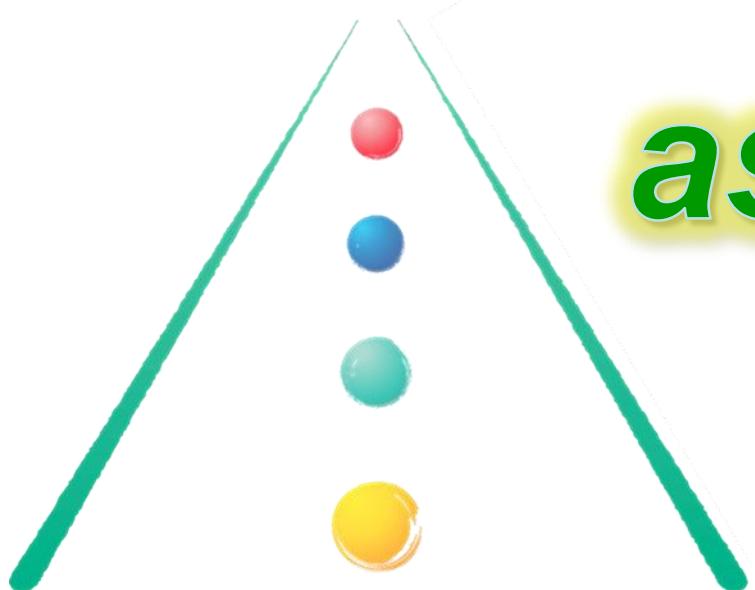


Let's "Go Anzen-ni !"

as **ONE TEAM**



UTAMAKAN KESELAMATAN **KAO**

Kirei—Making Life Beautiful

“Mottainai - Wastefulness – Never Today, Nor Tomorrow, Stop Pemborosan”

Keep Stability Individual Film Process On LSSG Product

Team : All In

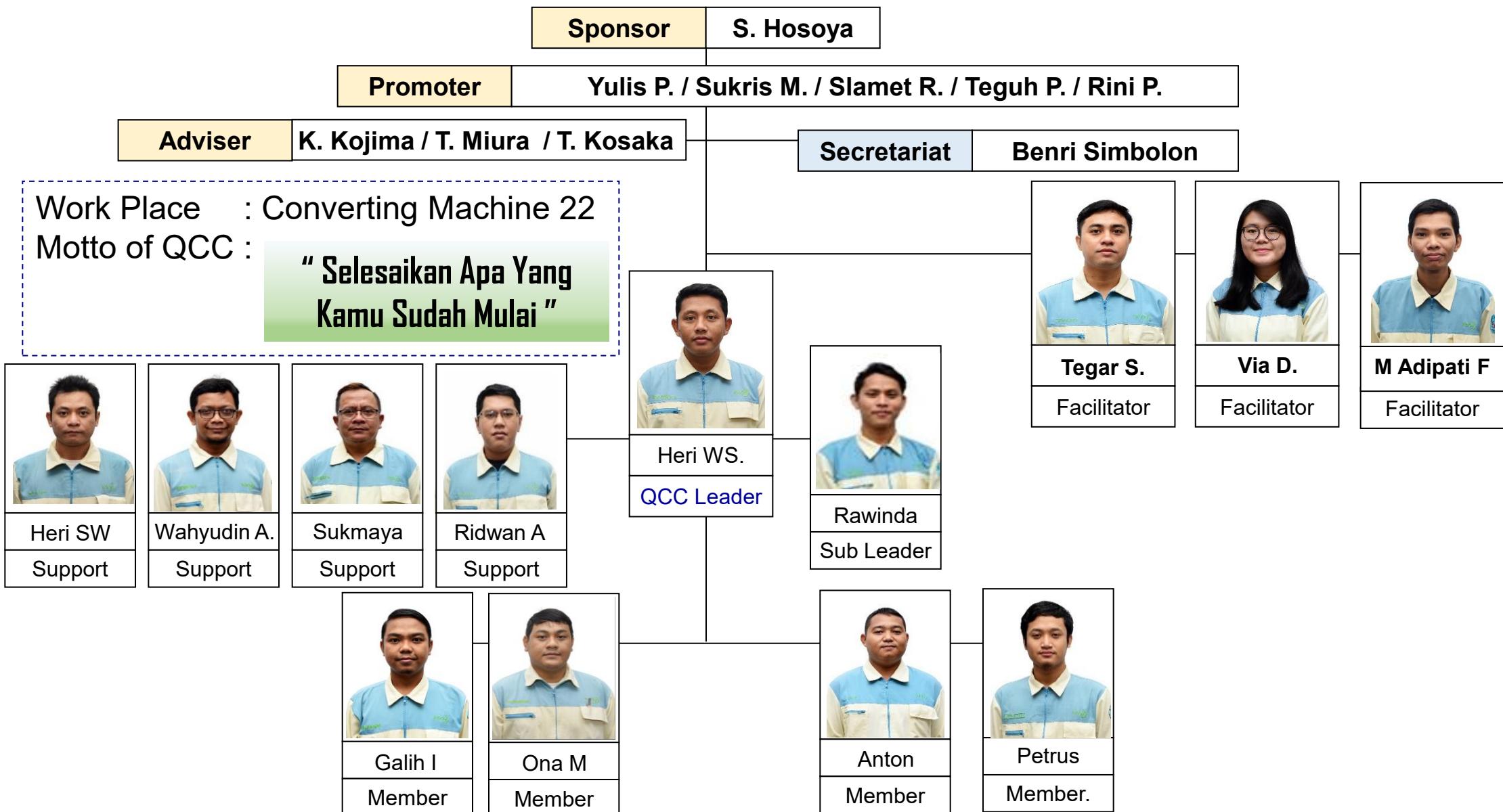
By : Heri Wahyu Styawan

Date : Maret 2024





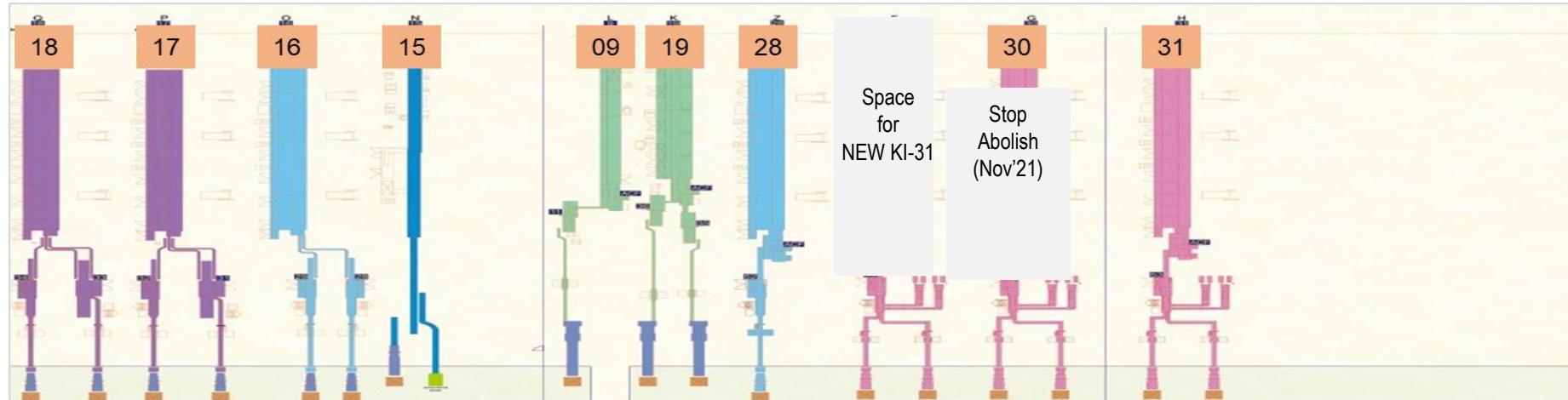
Introduction Team Name and QCC Member





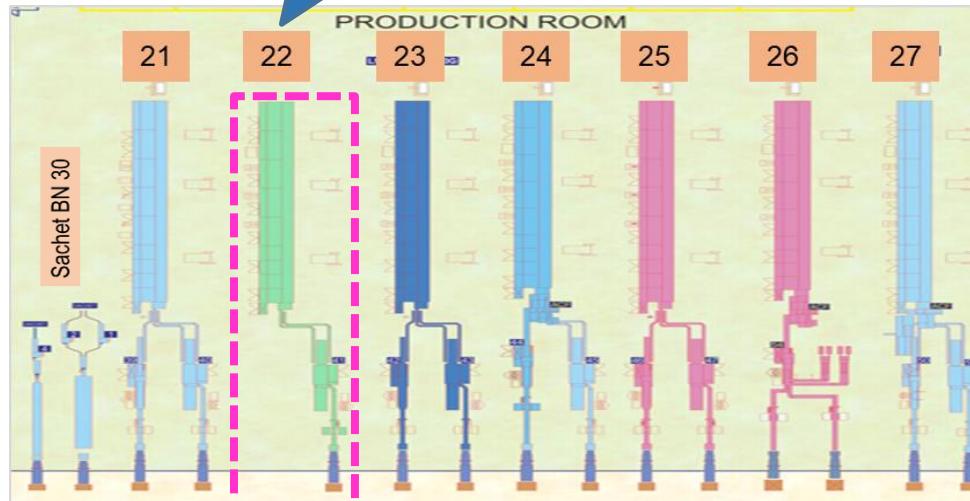
Human Health Care Layout

HHC Plant -1 (14 lines)



HHC Plant -2 (7 lines)

Qcc activity



Converting-22 Product is:

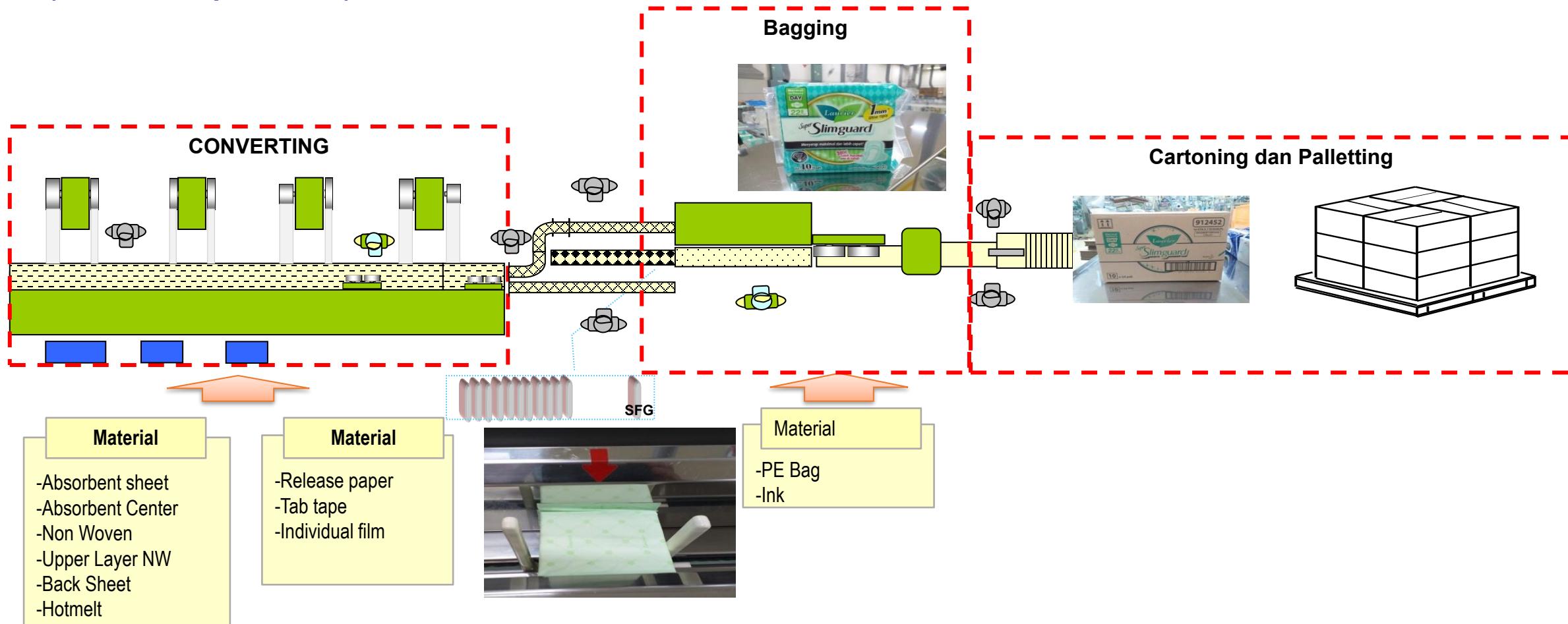


LSSG 22.5

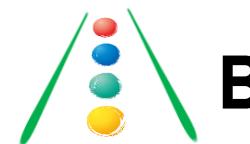


About Line No.22 (LSSG) process

Product LSSG 22.5 (Laurier Super Slim Guard 22.5) (Without Pulp Product)



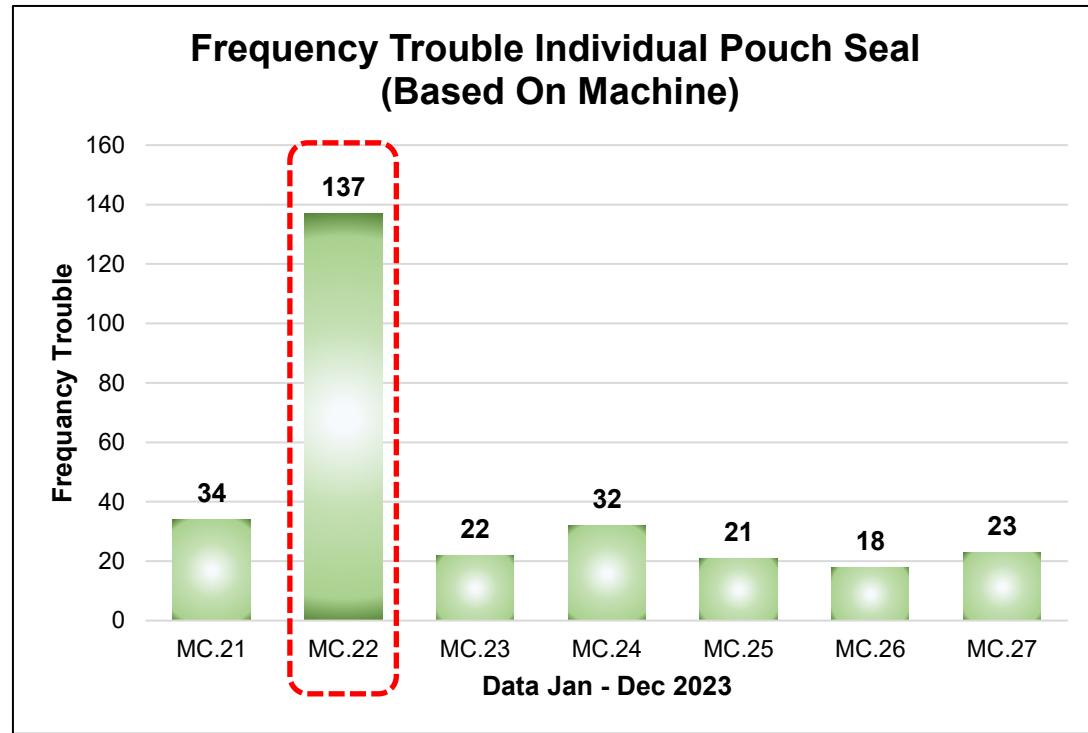
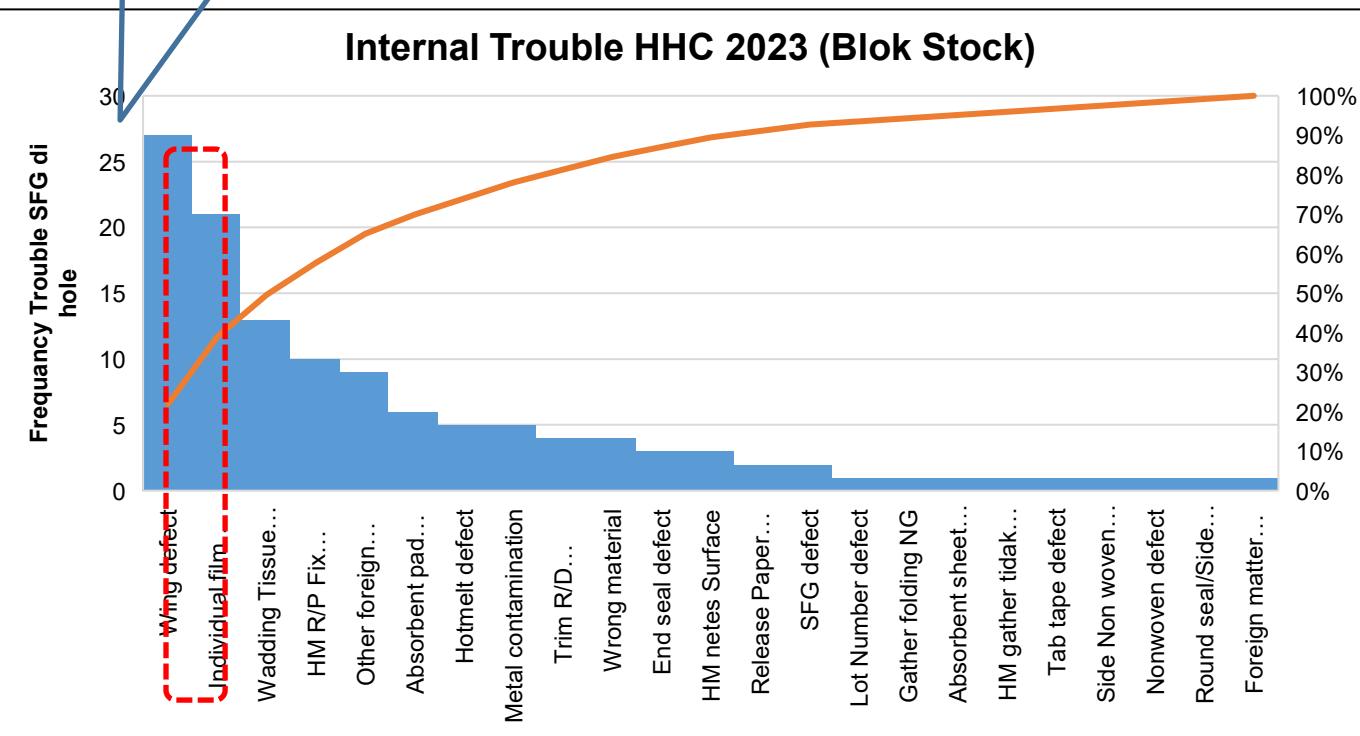
Flow Conv. 22



Background Data

□ Graphic Internal Trouble Line HHC (Jan – Dec '23)

Trouble wing detect
sudah di bahas team lain



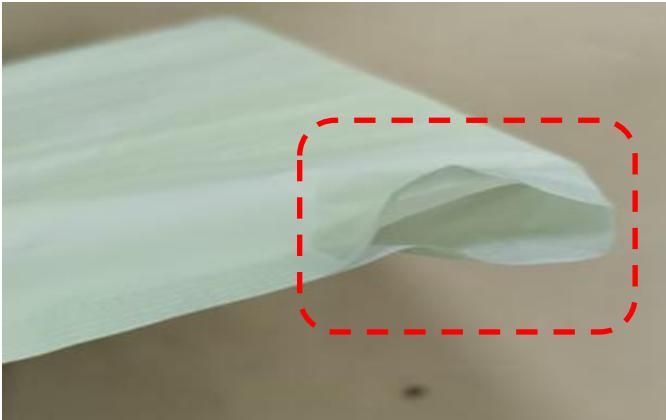
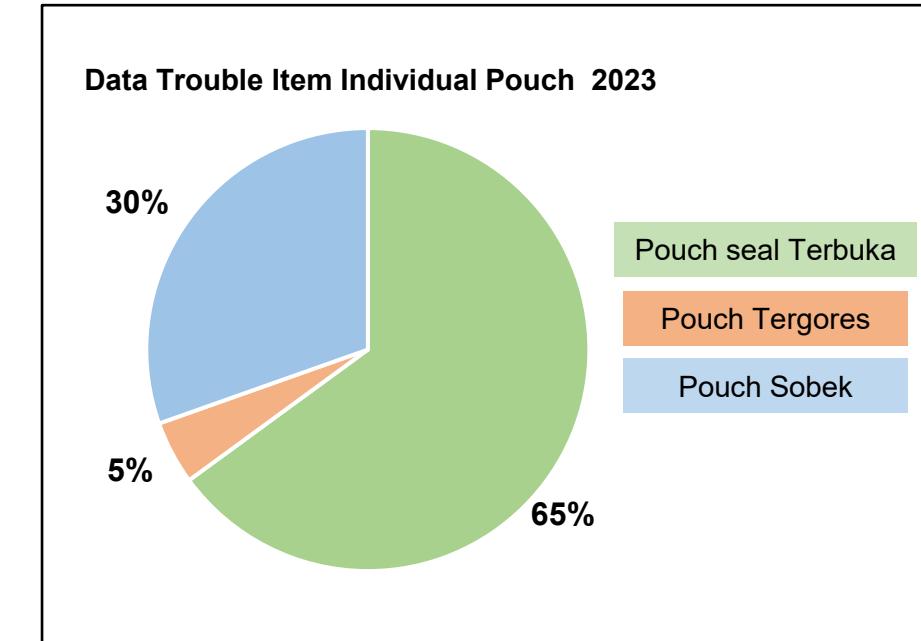
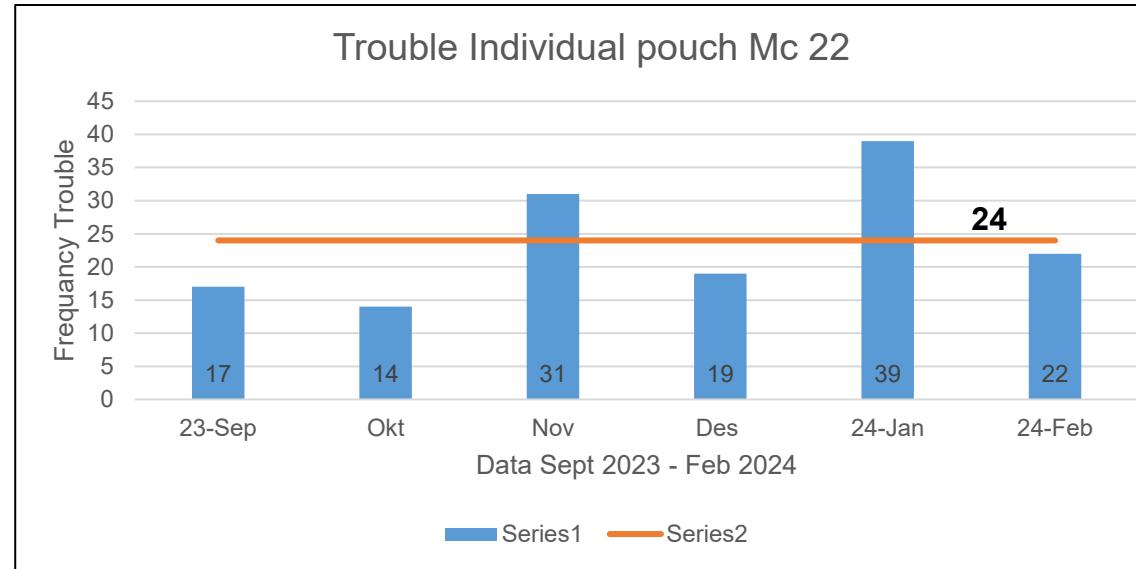
Berikut adalah data Frequency trouble individual Pouch di plant HHC 2 pada jan – des 2023 dimana mesin conveting 22 paling banyak terjadi trouble 137 kali



Background Data

□ Graphic Trouble Line 22 (Sep' 23 – Feb '24)

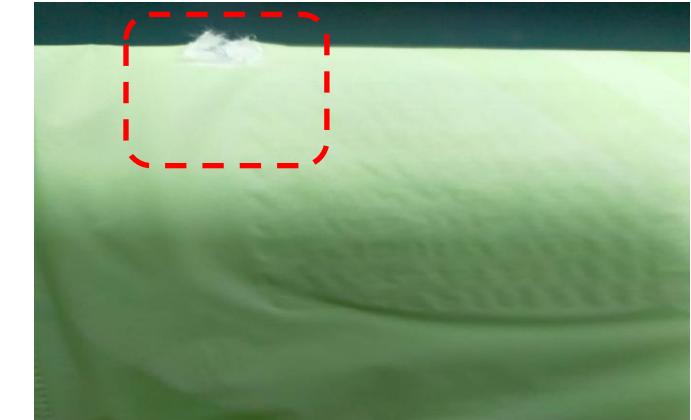
Berikut adalah table data trouble dari bulan sept 2023 sampai 16 feb 2024.



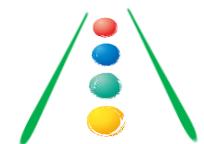
Pouch seal lemah/terbuka



Pouch Tergores

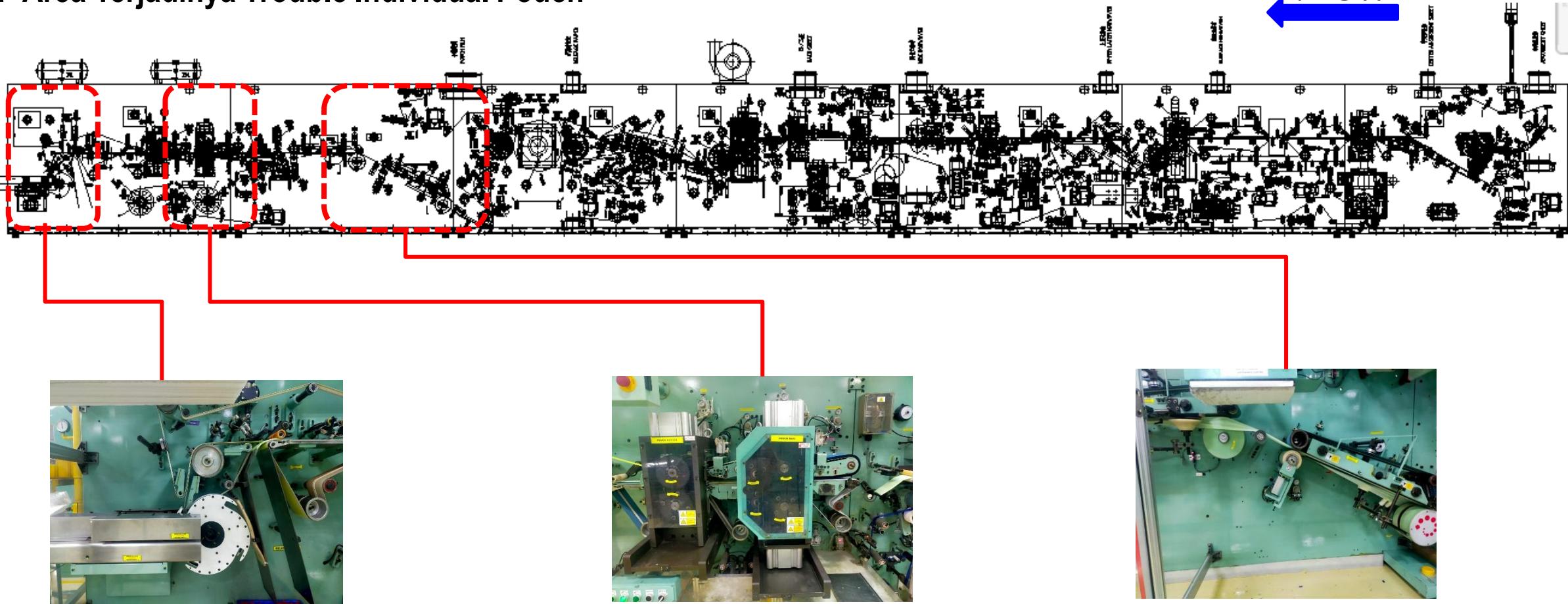


Pouch Sobek



Problem Understanding

Area Terjadinya Trouble Individual Pouch



Steker, yaitu Baling-baling transfer SFG menuju conveyor bagging

Di area steker terjadinya Pouch Tergores

Pouch Seal, yaitu Pengemasan dilakukan dengan men-seal kedua ujung material Ind.Film yang membungkus SFG,

Di area ini terjadinya Pouch seal lemah/terbuka

Folding If, yaitu Plat yang berfungsi untuk melipat SFG menjadi 3 bagian sebelum masuk ke tab tape

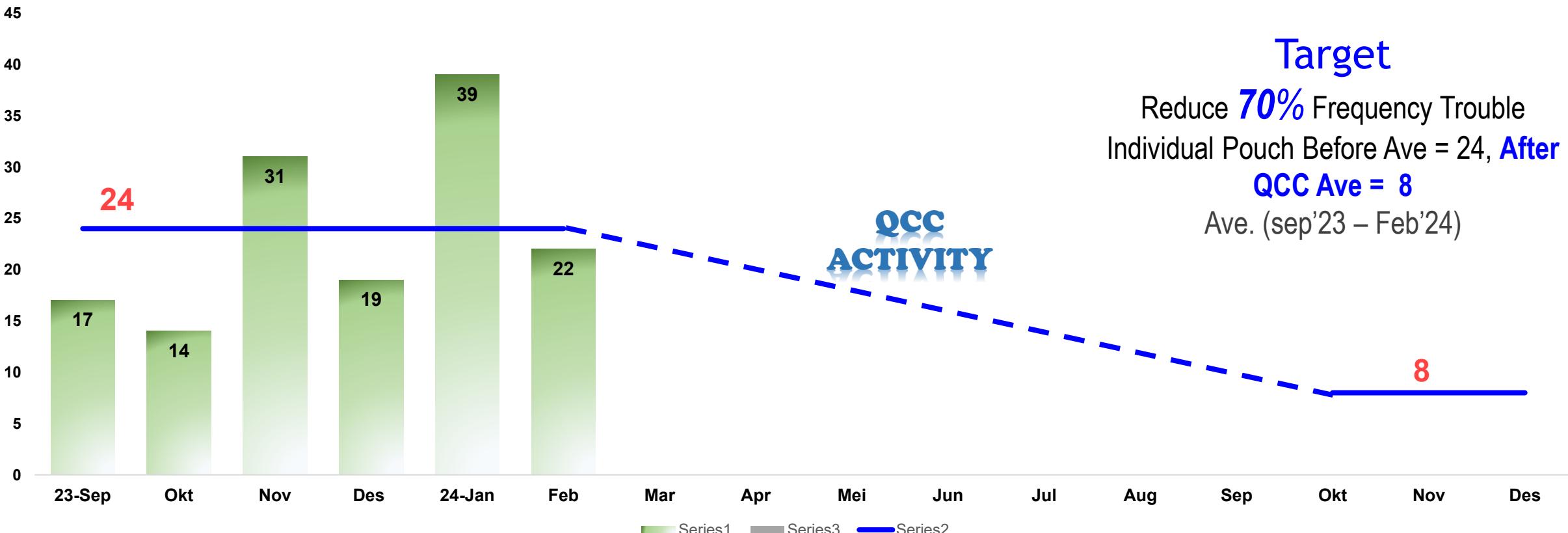
Di area folding If terjadinya Pouch Sobek



Reduce Frequency Trouble LINE 22 By reducing **Trouble Individual pouch**



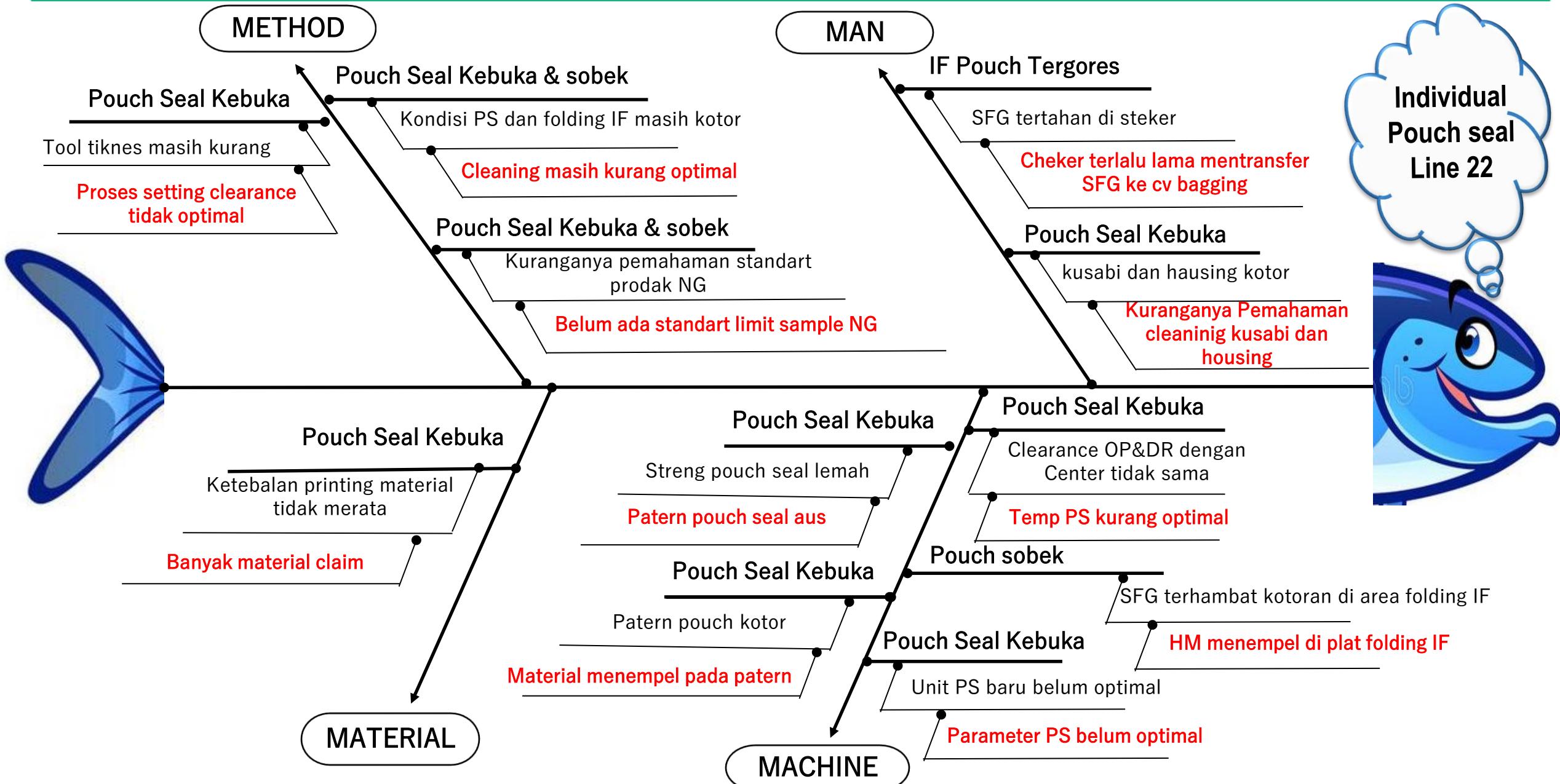
Frequency trouble Individual Pouch seal Line 22



With setting position guide plat, we can minimize trouble SFG drop at throw in area



Fishbone Diagram





Action Plan (5W + 1H)

Description	What	Why	How	Where	When	Who
	Factor	Root Cause	Improvement	Location	Time	PIC
Trouble Individual Pouch Mc 22	Man	Kurangnya Pemahaman cleaning kusabi dan housing	Refresh training	MC. 22	Mar - April 2024	Ona,Galih
		Cheker terlalu lama mentransfer SFG ke CV bagging	Refresh Training		Mar - April 2024	Petrus
	Machine	Material If menempel pada pattern PS (lengket)	Chek & re setting speed CV area individual transfer		April - Sept '2024	Heri ws
		Pattern dan anvil cepat aus	Study perawatan unit pouch seal		Mei - Sept '2024	Heri ws
		Parameter PS belum optimal	Study optimalisasi unit PS baru		Mei - Sept '2025	Anton
		Temperature PS kurang optimal	improve cover dan maksimalkan cleaning roll		Jan - Aug '2024	Anton
		Hm RP fixing menempel di area tripel folding	Aditional teflon coating plat		Juni-2024	Heri s
	Method	Cleaning masih kurang optimal	Study optimalkan cleaning patern		April '24	Rawinda
		Proses setting clearance tidak optimal	Study pengecekan clearance aktual		April'24	Rawinda
		standart limit sample NG belum ada	Pembuatan Standart limit sample NG		April'24	Rawinda,Petrus
	Material	Banyaknya material claim	Optimalkan pengunaan material		Jun-24	Ona,Galih



Action Plan (Time Schedule)

Activity		2024											
		Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec
Plan	Theme Selection	●	●										
	Problem Identification	●	●										
	Problem Classification	●	●										
	Problem Evaluation	●	●										
Do	Factor Analysis	●	●	●	●	●	●	●					
	Countermeasure Study & Implementation		●	●	●	●	●	●	●				
Check	Result Confirmation								●	●			
Action	Standardization								●	●			
	Next Plan										●	→	

●————● Plan

●————● Actual



Thank You

