Log Book From 19-07-2020 To 25-07-2020

Num.	Date	Day	Log/Activity
1	19-07-2020	Sunday	-N/A
2	20-07-2020	Monday	8.00 am - We are being briefing by HR on what is the main objective and background for MATTEL (Malaysia) 12.00 noon - We have being assigned by HR on our Supervisour (SV) 2.00 pm - Tour around the Production area , explained briefly by the SV assistant about the process that undergoes
3	21-07-2020	Tuesday	8.00 am - We undergoes Kaizen 555 at PNO department . We detect some issue that need to be solved which is there is a gap between that windows car and the body of the car . We met with PIM Leader where they are the one who produce that window . The issue is the pin that to plug to the body is a little bit longer than the usual that cause the gap . Then we solved this problem by taking up new limit and test again the product and the issue is settle ,This Kaizen 555 takes around 7 hours to investigate and solved the issue 3.30pm - We discuss the issue and precise the problem statement and the objective to be recorded into the report
4	22-07-2020	Wednesday	8.00am - Me and Rashna (Partner) undergoes Kaizen 555 at the PIM department where the project is about to reduce the Black Pigment percentage (Black Master) in the Casis Part from 1.6% to 1.3% 10.30am - We run some test on the Casis to test the colour of the Black Pigment is the any changed on the colour or not . This test takes around 60min to produce a different type of sample . 2.00pm - We met a few people to comfirm our calculation and to check the quality of the material if that the material is approved to be used in the production .
5	23-07-2020	Thursday	8.00am - Me and Rashna (Partner) undergoes Kaizen 555 at the Barbell Deperment (Producing wheels) 8.15am - We met Bala (Supervisour) and discuss about the issue and project that occurs at Barbell .The issue is to reduced the movement of the operator to troubleshoot the machine so we can improve and let the operator handle more machine.

Num.	Date	Day	Log/Activity
			9.30am - Start taking a few sample and data from the movement of the Operator from machine to another machine and also the average time for the operator to troubleshoot the machine . 2.00pm - We tabulated the data into table and start to brainstorm the idea how to overcome and solved this issue
6	24-07-2020	Friday	9.00am - Handle a booth that have been proposed by the company along time ago which is " Roadshow untuk Program Saya Boleh " . This allowed a stages of workers to Share their thoughts on improvement on their workplace. 2.30pm - Having a presentation throughout the week about Kaizen 555 with all the manager and have a a bit discussion about the progress and the achievement
7	25-07-2020	Saturday	-N/A

Company Supervisor Signature

Log Book From 26-07-2020 To 01-08-2020

Num.	Date	Day	Log/Activity
1	26-07-2020	Sunday	-N/A
2	27-07-2020	Monday	8.00am - Me and Kak Nani (Partners) , we undergoes KAIZEN 555 at the TAMPO Department . 8.35am - Met the Leader of the TAMPO and discuss the issue and problem that have been landing at the TAMPO 9.45am - Takes some data on the Nest that have been rejected due to some influenced by the ink , not in a good shape and so on . This takes long time to do some QC all the nest about 25 model . 2.30pm - Do some report and data tabulation on the reading that have been taken on morning inspection .
3	28-07-2020	Tuesday	8.00am - Me and Kak Nani (Partner) undergoes Kaizen 555 at the Tampo Depertment . 8.30am - We met the leaders and ask any problem that happen and get some briefing on the issue that occured . 9.00am - We inspect every machine that run the Model on Standard Machine (STD) only because STD undergoes alot of nest around 24 - 32 nest . So there will be alot of Nest to be checked on . So we try to figured out is there any nest block on the STD machine . 12.00Noon - We start to inspect other nest that are going to run on other Mix at the nest locator . Around 25 Model needed to be inspect on . We checked each nest on everymodel that is there any defect so we can prevent any loss on the production . This takes alot of time to inspect the nest and the data been collected .
4	29-07-2020	Wednesday	8.00am - Me and KakIda (Partners) we undergoes Kaizen 555 at Die Casting Department . She introduce me to the Leader , Supervisour and also every line leader . 8.45am - We firstly met the Die casting engineer asking for a Issue that happened at the Die Casting Department . The issue is the mold that produce my the machine does not run properly where the airpocket is harder and cause defect where the defect cannot be removed by the other machine , so it cause alot of time for the operator to trimming and cause lateness to the schedule .

Num.	Date	Day	Log/Activity
			10.00am - We ask the Die Stop Centre to reset again the mold where we open the airflow for the alloy does not flow and allow only one hold for the airpocket . 10.45am - We wait for the body to be produce and wait for the result and its worked . 12.00Noon - Then to be more clear the body need to spray on in Reinsbergh and this takes along progress to wait for the body to be coated with colours where we more clearly see that is there any defect or not after we change the new mold .
5	30-07-2020	Thursday	0800Hours - Me and Kakida (Partners) we undergoes Kaizen 555 at the Die Cast Department . \ 0900Hours - We GEMBA the department and found some defect issue .The problem is the body casis is to soft why when we undergoes separation process , the air pocket when goes down . Should be the air pocket must be stay on for to be socket on the ransburg processs. Almost 50% of the Casis were defected . 1000Hours - We pass on the mold to the engineer to be adjusted for to be thick more the air pocket so it does not separate during the process . 1300Hours - We start to run again the mold to see wheather the air pocket separate again from from the casis or not . 1400 Hours - The airpocket is good and ready to go for a long process and there is no more defect on the casis .
6	31-07-2020	Friday	-Raya Haji
7	01-08-2020	Saturday	-N/A

Company Supervisor Signature

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Log Book From 02-08-2020 To 08-08-2020

Num.	Date	Day	Log/Activity
1	02-08-2020	Sunday	-N/A
2	03-08-2020	Monday	-Apply Leave
3	04-08-2020	Tuesday	0800Hours - Start to undergoes my major project where i must do some research on Pearl Grey . To reduce the usage of Met Gray from 2% of usage to 1.8%. 0845Hours - I met up with Danial one of inchage at PIM Department . Discuss the process and the detail more the project and he delivered the exact value usage of the Pearl Grey. 0900Hours - Done my calcution the meet up with Ooi to ask a few questions and guidance . The this project help by Badrol the Line Leader for Shift A . We prepared the subtances for this project at the material store . 0940Hours - We start to run it on the M4 Machine . This takes a few time to processs and produce the sample . 1100 Hours - Done for the 1.8% sample . We decide to continue it on tomorrow because there it urgent item need to be run on back . 1200Hours - Me and KakIda (Partners) runs Kaizen 555 at the A&P . Where we discuss on the 3 machine and takes the actual time for each machine , and also what are the root cause for any product that stop . This takes long of observation almost 3 Hours to collect the data .
4	05-08-2020	Wednesday	0900Hours - I continue again my major project at PIM Department with the help of form Abang Badrul (Line leader from Shift A) . We run one more test on the product where 2% of Pearl Grey . 1130Hours - Once i get the result sample , i directly met up with Danial the Colour Engineer to be check up the colour quality is there any changes or can be accepted or not for the min-max of the standardize of colourisation. The result if approved 1400Hours - Then i helped up KakIda (partner) to undergoes Kaizen 555 at the A&P Department . We do some improvement at the 3CAR Machine . Do new procedure for the process to reduce the time cycle for the output . Also put limit to the glue jug and glue storage .

Num.	Date	Day	Log/Activity
5	06-08-2020	Thursday	0800Hour - We undergoes Kaizen 555 at Die Cast Department . The issue that we caught is the body have defect that already run until ransberk 0850Hour - We met up with the Line Leader to identify the problem . Then we undergoes GEMBA at the machine 67 and 34 . 0930Hours - The remaining body that already produce we undergoes it to separation machine to see wheather the body still have defect or not. Once it done , the body that have defect was only from Machine 34. 1015Hours - Machine 34 was the mold is problem . We found up that the indicator also at the red zone . We ask for the technician to checkup the indicator and setup again the mold to the mold centre. 1100Hours- The issue that we received feedback from the Mold centre was the mold has defect where the gate for the alloy was overflow hence that cause the body to defect. The Mold centre technician repair the mold and this process takes afew time to weld it again 1300Hour- We checkup the results that the body that produce by machine34 are good after the repairing process.
6	07-08-2020	Friday	8.00am - Me and KakIda (Partners) we undergoes Kaizen 555 at Die Casting Department . She introduce me to the Leader , Supervisour and also every line leader . 8.45am - We firstly met the Die casting engineer asking for a Issue that happened at the Die Casting Department . The issue is the mold that produce my the machine does not run properly where the airpocket is harder and cause defect where the defect cannot be removed by the other machine , so it cause alot of time for the operator to trimming and cause lateness to the schedule . 10.00am - We ask the Die Stop Centre to reset again the mold where we open the airflow for the alloy does not flow and allow only one hold for the airpocket . 10.45am - We wait for the body to be produce and wait for the result and its worked . 12.00Noon - Then to be more clear the body need to spray on in Reinsbergh and this takes along progress to wait for the body to be

Num.	Date	Day	Log/Activity
			coated with colours where we more clearly see that is there any defect or not after we change the new mold .
7	08-08-2020	Saturday	-N/A

Company Supervisor Signature

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Log Book From 09-08-2020 To 15-08-2020

Num.	Date	Day	Log/Activity
1	09-08-2020	Sunday	-N/A
2	10-08-2020	Monday	0800Hours - I undergoes Kaizen 555 at the Die Casting department . The issue that we get from gemba finding is the body for L2851 model is reject because the post of the model is longer from the actual sample so when undergoes tampo the design does not follow the requirement and the body a little bit bigger from the eyesight . This is the feedback from from the operator from die cast and tampo department. 0900Hours - We get into machine 78 and 62 where the body for L2851 produced . We find that the spray water for the machine is not functioning well and it does not follow the requirement standard reading . So we ask for the technician to look over the machine and we waited for the feedback sample . 0950Hour - We met up with the QC to check whether the post issue can be settle or not . Hence once we try on the reject sample for mating , the mating is comfirm accepted . So the issue of long post is affected only on the tampo department . This problem also being discuss on with the Engineer of Die cast and also the leader . 1100Hour - We met up with Shava the engineer of tampo for to check on the nest and the body post . Then we together moved to A&P to check whether the long post is affected on assembly or not . 1400Hour - The results from assembly are good . So the issue for the long post is settle only the tampo issue . So to overcome this issue is , Shava he approved that to put abit hole on the nest so that during tampo then body fully in with the long post . This process require along process where have to meet up with the techincian at the tampo to be put ahole .
3	11-08-2020	Tuesday	0800Hours - We undergoes Kaizen 555 at OMC Department . We met up the leader and ask for is there any problem that happen around the department . 0900Hours - The issue is one of the model for 9car is defect cause of the nest . The nest already changed to a new nest but still have a defect where the painted colour from tempo removed and also when casis undergoes mating it really hard to remove from the nest and cause the new operator hard to achieved the actual cycle time . 0945Hours - We do a few run test where we ask for old operator to run the model so is there any issue from different cycle time . Hence old operator is much better but still have a defect on the painted colour .

Num.	Date	Day	Log/Activity
			1020Hours - We ask for the Technician to put a tape on the nest to avoid the nest cause the scratches and defect to the painting . Even though it is not proper but it is a short term improvement. 1100Hours - We find a few nest from the nest storage for the same model and then try run it on the machine . Hence after we run it even on the new operator , the result is going good . From our observation the nest was alittle bit bigger that the actual one on the machine . So the issue for the defect and hard to removed from the nest is settle . 1345Hours - We met up with the nest technician , and ask why this issue happen same type of model but 1 is defect , the other 1 does not have defect on the model . The technician said that , the issue is mold to produce the body have 6 mold , but for nest only 1 mold . So there will be a slightly different from a mold to another mold so there is caused for the defect . Hence the improvement that we can make is , ask for the mold technician for sync the mold nest and also body mold.
4	12-08-2020	Wednesday	0800Hours - We undergoes Kaizen 555 at A&P Department , where we are more focus on DADS MACHINE 0830Hours -We met up with the leader of the DADS , and ask for any issue that occurs . The leader ask for to do Kaizen at DADS Machine 40 where she said it doesnt reach target of output 0900Hours - The issue that occours is the casis for the model GJV5109 it has some short-short on the hole where the operator have to push abit or hit with small hitter during mating process and it will increase the cycle time and also it will slow down the operator . 1000Hours - After GEMBA at the machine , we found that the casis have alot of problem that need to be rework , because of the short-short and flash . Only cavity 2 is in good condition , but cavity 3 and 5 have a problem . 1030Hours - We go down to the Die Cast Department to ensure that this casis does not proceed . We met up with the Leader for Rework ask for to sent a few operator to rework the remaining casis at the Dads 40 at the A&P . 1115Hours - Then we met up also with the Die Cast centre to ask for repair the mold and inform for the defect that occurs at casis . Then the tech said that the are going to repair the mold for a while and replace the current mold with the new mold cavity 1 and its a good one.

Num.	Date	Day	Log/Activity
			1345Hour - The result that produce were in good condition and it doesnt have any defect on the casis .
5	13-08-2020	Thursday	0800Hours - We do Kaizen 555 at Tampo Department . Then we met up with the leader and ask for any issue or problem that occurs 0830Hours - The problem that occours is model of GRX73 , its has excessive runner . From 50 sample that we take , we found that 20 of it has defect (40%) . The excessive runner cause the paint from tampo to peel off and no covered properly. 0915Hours - The we move to the PIM Deparment , then we met with the leader and show the problem that having on model GRX73 . The leader approved that there is a bit excessive runner that affected the paint . 1000Hours - The mold has been down for cavity 3 and 4 on machine M4-26 . The mold centre will repair the mold and this process takes abit longer time to repair . 1400Hours - Once the mold has been done and then we take the sample that produced . 1420Hours - We run test again the new sample on the Tampo Department . 1445Hours - We found back there is some defect again but not from the runner , and its a new defect maybe cause by the remold and it is a flash . This issue release affected the output , where from 40 sample we took , 15 of it has defect . 1530Hours - We sent again for the mold to be remold again at the mold centre .
6	14-08-2020	Friday	0800Hours - Goes back to the PIM department to check on the mold that have been remold. 0845Hours - So that the mold still in the process of remold and they run on different type of model on that machine . So this result of kaizen need to be futhur up once the mold is done . 0930Hours - Preparing slide for making presentation on Kaizen 555 this evening. 1430Hours- We are doing presentation of Kaizen 555 for Gung Ho Challenge with all the managers and all other department .
7	15-08-2020	Saturday	-*N/A*-

Company Supervisor Signature

Log Book From 16-08-2020 To 22-08-2020

Num.	Date	Day	Log/Activity
1	16-08-2020	Sunday	-*N/A*-
2	17-08-2020	Monday	0800Hours - We undegoes Kaizen 555 at DIe cast Department . We met up with the leader and ask for is there any issue that need to be covered up or solved 0830Hours - The issue that we get is for model CFG3901 it has defect on the casis where it has some flash and Legal Marking does not appear well . 0915Hours - During gemba finding , the flash only occurs on cavity 1 and the Legal Marking occours on cavity 5 . So we went to the machine 1 where cavity 1 is produced . The result sample produced shows that really has flash on the casis, so we ask for the technician to mold down the machine and run for repair at the mold centre . 1015Hours - We went to the Machine 80 where it is cavity 5 . The result sample shows that the Legal Marking does not appear clearly also .Then we ask for the technician to mold down the machine and sent to the mold centre to being repaired . 1130Hours - After being repaired , we see the result sample for the cavitiy 1 and 5 . The result produced by the machine are still the same where the casis still produced flash and the Legal Marking were not appear clearly also . 1215Hours - Then ,We ask for the both technician to mold down for the both mold to be repaired again at the mold centre . 1400Hours - Then when the mold is done after being repaired . We take the sample for 1 hour . For the first 1 hours the sample is okay . But after that it still be defect . 1430Hours -The technician give some suggestion why not to combine both mold in the same machine because it already run for repair 3 times , so why not give a try . Maybe cause by different combination .
3	18-08-2020	Tuesday	0800Hours - We undergoes Kaizen 555 at PNO Department .We met with the line leader and ask for is there any problem or issue that occurs . 0830Hours - So the issue is during the drilling/mating at the HWAI Machine , it clash with the pin the paint on the casis . So it cause the defect to the model during mating.

Num.	Date	Day	Log/Activity
			0915Hours- Around 35% of 100 were defect cause by the mating issue . Hence we ask for the techinician to troubleshoot the machine . 1015Hours- Once the repair is done , we wait for the result sample per hour to see is there any defect issue again or not. 1230Hours- During the new bin for the model arrived , there is some defect on the casis. The coated paint on the casis were scratches . 1315Hours- The operator said the reject was not during the assembly, it is caused by during the process of the casis to be sent for assembly. 1400Hours -So the improvement is , they need to be carefully handle the casis for the model for the casis does not clash during to be sent to any department
4	19-08-2020	Wednesday	0800Hours - We undergoes Kaizen at A&P Department where more specific is on HWAI section . We find the leader and we discuss is there any issue that need to be covered or issue that need to be settle on . 0830Hours - The issue that we're going to run is , about to improve the output that produced by HWAI . From gemba finding , the time cycle that used by the machine are to high where it is 7.0s per cycle . And also we can see that the operator are to relax during the assembly and mating the model . 0915Hours - The reasons they increase the time cycle because there is issue that the barbel keep on falling during transiton if the time cycle is 7.0s . 0945Hours - We try to take the output for the sample for 1hour for t.s 7.0s . 1100Hours - Then we solved the issue of the barbel , where we ask for the last operator to assembly on the barbel instead of the second operator . Because before this the barbal was assemble on the second operator so thats why the barbell keep falling when its reach on the third operator for t.s 7.0s . 1130Hours - For about 30min , the improvement is okay . Then we start to lower down the t.s to 6.5s where it should be actual t.s for 3 operator operating. 1200Hours - We take the sample for 1hours for this new t.s .

Num.	Date	Day	Log/Activity
			1330Hours - We found that the 6.5s t.s really almost hit the target of the output . Almost 90% to reach the output . Some are because of the operator need to refill up the stock and so on . And also the improvement for the issue being settle up and they can work more better .
5	20-08-2020	Thursday	0800Hours - We undergoes Kaizen 555 at ANP Deparment where more precisely is at DADS . We met up with the Supervisour ,Salina . We discuss the issue that need to be handle on 0830Hours - The issue that we are going to go through is we need to do some improvement on the labour work , where we try on reduced the centre person between line 3 and 4 and add on the jobscope for the last operator at the line 3 and line 4 where they need to put the card in the box . 0930Hours - Then we try on the line3 first where we add on the last operator jobscope to put the card in the box plus with the car . Then we take the result where is there any box that the operator missout . 1030Hours - After 1 hour we take the result , the line 3 operator she make out almost 131box that she didnt make it to put the card . Then we try on operator line 4 to take a sample results . 1145Hours - The results from line4 and line 3 are abit different where line 4 only 45 boxex that didnt make it . The issue is the operator easier to put the card in the box because there's no obstacle . So this operator has the easier way rather than operator at the line3 1200Hours - We let the result to proceed on the see is whether this new improvement can be proceed or not at the line on DADS . 1400Hours - After afew hours we check on the result where there is still lost a few boxex on the operator line 4 b
6	21-08-2020	Friday	0800Hours - We are preparing ourslide for today presentation . Complete all the data , gemba finding and so on . 1430Hours- We are doing presentation of Kaizen 555 for Gung Ho Challenge with all the managers and all other department .
7	22-08-2020	Saturday	-*N/A*-

Company Supervisor Signature

Log Book From 23-08-2020 To 29-08-2020

Num.	Date	Day	Log/Activity
1	23-08-2020	Sunday	-*N/A*-
2	24-08-2020	Monday	0800Hours - We undergoes Kaizen 555 at Tampo Department . We find the leader and we discuss is there any issue that need to be handle on . 0830Hours - The issue that we get is for model GRY69 , its have a problem due to allignment problem where the stability of accurateness of the tampo is around 20% 0915Hours -We do gemba finding during the product is running in the machine , help by the Mohan . 0945Hours - We found that the issue cause the allignment error are because of the base are loose and also the position of the stamp . Also Mohan told that the detail for the model are abit difficult for the paint to stick on the details . 1030Hours -Try by try , removing the stamps , change the position of the stamp to make it equilibrium situation effect the error that occours . 1130Hours - After 1 hours run the machine , the result that are produce are better where the alignment is in its track . 1230Hours- Due to the stamp are torn , we change the the stamp then when we run the machine , the alignment it start to run out of the track again . Then we called out the Technician again to check up , 1400Hours - The issue that cause are the stamp were no placing at the right hole . The sop for this model are alittle bit different from the other model . Then we run for a test again for 1 hour .
3	25-08-2020	Tuesday	0800Hours - We undergoes Kaizen 555 at the OMC Department . We find the line leader and we discuss what are the issue that need to be settle on . 0830Hours - The issue that we find is on machine 32 where the model of the car have a bit flash at the front and at the back of the car . This is cause after drilling the model , the model appear . Around 50 sample almost 35 of the are reject . So we decided to run some kaizen at this model . 0930Hours - We called for tech and ask for why this flash could be happen . It caused by the drilling power are to high cause the flash at the back . And the flash that cause at the infront are caused by the

Num.	Date	Day	Log/Activity
			nest are defected where it have been torn out at the top pin drilling , so when it force to drill down so there will be flash occours . 1030Hours - The improvement that we takes is , where we reduce that power of the drilling but it still reach the maximum and minimum power . 1115Hours - Then for short term action , we put tape at the hole that already defected . Then we met abang mail to ask for to repair the nest that have been broken . 1230Hours - The sample from the short term action are quite good but still need to be monitor is there another defect will occours .
4	26-08-2020	Wednesday	0800Hours - We undergoes Kaizen 555 at ANP Deparment where more precisely is at DADS . We met up with the Supervisour ,Salina . We discuss the issue that need to be handle on 0830Hours - The issue that we are going to go through is we need to do some improvement on the labour work , where we try on reduced the centre person between line 3 and 4 and add on the jobscope for the last operator at the line 3 and line 4 where they need to put the card in the box . 0930Hours - Then we try on the line3 first where we add on the last operator jobscope to put the card in the box plus with the car . Then we take the result where is there any box that the operator missout . 1030Hours - After 1 hour we take the result , the line 3 operator she make out almost 131box that she didnt make it to put the card . Then we try on operator line 4 to take a sample results . 1145Hours - The results from line4 and line 3 are abit different where line 4 only 45 boxex that didnt make it . The issue is the operator easier to put the card in the box because there's no obstacle . So this operator has the easier way rather than operator at the line3 1200Hours - We let the result to proceed on the see is whether this new improvement can be proceed or not at the line on DADS . 1400Hours - After afew hours we check on the result where there is still lost a few boxex on the operator line 4 but it start to reducing everyhour . 1430Hours - We start to discuss on the results , should be proceed on doing this method or be the old way .

Num.	Date	Day	Log/Activity
5	27-08-2020	Thursday	0800Hours - We undergoes Kaizen 555 at Barbell department . We met with Bala the Superviour at the Barbell then we discuss is there any issue that need to covered on or settled . 0830Hours - Then the issue that we are going to investigate or do Kaizen is about excessive amount of barbell that are unused and going to scarp . 0915Hours - We do some calculation on the amount of wheels in 1 bag where the amount is 20 000 of wheels . Then we refer on the schedule on the barbell , we see that the amount of excesive barbell can be reduced if we put the most optimum amount of barbell in one plastic bag which is 16 000 . 1000Hours - Then we proceed on to meet up with the leader of production of wheels , then we ask a few question is there any issue if we reduced to 16 000 . The issue is only about the operator need to be add on task where this issue is can be settle down . Then amount of recycle plastic that are limited . 1100Hours - Then by referring Kak Sara at the office and Pheii , this can be done and we need to calculated if the amount of plastic is enough or can be adjusted to make it enough for the the wheels production . 1230Hours - We makes afew of sample of 16 000 Wheels in 3 plastic then we try on to keep it on the store of barbell on the rack , where it can be in the space that provided , and also from the Operator PPIC , she told that if the amount of wheel is 16 000 it can fit to 3 plastic in one row . 14000Hours - Then after we calculated that , the amount that we can be reduced is alot if we changed the quantitiy of wheels in the plastic from 20 000qty to 16 000 qty .
6	28-08-2020	Friday	0800Hours - We are preparing ourslide for today presentation . Complete all the data , gemba finding and so on . 1430Hours- We are doing presentation of Kaizen 555 for Gung Ho Challenge with all the managers and all other department .
7	29-08-2020	Saturday	-*N/A*-

Company Supervisor Signature

Log Book From 30-08-2020 To 05-09-2020

Num.	Date	Day	Log/Activity
1	30-08-2020	Sunday	-*N/A*-
2	31-08-2020	Monday	National Holiday
3	01-09-2020	Tuesday	0800Hours - We undergoes Kaizen 555 at Tampo Department . We met up with the supervisour Kak Midah and we discuss is there any issue or problem that need to be handle on . 0830Hours - The issue that we facing is model of GRX21 is having tampo problem . The issue is the paint for grey colour is overcome the yellow colour . 0915Hours - We take around 100 sample of model and we found that 50% of the sample we rejected on the paint . This is because the machine run 2 set of output , so the left machine were error . 1000Hours - Then we ask for the technician to overlook the machine over . The problem that we found at that , the stamp were one of the cause for the tampo error . Then we changed for new stamp . Then the next root causes are because of the plate were thin . We adjust on the alignment and do a few run test , and the problem still on going. Then we check the plate and it is the cause . 1115Hours - So we ask for a new plate and run the machine and as we all know it will produced 50% from the real output because only 1 set machine is running . 1400Hours - Then after the plate is done we run the test at the machine and the result is good . So we try run for a test 100 sample and the output is okay .
4	02-09-2020	Wednesday	0800Hours - I undergoes Kaizen 555 at the Die Casting department . The issue that we get from gemba finding is the body for model GRX29 is reject because the post of the model is longer from the actual sample so when undergoes tampo the design does not follow the requirement and the body a little bit bigger from the eyesight . This is the feedback from from the operator from die cast and tampo department. 0900Hours - We get into machine1 , 9 , 29 , 32 where the body for GRX29 produced . We find that the spray water for the machine is not functioning well and it does not follow the requirement standard reading . So we ask for the technician to look over the machine and we waited for the feedback sample . 0950Hour - We met up with the QC to check whether the post issue can be settle or not . Hence once we try on the reject sample for mating , the mating is comfirm accepted . So the issue of long post

Num.	Date	Day	Log/Activity
			is affected only on the tampo department . This problem also being discuss on with the Engineer of Die cast and also the leader . 1100Hour - We met up with Shava the engineer of tampo for to check on the nest and the body post . Then we together moved to A&P to check whether the long post is affected on assembly or not . 1400Hour - The results from assembly are good . So the issue for the long post is settle only the tampo issue . So to overcome this issue is , Shava he approved that to put abit hole on the nest so that during tampo then body fully in with the long post . This process require along process where have to meet up with the techincian at the tampo to be put ahole .
5	03-09-2020	Thursday	0800Hours - Me and KakIda (Partners) we undergoes Kaizen 555 at Die Casting Department . She introduce me to the Leader , Supervisour and also every line leader . 0845Hours - We firstly met the Die casting engineer asking for a Issue that happened at the Die Casting Department . The issue is the mold that produce my the machine does not run properly where the airpocket is harder and cause defect where the defect cannot be removed by the other machine , so it cause alot of time for the operator to trimming and cause lateness to the schedule . 1000Hours - We ask the Die Stop Centre to reset again the mold where we open the airflow for the alloy does not flow and allow only one hold for the airpocket . 1045Hours - We wait for the body to be produce and wait for the result and its worked . 1230Hours - Then to be more clear the body need to spray on in Reinsbergh and this takes along progress to wait for the body to be coated with colours where we more clearly see that is there any defect or not after we change the new mold .
6	04-09-2020	Friday	0800Hours - We are preparing ourslide for today presentation . Complete all the data , gemba finding and so on . 1430Hours- We are doing presentation of Kaizen 555 for Gung Ho Challenge with all the managers and all other department .
7	05-09-2020	Saturday	-*N/A*-

Company Supervisor Signature

Log Book From 06-09-2020 To 12-09-2020

Num.	Date	Day	Log/Activity
1	06-09-2020	Sunday	-*N/A*-
2	07-09-2020	Monday	0800Hours - We undergoes Kaizen555 at PNO Department . The met up with the leader and we discuss a the issue that happen and need to be solved on . 0830Hours - The issue is the for model _____ , the nest for the model is to tight where we need to do extra forces to remove the model from the nest. Also next problem is , the body of the model we have a bit of flash on the parts where when we do spinning on the model , it cannot be assemble properly one of the parts . 1000Hours - From 100sample that we take , around 50 sample that have flash and have difficulty to asssemble the model .Then almost 15 out of 16 nest that need extra forces to remove the body from the nest . 1100Hours - We met with Abang Mail (nest) and tell him the issue of the nest . He says that yes the nest abit tight to the body . So he re-nest again the nest to make it bigger from the actual size of the nest . 1130Hours - All the model were been rework process by the operator to remove that flash . 1300Hours - Then when the new nest is done , we assemble the nest to the machine , and then we give a few run test . We can see that the new nest give a good result where we do not need to do extra forces to remve the body from the nest only just picking up like that . Then we see the results is there any defect issue occours after settle down the nest and the flash issue .
3	08-09-2020	Tuesday	- Not coming -
4	09-09-2020	Wednesday	0800Hours - We undergoes Kaizen 555 at A&P Department . We continue on the kaizen before where we are going to reduce the operator between Line 3 and Line 4 . 0830Hours - For this time , we make a little bit change where we interlude putting of the layer in the box for the line 3 and line 4 . 1000Hours - The results for the changes that we make is better , because the operator still have a gap time to put the layer . 1200Hours - After along time observation , we can see that a few problem occours when operator at line 3 start to not putting the layer

Num.	Date	Day	Log/Activity
			because of her hand is hurt and so arounf 70 box that line 4 need support than her responsible . 1300Hours - So based on the output , we can see that the output is achieved as same the previous shift but the movement of the conveyer is abit slow than the previous shift . But we can say that this process is accepted .
5	10-09-2020	Thursday	0800Hours - We undergoes Kaizen 555 at Tampo Department . We met with the Leader of the department and we discuss is there any issue that need to be handle on . 0830Hours - The issue that we are facing is the alignment for GHB61-3119 is quite not as set up . The shape of the star is not in its place and cause defect for tampo . 0915Hours - From the sample that we takes , around 20/100 sample were on the alignment issue . We called the technician to take a look for the machine . 0945Hours - From the observation that we takes , the issue cause this alignment is the stamp is corrupted which is it start to expand . And also the technician re-alignment again the table for the tampo . 1030Hours - The technician change over the stamp and then he run a few test for the model after the change over . 1115Hours - We met with Arvin to discuss abit about the design for the middle star , We give some idea that why not we let the size of the star is bigger that the actual size because if the alignment problem occours again , the defect we still cannot see the white paint because the star is bigger than its alignment . 1200Hours - Me , Pei Kei and TT Koh , we went to the A&P to do some observation on DADS . 1230Hours - We try another run for the line 3 and 4 , where line 3 put the layer then if line 3 didnt make it to put the layer , then the line 4 will be backup . So we do the run test around 1 hour and 30min . 1400Hours - The result that we get is , we can proceed with this idea , and the output still in it range , but the process is abit slow because we are trying to implement a new procedure .
6	11-09-2020	Friday	0800Hours - I was assigned to do slides based on Kaizen 555 through out the weeks and before . This slide is required to print out and to paste it on the board . It will represent to the operators what

Num.	Date	Day	Log/Activity
			have been done and the achievement that Kaizen 555 has been done . 1030Hours - This takes a long time because needed to prepared the slides for 16 slides with different department . 1430Hours - As always , we will undergoes presentation for the Kaizen555 for the throught out this weeks . We do the presentation with all the Kaizen555 members including the operator and also all the managers for each department will be sitting for the presentation .
7	12-09-2020	Saturday	-*N/A*-

Company Supervisor Signature

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Log Book From 13-09-2020 To 19-09-2020

Num.	Date	Day	Log/Activity
1	13-09-2020	Sunday	-*N/A*-
2	14-09-2020	Monday	0800Hours - We undergoes Kaizen 555 at Tampo Department . We met up with the leader and we discuss on the issue that happening at tampo . 0830Hours - During gemba finding at VUM , we continue on the issue for keris clip and ez clip . We are trying to get the best solution for the problem for keris clip . 0900Hours - We let the operator to racking the model first on the keris clip (first trolley) and then we take the cycle time for the trolley . Then we take the cycle time for the ez clip on the second trolley . 1000Hours - While waiting for both trolley to be VUM , we go to the repairing clips and we do gemba at there . We take the cycle time on how long we they need time to repair the clip .Around 1 Hours that need to be repair for 1 trolley . 1045Hours - Then we go to the blending for the spindle trolley . We do some gemba finding also , to seee , how much spindle that we can take on at one time . And also we get the cycle time for 1 spindle can be clean on . The operator say that , for 4 spindle we can be done in 3 mins . And then we went to spray the spindle to clean it with water . 1130 Hours - The operator says that he need to do it alone for the 2 process , the cleaning of the vum and then clean it with water . 1330 Hours - For the first time vum , the clip are still in the good condition . Then we proceed on for the second vum , to see are they clips still can be racking after 2 times .
3	15-09-2020	Tuesday	0800Hours - We undergoes Kaizen 555 at OMC Deparment . We met up with the line leader and we do some discussion is there any issue that need to be solved on . 0830Hours - We found a few issue which is for Model GHB47 (Party Wagon) . The assembly for the model is mistakes by the operator . Almost 240box need to be rework on because of misassembly during line . The issue cause is the interior that operator assembly to the model is inverted , and then go through spinning process . 0900Hours - We try a run test again for the model , to see is there any idea or suggestion to improve the design of the model .

Num.	Date	Day	Log/Activity
			0915Hours - We decided to improve on the model based on the pin inside the interior for a bit longer . So when operator pun the interior inverted , the interior will push up because of the longer pin . So we met up with the engineering (Hong) to discuss about the improvement on the model . 1000Hours - Next issue is , on model GRX95 . During gemba on the line , the issue that occours is , during spinning the model on the machine , the casis is burst due to spinning . 1030Hours - We do a few tests on the model where we try to mixed on the casis number , where casis 3 , interior 3 . Then we changed to casis 4 , interior 4 . Then we interlude where casis 3 , interior 4 . 1100Hours - So after we run test on different interior and casis , the issuefor casis burst is not about them . Then we try to adjust on the power of the spinning . We ask for operator to change the power. 1130Hours - Then the issue burst on the casis is done , and we check for the model to the QC and it is approved because the pin was not in full spinning because we lower down the power , but it is still in acceptable from QC . 1200Hours - For model GHB47 we keep on discussing about the pin that we want to long abit from the actual pin so we still in process of discussion .
4	16-09-2020	Wednesday	- Hari Malaysia -
5	17-09-2020	Thursday	0800Hours - We undergoes Kaizen 555 at Barbell Department . We met up with the supervisour and the leader , we discuss on what issue is barbell having on . 0830Hours - The issue that we are having is for axle wire is being excessive wire and being thrown away . 0900Hours - From the leader and operator that we are doing kaizen , the reason that this issue having is because , when the operator takes the axle wire from the storage , they dont have a specific amount or reading that they need to be taken .They take as much as they want or less they want . 0945Hours - We do gemba around the barbell machine and see the amount axle wire that the operator have been taken . Around 15 out of 83 machine where the operator takes excess of axle wire that the machine can be supported . 1030Hours - They we decided to find the ideal weight that the machine can be afford . So we run afew test which is we try to the

Num.	Date	Day	Log/Activity
			machine which machine is okay . From the test the most ideal weight is (3.00 - 3.50)kg . 1130Hours - So we set up a weighing place for the axle wire need to be weight , and we set up also the SOP for the operator to follow on when they refill again the machine with the axle wire. 1300Hours - For the excessice axle wire for 2 shift before , we weight the wire and the wire is 11.5kg . It is alot amount of wire that we can be saved on . 1330Hours - So for the result is there any wire excess or not , we let all the operator to use the axle wire (3.00 - 3.50)kg . Then wait for the results .
6	18-09-2020	Friday	0800Hours - We are preparing ourslide for today presentation . Complete all the data , gemba finding and so on . 1430Hours- We are doing presentation of Kaizen 555 for Gung Ho Challenge with all the managers and all other department .
7	19-09-2020	Saturday	-*N/A*-

Company Supervisor Signature

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Log Book From 27-09-2020 To 03-10-2020

Num.	Date	Day	Log/Activity
1	27-09-2020	Sunday	-*N/A*-
2	28-09-2020	Monday	0800Hours - We undergoes Kaizen 555 at PNO Department (OMC) . We met up with the leader and we ask for any issue that occours so we can undergoes Kaizen . 0830Hours - The issue that happen is the mistakes by the operator where they wrongly choose the blister card can causes reject pallet untuk 30 pallet . 0930Hours - We do some gemba at the IDA2 and meet up with the operator , ask why this reject could be happen . 1000Hours - They said that , the procedure first is whenever to spin the model at the machine , they must check for the serial number for the card and the model car so they will not do mistake combining the card . The operator assume that the previous shift maybe they didnt not look over the card when ever they see the model are blue and the card are blue . 1100Hours - We met up with the MH (feeder of the IDA2) . They said that they always brought the correct item and serial number , but maybe there's error on the blister card that have been reuse when it doesnt finish then they use the wrong one 1200Hours -The impromovement that we can make is for the short terms , we hang up the sample of the model blister card in front of the machine with the green card of the model , so the operator can always watch the reference so they will not be any mistake . 1230Hours - Second one is , we met up with the Ramesh , where we wanted to redesign
3	29-09-2020	Tuesday	-Absent-
4	30-09-2020	Wednesday	0800Hours - We undergoes Kaizen 555 at PIM Department . We met up with the Supervisor and the leader and we discuss a few issue that need to be settle . 0830Hours - The issue that we have been discuss is we wanted to reduce that Black Master colour that we mixed up with the regrind of the material . Where before this we use almost 75g of blasck master to mixed with the 6.25kg of regrind . Now we stick witht the regrind colour with its based colour so we do not need to mixed with the black master colour anymore . 0930Hours - We do some gemba findings where we weighing the weigh for the regrind to measure how much we produce the regrind

Num.	Date	Day	Log/Activity
			within one shift then we calculate how many time do we use the black master to mixed with . 1100Hours - Then we want to see the result for this Kaizen , we mixed up with the 75% Virgin and 25% Regrind of the colour , for the red colour that have 4 machine that are running . So we add on the new mixture and then we wait for the result for this new improvement . 1230Hours - What we see from the result , the colour have only a slightly different such 3% colour . And we ask all for Ooi , if this happen , we need to adjust the temperature of the machine to maintain the colour . 1330Hours - This Kaizen seems like succeed so we are trying to calculate the cost saving based on the 2 criteria which is the first one is reducing of usage of the black colour and 2nd is saving of 25% of the colour virgin where we use the regrind before .
5	01-10-2020	Thursday	0800Hours - We undergoes Kaizen 555 at Tampo Department . We met up with the Supervisor and the leader . We discuss afew topic and issue that need to be solved on . 0830Hours - The issue that we get from the disuccussion is we do some improvement on the reducing time of the operator waiting for the techinician to solved the machine issue . 0930Hours - We do some gemba findings where we measure the time taken for the techinician to repair the machine . And also we measure , if lets say 20min the technician needed to repair , so how much that operator can produce output within 20 min on other machine . 1030Hours - We met up with the Abang wan and we ask a few question about this new sop . 1115Hours - So we came out with new sop where we have 2 option where we the first one is the operator no need to move out from the machine when there is smaller issue such as pad , dry ink , but the operator need to move out from the machine and run on the other machine when the machine is having a an alighment issue . 1230 Hours - This new SOP we can reduce alot of time of operator waiting for the technician and also we can increase some output on the other machine intime while waiting for the technician to repair the machine .

Num.	Date	Day	Log/Activity
6	02-10-2020	Friday	0800Hours - We were doing our report for the presentation Kaizen 55 WE1001 . 0930Hours - We comfirming all our calculation about the saving the we have been done in the system and update it on to the data base . 1430Hours - We began our presentation at the Lean Room for Kaizen 555 infront all of the manager and we have abit discussion and a few Q&A amoung us .
7	03-10-2020	Saturday	-*N/A*-

Company Supervisor Signature

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Log Book From 04-10-2020 To 10-10-2020

Num.	Date	Day	Log/Activity
1	04-10-2020	Sunday	-*N/A*-
2	05-10-2020	Monday	0800Hours - We undergoes Kaizen 555 at Tampo Department . 0830Hours - We went to the DIJ Department (Direct Injection Plastic) where we wanted to see the process at DIJ . 0900Hours - They run a few models to show the laser process of the DIJ and they explain step by step about the process . The reason for the DIJ is to run on the model that have a complex shape of the model , and also to run for many colours that include together such as have gradient colour ,many colours in one tampo . 1000Hours - We do some gemba at the Tampo about the Downtime for the technician to repair the machine and the movement of the operator . 1030Hours - While doing the gemba , when the technician repair over the machine , we can see that the operator move to the other machine and run on it , where they can save their time without waiting the tech around 30-45min . So they can also produce output on other machine. 1200Hours - So what we can say that there a few types of downtime where we must highlight ,which is for problem pad , paint , and plate the operator no need to change over to another machine because the issue that occours were only a minor problem and can be settle around 10 - 15 min . While for error such as alignment and body error , the operator need to move to another machine while the technician repair over the machine , because the time taken to repair were around 30 - 45 min and can be longer until 1 hours . 1300Hours - We can save the labour cost if we are doing this method .
3	06-10-2020	Tuesday	0800Hours - We undergoes Kaizen 555 at OMC Department . We met up with the leader and the supervisor we ask for any issue that need to cater on or settle on . 0830Hours - We do gemba on every machine that running at the OMC 0900Hours - The issue that we get is for model FF117 , the spinning during the mating was not incomplete and have a gap . Around 97/140 were defect (70%) from the sample that we take .

Num.	Date	Day	Log/Activity
			0945Hours - We called out for the technician , and try to settle the issue that happen . 1030Hours - We try for increase the power of the spinning and harder on the stopper for the machine , to see whether is there any gap issue that occours . 1045Hours - Once we are running , we found that the issue still have but the gap are getting smaller . We show to the QC to see whether it is acceptable or not , and it is acceptable because still in its limit . 1115Hours - So we try again to move the stopper infront abit to the pole when they were spinning at the back of the pole so the stopper hold tighter infront of the pole , so it will not going to go upwards . 12000Hours - What we get the output is , the gap is vanish and settle on .So there is no more reject or gap issue that happen .
4	07-10-2020	Wednesday	0800Hour - We undergoes Kaizen 555 at Die Cast Department . The issue that we caught is the body have defect that already run until ransberk 0850Hour - We met up with the Line Leader to identify the problem . Then we undergoes GEMBA at the machine 67 and 34 . 0930Hours - The remaining body that already produce we undergoes it to separation machine to see wheather the body still have defect or not. Once it done , the body that have defect was only from Machine 34. 1015Hours - Machine 34 was the mold is problem . We found up that the indicator also at the red zone . We ask for the technician to checkup the indicator and setup again the mold to the mold centre. 1100Hours- The issue that we received feedback from the Mold centre was the mold has defect where the gate for the alloy was overflow hence that cause the body to defect. The Mold centre technician repair the mold and this process takes afew time to weld it again 1300Hour- We checkup the results that the body that produce by machine34 are good after the repairing process.
5	08-10-2020	Thursday	0800Hours - We undergoes Kaizen 555 at Barbell Deparment . We met up with Bala as the Supersvisor of the deparment and discuss on the issue that need to be settle on at the department . 0830Hours - The issue is for machine HB-5 , the barbell produced were not in good condition where the design should be printed and

Num.	Date	Day	Log/Activity
			only 1 dot is not print , but reject were produced all design is printed onto the barbell. 0930Hours - So we do some gemba on to the machine for 1 hours , we found that almost 95% (95/ 100) of the sample produced were rejected . 1030Hours - We met up with Abang Bad ,Engineer for Barbell . We discuss on the issue that happen . So he said that this were caused by the stamp already old and need to be renew on . And also the design already corrupted and the shape all ready missing abit , so when the pressure hit up the stamp , it covered all the barbell . 1115Hours - We design a new stamp and waited for the stamp to be done . 1300Hours - Once the stamp is done , we try run it on the machine to see the result , is there any changes or improvement that we made on . 1330Hours - The result were satisfied where the new stamp followed the design that we setup for .
6	09-10-2020	Friday	0800Hours - We were doing our report for the presentation Kaizen 555 WE1010 . 0930Hours - We comfirming all our calculation about the saving the we have been done in the system and update it on to the data base . 1430Hours - We began our presentation at the Lean Room for Kaizen 555 infront all of the manager and we have abit discussion and a few Q&A amoung us .
7	10-10-2020	Saturday	-*N/A*-

Company Supervisor Signature

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