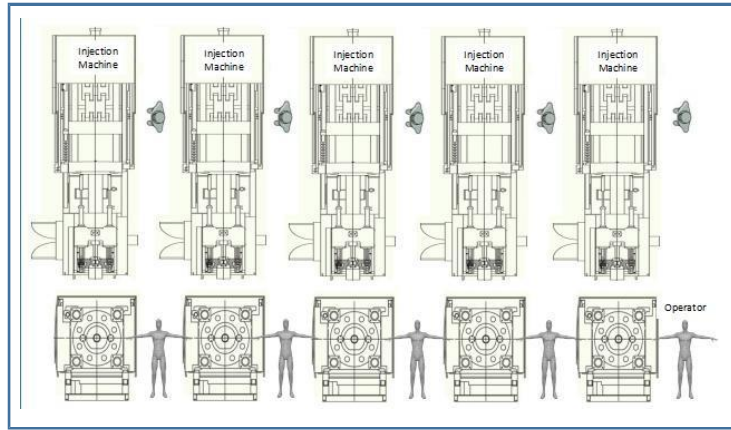
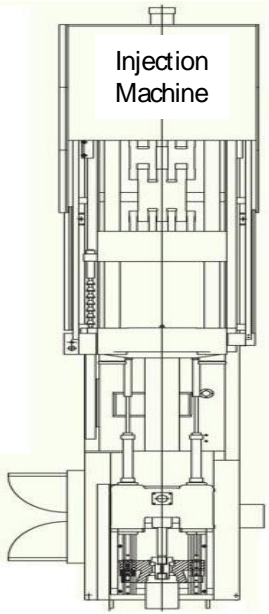


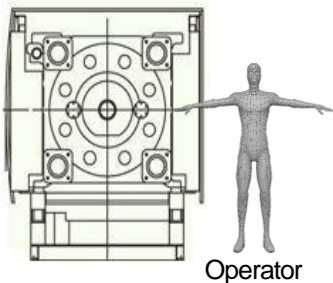
# **ROI (Return on Investment)**

Relocate Manpower  
and  
Est.budget investment

Report by PT.OCTAGON AUTHENTIC TEKINDO



Convention Method :  
One Operator / Machine

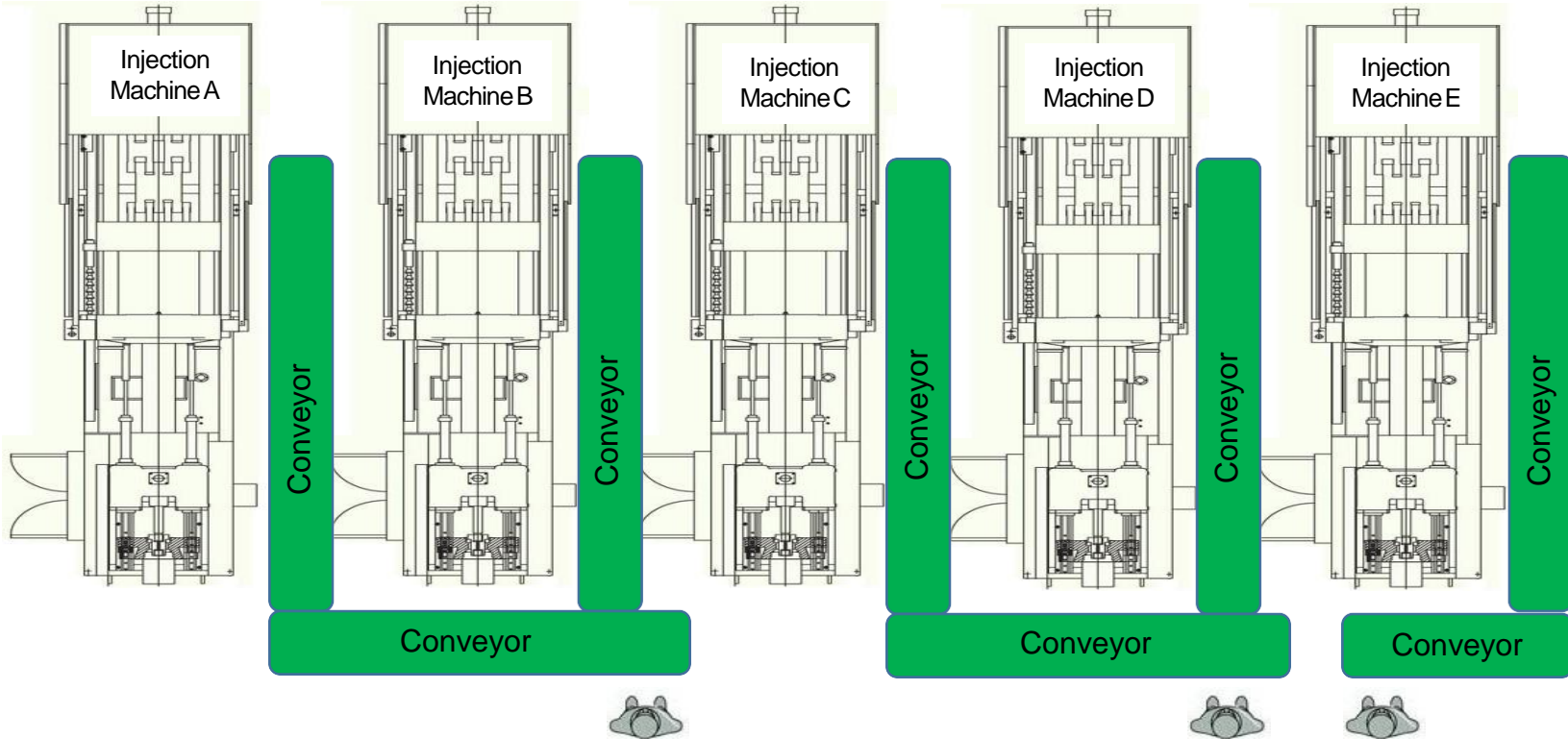


### Convention Method

	Shift 1	Shift 2	Shift 3	Total
Inj.Machine		5		5 unit
Operator/Machine	5	5	5	15

Convention Method :

1. Normally Production will setting One Operator per Machine to operate daily production.
2. Operator job content > Gate cutting, Flashing and Burr trimming and Packing.
3. Disadvantace of this setting is part cost increase, due to salary increment year by year.



### Convention Method with Conveyor System

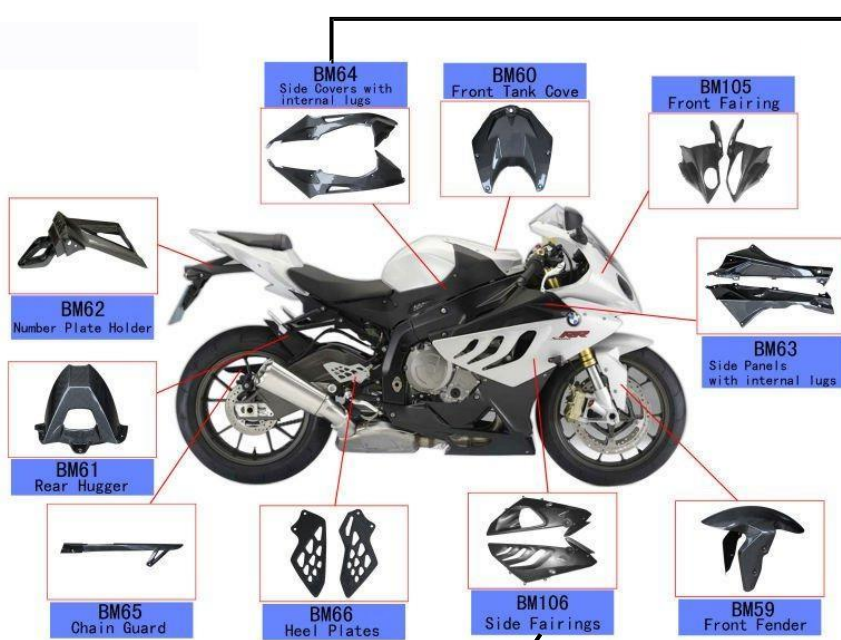
	Shift 1	Shift 2	Shift 3	Total
Inj. Machine		5		5 unit
Operator/Machine	3	3	3	9

### Conveyor Method :

- 1.If operate by conveyor system with 1 operator /2 machine.this system can reduce the manpower.
- 2.If only with 5machine/shift ,mean will save 2manpower and 6 manpower perday.



octagon.



≥6 point of gate



≥6 point of gate



4~6 point of gate

Cycle time of part 40.5s to 49.5s

1.mold closed 3.5s

2.Inject Time 8~11s

3.Cooling time 18~24s

4.Take Out 11s



4~6 Gate cutting

6~10 sec

\*\*Time cutting depend on part size and gate side



Part Flashing Trimming

5~10sec

\*\*Time cutting depend on tooling condition



Part pack into Tray / Carton

3~5 sec

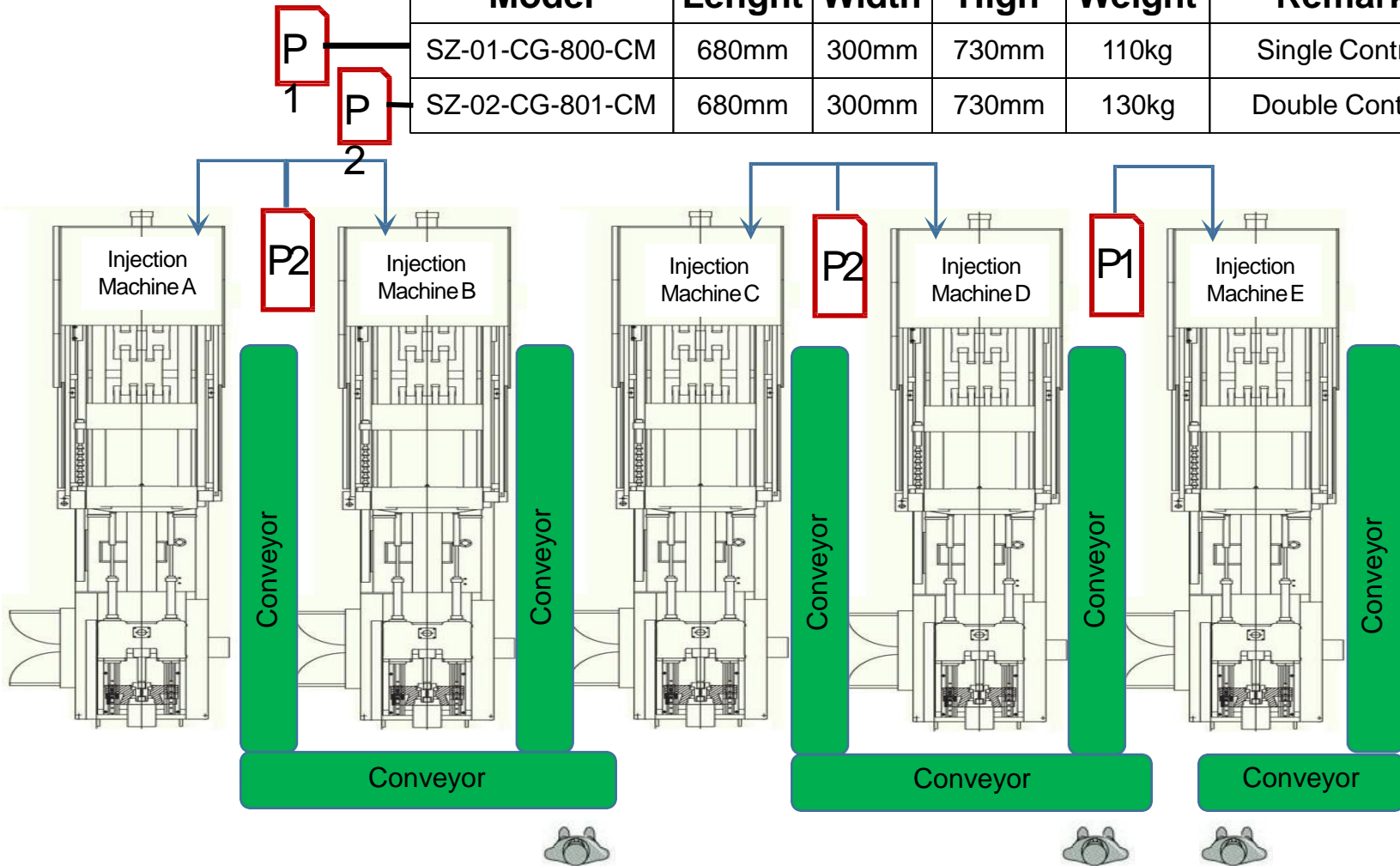


Operator

Total process time 20~50 sec

## HIGH PRESSURE CONTROLLER

Model	Length	Width	High	Weight	Remark
SZ-01-CG-800-CM	680mm	300mm	730mm	110kg	Single Control
SZ-02-CG-801-CM	680mm	300mm	730mm	130kg	Double Control



\* Two inj.machine sharing 1 H.Pressure controller.

Injection Portion	Time (S)	Cycle Time	Daily Operator / Machine A			Daily Operator / Machine B		
			Shift 1	Shift 2	Shift 3	Shift 1	Shift 2	Shift 3
Closed	3.5	44~53	1	1	1	1	1	1
Injection	8~11							
Cooling	18~24							
Take Out	11							
Open	3.5							
Operator/Machine								
Gate Cut	6~15	14~35	1	1	1	1	1	1
Finishing Touchup	5~15							
*Flashing,Burr								
Packing	3~5							
* Monthly salary/Operator Rp11juta			Rp11juta * 6 = Rp66juta / 2 inj.machine					

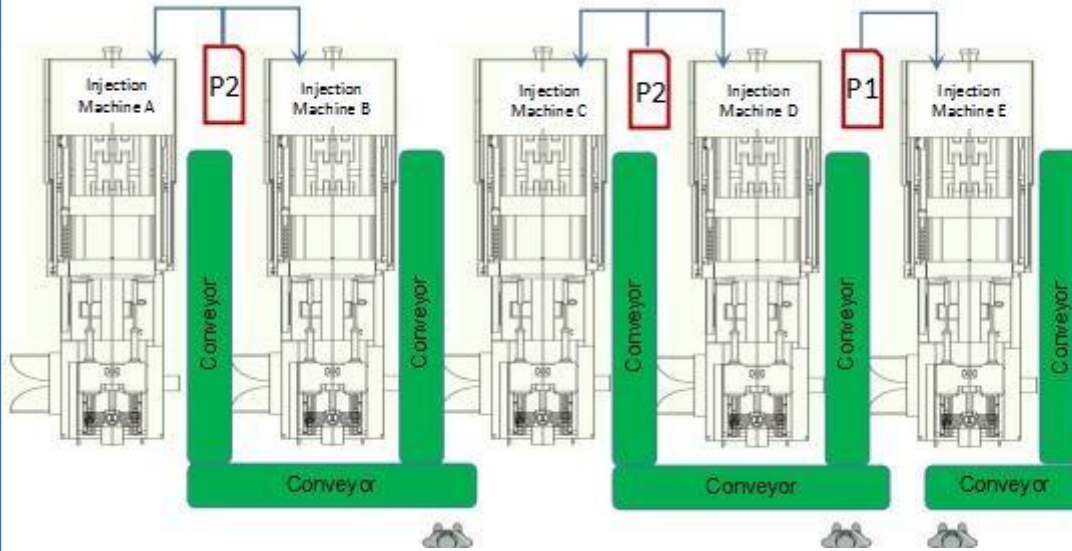
Injection Portion	Time (sec)	Cycle Time (sec)	Daily Operator / Machine A + B		
			Shift 1	Shift 2	Shift 3
Closed	3.5	44~53	1	1	1
Injection	8~11				
Cooling	18~24				
Take Out	11				
Open	3.5				
Operator/Machine					
Gate Cut	<b>(6~10) * 2</b>	28~50	1	1	1
Finishing Touchup	(5~10) * 2				
*Flashing,Burr					
Packing	(3~5) * 2				
* Monthly salary/Operator Rp11juta			Rp11juta*3=Rp33juta / 2 inj.Machine		

Eliminate Gate cut process

with "Inmold DegateSystem".

improve gate design to minimize the "NG".





HIGH P RESSURE CONTROLLER

P1

P2

Model	Remark
SZ-01-CG-800-CM	Single Control
SZ-02-CG-801-CM	Double Control

	Operator/Machine			Cost		5 unit injection machine	
	sh 1	sh 2	sh 3	Monthly	Yearly	Yearly	
Operator /Machine	1	1	1	Rp 33juta	Rp 429juta	Rp 2.145 M	
Inmold Degate Machine.S	Rp118juta/unit(1 time invesment)				Rp 118 juta	Rp 654 juta	
Inmold Degate Machine.D	Rp168juta/unit (1 time invesment)				Rp 336 juta		
Cutter tools on Mold	≥Rp40juta/mold and above (dependonmoldandcutterdesign)				≥Rp 200 juta		