core_engsel_core_sengon	Planer_B	get Operator_st1 WAIT L(73.5573, 1.9807) free Operator_st1	1	Stile_B	Buffer_1_2	FIRST 1	MOVE WITH Operator_st1 THEN
FREE							
Stile_B	Buffer_1_2		1	Stile_B	Edge_glueing_B	FIRST 1	MOVE WITH Operator_st2 THEN
FREE							
Lem_B_1	Lem_B_storage		1	Lem_B_1	Edge_glueing_B	JOIN 1	
Stile_B	Edge_glueing_B	JOIN 1 Lem_B_1 get Operator_st2 WAIT N(66.1591, 2.3133) free Operator_st2	1	Stile_B	Buffer_2_3	FIRST 1	MOVE WITH Operator_st2 THEN
FREE							
Stile_B	Buffer_2_3		1	Stile_B	Hot_press_B	FIRST 1	MOVE WITH Operator_st3 THEN
FREE							
Veneer_sengon_B	Veneer_sengon_B_storage		1	Veneer_sengon_B	Hot_press_B	JOIN 1	
Stile_B	Hot_press_B	JOIN 1 Veneer_sengon_B get Operator_st3					

		WAIT L(69.9557, 1.6679) free Operator_st3			
FREE		1	Stile_B	Buffer_3_4	FIRST 1 MOVE WITH Operator_st3 THEN
Stile_B	Buffer_3_4				
FREE		1	Stile_B	Planer_B_2	FIRST 1 MOVE WITH Operator_st4 THEN
Stile_B	Planer_B_2				
		get Operator_st4 WAIT L(65.3070, 1.8195) free Operator_st4			
FREE		1	Stile_B	Buffer_4_5	FIRST 1 MOVE WITH Operator_st4 THEN
Stile_B	Buffer_4_5				
FREE		1	Stile_B	Edge_glueing_B_2	FIRST 1 MOVE WITH Operator_st5 THEN
Lem_B_2	Lem_B_Storage_2				
Stile_B	Edge_glueing_B_2	1	Lem_B_2	Edge_glueing_B_2	JOIN 1
		JOIN 1 Lem_B_2 get Operator_st5 WAIT N(57.9905, 1.9824) free Operator_st5			
FREE		1	Stile_B	Buffer_5_6	FIRST 1 MOVE WITH Operator_st5 THEN
Stile_B	Buffer_5_6				
FREE		1	Stile_B	Komposer_B	FIRST 1 MOVE WITH Operator_st6 THEN
Lipping_B	Lipping_B_storage				
Stile_B	Komposer_B	1	Lipping_B	Komposer_B	JOIN 1
		JOIN 1 Lipping_B get Operator_st6 WAIT N(63.4823, 3.2796) free Operator_st6			
FREE		1	Stile_B	Buffer_6_7	FIRST 1 MOVE WITH Operator_st6 THEN
Stile_B	Buffer_6_7				
FREE		1	Stile_B	Planer_B_3	FIRST 1 MOVE WITH Operator_st7 THEN
Stile_B	Planer_B_3				
		get Operator_st7 WAIT L(73.0846, 4.1825) free Operator_st7			
FREE		1	Stile_B	Buffer_7_8	FIRST 1 MOVE WITH Operator_st7 THEN
Stile_B	Buffer_7_8				
FREE		1	Stile_B	Moulding_B	FIRST 1 MOVE WITH Operator_st8 THEN
Stile_B	Moulding_B				
		get Operator_st8 WAIT L(74.6210, 3.0314) free Operator_st8			

P R I N T A M A
 M I K A B A X A

FREE		1	Stile_B	Buffer_8_9	FIRST 1	MOVE WITH Operator_st8 THEN
Stile_B	Buffer_8_9	1	Stile_B	Boring_B	FIRST 1	MOVE WITH Operator_st9 THEN
FREE						
Stile_B	Boring_B					
			get Operator_st9			
			WAIT N(62.8915, 2.2141)			
			free Operator_st9			
FREE		1	Stile_B	Buffer_9_20	FIRST 1	MOVE WITH Operator_st9 THEN
Core_sengon_A	Core_sengon_A_storage	1	Core_sengon_A	Planer_A	FIRST 1	MOVE WITH Operator_st10 THEN
FREE						
Core_sengon_A	Planer_A					
			GET Operator_st10			
			WAIT N(61.6015, 2.3132)			
			FREE Operator_st10			
FREE		1	Komponen_A	Buffer_10_11	FIRST 1	MOVE WITH Operator_st10 THEN
Komponen_A	Buffer_10_11	1	Komponen_A	Edge_Glueing_A	FIRST 1	MOVE WITH Operator_st11 THEN
FREE						
Lem_A_1	Lem_A_storage	1	Lem_A_1	Edge_Glueing_A	JOIN 1	
Komponen_A	Edge_Glueing_A					
			JOIN 1 Lem_A_1			
			get Operator_st11			
			WAIT N(55.1284, 1.6720)			
			free Operator_st11			
FREE		1	Komponen_A	Buffer_11_12	FIRST 1	MOVE WITH Operator_st11 THEN
Komponen_A	Buffer_11_12	1	Komponen_A	Hot_Press_A	FIRST 1	MOVE WITH Operator_st12 THEN
FREE						
veneer_sengon_A	Veneer_sengon_A_storage	1	veneer_sengon_A	Hot_Press_A	JOIN 1	
Komponen_A	Hot_Press_A					
			JOIN 1 veneer_sengon_A			
			get Operator_st12			
			WAIT L(68.0005, 3.0438)			
			free Operator_st12			
FREE		1	Komponen_A	Buffer_12_13	FIRST 1	MOVE WITH Operator_st12 THEN
Komponen_A	Buffer_12_13	1	Komponen_A	Planer_A_2	FIRST 1	MOVE WITH Operator_st13 THEN
FREE						
Komponen_A	Planer_A_2					
			get Operator_st13			
			WAIT N(58.8538, 4.0483)			
			free Operator_st13			

FREE		1	Komponen_A	Buffer_13_14	FIRST 1 MOVE WITH Operator_st13 THEN
Komponen_A FREE	Buffer_13_14	1	Komponen_A	Edge_Glueing_A_2	FIRST 1 MOVE WITH Operator_st14 THEN
Lem_A_2 Komponen_A	Lem_A_storage_2 Edge_Glueing_A_2	1	Lem_A_2	Edge_Glueing_A_2	JOIN 1
			JOIN 1 Lem_A_2 get Operator_st14 WAIT W(22.628, 56.710) free Operator_st14		
FREE		1	Komponen_A	Buffer_14_15	FIRST 1 MOVE WITH Operator_st14 THEN
Komponen_A FREE	Buffer_14_15	1	Komponen_A	Komposer_A	FIRST 1 MOVE WITH Operator_st15 THEN
Lipping_A Komponen_A	Lipping_A_storage Komposer_A	1	Lipping_A	Komposer_A	JOIN 1
			JOIN 1 Lipping_A get Operator_st15 WAIT W(14.9216, 61.393) free Operator_st15		
FREE		1	Komponen_A	Buffer_15_16	FIRST 1 MOVE WITH Operator_st15 THEN
Komponen_A FREE	Buffer_15_16	1	Komponen_A	Planer_A_3	FIRST 1 MOVE WITH Operator_st16 THEN
Komponen_A	Planer_A_3		get Operator_st16 WAIT L(60.8127, 3.1131) free Operator_st16		
FREE		1	Komponen_A	Buffer_16_17	FIRST 1 MOVE WITH Operator_st16 THEN
Komponen_A FREE	Buffer_16_17	1	Komponen_A	Moulding_A	FIRST 1 MOVE WITH Operator_st17 THEN
Komponen_A	Moulding_A		get Operator_st17 WAIT N(51.3770, 2.5164) free Operator_st17		
FREE		1	Komponen_A	Buffer_17_18	FIRST 1 MOVE WITH Operator_st17 THEN
Komponen_A FREE	Buffer_17_18	1	Komponen_A	Moulding_A_2	FIRST 1 MOVE WITH Operator_st18 THEN
Komponen_A	Moulding_A_2		get Operator_st18 WAIT W(40.692, 53.256) free Operator_st18		
FREE		1	Komponen_A	Buffer_18_19	FIRST 1 MOVE WITH Operator_st18 THEN

Komponen_A FREE	Buffer_18_19		1	Komponen_A	Boring_A	FIRST 1 MOVE WITH Operator_st19 THEN
Komponen_A	Boring_A	get Operator_st19 WAIT L(55.9656, 1.9637) free Operator_st19	1	Komponen_A	Buffer_19_20	FIRST 1 MOVE WITH Operator_st19 THEN
FREE						
Komponen_A FREE	Buffer_19_20	COMBINE 2	1	sepasang_komponen_A	Assembling_press	FIRST 1 MOVE WITH Operator_st20 THEN
Stile_B	Buffer_9_20	COMBINE 2	1	sepasang_stile_B	Assembling_press	FIRST 1 MOVE WITH Operator_st20 THEN
FREE						
ALL	Assembling_press	COMBINE 2 GET Operator_st20 WAIT N(138.079, 6.9183) FREE Operator_st20				
FREE			1	Pintu	Buffer_20_21	FIRST 1 MOVE WITH Operator_st20 THEN
Pintu FREE	Buffer_20_21		1	Pintu	Edge_Glueing_pintu	FIRST 1 MOVE WITH Operator_st21 THEN
Lem_pintu Pintu	Lem_pintu_storage Edge_Glueing_pintu	JOIN 1 Lem_pintu get Operator_st21 WAIT N(109.575, 3.4015) free Operator_st21	1	Lem_pintu	Edge_Glueing_pintu	JOIN 1
FREE			1	Pintu	Buffer_21_22	FIRST 1 MOVE WITH Operator_st21 THEN
Pintu FREE	Buffer_21_22		1	Pintu	Hot_press_pintu	FIRST 1 MOVE WITH Operator_st22 THEN
Veneer_rangkai Pintu	Veneer_rangkai_storage Hot_press_pintu	JOIN 1 Veneer_rangkai get Operator_st22 WAIT W(42.146, 131.21) free Operator_st22	1	Veneer_rangkai	Hot_press_pintu	JOIN 1
FREE			1	Pintu	Buffer_22_23	FIRST 1 MOVE WITH Operator_st22 THEN


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Pintu          Buffer_22_23          1  Pintu          Repair_inspeksi_table FIRST 1  MOVE WITH Operator_st23 THEN
FREE

Serpihan_kayu  Serpihan_kayu_storage          1  Serpihan_kayu  Repair_inspeksi_table JOIN 1
Pintu          Repair_inspeksi_table
JOIN 1 Serpihan_kayu
get Operator_st23
WAIT N(121.332, 6.6225)
free Operator_st23

FREE          1  Pintu          Buffer_23_24          FIRST 1  MOVE WITH Operator_st23 THEN

Pintu          Buffer_23_24          1  Pintu          Packing_table          FIRST 1  MOVE WITH Operator_st24 THEN
FREE

Karton_dan_plastik  karton_dan_plastik_storage          1  Karton_dan_plastik  Packing_table          JOIN 1
Pintu          Packing_table
JOIN 1 Karton_dan_plastik
get Operator_st24
WAIT N(147.951, 7.8668)
free Operator_st24

FREE          1  Pintu          Buffer_Akhir          FIRST 1  MOVE WITH Operator_st24 THEN

Pintu          Buffer_Akhir          1  Pintu_siap_jual  EXIT          FIRST 1

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*****
*                      Arrivals                      *
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Entity	Location	Qty each	First Time	Occurrences	Frequency	Logic
Core_engsel_core_sengon	Core_engsel_dan_sengon_storage	500	0	inf	86400	
Lem_B_1	Lem_B_storage	500	0	inf	86400	
Veneer_sengon_B	Veneer_sengon_B_storage	500	0	inf	86400	
Lem_B_2	Lem_B_Storage_2	500	0	inf	86400	
Lipping_B	Lipping_B_storage	500	0	inf	86400	
Core_sengon_A	Core_sengon_A_storage	500	0	inf	86400	
Lem_A_1	Lem_A_storage	500	0	inf	86400	
veneer_sengon_A	Veneer_sengon_A_storage	500	0	inf	86400	
Lem_A_2	Lem_A_storage_2	500	0	inf	86400	
Lipping_A	Lipping_A_storage	500	0	inf	86400	
Lem_pintu	Lem_pintu_storage	250	0	inf	86400	
Veneer_rangkai	Veneer_rangkai_storage	250	0	inf	86400	
Serpihan_kayu	Serpihan_kayu_storage	250	0	inf	86400	
Karton_dan_plastik	karton_dan_plastik_storage	250	0	inf	86400	
Stile_B	Buffer_1_2	16	0	1		
Stile_B	Buffer_2_3	1	0	1		
Stile_B	Buffer_3_4	10	0	1		
Stile_B	Buffer_4_5	1	0	1		
Stile_B	Buffer_5_6	1	0	1		
Stile_B	Buffer_6_7	1	0	1		
Stile_B	Buffer_7_8	15	0	1		

Stile_B	Buffer_8_9	16	0	1
Stile_B	Buffer_9_20	2	0	1
Komponen_A	Buffer_10_11	1	0	1
Komponen_A	Buffer_11_12	1	0	1
Komponen_A	Buffer_12_13	1	0	1
Komponen_A	Buffer_13_14	1	0	1
Komponen_A	Buffer_14_15	1	0	1
Komponen_A	Buffer_15_16	1	0	1
Komponen_A	Buffer_16_17	1	0	1
Komponen_A	Buffer_17_18	1	0	1
Komponen_A	Buffer_18_19	1	0	1
Komponen_A	Buffer_19_20	2	0	1
Pintu	Buffer_20_21	1	0	1
Pintu	Buffer_21_22	1	0	1
Pintu	Buffer_22_23	1	0	1
Pintu	Buffer_23_24	1	0	1

 * Shift Assignments *

Locations	Resources	Shift Files	Priorities	Disable Logic
Operator_st1:	D:\Fendy\Skripsi\Skripsiku\jam	99,99,99,99	No	
Operator_st10				
Operator_st11				
Operator_st12				
Operator_st13				
Operator_st14				
Operator_st15				
Operator_st16				
Operator_st17				
Operator_st18				
Operator_st19				
Operator_st2				
Operator_st20				
Operator_st21				
Operator_st22				
Operator_st23				
Operator_st24				
Operator_st3				
Operator_st4				
Operator_st5				
Operator_st6				
Operator_st7				
Operator_st8				
Operator_st9				

* External Files *

ID	Type	File Name	Prompt
(null)	Shift	D:\Fendy\Skripsi\Skripsiku\jam kerja.sft	

General Report

Output from D:\FENDY\SKRIPSI\SKRIPSIKU\MODEL USULAN.MOD

Date: Nov/30/2004 Time: 02:54:34 AM

Scenario : Normal Run

Replication : Average

Period : Final Report (0 sec to 9 hr Elapsed: 9 hr)

Simulation Time : 9 hr

LOCATIONS

Location Name	Scheduled Hours	Capacity	Total Entries	Average Seconds Per Entry	Average Contents	Maximum Contents	Current Contents	% Util	
Planer A	9	1	340.2	80.330138	0.843466	1	0.9	84.35	(Average)
Planer A	0	0	0.695852	2.362488	0.024826	0	0.307794	2.48	(Std. Dev.)
Core sengan A storage	9	500	500	20916.313560	322.783	500	159.8	64.56	(Average)
Core sengan A storage	0	0	0	20.322902	0.313625	0	0.695852	0.06	(Std. Dev.)
Buffer 10 11	9	1	340.2	85.216317	0.894769	1	0.9	89.48	(Average)
Buffer 10 11	0	0	0.695852	3.643658	0.0382086	0	0.307794	3.82	(Std. Dev.)
Edge Glueing A	9	1	339.2	80.800170	0.845904	1	0.85	84.59	(Average)
Edge Glueing A	0	0	0.695852	0.222034	0.000923732	0	0.366348	0.09	(Std. Dev.)
Lem A storage	9	500	500	20971.485180	323.634	500	160.8	64.73	(Average)
Lem A storage	0	0	0	20.218227	0.31201	0	0.695852	0.06	(Std. Dev.)
Buffer 11 12	9	1	339.35	89.859285	0.941166	1	1	94.12	(Average)
Buffer 11 12	0	0	0.587143	2.396744	0.0251571	0	0	2.52	(Std. Dev.)
Hot Press A	9	1	338.35	83.776659	0.874869	1	0.95	87.49	(Average)
Hot Press A	0	0	0.587143	0.166149	0.000216454	0	0.223607	0.02	(Std. Dev.)
Veneer sengan A storage	9	500	500	21026.953500	324.49	500	161.65	64.90	(Average)
Veneer sengan A storage	0	0	0	20.023586	0.309006	0	0.587143	0.06	(Std. Dev.)
Buffer 12 13	9	1	338.35	56.439130	0.589346	1	0.95	58.93	(Average)
Buffer 12 13	0	0	0.587143	6.763318	0.0703238	0	0.223607	7.03	(Std. Dev.)
Planer A 2	9	1	337.35	78.635323	0.818749	1	0.7	81.87	(Average)
Planer A 2	0	0	0.587143	0.481764	0.00434439	0	0.470162	0.43	(Std. Dev.)
Edge Glueing A 2	9	1	336.5	79.624179	0.826957	1	0.65	82.70	(Average)
Edge Glueing A 2	0	0	0.606977	0.695140	0.00693756	0	0.48936	0.69	(Std. Dev.)
Buffer 13 14	9	1	337.5	62.010596	0.645956	1	0.85	64.60	(Average)
Buffer 13 14	0	0	0.606977	4.520934	0.0472772	0	0.366348	4.73	(Std. Dev.)
Lem A storage 2	9	500	500	21096.043680	325.556	500	163.5	65.11	(Average)
Lem A storage 2	0	0	0	20.611570	0.31808	0	0.606977	0.06	(Std. Dev.)
Komposer A	9	1	335.8	81.407131	0.843726	1	0.85	84.37	(Average)

Komposer A	0	0	0.767772	2.403801	0.0251568	0	0.366348	2.52	(Std. Dev.)
Buffer 14 15	9	1	336.8	68.830214	0.715469	1	0.95	71.55	(Average)
Buffer 14 15	0	0	0.767772	3.747616	0.038534	0	0.223607	3.85	(Std. Dev.)
Lipping A storage	9	500	500	21135.222600	326.161	500	164.2	65.23	(Average)
Lipping A storage	0	0	0	21.789788	0.336262	0	0.767772	0.07	(Std. Dev.)
Buffer 15 16	9	1	335.95	75.156125	0.77928	1	1	77.93	(Average)
Buffer 15 16	0	0	0.825578	3.277309	0.0339736	0	0	3.40	(Std. Dev.)
Planer A 3	9	1	334.95	80.805027	0.835352	1	0.95	83.54	(Average)
Planer A 3	0	0	0.825578	2.422643	0.0248667	0	0.223607	2.49	(Std. Dev.)
Buffer 16 17	9	1	335	75.034607	0.775777	1	1	77.58	(Average)
Buffer 16 17	0	0	0.858395	4.276673	0.0435015	0	0	4.35	(Std. Dev.)
Moulding A	9	1	334	82.390699	0.849329	1	0.95	84.93	(Average)
Moulding A	0	0	0.858395	0.529238	0.00459421	0	0.223607	0.46	(Std. Dev.)
Buffer 17 18	9	1	334.05	84.515776	0.871352	1	1	87.14	(Average)
Buffer 17 18	0	0	0.825578	3.156634	0.0320761	0	0	3.21	(Std. Dev.)
Moulding A 2	9	1	333.05	81.829450	0.841146	1	0.85	84.11	(Average)
Moulding A 2	0	0	0.825578	0.313640	0.00246843	0	0.366348	0.25	(Std. Dev.)
Buffer 18 19	9	1	333.1	87.619618	0.900764	1	0.9	90.08	(Average)
Buffer 18 19	0	0	0.788069	4.141160	0.0417595	0	0.307794	4.18	(Std. Dev.)
Boring A	9	1	332.15	85.441294	0.8759	1	0.8	87.59	(Average)
Boring A	0	0	0.812728	0.223265	0.000623824	0	0.410391	0.06	(Std. Dev.)
Buffer 19 20	9	2	333.3	149.528434	1.53823	2	1.5	76.91	(Average)
Buffer 19 20	0	0	0.732695	9.272235	0.0959121	0	0.606977	4.80	(Std. Dev.)
Assembling press	9	2	331.5	165.112427	1.68933	2	1.6	84.47	(Average)
Assembling press	0	0	0.760886	4.824480	0.0488742	0	0.680557	2.44	(Std. Dev.)
Buffer 20 21	9	1	165.95	9.570172	0.0490176	1	0.05	4.90	(Average)
Buffer 20 21	0	0	0.223607	0.004039	6.83656e-05	0	0.223607	0.01	(Std. Dev.)
Edge Glueing pintu	9	1	165.85	126.664367	0.648384	1	0.55	64.84	(Average)
Edge Glueing pintu	0	0	0.366348	8.939624	0.0459328	0	0.510418	4.59	(Std. Dev.)
Buffer 21 22	9	1	166.3	10.861453	0.0557389	1	0.15	5.57	(Average)
Buffer 21 22	0	0	0.470162	4.839238	0.024773	0	0.366348	2.48	(Std. Dev.)
Hot press pintu	9	1	166.05	147.701927	0.756977	1	0.65	75.70	(Average)
Hot press pintu	0	0	0.223607	7.965088	0.040911	0	0.48936	4.09	(Std. Dev.)
Veneer rangkai storage	9	250	250	21327.567600	164.565	250	83.95	65.83	(Average)
Veneer rangkai storage	0	0	0	21.888944	0.168896	0	0.223607	0.07	(Std. Dev.)
Buffer 22 23	9	1	166.4	12.687833	0.0652148	1	0	6.52	(Average)
Buffer 22 23	0	0	0.502625	9.313121	0.0480612	0	0	4.81	(Std. Dev.)
Repair inspeksi table	9	1	166.35	142.779681	0.733071	1	0.75	73.31	(Average)
Repair inspeksi table	0	0	0.48936	7.800589	0.0402455	0	0.444262	4.02	(Std. Dev.)
Serpihan kayu storage	9	250	250	21310.893360	164.436	250	83.65	65.77	(Average)
Serpihan kayu storage	0	0	0	20.236072	0.156143	0	0.48936	0.06	(Std. Dev.)
Buffer 23 24	9	1	166.6	74.043356	0.380865	1	0	38.09	(Average)
Buffer 23 24	0	0	0.502625	30.722822	0.158428	0	0	15.84	(Std. Dev.)
Packing table	9	1	166.6	169.089981	0.86945	1	0.8	86.94	(Average)
Packing table	0	0	0.502625	0.862846	0.00383107	0	0.410391	0.38	(Std. Dev.)

Boring B	9	1	330.7	73.731626	0.752563	1	0.65	75.26	(Average)
Boring B	0	0	0.656947	4.023789	0.0410904	0	0.48936	4.11	(Std. Dev.)
Buffer 9 20	9	2	332.05	96.136985	0.98519	2	0.75	49.26	(Average)
Buffer 9 20	0	0	0.759155	11.237930	0.114526	0	0.638666	5.73	(Std. Dev.)
Buffer 8 9	9	16	330.9	308.391038	3.14969	16	0.15	19.69	(Average)
Buffer 8 9	0	0	0.788069	16.718184	0.173149	0	0.366348	1.08	(Std. Dev.)
Moulding B	9	1	315.7	85.849932	0.836503	1	0.8	83.65	(Average)
Moulding B	0	0	0.656947	0.214437	0.000370822	0	0.410391	0.04	(Std. Dev.)
Buffer 7 8	9	15	330.6	1452.731052	14.8232	15	14.85	98.82	(Average)
Buffer 7 8	0	0	0.598243	6.723217	0.056287	0	0.366348	0.38	(Std. Dev.)
Planer B 3	9	1	316.45	85.040739	0.830578	1	0.85	83.06	(Average)
Planer B 3	0	0	0.604805	2.587034	0.0249042	0	0.366348	2.49	(Std. Dev.)
Buffer 6 7	9	1	317.45	96.803167	0.948458	1	0.95	94.85	(Average)
Buffer 6 7	0	0	0.604805	0.332903	0.00260758	0	0.223607	0.26	(Std. Dev.)
Komposer B	9	1	317.3	84.161409	0.824234	1	0.8	82.42	(Average)
Komposer B	0	0	0.656947	3.412369	0.0340006	0	0.410391	3.40	(Std. Dev.)
Lipping B storage	9	500	500	22055.427000	340.362	500	182.7	68.07	(Average)
Lipping B storage	0	0	0	22.477412	0.346874	0	0.656947	0.07	(Std. Dev.)
Edge glueing B 2	9	1	318.2	83.990673	0.82487	1	0.9	82.49	(Average)
Edge glueing B 2	0	0	0.695852	2.531785	0.0248795	0	0.307794	2.49	(Std. Dev.)
Buffer 5 6	9	1	318.3	93.920626	0.922684	1	1	92.27	(Average)
Buffer 5 6	0	0	0.656947	2.454537	0.0242117	0	0	2.42	(Std. Dev.)
Lem B Storage 2	9	500	500	22001.654820	339.532	500	181.8	67.91	(Average)
Lem B Storage 2	0	0	0	22.822649	0.352201	0	0.695852	0.07	(Std. Dev.)
Buffer 4 5	9	1	319.2	90.515422	0.891765	1	1	89.18	(Average)
Buffer 4 5	0	0	0.695852	3.430741	0.0343551	0	0	3.44	(Std. Dev.)
Planer B 2	9	1	319.2	84.166271	0.829193	1	1	82.92	(Average)
Planer B 2	0	0	0.695852	2.518300	0.0248234	0	0	2.48	(Std. Dev.)
Buffer 3 4	9	10	329.2	946.234649	9.61413	10	10	96.14	(Average)
Buffer 3 4	0	0	0.695852	6.836350	0.0600582	0	0	0.60	(Std. Dev.)
Hot press B	9	1	319.95	83.920261	0.828706	1	0.75	82.87	(Average)
Hot press B	0	0	0.759155	2.528103	0.0248313	0	0.444262	2.48	(Std. Dev.)
Veneer sengan B storage	9	500	500	21915.532620	338.203	500	180.05	67.64	(Average)
Veneer sengan B storage	0	0	0	20.890145	0.322379	0	0.759155	0.06	(Std. Dev.)
Buffer 2 3	9	1	320.95	93.907867	0.930217	1	0.85	93.02	(Average)
Buffer 2 3	0	0	0.759155	2.651013	0.0256023	0	0.366348	2.56	(Std. Dev.)
Edge glueing B	9	1	320.75	83.110189	0.822753	1	0.65	82.28	(Average)
Edge glueing B	0	0	0.638666	3.483558	0.0342339	0	0.48936	3.42	(Std. Dev.)
Lem B storage	9	500	500	21861.364200	337.367	500	179.25	67.47	(Average)
Lem B storage	0	0	0	20.314433	0.313494	0	0.638666	0.06	(Std. Dev.)
Buffer 1 2	9	16	334.25	1186.438185	12.24	16	13.4	76.50	(Average)
Buffer 1 2	0	0	0.55012	36.498805	0.385273	0	0.820783	2.41	(Std. Dev.)
Planer B	9	1	319.25	83.585452	0.823606	1	0.95	82.36	(Average)
Planer B	0	0	0.55012	3.449943	0.0341545	0	0.223607	3.42	(Std. Dev.)
Core engsel dan sengan storage	9	500	500	22043.594700	340.179	500	180.75	68.04	(Average)

Core engsel dan sengon storage	0	0	0	13.235793	0.204256	0	0.55012	0.04	(Std. Dev.)
Lem pintu storage	9	250	250	21359.550600	164.811	250	84.15	65.92	(Average)
Lem pintu storage	0	0	0	22.552308	0.174015	0	0.366348	0.07	(Std. Dev.)
karton dan plastik storage	9	250	250	21332.037720	164.599	250	83.4	65.84	(Average)
karton dan plastik storage	0	0	0	23.061113	0.177941	0	0.502625	0.07	(Std. Dev.)
Komponen panel spindle storage	9	250	0	0.000000	0	0	0	0.00	(Average)
Komponen panel spindle storage	0	0	0	0.000000	0	0	0	0.00	(Std. Dev.)
Buffer Akhir	9	250	165.7	0.000000	0	1	0	0.00	(Average)
Buffer Akhir	0	0	0.470162	0.000000	0	0	0	0.00	(Std. Dev.)

LOCATION STATES BY PERCENTAGE (Multiple Capacity)

Location Name	Scheduled Hours	% Empty	% Partially Occupied	% Full	% Down	
Core sengon A storage	9	0.00	99.99	0.01	0.00	(Average)
Core sengon A storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem A storage	9	0.00	99.98	0.02	0.00	(Average)
Lem A storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Veneer sengon A storage	9	0.00	99.98	0.02	0.00	(Average)
Veneer sengon A storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem A storage 2	9	0.00	99.98	0.02	0.00	(Average)
Lem A storage 2	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lipping A storage	9	0.00	99.98	0.02	0.00	(Average)
Lipping A storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Buffer 19 20	9	4.58	37.01	58.41	0.00	(Average)
Buffer 19 20	0	4.93	4.55	5.66	0.00	(Std. Dev.)
Assembling press	9	9.80	11.46	78.74	0.00	(Average)
Assembling press	0	0.01	4.88	4.88	0.00	(Std. Dev.)
Veneer rangkai storage	9	0.00	99.97	0.03	0.00	(Average)
Veneer rangkai storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Serpihan kayu storage	9	0.00	99.97	0.03	0.00	(Average)
Serpihan kayu storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Buffer 9 20	9	27.88	45.73	26.40	0.00	(Average)
Buffer 9 20	0	6.06	4.60	6.28	0.00	(Std. Dev.)
Buffer 8 9	9	54.32	45.66	0.01	0.00	(Average)
Buffer 8 9	0	3.71	3.71	0.00	0.00	(Std. Dev.)
Buffer 7 8	9	0.00	17.65	82.35	0.00	(Average)
Buffer 7 8	0	0.00	5.60	5.60	0.00	(Std. Dev.)
Lipping B storage	9	0.00	99.97	0.03	0.00	(Average)
Lipping B storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem B Storage 2	9	0.00	99.97	0.03	0.00	(Average)
Lem B Storage 2	0	0.00	0.00	0.00	0.00	(Std. Dev.)

Buffer 3 4	9	0.00	25.72	74.28	0.00	(Average)
Buffer 3 4	0	0.00	5.04	5.04	0.00	(Std. Dev.)
Veneer sengon B storage	9	0.00	99.97	0.03	0.00	(Average)
Veneer sengon B storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem B storage	9	0.00	99.97	0.03	0.00	(Average)
Lem B storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Buffer 1 2	9	0.00	99.98	0.02	0.00	(Average)
Buffer 1 2	0	0.00	0.01	0.01	0.00	(Std. Dev.)
Core engsel dan sengon storage	9	0.00	99.99	0.01	0.00	(Average)
Core engsel dan sengon storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem pintu storage	9	0.00	99.97	0.03	0.00	(Average)
Lem pintu storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
karton dan plastik storage	9	0.00	99.97	0.03	0.00	(Average)
karton dan plastik storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Komponen panel spindle storage	9	100.00	0.00	0.00	0.00	(Average)
Komponen panel spindle storage	0	0.00	0.00	0.00	0.00	(Std. Dev.)
Buffer Akhir	9	100.00	0.00	0.00	0.00	(Average)
Buffer Akhir	0	0.00	0.00	0.00	0.00	(Std. Dev.)

LOCATION STATES BY PERCENTAGE (Single Capacity)

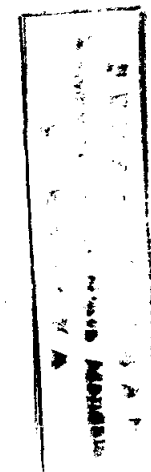
Location Name	Scheduled Hours	% Operation	% Setup	% Idle	% Waiting	% Blocked	% Down	
Planer A	9	64.62	0.00	15.65	4.44	15.29	0.00	(Average)
Planer A	0	0.19	0.00	2.48	5.58	5.73	0.00	(Std. Dev.)
Buffer 10 11	9	0.00	0.00	10.52	11.09	78.39	0.00	(Average)
Buffer 10 11	0	0.00	0.00	3.82	0.04	3.80	0.00	(Std. Dev.)
Edge Glueing A	9	57.69	0.00	15.41	2.22	24.68	0.00	(Average)
Edge Glueing A	0	0.17	0.00	0.09	4.56	4.56	0.00	(Std. Dev.)
Buffer 11 12	9	0.00	0.00	5.88	9.38	84.74	0.00	(Average)
Buffer 11 12	0	0.00	0.00	2.52	0.02	2.51	0.00	(Std. Dev.)
Hot Press A	9	70.88	0.00	12.51	2.78	13.83	0.00	(Average)
Hot Press A	0	0.21	0.00	0.02	4.93	5.06	0.00	(Std. Dev.)
Buffer 12 13	9	0.00	0.00	41.07	9.64	49.30	0.00	(Average)
Buffer 12 13	0	0.00	0.00	7.03	0.18	6.88	0.00	(Std. Dev.)
Planer A 2	9	61.20	0.00	18.13	2.22	18.45	0.00	(Average)
Planer A 2	0	0.24	0.00	0.43	4.56	4.79	0.00	(Std. Dev.)
Edge Glueing A 2	9	57.48	0.00	17.30	2.22	23.00	0.00	(Average)
Edge Glueing A 2	0	0.22	0.00	0.69	4.56	4.49	0.00	(Std. Dev.)
Buffer 13 14	9	0.00	0.00	35.40	8.16	56.43	0.00	(Average)
Buffer 13 14	0	0.00	0.00	4.73	0.14	4.63	0.00	(Std. Dev.)
Komposer A	9	61.26	0.00	15.63	1.67	21.44	0.00	(Average)
Komposer A	0	0.38	0.00	2.52	4.07	4.41	0.00	(Std. Dev.)

Buffer 14 15	9	0.00	0.00	28.45	9.05	62.49	0.00	(Average)
Buffer 14 15	0	0.00	0.00	3.85	2.48	4.09	0.00	(Std. Dev.)
Buffer 15 16	9	0.00	0.00	22.07	11.16	66.76	0.00	(Average)
Buffer 15 16	0	0.00	0.00	3.40	2.49	4.41	0.00	(Std. Dev.)
Planer A 3	9	62.76	0.00	16.46	2.78	17.99	0.00	(Average)
Planer A 3	0	0.21	0.00	2.49	4.93	5.21	0.00	(Std. Dev.)
Buffer 16 17	9	0.00	0.00	22.42	8.74	68.84	0.00	(Average)
Buffer 16 17	0	0.00	0.00	4.35	0.08	4.33	0.00	(Std. Dev.)
Moulding A	9	52.88	0.00	15.07	1.67	30.39	0.00	(Average)
Moulding A	0	0.12	0.00	0.46	4.07	4.18	0.00	(Std. Dev.)
Buffer 17 18	9	0.00	0.00	12.86	10.72	76.41	0.00	(Average)
Buffer 17 18	0	0.00	0.00	3.21	0.08	3.19	0.00	(Std. Dev.)
Moulding A 2	9	53.99	0.00	15.89	2.78	27.34	0.00	(Average)
Moulding A 2	0	0.15	0.00	0.25	4.94	4.95	0.00	(Std. Dev.)
Buffer 18 19	9	0.00	0.00	9.92	9.15	80.93	0.00	(Average)
Buffer 18 19	0	0.00	0.00	4.18	0.03	4.18	0.00	(Std. Dev.)
Boring A	9	57.35	0.00	12.41	6.67	23.58	0.00	(Average)
Boring A	0	0.21	0.00	0.06	5.58	5.57	0.00	(Std. Dev.)
Buffer 20 21	9	0.00	0.00	95.10	4.90	0.00	0.00	(Average)
Buffer 20 21	0	0.00	0.00	0.01	0.01	0.00	0.00	(Std. Dev.)
Edge Glueing pintu	9	55.95	0.00	35.16	8.89	0.00	0.00	(Average)
Edge Glueing pintu	0	0.20	0.00	4.59	4.56	0.00	0.00	(Std. Dev.)
Buffer 21 22	9	0.00	0.00	94.43	5.51	0.06	0.00	(Average)
Buffer 21 22	0	0.00	0.00	2.48	2.48	0.03	0.00	(Std. Dev.)
Hot press pintu	9	66.25	0.00	24.30	9.44	0.00	0.00	(Average)
Hot press pintu	0	0.17	0.00	4.09	4.07	0.00	0.00	(Std. Dev.)
Buffer 22 23	9	0.00	0.00	93.48	5.06	1.46	0.00	(Average)
Buffer 22 23	0	0.00	0.00	4.81	0.25	4.59	0.00	(Std. Dev.)
Repair inspeksi table	9	62.21	0.00	26.69	5.02	6.08	0.00	(Average)
Repair inspeksi table	0	0.22	0.00	4.02	5.65	6.91	0.00	(Std. Dev.)
Buffer 23 24	9	0.00	0.00	61.91	5.69	32.40	0.00	(Average)
Buffer 23 24	0	0.00	0.00	15.84	0.20	15.70	0.00	(Std. Dev.)
Packing table	9	75.83	0.00	13.05	11.11	0.00	0.00	(Average)
Packing table	0	0.38	0.00	0.38	0.00	0.00	0.00	(Std. Dev.)
Boring B	9	64.11	0.00	24.74	6.12	5.02	0.00	(Average)
Boring B	0	0.13	0.00	4.11	5.66	5.34	0.00	(Std. Dev.)
Moulding B	9	72.54	0.00	16.35	11.11	0.00	0.00	(Average)
Moulding B	0	0.04	0.00	0.04	0.00	0.00	0.00	(Std. Dev.)
Planer B 3	9	71.26	0.00	16.94	2.23	9.57	0.00	(Average)
Planer B 3	0	0.28	0.00	2.49	4.55	4.90	0.00	(Std. Dev.)
Buffer 6 7	9	0.00	0.00	5.15	12.84	82.01	0.00	(Average)
Buffer 6 7	0	0.00	0.00	0.26	2.49	2.47	0.00	(Std. Dev.)
Komposer B	9	62.15	0.00	17.58	1.11	19.16	0.00	(Average)
Komposer B	0	0.25	0.00	3.40	3.42	4.50	0.00	(Std. Dev.)
Edge glueing B 2	9	56.92	0.00	17.51	2.22	23.35	0.00	(Average)

Edge glueing B 2	0	0.16	0.00	2.49	4.56	4.87	0.00	(Std. Dev.)
Buffer 5 6	9	0.00	0.00	7.73	13.37	78.90	0.00	(Average)
Buffer 5 6	0	0.00	0.00	2.42	3.42	4.07	0.00	(Std. Dev.)
Buffer 4 5	9	0.00	0.00	10.82	12.64	76.54	0.00	(Average)
Buffer 4 5	0	0.00	0.00	3.44	2.48	4.09	0.00	(Std. Dev.)
Planer B 2	9	64.24	0.00	17.08	3.89	14.79	0.00	(Average)
Planer B 2	0	0.13	0.00	2.48	5.44	5.59	0.00	(Std. Dev.)
Hot press B	9	69.03	0.00	17.13	3.89	9.95	0.00	(Average)
Hot press B	0	0.16	0.00	2.48	5.43	5.67	0.00	(Std. Dev.)
Buffer 2 3	9	0.00	0.00	6.98	12.97	80.05	0.00	(Average)
Buffer 2 3	0	0.00	0.00	2.56	2.48	3.33	0.00	(Std. Dev.)
Edge glueing B	9	65.43	0.00	17.72	2.22	14.62	0.00	(Average)
Edge glueing B	0	0.13	0.00	3.42	4.56	5.28	0.00	(Std. Dev.)
Planer B	9	72.36	0.00	17.64	10.00	0.00	0.00	(Average)
Planer B	0	0.03	0.00	3.42	3.42	0.00	0.00	(Std. Dev.)

RESOURCES

Resource Name	Units	Scheduled Hours	Number Of Times Used	Average Seconds Per Usage	Average Seconds Travel To Use	Average Seconds Travel To Park	% Blocked In Travel	% Util	
Operator st10	1	8	1019.7	22.929551	2.398587	0.000000	0.00	89.68	(Average)
Operator st10	0	0	1.92217	0.053601	0.000727	0.000000	0.00	0.24	(Std. Dev.)
Operator st11	1	8	1016.85	20.780007	2.398939	0.000000	0.00	81.84	(Average)
Operator st11	0	0	1.78517	0.034284	0.000930	0.000000	0.00	0.22	(Std. Dev.)
Operator st12	1	8	1014.1	24.643795	1.998915	0.000000	0.00	93.81	(Average)
Operator st12	0	0	1.74416	0.058732	0.000441	0.000000	0.00	0.25	(Std. Dev.)
Operator st13	1	8	1011.4	22.005129	2.398546	0.000000	0.00	85.70	(Average)
Operator st13	0	0	1.63514	0.071361	0.001098	0.000000	0.00	0.28	(Std. Dev.)
Operator st14	1	8	1009	20.455318	1.999030	0.000000	0.00	78.67	(Average)
Operator st14	0	0	1.89181	0.066079	0.001047	0.000000	0.00	0.26	(Std. Dev.)
Operator st15	1	8	1006.6	21.718274	1.998947	0.000000	0.00	82.90	(Average)
Operator st15	0	0	2.34857	0.103781	0.000787	0.000000	0.00	0.44	(Std. Dev.)
Operator st16	1	8	1003.9	22.654497	2.398805	0.000000	0.00	87.33	(Average)
Operator st16	0	0	2.48998	0.058508	0.000003	0.000000	0.00	0.26	(Std. Dev.)
Operator st17	1	8	1001.05	19.112806	1.998951	0.000000	0.00	73.38	(Average)
Operator st17	0	0	2.52305	0.034141	0.000224	0.000000	0.00	0.16	(Std. Dev.)
Operator st18	1	8	998.3	19.922583	2.398557	0.000000	0.00	77.37	(Average)
Operator st18	0	0	2.36421	0.031024	0.000741	0.000000	0.00	0.21	(Std. Dev.)
Operator st19	1	8	995.7	20.659623	1.998835	0.000000	0.00	78.34	(Average)
Operator st19	0	0	2.17885	0.043770	0.001132	0.000000	0.00	0.27	(Std. Dev.)
Operator st1	1	8	956.8	27.302028	2.798390	0.000000	0.00	100.00	(Average)



Operator st1	0	0	1.64157	0.051628	0.000654	0.000000	0.00	0.00	(Std. Dev.)
Operator st2	1	8	961.7	24.843759	2.798253	0.000000	0.00	92.30	(Average)
Operator st2	0	0	2.05452	0.034137	0.001549	0.000000	0.00	0.17	(Std. Dev.)
Operator st3	1	8	959.25	26.113265	2.798832	0.000000	0.00	96.30	(Average)
Operator st3	0	0	2.14905	0.035004	0.001233	0.000000	0.00	0.22	(Std. Dev.)
Operator st4	1	8	956.6	24.556247	2.798536	0.000000	0.00	90.86	(Average)
Operator st4	0	0	2.08756	0.049849	0.000003	0.000000	0.00	0.17	(Std. Dev.)
Operator st5	1	8	953.7	22.135818	2.798637	0.000000	0.00	82.57	(Average)
Operator st5	0	0	2.00263	0.027989	0.000521	0.000000	0.00	0.21	(Std. Dev.)
Operator st6	1	8	951.1	23.971192	2.798002	0.000000	0.00	88.40	(Average)
Operator st6	0	0	1.74416	0.080925	0.001253	0.000000	0.00	0.29	(Std. Dev.)
Operator st7	1	8	948.55	27.140136	2.798304	0.000000	0.00	98.61	(Average)
Operator st7	0	0	1.63755	0.084040	0.001358	0.000000	0.00	0.33	(Std. Dev.)
Operator st8	1	8	946.35	27.633997	2.798415	0.000000	0.00	100.00	(Average)
Operator st8	0	0	2.0844	0.067168	0.001529	0.000000	0.00	0.00	(Std. Dev.)
Operator st9	1	8	991.5	23.750078	2.798064	0.000000	0.00	91.40	(Average)
Operator st9	0	0	2.01311	0.035948	0.001765	0.000000	0.00	0.17	(Std. Dev.)
Operator st20	1	8	662.15	38.047671	3.598823	0.000000	0.00	95.75	(Average)
Operator st20	0	0	1.26803	0.148839	0.001444	0.000000	0.00	0.28	(Std. Dev.)
Operator st21	1	8	497.05	39.668398	3.194873	0.000000	0.00	73.98	(Average)
Operator st21	0	0	0.887041	0.117344	0.003686	0.000000	0.00	0.23	(Std. Dev.)
Operator st22	1	8	497.6	46.336830	3.196424	0.000000	0.00	85.58	(Average)
Operator st22	0	0	0.88258	0.097018	0.004137	0.000000	0.00	0.21	(Std. Dev.)
Operator st23	1	8	498.35	43.642117	3.195825	0.000000	0.00	81.05	(Average)
Operator st23	0	0	1.34849	0.190617	0.003144	0.000000	0.00	0.25	(Std. Dev.)
Operator st24	1	8	499	52.436160	2.648638	4.716090	0.00	95.44	(Average)
Operator st24	0	0	1.29777	0.266660	0.064450	0.010030	0.00	0.53	(Std. Dev.)

RESOURCE STATES BY PERCENTAGE

Resource Name	Scheduled Hours	% In Use	% Travel To Use	% Travel To Park	% Idle	% Down	
Operator st10	8	81.18	8.49	0.00	10.32	0.00	(Average)
Operator st10	0	0.23	0.02	0.00	0.24	0.00	(Std. Dev.)
Operator st11	8	73.37	8.47	0.00	18.16	0.00	(Average)
Operator st11	0	0.21	0.01	0.00	0.22	0.00	(Std. Dev.)
Operator st12	8	86.78	7.04	0.00	6.19	0.00	(Average)
Operator st12	0	0.24	0.01	0.00	0.25	0.00	(Std. Dev.)
Operator st13	8	77.28	8.42	0.00	14.30	0.00	(Average)
Operator st13	0	0.27	0.02	0.00	0.28	0.00	(Std. Dev.)
Operator st14	8	71.66	7.00	0.00	21.33	0.00	(Average)
Operator st14	0	0.25	0.01	0.00	0.26	0.00	(Std. Dev.)

Operator st15	8	75.91	6.99	0.00	17.10	0.00	(Average)
Operator st15	0	0.43	0.02	0.00	0.44	0.00	(Std. Dev.)
Operator st16	8	78.97	8.36	0.00	12.67	0.00	(Average)
Operator st16	0	0.25	0.02	0.00	0.26	0.00	(Std. Dev.)
Operator st17	8	66.43	6.95	0.00	26.62	0.00	(Average)
Operator st17	0	0.14	0.02	0.00	0.16	0.00	(Std. Dev.)
Operator st18	8	69.06	8.31	0.00	22.63	0.00	(Average)
Operator st18	0	0.19	0.02	0.00	0.21	0.00	(Std. Dev.)
Operator st19	8	71.43	6.91	0.00	21.66	0.00	(Average)
Operator st19	0	0.25	0.02	0.00	0.27	0.00	(Std. Dev.)
Operator st1	8	90.70	9.30	0.00	0.00	0.00	(Average)
Operator st1	0	0.02	0.02	0.00	0.00	0.00	(Std. Dev.)
Operator st2	8	82.96	9.34	0.00	7.70	0.00	(Average)
Operator st2	0	0.16	0.02	0.00	0.17	0.00	(Std. Dev.)
Operator st3	8	86.98	9.32	0.00	3.70	0.00	(Average)
Operator st3	0	0.20	0.02	0.00	0.22	0.00	(Std. Dev.)
Operator st4	8	81.56	9.30	0.00	9.14	0.00	(Average)
Operator st4	0	0.16	0.02	0.00	0.17	0.00	(Std. Dev.)
Operator st5	8	73.30	9.27	0.00	17.43	0.00	(Average)
Operator st5	0	0.19	0.02	0.00	0.21	0.00	(Std. Dev.)
Operator st6	8	79.16	9.24	0.00	11.60	0.00	(Average)
Operator st6	0	0.28	0.02	0.00	0.29	0.00	(Std. Dev.)
Operator st7	8	89.39	9.22	0.00	1.39	0.00	(Average)
Operator st7	0	0.32	0.02	0.00	0.33	0.00	(Std. Dev.)
Operator st8	8	90.80	9.20	0.00	0.00	0.00	(Average)
Operator st8	0	0.02	0.02	0.00	0.00	0.00	(Std. Dev.)
Operator st9	8	81.76	9.63	0.00	8.60	0.00	(Average)
Operator st9	0	0.15	0.02	0.00	0.17	0.00	(Std. Dev.)
Operator st20	8	87.48	8.28	0.00	4.25	0.00	(Average)
Operator st20	0	0.28	0.01	0.00	0.28	0.00	(Std. Dev.)
Operator st21	8	68.46	5.51	0.00	26.02	0.00	(Average)
Operator st21	0	0.23	0.01	0.00	0.23	0.00	(Std. Dev.)
Operator st22	8	80.06	5.52	0.00	14.42	0.00	(Average)
Operator st22	0	0.20	0.01	0.00	0.21	0.00	(Std. Dev.)
Operator st23	8	75.52	5.53	0.00	18.95	0.00	(Average)
Operator st23	0	0.25	0.02	0.00	0.25	0.00	(Std. Dev.)
Operator st24	8	90.85	4.59	0.95	3.61	0.00	(Average)
Operator st24	0	0.43	0.11	0.11	0.44	0.00	(Std. Dev.)

NODE ENTRIES FOR Net_st10

Node	Total	Blocked
Name	Entries	Entries
----	-----	-----



N1	679.4	0	(Average)
N1	1.3917	0	(Std. Dev.)
N2	339.2	0	(Average)
N2	0.695852	0	(Std. Dev.)
N3	340.2	0	(Average)
N3	0.695852	0	(Std. Dev.)

NODE ENTRIES FOR Net_st11

Node Name	Total Entries	Blocked Entries	
N1	339.3	0	(Average)
N1	0.571241	0	(Std. Dev.)
N2	677.5	0	(Average)
N2	1.23544	0	(Std. Dev.)
N3	338.35	0	(Average)
N3	0.587143	0	(Std. Dev.)

NODE ENTRIES FOR Net_st12

Node Name	Total Entries	Blocked Entries	
N1	338.35	0	(Average)
N1	0.587143	0	(Std. Dev.)
N2	675.7	0	(Average)
N2	1.17429	0	(Std. Dev.)
N3	337.35	0	(Average)
N3	0.587143	0	(Std. Dev.)

NODE ENTRIES FOR Net_st13

Node Name	Total Entries	Blocked Entries	
N1	337.4	0	(Average)
N1	0.598243	0	(Std. Dev.)
N2	673.85	0	(Average)
N2	1.13671	0	(Std. Dev.)
N3	336.5	0	(Average)
N3	0.606977	0	(Std. Dev.)

NODE ENTRIES FOR Net_st14

Node Name	Total Entries	Blocked Entries	
N1	336.65	0	(Average)
N1	0.587143	0	(Std. Dev.)
N2	672.2	0	(Average)
N2	1.19649	0	(Std. Dev.)
N3	335.8	0	(Average)
N3	0.767772	0	(Std. Dev.)

NODE ENTRIES FOR Net_st15

Node Name	Total Entries	Blocked Entries	
N1	335.85	0	(Average)
N1	0.812728	0	(Std. Dev.)
N2	670.7	0	(Average)
N2	1.59275	0	(Std. Dev.)
N3	334.95	0	(Average)
N3	0.825578	0	(Std. Dev.)

NODE ENTRIES FOR Net_st16

Node Name	Total Entries	Blocked Entries	
N1	334.95	0	(Average)
N1	0.825578	0	(Std. Dev.)
N2	668.95	0	(Average)
N2	1.66938	0	(Std. Dev.)
N3	334	0	(Average)
N3	0.858395	0	(Std. Dev.)

NODE ENTRIES FOR Net_st17

Node Name	Total Entries	Blocked Entries
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N1	334	0	(Average)
N1	0.858395	0	(Std. Dev.)
N2	667.05	0	(Average)
N2	1.66938	0	(Std. Dev.)
N3	333.05	0	(Average)
N3	0.825578	0	(Std. Dev.)

NODE ENTRIES FOR Net_st18

Node Name	Total Entries	Blocked Entries	
N1	333.05	0	(Average)
N1	0.825578	0	(Std. Dev.)
N2	665.15	0	(Average)
N2	1.59852	0	(Std. Dev.)
N3	332.1	0	(Average)
N3	0.788069	0	(Std. Dev.)

NODE ENTRIES FOR Net_st19

Node Name	Total Entries	Blocked Entries	
N1	332.2	0	(Average)
N1	0.767772	0	(Std. Dev.)
N2	663.4	0	(Average)
N2	1.50088	0	(Std. Dev.)
N3	331.3	0	(Average)
N3	0.732695	0	(Std. Dev.)

NODE ENTRIES FOR Net_st1

Node Name	Total Entries	Blocked Entries	
N1	637.5	0	(Average)
N1	1.10024	0	(Std. Dev.)
N2	318.25	0	(Average)
N2	0.55012	0	(Std. Dev.)
N3	319.25	0	(Average)

N3 0.55012 0 (Std. Dev.)

NODE ENTRIES FOR Net_st2

Node Name	Total Entries	Blocked Entries	
N1	320.85	0	(Average)
N1	0.74516	0	(Std. Dev.)
N2	640.65	0	(Average)
N2	1.30888	0	(Std. Dev.)
N3	319.95	0	(Average)
N3	0.759155	0	(Std. Dev.)

NODE ENTRIES FOR Net_st3

Node Name	Total Entries	Blocked Entries	
N1	320.1	0	(Average)
N1	0.788069	0	(Std. Dev.)
N2	639.1	0	(Average)
N2	1.44732	0	(Std. Dev.)
N3	319.2	0	(Average)
N3	0.695852	0	(Std. Dev.)

NODE ENTRIES FOR Net_st4

Node Name	Total Entries	Blocked Entries	
N1	319.2	0	(Average)
N1	0.695852	0	(Std. Dev.)
N2	637.4	0	(Average)
N2	1.3917	0	(Std. Dev.)
N3	318.2	0	(Average)
N3	0.695852	0	(Std. Dev.)

NODE ENTRIES FOR Net_st5

Node	Total	Blocked
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Name	Entries	Entries	
----	-----	-----	
N1	318.2	0	(Average)
N1	0.695852	0	(Std. Dev.)
N2	635.5	0	(Average)
N2	1.31789	0	(Std. Dev.)
N3	317.3	0	(Average)
N3	0.656947	0	(Std. Dev.)

NODE ENTRIES FOR Net_st6

Node	Total	Blocked	
Name	Entries	Entries	
----	-----	-----	
N1	317.3	0	(Average)
N1	0.656947	0	(Std. Dev.)
N2	633.65	0	(Average)
N2	1.30888	0	(Std. Dev.)
N3	316.45	0	(Average)
N3	0.604805	0	(Std. Dev.)

NODE ENTRIES FOR Net_st7

Node	Total	Blocked	
Name	Entries	Entries	
----	-----	-----	
N1	316.5	0	(Average)
N1	0.512989	0	(Std. Dev.)
N2	631.95	0	(Average)
N2	1.09904	0	(Std. Dev.)
N3	315.6	0	(Average)
N3	0.598243	0	(Std. Dev.)

NODE ENTRIES FOR Net_st8

Node	Total	Blocked	
Name	Entries	Entries	
----	-----	-----	
N1	315.75	0	(Average)
N1	0.71635	0	(Std. Dev.)
N2	630.55	0	(Average)
N2	1.35627	0	(Std. Dev.)

N3	314.9	0	(Average)
N3	0.788069	0	(Std. Dev.)

NODE ENTRIES FOR Net_st9

Node Name	Total Entries	Blocked Entries	
----	-----	-----	
N1	330.75	0	(Average)
N1	0.71635	0	(Std. Dev.)
N2	660.55	0	(Average)
N2	1.35627	0	(Std. Dev.)
N3	330.05	0	(Average)
N3	0.759155	0	(Std. Dev.)

NODE ENTRIES FOR Net_st20

Node Name	Total Entries	Blocked Entries	
----	-----	-----	
N1	165.9	0	(Average)
N1	0.307794	0	(Std. Dev.)
N2	496.45	0	(Average)
N2	0.887041	0	(Std. Dev.)
N3	164.95	0	(Average)
N3	0.223607	0	(Std. Dev.)
N4	165.65	0	(Average)
N4	0.48936	0	(Std. Dev.)

NODE ENTRIES FOR Net_st21

Node Name	Total Entries	Blocked Entries	
----	-----	-----	
N1	165.9	0	(Average)
N1	0.307794	0	(Std. Dev.)
N2	330.8	0	(Average)
N2	0.523148	0	(Std. Dev.)
N3	165.3	0	(Average)
N3	0.470162	0	(Std. Dev.)

NODE ENTRIES FOR Net_st22

Node Name	Total Entries	Blocked Entries	
N1	166.15	0	(Average)
N1	0.366348	0	(Std. Dev.)
N2	331.3	0	(Average)
N2	0.571241	0	(Std. Dev.)
N3	165.4	0	(Average)
N3	0.502625	0	(Std. Dev.)

NODE ENTRIES FOR Net_st23

Node Name	Total Entries	Blocked Entries	
N1	166.4	0	(Average)
N1	0.502625	0	(Std. Dev.)
N2	331.75	0	(Average)
N2	0.966546	0	(Std. Dev.)
N3	165.6	0	(Average)
N3	0.502625	0	(Std. Dev.)

NODE ENTRIES FOR Net_st24

Node Name	Total Entries	Blocked Entries	
N1	166.6	0	(Average)
N1	0.502625	0	(Std. Dev.)
N2	332.3	0	(Average)
N2	0.923381	0	(Std. Dev.)
N3	165.7	0	(Average)
N3	0.470162	0	(Std. Dev.)

FAILED ARRIVALS

Entity Name	Location Name	Total Failed	
Core engsel core sengon	Core engsel dan sengon storage	0	(Average)

Core engsel core sengon	Core engsel dan sengon storage	0	(Std. Dev.)
Lem B 1	Lem B storage	0	(Average)
Lem B 1	Lem B storage	0	(Std. Dev.)
Veneer sengon B	Veneer sengon B storage	0	(Average)
Veneer sengon B	Veneer sengon B storage	0	(Std. Dev.)
Lem B 2	Lem B Storage 2	0	(Average)
Lem B 2	Lem B Storage 2	0	(Std. Dev.)
Lipping B	Lipping B storage	0	(Average)
Lipping B	Lipping B storage	0	(Std. Dev.)
Core sengon A	Core sengon A storage	0	(Average)
Core sengon A	Core sengon A storage	0	(Std. Dev.)
Lem A 1	Lem A storage	0	(Average)
Lem A 1	Lem A storage	0	(Std. Dev.)
Lem A 2	Lem A storage 2	0	(Average)
Lem A 2	Lem A storage 2	0	(Std. Dev.)
Lem pintu	Lem pintu storage	0	(Average)
Lem pintu	Lem pintu storage	0	(Std. Dev.)
veneer sengon A	Veneer sengon A storage	0	(Average)
veneer sengon A	Veneer sengon A storage	0	(Std. Dev.)
Lipping A	Lipping A storage	0	(Average)
Lipping A	Lipping A storage	0	(Std. Dev.)
Veneer rangkai	Veneer rangkai storage	0	(Average)
Veneer rangkai	Veneer rangkai storage	0	(Std. Dev.)
Serpihan kayu	Serpihan kayu storage	0	(Average)
Serpihan kayu	Serpihan kayu storage	0	(Std. Dev.)
Komponen A	Buffer 10 11	0	(Average)
Komponen A	Buffer 10 11	0	(Std. Dev.)
Komponen A	Buffer 11 12	0	(Average)
Komponen A	Buffer 11 12	0	(Std. Dev.)
Komponen A	Buffer 12 13	0	(Average)
Komponen A	Buffer 12 13	0	(Std. Dev.)
Komponen A	Buffer 13 14	0	(Average)
Komponen A	Buffer 13 14	0	(Std. Dev.)
Komponen A	Buffer 14 15	0	(Average)
Komponen A	Buffer 14 15	0	(Std. Dev.)
Komponen A	Buffer 15 16	0	(Average)
Komponen A	Buffer 15 16	0	(Std. Dev.)
Komponen A	Buffer 16 17	0	(Average)
Komponen A	Buffer 16 17	0	(Std. Dev.)
Komponen A	Buffer 17 18	0	(Average)
Komponen A	Buffer 17 18	0	(Std. Dev.)
Komponen A	Buffer 18 19	0	(Average)
Komponen A	Buffer 18 19	0	(Std. Dev.)
Komponen A	Buffer 19 20	0	(Average)
Komponen A	Buffer 19 20	0	(Std. Dev.)

Stile B	Buffer 9 20	0 (Average)
Stile B	Buffer 9 20	0 (Std. Dev.)
Stile B	Buffer 8 9	0 (Average)
Stile B	Buffer 8 9	0 (Std. Dev.)
Stile B	Buffer 7 8	0 (Average)
Stile B	Buffer 7 8	0 (Std. Dev.)
Stile B	Buffer 6 7	0 (Average)
Stile B	Buffer 6 7	0 (Std. Dev.)
Stile B	Buffer 5 6	0 (Average)
Stile B	Buffer 5 6	0 (Std. Dev.)
Stile B	Buffer 4 5	0 (Average)
Stile B	Buffer 4 5	0 (Std. Dev.)
Stile B	Buffer 3 4	0 (Average)
Stile B	Buffer 3 4	0 (Std. Dev.)
Stile B	Buffer 2 3	0 (Average)
Stile B	Buffer 2 3	0 (Std. Dev.)
Stile B	Buffer 1 2	0 (Average)
Stile B	Buffer 1 2	0 (Std. Dev.)
Pintu	Buffer 20 21	0 (Average)
Pintu	Buffer 20 21	0 (Std. Dev.)
Pintu	Buffer 21 22	0 (Average)
Pintu	Buffer 21 22	0 (Std. Dev.)
Pintu	Buffer 22 23	0 (Average)
Pintu	Buffer 22 23	0 (Std. Dev.)
Pintu	Buffer 23 24	0 (Average)
Pintu	Buffer 23 24	0 (Std. Dev.)
Karton dan plastik	karton dan plastik storage	0 (Average)
Karton dan plastik	karton dan plastik storage	0 (Std. Dev.)

ENTITY ACTIVITY'

Entity Name	Total Exits	Current Quantity In System	Average Seconds In System	Average Seconds In Move Logic	Average Seconds Wait For Res, etc.	Average Seconds In Operation	Average Seconds Blocked	
Core engsel core sengan	0	181.7	-	-	-	-	-	(Average)
Core engsel core sengan	0	0.571241	-	-	-	-	-	(Std. Dev.)
Lem B 1	320.75	179.25	15971.873986	0.000000	0.000000	0.000000	15971.873986	(Average)
Lem B 1	0.638666	0.638666	17.662765	0.000000	0.000000	0.000000	17.662765	(Std. Dev.)
Veneer sengan B	319.95	180.05	16015.431794	0.000000	0.000000	0.000000	16015.431794	(Average)
Veneer sengan B	0.759155	0.759155	22.682333	0.000000	0.000000	0.000000	22.682333	(Std. Dev.)
Lem B 2	318.2	181.8	16060.659923	0.000000	0.000000	0.000000	16060.659923	(Average)
Lem B 2	0.695852	0.695852	24.381494	0.000000	0.000000	0.000000	24.381494	(Std. Dev.)

Lipping B	317.3	182.7	16099.050677	0.000000	0.000000	0.000000	16099.050677	(Average)
Lipping B	0.656947	0.656947	25.001353	0.000000	0.000000	0.000000	25.001353	(Std. Dev.)
Core sengon A	0	160.7	-	-	-	-	-	(Average)
Core sengon A	0	0.571241	-	-	-	-	-	(Std. Dev.)
Lem A 1	339.2	160.8	15553.693712	0.000000	0.000000	0.000000	15553.693712	(Average)
Lem A 1	0.695852	0.695852	26.572725	0.000000	0.000000	0.000000	26.572725	(Std. Dev.)
Lem A 2	336.5	163.5	15603.621607	0.000000	0.000000	0.000000	15603.621607	(Average)
Lem A 2	0.606977	0.606977	18.816363	0.000000	0.000000	0.000000	18.816363	(Std. Dev.)
Lem pintu	165.85	84.15	15757.730087	0.000000	0.000000	0.000000	15757.730087	(Average)
Lem pintu	0.366348	0.366348	38.921536	0.000000	0.000000	0.000000	38.921536	(Std. Dev.)
veneer sengon A	338.35	161.65	15593.353005	0.000000	0.000000	0.000000	15593.353005	(Average)
veneer sengon A	0.587143	0.587143	25.047106	0.000000	0.000000	0.000000	25.047106	(Std. Dev.)
Lipping A	335.8	164.2	15626.928560	0.000000	0.000000	0.000000	15626.928560	(Average)
Lipping A	0.767772	0.767772	22.282552	0.000000	0.000000	0.000000	22.282552	(Std. Dev.)
Veneer rangkai	166.05	83.95	15729.650828	0.000000	0.000000	0.000000	15729.650828	(Average)
Veneer rangkai	0.223607	0.223607	36.031380	0.000000	0.000000	0.000000	36.031380	(Std. Dev.)
Serpihan kayu	166.35	83.65	15734.591844	0.000000	0.000000	0.000000	15734.591844	(Average)
Serpihan kayu	0.48936	0.48936	38.406218	0.000000	0.000000	0.000000	38.406218	(Std. Dev.)
Komponen A	332.9	17.9	15699.292423	173.190234	49.492346	567.247359	14909.362483	(Average)
Komponen A	1.02084	0.307794	30.298764	5.366202	8.889034	0.572515	31.676422	(Std. Dev.)
Stile B	331.5	49.8	15713.626708	201.764612	56.573131	542.514788	14912.774176	(Average)
Stile B	0.888523	1.10501	33.726996	8.501768	6.213138	0.460452	35.293145	(Std. Dev.)
Pintu	0	3.25	-	-	-	-	-	(Average)
Pintu	0	0.444262	-	-	-	-	-	(Std. Dev.)
sepasang komponen A	165.65	0.3	141.052139	19.200000	22.350731	0.000000	99.501409	(Average)
sepasang komponen A	0.48936	0.470162	8.933753	0.000000	9.548769	0.000000	11.020968	(Std. Dev.)
sepasang stile B	165.65	0.8	56.492049	25.130692	0.057954	0.000000	31.303403	(Average)
sepasang stile B	0.48936	0.410391	12.328384	9.777626	0.000172	0.000000	9.072225	(Std. Dev.)
Karton dan plastik	166.6	83.4	15791.311668	0.000000	0.000000	0.000000	15791.311668	(Average)
Karton dan plastik	0.502625	0.502625	47.230723	0.000000	0.000000	0.000000	47.230723	(Std. Dev.)
Komponen panel spindle	0	0	-	-	-	-	-	(Average)
Komponen panel spindle	0	0	-	-	-	-	-	(Std. Dev.)
Pintu siap jual	165.7	0	884.272094	156.471376	10.863089	638.780574	78.157056	(Average)
Pintu siap jual	0.470162	0	40.324422	21.499152	11.145380	1.163113	47.600760	(Std. Dev.)

ENTITY STATES BY PERCENTAGE

Entity Name	% In Move Logic	% Wait For Res, etc.	% In Operation	% Blocked	
Core engsel core sengon	-	-	-	-	(Average)
Core engsel core sengon	-	-	-	-	(Std. Dev.)
Lem B 1	0.00	0.00	0.00	100.00	(Average)

Lem B 1	0.00	0.00	0.00	0.00	(Std. Dev.)
Veneer sengan B	0.00	0.00	0.00	100.00	(Average)
Veneer sengan B	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem B 2	0.00	0.00	0.00	100.00	(Average)
Lem B 2	0.00	0.00	0.00	0.00	(Std. Dev.)
Lipping B	0.00	0.00	0.00	100.00	(Average)
Lipping B	0.00	0.00	0.00	0.00	(Std. Dev.)
Core sengan A	-	-	-	-	(Average)
Core sengan A	-	-	-	-	(Std. Dev.)
Lem A 1	0.00	0.00	0.00	100.00	(Average)
Lem A 1	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem A 2	0.00	0.00	0.00	100.00	(Average)
Lem A 2	0.00	0.00	0.00	0.00	(Std. Dev.)
Lem pintu	0.00	0.00	0.00	100.00	(Average)
Lem pintu	0.00	0.00	0.00	0.00	(Std. Dev.)
veneer sengan A	0.00	0.00	0.00	100.00	(Average)
veneer sengan A	0.00	0.00	0.00	0.00	(Std. Dev.)
Lipping A	0.00	0.00	0.00	100.00	(Average)
Lipping A	0.00	0.00	0.00	0.00	(Std. Dev.)
Veneer rangkai	0.00	0.00	0.00	100.00	(Average)
Veneer rangkai	0.00	0.00	0.00	0.00	(Std. Dev.)
Serpihan kayu	0.00	0.00	0.00	100.00	(Average)
Serpihan kayu	0.00	0.00	0.00	0.00	(Std. Dev.)
Komponen A	1.10	0.32	3.61	94.97	(Average)
Komponen A	0.03	0.06	0.01	0.08	(Std. Dev.)
Stile B	1.28	0.36	3.45	94.90	(Average)
Stile B	0.05	0.04	0.01	0.05	(Std. Dev.)
Pintu	-	-	-	-	(Average)
Pintu	-	-	-	-	(Std. Dev.)
sepasang komponen A	13.67	15.78	0.00	70.55	(Average)
sepasang komponen A	0.95	6.38	0.00	6.29	(Std. Dev.)
sepasang stile B	44.02	0.11	0.00	55.88	(Average)
sepasang stile B	10.28	0.02	0.00	10.28	(Std. Dev.)
Karton dan plastik	0.00	0.00	0.00	100.00	(Average)
Karton dan plastik	0.00	0.00	0.00	0.00	(Std. Dev.)
Komponen panel spindle	-	-	-	-	(Average)
Komponen panel spindle	-	-	-	-	(Std. Dev.)
Pintu siap jual	17.74	1.25	72.38	8.64	(Average)
Pintu siap jual	2.58	1.28	3.25	4.93	(Std. Dev.)

□

J E K P S T A D A
 Direktorat Jendral Bina Marga
 A T K A H A Y A