



TOYOTA
INDONESIA

QCC PAD

Logistic Operation



Handling



Supply



Fill - in



CAHYA T K L

09709655



Filosofi Rumah,
yang mengajarkan
saat membentuk
sebuah kenyamanan harus
melibatkan semua aspek
yang ada di dalamnya.

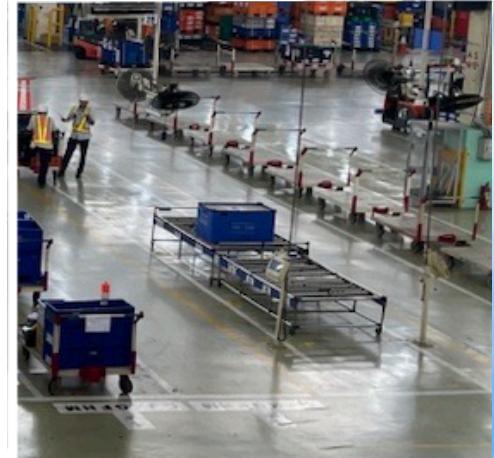


Menuju Era Elektrifikasi 2025

Mari kita perkuat pondasi dasar kita dengan
meningkatkan kenyamanan bekerja melalui
pendekatan digitalisasi dan otomasi.

Harmonis

4. Attitude *bagaikan Pondasinya, yang mampu Mengokohkan rumah dari guncangan.*



Area Kerja



Covering Area PAD Log Unit Plant

Covering Area PAD Log Krw Vehicle Plant

Press	Welding	Toso	Assy	Delivery
Log			Log	

Struktur Promotor



DpH LOD

9 Advisor

25 Facilitator

33 Group QCC

318 Member

A1 Red	A1 White	W Red	W White	A2 Red	A1 Eng	A2 White	W Eng	A2 Eng
4 Fcl	4 Fcl	3 Fcl	3 Fcl	4 Fcl	1 Fcl	4 Fcl	1 Fcl	1 Fcl
6 Grp	6 Grp	3 Grp	3 Grp	6 Grp	1 Grp	6 Grp	1 Grp	1 Grp



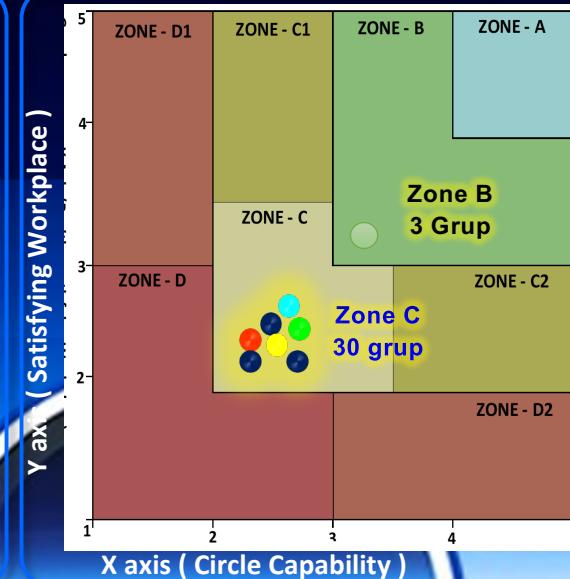
QCC MILESTONE LOGISTIC



Division Hoshin

FY23/24 DIVISION Strategic Execution Plan (Sort by Priority - Strength & Innovative Activity)									
KARAKTERISASI PAD MISSION : To realize Best Safety, Productivity & RW Cost Achievement (Flexibility & Agility towards Future Transformation)									
3rd Challenge for Future ① Safety & Health : Prev action by Human Dev & Henkoten Mgt. Awareness ② Environment: Carbon Neutral ③ Productivity : Built EV with best competitive productivity									
2nd Real Competitiveness ① Safety : Safety culture & awareness through SGA in daily activity ② Environment: Green technology equipment ③ Productivity : Expansion PEF for all direct labor, RMC from AP									
1st Survival Period ① Safety : "0" Accident, No retrace area, Strong Communication, Enployee working environment ② Environment: Simple Improvement & minimizes to energy ③ Productivity : Achieve Puff 10R, STI score function activity & reduce similar job									
Manufacturing Result Item No. Item Name FY23/24 KPI & Target Strategic Execution FY23/24 KPI & Target Init. In Charge Resources Budget Mfg. Eng. Inv. Expenses									
Focus 0. Maintain & Strengthen the Company Basic Foundation & Comprehensiveness 1. [1-4] Strengthening basic foundation to support interconnected safety culture by level up safety management system & preventive safety activities 1.1 Case Total traffic, Remote area, High border (origin) & destination area, safety does for newAP, WHSA for CL, HQ for license 1.2 Improve ETC performance by reduce delay ticket & safety gate time 1.3 Enhances awareness map in traffic by promotion activity & routine checking activity 1.4 Enhances contractor capacity through KPI review & direct coaching activity									
2. [1a-3] Stick to the delivery one by one and promote the speedy off-line vehicle eng. ETDA/Hr = 100% ETDA/Hr = 90% 2.1 Improve ETC performance by reduce delay ticket & safety gate time 2.2 Improve to end part assessment monitoring to Maximize Data Delivery (D2) performance									
3. [1a-4] Strengthening shop floor foundation people development 3.1 Other pilot line each area (Pilot Line 1, Pilot Line 2, Staff 1, Staff 2, TPS 1, 4th dev, IMP) 3.1.1 Optimize ETC performance by reduce delay ticket & safety gate time 3.1.2 Continuously develop people through cross TPS APD Level 3 - TPS KPI Level 4 3.2 Continuously develop people through cross TPS APD Level 3 - TPS KPI Level 4									
4. [1a-3] Properly identify and handle risk factors to increase robustness of risk opportunity and maintain compliance with regulations & adherence comp., to maintain stable labor relation 4.1 Properly identify and handle risk factors to increase robustness of risk opportunity and maintain compliance with regulations & adherence comp., to maintain stable labor relation									

Current Condition Assesment



30 Grup Masih di Zona C

X - Axis Circle
Capability <2,8>

Y – Axis Satisfy
Workplace <2,8>

QCC Step
Solving

Teamwork

Leadership

Motivation

QCC Tools

Komunikasi

Multiple Skill

Meeting QCC

Kaizen
Method

Safety Rule

Strategy

Strengthening Shopfloor Management to Ensure
QCC Circumstances Being Achievable

2021

2022

2023

2024

Activity

Remote
Improvement
During Pandemic

Promote QCC, SS
Activities with 4S
as Fundamental

SR Expansion
through
Digitalization and
Automation

Logistic Flexibility
Facing Electrical
Era

Synergize DX with Labor Relationship

2025

Electrification Era

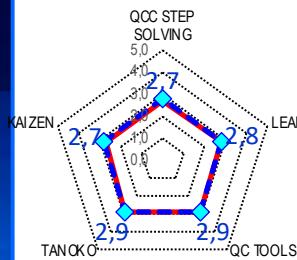
Connectivity and
Low Logistics
Cost on Digital
Era

Setting target

Strategy

Action

Focus Point X - AXIS Circle Capability



**Target Level Up X-a & X-b
(Qcc Step Solving & Kaizen Method)**

2,7 & 2,7 => 2,8

X-axis

- Meningkatkan pemahaman G-QCC step solving ke semua CL & Thema leader.
- Meningkatkan Kaizen Method semua CL.

1 Diskusi dengan sekretariat QCC Divisi & semua advisor terkait kondisi aktifitas QCC di PAD



3 Training G-QCC untuk semua tema leader (Jun-Jul 2023)



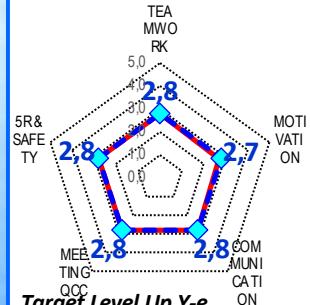
2 All CL training internal dengan trainer dari Welding Divisi atas rekomendasi dari TIA, (Bapak Samarkandi)



4 Menghidupkan kembali LINE IDEA, QCC & SAFETY setelah pandemi



Focus Point Y - AXIS Satisfying Workplace



**Target Level Up Y-e
(Motivation)**

2,7 => 2,8

Y-axis

- Absorb MEMBER VOICE for Enjoyable Workspace.

1 Follow aktifitas QCC grup KALORI, karena tema yang diambilnya berkaitan dengan Member Voice untuk menciptakan Enjoyable Workspace.



2 Support realisasi member voice (shutter, dolly transfer, etc), agar kendala yang menyusahkan proses member dan menyebabkan members cedera bisa dihindari.

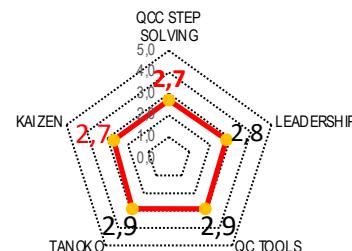


Result

- 1). All Circle leader & thema leader paham tentang G-QCC
- 2). All CL & thema leader tahu tugas & perannya di QCC
- 3). Pemahaman G-QCC teraplikasikan
- 4). Komunikasi semua level terjalin dengan baik
- 5). Penerapan Kaizen method
- 6). Pencapaian step QCC ter-follow

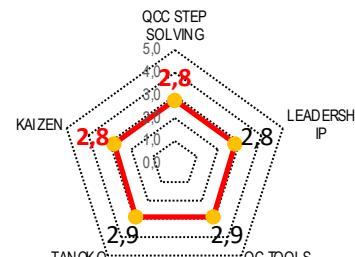
Before

Circle Capability

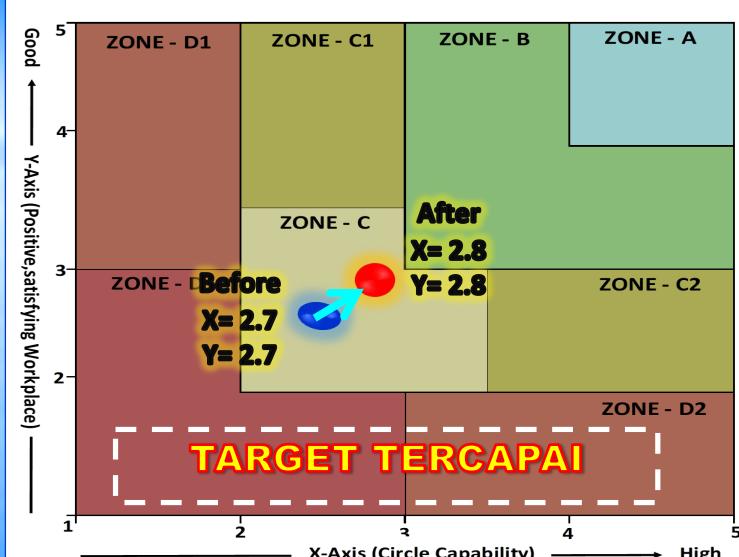


After

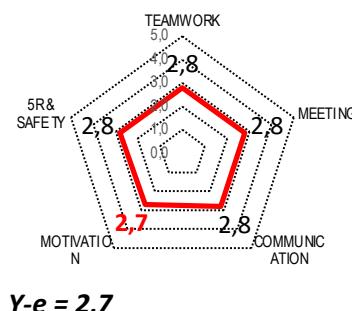
Circle Capability



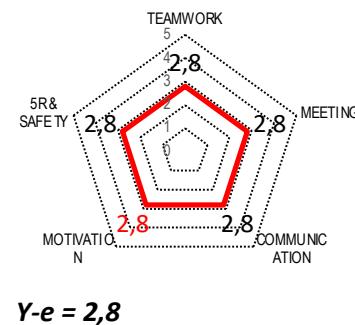
Level assesment all group Jul 2023



Satisfying workplace



Satisfying workplace



Untuk aktifitas Absorb **MEMBER VOICE**
 (Menurunkan Cycle Time Proses Unpacking I)
 Akan dipresentasikan detail oleh grup **QCC KALORI**.



LOGISTIC OPERATION



Struktur Organisasi

Nama Group : KALORI
Dibentuk : 10 Jan 2014
Kehadiran : 100 %
Tema Ke : 5

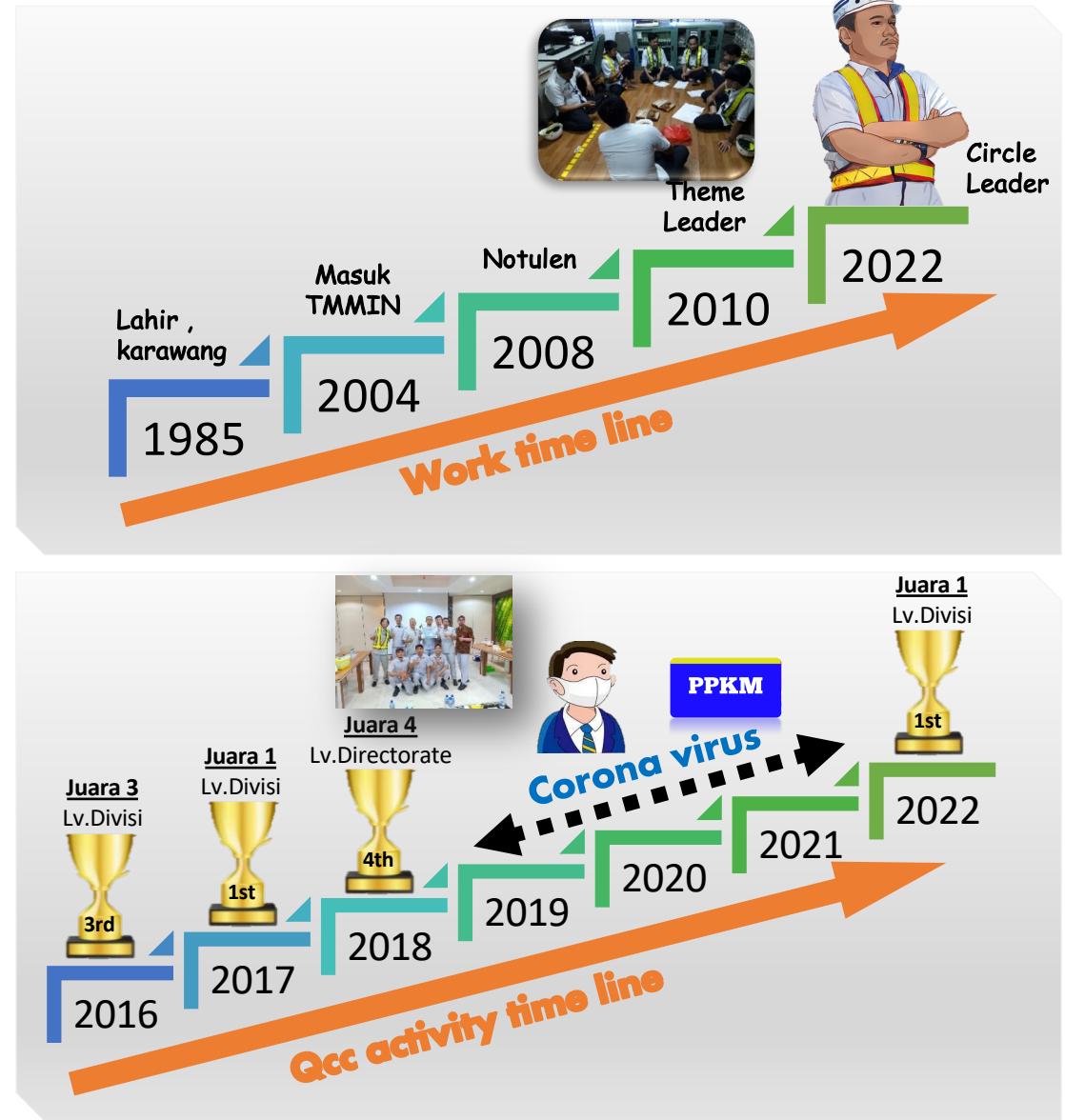
Member





KARYADI

LAHIR : KARAWANG , 21 September 1985





FILOSOFI SEMUT

MAKNA FILOSOFI CIRCLE LEADER :

*"Seorang circle Leader harus mampu "**bekerja sama** dan **saling tolong menolong dalam segala situasi** serta **menghormati tanpa membedakan status.**"*

GOAL SAYA SEBAGAI SEORANG LEADER

4 LEAD :



1. Loyalty, Seorang leader harus bisa membangkitkan dan memberikan loyalitasnya terhadap rekannya



2. Educate, Seorang leader harus mampu mengedukasi dan memberikan knowledge terhadap rekannya



3. Advice, Seorang leader harus mampu memberikan saran dan nasehat dari problem yang ada



4. Disiplin, Seorang Leader harus mampu memberikan keteladanan di setiap aktivitas



ASSESSMENT LEVEL CIRCLE LEADER

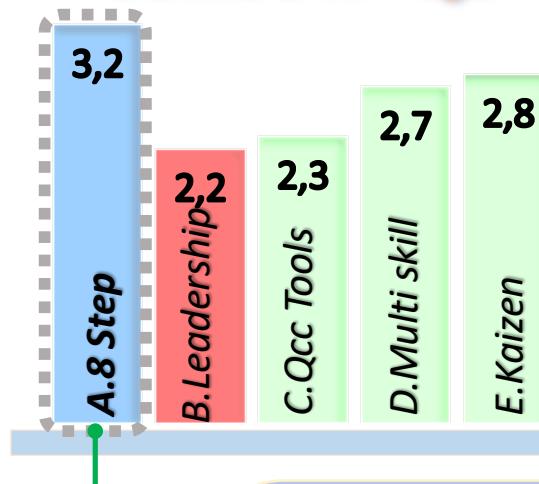
CIRCLE LEADER
MR.KARYADI



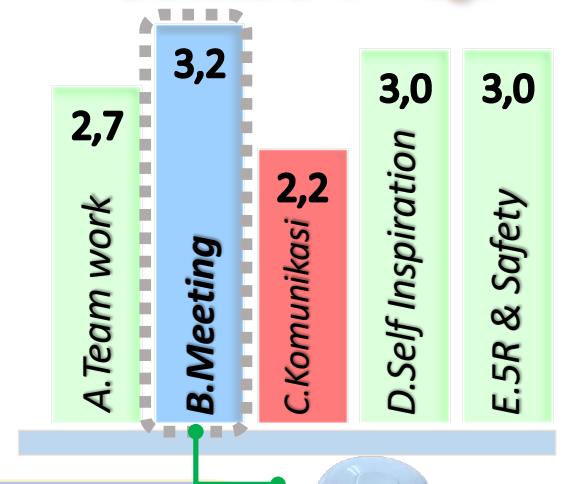
"Assesment oleh facilitator"



SUMBU X = 2,6



SUMBU Y = 2,7



STRONG POINT :

"Pengalaman saya di training G-QCC

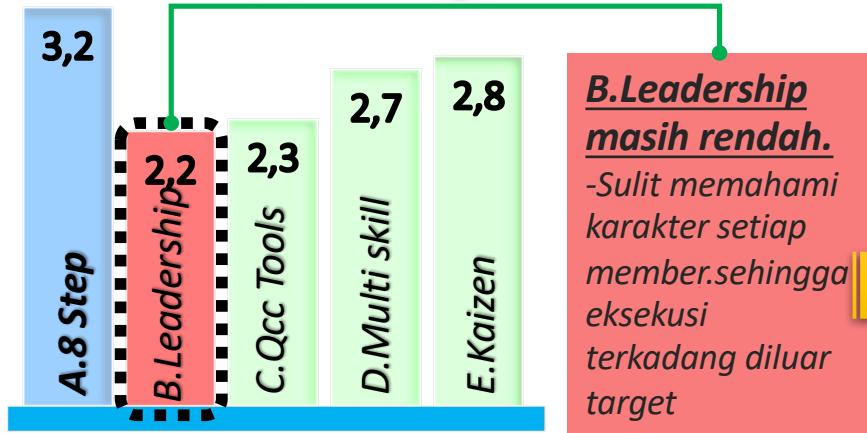
adalah bekal saya untuk development member...!!!"



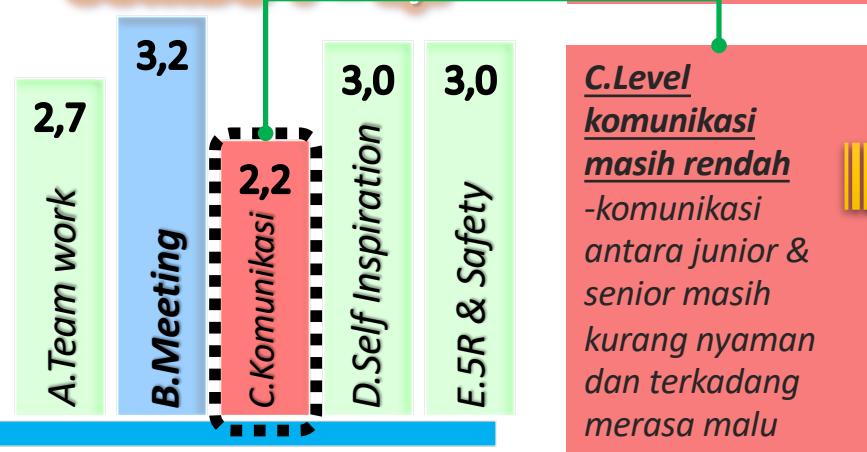


WEAKNESS POINT :

SUMBU X = 2,6



SUMBU Y = 2,7



STRATEGY:



Menjadi Leader di activity 4S



Menjadi Delegasi activity ke supplier

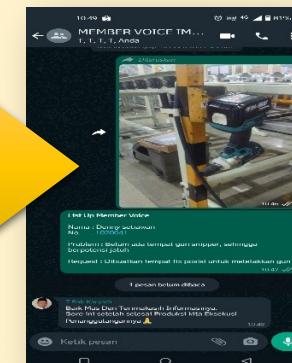


"Evaluasi oleh facilitator"

'Hasilnya cukup memuaskan,pak Karyadi siap Development members'



SAYA SIAP MEMBAWA KALORI JUARA.. JOSHH!!!

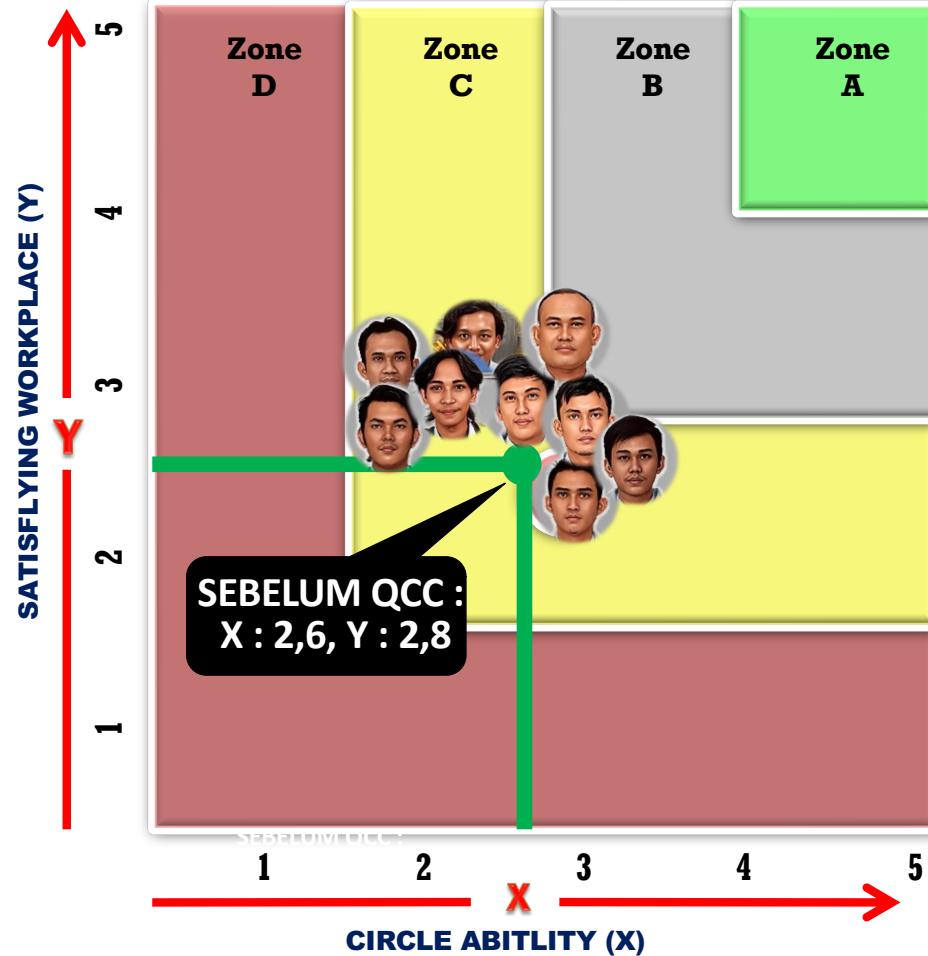


Member voice digital via WA



Meningkatkan public speaking di setiap event

CONDITION ASSESSMENT BEFORE QCC (STRONG POINT)



Level Assesment Group

Member KALORI	SUMBU X					AVE SUMBU X	ZON E	AVE SUMBU Y	SUMBU Y				
	A.8 Step Solving	B.Leadership	C.Qcc Tools	D.Multi skill	E.Kaizen				A	B	C	D	E
Karyadi	4	3	3	3	3	3,2	B	3,2	3	4	3	3	3
Andri	4	3	3	3	3	3,2	B	3,2	3	4	3	3	3
Roni A.	3	2	2	2	3	2,4	C	2,6	2	3	2	3	3
Aldi S.	3	2	2	3	3	2,6	C	2,8	3	3	2	3	3
Dimas R.	3	2	2	1	3	2,2	C	2,6	2	3	2	3	3
Kurnadi	3	2	2	3	3	2,6	C	2,8	3	3	2	3	3
Giras CK.	3	2	2	3	2	2,4	C	2,8	3	3	2	3	3
Denny.s	3	2	3	3	3	2,8	C	2,8	3	3	2	3	3
Ardika	3	2	2	3	2	2,4	C	2,4	1	3	2	3	3
AVE GROUP	3,2	2,2	2,3	2,7	2,8	2,6		2,8	2,6	3,2	2,2	3,0	3,0

STRONG POINT SUMBU X

"Kemampuan Menyelesaikan 8 Step solving tinggi"

- 1 Training G-QCC untuk semua anggota (Jun-Jul 2023)



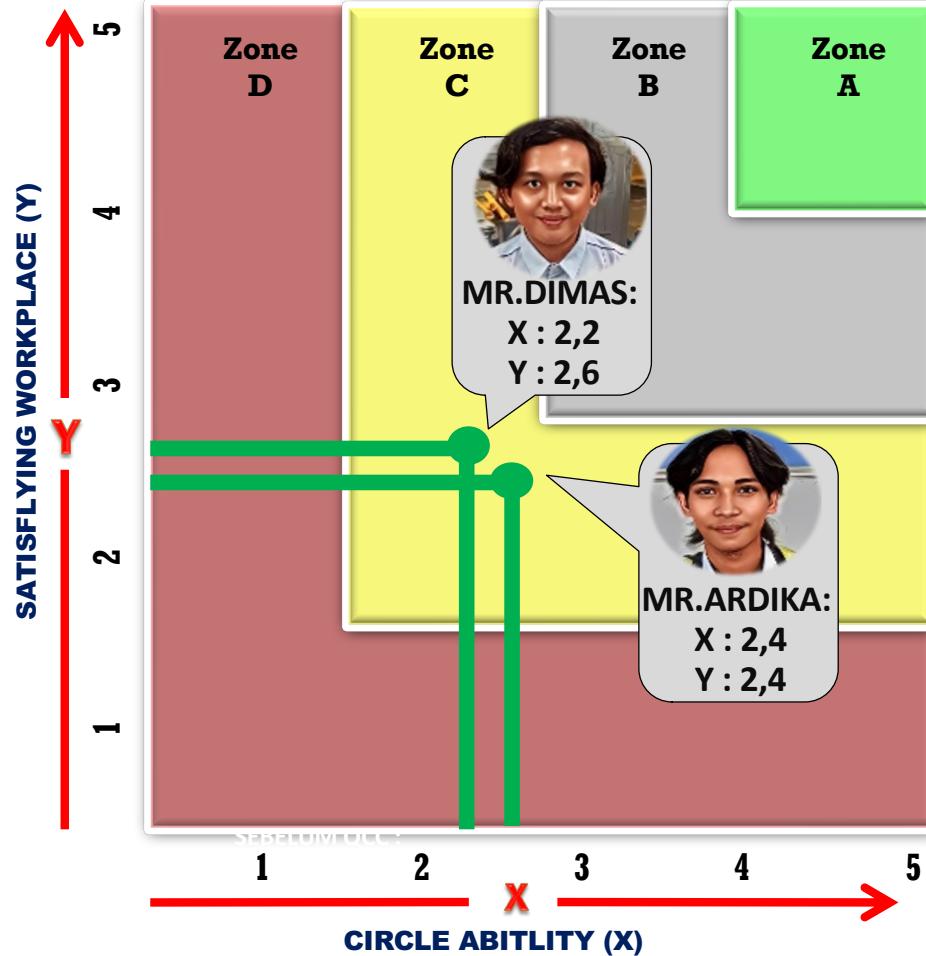
STRONG POINT SUMBU Y

"Antusias tehadap meeting tinggi"

- 1 Olahraga bersama setiap hari sabtu



CONDITION ASSESSMENT BEFORE QCC (WEAKNESS POINT)



Level Assesment Group

Member KALORI	SUMBU X					AVE SUMBU X	ZON E	AVE SUMBU Y	SUMBU Y				
	A.8 Step Solving	B.Leadership	C.Qcc Tools	D.Mutiskill	E.Kaizen				A.Team work	B.Meeting	C.Komunikasi	D.Self Inspiration	E.5R & safety
Karyadi	4	3	3	3	3	3,2	B	3,2	3	4	3	3	3
Andri	4	3	3	3	3	3,2	B	3,2	3	4	3	3	3
Roni A.	3	2	2	2	3	2,4	C	2,6	2	3	2	3	3
Aldi S.	3	2	2	2	3	2,6	C	2,8	3	3	2	3	3
Dimas R.	3	2	2	2	3	2,4	C	2,6	2	3	2	3	3
Kurnadi	3	2	2	3	3	2,6	C	2,8	3	3	2	3	3
Giras CK.	3	2	2	3	2	2,4	C	2,8	3	3	2	3	3
Denny.s	3	2	3	3	3	2,8	C	2,8	3	3	2	3	3
Ardika	3	2	2	3	2	2,4	C	2,6	2	3	2	3	3
AVE GROUP	3,2	2,2	2,3	2,8	2,8	2,7		2,8	2,7	3,2	2,2	3,0	3,0

WEAKNESS POINT SUMBU X

"Sumbu X Mr.Dimas **MULTISKILL** masih rendah"

"Mr.Dimas Member baru di Import (Dampak Rotasi structural reform)."

NAMA	JOB 1	JOB 2	JOB 3	JOB 4	JOB 5	JOB 6	JOB 7
Dimas Dicky R.	⊕	⊕	⊕	⊕	⊕	⊕	⊖

Tanoko Dimas baru menguasai 1 Job

WEAKNESS POINT SUMBU Y

"Sumbu Y Mr.Ardika TEAMWORK Masih rendah"

"Mr.Ardika kurang peduli dengan area kerja nya sendiri"



Kondisi 5R buruk di area kerja



ROAD MAP DEVELOPMENT PROGRESS

1

PROBLEM SUMBU X

Member baru di line Import,belum pengalaman menghadapi situasi di lapangan



Mr. Dimas

NAMA	JOB 1	JOB 2	JOB 3	JOB 4	JOB 5	JOB 6	JOB 7
	OPERATION IPMS & ISS	DMC, CSC & SNQR	DEVANING	STAFFING & RECEIVING	TAPPING PARTS	REPACKING & OVERFLOW	AUTO SORTING BY CONVEYOR 1
Dimas Dicky R.	⊕	⊕	⊕	⊕	⊕	⊕	●

2

STRATEGY

PLANNING ROTASI
MULTI SKILL WORK



3

EKSEKUSI



Rotasi job di lakukan rutin selama 2 bulan sekali

4

EVALUASI



Mr dimas memahami proses barunya dengan pendampingan cicle leader

Dengan METODE
TJI ,Mr Dimas
lebih cepat
memahami
pekerjaannya





ROAD MAP DEVELOPMENT PROGRESS

1

PROBLEM SUMBU Y



Mr. Ardika

Mr. Ardika masih kurang peduli dengan area kerjanya



Kondisi 5R buruk di area kerja

2

STRATEGY



Dengan bekal 4S & improvement yang saya miliki saya akan merubah Mr. Ardika

3

EKSEKUSI



1. Melibatkan Mr. Ardika dalam Improvement



2. Melibatkan Mr. Ardika dalam 4S

4

EVALUASI



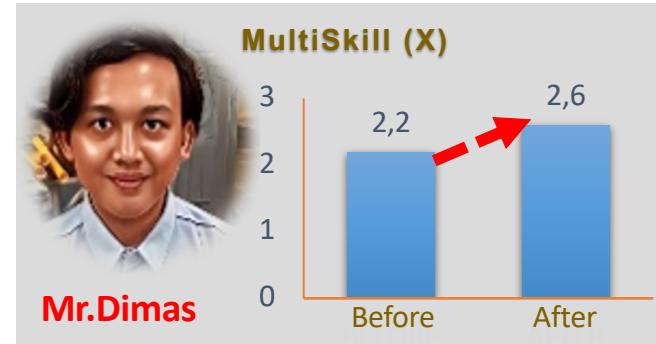
Mr. Ardika lebih solid terhadap rekan kerjanya.

4S Bronze dapat dicapai..!!!!

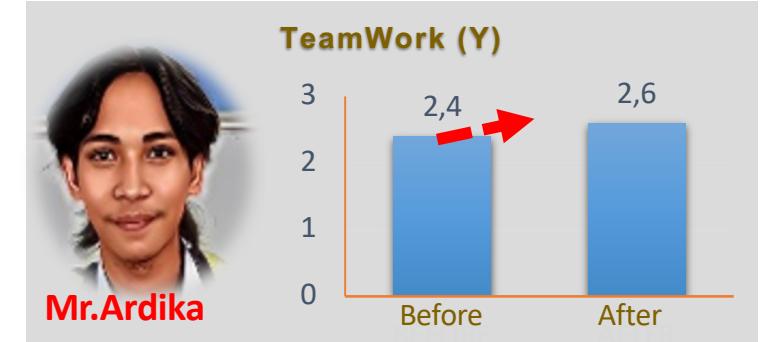


EVALUASI HASIL

RESULT DEVELOPMENT



Mr.Dimas Multi skill Naik menjadi 2,6



Mr.Ardika Team work Naik menjadi 2,6





PERKENALAN



KALORI

Kami Logistic RED Import P#2



STEP 01. PEMILIHAN THEMA

List Up problem berdasarkan member voice

No	Tema di usulkan (Member Voice)	PIC	Point untuk pemilihan tema					Total Point	Priority Rank
			Kesulitan pekerjaan	Kemungkinan di selesaikan	Waktu penggerjaan	Dampak ke next proses	Benefit		
1	Mengantri pengisian BBM Pertamax	Giras	2	2	2	1	2	8	VI
2	Waktu proses unpacking lama	Ardika	3	3	2	3	3	14	I
3	Sulit mencari part yang akan di tapping pada module	Aldy	3	3	2	3	2	13	II
4	Manufer forklift sempit di area Devaning	Kurnadi	2	3	2	1	2	10	V
5	Lama proses kalkulasi data IPSS	Roni A.	2	3	2	3	2	12	III
6	Handle box kardus rusak	Dimas	3	3	2	1	2	11	IV

Thema : **MENURUNKAN WAKTU UNPACKING LAMA**

Keterangan :

Kesulitan pekerjaan	Kemungkinan diselesaikan	Waktu penggerjaan	Dampak ke next prosess	Benefit
1. Problem mudah	1.Tidak bisa	1. >6 bulan	1.Tidak ada	1. <1 jt
2. Problem sedang	2.Butuh bantuan	2. 4–6 bulan	2.Criple	2.1-5 jt
3. Problem sulit	3.Bisa	3. 1-4 bulan	3.Line stop	3.>5 jt



AKTIFITAS

Circle Activity



Circle Leader
Karyadi

No.	Aktivity Circle Leader	PIC	May-22	Jun-22	Jul-22	Aug-22	Sep-22	Oct-22	Nov-22	Dec-22	Jan-23	Feb-23	Mar-23	Apr-23
1	Mengetahui Kondisi Group	Karyadi (Circle Leader)												
2	Tentukan Target													
3	Buat Strategi													
4	Eksekusi													
5	Evaluasi & Follow Up													

No.	Aktivity Circle Leader	PIC	May-22	Jun-22	Jul-22	Aug-22	Sep-22	Oct-22	Nov-22	Dec-22	Jan-23	Feb-23	Mar-23	Apr-23
Step 0-1	Pemilihan Tema	Andri												
Step 0-2	Perencanaan Aktivitas	Aldy S.												
Step 1	Klarifikasi Masalah	Karyadi												
Step 2	Analisa Kondisi Yang Ada	Kurnadi												
Step 3	Penetapan Target	Denny S.												
Step 4	Analisa Sebab Akibat	Dimas												
Step 5	Rencana Penanggulangan	Giras CPK												
Step 6	Implementasi Penanggulangan	Andri												
Step 7	Evaluasi Hasil	Karyadi												
Step 8	Standarisasi & Tindak Lanjut	Denny S.												

: Planning

: Actual

Thema Activity



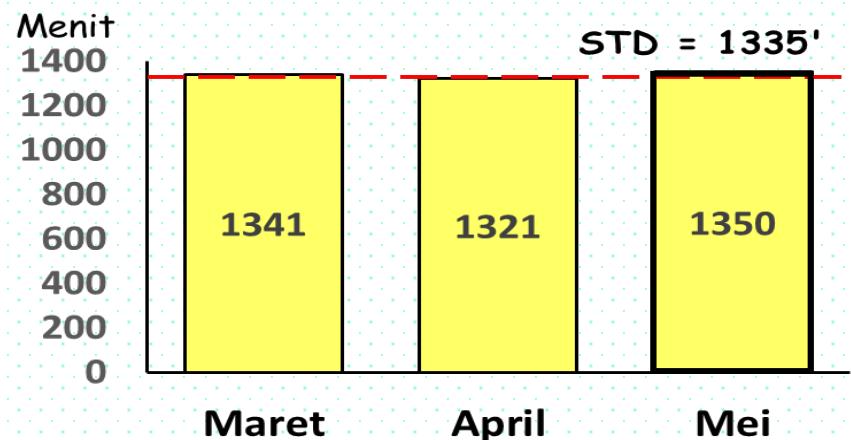
Thema
Leader
Andri



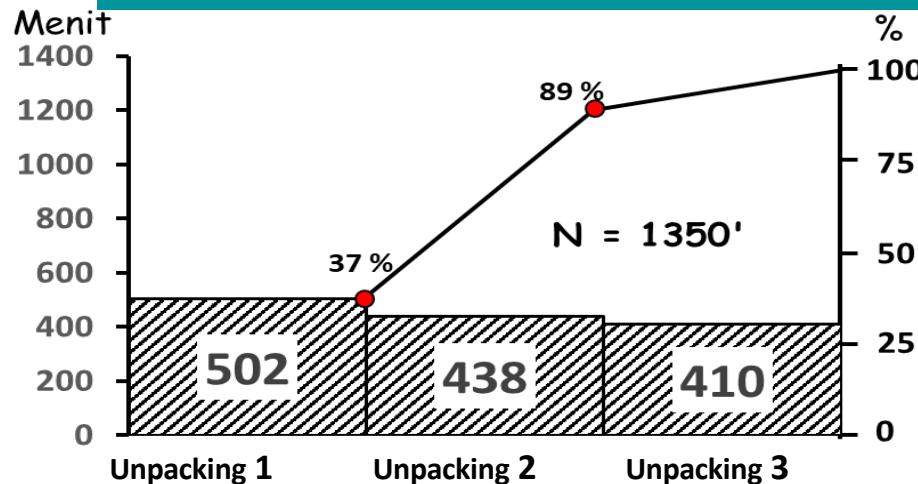
MASALAH



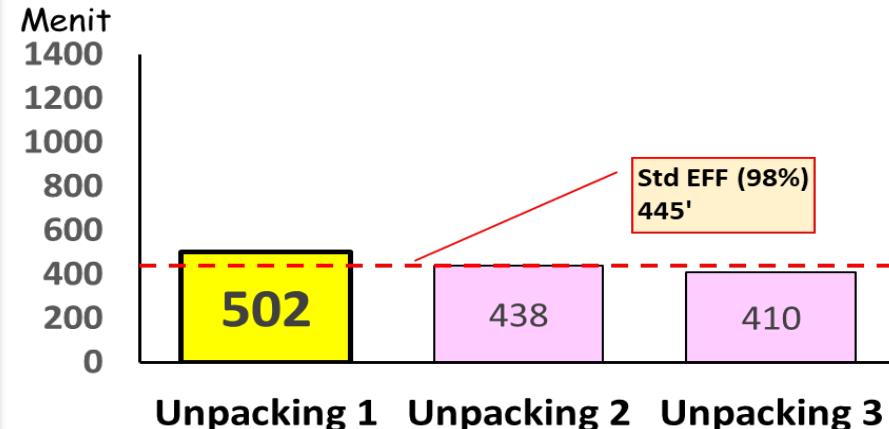
A. Waktu Unpacking Mar – Mei '22



C. Grafik pareto Unpacking 1



B. Grafik Unpacking per MP



Sub
Thema: MENURUNKAN
WAKTU UNPACKING
1 YANG TINGGI





Flow Prosess Import Part



Prosess Unpacking



Late Supply Part

Dampak Unpacking Delay

Line Stop

Criple

Delay Supply



**Waktu indent costumer
bertambah lama**



STEP 2. ANALISA KONDISI YANG ADA

FLOW Proses Unpacking

1

Angkat part
yang akan ditulisCompare part
dengan content
listTulis nomor cycle
& route supplyCoret
content listSupply part
ke shutter

Faktor 4M + 1E

No	Faktor	Control Item	Control Point	Ideal Condition	Actual Condition	Potensi
1	Man	MP	Knowledge	Tanoko 75%	Tanoko 75%	T.A
2	Machine	Content List	bahan kertas	Tidak mudah sobek	Tidak mudah sobek	T.A
3	Material	Box	Kondisi box	Box tidak rusak	Box tidak rusak	T.A
4	Methode	Akurasi	Cara compare	Mudah compare	Sulit compare	Ada
5	Envirotment	Pencahayaan	Luminasi (Lux)	+ - 300 Lux	+ - 300 Lux	T.A



**SULIT COMPARE
UNIQ PADA
CONTENT LIST VS
KANBAN**

Grafik compare part dengan content list

Tanggal observasi 8 Juni 2022

GAP : 18'





STEP 2. ANALISA KONDISI YANG ADA

FLOW Proses Unpacking

1

Angkat part
yang akan ditulisCompare part
dengan content
listTulis nomor cycle
& route supplyCoret
content listSupply part
ke shutter

Faktor 4M + 1E

No	Faktor	Control Item	Control Point	Ideal Condition	Actual Condition	Potensi
1	Man	MP	Knowledge	Tanoko 75%	Tanoko 75%	T.A
2	Machine	Dematograph	Bahan	Tidak mudah patah	Tidak mudah patah	T.A
3	Material	Box	Kondisi box	Box tidak rusak	Box tidak rusak	T.A
4	Methode	Content List	Proses tulis	Waktu tulis nomor cycle cepat	Waktu tulis nomor cycle lama	Ada
5	Envirotment	Pencahayaan	Luminasi (Lux)	+- 300 Lux	+- 300 Lux	T.A



**LAMA MENULIS
NOMOR CYCLE**

Grafik problem tulis nomor cycle & route supply





STEP 2. ANALISA KONDISI YANG ADA

FLOW Prosess Unpacking

1

Angkat part
yang akan ditulisCompare part
dengan content
listTulis nomor cycle &
route supplyCoret
content listSupply part
ke shutter

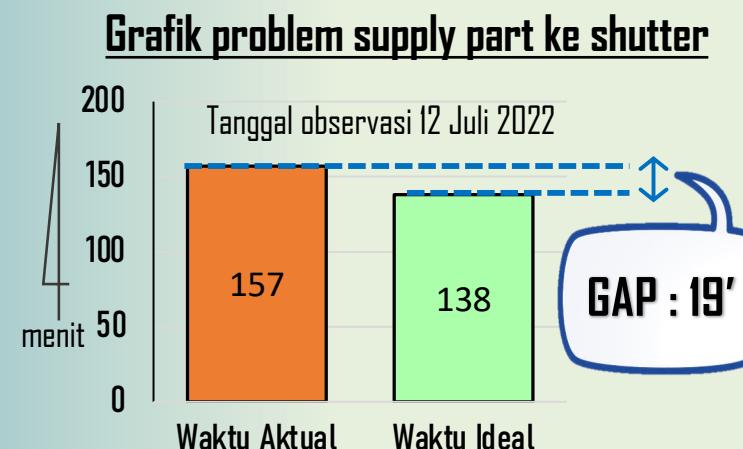
Faktor 4M + 1E

No	Faktor	Control Item	Control Point	Ideal Condition	Actual Condition	Potensi
1	Man	MP	Knowledge	Tanoko 75%	Tanoko 75%	T.A
2	Machine	Roller shutter	Kondisi roller	Tidak rusak	Tidak rusak	T.A
3	Material	Box	Kondisi box	Box tidak rusak	Box tidak rusak	T.A
4	Methode	Gentan-i	Methode Supply	Supply part ke shutter cepat	Supply part ke shutter lama	Ada
5	Envirotment	Pencahayaan	Luminasi (Lux)	+ - 300 Lux	+ - 300 Lux	T.A



LINE OFF	P-LANE	ANDON UNPACKING			TIME
116	08	NOW	NEXT	PROGRESS	10:51:12
		Module Code	PQ	Module Code	VB
		Module No.	PQ3366	Module No.	VB1565
		Rotary No.	#2	Rotary No.	#1
		Remaining CD	0	Remaining CD	12
				Efficiency	98%
				Target Produk	VB1565
				Status	DELAY

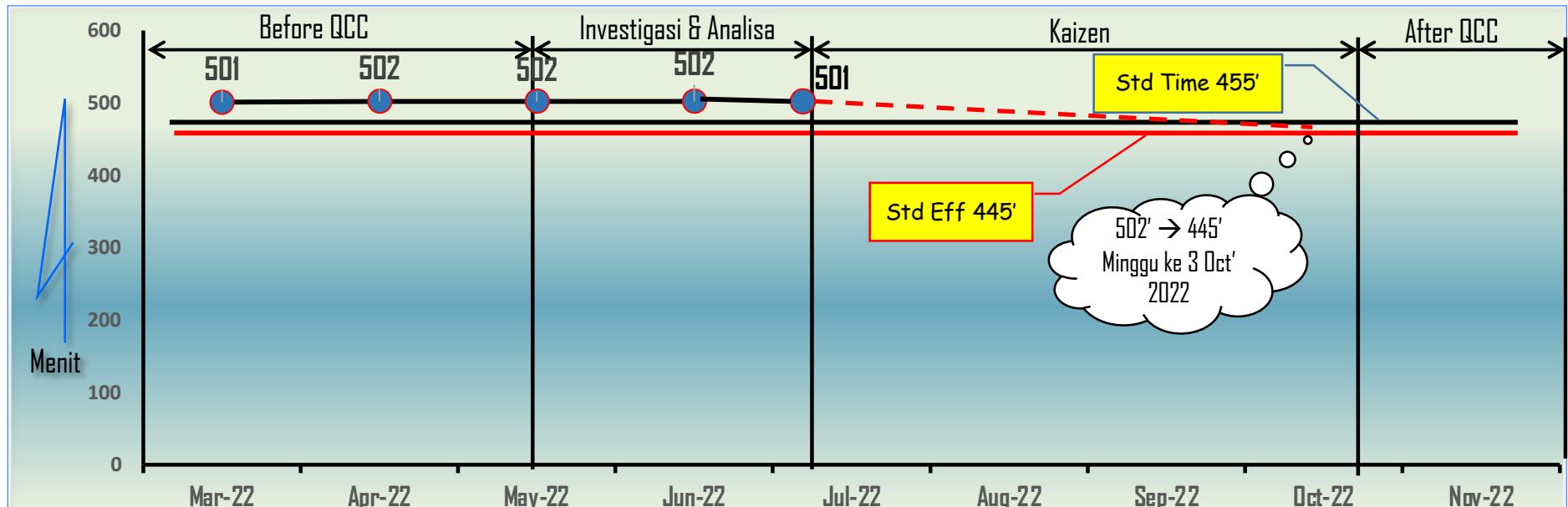
SUPPLY PART KE SHUTTER LAMA





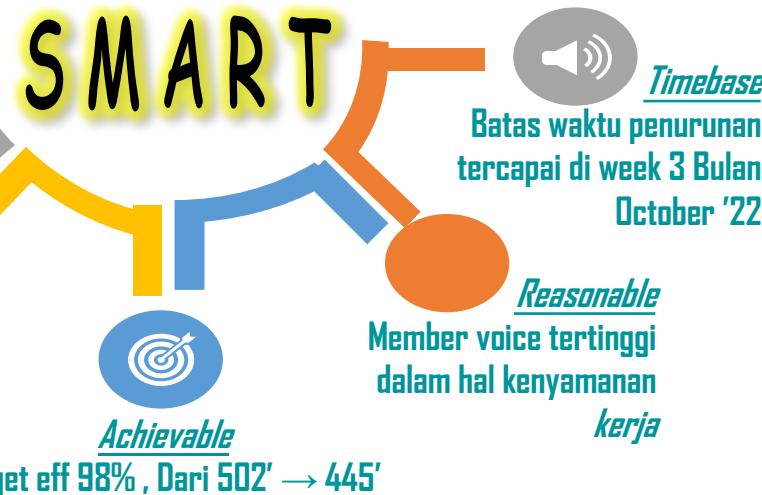
STEP 3. PENETAPAN TARGET

Grafik target waktu unpacking 1 yang tinggi

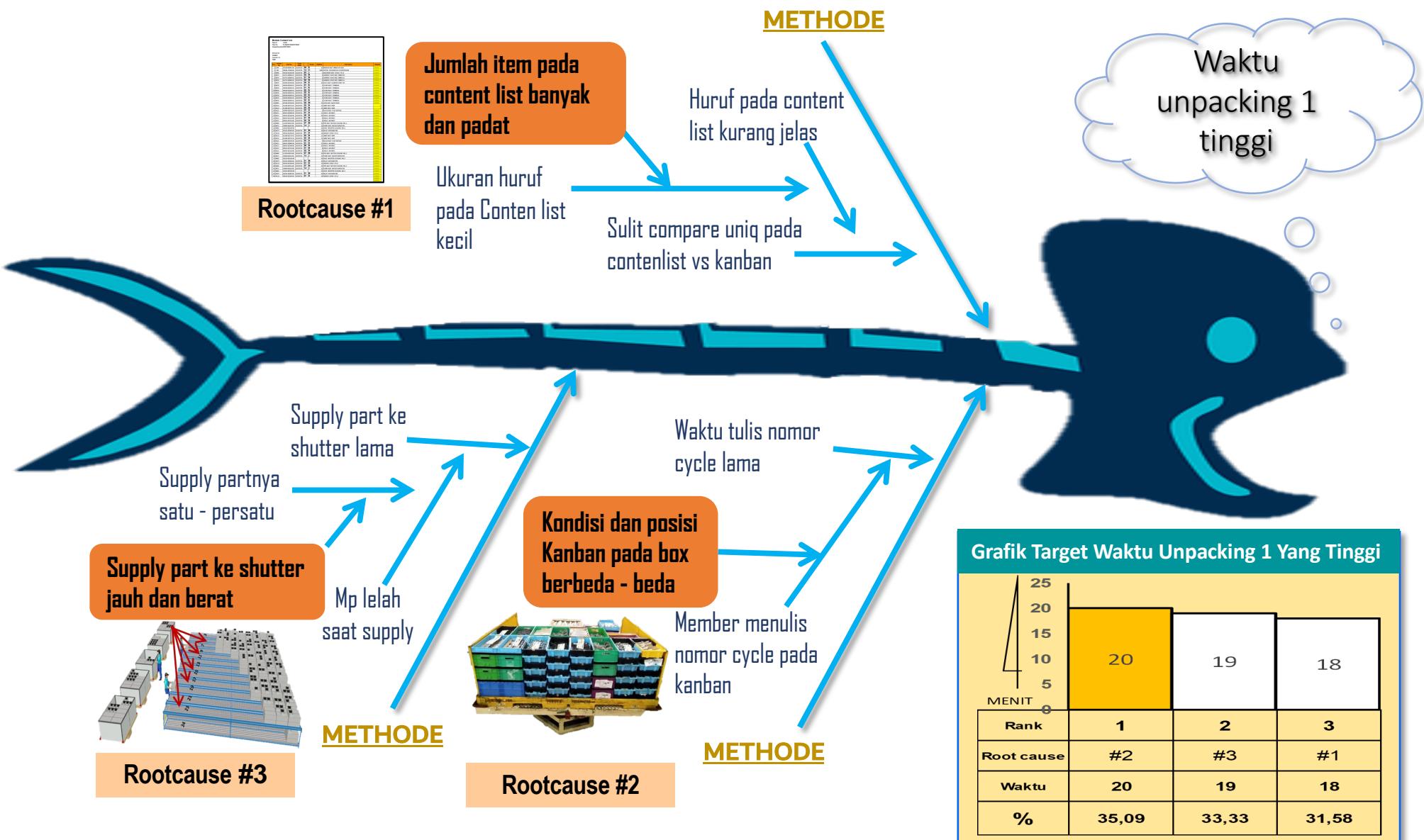


Spesifik Menurunkan waktu unpacking 1 yang tinggi

Measurable Satuan yang di gunakan adalah **menit**



Grup KALORI bertekad dengan yakin untuk mempercepat waktu Unpacking 1



Rootcause #1

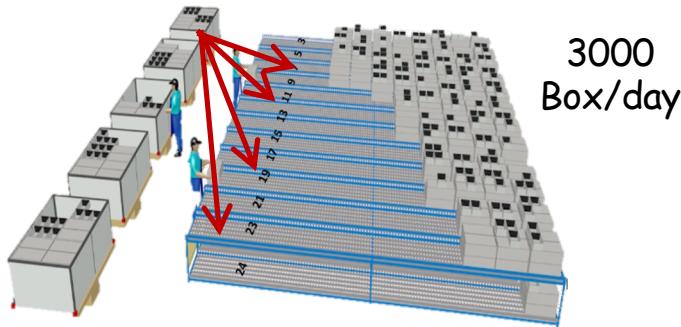
Jumlah item pada content list banyak & padat

Module Content List											
No.	Content List	Description	Code	Unit	Qty	Unit Qty	Unit Price	Unit Total	Unit	Unit Price	Unit Total
1	Wrench Assy	WRENCH ASSY	14.0	PC	2	2	10.00	20.00	PC	10.00	20.00
2	SCREW CHUCKER ASSY	SCREW CHUCKER ASSY	14.0	PC	1	1	10.00	10.00	PC	10.00	10.00
3	SCREW CHUCKER ASSY	SCREW CHUCKER ASSY	14.0	PC	1	1	10.00	10.00	PC	10.00	10.00
4	SCREW CHUCKER ASSY	SCREW CHUCKER ASSY	14.0	PC	1	1	10.00	10.00	PC	10.00	10.00
5	GARISON ASSY	GARISON ASSY	05.J	PC	2	2	10.00	20.00	PC	10.00	20.00
6	GARISON ASSY	GARISON ASSY	04.N	PC	3	3	10.00	30.00	PC	10.00	30.00
7	GARISON ASSY	GARISON ASSY	01.N	PC	3	3	10.00	30.00	PC	10.00	30.00
8	GARISON ASSY	GARISON ASSY	02.N	PC	3	3	10.00	30.00	PC	10.00	30.00
9	GARISON ASSY	GARISON ASSY	06.K	PC	24	24	10.00	240.00	PC	10.00	240.00
10	COVER ASSY	COVER ASSY	01.K	PC	3	3	10.00	30.00	PC	10.00	30.00
11	COVER ASSY	COVER ASSY	01.K	PC	3	3	10.00	30.00	PC	10.00	30.00
12	COVER ASSY	COVER ASSY	02.K	PC	3	3	10.00	30.00	PC	10.00	30.00
13	COVER ASSY	COVER ASSY	03.K	PC	3	3	10.00	30.00	PC	10.00	30.00
14	COVER ASSY	COVER ASSY	03.K	PC	3	3	10.00	30.00	PC	10.00	30.00
15	LOCK ASSY BACK DOOR	LOCK ASSY BACK DOOR	02.M	PC	24	24	10.00	240.00	PC	10.00	240.00
16	LAMP ASSY	LAMP ASSY	02.N	PC	32	32	10.00	320.00	PC	10.00	320.00
17	LAMP ASSY	LAMP ASSY	05.N	PC	32	32	10.00	320.00	PC	10.00	320.00
18	LAMP ASSY	LAMP ASSY	03.N	PC	32	32	10.00	320.00	PC	10.00	320.00
19	BLOCK ASSY FOR MACHINING	BLOCK ASSY FOR MACHINING	01.H	PC	12	12	10.00	120.00	PC	10.00	120.00
20	UNICLE AIR BAG	UNICLE AIR BAG	06.N	PC	30	30	10.00	300.00	PC	10.00	300.00

Sulit compare uniq pada content list VS kanban

Rootcause #3

Supply part ke shutter jauh dan berat



Supply part ke shutter lama

Temporary

Module Content List											
No.	Content List	Description	Code	Unit	Qty	Unit Qty	Unit Price	Unit Total	Unit	Unit Price	Unit Total
1	Wrench Assy	WRENCH ASSY	14.0	PC	2	2	10.00	20.00	PC	10.00	20.00
2	SCREW CHUCKER ASSY	SCREW CHUCKER ASSY	14.0	PC	1	1	10.00	10.00	PC	10.00	10.00
3	SCREW CHUCKER ASSY	SCREW CHUCKER ASSY	14.0	PC	1	1	10.00	10.00	PC	10.00	10.00
4	SCREW CHUCKER ASSY	SCREW CHUCKER ASSY	14.0	PC	1	1	10.00	10.00	PC	10.00	10.00
5	GARISON ASSY	GARISON ASSY	05.J	PC	2	2	10.00	20.00	PC	10.00	20.00
6	GARISON ASSY	GARISON ASSY	04.N	PC	3	3	10.00	30.00	PC	10.00	30.00
7	GARISON ASSY	GARISON ASSY	01.N	PC	3	3	10.00	30.00	PC	10.00	30.00
8	GARISON ASSY	GARISON ASSY	02.N	PC	3	3	10.00	30.00	PC	10.00	30.00
9	GARISON ASSY	GARISON ASSY	06.K	PC	24	24	10.00	240.00	PC	10.00	240.00
10	COVER ASSY	COVER ASSY	01.K	PC	3	3	10.00	30.00	PC	10.00	30.00
11	COVER ASSY	COVER ASSY	01.K	PC	3	3	10.00	30.00	PC	10.00	30.00
12	COVER ASSY	COVER ASSY	02.K	PC	3	3	10.00	30.00	PC	10.00	30.00
13	COVER ASSY	COVER ASSY	03.K	PC	3	3	10.00	30.00	PC	10.00	30.00
14	COVER ASSY	COVER ASSY	03.K	PC	3	3	10.00	30.00	PC	10.00	30.00
15	LOCK ASSY BACK DOOR	LOCK ASSY BACK DOOR	02.M	PC	24	24	10.00	240.00	PC	10.00	240.00
16	LAMP ASSY	LAMP ASSY	02.N	PC	32	32	10.00	320.00	PC	10.00	320.00
17	LAMP ASSY	LAMP ASSY	05.N	PC	32	32	10.00	320.00	PC	10.00	320.00
18	LAMP ASSY	LAMP ASSY	03.N	PC	32	32	10.00	320.00	PC	10.00	320.00
19	BLOCK ASSY FOR MACHINING	BLOCK ASSY FOR MACHINING	01.H	PC	12	12	10.00	120.00	PC	10.00	120.00
20	UNICLE AIR BAG	UNICLE AIR BAG	06.N	PC	30	30	10.00	300.00	PC	10.00	300.00

Memperbesar ukuran font

Result



Problem : Content list menjadi 2 lembar dan bolak - balik melihatnya

Memudahkan MP melihat dan membaca content list

Temporary



Buatkan dolly transfer

Result



Problem : Supply part bolak - balik

Membawa part lebih ringan



PENANGGULANGAN

Rootcause #2

- 💡 Kondisi dan posisi kanban pada box berbeda - beda



Waktu tulis nomor cycle
lama

PIC UTAMA



Mr. Dimas dijadikan
PIC agar meningkat
multiskilinya



Point : 1 = kurang, 2 = sedang, 3 = baik

5W1H

What	How	Where	When	Who	Why	How Much
Root Cause	Penanggulangan	Activity	Location	Time	PIC	Reason
Kondisi dan Posisi kanban pada box berbeda-beda	Metode tulis no. cycle dirubah menjadi stampel	Desain	Import	25/08/2022	Aldy S.	Proses tulis no. cycle Jelas dan Rapi
		Order	Stationery	26/08/2022	Dimas	
		Trial	Unpacking Area	01/09/2022	Ardika	

Alternatif 1

Menggunakan sticker nomor cycle

Design :



**TOTAL
7 Point**

Point penilaian

Effect Kaizen : 3

Cost : 1

Difficult : 1

Time : 2

Alternatif 2

Dibuatkan stempel nomor cycle

Design :



23
25 Aug 2022

**TOTAL
10 Point**

Point penilaian

Effect Kaizen : 3

Cost : 2

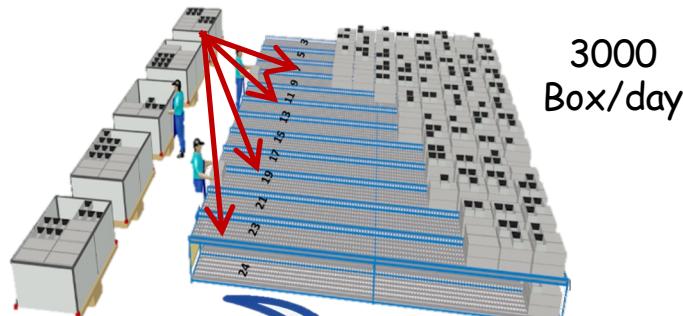
Difficult : 3

Time : 2



Rootcause #3

💡 Supply part ke shutter jauh dan berat

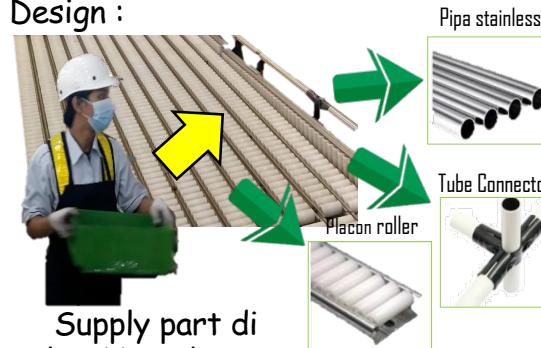


MP Supply Part ke
Shutter Lama

Alternatif 1

Pembuatan transfer table

Design :



Supply part di letakkan diatas transfer table

**TOTAL
10 Point**

APPROVED

Point Penilaian**Effect Kaizen : 3**

Cost : 3

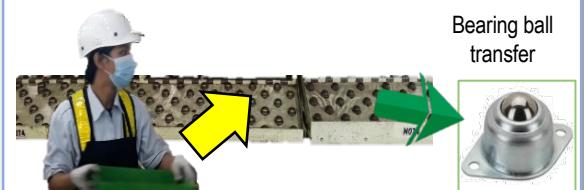
Difficult : 2

Time : 2

Alternatif 2

Pembuatan bearing ball pada shutter

Design :



Supply part di letakkan diatas bearing ball

**TOTAL
7 Point**

Point Penilaian**Effect Kaizen : 3**

Cost : 1

Difficult : 2

Time : 1

PIC UTAMA



SAYA SIAP !!!

Mr. ARDIKA dijadikan
PIC agar meningkat
Team Worknya



5W1H

What	How	Where	When	Who	Why	How Much	
Root Cause	Penanggulangan	Activity	Location	Time	PIC	Reason	Budget
Supply part ke shutter jauh dan berat	Installasi bearing ball pada shutter	Gembä	Prep. Engine	05/09/2022	Denny S.	Tidak double handling angkat box	Rp. 5.000.000
		Desain	Oasis Import	06/09/2022	Andri		
		Order	Vendor	12/09/2022	Ardika		
		Trial	Unpacking Area	04/10/2022	Dimas		



STYL D. PENANGGULANGAN



Rootcause #1

- 💡 Jumlah item pada content list banyak & padat**

Module Content List									
No.	Part No.	Unit	Item	Spec	Port Name	Port	Notes	Unit	Unit
1	317244	317244-0001-00	20220720	06 K	30MM CIRCLE ADJUST INNER RR VIEW				
2	317245	317245-0001-00	20220720	14 O	30MM CIRCLE CIRCLESLESS COUNTERTOP				
3	317246	317246-0001-00	20220720	06 K	30MM CIRCLE ADJUST INNER RR				
4	317247	317247-0001-00	20220720	06 N	30MM CIRCLE SIDE INNER RR				
5	317248	317248-0001-00	20220720	01 N	30MM CIRCLE SIDE INNER LR				
6	317249	317249-0001-00	20220720	06 K	30MM CIRCLE ADJUST QUARTER FRONT RR				
7	317250	317250-0001-00	20220720	01 K	COVER ADJUST TORSIONAU				
8	317251	317251-0001-00	20220720	01 K	COVER ADJUST TORSIONAU				
9	317252	317252-0001-00	20220720	02 K	COVER ADJUST TORSIONAU				
10	317253	317253-0001-00	20220720	02 K	COVER ADJUST TORSIONAU				
11	317254	317254-0001-00	20220720	02 K	COVER ADJUST TORSIONAU				
12	317255	317255-0001-00	20220720	03 K	COVER ADJUST TORSIONAU				
13	317256	317256-0001-00	20220720	03 K	COVER ADJUST TORSIONAU				
14	317257	317257-0001-00	20220720	03 K	COVER ADJUST TORSIONAU				
15	317258	317258-0001-00	20220720	02 N	LOCK ADJUST JACK DOOR				
16	317259	317259-0001-00	20220720	02 N	LOCK ADJUST JACK DOOR				
17	317260	317260-0001-00	20220720	05 N	30MM ADJUST ARM				
18	317261	317261-0001-00	20220720	01 H	LOCK ADJUST ARM PLATE				
19	317262	317262-0001-00	20220720	01 H	LOCK ADJUST ARM PLATE				
20	317263	317263-0001-00	20220720	08 N	REAR DOOR AIR INLET				
21	317264	317264-0001-00	20220720	02 N	REAR DOOR AIR INLET				
22	317265	317265-0001-00	20220720	07 M	REAR DOOR AIR INLET				
23	317266	317266-0001-00	20220720	14 J	REAR DOOR AIR INLET				
24	317267	317267-0001-00	20220720	02 N	REAR DOOR AIR INLET				
25	317268	317268-0001-00	20220720	01 M	REAR DOOR INTERACTION				
26	317269	317269-0001-00	20220720	01 M	REAR DOOR SPEED PUMP				
27	317270	317270-0001-00	20220720	01 H	REAR DOOR SPEED PUMP				

Sulit Mencocokkan Uniq Pada Content List VS Pada Kanban

Alternatif 1

Compare data menggunakan Tablet

Design :



Data content list di masukkan ke tablet

**TOTAL
6 Point**

Point Penilaian
Effect Kaizen : 1

Cost : 3
Difficult : 1
Time : 1

Alternatif 2

Compare data menggunakan barcode scanner

Design :



Pembacaan kanban di lakukan oleh scanner

**TOTAL
10 Point**

Point Penilaian
Effect Kaizen : 3

Cost : 2
Difficult : 3
Time : 2



Point : 1 = kurang, 2 = sedang, 3 = baik

5W1H

What	How	Where	When	Who	Why	How Much	
Root Cause	Penanggulangan	Activity	Location	Time	PIC	Reason	Budget
Jumlah item pada content list banyak dan padat	Compare data menggunakan barcode scanner	Desain	Import Area	07/09/2022	Kurnadi	Mudah di gunakan	Rp. 5.000.000
		Order	Engser	07/09/2022	Denny S.		
		Trial	Unpacking Area	09/09/2022	Giras		

**JOS....!!!
LANJUTKAN**



Rootcause #2

Kondisi dan posisi Kanban pada box berbeda - beda

Kondisi kanban terlipat



Posisi kanban di atas box

Alas untuk menulis tidak flat

Posisi kanban samping box

Kondisi kanban terlipat

Waktu tulis nomor cycle lama

Penanggulangan

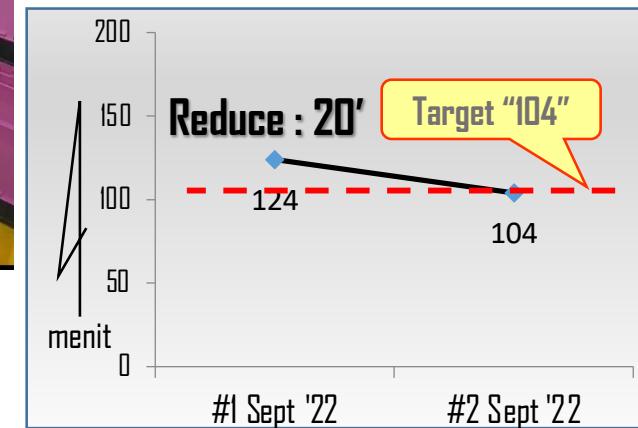
Penulisan nomor cycle di ganti dengan stempel nomor cycle



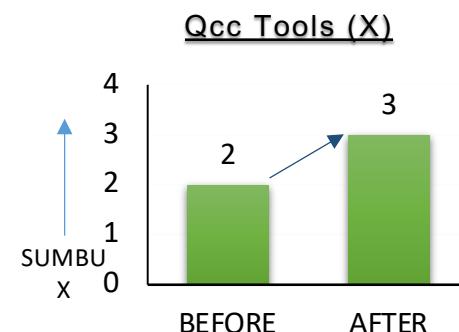
Result :

Penulisan nomor cycle terlihat rapih dan jelas

Grafik waktu tulis nomor cycle lama



"DIMAS dapat bekerja sama menyelesaikan step6



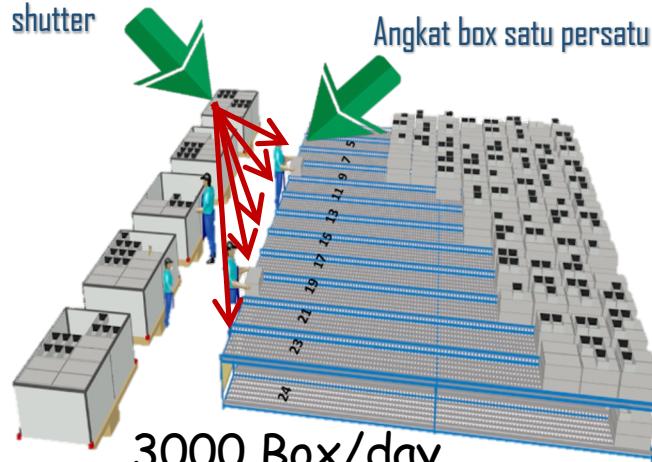
Sejauh ini DIMAS dapat menggunakan QCC tools



Rootcause #3

Supply part ke shutter jauh & berat

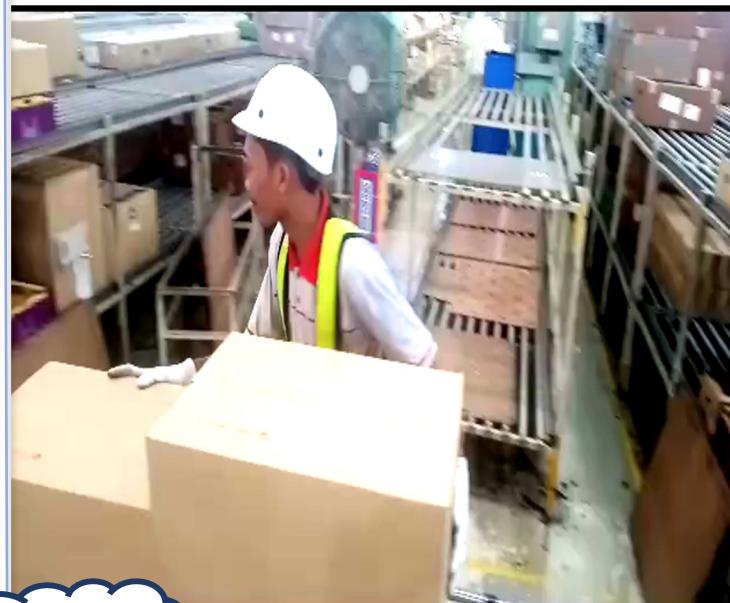
Proses kerjanya bolak balik dari module ke shutter



Supply part ke shutter lama

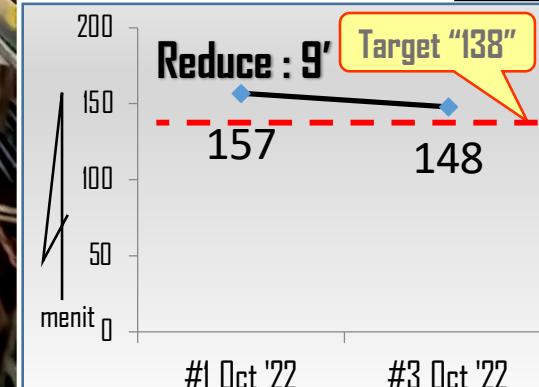
Penanggulangan

Pembuatan transfer table



Result :
menjadi ringan saat di dorong di atas transfer table

Grafik supply part ke shutter lama



Waktu supply ke shutter **berkurang** tapi waktunya **belum mencapai target**



Masih belum berhasil



Harus melakukan PDCA secepatnya



Kesulitan :

- Supply part MUDA Langkah
- Double handling prosess supply

GAGAL



STEP 6. PENANGGULANGAN

PDCA Rootcause #3	Inspirasi	Implementasi PDCA												
<p>METHODE</p> <p>Supply part masih di dorong manual</p> <p>Supply partnya bolak-balik</p>	<p>Conveyor distribusi otomatis pabrik minuman</p> <p>Sumber Video </p>	<p>Implementasi Conveyor Distribusi</p>												
<p>Yes....!!!</p> <p>ARDIKA sudah mulai bisa public speaking!!!</p> <p>Komunikasi (Y)</p> <table border="1"> <thead> <tr> <th>Kategori</th> <th>Komunikasi (Y)</th> </tr> </thead> <tbody> <tr> <td>BEFORE</td> <td>2</td> </tr> <tr> <td>AFTER</td> <td>3</td> </tr> </tbody> </table>	Kategori	Komunikasi (Y)	BEFORE	2	AFTER	3	<p>Result PDCA :</p> <ol style="list-style-type: none"> 1. Eliminasi supply part Muda langkah 2. Eliminasi Double handling prosess supply 	<p>Grafik supply part ke shutter lama</p> <table border="1"> <thead> <tr> <th>Tanggal</th> <th>Waktu (menit)</th> </tr> </thead> <tbody> <tr> <td>#3 Oct '22</td> <td>148</td> </tr> <tr> <td>#2 Jan '23</td> <td>50</td> </tr> </tbody> </table> <p>Target "138"</p> <p>Reduce : 98'</p>	Tanggal	Waktu (menit)	#3 Oct '22	148	#2 Jan '23	50
Kategori	Komunikasi (Y)													
BEFORE	2													
AFTER	3													
Tanggal	Waktu (menit)													
#3 Oct '22	148													
#2 Jan '23	50													



STEP 6. PENANGGULANGAN

Rootcause #1

Jumlah item pada content list banyak & padat

No.	Part No	Part Name	Spec	Model	Part Name	Model
1						
2						
3						
4						
5						
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100						

Sulit Mencocokan Uniq Pada Content List VS Pada Kanban



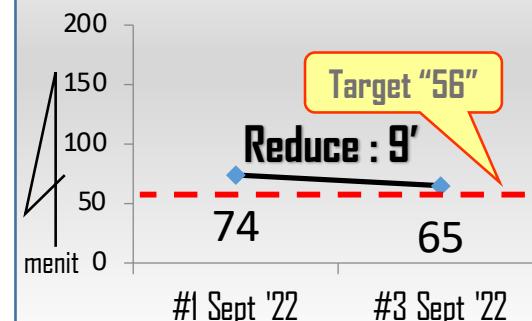
Compare data menggunakan barcode scanner

Result

Dapat melihat jelas nomor uniq dan nomor cycle pada scanner



Grafik sulit compare uniq pada content list Vs kanban



Waktu compare data berkurang tapi waktunya belum mencapai target



Masih belum berhasil

Harus melakukan PDCA secepatnya, Harus berhasil

Kesulitan :

- Scanner tidak memberikan informasi secara lengkap
- Scanner harus selalu di bawa-bawa



GAGAL

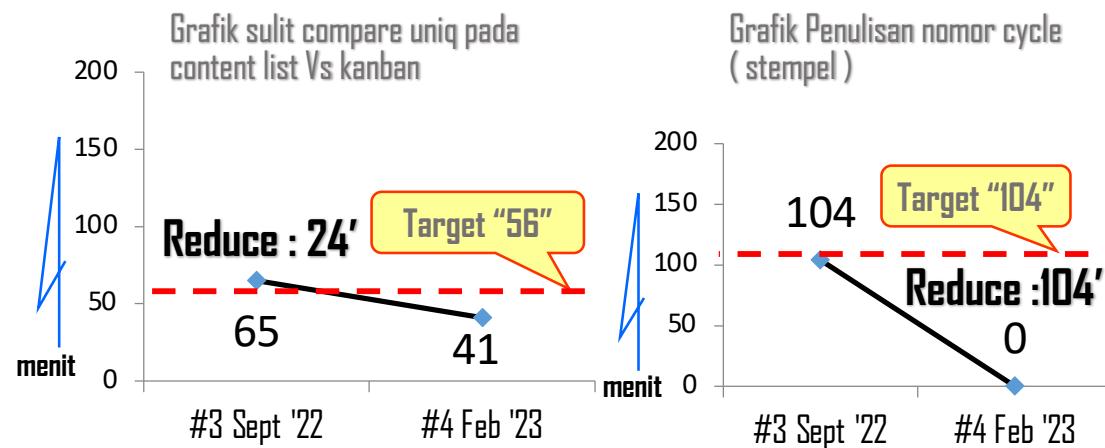


STEP 6. PENANGGULANGAN

PDCA Rootcause #1	Inspirasi	Implementasi PDCA
<p>METHODE</p>	<p>Tilang elektronik (ELTE)</p>	<p>Penerapan teknologi OCR (Optical Caracter Recognition)</p> <p>Teknologi ini Pertama di TMMIN and TOYOTA AFILIATE</p>

Result :

1. Eliminasi proses compare manual
2. Eliminasi Printing Content List
3. Eliminasi Proses writing no. cycle

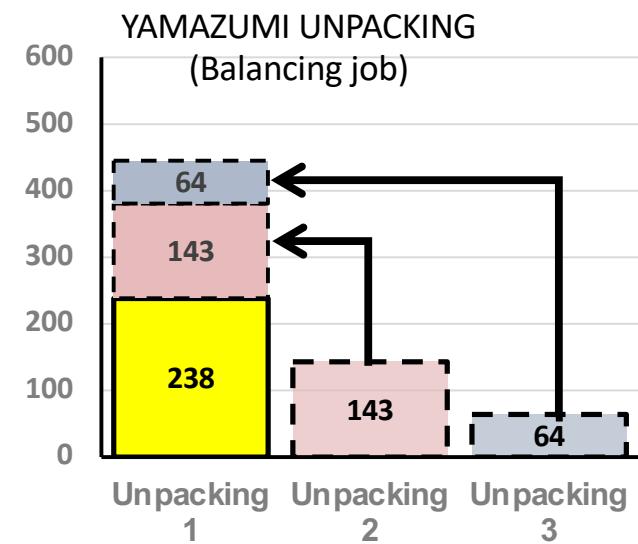
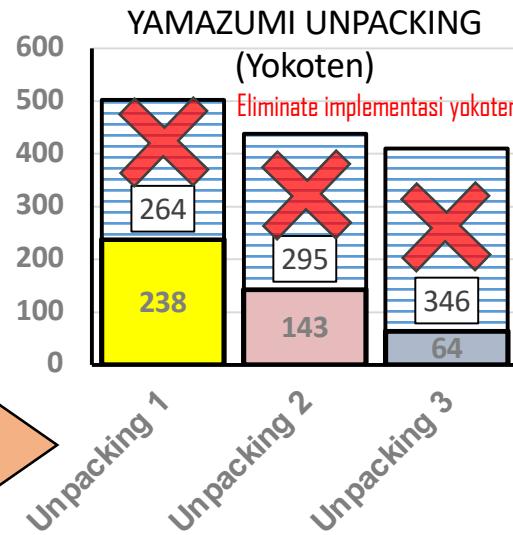
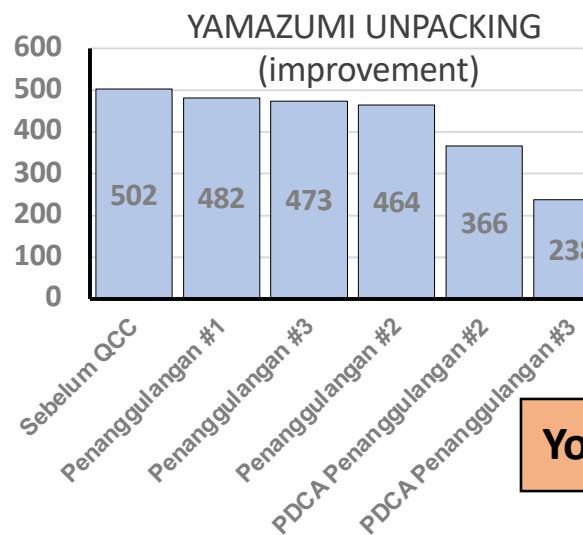
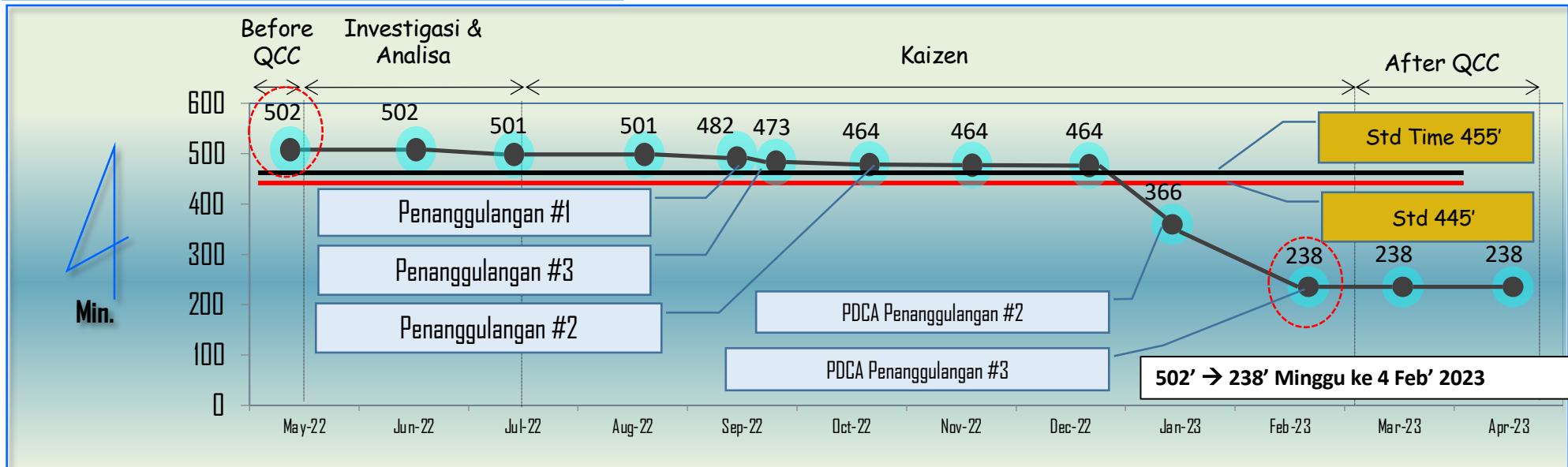


AUTO SORTING SYSTEM



STEP 7. EVALUASI HASIL

Grafik Penurunan Waktu Unpacking



Yokoten

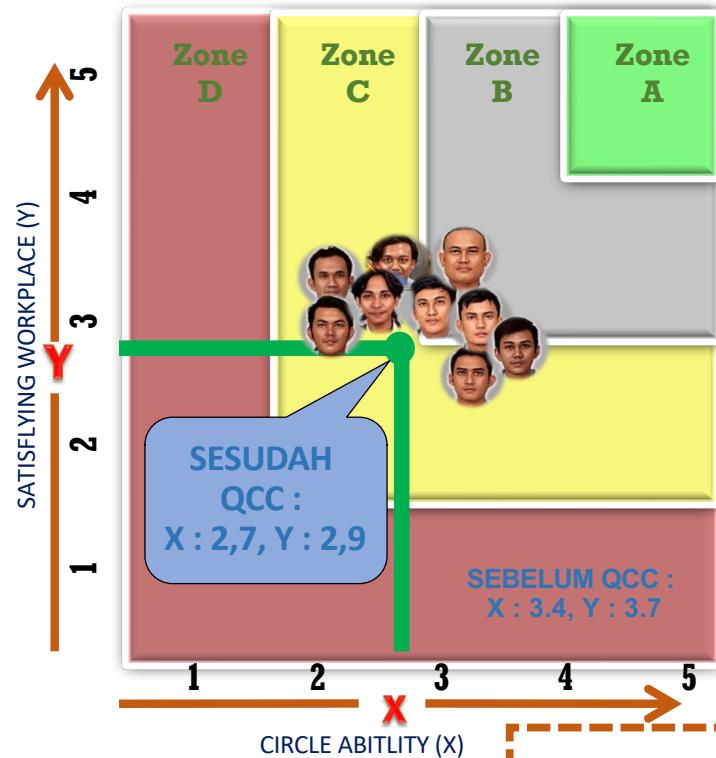


STEP 7. EVALUASI HASIL

DAMPAK QCC TERHADAP SAFETY, QUALITY, PRODUCTIVITY, COST, & HR

Faktor	Sebelum	Sesudah	Result
 Safety & Health	Member membungkuk untuk fill in box ke shutter bawah (ergonomi issue)	Member tidak ada proses membungkuk untuk proses fill in ke shutter	Menghilangkan ergonomi issue
 Quality	Part salah masuk cycle karena salah baca atau salah tulis	Tidak ada part salah masuk cycle karena sudah automatic	kualitas proses kerja tergaransi
 Productivity	Σ MP Unpacking / shift = 3 MP	Σ MP Unpacking / shift = 1 MP	Menurunkan 16 MH dan menaikan productivity quantity box per hour
	Σ MP Box / shift = 990 box	Σ MP Box / shift = 1.700 box	
 Cost	MH : $(24 \times 2) \times 127.000 \times 295$ hari = Rp. 1.798.320.000 / year	MH = $(8 \times 2) \times 127.000 \times 295$ = Rp. 599.440.000 / year	Total Investasi Rp 3,6 M Total Cost Reduction = Rp 1.731.080.000 M per tahun BEP = 2 tahun
	Paper : 30rim/month X Rp 85.000 = Rp 2.550.000 X 12month = Rp 30.600.000	Rp 0 (tidak ada pemakaian)	
	Toner : 6toner/month X Rp 300.000 = Rp 1.800.000 X 12month = Rp 21.600.000	Rp 0 (tidak ada pemakaian)	
	Space Import Unpacking 720 m²	Space Import Unpacking 400 m²	
 HR	Bekerja secara Manual	Member mengenal teknologi dan sistematis	DX Development

CONDITION ASSESSMENT AFTER DEVELOPMENT

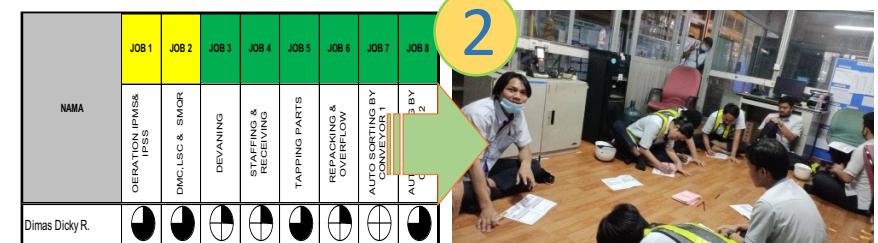


Member KALORI	SUMBU X					AVE SUMBU X	Z _{AVE}	AVE SUMBU Y	SUMBU Y					
	A.8 Step Solving	B.Leadership	C.Qcc Tools	D.Multi skill	E.Kaizen				A	B	C	D	E	
KARYADI	4	3	3	3	3	3,2	B	3,2	3	4	3	3	3	
ANDRI	4	3	3	3	3	3,2	B	3,2	3	4	3	3	3	
RONI A.	3	2	3	2	3	2,6	C	2,6	2	3	2	3	3	
ALDLS	3	2	2	3	3	2,6	C	3	3	3	3	3	3	
DIMAS R.	3	2	2	3	3	2,6	C	2,6	2	3	2	3	3	
KURNADI	3	2	2	3	3	2,6	C	2,8	3	3	2	3	3	
GIRAS C.	3	2	2	3	3	2,6	C	2,8	3	3	2	3	3	
DENNY.S	3	2	3	3	3	2,8	C	2,8	3	3	2	3	3	
ARDIKA	3	2	2	3	2	2,4	C	3,2	4	3	3	3	3	
AVE GROUP		3,2	2,2	2,4	2,9	2,9	2,7		2,9	2,9	3,2	2,4	3,0	3,0



Kesadaran 5R sudah tertanam di diri Mr.Ardika

Efeknya area kerja menjadi bersih & rapih

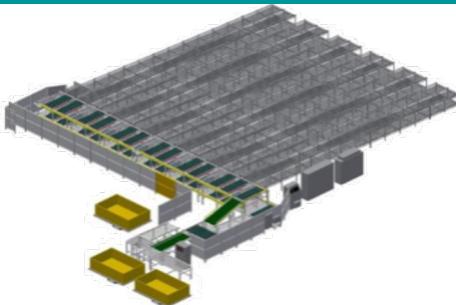


Level tanoko Multi skill
Mr.Dimas naik

Efeknya Mr Dimas menjadi lebih berani public speaking

Standarisasi

Standar Improvement



SOP



Training Member



Sharing Yokoten



"Improvement ini sudah
kita sharing yokoten ke
Logistic Import P#1"



Logistic Import P#1 Sedang
pengajuan proposal Autosorting



SOSIALISASI AUTO SORTING

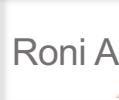
SOSIALISASI TO OPERATION					
Section Head	Group Leader	Team Leader	Unpacking #1	Unpacking #2	Unpacking #3
REO SHAFRI	YEHONAHAN P.	KARYADI	ANDRA	ANDRI	DIMAS
ZULFIKAR	SUPRIATNA	SUSENG P.	A. FAUZI	DENNY S.	GIRAS

SOSIALISASI AUTO SORTING					
Section Head	Group Leader	Team Leader	Unpacking #1	Unpacking #2	Unpacking #3
REO SHAFRI	YEHONAHAN P.	KARYADI	ANDRA	ANDRI	ZULFIKAR
SUPRIATNA	SUSENG P.	A. FAUZI	DENNY S.	GIRAS	SURYA W.

Sosialisasi Pihak Terkait



Tindak Lanjut Remaining 5 Problem Member Voice

No	Tema di usulkan (Member Voice)	PIC	Point untuk pemilihan tema					Total Point	Priority Rank
			Kesulitan pekerjaan	Kemungkinan di selesaikan	Waktu penggerjaan	Dampak ke next proses	Benefit		
1	Mengantri pengisian BBM Pertamax	 Giras	2	2	2	1	2	8	V
2	Sulit mencari part yang akan di tapping pada module	 Aldy	3	3	2	3	2	13	I
3	Manufer forklift sempit di area Devaning	 Kurnadi	2	3	2	1	2	10	IV
4	Lama prosess kalkulasi data IPSS	 Roni A.	2	3	2	3	2	12	II
5	Handle box kardus rusak	 Dimas	3	3	2	1	2	11	III

Dari data di atas kami sepakat mengambil Next tema :

Thema :
“Mempermudah Mencari Part tapping pada module”

Keterangan :

Kesulitan pekerjaan	Kemungkinan diselesaikan	Waktu penggerjaan	Dampak ke next prosess	Benefit
1. Problem mudah	1.Tidak bisa	1. >6 bulan	1.Tidak ada	1. <1 jt
2. Problem sedang	2.Butuh bantuan	2. 4–6 bulan	2.Criple	2.1-5 jt
3. Problem sulit	3.Bisa	3. 1-4 bulan	3.Line stop	3.>5 jt



TOYOTA
INDONESIA
PT Toyota Motor Manufacturing Indonesia



**TERIMA
KASIH**

