

Trial Report

GADC rollout

Fan Nozzle Die + Tray Outlet tool



Date : 16/11/2018

Rev : 00

Topic of Report	: Ability for GADC rollout
Place of machine / Trial	: CV Prima Sakti
Machine No.	: Fan Nozzle + Tray Outlet Tool
Product	: Wanne GADC 035/1
PO / Capex	: PO 770000527 / No GI-2018X-4097
Manufactured	: CV Prima Sakti
	JL Industri Randuagung Malang Telp. 0341 458899

Process	
Date	: 15/11/2018
Product	: Wanne GADC 35/1 (400-0000638795) : fan Nozzle process + Tray Outlet process

A. Machine + Tool Overview

Machine : Hydraulic punch cap 100 T , CV Prima Sakti Malang
Die Qty : Fan Nozzle GADC + Tray Outlet
Function : punching process for Wanne GADC + Tray 1 1/4
Location : CV Prima Sakti Malang
2 kind of tool (GI Aset) will be send to CV Prima sakti
(sub contracting for Man power process.)



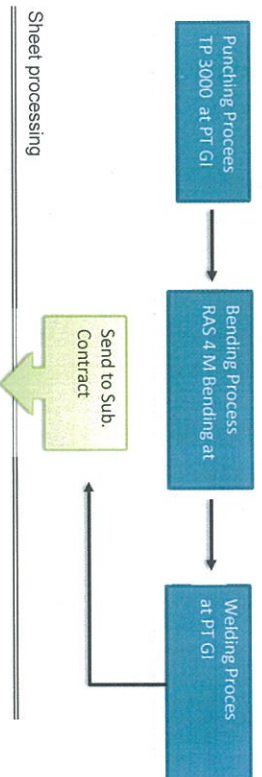
Fan Nozzle Die



Tray Outlet Tool

B. Wanne GADC 35/1 (400-0000638795)

Routing Process (Sheet Metal Processing)



Finish
Wanne will be send back to GI

Note :
this routing is doing only trial process ,
for the mass production was handled by vendor
optional Sub Cont.

Sub Cont. processing

Fan Nozzle Process (CV Prima Sakti Malang)



Punching process step 1



Burr removing



Punching Oil used



Drawing process step 2



Finish product

C. Visual + Dimension Checking

This actual measurement will be used to determine what tolerance is allowed as the standard



Visual Dimension Wanne GADC 35/14

Visual Dimension Waive GADC 35/14									
Measured by :		Aoi Handoyo + Choiht							
		Aodii (PE) + Fujii (IE)							
Fan nozzle height	Std	1	2	3	4	5	6	7	8
		71	71.18	71.78	71.55	72.27	71.2	71.7	71.51
ID fan nozzle	Std								
		364	364.4	363.3	363.3	364.5			
Fan mounting	Std								
		10	10.6	10.6	10.6				
Average									
		71.69875							
		363.875							
		10.6							

Height of nozzle	: approx. +/- 1
ID of nozzle	: approx. +/- 1
Mounting Dia.	: approx. + 0,6

D. Standard Routing propose

Base on trial activities was implemented with CV Prima Sakti Malang (Sub Contract) the routing proposed are :

Routing Wanne GADC 35/14

Routing No.	Process	Machine	Location
1	Cutting + punching	TP/TC 3000	Sheet Metal Sub Dept.
2	Bending	RAS / Bystronic	
3	Welding tray / wanne	Manual Welding	
4	Fan nozzle processing	Hydrolic Machine	
5	Tray outlet processing	Hydrolic Machine	
			Sub Contract (CV Prima Sakti)

E. Appendix of Trial with CV Prima Sakti

1. Cutting hole with 2 step process (Cutting + burr removing)

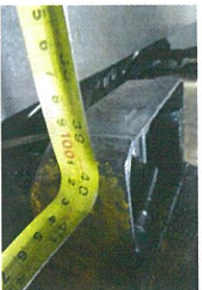


Step :

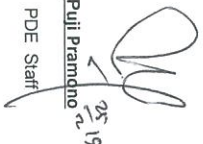
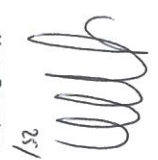
1. Cutting process with Die cutting
2. Burr removed
3. Oil usaged

Cutting step , for the minimize crack on nozzle

2. Working space (Max. Of the width material)



Working space = 1000 mm
Working space = 1040 mm , vendor must be used spacer for backup the condition

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