

LEMBAR KONTROL HASIL ( DEKI DAKA )

LEMBAR KONTROL HASIL (DEKIDAKA)	
Hari / Tanggal	2 Apr / 76.022
Seksi	HOUSING
Nama Linca/Mesin	Cold Forging I
PIC (leader)	Sgt
Jam Kerja	08.00 - 16.00

  

Keterangan (m <sup>2</sup> /jam)	pcs
TT	sec
Opda Time MAYORHEKIN	1 sec

  

Batas Kontrol	
100%	3600
85%	3060
100% SM	3300
85% SM	2895

Cardas

**Man Power :**

JAM	Rencana	Actual	PROBLEM	Action	Lost Time	Qty Setting	Paraf Leader
08:00	3600	3600	Respon Jajut Hualisa	Merblank-	10	70	✓
09:00	3600	3600	Respon Jajut Hualisa Pasar (Hualisa)		10	70	✓
10:00	3600	3600			10	70	✓
11:00	3600	3600			10	70	✓
12:00	3600	3600			10	70	✓
13:00	3600	3600	Costolusi Quality part		10	70	✓
14:00	3600	3600	Jajut partal... partal	Cutter	10	70	✓
15:00	3600	3600			10	70	✓
16:00	3600	3600			10	70	✓
17:00	3600	3600	tools fire mesin	Counting	10	70	✓
18:00	3600	3600	partal... partal	partal... partal	10	70	✓
19:00	3600	3600			10	70	✓
20:00	3600	3600			10	70	✓
TOTAL							

# DAILY PRODUCTION RECORD

		JAM										TOTAL CITY
NO	PART NO.	MODEL	08:00 - 09:00	09:00 - 10:00	10:00 - 11:00	11:00 - 12:00	13:00 - 14:00	14:00 - 15:00	15:00 - 16:00	16:00 - 17:00		
1	-1613	U16FS-U										
2	-1631	U20FS-U										
3	-1641	U22FS-U										
4	-9580	U22FER9										
5	-9470	U20EPR9										
6	-9260	U22EPR9										
7	-5381	U24EPR9										
8	-5391	U21EPR9	0	0	0	0	0	410	410	410	1100	
9	-5900	XU22PR9										
			TOTAL									19200

GRAND TOTAL QTY

**KETERANGAN**

- 2) Centi Pi 4/6, 5/6
- 3) Spring chis 4/6, 5/6 (sx)
- 4) Setting pringer 4/6 (4x)
- 5) Setting of Centi 4/6 Punch 3/6, 4/6, 5/6 (4x)
- 6) Centi Mesurant 4/6, 5/6

TOTAL LOSE TIME					
NO	Item	Lose Time (Minute)	NO	Item	Lose Time (Minute)
1	Dendery	90	4	Chokohel	
2	BM		5	Peparation	10
3	Quarfy	120	6	Others	40 (Dagaliqasi)

  

No	Item	Lose Time (minute)
7	Part Shortage	

  

1> Jika actual hasil mencapai 85% / lebih, tulis dengan tinta warna biru/hitam  
 2> Jika actual hasil kurang dari 85%, tulis dengan tinta warna merah dan beri alasannya  
 3> Jika melakukan setting tulis NG nya

Cat (Tanda tangan) Leader Foreman

*[Signature]*



Hari / Tanggal : Senin / 28.10.22

Seksi : HOUSING

Nama LineMesin : Cold Forging 1

PIC (leader) : Syaf

Jam Kerja : 08.00 - 16.00

Kedudukan (ml / ml)	PCS
TT	sec
One Time KAJUHEKIN	1 sec

Batas Kontrol	
100%	3600
85%	3060
100% 5M	3300
85% 5M	2805

JUMAT SIANG	EXCEPT TIME	(Minute)
3	0	0

JAM PRODUK PERTAMA

Layout : Gundur

Man Power :

JAM	Rencana	Actual	PROBLEM	Action	Lost Time	Paraf Leader
08:00	3600	0	Meeting CE Housing		30	
09:00	3600	0	Perbaikan CE 2		30	
09:00	3600	0	Panduan U22EPH9 -> U20EPH9		60	
10:00	3600	0				
10:00	3600	0	Junggu hasil filter flow		60	
11:00	10800	0				
11:00	3600	2680				
13:30	3600	14400				
13:30	3600	18000				
14:30	3600	5.400	Perbaikan. part awal		30	
14:30	3600	0			60	
15:30	21600					
15:30	3600	800			40	
16:30	25200					
16:30	3600	2680				
17:30	28800					
17:30	3600	2680				
19:00	32400					
19:00	3600	2680				
20:00	36000					
20:00	3300					
21:00	39300					

DAILY PRODUCTION RECORD

PART NO.	MODEL	JAM												TOTAL QTY
		08:00 - 09:00	09:00 - 10:00	10:00 - 11:00	11:00 - 12:30	12:30 - 13:30	13:30 - 14:30	14:30 - 15:30	15:30 - 16:30	16:30 - 17:30				
1	-1613 U16FS-U													
2	-1631 U20FS-U													
3	-1641 U22FS-U													
4	-9680 U22FER9													
5	-9470 U20EPR9	0	0	0	3600	1800	0	800	2400	2400	2400			17200
6	-9260 U22EPR9													
7	-5381 U24EPR9													
8	-5391 U27EPR9													
9	-5800 XU22PR9													
GRAND TOTAL QTY														

KETERANGAN

> Ganti Di Guide 3/6 kros 2/6, 1/6, kicu out side 1/6.  
- Ganti Cutter (Repair) + Saling Clearing Gull Cutter  
- Ganti PPF 3220 -> 3222  
- Ganti dia 5/6  
- Ganti kos 5/6

TOTAL LOSE TIME

NO	Item	Lose Time (Minute)	Item				Lose Time (Minute)
			1	4	5	6	
1	Dandory	6070		Chokdel			
2	BM			Preparation			
3	Quality	107		Others / Part Shortage			
1> jika actual hasil mencapai 85% / lebih, tulis dengan tinta warna biru/ungu 2> jika actual hasil kurang dari 85%, tulis dengan tinta warna merah dan beri alasannya							
Cek (tanda tangan) Leader / Foreman							



LEMBAR KONTROL HASIL (DEKSI DAKA)

Hari / Tanggal Kuany 22.10.22  
 Saksi HOUSING  
 Nama Line/Mesin Cold Forging 1  
 PIC (leader) Sgt

Kategori	PCS
TT	Sec
On the Time KANTOR MENIK	1 Sec

Batas Kontrol	
100%	3600
85%	3060
100% SM	3300
85% SM	2805

SIANG	SIANG
EXCEPT TIME	
(Minute)	
5 Minute	

Man Power : Cultur

JAM	Rencana	Actual	PROBLEM	Action	Lost Time	Qty Setting	Paraf Leader
08:00	3600	0	1) Persiapan	1) Cek blank 4519	10	30'	
09:00	3600	0	1) Tools life	1) Ganti HPR 24.7%	50		
09:00	3600	0	1) HPR (Garis)	1) Reput 5/8	60		
09:00	3600	0	1) G/S rejuv	1) Adjust punch 5/8	15		
10:00	3600	0	1) Kes Pecan	1) Ganti kos 3/8 6/16	25		
11:00	3600	0	1) Under life time	1) Setting kualitas	30		
12:00	3600	0	1) Part habis	1) Ganti part baru	15		
13:00	3600	0					
14:00	3600	0					
15:00	3600	0					
15:00	3600	0	1) Tool life	1) Ganti D1 1/6	20		
16:00	3600	0					
17:00	3600	0					
17:00	3600	0	1) Ganti part baru	1) Part	80		
18:00	3600	0	1) Error		40		
19:00	3600	0					
20:00	3600	0					
TOTAL	37800				155		

DAILY PRODUCTION RECORD

No	PART NO.	MODEL	JAM										TOTAL QTY
			08:00 - 09:00	09:00 - 10:00	10:00 - 11:00	11:00 - 12:00	12:00 - 13:00	13:00 - 14:00	14:00 - 15:00	15:00 - 16:00	16:00 - 17:00		
1	-1613	U16FS-U											
2	-1631	U20FS-U											
3	-1641	U22FS-U											
4	-9580	U22FER9											
5	-9470	U20EPR9											
6	-9260	U22EPR9											
7	-5381	U24EPR9											
8	-5391	U27EPR9	0	0	200	400	400	400	400	600	200	2400	
9	-5900	XU22PR9											

1) Kos Retak 1/6 (Life time) -> Ganti

KETERANGAN

TOTAL LOSE TIME						
NO	Item	Lose Time (Minute)	NO		Lose Time (Minute)	
				Item		
1	Dandry	77720	4	Choklet		
2	BM	50	5	Preparation	10	
3	Quality	73	6	Others	5	

1> Jika actual hasil mencapai 85% / lebih, tulis dengan tinta warna biru/hitam

2> Jika actual hasil kurang dari 85%, tulis dengan tinta warna merah dan beri alasannya

3> Jika melakukan setting tulis quantity NG nya

No	Item	Lose Time (minute)
7	Part Shortage	

Cek (Tanda tangan) Leader Foreman

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