Improvement

1. Ada rencana tahunan untuk mempersiapkan alat/perlengkapan untuk kaizen.

Change panel electric 1st annealer, tidy up cable,

Switch the power of the machine lighting from the

Modification of the model's one-sided display cover using screws so that the cover can be easily removed.

move position panel more good.

Install Smoke Detector.

panel to the TL lamp lighting.

Moved position panel

Repair broken cables

SAFETY ACTIVITY IMPROVEMENT PLAN

		M/C									Original	1000000								T
No. Urgent Area		Area	Item Finding			Improvement		PIC	PIC	Apr	May	Jun	м	Aug	Remark	Ш				
Elec	tric Shoc	k														1	- 22			
29		V-4AB	Panel	electric V4.				panel heater many cable untidy , cable untidy; at heater pane		Change panel electric 1st annealer, tidy up cable, move position panel more good.	MTN	MTN					Co	ont.FY23		
44		Finding (Safety NDKI)	Trafo r	oom (Pane	).& hydrant	pump room	No have	alarm detector (Smoke Detecto	r).	Install Smoke Detector.	Safety	MCH					FII	WISH		
45		MSTS (MTN)	Cleaning main machine panel (Vertical & Horizontal).			When cleaning the panel with a second cleaner, the condition of the main breaker cannot be turned to because if it is OFF the engine light will turn off and interfere a coverage of the condition of the main second conditions.			Switch the power of the machine lighting from the panel to the TL lamp lighting.	MTN	MTN					lng	orogress			
46		Replacement of MSTS (MTN) Vertical, Horizon						placing the common alarm lamp, alt because it hits the deck.	, you have to lift the display cover up and	ave to lift the display cover up and Modification of the model's one-sided display cover using screws so that the cover can be easily removed.		MTN	H1A B					illow project TA ( Next V8)	0	
		MSTS (MTN)		() Repair electric control panel Varnish V4.		Area pa	nel narrow space.		Moved position panel .	MTN	MCH									
49		MSTS (MTN)	TS (MTN)		micro la	ser cable peeled off		Repair broken cables	MTN	MCH					FII	WISH		Ť		
Crar	ne and He	Objects									31500									$^{+}$
							Conside	r Installing Crane for Top Sheave	Maintenance.	Old V2 Area Crane installation.		MCH								T
13		Vertical M/C	Crane.							V12 Crane installation.	140	MCH					Ne	xt FY2024		Ť
54		RM WH	Calibra	ation Floor S	Scale.		It's diffic	uit to lift up top plat of floor scale	during calibration operation.	Improvement after Operation Check.	RMWHS	MCH					CL	OSED		
inal		PIC	Apr	May	Jun	Jul	Aug	Remark	ght 80Kg), possibility fall down & et this work	Prepare girder for litting up/down upper sheave use chain block & make WI.	MTN	MTN					Int	progress		
0			, ψ.	ay	ou.	ou.	, and	Tional.	ge not use special scafolding, special tools & equipment for this work.	Prepare lifter or scaffolding & make WI.	MTN	MTN					Ing	progress	П	Ť
									lift, some time difficult to setting d make WI for guidance for work	Prepare additional Gimpole / Beam on existing girder chain block & make WI.  Gimpole prepare by Taiyo.	MTN	MTN								T
N		MTN						Cont.FY23	lock, possibility pinched hands, need	Make WI	MTN	MTN					Ins	progress		
ety		мсн						FINISH	k & already stanby girder, possibility for work pair activity.	Make WI.	MTN	MTN					FII	NISH		
									ain block & prepare hanger for seting	Prepare window for acces chain block & make WI.	MTN	MTN			V12		FII	WISH		
N		MTN						Inprogress	nual, no have gidder for install chain	Install girder for chain block & make WI.	MTN	MTN	A line			•		orogress main WI		Ī
									enli use Gimpole & chain block but not con.	Prepare Gimpole & make WI.	MTN	MTN				V11 &		NISH	П	T
N		MTN	H1A					Follow project	ne drawing use hydrolic jack/puller & for	prepare game pole & make WI.	MTN	MTN				Ĭ		progress		T
			В					HTA ( Next V8)	an use chain block, but same an, dificult to turn sling belt become	Prepare accesories chain block & make WI,	MTN	MTN					Ing	progress		T
N		MCH							approximately 2500 ~ 2800 mm,	making tools such as lifters or scaffolding.	MTN	MTN							$\Box$	
N		MCH						FINISH	let or above the product spool.  parking area after use.	Hoist crane after use must be returned to its place immediately.	QC	Vertical					Fil	nish		T
	100								allet.	Chenge position keeping pallet for product ( Change position product after finish)	Ver	Vertical					Fit	nish		
83		MTN (MSTS)	Lifting	heavy obje	cts ( Cooling	tower area)		coling tower pump motor from the	e road to the cooling tower base via the	Create an access road above the gutter	MTN	MTN					● Fit	nish		Ť
84		MTN (MSTS)	Chang	e Parts FP	500.			to nydrant pipe. cess of replacing motor speed re	ducer parts weighing 50 kg.	Use a lifter tool when lifting the speed reducer part	MTN	MTN					-	nish		$^{\dagger}$
																			+	-

○=Plan, ●=Finish, ×=Delay

1. Ada rencana tahunan untuk mempersiapkan alat/ perlengkapan untuk kaizen.

	iii noi	IVIII IMPROVI	EMENT PLAN			o=Plan, ●=	rillisti, A	-Dela	y				WIN-I Safety		
					7		_		_	_		21-Aug-24	_	_	
No.	Urgent	M/C Area	Item	Finding	Improvement	Original PIC	PIC	Apr	May	Jun	Jul	Aug	Remark		
. Rota	ating Parts		*11												Т
63		Reel Polishing WHS	Cleaning / Polishing with sandpaper sponge during reel rotating.	Current condition cleaning reel machine no have Emergency Stop (Total have 5 M/C :#1, #2, #3, #4, #5)	Need to install Emergency Stop.	RM whs/ SPO	MCH						FINISH		T
70		H1,H2 & V12	Take up machine H1 , H2 & V12.	Take up machine H1, H2 & ¥12 not yet install emergency stop.	Need to install Emergency Stop.	SPO	MCH						FINISH		Ī
74		Pulling machine Vertical	Pulling to change the size of the bare wire in the coating vertical (V12)	The spooler pulling of the plastic material has a less slippery surface which makes it difficult to remove the wire when pulling.	Use a spooler pulling that is smoother on the surface and uses a harder material.	Vertical	MCH	•					FINISH		Ī
Fall	ling Down													Т	Т
27		V-6	Pass-Line Check.	Sheaves after 1st Pre-Annealer are Placed Outside of 2nd Deck.	Extend 2nd Deck or Modify Pass-Line.		MCH						Make banner		Ť
151		MSTS (MTN)	Cleaning & change multi Media Filter RO (Horizontal RO).	The filter tube is blocked by the panel, because the tube must be taken out.  Narrow space; during RO cleaining, need to re lay out.	Move the panel position next to the RO, during repair or cleaning the tube can pass through the panel area.	MTN	MCH						Next FY2024		(
154		MSTS (MTN)	Raising and lowering the upper sheave (V4-, V10 & V11).	There is no tool to lift the upper sheave because the weight of the upper sheave is approximately 80 kg.	A hoist crane or chain block is made to liftflower the upper sheave.	MTN	MCH						FINISH		İ
162		Horizontal Coating	Move position filter lubricant	Uneven deck lubricant.	The operator tripped and fell.	Horizontal	MCH				•		FINISH		Ť
, Hig	h Temper	atures, Explosives,	Noxious Gases, Chemicals	Mission I Row E & and SI & Luncillab the addition E 2241 7 must be obtained for it in 1.1	I lains a machina to atir when the process of minion										
65		Varnish (MSTS)  Modification of varnish.  Mixing Liton FA and SLAI varnish, the additive FA341-7 must be keep package when it will be used.		Mixing Liton FA and SLAI varnish, the additive FA341-7 must be shaken first in a 15 kg package when it will be used.	Using a machine to stir, when the process of mixing	Varnish	Varnish								
66		MSTS (QC)	The process of checking the cut through machine (1).	The dumper does not function when the cut trough M/C is cooling, so the cooling process and hot steam causes the heat sensor activated.	Dumper is repaired so it works properly.	QC	MTN					3	FINISH		Ī
70		Varnish (MSTS)	Varnish drain pipe.( Machine H-1)	The varnish drain pipe is not long enough, when draining the varnish, add the pipe.	Install a permanent connection pipe.	Varnish	MCH								t
71		Varnish (MSTS)	Drum varnish supply.	Often the varnish supply pipe is left without a varnish drum covering it. (H3,H4,H5,H76 & V3)	Made a pipe holder for the varnish pipe.	Varnish	MCH						FINISH		Ī
72		Varnish (MSTS)	Take out Vamish V4	The varnish tank cover is small, the operator finds it difficult to clean the varnish.	The varnish cover is replaced with one cover     Ball sensor replaced with stick sensor.	Varnish	MCH								
73		Varnish (MSTS)	Replace the varnish line (V10)	The "L" channel for top coat is difficult because it is narrow	Modify the space between the mouthpiece and the toi	Varnish	MCH						FINISH		
74		Vertical Coating	Varnish charging	Vamish charging manual.	Splash by varnish.	Varnish	MCH						Inprogress		İ
75		Varnish	Modification of varnish	The varnish filter cannot fit into the mixer hole.	Splash by varnish.	Varnish	MCH								
															1

1. Ada rencana tahunan untuk mempersiapkan alat/perlengkapan untuk kaizen.

Aur Dies Das Profis Chart & Rigal Course

With Streeting Street

III

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Diam'r.

Nembe

Also, Mile Start many Dereken 99-Aug-24 **Faredy** Section. Priority Magnitud Whole COMPY Description above District of the April Martis Aviti Artis Augus Beatts Datts Novice Dects Jartis Peatts Martis HARRY BURNS, CALL STOR CAR SHOULD ... Retended E0000 N. A. LOUIS D. D. lefacturies biggs 20 Seems N. A. Sec. 8 5 Communication belows 81 0.46 00004 81 Annuation MITELES CONTRACTOR IS 03001 4.00 P.E. 9800 OF BUILDING ON Theories PAR size delicated to \$100. Trackular secure of a No. To an Abbit E Avio Serson Geraro seri OSEOWOL. PE. Code to have to be built to the force fig. GENERAL ITEM (less than 100KUSD) MRXiax Plear State Digital weighting Area Quetto SAMBIERI SA Ruston (Ar Serve S.) Section Priority Item Machine / Place Property Street Contract of National Street, by Street, and Street, 21 and 50 persons Danie Charles and Microsophia and a Sale Fride Lane 3. Sen Handlift Battery, Cap. 2.5 Ton. Committee Steam error Washing William Service Derry A-Line & A-00 A-00.A-Line & B-MR/Aux Refractometer Digital Restriction of the Board of Line Service Aritic Service. A-00.A-Line & B-(C) Visite Salar Millionetral N-33 9.63 DRAWING MR/Aux Conductivity Meter Dec or Mr. Yudhi INF. Michigano earlier investo (C) 6.21 Æ. Description Mr. M. Syarif H. And Diss. Annual Will A. (\$10.0). Play tones 09 В Vaccum Machine A-03 Dusty (Mr. Bonar S.) 1889 N. E. / Wild 1985 Chargo sension almost all Straffe. 10/2/2007/00 Sk me Prote Nation TA3 cognision 101.000 MA 0.00 A Common Sudde Sharove Approxim 0.00 On Mine or A Section 60 March Country, 1997 Country, 6. O. ofer Cold Welder BM101 V-8. V-9. V-11 equipment of TALL STREET, STREET, ST. MR. V-4 Change Sentine Streets Expose Continue Sales. Tension meter DTMB-10C V-8. V-9 A 164 rest New Cornery Rolls FC rate (NC If the most Assessed time the DI IC OR 181 B FP/CP-500 Rewinding M/C VERTICAL Barricon Holde Revenu (Cornell Sending) 181 Custo Mr. Rohim MR Carry Dec For All marking make you for soon make 1864 Pedebug SPB-Oil Box for Rewinding M/C Mr. M. Syarif H. MR. Bowers Tools for Honey Drowing Diss. 24 Probecies (Mr. Bonar S.) Aux Diss Remove Drawing Display Producting owners No. of Concession, DO: Personal SPB Oil Box for V-11B V-11B A Low Some various and to her tier 580 bely # BPS-DESpeers Aver Designing Artes W. 040 Derv and Other property and all of February and From Sec. property MESS MH Steel 's A DOC DOOR VALUE OF letter lac 196 Encourage.

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HAMP FAMOUR

Drighted West on May be

1. Ada rencana tahunan untuk mempersiapkan alat/perlengkapan untuk kaizen

NEW PRODUST AISIN Remarks Priority Items Machine / Place Category Amount Depreciation (Spec. etc.) Apr'24 May'24 Jun'24 Jul'24 Aug'24 Sep'24 Oct'24 Nov'24 Dec'24 Jan'25 Feb'25 Mar'25 S Oven - Upper sheave cover 12,000 Original Plan on Aug'24 MN Productivity New product AISIN KIAN S Oven - PB-box filter Productivity New product AISIN 10,000 10,000 Original Plan on Aug'24 S Oven - Positive pressure in applicator room V11B MN Productivity New product AISIN 22,000 KIAN Original Plan on Oct'24 KIAN 52,000 S Oven - Heat resistant filter V11B MN Productivity New product AISIN 52,000 Original Plan on Nov'24 KIAN 12,000 Passine - Cover prevent for falling foreign material Productivity New product AISIN 12,000 Original Plan on Sep'24 Passine - Hoistcrane change iron powderless type VIIB MN Productivity New product AISIN 95,000 KIAN Original Plan on Dec'24 Passline - Cover prevent for falling foreign material [20000] Re-winding Productivity New product AISIN MACHINERY Mr. Arfin S. New product AISIN → switch to Budget A-100 add S Installation Shaving Machine Mr. Nakamura S Installation Optical blister detector/Discoloration sensor VIIB MN Productivity New product AISIN 20,000 KIAN 20,000 Original Plan on Aug'24 Mr. Boner S. Install PDIV Tester (Including Humidity Room) 315,000 KIAN 315,000 QC Room QC New product AISIN Original Plan on Nov'24 Install Dielectric Constant Tester KIAN QC Room QC New product AISIN 25,000 Original Plan on Aug'24 LCR meter for AISIN) Install New Elongation Tester QC Room QC Quality New product AISIN 25,000 KIAN 25,000 Original Plan on Aug'24 Original Plan on Sep'24 QC Room QC New product AISIN Tablet or similar tools / Need to discuss with member Change Isyout QC room for installation new tester 70,000 Original Plan on Nov'24 QC Room QC Quality New product AISIN 82,000 411,000 124,000 25,000

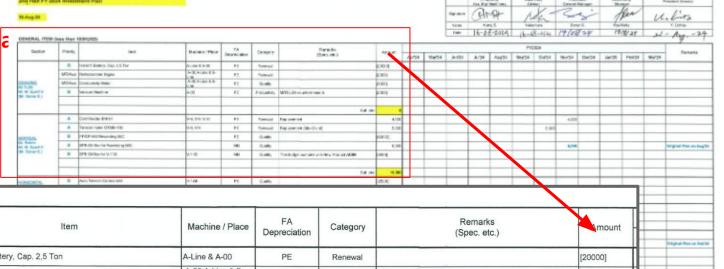
### **NEW PRODUCT AISIN**

Section	Priority	Items	Machine / Place				
	s	Oven - Upper sheave cover	V11B				
	S	Oven - PB-box filter	V11B				
	S	Oven - Positive pressure in applicator room	V11B				
	S	Oven - Heat resistant filter	V11B				
	s	Passline - Cover prevent for falling foreign material	V11B				
	S	Passline - Hoistcrane change iron powderless type	V11B				
	Section	\$ \$ \$ \$ \$	S Oven - Upper sheave cover S Oven - PB-box filter S Oven - Positive pressure in applicator room S Oven - Heat resistant filter S Passline - Cover prevent for falling foreign material				

2. Ada alokasi anggaran tahun (termasuk MH)
untuk kegiatar
kaizen.

GENERAL ITEM (less than 100KUSD untuk kegiatan

GENERAL ITEM (less than 100KUSD)



Section	Priority	ltem	Machine / Place	FA Depreciation	Category	Remarks (Spec. etc.)	mount	Diagnal Nas on Facility
	В	Handlift Battery, Cap. 2,5 Ton	A-Line & A-00	PE PE	Renewal		[20000]	
	MR/Aux	Refractometer Digital	A-00,A-Line & B- Line		Renewal		[2000]	
DRAWING Mr. Yudhi	MR/Aux	Conductivity Meter	A-00,A-Line & B- Line	PE	Quality		[1000]	
Mr. M. Syarif H. (Mr. Bonar S.)	В	Vaccum Machine	A-03	PE	Productivity	MITSUBA countermeasure	[2000]	
						Sub total	1 0	
	Α	Cold Welder BM101	V-8, V-9, V-11	PE	Renewal	Replacement	4,000	
	Α	Tension meter DTMB-10C	V-8, V-9	PE	Renewal	Replacement (Qty=2 unit)	5,000	Original Ros on Aug 56
VERTICAL	В	FP/CP-500 Rewinding M/C		PE	Quality		[60000]	
Mr. Rohim Mr. M. Syarif H.	Α	SPB-Oil Box for Rewinding M/C		MN	Quality		6,000	
(Mr. Bonar S.)	В	SPB Oil Box for V-11B	V-11B	MN	Quality	This budget combine with New Product AISIN	[0000]	
						Sub total	15,000	Chighral Was on May be

3. Kegiatan kaizen bisa dilanjutkan tanpa mempengaruhi produksi.

D2-IDW-4E 0.83

79.5 m/ 22.94

2PEW 0.80

MELCO (PT-200)

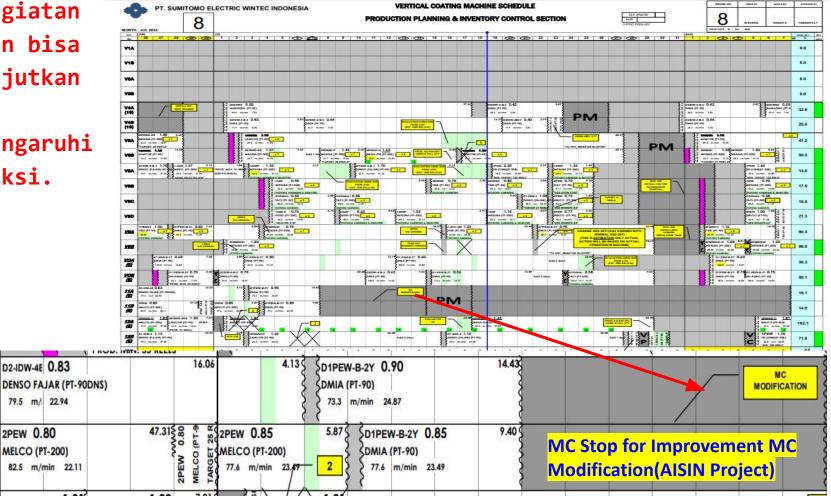
82.5 m/min 22.11

11A

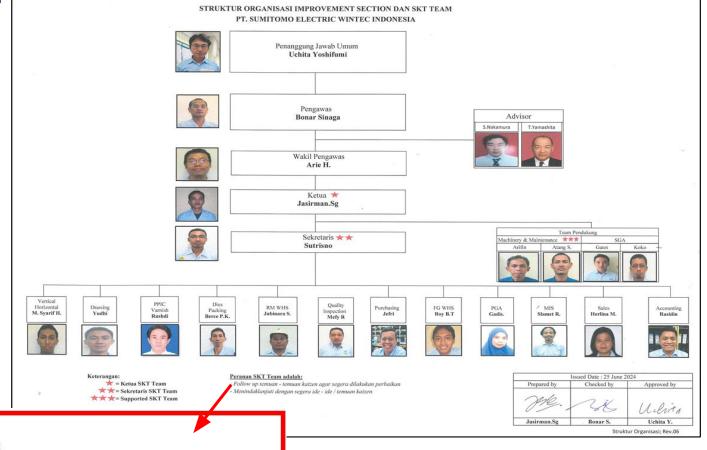
(5)

11B

(5)



4. Ada tim kaizen (SKT) yang merealisasikan kaizen dengan cepat dan tugasnya juga jelas. (SKT yaitu tim yang terdiri 2 orang atau lebih dengan tugas yang sudah ditentukan.)

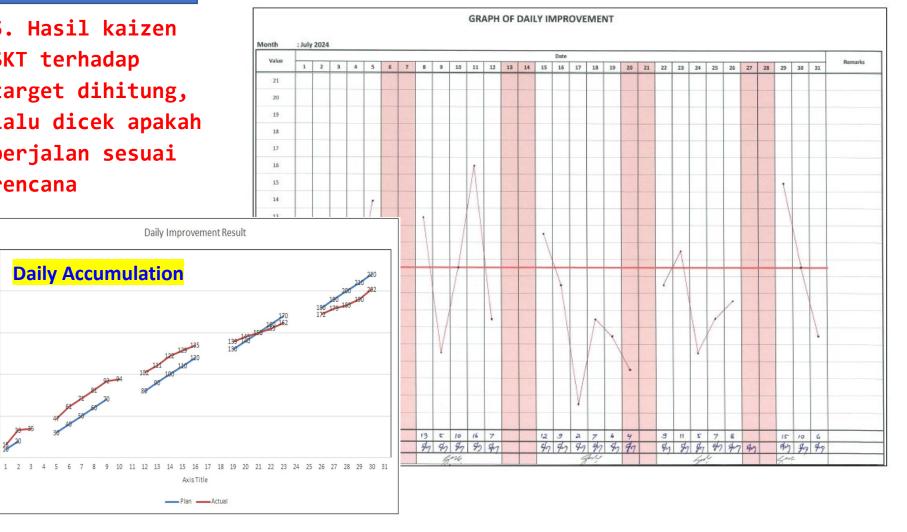


## Peranan SKT Team adalah:

- Follow up temuan temuan kaizen agar segera dilakukan perbaikan
- Menindaklanjuti dengan segera ide ide / temuan kaizen.

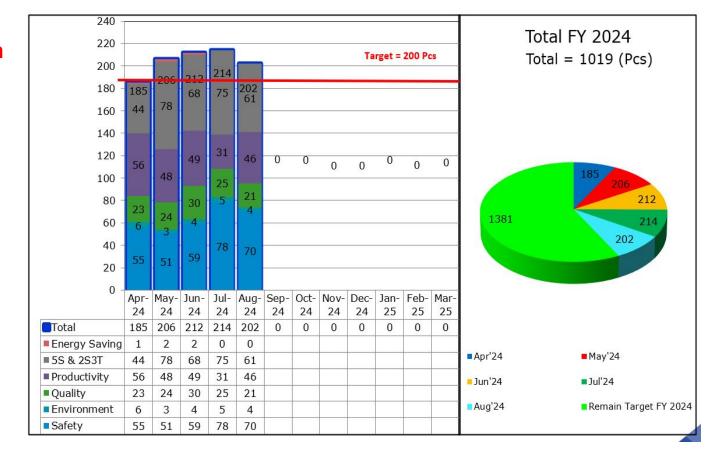
5. Hasil kaizen SKT terhadap target dihitung, lalu dicek apakah berjalan sesuai rencana

**Daily Accumulation** 



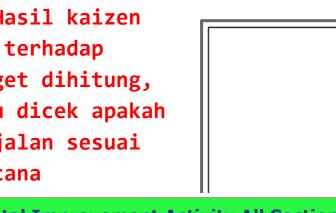
5. Hasil kaizen
SKT terhadap
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berjalan sesuai
rencana

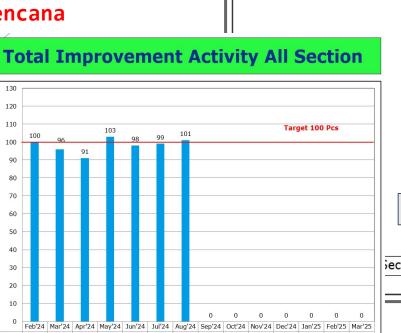
# **Total of Improved Item (Pcs) (1st Half FY 2024)**



# 5. Hasil kaizen SKT terhadap target dihitung, lalu dicek apakah berjalan sesuai rencana

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## **Breakdown each section**

