

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

2. Work Center A3303 : Sub-Assembly Control Valve

No	Op	Process Name	Item	Qty	Run Hrs
26	3260	Inst P Hose To Cont Val	1	1	0.02
27	3270	Inst P Hose To Cont Val	3	10	0.03
28	3280	Inst P Hose To Cont Val	2	5	0.03
29	3290	Inst P Hose To Cont Val	2	5	0.03
30	3300	Inst P Hose To Cont Val	2	3	0.03
31	3310	Inst P Hose To Cont Val	2	3	0.03
32	3320	Inst P Hose To Cont Val	1	1	0.02
33	3330	Inst P Hose To Cont Val	2	3	0.03
34	3340	Inst P Hose To Cont Val	3	3	0.05
35	3350	Inst P Hose To Cont Val	2	3	0.03
36	3360	Inst P Hose To Cont Val	2	3	0.03
37	3370	Inst P Hose To Cont Val	3	6	0.03
38	3380	Inst P Hose To Cont Val	2	3	0.03
39	3390	Inst P Hose To Cont Val	3	6	0.03
40	3400	Inst P Hose To Cont Val	2	3	0.03
41	3410	Inst P Hose To Cont Val	2	3	0.03
42	3420	Inst Strap pada Hose As	1	8	0.03
43	3430	Inst Supp As To Cont V	3	5	0.07
44	3440	Inst Clip To Cont Valve	3	3	0.03
Total :			154	306	3.10

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

3. Work Center A1102 : Sub-Assembly Swing Frame 1.

No	Op	Process Name	Item	Qty	Run Hrs
1	2010	Load S/F to Carrier	1	1	0.08
2	2020	Inst. Grommet To S F	7	8	0.10
3	2030	Inst. Grommet To S F	5	6	0.06
4	2040	Inst. Harn, Cable To S F	2	2	0.15
5	2050	Inst. Clip Harness To S F	3	9	0.03
6	2060	Inst. Clip Harness To S F	4	16	0.10
7	2070	Inst. Clip, Grommet To S F	7	17	0.10
8	2080	Inst. Clip To S F	4	14	0.10
9	2090	Inst. Harn, Clip & Bracket	7	19	0.13
10	2100	Inst. Horn To S F	4	6	0.08
11	2110	Inst. Slip To S f	4	10	0.05
12	2120	Inst. Clip To S F	4	4	0.03
13	2130	Inst. Support T S F	3	3	0.05
14	2140	Inst. Clip To S F	5	24	0.10
15	2150	Inst. Clip To S F	3	3	0.03
16	2160	Inst Clip, Clamp To S F	9	11	0.10
17	2170	Inst Clip To S F	3	6	0.03
18	2180	Inst strap To S F	1	6	0.02
19	2190	Inst Clip To S F	3	6	0.03
20	2200	InstCont Val Sub To S F	3	9	0.13
21	2210	Inst strap To S F	3	7	0.03
22	2220	Inst Val Gp To Cont Val	5	11	0.12
23	2230	Inst Elbow, Hose To Cont	3	3	0.10
24	2240	Inst Pipe As To Cont	5	12	0.07
Total :			98	213	1.82

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

4. Work Center A3405 : Sub-Assembly Floor Plate

No	Op	Process Name	Item	Qty	Run Hrs
1	5010	Inst. Floor Plate To Stan	1	1	0.10
2	5020	Inst. Groom, Supp To PF	4	10	0.10
3	5030	Inst. Valve Gp To PF	3	9	0.07
4	5040	Inst. Step As To Platform	3	10	0.07
5	5050	Inst. Pedal As To Val Gp	4	10	0.10
6	5060	Inst. Suspension to PF	2	5	0.08
7	5070	Inst. Cons Gp Opr To Supp	3	18	0.25
8	5080	Inst. Connector To Val Gp	4	14	0.08
9	5090	Inst. Hose As To Valv Lh	11	16	0.15
10	5100	Inst. Hose As To Valv Rh	10	16	0.15
11	5110	Inst. Valve Gp To Consule	2	12	0.05
12	5120	Inst. Guard Gp , Suipp to PF	10	30	0.15
13	5130	Inst. Lever Gp To PF	4	10	0.07
14	5140	Inst. Lever Gp To Pedal G	4	10	0.05
15	5150	Inst. Block, Conn To PF	5	7	0.05
16	5160	Inst. Plug, Elb, Conn To PF	3	10	0.04
17	5170	Inst. Swich, Elb To PF	4	8	0.05
18	5180	Inst. Hose As To valve	1	2	0.03
19	5190	Inst. Bracket To Platform	6	33	0.10
20	5200	Inst. Strip To Platform	4	10	0.10
21	5210	Inst. Harnnes To Platform	13	76	0.30
22	5220	Inst. Guard, Strip To P H	3	15	0.04
23	5230	Inst Sensor To Floorplate	4	5	0.05
Total :			108	337	2.23

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

5. Work Center A1104 : Sub-Assembly **Swing Frame 2.**

No	Op	Process Name	Item	Qty	Run Hrs
1	4010	Inst. Hose, Clip To Cont V	8	8	0.10
2	4020	Inst. Moun As To S F	5	44	0.13
3	4030	Inst. Hose As To Cont V	11	24	0.23
4	4040	Inst. Tube As To Cont V	14	30	0.28
5	4050	Inst. Bracket To Plaform	5	13	0.10
6	4060	Inst. Clip To Platform As	5	17	0.07
7	4070	Inst. Hyd Tank To S F	3	13	0.27
8	4080	Inst Fuel Tank To S F	3	9	0.20
9	4090	Inst. Box Gp To S F	3	8	0.10
10	4100	Inst. Pipe As To Hyd T As	4	10	0.10
11	4110	Inst. Strap Cable To Hyd	4	4	0.05
12	4120	Stamping Unit (Serial No.)			0.33
Total :			65	180	1.96

6. Work Center A1106 : Sub-Assembly **Engine**

No	Op	Process Name	Item	Qty	Run Hrs
1	6010	Inst. Pump Gp To Eng Ar	8	36	0.33
2	6020	Inst. Brack To Eng Ar	5	36	0.16
3	6030	Inst. Lines Gp Drain To M	7	7	0.10
4	6040	Inst. Brack To Eng Eng Block	3	7	0.05
5	6050	Inst. Clip To Bracket Eng	3	3	0.03
6	6060	Inst. Lev As To Engine	3	5	0.05
7	6070	Inst. Clip To Bracket Eng B	4	4	0.03
8	6080	Inst. Elb As To Pump Gp	9	23	0.08
9	6090	Inst. Strap, Clamp To Eng	3	3	0.02
Total :			45	124	0.85

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

7. Work Center A1106 : Sub-Assembly **Swing Frame 3.**

No	Op	Process Name	Item	Qty	Run Hrs
1	6100	Inst. Strap As to S F	3	3	0.02
2	6110	Inst. Cont Gp Gov To S F	6	10	0.12
3	6120	Inst. Eng Ar To S F	6	28	0.17
4	6130	Inst. Clip, Strap To Eng B	5	12	0.08
5	6140	Inst Strap As To Eng Blo	2	2	0.02
6	6150	Inst Clip To Engine	17	31	0.20
7	6160	Inst Brack, Clamp To Eng	7	7	0.07
8	6170	Inst Cable To Motor stat	2	2	0.02
9	6180	Inst Bracket To Pump	3	5	0.03
10	6190	Inst Clamp To Eng Gp	1	2	0.02
11	6200	Inst Elb, Hose As To Tank	21	29	0.35
12	6210	Inst Hose Fuel To Eng	12	32	0.22
13	6220	Inst Hose As To Pump Gp	13	58	0.37
14	6230	Inst Pipa As To Valve Gp	10	19	0.25
15	6240	Inst pipe As To Pump Gp	7	13	0.20
16	6250	Inst Strap To Harnnes	3	6	0.05
17	6260	Inst Clip,Brack To Pump	3	3	0.03
18	6270	Inst Sheet As To S F	2	4	0.10
Total :			123	266	2.32

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

8. Work Center A1108 : Sub-Assembly Swing Frame 4.

No	Op	Process Name	Item	Qty	Run Hrs
1	7010	Inst Radiator To S F	10	16	0.17
2	7020	Inst. Guard As To Radiator	5	23	0.10
3	7030	Inst. Brace To Radiator	4	6	0.10
4	7040	Inst. Hose R Gp To Eng Ar	2	4	0.07
5	7050	Inst Swivel As To Radiat	11	32	0.28
6	7060	Inst Pipe As To Valve Gp	6	18	0.25
7	7070	Inst Pipe As To Oil Cool	7	18	0.23
8	7080	Inst Brack As To S F	6	10	0.13
9	7090	Inst Tank As To S F	7	11	0.13
10	7100	Inst Lins Gp To Fill Gp	4	4	0.08
11	7110	Inst Elb As To Pilot Fil	15	16	0.25
12	7120	Inst Lins Gp Pilot	3	3	0.05
13	7130	Inst Clip, Strap To H Swi	4	10	0.20
Total :			84	171	2.04

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

9. Work Center A1109 : Sub-Assembly **Swing Frame 5.**

No	Op	Process Name	Item	Qty	Run Hrs
1	8010	Inst Supp As To S F	5	11	0.17
2	8020	Inst Sheet As To Supp As	3	7	0.12
3	8030	Inst Support As To S F	2	3	0.05
4	8040	Inst Sheet As To Supp As	4	12	0.20
5	8050	Inst Sheet As To Supp	3	10	0.17
6	8060	Inst Supp As To S F	2	5	0.08
7	8070	Inst Panel Gp To Sheet A	6	18	0.17
8	8080	Inst Harness Gp To Panel	15	41	0.15
9	8090	Inst Sheet As To Supp As	2	3	0.15
10	8100	Inst Supp As To Supp As	2	5	0.08
11	8110	Inst Supp As To	2	3	0.05
12	8120	Inst Strap To Cover	1	2	0.03
13	8130	Inst Sheet To Supp As	2	9	0.15
14	8140	Inst Supp As To S F	2	5	0.08
15	8150	Inst Supp to S F	5	11	0.12
16	8160	Inst Supp As To S F	2	5	0.08
17	8170	Inst Cover As To Supp As	2	5	0.08
18	8180	Inst Sheet As To Supp	3	9	0.15
19	8190	Inst supp As To S F	2	8	0.20
Total :			65	172	2.28

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

10. Work Center A1110 : Sub-Assembly Swing Frame 6.

No	Op	Process Name	Item	Qty	Run Hrs
1	9010	Inst Sparator Gp	14	25	0.32
2	9020	Inst Battery To S F	10	12	0.30
3	9025	Inst Hose Wiver	7	23	0.20
4	9030	Inst Air Cleaner To Supp	3	9	0.08
5	9040	Inst Hose Radi To Eng Ar	5	6	0.12
6	9050	Inst Strap Clr Switch	2	3	0.05
7	9060	Inst Cover As To Supp	2	5	0.08
8	9070	Inst Door As To Supp	5	8	0.17
9	9080	Inst Door As To Supp	5	8	0.17
10	9090	Inst Straiker To Door As	9	32	0.22
11	9100	Inst rod To Supp As	4	6	0.07
12	9110	Inst Striker To Supp	5	9	0.10
13	9120	Inst Hose As To Tube As	23	32	0.67
14	9130	Inst Door As To Supp As	5	8	0.12
15	9140	Inst Supp As To Door As	9	16	0.17
16	9150	Inst Door As To Supp As	6	13	0.13
17	9160	Inst Striker To Supp As	5	9	0.08
Total :			119	224	3.05

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

11. Work Center A2101 : Sub-Assembly Base Frame.

No	Op	Process Name	Item	Qty	Run Hrs
1	1010	Inst Gear Gp Bearing	4	82	0.42
2	1020	Inst Tube As	4	6	0.07
3	1030	Inst Swivel Gp	4	15	0.12
4	1040	Inst Drive Gp-Final	3	66	0.37
5	1050	Inst Sproket Gp	2	34	0.33
6	1060	Inst Lines Gp T Motor	16	113	0.83
7	1070	Inst Cover	4	6	0.03
8	1080	Inst B Frame To OTP	1	1	0.12
9	1090	Inst Roller Gp	3	126	0.28
10	1100	Inst Guard Gp -Track	3	18	0.17
11	1110	Inst Idler Gp LH	3	6	0.13
12	1120	Inst Idler Gp RH	3	6	0.13
13	1130	Inst Film Warning	2	10	0.07
14	1140	Inst Carrir Rolle	2	8	0.10
Total :			54	497	3.17

12. Work Center A4111 : Process Docking, Fuel and Oil.

No	Op	Process Name	Item	Qty	Run Hrs
1	10010	Laying Track Shoes Gp	1	2	0.33
2	10020	Mount Base Frame	1	1	0.08
3	10030	Inst Lubri Dan Sealant	2	2	0.13
4	10040	Inst. Swing Frame Gp.	4	76	0.47
5	10050	Inst. Tube to Swing Fr	2	2	0.03
6	10060	Inst. Boot To Swivel Gp	5	19	0.12
7	10070	Inst. Support to Swiv	3	5	0.05
8	10080	Inst. Drive Gp Swing	8	31	0.35
9	10090	Inst. Hose to Swivel	8	48	0.33
10	10100	Inst Hose As To Drive Gp	8	53	0.28
11	10110	Inst Elb.conn,Hose To Dr	6	6	0.13
12	10120	Inst Lubricant Gp	4	4	0.37
13	10130	Inst Pin Master To Link	3	8	0.13
Total :			55	257	2.80

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

13. Work Center A4112 : Install Counterweight and Testing.

No	Op	Process Name	Item	Qty	Run Hrs
1	11010	Inst Lin, Insulat To Crwt	10	16	0.17
2	11020	Inst Crwt	5	14	0.35
3	11030	Inst Spring To Supp As	4	5	0.08
4	11040	Pressure Test			1.33
5	11050	O R Test			0.50
Total :			19	35	2.43

14. Work Center A3613 : Sub-Assembly Boom, Stick & Bucket.

No	Op	Process Name	Item	Qty	Run Hrs
1	12010	Inst Lines Gp Grease	14	39	0.50
2	12020	Inst Lines Gp To Boom	15	80	0.82
3	12030	Inst Cyl Gp Stick To Boo	7	8	0.10
4	12040	Inst Lines Gp Bucket	11	16	0.15
5	12050	Inst linkage Gp To Stick	10	24	0.33
6	12060	Inst Bucket Gp Sub Assy	4	19	0.12
7	12070	Inst Bucket Gp Sub Assy	5	19	0.17
Total :			66	205	2.19

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

15. Work Center A5614 : Install **Sub-Boom, Stick and Bucket.**

No	Op	Process Name	Item	Qty	Run Hrs
1	13010	Inst Boom Gp Sub	9	11	0.18
2	13020	Inst Cyl Gp Boom	6	19	0.17
3	13030	Inst Stick Gp Sub	7	8	0.15
4	13040	Inst Cyl Gp Stick	6	7	0.12
5	13050	Inst Hose As To Stick	2	4	0.13
6	13060	Inst Bucket Gp Stick	5	7	0.17
7	13070	Inst Linkage Gp To Buck	4	6	0.13
8	13080	Inst Adjuster Gp To Buck	5	19	0.13
9	13090	Inst Lubricant Gp	1	2	0.18
10	13100	Flushing			0.42
11	13110	Performent Test			0.50
Total :			45	83	2.28

16. Work Center R1016 : **Steam Washing.**

No	Op	Process Name	Item	Qty	Run Hrs
1	14010	Steam Washing	1	1	1.50

17. Work Center R2017 : **Sanding.**

No	Op	Process Name	Item	Qty	Run Hrs
1	15010	Sanding	1	1	1.50

18. Work Center R4019 : **Masking and Painting.**

No	Op	Process Name	Item	Qty	Run Hrs
1	16010	Masking	1	1	1.50
2	17010	Yellow Primer paint	1	1	0.20
3	17020	Yellow Finish Paint	1	1	1.50
Total :			3	3	3.20

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

19. Work Center R5020 : Decall.

No	Op	Process Name	Item	Qty	Run Hrs
1	18010	Paint Blak Decall	1	1	2.25
2	18020	Paint Black Track	1	1	1.15
Total :			2	2	3.40

20. Work Center R6027 : Install Cabin for Operator.

No	Op	Process Name	Item	Qty	Run Hrs
1	19010	Inst Panel, Clip To Cabin	9	14	0.27
2	19020	Inst Lighting Gp To Cab	7	12	0.23
3	19030	Inst Lighting Gp To Cab	8	14	0.23
4	19040	Inst Cabin To Platform	6	22	0.38
5	19050	Inst Heater To Platform	5	15	0.22
6	19060	Inst Duct Gp To Cabin	6	11	0.40
7	19070	Inst Cover Gp To Cabin	7	16	0.07
8	19080	Inst Visor Gp Cabin	12	26	0.30
9	19090	Inst Bumper To S F	3	9	0.07
10	19100	Inst Hood Gp To Supp As	11	22	0.27
11	19110	Inst Cover As To Supp as	5	13	0.15
12	19120	Inst Guard Gp Bottom	9	44	0.45
13	19130	Cover guard Track Mot	3	10	0.10
Total :			91	228	3.14

Lampiran 17

DATA DETAIL PROSES PERAKITAN 320C HEX

21. Work Center R7022 : Install Enclosure.

No	Op	Process Name	Item	Qty	Run Hrs
1	20010	Inst. Film to Unit	30	45	1.13
2	20020	Inst. Film to Cabin	12	12	0.28
3	20030	Inst Seat Dan Harnnes	5	10	0.28
4	20040	Inst Tank Gp-Washer W	4	3	0.07
5	20050	Inst Cont Gp-Operator	6	10	0.13
6	20060	Inst Lighting Gp To Boom	11	24	0.28
7	20070	Inst Supp Gp Greas Gun	3	5	0.05
8	20080	Inst Step As To Fender	2	3	0.04
9	20090	Inst Handrail Gp	6	11	0.17
10	20100	Inst Bar As Gp-Mirror	4	13	0.08
11	20110	Inst Cover Gp Fender	44	9	0.10
Total :			127	145	2.61