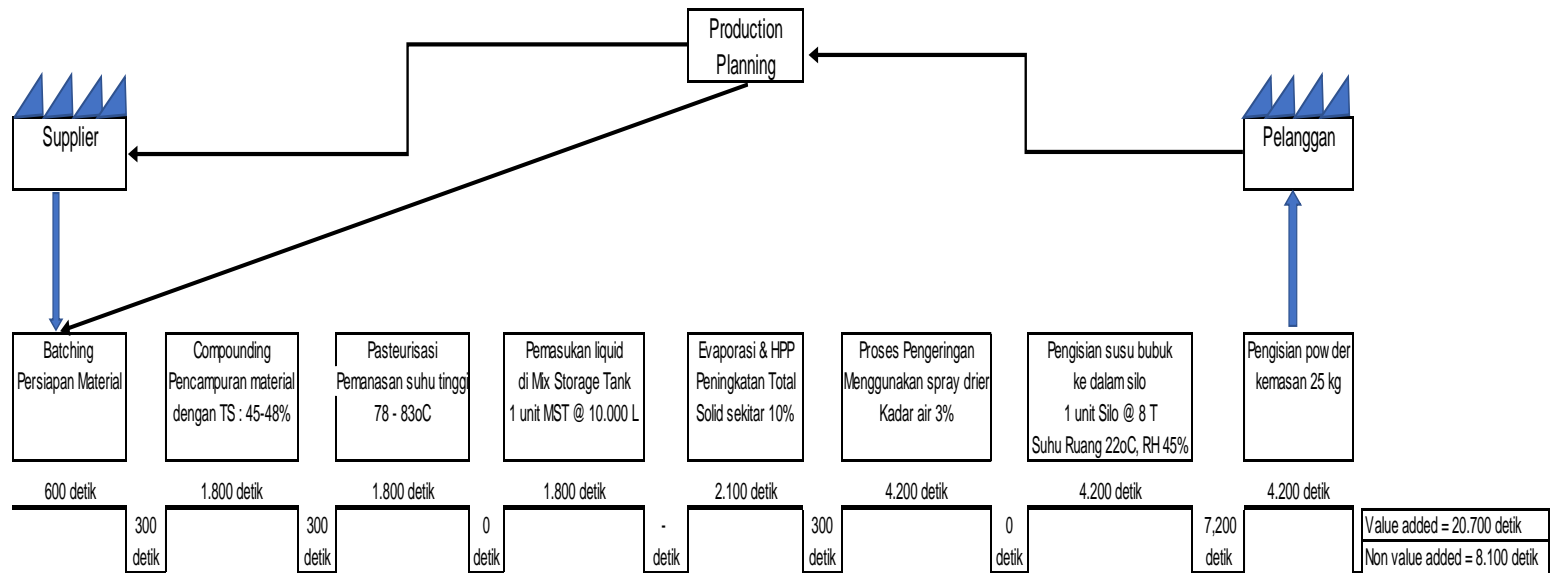



Lampiran 1. Gambar Value Stream Mapping sebelum perbaikan



Lampiran 2. Gambar Value Stream Mapping setelah perbaikan

	FORM			
	Change Control Document Dokumen Pengendalian Perubahan			
	NO	F/PCM/001-XX-04	SITE	SOP/PCM/009
EFFECTIVE DATE	10/05/2017	ISSUE NO	03	

Change Control Notification Request

Section I:			
General Information (General Information for Project)			
To be completed by initiator prior to meeting with the Change Control Committee			
Project Title:	Hopper 8.5 ton for Fill Bag	Change Control No:	CCR-009B-JOG-2017-MFG- Hopper 8.5 ton for Fill Bag
Initiator:	Yosep M Nalbaho	Project Owner (if other than initiator):	Yosep M Nalbaho
Date:	2 August 2017	Expected Implementation Date:	Nov 2017
Site originating the change:		Open Way Project:	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
Project team:	Agnes Puspitasari		Production
	Bachtiar		Engineering
	Hana Maria		QID
	Terry Trihantara		PCM
	Arifin Suparja		Project-Civil
	Destya P A + Anang		Project - Electrical
	Darmawan W Prabawa		Project Manager
Is this an Emergency Request (to be implemented within 7 days)?		<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	
Describe Current Operation			
There are 4 silos @ TFD 315. Due to the energy consumption, quality issue, we will dismantled 4 Silos and others utility support and will be replaced with 1 new hopper with capacity 8.5 Ton			
The area of HCA also quite big + some equipment with water located inside HCA, It is not recommended by NNE.			
Describe Proposed Operation and Impact			
The proposal consists of:			
1. New Hopper Fill Bag 8.5 Ton			
a) New hopper 8.5 Ton			
b) Install airlock below new hopper + BFM			
c) Reposition compact sieve from elevation 7000 to 8500			
d) Dismantle all silos			
e) Install new platform & stair			
f) Create partition from Sandwich panel to separate HCA Silo & LCA Drier			
g) Install new load cell to replace the broken load cell + programming PLC/HMI			
h) Modified ducting & utilized 1 DMDF for both F/P room + Silo room			



Jogja Factory: Jl. Kusumanegara No. 173, Umbulharjo, Yogyakarta 55165, Indonesia Tel: +62 274 512990 Fax: +62 274 563328
Prambanan Factory: Jl. Raya Jogja Solo Km. 19, Kemudo, Klaten 57454, Indonesia. Tel: +62 274 498001 Fax: +62 274 498008

Lampiran 3. Contoh dokumen change control management terhadap perubahan yang dilakukan dalam continuous improvement



FORM

Change Control Document

Dokumen Pengendalian Perubahan

NO	F/PCM/001-XX-04	SITE	SOP/PCM/009
EFFECTIVE DATE	10/05/2017	ISSUE NO	03

- i) Inline metal detector
- j) Revise piping (prod, DMDF, compres air, etc)
- k) Upgrade rotary magnet 11.5 kg

Please find the ppt below for details information

Project:
New Hopper 12.7m Hopper @ TFD 315



P&ID silo hopper
8.5T Layout1 (1).pdf

Describe Rationale/Justification for Change

The justification are

1. Quality
 - Reduce the quantity of Silos will reduce the risk of MIFCA
 - Reduce the area of HCA, will reduce the risk as well
 - Simplify the route/access between BF & silo, segregate HCA, LCA + relocate all "water contain" equipment as part of NNS.
2. Cost
 - Eliminated 2 compressors for Bag Filling so reduce the Kwh usage and the compressor will be centralized
 - Maintenance cost
3. Delivery
4. Environment

Change Control Category: (Can select more than 1 category)

<input type="checkbox"/> Artwork	<input type="checkbox"/> Formulation	<input type="checkbox"/> Regulations
<input type="checkbox"/> Computer System/Hardware	<input type="checkbox"/> Import/Export	<input checked="" type="checkbox"/> Site of Manufacturing
<input type="checkbox"/> Distribution	<input checked="" type="checkbox"/> Manufacturing Process Conditions	<input type="checkbox"/> Supplier
<input checked="" type="checkbox"/> Documentation/SOP	<input type="checkbox"/> Master Batch Record	<input type="checkbox"/> Testing/Analytical Methodology
<input checked="" type="checkbox"/> Equipment	<input type="checkbox"/> Packaging Material	<input type="checkbox"/> Warehousing
<input checked="" type="checkbox"/> Facility	<input type="checkbox"/> Raw Materials	<input type="checkbox"/> Other:

Department, Process, Processing Area, Line or Equipment where change is affected (if applicable):

Production TFD 315, Bag Filling, Access area HCA/LCA + stairs + Platform + Silo



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Notulen Meeting Project Jogja Kembali
Topic: Reduksi Jumlah MST

Hari/Tanggal : 10 Oktober 2017

Jam : 09.00 - 15.00

Tempat : Ruang Meeting SGM Explore

Peserta : ARF,ADY,YMN,YEG,TER,Imam A, Rosma, Imam C, Hari S,Sulis, Anto

Arif W, Istono,Adit,Agnes,Gusman,Sulistio,Agus P,Adi R

No	Issue	Action	PIC	Due Date	Remark
Highlight: Project Jogja Kembali akan dilakukan estimasi bulan Mei 2018 selama 3 bulan					
Perbaikan proses ini bisa dilakukan berbarengan dengan waktu tersebut					
	Metode				
1	Formula condensate milk dimasukkan di MST	Dilakukan trial untuk dimasukkan di compounding	Rosma	17-Nov-17	
		Uji Sensori dari hasil trial	Adi R	27-Nov-17	
2	Keseimbangan kapasitas	dilakukan kalkulasi keseimbangan kapasitas	Hari S		
3	Aspek safety dan ergonomi terhadap point 1	Dilakukan observasi di lapangan untuk memastikan aman	Gusman		
	Material/Produk				
4	Kualitas produk sama dengan produk reguler	pengujian kualitas sesuai parameter standar dari hasil trial	Adit	27-Nov-17	
		Sesuai standar trial dilakukan 3 kali	ADY	15-Jan-18	
	Machine/System				
5	Perubahan automation system (skala trial)	Dilakukan testing IO dan functional test sebelum jalan	Agus P	10-Nov-17	
6	Instalasi elektrik baru (skala trial)	Instalasi kabel sesuai standard	Anto	10-Nov-17	
7	Perubahan di SAP dan MES	Identifikasi kebutuhan perubahan tsb	Imam C	1-Dec-17	
	Karyawan				
8	Perubahan way of working	Dilakukan diskusi dan small workshop	ADY	10-Nov-17	
		Menjadi bagian SGIA 2018	Agnes	15-Jan-18	
	Finansial Aspect				
9	Apakah ada tambahan cost dari yang sudah di plan?		YMN	10-Nov-17	
10	Hitung potensi saving yang didapatkan untuk masuk productivity 2018		ADY	15-Jan-18	

Lampiran 4. Contoh notulen diskusi project

Ringkasan Diskusi Lean MST di Proses Basah

Participant:

- Adi Yasir
- Terry Trihantara
- Rosmarini L
- Tri Atmoko
- Purwadi
- Yosep MN

Date : 15 Jan 2018

What was the main point ?

- Spray drier memiliki 4 tangga MST untuk menyimpan liquid
- Stock liquid harus penuh baru bisa dispray karena ada material yang ditambahkan di MST (Condensate milk)
- Apakah mungkin mengurangi jumlah MST dan Condensate milk dipindahkan di step sebelumnya ?
- Compounding harus diperhatikan dan keseimbangan kapasitas

What approach did we choose ?

- Lean di proses produksi dengan 1 MST atau max 2 MST ?
- Pindahkan pemasukan condensate milk dari MST ke compounding tank
- Mengatur perubahan cara produksi bagi operator

What we achieved

- Kondisi lebih lean, semua material dimasukkan di compounding tank
- Lean di equipment, reduksi 3 MST
- Peningkatan produktivitas dari energy dan material efisiensi
- Mengurangi resiko dari mikro karena just in time

Potential Tangible impact:

- Potential generate saving from energy and material efisiensi, TBD
- Shorter lead time, TBD



Lampiran 6. Contoh sosialisasi dan diskusi *continuous improvement*