

TABLE OF FIGURES

Figure I.1 Pattern Demand (PT. BIG, 2016).....	2
Figure I.2 Punching Machine Existing (PT. BIG, 2016).....	3
Figure II.1 Jacquard Card (PT. BIG, 2016).....	8
Figure II.2 Mechanism of Punching Process (Black, 2008).....	9
Figure II.3 Electrical Symbols In General.....	15
Figure II.4 Ladder Diagram (Petruzella, 2005).....	16
Figure II.5 Wiring Diagram (Petruzella, Industrial Electronics, 1996).....	16
Figure II.6 Single-Line and Block Diagram.....	17
Figure II.7 Motor Connection Diagram.....	17
Figure II.8 Element of an Automated System.....	19
Figure II.9 Open-Loop Control System.....	20
Figure II.10 Closed-Loop Control System.....	20
Figure II.11 Hierarchy of Sensor.....	21
Figure II.12 Light Dependant Resistor.....	21
Figure II.13 Limit Switch (Schneider Electric).....	22
Figure II.14 Inductive Sensor (Festo Didactic Device).....	23
Figure II.15 Capacitive Sensor (IFM Electronic Germany).....	24
Figure II.16 Reed Switch (Ebel & Idler, 2008).....	24
Figure II.17 Photoelectric Sensor (Omron Sensor Device).....	25
Figure II.18 Hierarchy of Controller.....	26
Figure II.19 PLC System Layout and Connection.....	28
Figure II.20 PLC Omron CP1L Compact (Omron).....	28
Figure II.21 PLC Omron CJ2M Modular (Omron).....	29
Figure II.22 Hierarchy of Actuator.....	30
Figure II.23 Relays and Schematic (www.gloab.com).....	31
Figure II.24 Single Coil Solenoid (www.woodward.com).....	31
Figure II.25 Three-Phase AC Motor (www.weg.net).....	32
Figure II.26 DC Motor (www.globalindustrial.com).....	32
Figure II.27 Single-Acting Cylinder (Ebel & Idler, 2008).....	33
Figure II.28 Double-Acting Cylinder (Ebel & Idler, 2008).....	34
Figure II.29 Elements in Ladder Diagram.....	35

Figure II.30 Software CX - Programmer V9.4	37
Figure II.31 CX-Programmer Environment.....	37
Figure II.32 Human Machine Interface Window.....	38
Figure II.33 Sequential Function Diagram	39
Figure III.1 Conceptual Model.....	44
Figure III.2 Problem Solving Systematic.....	47
Figure IV.1 Jacquard Card Raw Material	48
Figure IV.2 Flowchart Existing Jacquard Card Process	50
Figure IV.3 Existing Punching Machine	51
Figure IV.4 Proposed New Model Design.....	53
Figure IV.5 Flow Process Chart Proposed System.....	54
Figure IV.6 Flow Process Chart Proposed System (Cont.)	55
Figure IV.7 Flow Process Chart Proposed System (Cont.)	56
Figure IV.8 System Hardware Requirement.....	65
Figure IV.9 Interface Microsoft Excel 2007 (Haris Rahmat at all)	66
Figure IV.10 ImageToExcel Adds-In (Haris Rahmat at all).....	67
Figure IV.11 Binary Pattern in Excel.....	68
Figure IV.12 CX-Programmer Hierarchy	69
Figure IV.13 HMI System Design Structure	75
Figure IV.14 Design Home Window Interface.....	76
Figure IV.15 Design Main Menu Window Interface.....	76
Figure IV.16 Design About Us Window Interface	77
Figure IV.17 Design Log In Window Interface	77
Figure IV.18 Design Plant Process Window Interface	78
Figure IV.19 Design Change Password Window Interface	78
Figure IV.20 Design Configure User Window Interface.....	79
Figure IV.21 Design Log Out Window Interface	79
Figure IV.22 Control Panel Box	80
Figure IV.23 Panel Box Layout	81
Figure IV.24 Scenario Model Design	86
Figure V.1 PLC Omron CP1E (CP1E Hardware)	96
Figure V.2 Sequential Functional Chart Analysis	97

Figure V.3 System Intiation Analysis	98
Figure V.4 System Ready Analysis	98
Figure V.5 Auto Mode Analysis	99
Figure V.6 One Cycle Mode Analysis	99
Figure V.7 Manual Mode Analysis.....	100
Figure V.8 Lifting Up Process Analysis	101
Figure V.9 Lifting Down Process Analysis	101
Figure V.10 Push Card Process Analysis	102
Figure V.11 System State Punching Process Analysis	103
Figure V.12 Transferring Decimal Data Analysis	103
Figure V.13 Transferring Data to Internal Relay Analysis.....	104
Figure V.14 Physical Solenoid Ouput Analysis	104
Figure V.15 Lever System Analysis	106
Figure V.16 Timer Lever Analysis	106
Figure V.17 Motor Backward Analysis	107
Figure V.18 Motor Forward Analysis.....	107
Figure V.19 Emergency System Analysis	108
Figure V.20 Result of Home Window	112
Figure V.21 Result of Main Menu Window	112
Figure V.22 Result of Login Window	113
Figure V.23 Result of Change Password Window	113
Figure V.24 Result of Configure User Window	114
Figure V.25 Result of About Us Window.....	114
Figure V.26 Result of Punching Process Window.....	115
Figure V.27 Result of Punching Machine Window	115
Figure V.28 Panel Box Front Side Analysis	117