

Storing Online FI Card



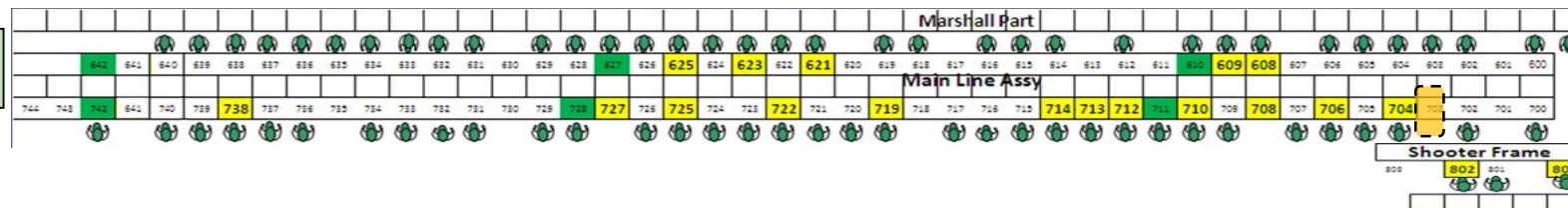
PT.Astra Honda Motor

Project Overview

(Background)

- Global Direct Pass (GDP) merupakan pengukuran kualitas proses dalam menciptakan suatu unit motor yang diukur mulai dari line assembly unit (AU) sampai final inspection (FI). Unit yang masuk dalam perhitungan GDP adalah unit yang mulai dari line AU sampai FI tanpa ada temuan atau not good (NG) poin yang menyebabkan unit harus di-repair.
- Latar belakang GDP ini adalah karena adanya Global Quality Control System of Honda untuk dapat meningkatkan kualitas dan untuk mengetahui posisi AHM secara Honda Global.
- Perhitungan GDP ini menggunakan FI Card yang proses pengisiannya dilakukan disetiap titik Q-Gate (quality gate) dan titik final inspection

Final Inspection



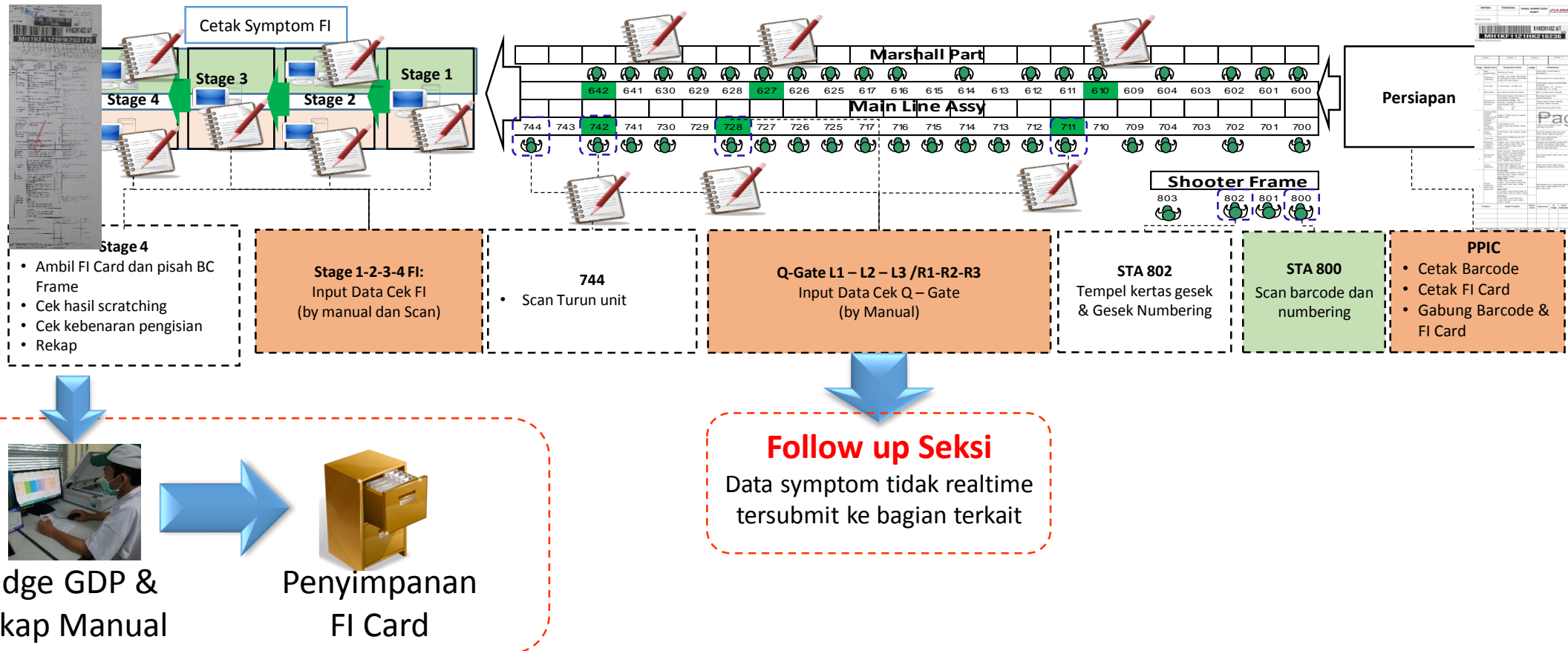
Konsen Item Final Inspection:

- 4 Field Kode Operator
- 18 Field Judge Quality

Konsen Item Q-Gate:

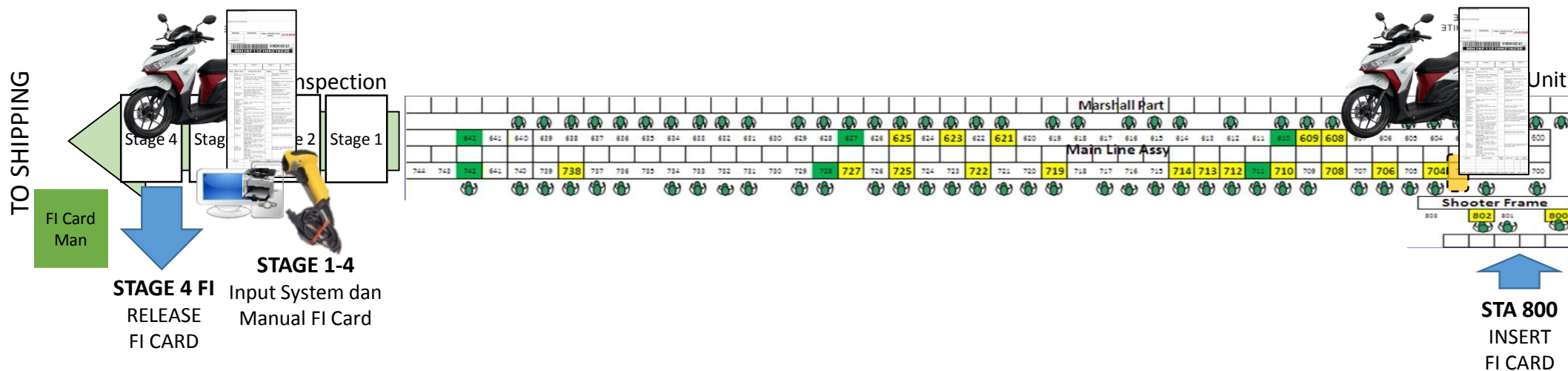
- 132 Field Judge Quality

Deskripsi : FI Card ditempel barcode oleh PC dan digantung di unit motor, pengisian dilakukan QG:Manual dan FI: System dan Manual, rekap FI Card secara manual



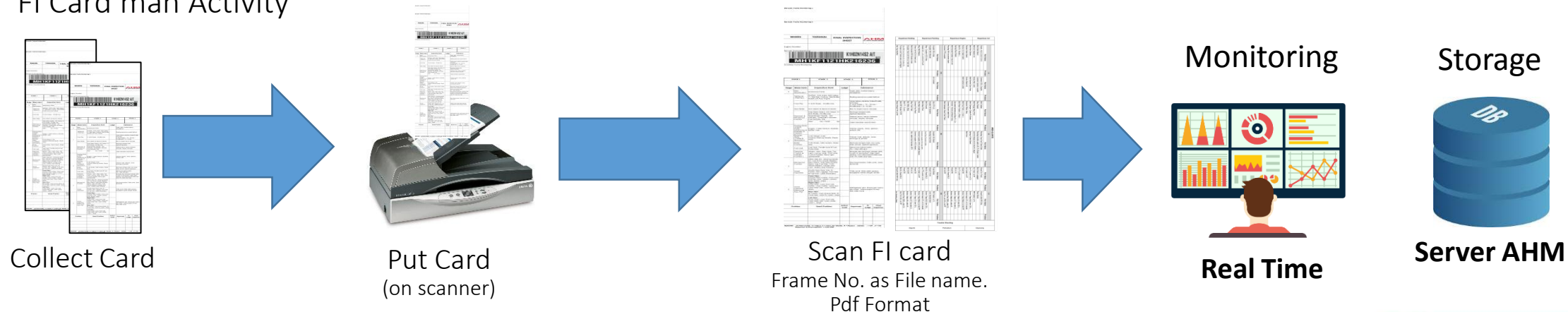
• Kondisi as-is ini menyebabkan beberapa permasalahan yaitu :

1. Adanya proses rekap manual yang menyebabkan feedback temuan membutuhkan waktu H+1.
2. Adanya kebutuhan cost yang besar untuk menyimpan Check sheet FI Card secara manual selama 15 tahun.



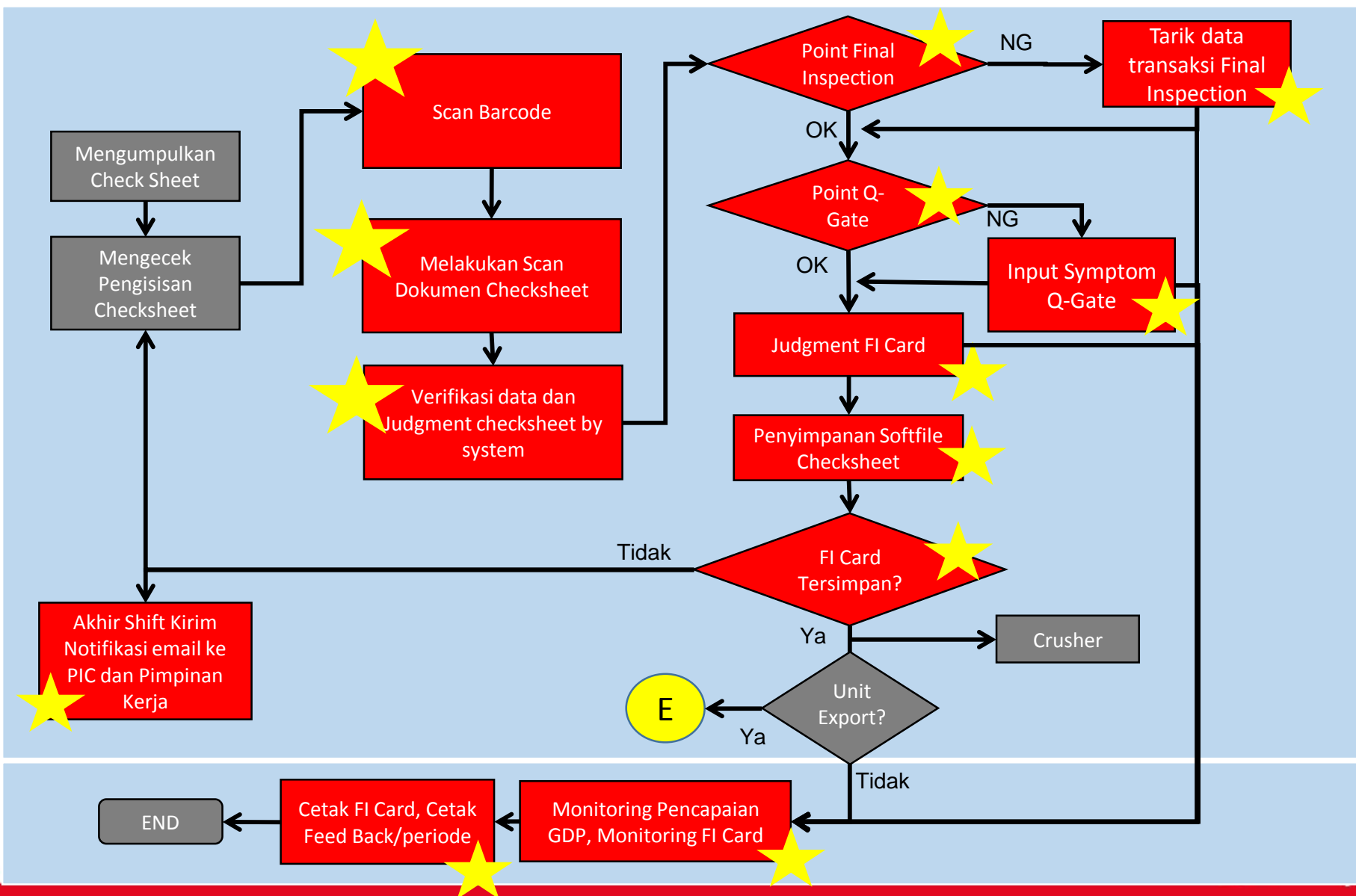
- Unit motor → ke shipping
- FI Card → ke FI Card Man

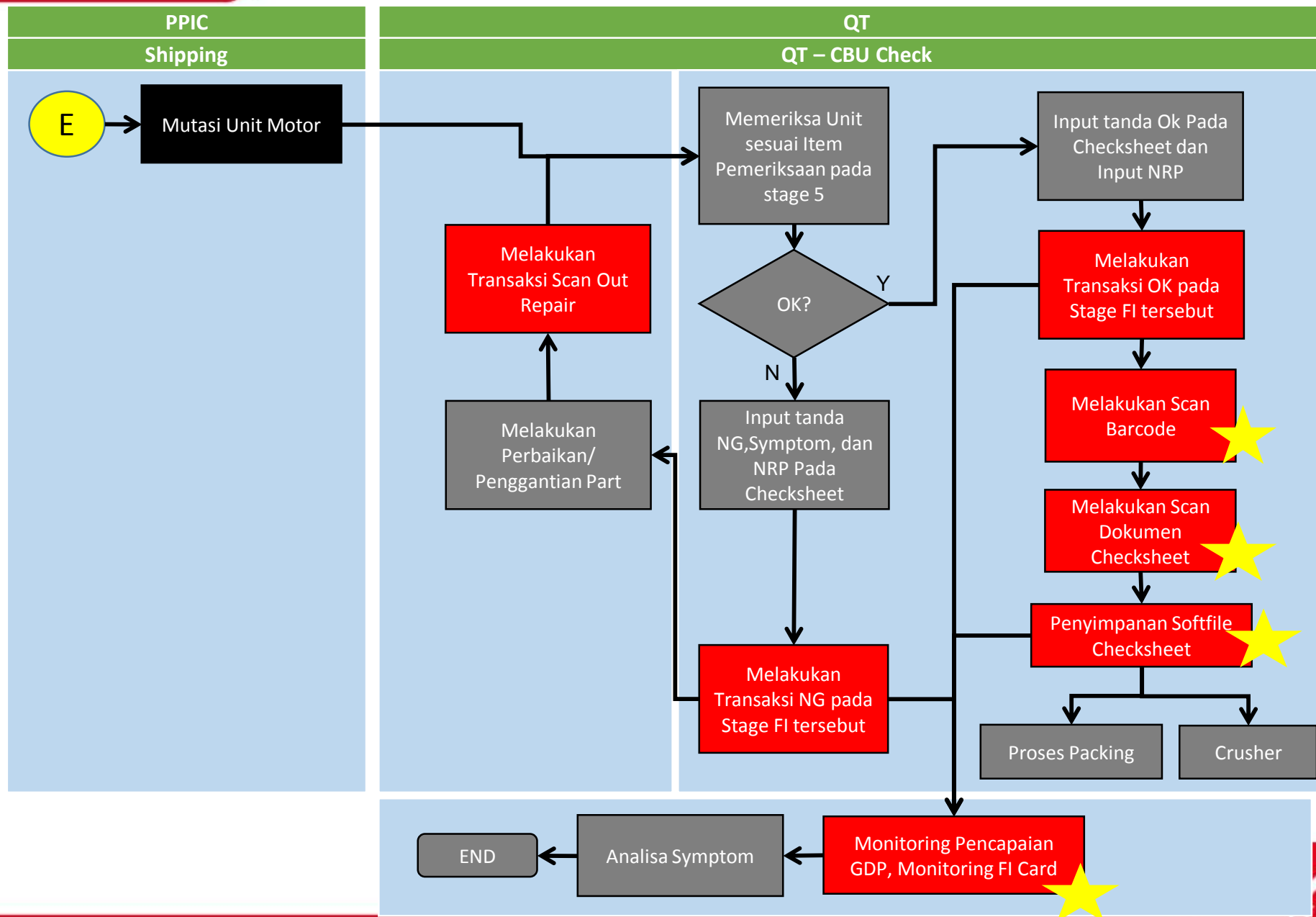
FI Card man Activity



QT

QT – Admin FI Card







Storing FI Card

Kode Plant

1700

Kode Line

7AUA

Kode WCT

P7AUA0

Kode Operator

XXXXXX

Nama Operator

Nomor Frame*

Type

START

ENTER

RETRY

Nomor Frame

Type Motor

Area Check

FI Card

Q-Gate

Qty Item Check

No Repair

Repair Inline

Repair Outline

Judgement

OK

NG

Notifikasi Keberhasilan/Kegagalan Proses

Scanning

Verifikasi Data

Display FI Card

MODEL

TANGGAL

FINAL INSPECTION SHEET

AHM

Engine Number

KYH02N14S2 AJT

MH1KF1121HK216236

STAGE 1

STAGE 2

STAGE 3

STAGE 4

Image

Media Item

Inspection Item

Judgment

Remarks

1

2

3

4

5

6

7

8

9

10

Produksi

Detail Produksi

Revisi

Revisi

Revisi

Proses kerja :

1. Klik Start → Mentrigger scanner untuk menarik kertas FI Card
2. Scanner membaca barcode Frame untuk menjadi inputan kolom Nomor Frame
3. Proses scan FI Card
4. Verifikasi value FI Card (Final Inspection dan Q-Gate)
 - > Final Inspection : - Kode Operator harus terisi
 - Kolom judgment (I/X)
 - > Q-Gate : - Kolom Judgemnt (I/O/X)
5. Jika ada temuan repair inline maupun outline
 - > Final Inspection : - Menarik data trx Final Inspection
 - > Q-Gate : - Input Symptom Manual
6. Judgement GDP : - OK : *Tanpa ada temuan repair outline
- NG : *Ada temuan repair outline
7. Jika semua data sudah sesuai klik Enter untuk menyimpan data dan dokumen FI Card.Pdf dengan identitas No Frame
8. Muncul notifikasi keberhasilan proses
9. Jika ada data yang tidak sesuai maka klik Retry untuk memproses ulang sekaligus reset data.
10. Jika ada konten yang belum terisi muncul notifikasi dan menggagalkan proses verifikasi.

Jika ditemukan NG Q-Gate

ID	Area Repair	Point Check	Symptom	Select
L1.1	Outline	Stay Cover Under	LM. Stay Cover Under Las minus	<input checked="" type="checkbox"/>
			BK. Stay Cover Under Bengkok	<input type="checkbox"/>
			TT. Stay Cover Under Tidak	<input type="checkbox"/>
			PTH. Stay Cover Under Patah	<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>
				<input type="checkbox"/>

Proses kerja :

1. Pilih satu symptom yang sesuai (Pilihan lain langsung terlock)
2. Klik Submit untuk kembali ke halaman utama



Storing FI Card

Kode Plant: 1700 Kode Line: 7AUA Kode WCT: P7AUA0

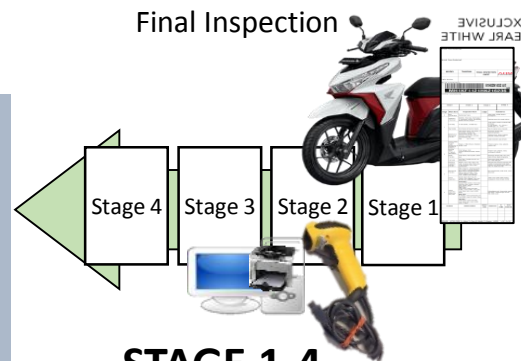
Kode Operator: XXXXX
Nama Operator:
Nomor Frame*:
Type:

NomorFrame:
Type Motor:
Area Check:

Qty Item Check:
OK (No Repair):
NG (Repair InLine):
NG (Repair Outline):
Judgement:

Notifikasi Keberhasilan/ Kegagalan Proses

Scanning → Verifikasi Data → Display FI Card



STAGE 1-4

Input data Inspection System dan Manual

STAGE 4

Scan In Shipping



Scan Turun Unit

Monitoring FI Card																	
Monitoringing	LOV (GDP/FI CARD)																
Date (Date & Time)	From	To															
Tag Frame			Plant_ID	WCT_ID	Tgl Produksi	Waktu	Type	No Frame	No Engine	Status Unit	Tgl Scan FI Card	Waktu	Status FI Card	Path Preview	Area Temuan	Area Perbaikan	Symptom
Tag Engine			1700	P7AUA0	08-Sep-17	10.35.30	MHXXXX	JFXXX		Scan Turun/ Stage FI/ In Shipping	08-Sep-17	10.37.00	OK/NG/Belum Scan	.pdf	Q-Gate/Stage FI	In Line/out Line	Status CBU Check
WCT_ID	LOV																
Plant ID	Based On WCT-ID																
Type																	
Status	OK/NG/Belum Scan/All																

- Unit motor yang belum terscan FI cardnya secara otomatis :
→ Data akan ternotifikasi ke PIC,Kasie,CC : Manager (By Email) → Akhir Shift

Monitoring Progress FI Card

[illegible]

- ➔ GDP > Parameter search berdasarkan time storing FI Card
Untuk cetak Feed Back dan FI Card,
- ➔ FI Card > Parameter search berdasarkan time produksi unit
Untuk monitoring progress storing FI Card.

Cetak Feed Back

REMARK : ACTION CODE : A = Adjust, C = Clean, M = Modify, R = Replace JUDGE : ✓ = OK, X = NG
Basismen & Final Inspector = Tulis NBB

Monitoring Pencapaian GDP

Monitoring Straight Pass Assembly

ahmmosfc155b01 USER PRODUKSI PLANT 4



* Category U - UNIT MOTOR

* Transaction R - ROYAL STRAIGHT PASS

* Date From 01-Nov-2017

* Date To 01-Nov-2017

Shift Id

Plant Id 1700 - Plant Karawang

Line Id

Line Desc.

M/C Type Id

M/C Type Desc.

View Detach

#	Plant Id	Line Id	Shift Id	M/C Type Id	Straightpass Qty	Production Qty	Straightpass %
1	1700	7AUA	1	GZ2	99	100	99
2	1700	7AUA	1	GZ3	1,078	1,100	98
3	1700	7AUA	2	GZ3	793	800	99.12
4	1700	7AUA	2	HA3	195	200	97.5
5	1700	7AUB	1	HK2	100	100	100
6	1700	7AUB	2	HK2	99	100	99
7	1700	7AUB	1	HL4	1,103	1,120	98.48
8	1700	7AUB	2	HL4	818	830	98.55
9	1700	7AUB	2	HM3	95	100	95

Summary

Straightpass Qty 4,380
Production Qty 4,450
Straightpass % 98.43



Monitoring Straigh pass dan GDP Assembly

ahmmosfc155b01

*Category Lov Unit/Engine
*Transaction Lov RSP,FSP,GDP
*Date From To
Time From To
Shift Id
Plant Id Lov
Line Id
Line Desc Mandatory
M/C Type Id
M/C Type Desc. Mandatory


No	Plant Id	Line ID	Export to excel	M/C Type Id	GDP Qty	Production Qty	GDP %
1	1100	P1AUA0		GZ2	850	1000	85%

Summary

GDP Qty 850
Production Qty 1000
GDP % 85%

ENGINE NO. :

TAG INSPECTION CARD
K81- PH


 ASTRA HMM

PRODUCTION DATE :

PROCESS INSPECTION

FINAL INSPECTION STAGE 4

NO	QUALITY RATE	INSPECTION ITEM	REMARK	NO	STAGE	INSPECTION ITEM	REMARK
1	Q-CATE 1	NUMBERING FRONT BODY SETTING TYPE AND UNIT MOTOR SERVING AND/OF CASE STAGE		4	STAGE 4	COVER HANDLE FRONT FRONT TOP COVER FRONT COVER REAR LIGHT COVER BODY R COVER BODY L	
2	Q-CATE 1	BARCODE, TAG NUMBER & REAR FRONT SETTING SCREW BALL U LOCK KEY SET SETTING HOSE COMP FUEL LINE					CHECKED BY
3	Q-CATE 0	INSULATING LINER HANDLE VS FRAME TURQUOISE LINER ENGINE HANDLE VS FRAME TURQUOISE WELT WIPPER INSULATING HANDLES WIRE					
4	Q-CATE 4	INSULATING SUB HANDLES ENGINE INSULATING SUB HANDLES PHOSPHORITE TURQUOISE NOT THROTTLE COMP A CABLE (UNDER) TURQUOISE NOT THROTTLE COMP B CABLE (UNDER)		5	PAGE 5	LINEAL TEST DRAIN LEAKS ACCELERATOR NOTICE ENGINE JULGUNG STOP SYSTEM GOLF RODS VISUAL CHECK AIR FILTER BRAKE SHOCK MATCH STEERING FRONT COVER REAR LIGHT MATCH STEERING COVER BODY & L TAIL LIGHT	REMARK
5	Q-CATE 1	INSULATING THROTTLE COMP A CABLE INSULATING THROTTLE COMP B CABLE INSULATING REAR BRAKE CABLE					
6	Q-CATE 1	INSULATING FRONT BRAKE CABLE TURQUOISE NOT 10 5 STEERING HANDLE INSULATING FRAME EXCHANGING CABLE INSULATING COIL COMP IGNITION CABLE TURQUOISE COIL COMP IGNITION (R)					
6	Q-CATE 1	REAR LIGHT GRIP THROTTLES TURQUOISE NOT THROTTLE COMP A CABLE (UPPER) TURQUOISE NOT THROTTLE COMP B CABLE (UPPER) STEERING SHIFTER SETTING OIL TEMPERATURE SENSOR INSULATING ENGINE GROUNDING CABLE INSULATING TUBE JAWAN FUEL TURQUOISE COIL FUEL CUMULON (L)					
7	Q-CATE 1	SETTING SECOND COIL IGNITION PANEL DRIVE CAUTION AIR/FUEL INFORMATION					

FINAL INSPECTION STAGE 1 ~ 3			
NO	STAGE	INSPECTION ITEM	REMARK
1	STAGE 1	FRONT BRAKE & REAR BRAKE BRAKE FUNCTION HANDLE LOCK KEY BRAKE SHOCK	
2	STAGE 2	SEAT STARTER SLANG STOP SYSTEM OIL REAR PHOSPHORITE ENGINE NOISE WHEEL & REAR WHEEL SIDE STAND	
3	STAGE 3	MAIN STAND BRAKE & REAR LOCK LOCK DOUBLE SEAT FUNCTION UNDER DOUBLE SEAT (PART L & RABLE)	

PACKAGING INSPECTION			
NO	STATION	INSPECTION ITEM	REMARK
1	STATION 10	PACKET/FIN FINISHING CHUSON BERBER DARI OLI PACKET/FIN CHUSON BULI 500 GRU SUGAR PERMANGAS DARI SUGAR DI MARKING	
2	STATION 20	PACKET/FIN FINISHING CHUSON BERBER DARI OLI PACKET/FIN CHUSON BERBER 500 GRU SUGAR PERMANGAS DARI SUGAR DI MARKING	

CRATE INSPECTION			
NO	STATION	INSPECTION ITEM	REMARK
1	STATION 10	CLAMP LOCK CASE LOCK TIGHTEN ANGLES	
		FOSSIL UNIT KELIPANGKARAN BATTERY DEKORASI GARDER	

<input checked="" type="checkbox"/>	OK CHECK
<input checked="" type="checkbox"/>	ANY FINDING, NOT YET REPORT
<input checked="" type="checkbox"/>	ANY FINDING, ALREADY REPORT

APPROVED BY
 DEPARTMENT HEAD QP 3

Requirement Project

- CT Proses normal max 15 Detik
- CT Proses + Input symptom max 20 Detik
- Membutuhkan 1 Unit Highspeed Scanner
- Duplex
- Produksi unit /Line : min: 2200, max : 3000/day
- Membaca Barcode 2D

NO	Control Item	2017			2018																							
		Oct	Nov	Dec	Jan				Feb				Mar				Apr				May				Jun			
					1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4
1	Detil Konsep	▲	▲	▲																								
2	Multisourcing																											
	Anwizjing					▲																						
	Propose and Solution																											
	Kontrak																											
	MHRM																											
	PR dan PO																											
3	Aplication Development																											
4	Testing Aplication																											
5	Preparation dan sosialisasi P4																											
6	Operational																											
7	Post Go Live																											

THANK YOU