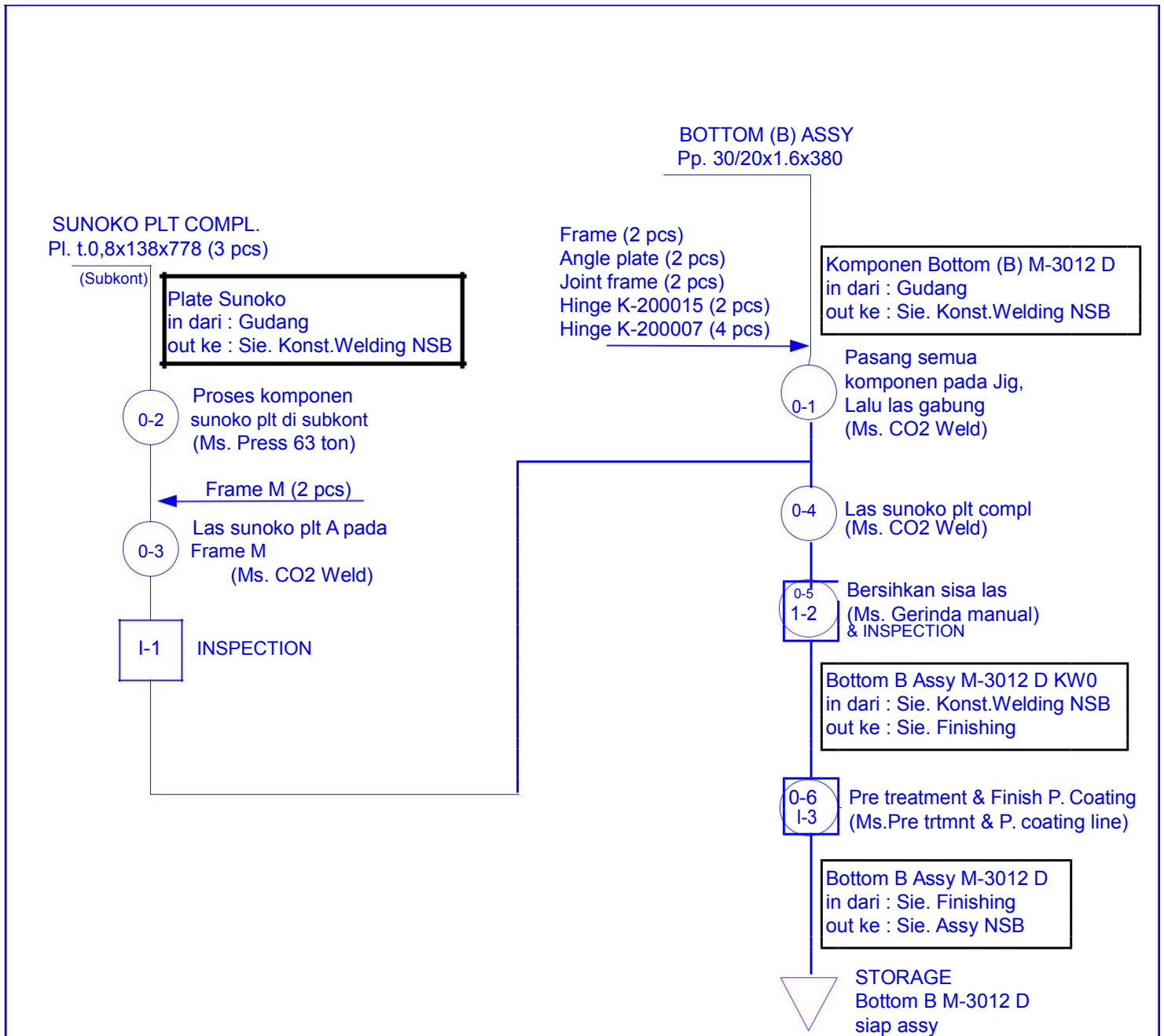


OPERATION PROCESS CHART (OPC)

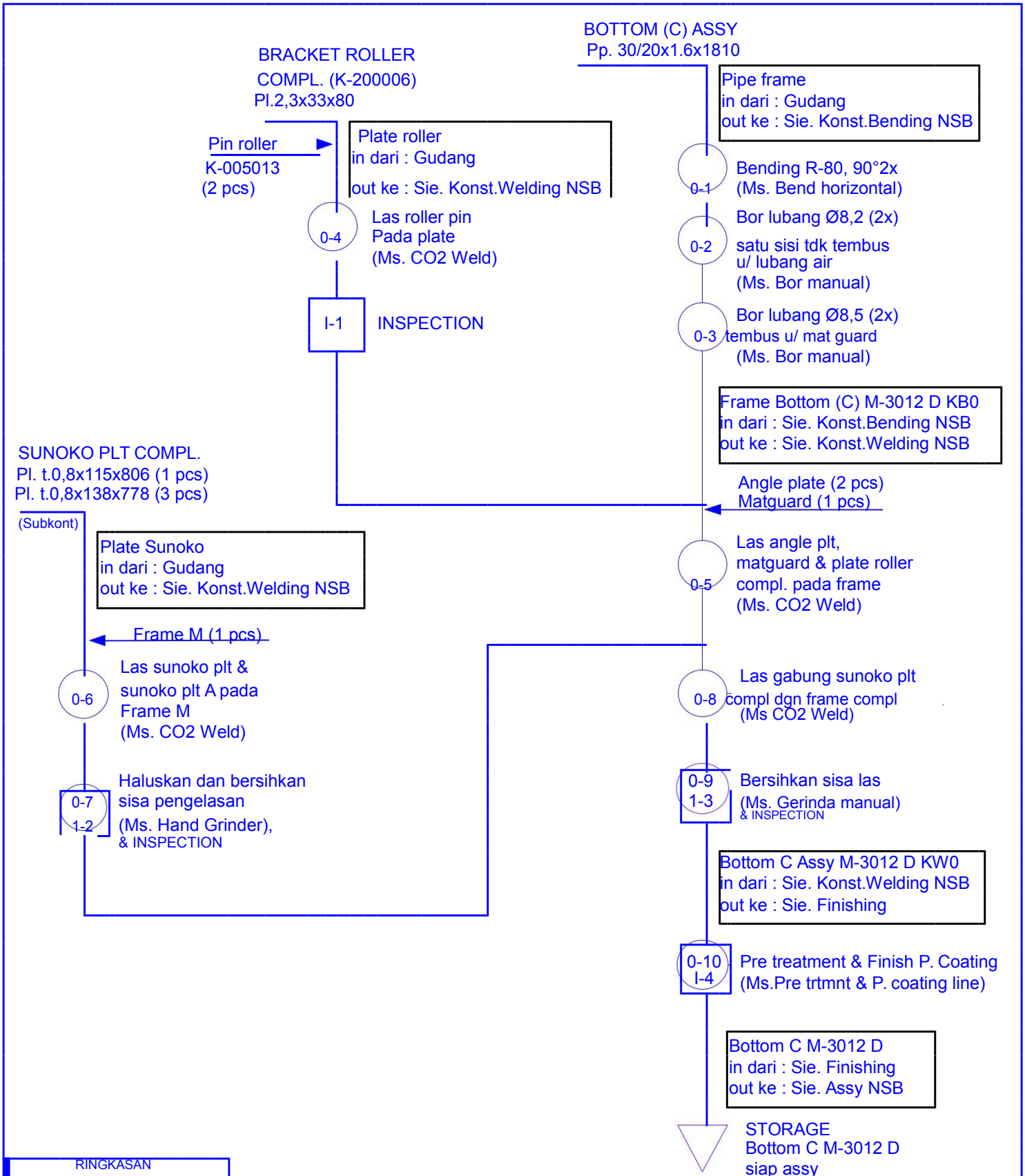
JENIS : NSB MODEL : M – 3012 D-ST TIPE : 2 CRANK 1 GASLIFT CYLINDER KOMPONEN : BOTTOM (B) ASSY

FINISHING : POWDER COATING



| RINGKASAN              |        |       |
|------------------------|--------|-------|
|                        | JUMLAH | WAKTU |
| Operation              | 4      |       |
| Inspection             | 1      | ..... |
| Inspection & operation | 2      | ..... |
| TOTAL WAKTU            |        | ..... |

| No | Dibuat oleh      | Validasi | Revisi | Disetujui Oleh | Validasi | Tgl. Efektif |
|----|------------------|----------|--------|----------------|----------|--------------|
| 1  | PSD              |          | △N     | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | △1     | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | △2     | R&D Mgr        |          | 06-06-2014   |



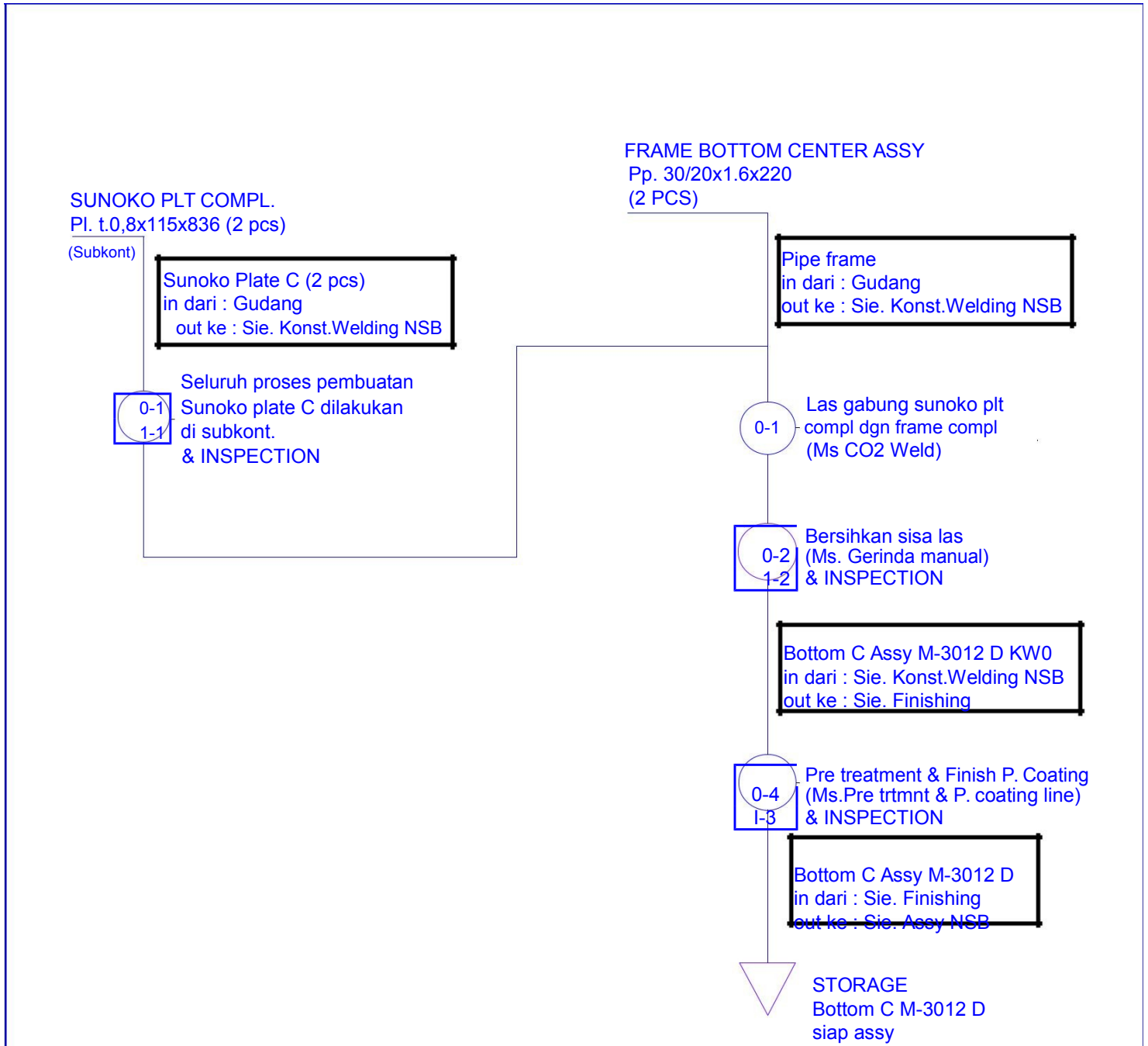
| RINGKASAN              |        |       |
|------------------------|--------|-------|
|                        | JUMLAH | WAKTU |
| Operation              | 8      |       |
| Inspection             | 2      | ..... |
| Inspection & operation | 2      | ..... |
| TOTAL                  |        | ..... |
| WAKTU                  |        | ..... |

| No | Dibuat oleh      | Validasi | Revisi | Disetujui Oleh | Validasi | Tgl. Efektif |
|----|------------------|----------|--------|----------------|----------|--------------|
| 1  | PSD              |          | N      | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | 1      | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | 2      | R&D Mgr        |          | 06-06-2014   |

OPERATION PROCESS CHART (OPC)

JENIS : NSB MODEL : M-3012 D-ST TIPE : 2 CRANK 1 GASLIFT CYLINDER KOMPONEN : CENTER BOTTOM ASSY

FINISHING : POWDER COATING



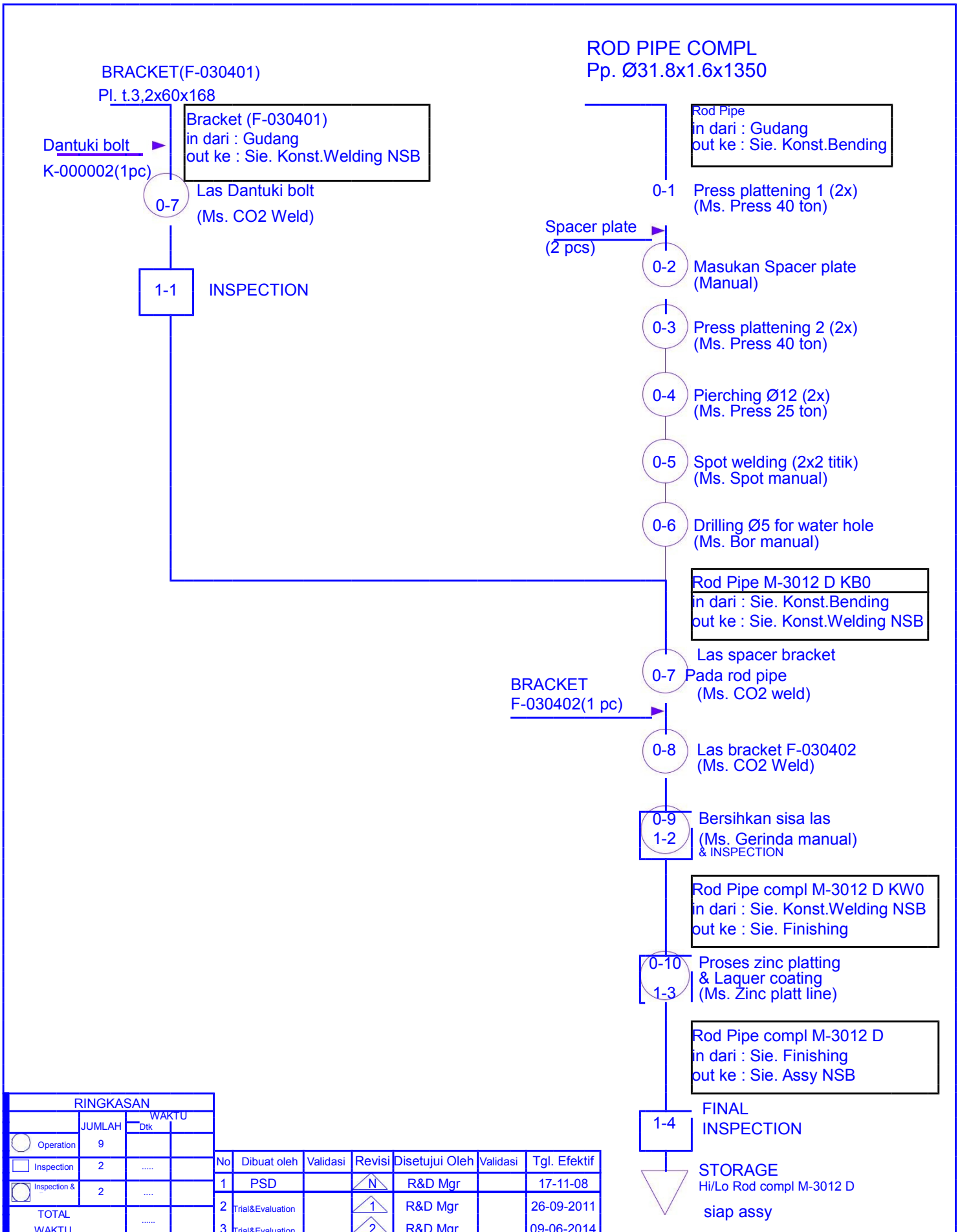
| RINGKASAN                |        |       |
|--------------------------|--------|-------|
|                          | JUMLAH | WAKTU |
| ○ Operation              | 8      |       |
| □ Inspection             | 2      | ..... |
| ⊖ Inspection & operation | 2      | ....  |
| <b>TOTAL WAKTU</b>       |        |       |

| No | Dibuat oleh      | validasi | Rev/si | Disetujui Oleh | validasi | Tgl. Efektif |
|----|------------------|----------|--------|----------------|----------|--------------|
| 1  | PSD              |          | N      | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | 1      | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | 2      | R&D Mgr        |          | 06-06-2014   |

OPERATION PROCESS CHART (OPC)

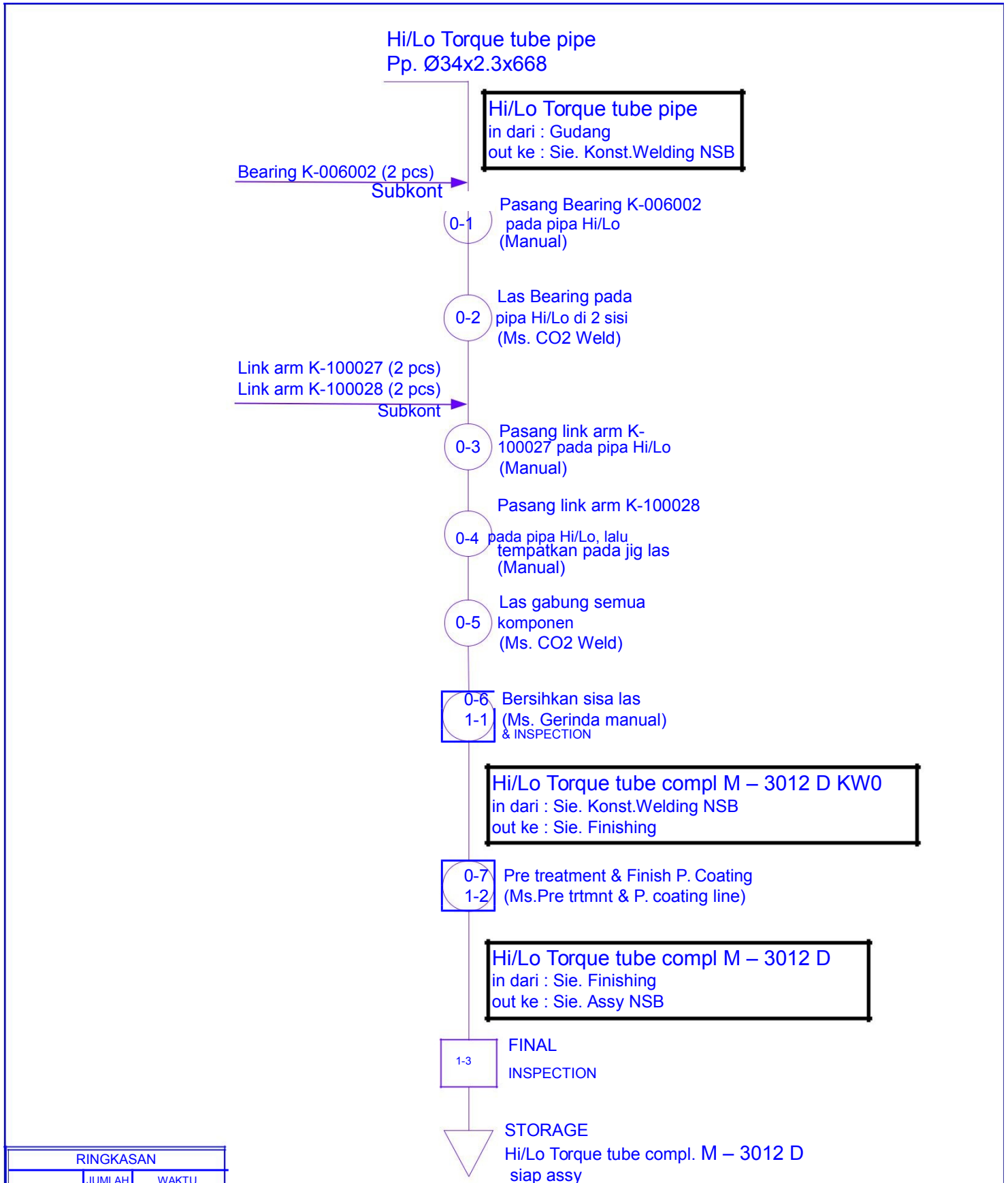
JENIS : NSB MODEL : M - 3012 D-ST TIPE : 2 CRANK 1 GASLIFT CYLINDER KOMPONEN : Hi/Lo ROD COMPL

FINISHING : ZINC PLATTING + LAQUER



| RINGKASAN      |        |       |
|----------------|--------|-------|
|                | JUMLAH | WAKTU |
|                |        | Dtk   |
| ○ Operation    | 9      |       |
| □ Inspection   | 2      | ..... |
| ◻ Inspection & | 2      | ....  |
| TOTAL WAKTU    |        | ..... |

| No | Dibuat oleh      | Validasi | Revisi | Disetujui Oleh | Validasi | Tgl. Efektif |
|----|------------------|----------|--------|----------------|----------|--------------|
| 1  | PSD              |          | △N     | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | △1     | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | △2     | R&D Mgr        |          | 09-06-2014   |

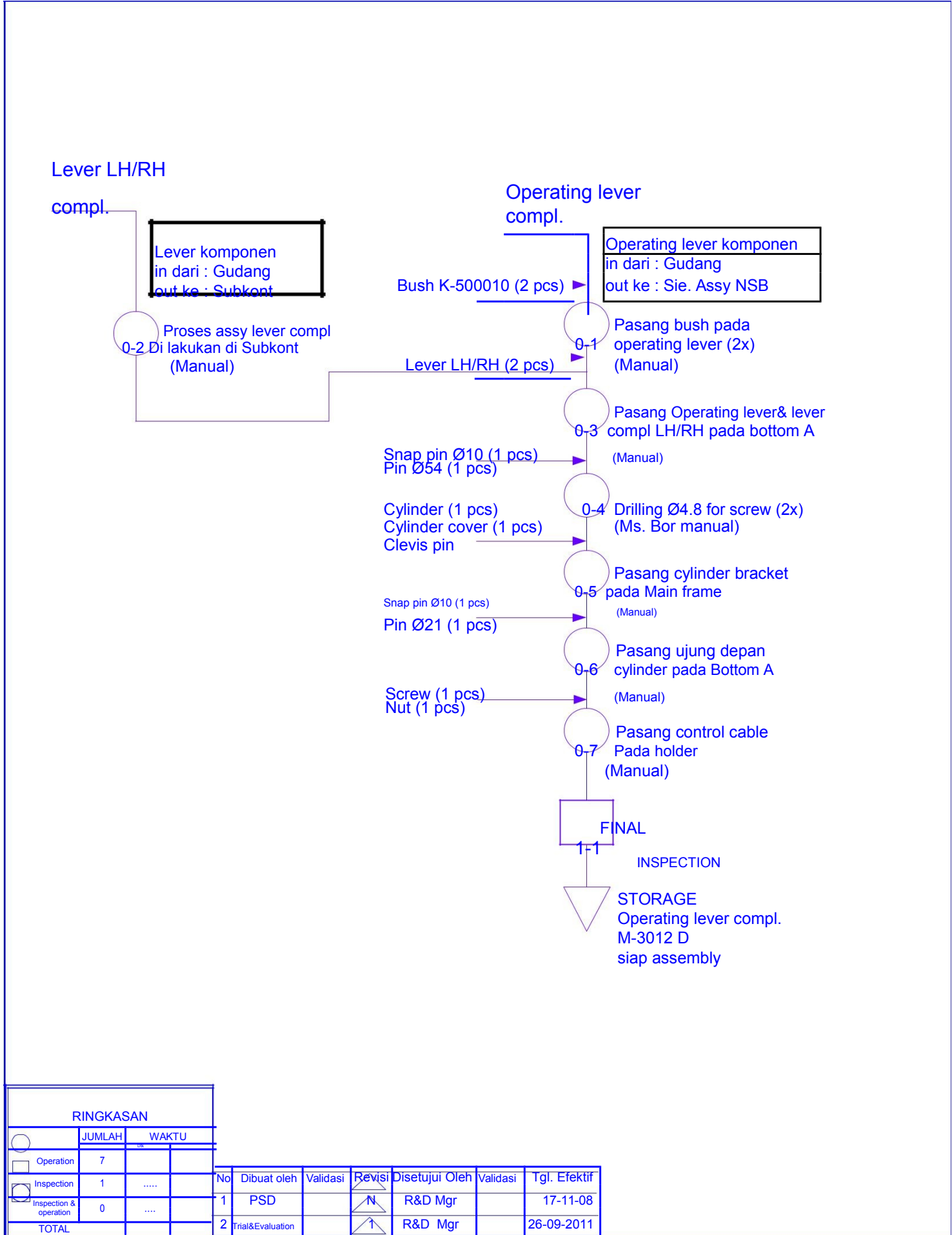


| RINGKASAN                |        |       |
|--------------------------|--------|-------|
|                          | JUMLAH | WAKTU |
| ○ Operation              | 5      |       |
| □ Inspection             | 1      | ..... |
| ◻ Inspection & operation | 2      | ....  |
| <b>TOTAL WAKTU</b>       |        | ..... |

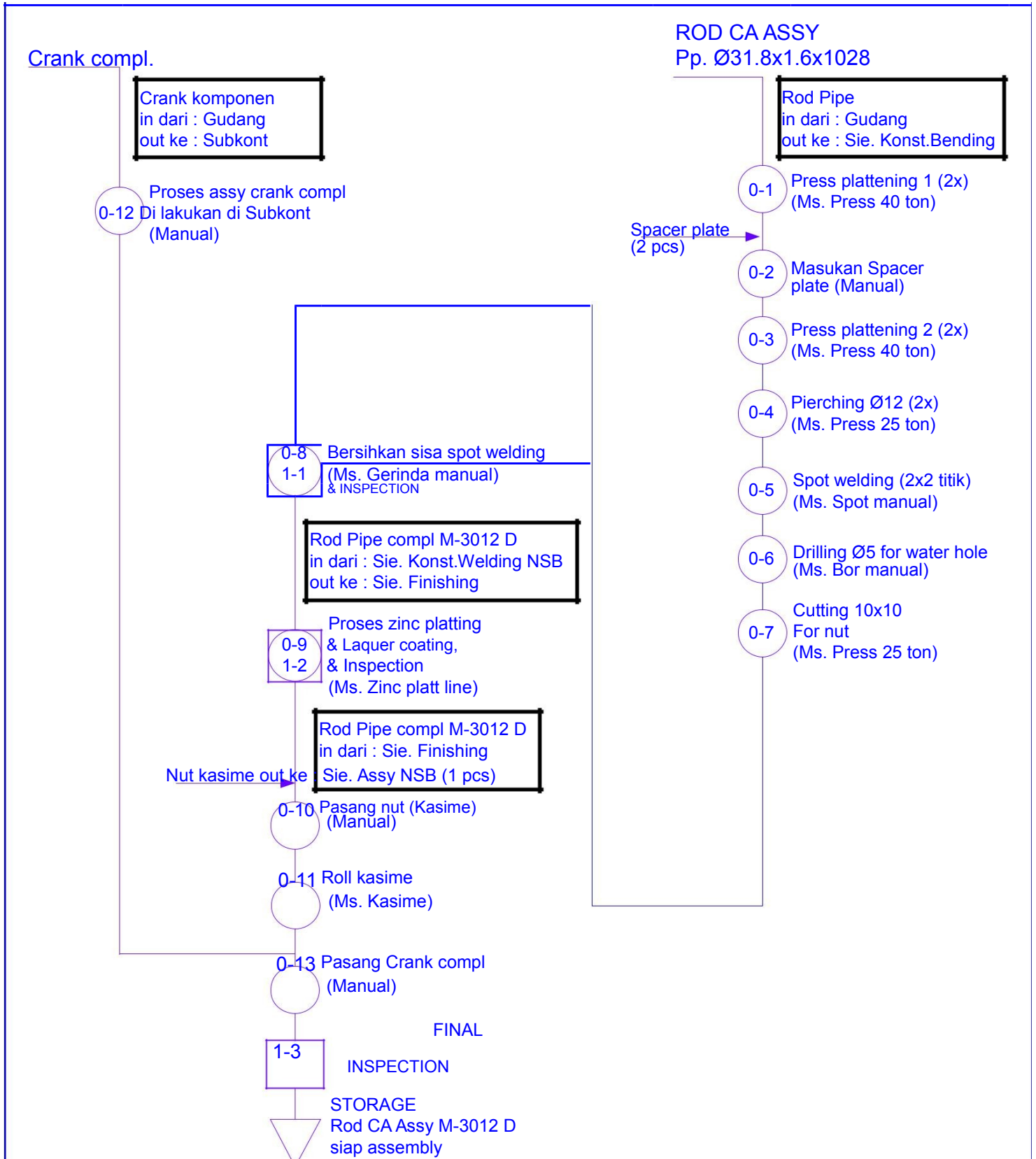
| No | Dibuat oleh      | Validasi | Revisi         | Disetujui Oleh | Validasi | Tgl. Efektif |
|----|------------------|----------|----------------|----------------|----------|--------------|
| 1  | PSD              |          | △ <sub>N</sub> | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | △ <sub>1</sub> | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | △ <sub>2</sub> | R&D Mgr        |          | 09-06-2014   |

OPERATION PROCESS CHART (OPC)

JENIS : NSB MODEL : M-3012 D-ST TIPE : 2 CRANK 1 GASLIFT CYLINDER KOMPONEN : OPERATING LEVER COMPL.  
FINISHING : ZINC PLATTING & POWDER COATING



JENIS : NSB MODEL : M-3012-ST D TIPE : 2 CRANK 1 GASLIFT CYLINDER KOMPONEN : ROD & CRANK COMPL  
 FINISHING : ZINC PLATTING & POWDER COATING



RINGKASAN

|                        | JUMLAH | WAKTU |
|------------------------|--------|-------|
| Operation              | 11     |       |
| Inspection             | 1      | ..... |
| Inspection & operation | 1      | ..... |
| <b>TOTAL WAKTU</b>     |        | ..... |

| No | Dibuat oleh      | Validasi | Revisi | Disetujui Oleh | Validasi | Tgl. Efektif |
|----|------------------|----------|--------|----------------|----------|--------------|
| 1  | PSD              |          | N      | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | 1      | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | 2      | R&D Mgr        |          | 10-06-2014   |



(Ms Gerinda manual)

3  
5  
"

(Ms. Bor manual)

Bor lubang Ø6,5 (2x)

0-26 u/ House holder side rail

Main frame M – 3012 D  
in dari : Sie. Finishing P.  
Coating

out ke : Sie. Assy NSB

- 14

FINAL  
INSPECTION

STORAGE

siap assy

| RINGKASAN              |    | JUMLAH | WAKTU |
|------------------------|----|--------|-------|
| Operation              | 23 |        |       |
| Inspection             | 7  | .....  |       |
| Inspection & operation | 8  | .....  |       |
| TOTAL                  |    | .....  |       |
| WAKTU                  |    |        |       |

| No | Dibuat oleh      | Validasi | Revisi | Disetujui Oleh | Validasi | Tgl. Efektif |
|----|------------------|----------|--------|----------------|----------|--------------|
| 1  | PSD              |          | N      | R&D Mgr        |          | 17-11-08     |
| 2  | Trial&Evaluation |          | 1      | R&D Mgr        |          | 26-09-2011   |
| 3  | Trial&Evaluation |          | 2      | R&D Mgr        |          | 10-06-2014   |

Main frame  
M – 3012 D