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LAMPIRAN

Lampiran 1 Form quality control sizing

CHECKLIST MC SIZING

Tgl 7 Juli 2017 07-10-2017

NO	CHECKLIST	MC 2		MC 3		MC 4		MC 6		MC 7		MC 8	MC 9	MC 10	
		SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT				
1	konstruksi	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01	1.84.09.12.05.01				
b	DITAI BELAJ	824 / 22000	824 / 22000	824 / 22000	824 / 22000	824 / 22000	824 / 22000	824 / 22000	824 / 22000	824 / 22000	824 / 22000				
c	KONSTRUKSI BEAM	12	12	12	12	12	12	12	12	12	12				
2	JARAI & KOMPRESI														
b		P. H. 20 25	P. H. 20 25	M. 20 25	M. 20 25	P. H. 20 25	P. H. 20 25	P. H. 20 25	P. H. 20 25	P. H. 20 25	P. H. 20 25				
c		Compress 10	Compress 10	Compress 10	Compress 10	Compress 10	Compress 10	Compress 10	Compress 10	Compress 10	Compress 10				
d		AS 60	AS 60	AS 60	AS 60	AS 60	AS 60	AS 60	AS 60	AS 60	AS 60				
e		Compress 30	Compress 30	Compress 30	Compress 30	Compress 30	Compress 30	Compress 30	Compress 30	Compress 30	Compress 30				
	NR	550	550	480	480	550	550	600	600	600	600				
	KANE JADI	700	700	700	700	700	700	800	800	800	800				
	REF / VISKO	5 / 5.5	7 / 9	5 / 5.5	5 / 5.5	5 / 5.5	5 / 5.5	10 / 11	10 / 11	10 / 11	10 / 11				
	SPU	-0.5	0.5	-0.5	-0.5	-0.5	-0.5	0.5	0.5	0.5	0.5				
	BEAM KE	10	5	14	4	4	4	7	7	7	7				
	DRAF	4	1	4	4	4	4	1	1	1	1				
3	TEK SIZESING ROLL														
b	START	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3				
c	FINISH	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1				
d	WID TENSION	180	200	180	150	150	150	150	150	150	150				
e	SPEED	3.5	4.0	3.5	4.0	4.0	4.0	3.5	3.5	3.5	3.5				
4	TEK PRESS ROLL	3.2	3.8	3.2	3.2	3.8	3.8	3.8	3.8	3.8	3.8				
5	SETTING TEMPERATURE														
	DRYING	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT
	1	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	2	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	3	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	4	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	5	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	6	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	PRE DRYING (1)	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT
	1			115	115	115	115	115	115	115	115	115	115	115	115
	2			115	115	115	115	115	115	115	115	115	115	115	115
	3			115	115	115	115	115	115	115	115	115	115	115	115
	4			115	115	115	115	115	115	115	115	115	115	115	115
	5			115	115	115	115	115	115	115	115	115	115	115	115
	6			115	115	115	115	115	115	115	115	115	115	115	115
	PRE DRYING (2)	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT
	1	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	2	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	3	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	4	115	115	115	115	115	115	115	115	115	115	115	115	115	115
	SIZE BOX	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT	SET	ACT
	1			70	70	70	70	70	70	70	70	70	70	70	70
	2	70	69	90	87	70	70	70	70	70	70	70	70	70	70

Lampiran 2 Form status persiapan mesin sizing

STATUS MC SIZING PERSIAPAN												
BULAN												
PT DMDT V												
Bagian	Item	Cek point	no mc sizing									
			1	2	3	4	5	6	7	8	9	10
Head	Bearing spindle beam	Grease										
	Bearing roll penghantar	Grease										
	Bearing roll karet/drag roll	Grease										
	PIV+gear box	Oil										
	Rantai-rantai penggerak	Oil										
	Pneumatic press roll, spindle, hanger beam	Fungsional										
	Instalasi angin	Kebocoran										
	Sisir ekspansi	Fungsional										
Drying, pre drying dan 2	Bearing cylinder	Grease										
	Bearing roll penghantar	Grease										
	Rantai-rantai dan spoket	Oil										
	Gear box	Oil										
	Instalasi angin	Kebocoran										
	Instalasi steam	Kebocoran										
Size box 1	Instalasi angin	Kebocoran										
	Bearing roll penghantar	Grease										
	Bearing squeezing roll	Grease										
	Bearing bottom roll	Grease										
	Rantai-rantai penggerak	Oil										
	Pompa sirkulasi	Kebocoran										
	PIV+gear box	Oil										
	Pneumatic squeezing roll	Fungsional										
	Instalasi steam	Kebocoran										
Size box 2	Immersion roll	Fungsional										
	Instalasi angin	Kebocoran										
	Bearing roll penghantar	Grease										
	Bearing squeezing roll	Grease										
	Bearing bottom roll	Grease										
	Rantai-rantai penggerak	Oil										
	Pompa sirkulasi	Kebocoran										
	PIV+gear box	Oil										
	Pneumatic squeezing roll	Fungsional										
Beam stand	Instalasi steam	Kebocoran										
	Immersion roll	Fungsional										
	Pneumatic rem	Fungsional										
	Instalasi angin	Kebocoran										
	Breake	Fungsional										
	Bearing roll penghantar	Grease										
	Roller	Fungsional										