

OPS - PT Philips Industries Batam SWS for 4oz Natural Keymodul

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Reason for change




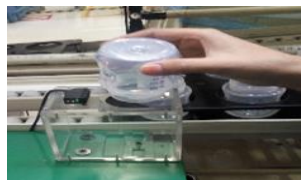


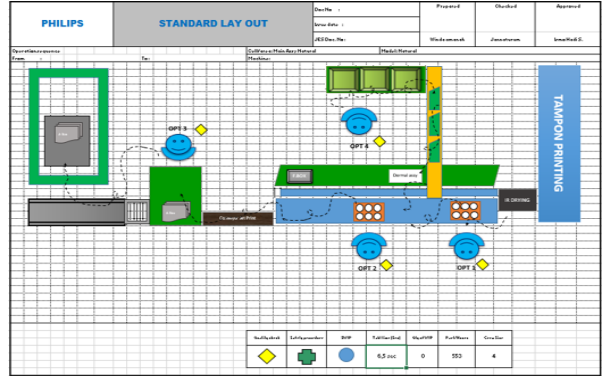

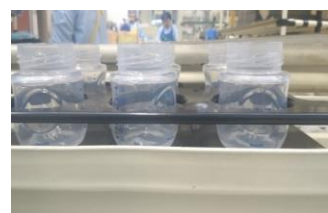
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Body files








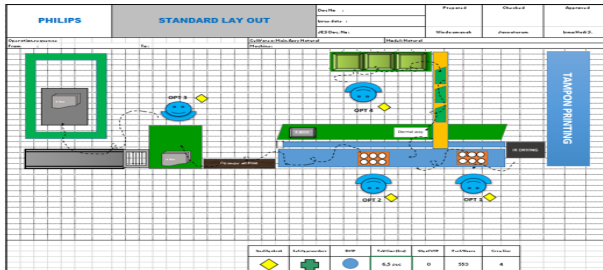
18090-00078008 SWS FOR 4OZ NATURAL KEYMODUL.pdf

QMS ID










QMS-0092

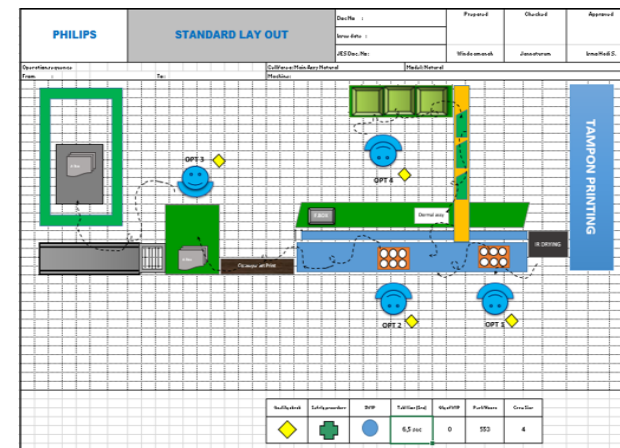
CELL / AREA : MAIN ASSEMBLY			CYCLE TIME (second)			TAKT TIME	SWIP	SWIP SYMBOL	QUALITY CHECK	SAFETY
STATION : STATION 1			24			6,5	6			
Job Element						PPE and Standard Layout				
No	Activity	Picture	MAN	AUTO	WALK					
1	English: Take 1 bottle and blow it to the air blow box, and make sure the bottom side of the bottle is not dented. Also, check the visual bottle includes bottle laser, printing on the scale, and printing on the logo.		1			<div><div> Think safety,work safety prioritizing safety,always working carefully. SAFETY FIRST : Think Safety, Work Safety Selalu mengutamakan keselamatan, Selalu bekerja dengan hati-hati.</div><div> Supplier-customer relation ship always check the result of work from the previous process and check the result our work before being transferred to the next process. QUALITY CONCERN : Supplier - Customer relation ship / Selalu memeriksa hasil pekerjaan dari proses sebelumnya dan memeriksa hasil pekerjaan kita sebelum diberikan ke proses selanjutnya.</div></div> 				
	Bahasa: Ambil 1 buah botol dan blow kedalam box air blow, pastikan bawah bagian bawah dari botol tidak penyok. Juga, cek visual botol termasuk laser botol, cetakan di ukuran, dan cetakan di logo.									
2	English: Make sure the air blow function properly so the dirt can come out from the bottle.		4							
	Bahasa: Pastikan air blow berfungsi dengan baik sehingga kotoran bisa keluar dari botol.									
3	English: Put 6 pcs bottles that have been checked into the jig.		0,5							
	Bahasa: Masukkan 6 pcs botol yang telah di cek ke dalam jig.									

Version	Release Date	Author	Approver	Description of change
1	As Per DIM Released	Jannaturrum	Ismo Hadi Sukoco	This is initial released in DIM. Actual update when upload to DIM is on Revision 3 (previous history refer to CSV-14-062-14005).







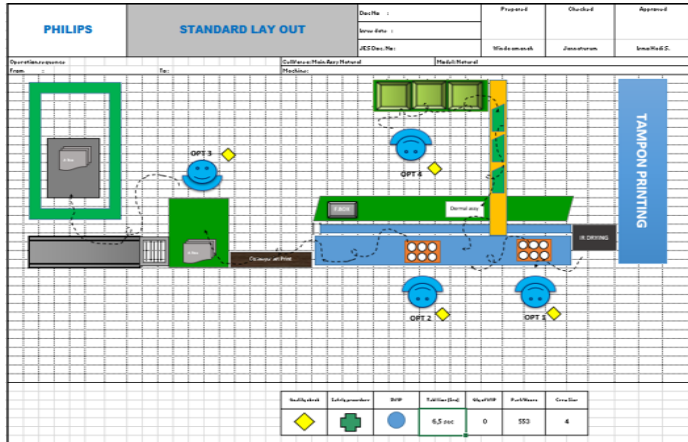

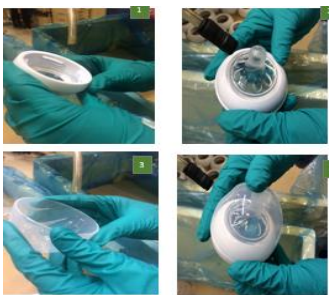
CELL / AREA : MAIN ASSEMBLY			CYCLE TIME (second)			TAKT TIME	SWIP	SWIP SYMBOL	QUALITY CHECK	SAFETY
STATION : STATION 2			24			6,5	6			
Job Element						PPE and Standard Layout				
No	Activity	Picture	MAN	AUTO	WALK					
1	English: Take the dormal and assembly it. Make sure no hair, no insect, and number hole is correct.		5			<div> Think safety,work safety prioritizing safety,always working carefully. SAFETY FIRST : Think Safety, Work Safety Selalu mengutamakan keselamatan, Selalu bekerja dengan hati-hati.</div> <div> Supplier-customer relation ship always check the result of work from the previous process and check the result our work before being transferred to the next process.</div> <div>QUALITY CONCERN : Supplier - Customer relation ship / Selalu memeriksa hasil pekerjaan dari proses sebelumnya dan memeriksa hasil pekerjaan kita sebelum diberikan ke proses selanjutnya.</div>				
	Bahasa: Ambil dormal dan rakit dormal dengan botol. Pastikan tidak ada rambut, tidak ada serangga, dan nomor hole yang di gunakan benar.									
2	English: Put the bottle to conveyer for the next process.		4							
	Bahasa: Lalu letakkan botol ke conveyer untuk di proses pada station packing.									

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CELL / AREA : MAIN ASSEMBLY			CYCLE TIME (second)			TAKT TIME	SWIP	SWIP SYMBOL	QUALITY CHECK	SAFETY
STATION : STATION 3			24			6,5	6			
Job Element						PPE and Standard Layout				
No	Activity	Picture	MAN	AUTO	WALK					
1	English: Buy off the sticker A-box before use. If pass, put the A-box sticker that has an IQ stamp in the barcode FA. Take the sticker A-box and paste it in front of the A-box then fold the A-box to the pattern. Bahasa: Buy off A-box stiker sebelum digunakan. Jika pass, letakkan A-box sticker yang stempel IQ di FA barcode. Ambil A-box stiker dan tempel di depan A-box lalu lipat A-box sesuai pola.		0,5			 Think safety,work safety prioritizing safety,always working carefully. SAFETY FIRST : Think Safety, Work Safety Selalu mengutamakan keselamatan, Selalu bekerja dengan hati-hati.  Supplier-customer relation ship always check the result of work from the previous process and check the result our work before being transferred to the next process. QUALITY CONCERN : Supplier - Customer relation ship / Selalu memeriksa hasil pekerjaan dari proses sebelumnya dan memeriksa hasil pekerjaan kita sebelum diberikan ke proses selanjutnya.				
2	English: Take the bottle from the conveyor, and then check the laser visual and DFU, arrange it into a box (1 box = 120 pcs, 1 layer = 40 pcs), put it into the layer box after full 1 layer. Bahasa: Ambil botol dari konveyor, dan kemudian cek visual laser dan DFU, susun ke dalam box (1 box =120 pcs, 1 layer=40 pcs), masukan ke layer box setelah penuh 1 layer.		2,5							
3	English: Put the bottles neatly to avoid missing quantity and make sure the bottles are assembled with complete parts there is no insect and hair contamination in the dormal and bottle. Bahasa: Letakkan botol dengan rapi untuk menghindari kuantitas yang hilang dan pastikan botol terakit dengan bagian yang komplit tidak ada serangga dan kontaminasi rambut pada dormal dan botol.									
4	English: Make sure operator production area station 4. Before putting the A-box on the pallet, the operator should be check to drawing pallet on the monitor. To avoid complaints from customers. Bahasa: Pastikan operator production area station 4. Sebelum meletakkan A-box ke pallet, operator harus mengecek gambar pallet yang ada di layar, untuk menghindari komplain dari pelanggan.		0,5	0,5	1					



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CELL / AREA : MAIN ASSEMBLY			CYCLE TIME (second)			TAKT TIME	SWIP	SWIP SYMBOL	QUALITY CHECK	SAFETY
STATION : STATION 4			24			6,5	6			
Job Element						PPE and Standard Layout				
No	Activity	Picture	MAN	AUTO	WALK					
1	English: Take the 1 hole galaxy teat and air blow. Assembly teat with screw ring. Ensure the number hole teat is correct. Use hand gloves to avoid contamination. Bahasa: Ambil teat 1 hole galaxy lalu gunakan air blow. Rakit teat dengan screw ring. Pastikan teat yg di gunakan benar. Gunakan sarung tangan untuk menghindari kontaminasi.	 number hole 0 hole = 2 Oz Natural 1 hole = 4 Oz Natural 2 hole = 9 Oz Natural	1			<p> Think safety,work safety prioritizing safety,always working carefully. SAFETY FIRST : Think Safety, Work Safety Selalu mengutamakan keselamatan, Selalu bekerja dengan hati-hati.</p> <p> Supplier-customer relation ship always check the result of work from the previous process and check the result our work before being transferred to the next process.</p> <p>QUALITY CONCERN : Supplier - Customer relation ship / Selalu memeriksa hasil pekerjaan dari proses sebelumnya dan memeriksa hasil pekerjaan kita sebelum diberikan ke proses selanjutnya.</p> 				
2	English: Make sure the teat and screw ring are assembled properly. Bahasa: Pastikan teat dan screw ring di rakit dengan benar.	 NOT GOOD GOOD Teat and screwing assembly with properly	1							
3	English: Take the screw ring assembly, use the air blow on the inside and outside of the screw ring and dormal cap to avoid insects and hair. Then close screw ring with a dormal cap. Ensure the dormal cap that is used is correct according to BOM list (with hole or without hole). Bahasa: Ambil rakitan screw ring, gunakan air blow pada bagian dalam dan luar screw ring dan dormal cap untuk menghindari serangga dan rambut. Lalu tutup screw ring dengan dormal cap. Pastikan dormal cap yang di gunakan benar sesuai dengan BOM list (dengan lubang atau tanpa lubang).		3							

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