

LAMPIRAN

Lampiran 1. Data hasil Produksi dan Delay Time untuk bulan Juli, Agustus, dan September 2012

[Redacted Header]									
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Juli '12	480	5	10	45	4	35,5	14	2	70,5
Agus'12	448	5	15	35	6	30,5	14	2,5	73,0
Sept'12	480	6	4	65	5	25	15	1,5	56,5

Data produksi (*gross product*) dan data product cacat (*reject*)

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Juli'12	217	9	8	6
Agust'12	217	6	5	4
Sept'12	210	7	6	5

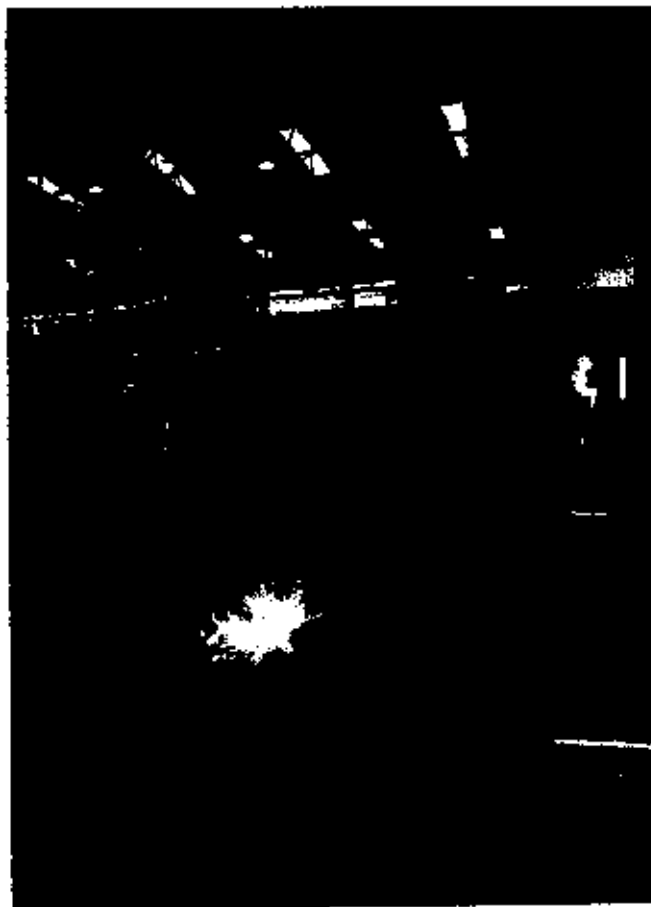
SCHEDULE ACTIVITY REPAIR

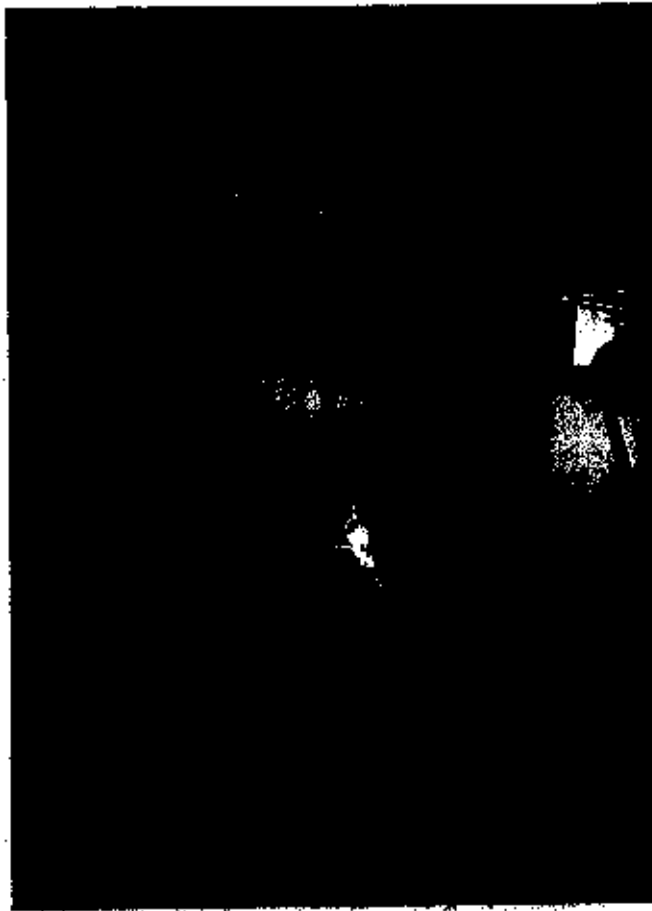
NO	W/C NAME	PERBANKAN / ACTIVITY	KIC	ACRONYM	April '12							Maret '12							REMARKS								
					1	2	3	4	5	6	7	1	2	3	4	5	6	7									
				PLAN																							
				ACT																							
				PLAN																							
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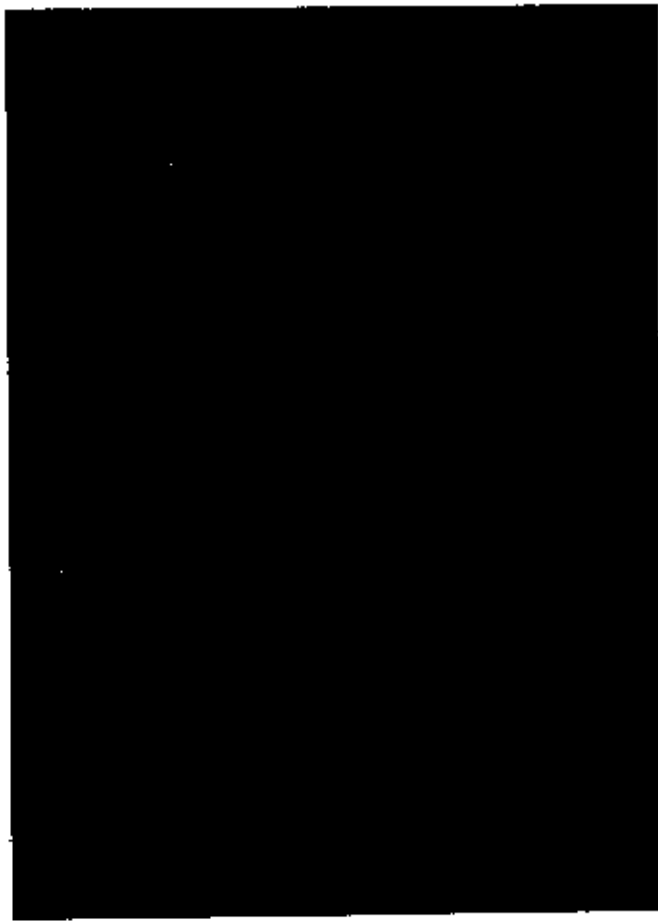
Menyetujui
Procurement Dept.

Keterangan :

PLAN
 ACTUAL







PREVENTIVE & ACTIVITY

→ Preventive → Activity

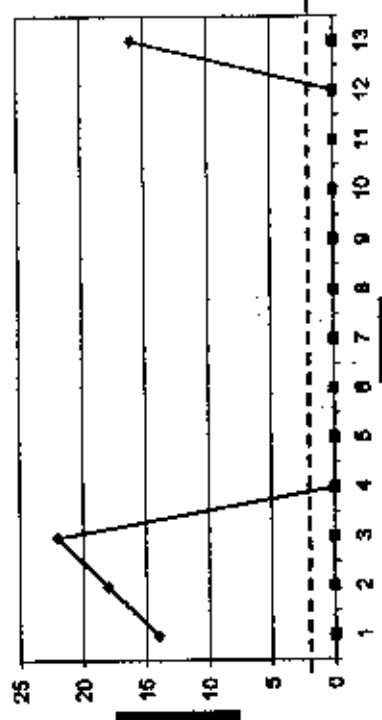
Tahun 2012

Jumlah

40

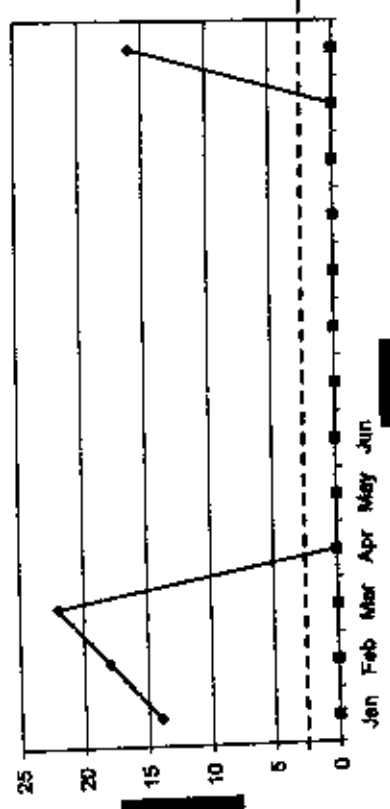
MC Dies/ JigShop

—●— LK CO2 Welding
 -■- Downtime



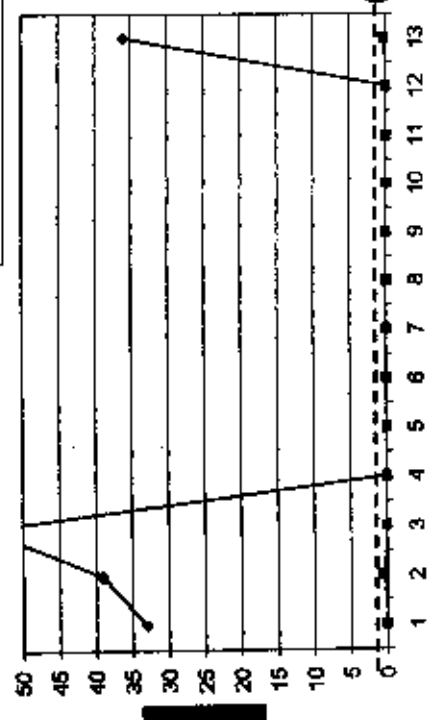
MC Painting

—●— LK CO2 Welding
 -■- Downtime



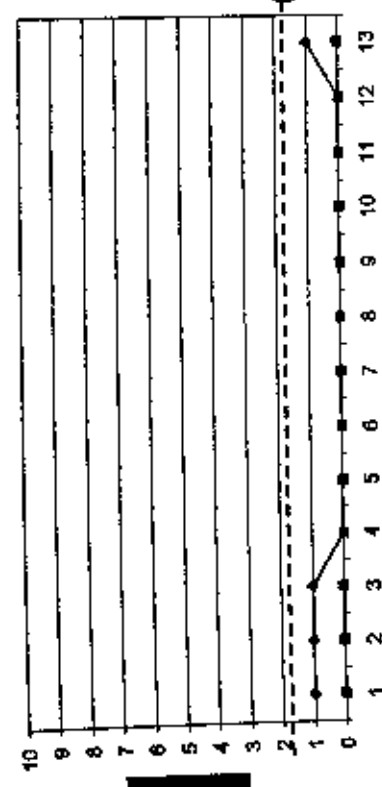
ALL Machine

—●— LK Total
 -■- DOWNTIME MESH (ALL)



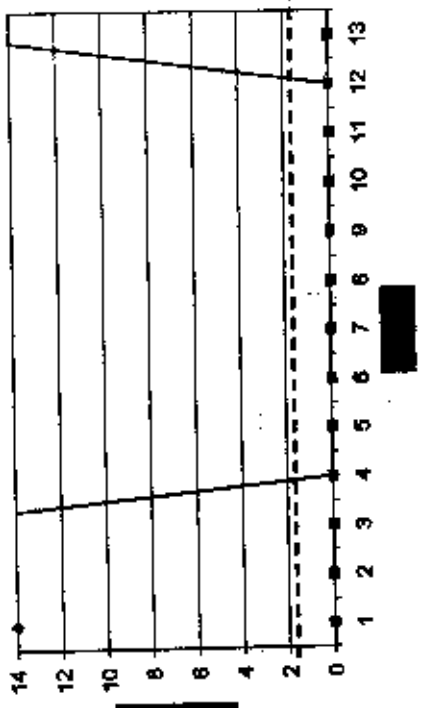
General Mtc/ McShop

—●— LK General / Mc shop
 -■- Downtime Mtc/ Mc Shop



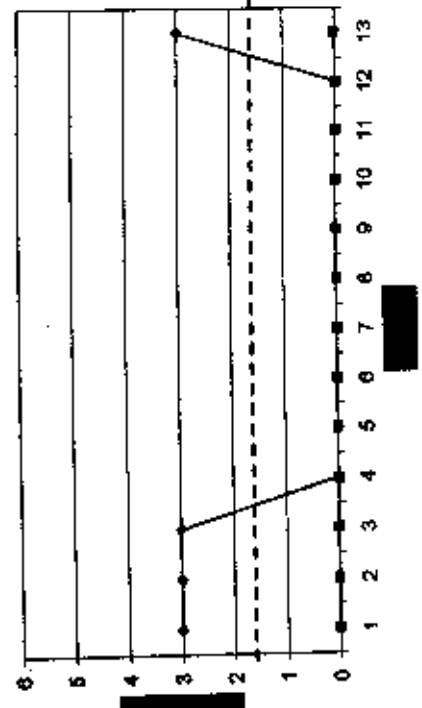
MC CO2 Welding

◆ LK CO2 Welding
 ■ Downtime



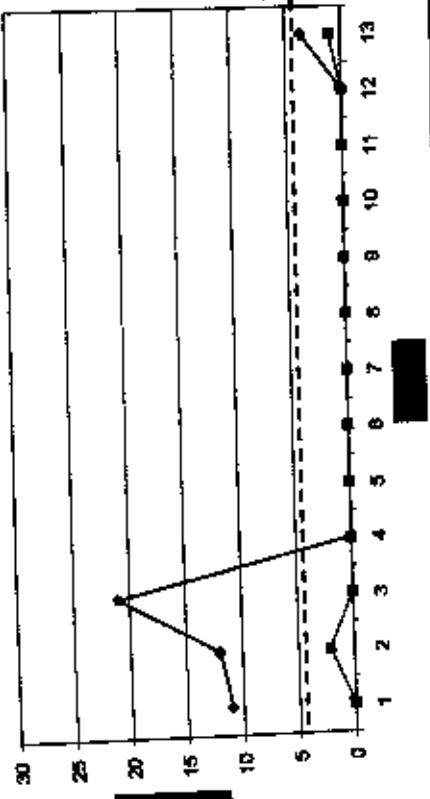
MC Spot Weld/ Rivet

◆ LK Spot Weld
 ■ Downtime Mc Spot Welding



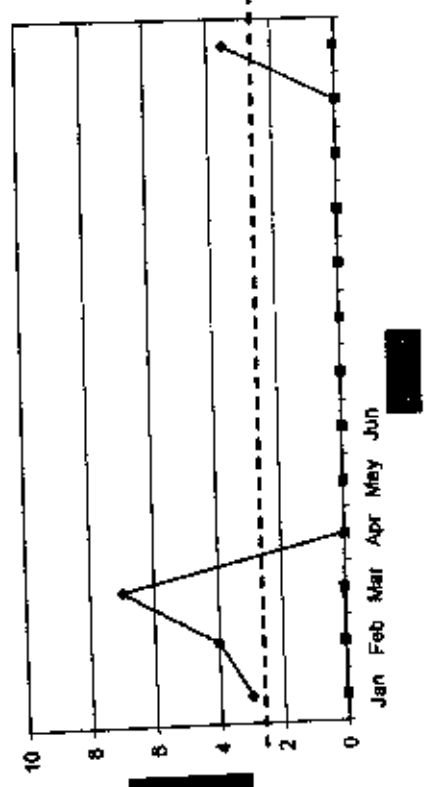
MC Press

◆ LK MC PRESS
 ■ Downtime



MC Bend/ Cut/ Shearing

◆ LK Bend/ Cut/ Shear
 ■ Downtime



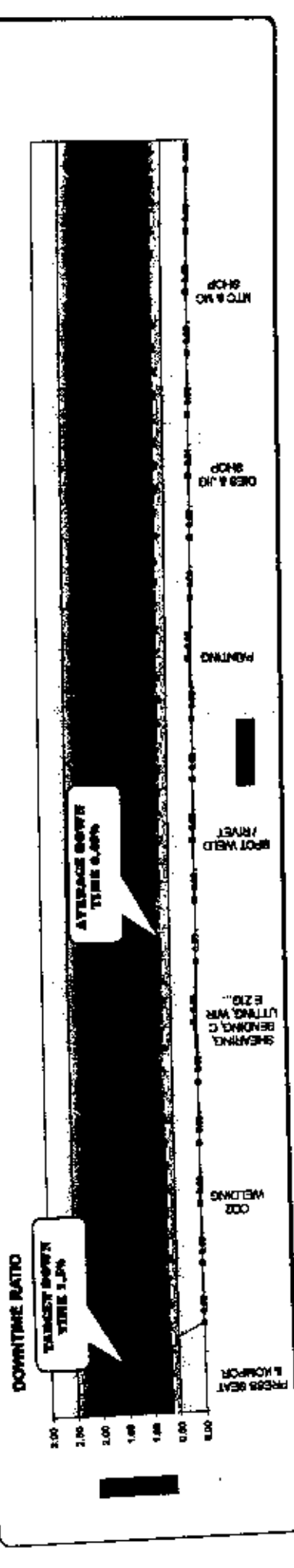
10	Bending	B02	Pipe binder rhyton	8-Feb-12	8-Feb-12	Schedule preventive	1. Timing Belt 2.Ampere 3 Volt meter 3.Electrik komponen	N	UK	80	OK
11	Spot	AJ 08	Spot duduk	8-Feb-12	8-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
12	Bending	B03	Pipe binder CNC	9-Feb-12	9-Feb-12	Schedule preventive	1. Timing Belt 2.Ampere 3 Volt meter 3.Electrik komponen	N	UK	80	OK
13	Spot	AJ 07	Spot duduk	9-Feb-12	9-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
14	Spot	PGW 01	Spot gantung	10-Feb-12	10-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
15	Bending	B04	Pipe binder chisabang	10-Feb-12	10-Feb-12	Schedule preventive	1. Timing Belt 2.Ampere 3 Volt meter 3.Electrik komponen	N	UK	80	OK
16	Spot	PGW 02	Spot gantung	13-Feb-12	13-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
17	Bending	B05	Pipe binder chisabang	13-Feb-12	13-Feb-12	Schedule preventive	1. Timing Belt 2.Ampere 3 Volt meter 3.Electrik komponen	N	UK	80	OK
18	Spot	BW 01	Spot duduk	14-Feb-12	14-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
19	Wire	W1 01	Wire Zigzag Clano	14-Feb-12	14-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
20	Spot	BW 02	Spot duduk	15-Feb-12	15-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
21	Wire	W1 02	Highspeed wire	15-Feb-12	15-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
22	Spot	BW 03	Spot duduk	16-Feb-12	16-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
23	Wire	W1 03	Wire Zigzag	16-Feb-12	16-Feb-12	Schedule preventive	3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
24	Spot	BW 04	Spot duduk	17-Feb-12	17-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
25	Wire	W1 04	Oven cabinet	20-Feb-12	20-Feb-12	Schedule preventive	1. Electrik komponen 2. Karetan spiral	N	UK	80	OK
26	Spot	BW 05	Spot duduk	20-Feb-12	20-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
27	Riveting	R01	Riveting	21-Feb-12	21-Feb-12	Schedule preventive	1.Hydraulic Unit 2.Colland tank 3.electrik komponen	N	UK	80	OK
28	Spot	BW 06	Spot duduk	21-Feb-12	21-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
29	Riveting	R02	Riveting	22-Feb-12	22-Feb-12	Schedule preventive	1.Hydraulic Unit 2.Colland tank 3.electrik komponen	N	UK	80	OK
30	Spot	BW 07	Spot duduk	22-Feb-12	22-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
31	Spot	BW 08	Spot duduk	23-Feb-12	23-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
32	Spot	BW 09	Spot duduk	23-Feb-12	23-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
33	Riveting	R03	Riveting	24-Feb-12	24-Feb-12	Schedule preventive	1.Hydraulic Unit 2.Colland tank 3.electrik komponen	N	UK	80	OK
34	Cutting	C01	Cold saw cutting	24-Feb-12	24-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
35	Cutting	C02	Hij speed cutting	25-Feb-12	25-Feb-12	Schedule preventive	1.Valve tritona 2.Ampere 3.Britolast air pendingin 4.Dudukan cup lip	N	UK	80	OK
36	Cutting	C03	Horizontal band saw	25-Feb-12	25-Feb-12	Schedule preventive	1.Hydraulic Unit 2.Colland tank 3.electrik komponen	N	UK	80	OK

Page 28 of 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100

Prepared	Checked	Approved
Signed	Verified	Issued

No	Detail	No/Spesifikasi	No/Spesifikasi Nama	Plan	Actual	Schedule preventive mesin	Preventive Action	Penyakit (D/W)	Operator	Jam Kerja	Remarks
1	Spot	AJ 01	Spot duduk	1-Feb-12	1-Feb-12	Schedule preventive	1.Valve trilekone 2.Ampere 3.Berikutasi air pendingin 4.Dudukan cup lip	N	LM	90	Ok
2	Shearing	801	Shearing ajkita	1-Feb-12	1-Feb-12	Schedule preventive	1.shearing PAD 2.Bearing 3.Electrik komponen.	N	LM	90	Ok
3	Spot	AJ 02	Spot duduk	2-Feb-12	2-Feb-12	Schedule preventive	1.Valve trilekone 2.Ampere 3.Berikutasi air pendingin 4.Dudukan cup lip	N	LM	90	Ok
4	Shearing	802	Shearing Korakita	2-Feb-12	2-Feb-12	Schedule preventive	1.Hidrolik unit 2.shearing PAD 3.Bearing 4.Electrik komponen.	N	LM	90	Ok
5	Spot	AJ 03	Spot duduk	3-Feb-12	3-Feb-12	Schedule preventive	1.Valve trilekone 2.Ampere 3.Berikutasi air pendingin 4.Dudukan cup lip	N	LM	90	Ok
6	Shearing	803	Shearing LYD	6-Feb-12	6-Feb-12	Schedule preventive	1.Hidrolik unit 2.shearing PAD 3.Bearing 4.Electrik komponen.	N	LM	90	Ok
7	Spot	AJ 04	Spot duduk	6-Feb-12	6-Feb-12	Schedule preventive	1.Valve trilekone 2.Ampere 3.Berikutasi air pendingin 4.Dudukan cup lip	N	LM	90	Ok
8	Banding	B01	Pipe binder mihgita	7-Feb-12	7-Feb-12	Schedule preventive	1.Tweeing Belt 2.Ampere & Volt meter 3.Electrik komponen.	N	LM	90	Ok
9	Spot	AJ 05	Spot duduk	7-Feb-12	7-Feb-12	Schedule preventive	1.Valve trilekone 2.Ampere 3.Berikutasi air pendingin 4.Dudukan cup lip	N	LM	90	Ok

DESCRIPTION	PRESS BEAT & KOMPOR		COIL WELDED		SHIMMING, GRINDING, CUTTING, WELDING ZAKUARD WORK		SPOT WELD / RIVET		PAINTING		CASA & JO SHOP		MTC & MC SHOP		Approved
	Shift 1	Shift 2	Shift 1	Shift 2	Shift 1	Shift 2	Shift 1	Shift 2	Shift 1	Shift 2	Shift 1	Shift 2	Shift 1	Shift 2	
	41	41	50	50	18	18	21	21	8	8	27	27	24	24	
TOTAL MESIN	41	41	50	50	18	18	21	21	8	8	27	27	24	24	
MESIN TERPAKAI	41	41	50	50	18	18	21	21	8	8	27	27	24	24	
JAM KERJA / HARI (mesin baru)	8	8	8	8	8	8	8	8	8	8	8	8	8	8	
TOTAL JAM KERJA MESIN	328.0	328.0	400.0	400.0	144.0	144.0	168.0	168.0	64.0	64.0	216.0	216.0	192.0	192.0	
KAPASITAS MESIN / BULAN (30 HR)	8.40	8.40	12.000	12.000	4.800	4.800	5.600	5.600	1.600	1.600	7.200	7.200	6.400	6.400	
HARI KERJA	18	11	9	9	23	11	23	10	23	11	23	11	23	6	
KAPASITAS TERPAKAI / BULAN	5.004	3.058	9.200	3.600	3.512	284	3.864	960	1.472	0	4.888	1.520	4.416	1.192	
ISSUE KAPASITAS / BULAN	3.398	8.732	2.800	8.400	1.028	4.058	1.176	4.480	448	1.320	1.512	5.180	1.344	4.808	
JUMLAH LK	12	12	16	16	4	4	8	8	8	8	1	1	1	1	
JUMLAH DOWNTIME	11	11	8	8	4	4	3	3	8	8	1	1	1	1	
JUMLAH PREVENTIVE	0	0	0	0	12	12	21	21	0	0	0	0	0	0	
TOTAL WAKTU DOWNTIME (Mesin)	26.08	26.08	236	236	248	248	188	188	128	128	60	60	128	128	
TARGET DOWNTIME (Mesin)	2.5916	2.5916	2800	2800	1035	1035	1205	1205	405	405	1552	1552	1524	1524	



NO	TANGGAL	SECTION	NO MC	NAMA MESIN	PROBLEM	ROOT CAUSE	CORRECTIVE & PREVENTIVE ACTION	STATUS MESIN	PIO
1	11-Feb-12	Press	P01	Amada 80 T	Bushing fly wheel goyang	As & bhusing aus	Genral bhusing baru	On progress	Cx Pram prima
2	11-Feb-12	Press	P15	Okk 100 T	Angin braka bocor	Dees braka rusak/ Pecah	Genral disc brake baru	On progress	PL Machiko jaya