1. **Standar yang diperlukan untuk prosedur pengoperasian sudah dibuat dan disusun secara sistematis termasuk one-point standard.**

Jumlah IK & STANDARD ALL SECTION

No.	Section	IK	Standard	One Point Control	One Point Standard
1	PE	31	81	26	11
2	MAINTENANCE	62	15	2	-
3	ACCOUNTING	1	0	-	-
4	CALIBRATION	11	0	-	-
5	DIES	36	12	-	-
6	DRAWING	39	0	1	-
7	ENVIROMENTAL	36	0	-	-
8	HORIZONTAL	57	0	6	11
9	IMPROVEMENT	4	1	-	-
10	MACHINERY	16	1	-	-
11	MIS	8	2	-	-
12	PACKING	11	0	-	-
13	PGA	24	0	-	-
14	PPC	13	1	-	-
15	PUR	11	0	-	-
16	QA	92	67	13	-
17	QI	54	0	-	-
18	SAFETY	35	2	-	-
19	SALES	14	1	-	-
20	SHIPPING	16	0	-	-
21	VARNISH	15	2	2	-
22	VERTICAL	90	0	19	5
23	WAREHOUSE	33	1	3	-

1. **Standar yang diperlukan untuk prosedur pengoperasian sudah dibuat dan disusun secara sistematis termasuk one-point standard.**

PE Dept Work Instructions

PT. SUMITOMO ELECTRIC WINTEC INDONESIA	No. Dokumen	4-QAS-052
	Revisi	00
DAFTAR INSTRUKSI KERJA / STANDAR / FORM	Tgl Berlaku	18 October 2023

NO.	Dokumen No.	Judul Dokumen	Tanggal terbit	Revisi	Review Date	Remark
1	2-PEG-001	PE Job Description & Distribution	1-Dec-23	03	30-Apr-24	
2	2-PEG-002	Pembuatan Indication Slip	23-Aug-21	04	30-Apr-24	
3	2-PEG-003	Analisa Blister	24-Feb-17	00	30-May-24	
4	2-PEG-004	Pengoperasian Blister Collecting Machine	29-Mar-17	00	20-May-24	
5	2-PEG-005	Cara Pengujian Viscositas	1-Mar-24	02	21-Jun-24	
6	2-PEG-007	Input cost sheet costing ke EZ runner	24-Aug-24	00	24-Jun-24	
7	2-PEG-008	Pengontrolan Kondisi Varnish (Viscositas & Resin %) Saat Proses Produksi	24-Feb-17	00	16-Jul-24	
8	2-PEG-009	Input data Overall Equipment Effectiveness machine vertical (OEE)	28-Mar-24	00		
9	2-PEG-018	Pengecekan Air Flow	21-Dec-21	00	26 jul 24	
10	2-PEG-020	Hot Oven Filtering	21-Jan-19	00		
11	2-PEG-021	Pengoperasian mesin Twist Test	30-Apr-19	00		
12	2-PEG-022	Pengukuran Dimensi menggunakan Portable Laser Micro	4-Feb-20	00		
13	2-PEG-023	Pengecekan Setting Eddy Current Sensor Mesin A-00	17-Jul-20	00		
14	2-PEG-024	Pengontrolan WIP & stock taking	27-May-21	00		
15	2-PEG-025	Pengecekan Torque	23-Jun-21	00		
16	2-PEG-026	Kalkulasi coating dies step	29-Jul-21	00		
17	2-PEG-027	Tata Cara Pengecekan Pada Benda Yang Berputar	29-Oct-21	00		
18	2-PEG-028	Input Online Alarm	25-Jul-22	00		
19	2-PEG-029	Pembuatan DVNZ Vertical & Horizontal coating	24-Aug-22	00		
20	2-PEG-031	Input Effisiensi ke EZ Runner	23-Feb-23	00		
21	2-PEG-032	Input DVNZ to EZ Runner	9-Mar-23	00		
22	2-PEG-033	Kalkulasi costing manual	26-Apr-23	00		
23	2-PEG-034	Pengecekan New Eddy Current sensor mesin A-00	5-May-23	00		
24	2-PEG-035	Input data OEE mesin vertical	13-Feb-24	00		
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NOTE : - Plan Review IK from Apr 2024 - March 2025

- Target every month 2 IK

18. Standar/prosedur

2. **Ada mekanisme/aturan untuk mengecek** semua prosedur kerja yang diperlukan sudah distandarisasi.

Vertical Dept Work Instructions

DAFTAR INSTRUKSI KERJA / STANDAR / FORM	No. Dokumen	4-QAS-052
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VERTICAL SECTION

Issued Date : 20 November 2023

	Dokumen No.	Judul Dokumen	Tanggal terbit	Revisi	Review Date	Review Date	Remark
1	2-VRT-001	Pengecekan Material Sebelum Star Up	6-Oct-22	06			
2	2-VRT-002	Pengecekan Mesin Sebelum Star Up & Sample	14-Jul-22	08			
3	2-VRT-003	Pengecekan Bentuk Gulungan	10-Aug-23	07			
4	2-VRT-004	Pengecekan Tension Barewire pada PAY OFF	2-Dec-16	00			
5	2-VRT-005	Pengecekan Kondisi Pengapungan Floating Dies	28-Jun-19	01			
6	2-VRT-006	Cara Memarikulasi & Pengecekan Alran Varnish	10-Aug-17	01			
7	2-VRT-007	Pengelasan Kondisi Kerja Water Bath	2-Dec-16	00			
8	2-VRT-008	Cara Pemasangan & Pengecekan Cooling Oil	7-Oct-19	03			
9	2-VRT-009	Pengecekan Temperature Proses	30-Jan-20	02	10 Sept 23		-
10	2-VRT-010	Barewire Joint pada Inline Machine	18-Aug-21	05	10 Sept 23		-
11	2-VRT-011	Barewire Joint pada Outline Machine	29-Aug-19	05	10 Sept 23		-
12	2-VRT-012	Cara Wire Joint pada Barewire Drum Outline Machine	2-Dec-16	00	17 Oct 23		-
13	2-VRT-013	Pengaturan Barewire Joint Basket Pakai Sensor	2-Dec-16	00	17 Oct 23		-
14	2-VRT-014	Pengukuran Wire Speed	2-Dec-16	00	17 Oct 23		-
15	2-VRT-015	Cara Pengemblan Reel dari Keranjang	2-Dec-16	00	16 Nov 23		-
16	2-VRT-016	Pengecekan pada Produk Akhir	20-Jul-22	03	16 Nov 23	16-4-24	Retraining
17	2-VRT-017	Penanganan Mesin pada Saat Listrik Mati	2-Dec-16	00	16 Nov 23		Revised
18	2-VRT-018	Sistem Kerja KO & Lubricant	22-Jun-18	01	22 Dec 23		Revised

86	2-VRT-094	Standard Pengontrolan Instruksi Kerja (IK) & Grade	3-Nov-23	00			
87	2-VRT-095	Penggantian Drum Varnish	18-Sep-23	00			
88	2-VRT-096	Cara Penanganan Produk Alarm Laser Micro	17-Apr-24	00	17-Apr-24		Retraining
89	2-VRT-097	Pengontrolan kebersihan sheave		00	18 June 24		Training

Note: - Plan Review WI form May 2024 ~ Sep 2026
- Target every month 3 WI

Total WI = 89 pcs
Plan Review : May 24 – Sep 26
Target : 3 / Month

18. Standar/prosedur

2. **Ada mekanisme/aturan untuk mengecek** semua prosedur kerja yang diperlukan sudah distandarisasi.

PE Dept Work Instructions

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6	2-PEG-007	Input cost sheet costing ke EZ runner	24-Aug-24	00	24-Jun-24	
7	2-PEG-008	Pengontrolan Kondisi Varnish (Viscositas & Resin %) Saat Proses Produksi	24-Feb-17	00	16-Jul-24	
8	2-PEG-009	Input data Overall Equipment Effectiveness machine vertical (OEE)	28-Mar-24	00		
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12	2-PEG-022	Pengukuran Dimensi menggunakan Portable Laser Micro	4-Feb-20	00		
13	2-PEG-023	Pengecekan Setting Eddy Current Sensor Mesin A-00	17-Jul-20	00		
14	2-PEG-024	Pengontrolan WIP & stock taking	27-May-21	00		
15	2-PEG-025	Pengecekan Torque	23-Jun-21	00		
16	2-PEG-026	Kalkulasi coating dies step	29-Jul-21	00		
17	2-PEG-027	Tata Cara Pengecekan Pada Benda Yang Berputar	29-Oct-21	00		
18	2-PEG-028	Input Online Alarm	25-Jul-22	00		
19	2-PEG-029	Pembuatan DVNZ Vertical & Horizontal coating	24-Aug-22	00		
20	2-PEG-031	Input Effisiensi ke EZ Runner	23-Feb-23	00		
21	2-PEG-032	Input DVNZ to EZ Runner	9-Mar-23	00		
22	2-PEG-033	Kalkulasi costing manual	26-Apr-23	00		
23	2-PEG-034	Pengecekan New Eddy Current sensor mesin A-00	5-May-23	00		
24	2-PEG-035	Input data OEE mesin vertical	13-Feb-24	00		
37						
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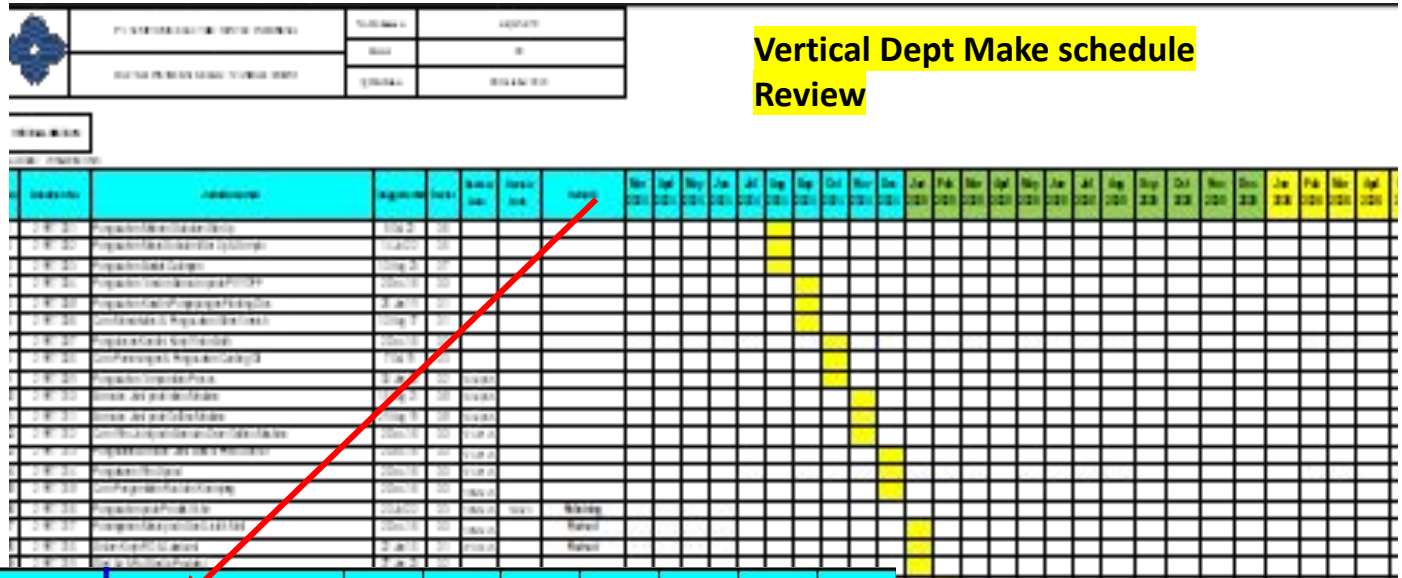
NOTE : - Plan Review IK from Apr 2024 - March 2025

- Target every month 2 IK

Total WI = 24 pcs
Plan Review : Apr 24 – March25
Target : 2 / Month

3. **Standar ditinjau/review sesuai rencana, dan progresnya ditelusuri berkala.**

Vertical Dept Make schedule Review



Tanggal terbit	Revisi	Review Date	Review Date	Remark	Mar 2024	Aprl 2024	May 2024	Jun 2024	Jul 2024	Aug 2024	Sep 2024
6-Oct-22	06										
14-Jul-22	08										
10-Aug-23	07										
2-Dec-16	00										
28-Jun-19	01										
10-Aug-17	01										

4. Progres peninjauan/review standar berjalan sesuai rencana tanpa tertunda. **Bila terjadi keterlambatan, ambil penanganan yang diperlukan termasuk sesuaikan jadwal.**

If Review Not as Plan, Additional QTy WI Review on next month

VERTICAL SECTION POLICY

Theme	POLICY	ACTIVITY PLAN	FY 2024 Target	FY 2023 MONTHLY RESULT						Remark
				APR'24	MAY	JUNE	JULY	AUG	SEPT	
Safety	Zero Accident	Zero Accident Win -I	0	0	0	0	0			
		Zero Hiyari section	0	0			0			
		Zero safety glass wearing violation	0	0			0			
	Zero Accident	Zero Accident Win -I	0	0			0			
		Zero Hiyari section	0	0	0	0	0			
	Reduce Co2 Emissions	Clear saving energy target (kWh)	5,427	16,830	6,335	31,659	12,112			
	Zero Claim and reduce feedback	Zero Claim Win-I	0	0	0	0	0			
		Reduce Feedback section	4 cases/Y	0	0	0	1			
		Zero Human Error	0	2	0	0	0			
		MFA level up (by external auditor)	Level 3	2.3	2.0	2.0	2.0			
		Training and Re-training WI to all opr	3 /M	3	3	3	3			
		Self section improv. for 200 kaizen	8/M	8	8	8	8			
		Activity plan achievement (%)	100%	100	100	100	100			
		Strenghten Passline Patrol after S/U	8	8	8	8	8			
		Controlled passline (reduce finding)	5 /Y	0	0	0	0			
Cost	Reduce Total Loss	Reducing Operation loss ratio (%)	2.95	3.50	2.62	3.66	2.99			
		Reducing Wire break (ton/break)	80 ton/ Break	85.6	95.6	80.2	72.7			
	Reduce S/U Time Loss	Idle time on Start Up m/c	9.5 h	9.4	9.3	9.1	9.5			
	Reduce Production Cost	Labor Hour control (vs Plan Act.)	45,791	25,002	38,613	36,088	40,631			
		Auxiliary Cost control (vs Plan Act.)	23,295	23,724	16,072	26,833	21,958			
		CR Plan (US$)		2,815	899	4,494	1,719			

Blister,
1AIW-S 0.65 (PIDSG)
V8D4310-007-02

18. Standar/prosedur

4. Progres peninjauan/review standar berjalan sesuai rencana tanpa tertunda.

Bila terjadi keterlambatan, ambil penanganan yang diperlukan termasuk sesuaikan jadwal.

PE Dept Work Instructions

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12	2-PEG-022	Pengukuran Dimensi menggunakan Portable Laser Micro	4-Feb-20	00		
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14	2-PEG-024	Pengontrolan WIP & stock taking	27-May-21			
15	2-PEG-025	Pengecekan Torque	23-Jun-21			
16	2-PEG-026	Kalkulasi coating dies step	29-Jul-			
17	2-PEG-027	Tata Cara Pengecekan Pada Benda Yang Berputar	29			
18	2-PEG-028	Input Online Alarm	25-Jul-22			
19	2-PEG-029	Pembuatan DVNZ Vertical & Horizontal coating	24-Aug-22			
20	2-PEG-031	Input Effisiensi ke EZ Runner	23-Feb-23			
21	2-PEG-032	Input DVNZ to EZ Runner	9-Mar-23			
22	2-PEG-033	Kalkulasi costing manual	26-Apr-23			
23	2-PEG-034	Pengecekan New Eddy Current sensor mesin A-00	5-May-23			
24	2-PEG-035	Input data OEE mesin vertical	13-Feb-24			
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If Review Not as Plan, Additional QTy WI Review on next month

NOTE : - Plan Review IK from Apr 2024 - March 2025

- Target every month 2 IK

18. Standar/prosedur

5. Kegiatan dibuat untuk mendorong operator melaporkan pekerjaan yang sulit dilakukan dan **ketidaksesuaian antara aktual pengoperasian dan prosedur**. Hasil kegiatan tersebut mengarah ke revisi standar.

Saat sedang melakukan Pass line kadang operator tidak bisa fokus dan pengecekan terlewat karena ada beberapa mesin yang harus joint atau angkat produk full winding (Opr Feedback)

3 Point Control Patrol

Improvement Patrol Summary

Date : 06 June 2024
Time : 10.30 wib
Inspector : Mr. Marlin
Tema : Pengecekan Mesin Sebelum Start Up dan Sample (2-WB 002)
► 3 POINT CONTROL PATROL

Attendance
1. Suriono
2. Mely
3. Sirin
4. Yudhi
5. Rohim
6. Arie
7. M. Syaiful
8. Jaelmen

No.	Findings	Finding Picture	Finding Type	Area	PIC	Risk Level	Countermeasure	Picture after Improved	Due date	Finish date	Recheck date	Status
									Filled by Improvement Section			
1	Prosedur timing urutan pemeriksaan proses start up belum ada?		Level 1	CV	Mr. Rohim	-	Akan dibuatkan prosedure	No Picture	20-Jun-24	19-Jun-24	19-Jun-24	Closed
2	Double cek metode yang dilakukan leader kurang jelas dan detail		Level 1	CV	Mr. Rohim	-	Double check dilakukan oleh Leader sebelum sample dikirim ke QC	No Picture	20-Jun-24	19-Jun-24	19-Jun-24	Closed
3	Urutan kerja harus dibuat sesuai dengan urutan pekerjaan yang dilakukan, dan bagaimana caranya agar work sheet dan instruksi kerja pas dan sesuai..		Level 1	CV	Mr. Rohim	-	Worksheet Start up dibuat beda (Stock warna)	No Picture	20-Jun-24	19-Jun-24	19-Jun-24	Closed
4	Tombol ultrasonic tidak menyala		Level 1	CV	Mr. Rohim	-	MTR 27 Juni 2024		20-Jun-24	19-Jun-24	19-Jun-24	Closed
5	Hot jetter fluktuasi		Level 1	CV	Mr. Rohim	-	MTR 27 Juni 2024		20-Jun-24	19-Jun-24	19-Jun-24	Closed
6	New Lile before annealer groove		Level 1	CV	Mr. Rohim	-	MTR 27 Juni 2024		20-Jun-24	19-Jun-24		
7	Indikasi Pressure air wiper melebihi standar.		Level 1	CV	Mr. Rohim	-	MTR 27 Juni 2024		20-Jun-24	19-Jun-24		
8	Vamish tank control panel tidak dipakai, sebaiknya dilakukan cut.		Level 1	CV	Mr. Rohim	-	MTR 27 Juni 2024		20-Jun-24	19-Jun-24		
9	Saat sedang melakukan Pass line kadang operator tidak bisa fokus dan pengecekan terlewat karena ada beberapa mesin yang harus joint atau angkat produk full winding (Opr Feedback)		Level 1	CV	Mr. Rohim	-	Info ke Leader atau rekan kerja untuk membantu joint / mengangkat produk full winding.	No Picture	20-Jun-24	19-Jun-24	19-Jun-24	Closed

Total	9
CLOSED	9
OPEN	0
Finish Ratio (%)	100%

*. Finding Type :
I = Initial
R = Recurrence
S = Similar

** Risk Level :
Risk Level 4 = Proses operasi yang sangat bahaya
Risk Level 3 = Meskipun kita sudah mengikuti aturan terkadang kecelakaan masih bisa terjadi.
Risk Level 2 = Hanya jika kita tidak mengikuti aturan saja kita bisa celaka.
Risk Level 1 = Meskipun kita tidak hati hati atau tidak perhatian kecelakaan mungkin tidak terjadi.

Info ke Leader atau rekan kerja untuk membantu joint / mengangkat produk full winding.

Back