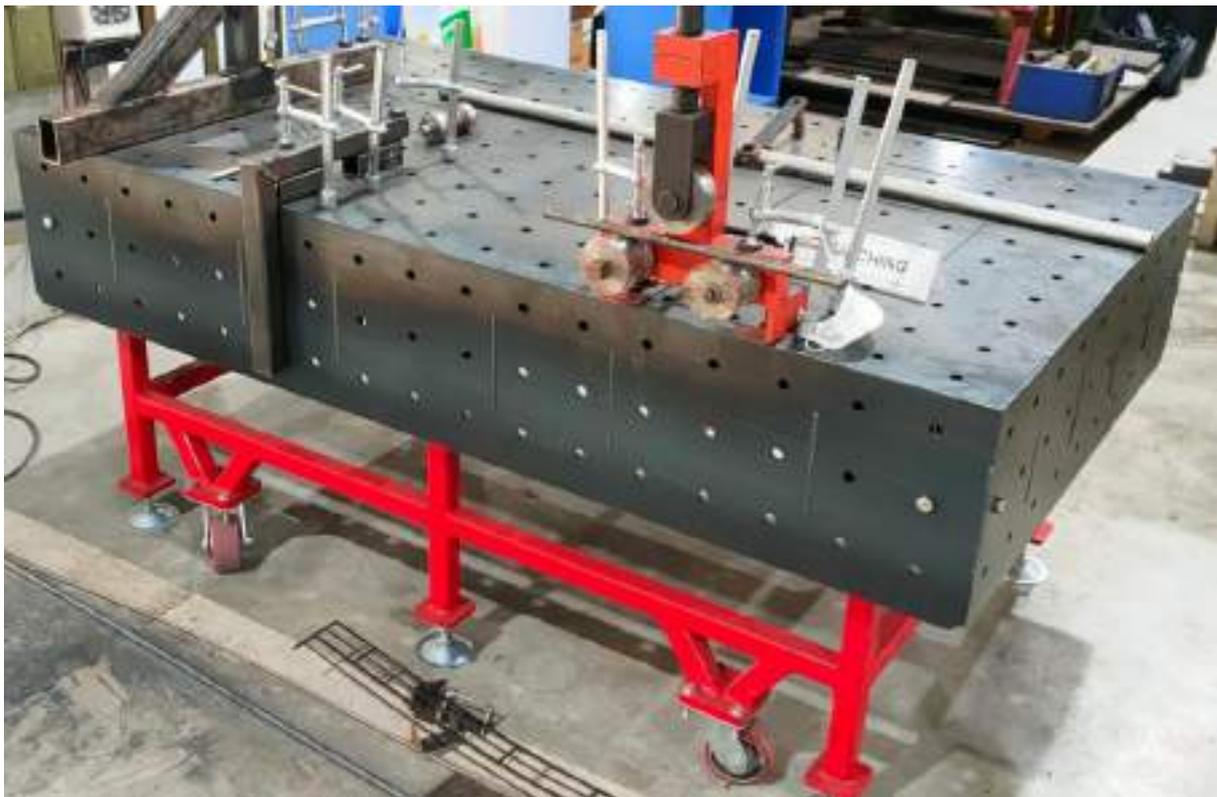
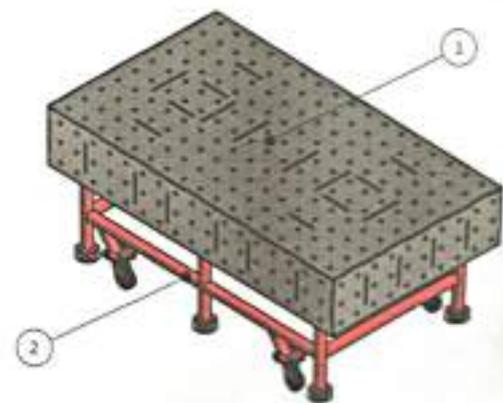
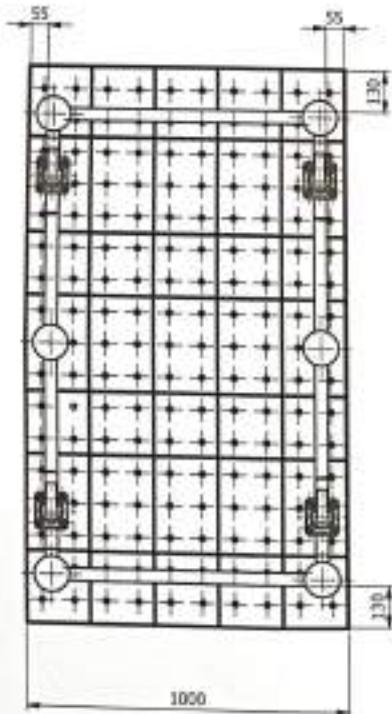
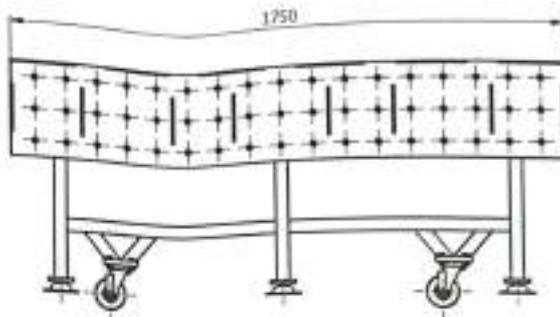
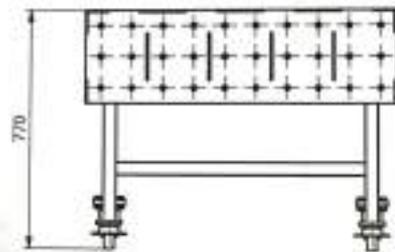


Deskripsi Alat Bantu Produksi: *Table Jig Welding*

Proses pembuatan Trailer Jetski melalui beberapa proses, salah satunya proses pengelasan. Pembuatan alat bantu produksi skala terbatas Trailer Jetski adalah dengan membuat universal *Table Jig Welding*. *Jig* ini dilengkapi dengan roda berjumlah 4 roda yang difungsikan untuk memudahkan *jig* untuk dipindah tempatkan. Tingginya sangat ergonomis yakni sudah sesuai kebutuhan operator yang dapat mencegah *musculoskeletal disorder*. *Jig* ini dibuat dengan 2 material yang lebih dominan, yaitu Besi *Hollow* dan *Sheet Metal*. Besi *Hollow* yang digunakan berukuran 40mmx40mm dengan ketebalam 3mm. *Sheet Metal* yang digunakan berukuran tebal 5mm. *Universal Jig Welding* ini mampu digunakan untuk berbagai macam pengelasan, dan dapat memastikan material yang akan di las dapat statis. Dengan pembuatan alat bantu/ *Jig Table Welding* tersebut dapat membantu proses pabrikasi dan pengelasan komponen-komponen Trailer Jetski. Tujuannya adalah untuk meningkatkan produktivitas, menghilangkan waktu *setting*, meningkatkan waktu proses, dan mempermudah operator untuk melakukan proses pengelasan. Perancangan desain *Universal Jig Welding* ini mengacu pada pembuatan Trailer Jet Ski dari segi dimensi dan fitur. *Universal Table Jig Welding* yang dibuat dengan dimensi 1750x1000x770mm.

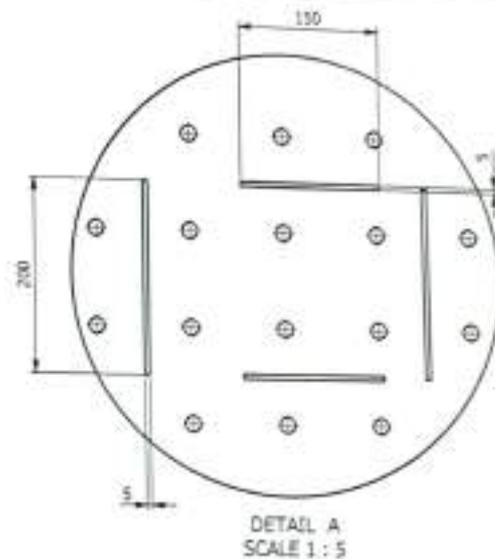
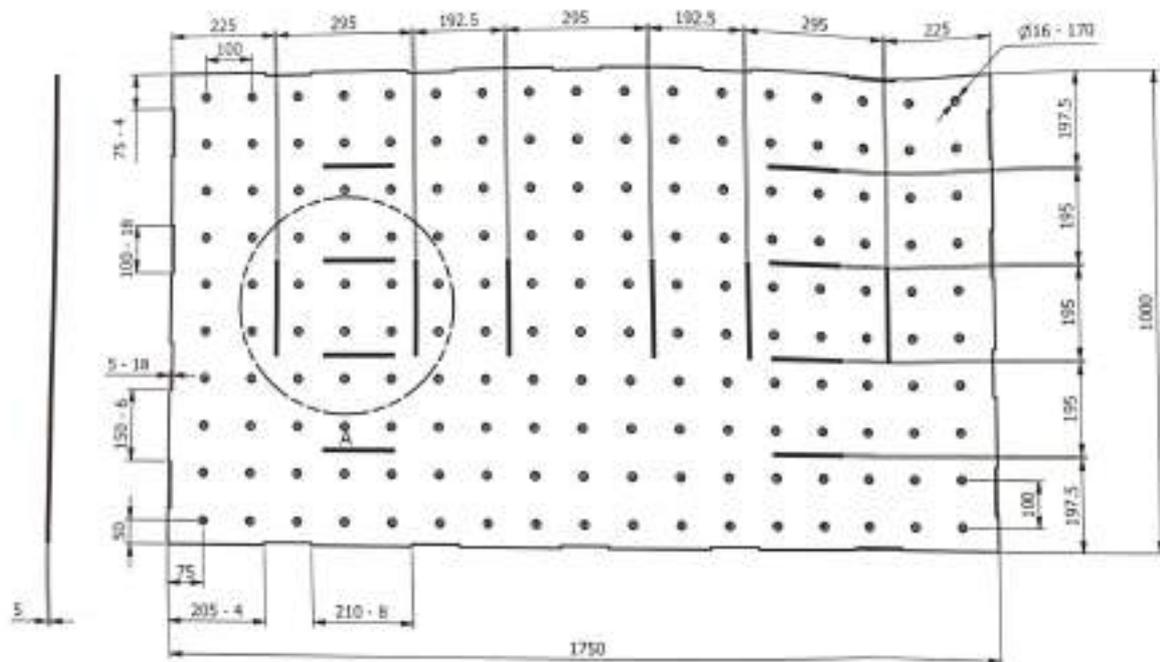




2	Lower Assy			1	B-WV-SA-02
1	Upper Assy			1	B-WV-SA-01
No	Description	Material	Dimension	Qty	Remark
Scale	1 : 15	Hard	Roughness	Checked	Approved
Finish	Faint			<i>[Signature]</i>	<i>[Signature]</i>
Tolerance	Middle	HRC	70 (✓) (✓)	Ring	Heavy
			⊕	p. 7/25	Drawn
				Asst	AKA
No.	Revision	Date	Sign	Ass. No.	Des. No.
AKA	01	17-04-2017	AKA	B-WV-MA-00	B-WV-MA-00
File	AKA	01	AKA	No. order	Origin
Block	AKA	01	AKA		
Sheet	AKA	01	AKA		
				Date of final sign: 17-04-2017	
				A3	

ASTRA POLYTECHNIC
 3, Gelora Blok F3 No. 1 Lingsar Cikarang, Cirebon - 17538
 Telp: (021) 451355, Fax: (021) 4519631

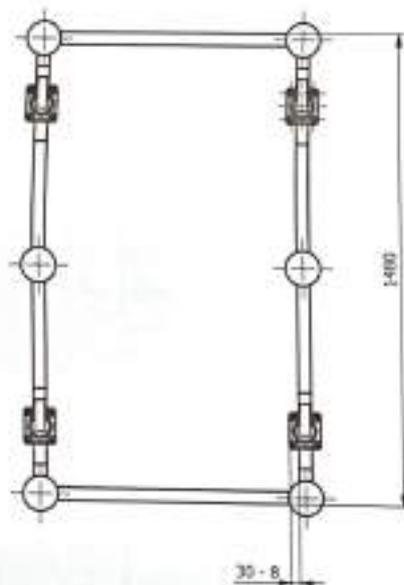
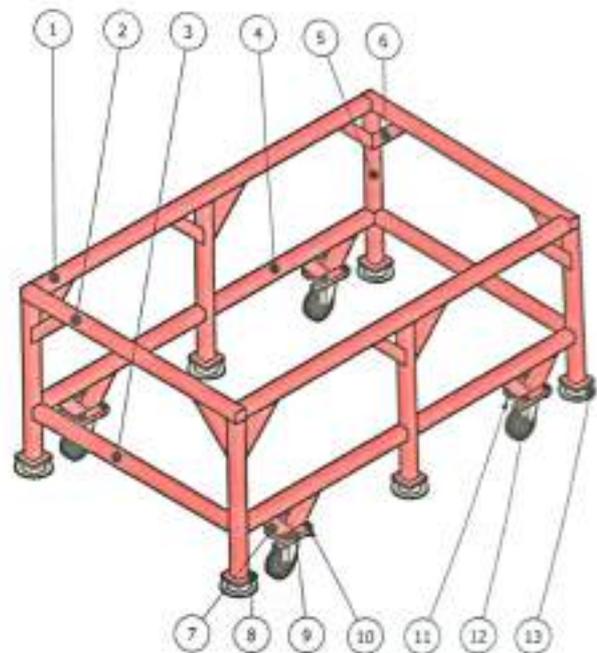
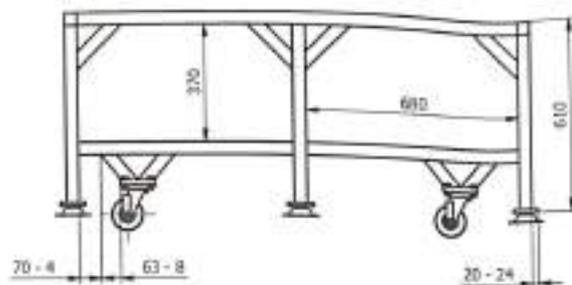
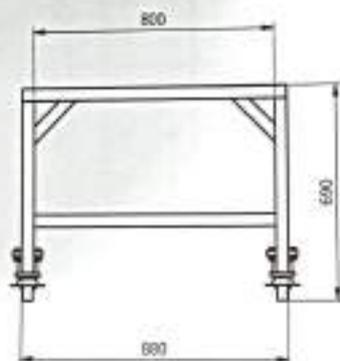
Jig Welding Universal



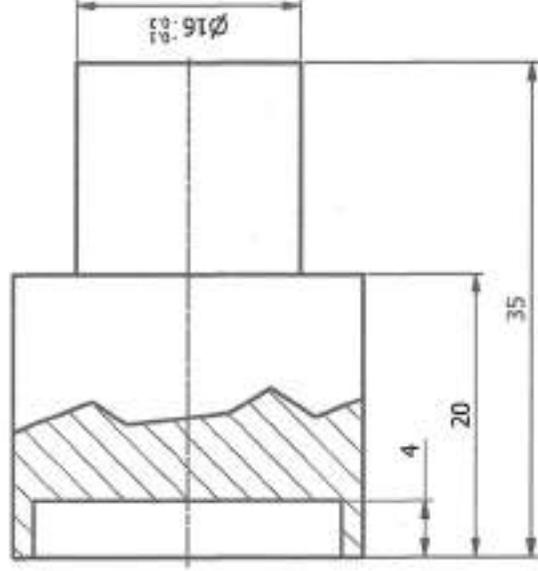
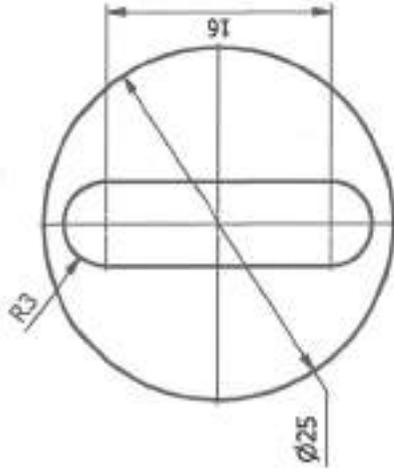
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Finish	Cutting	HRc	N/A (✓)	Ring	Henry		
Tolerance	Abadir	HRc	⊕	Designed	Drawn		
				Asst	Yusuf		
Rev	Revisions	Date	Sign				
Rev 1	175-02-1-4-01-01	18/08/2017	AS				
Rev 2	175-02-1-4-01-01	28/11/2017	AS				
Rev 3	175-02-1-4-01-01	28/11/2017	AS				
Rev 4	175-02-1-4-01-01	28/11/2017	AS				
Rev 5	175-02-1-4-01-01	28/11/2017	AS				
Rev 6	175-02-1-4-01-01	28/11/2017	AS				
Rev 7	175-02-1-4-01-01	28/11/2017	AS				
Rev 8	175-02-1-4-01-01	28/11/2017	AS				
Rev 9	175-02-1-4-01-01	28/11/2017	AS				
Rev 10	175-02-1-4-01-01	28/11/2017	AS				
Rev 11	175-02-1-4-01-01	28/11/2017	AS				
Rev 12	175-02-1-4-01-01	28/11/2017	AS				
Rev 13	175-02-1-4-01-01	28/11/2017	AS				
Rev 14	175-02-1-4-01-01	28/11/2017	AS				
Rev 15	175-02-1-4-01-01	28/11/2017	AS				
Rev 16	175-02-1-4-01-01	28/11/2017	AS				
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Rev 19	175-02-1-4-01-01	28/11/2017	AS				
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Rev 21	175-02-1-4-01-01	28/11/2017	AS				
Rev 22	175-02-1-4-01-01	28/11/2017	AS				
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Rev 27	175-02-1-4-01-01	28/11/2017	AS				
Rev 28	175-02-1-4-01-01	28/11/2017	AS				
Rev 29	175-02-1-4-01-01	28/11/2017	AS				
Rev 30	175-02-1-4-01-01	28/11/2017	AS				
Rev 31	175-02-1-4-01-01	28/11/2017	AS				
Rev 32	175-02-1-4-01-01	28/11/2017	AS				
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Rev 34	175-02-1-4-01-01	28/11/2017	AS				
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Rev 37	175-02-1-4-01-01	28/11/2017	AS				
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Rev 39	175-02-1-4-01-01	28/11/2017	AS				
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Rev 81	175-02-1-4-01-01	28/11/2017	AS				
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Rev 99	175-02-1-4-01-01	28/11/2017	AS				
Rev 100	175-02-1-4-01-01	28/11/2017	AS				

Jig Welding Universal
 Top Cover

Job No. B-JW-S4-01
 Draw No. B-JW-S41-PRT-001

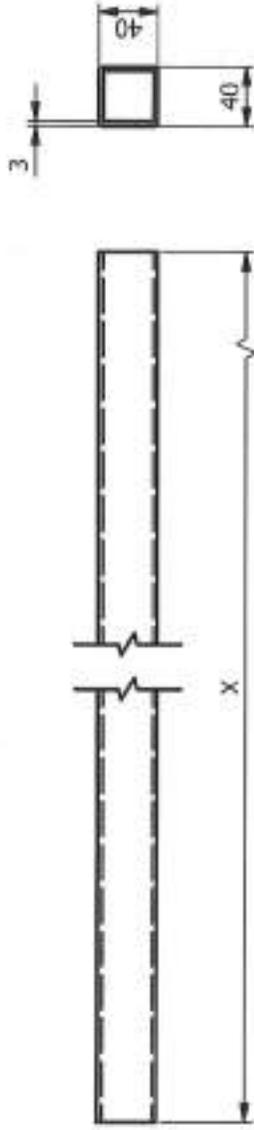


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12	Caster Wheel	Standard	-	4	
11	ISO 4161 - M10	Standard	-	16	
10	AS 1427 - M10 x 30	Standard	-	16	
9	Caster Wheel Holder	SS41	113 x 100 x 16	4	
8	Shoes Foot	SS41	80 x 80 x 10	6	
7	Hollow Support Holder	Hollow 3mm	138 x 40 x 40	6	
6	Hollow Support Frame	Hollow 3mm	200 x 40 x 40	12	
5	Hollow 560	Hollow 3mm	560 x 40 x 40	6	
4	Hollow 680	Hollow 3mm	680 x 40 x 40	4	
3	Hollow 800	Hollow 3mm	800 x 40 x 40	2	
2	Hollow 880	Hollow 3mm	880 x 40 x 40	2	
1	Hollow 1400	Hollow 3mm	1400 x 40 x 40	2	
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Tolerance	Mobile	HRc	<input checked="" type="checkbox"/>	Ring	Henry
			<input checked="" type="checkbox"/>	Designed	Drawn
			<input checked="" type="checkbox"/>	Ass	Arka
ASTRA POLYTECHNIC 3/Gilmer Blok F3 No.1 Upper Claring, Cikau - L7531 Telp (021) 4611955, Fax (021) 46119621					
Jig Welding Universal Lower Assy				No order Volume at shop order 1/3	43 172

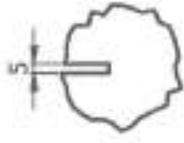


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Finish	Turn		Roughness			Jl. Gaharu Blok F3 No.1 Lippo Cikarang, Cikarang - 17530					
Tolerance	Fine		N7/ (✓)	Rina	Merry	telp.(021)-651955, fax.(021)-6519621					
	HRC			21.7.23	Drawn	Title:					
	Date			Designed		Clamping					
	Sign					Bushing Slot					
No.	Revision	Date	Sign			Asy no.		Dwg no.		B-JW-CL-PRT-001	
Accur	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 315	315 - 630	630 - 1000			No order :	
Fine	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5			Origin :	
Middle	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2			Deburred all sharp edge 0.3	
Rough	±0.15	±0.2	±0.5	±0.8	±1.2	±2	±3			A4	
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1 of 1											

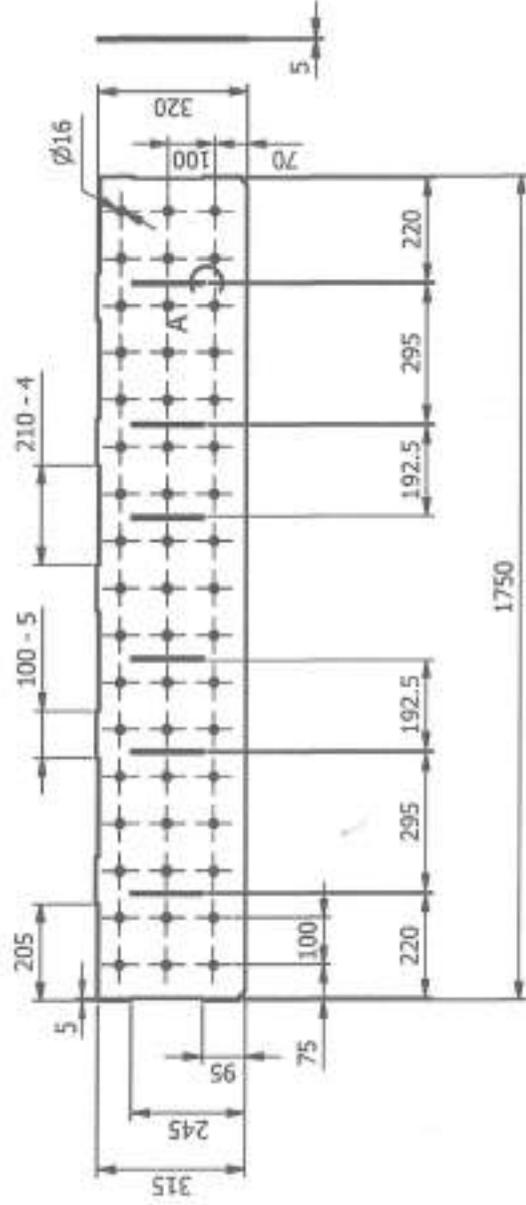
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2	Hollow 880	880	2	B-JW-SA2-PRT-002
3	Hollow 800	800	2	B-JW-SA2-PRT-003
4	Hollow 680	680	4	B-JW-SA2-PRT-004
5	Hollow 560	560	6	B-JW-SA2-PRT-005



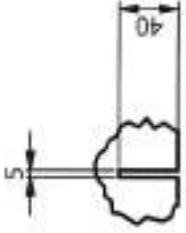
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Scale	1 : 5		Hard	Checked Approved		Roughness		Material		ASTRA POLYTECHNIC		40 x 40		16		40 x 40	
Finish	Cutting		HRC	Rina		N7/ (∇)		Herry		3L Gaharu Blok F3 No.1 Lippo Cikarang, Cibatu - 17530		40 x 40		16		40 x 40	
Tolerance	Middle			31.7.23		∇		Designed		Isip. (021)-651955, fax. (021)-6519821		40 x 40		16		40 x 40	
4				Drawn		∅		Aziz		Jig Welding Universal		40 x 40		16		40 x 40	
3				Noel		∅		21.7.23		Hollow		40 x 40		16		40 x 40	
2				21.7.23		∅		21.7.23		Hollow		40 x 40		16		40 x 40	
1				21.7.23		∅		21.7.23		Hollow		40 x 40		16		40 x 40	
No.	Revision	Date	Sign	No order :		Deburred all sharp edge 0.3		No order :		No order :		No order :		No order :		No order :	
Accur	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 315	315 - 1000	1000 - 5000	No order :		No order :		No order :		No order :		No order :	
Fine	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	No order :		No order :		No order :		No order :		No order :	
Middle	+0.1	+0.1	+0.2	+0.3	+0.5	+0.8	+1.2	No order :		No order :		No order :		No order :		No order :	
Rough	+0.15	+0.3	+0.5	+0.8	+1.2	+2	+3	No order :		No order :		No order :		No order :		No order :	
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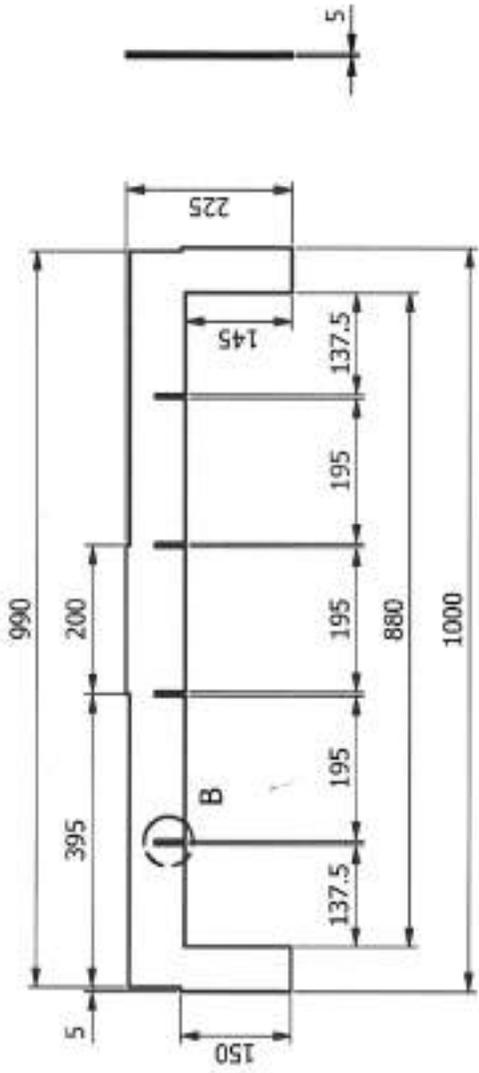
DETAIL A
SCALE 1 / 4



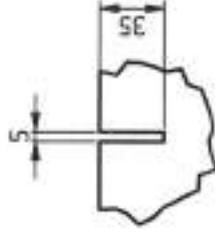
2	Side Cover	Sheet Metal	1750 x 305 x 5	2	
No	Description	Material	Dimension	Qty	Remark
Scale	1 : 15	Hard	ASTRA POLYTECHNIC		
Finish	Cutting	Roughness	Jl. Gaharu Blok F3 No.1 Lippo Cikarang, Cikatu - 17530		
Tolerance	Middle	HRC	Telp. (021)-651955, Fax. (021)-6519821		
4			Tribu.		
3			Jig Welding Universal		
1			Side Cover		
No.	Revision	Date	Sign	Dwg no.	
03-3	3-4	16-30-2010	139-315	B-JW-SA-PRT-002	
Fine	± 0.05	± 0.1	± 0.15	Origin:	
Middle	± 0.1	± 0.2	± 0.3	Deburred all sharp edge 0.3	
Rough	± 0.15	± 0.5	± 1.0	A4	
File name : C:\Users\20200303\Documents\201\Part\20200303\Side Cover.dwg					



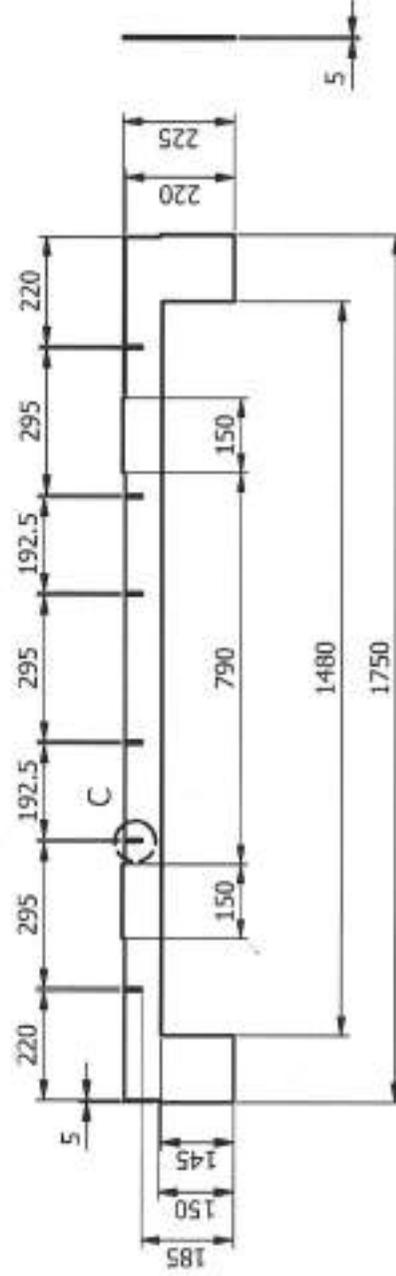
DETAIL B
SCALE 1 : 5



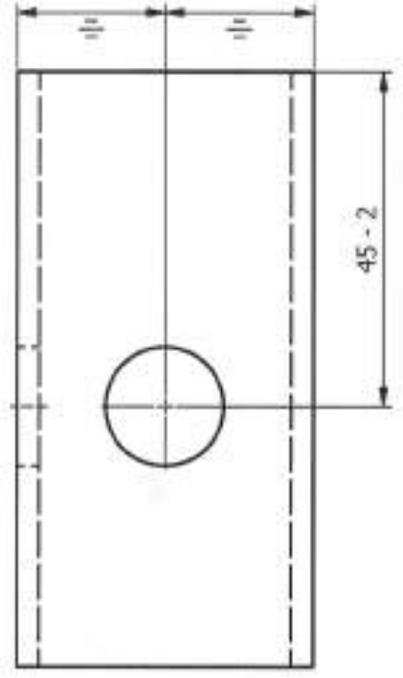
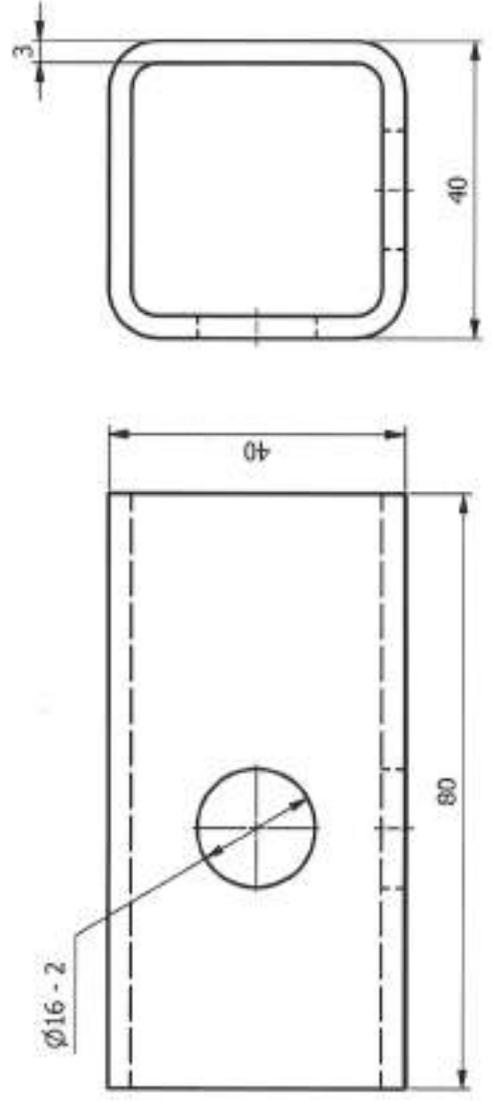
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No		Description		Material		Dimension		Qty		Remark	
Scale	1 : 10	Hard	Roughness	Checked	Approved						
Finish	Cutting		N7 (▽)								
Tolerance	Middle	HRC		Rina	Herry						
				21.7.23	Designed						
					Drawn						
No.	Revision	Date	Sign								
Accur	0.5 - 3	3 - 6	6 - 30	30-120	158-315	305-3008	1000-2000				
Fine	+0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5				
Middle	+0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2				
Rough	+0.15	±0.2	±0.5	±0.8	±1.2	±2	±3				
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				Jl.Gaharu Blok F3 No.1 Lippo Cikarang, Cikatu - 17530		telp. (021)-651955, fax. (021)-6519821					
				Title		Jig Welding Universal					
				Support Flange							
				Assy no.		B-JW-SA-01		Dwg no.		B-JW-SA1-PRT-004	
				No order :				Origin :		A4	
				Deburred all sharp edge 0.3						7 of 14	



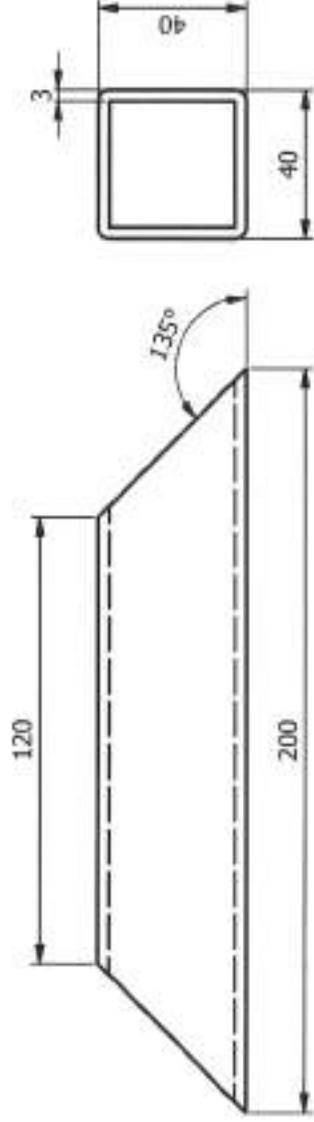
DETAIL C
SCALE 1 / 4



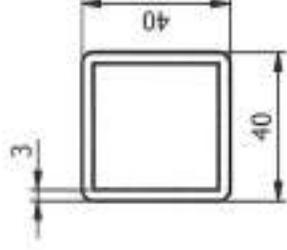
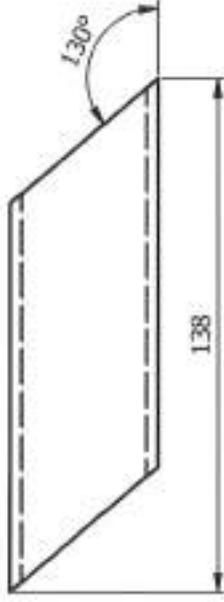
5	Support Rib	Sheet Metal	1750 x 225 x 5	4			
No	Description	Material	Dimension	Qty	Remark		
Scale	1 : 15	Hard					
Finish	Cutting						
Tolerance	Middle	HRC					
4							
3							
2							
1							
No.	Revision	Date	Sign				
Accur	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 315	315 - 1000	1000 - 2000
Fine	+0.05	+0.05	+0.1	+0.15	+0.2	+0.3	+0.5
Middle	+0.1	+0.1	+0.2	+0.3	+0.5	+0.8	+1.2
Rough	+0.15	+0.2	+0.5	+0.8	+1.2	+2	+3
File name : c:\users\luciano\Documents\Veri\2023-7-12\Astra\Astra\B-JW-Support Rib.dwg							
ASTRA POLYTECHNIC		Jl.Gaharu Blok F3 No.1 Lippo Cikarang, Cibatu - 17530		Telp.(021)-651955, fax.(021)-6519821			
Title:		Jig Welding Universal		Support Rib			
Asy no.		B-JW-SA-01		Drawg no. B-JW-SA1-PRT-005			
No order :		21.7.21		17			
Deburat at sharp edges 0.3				Origin :			
				A4			
				8 of 14			



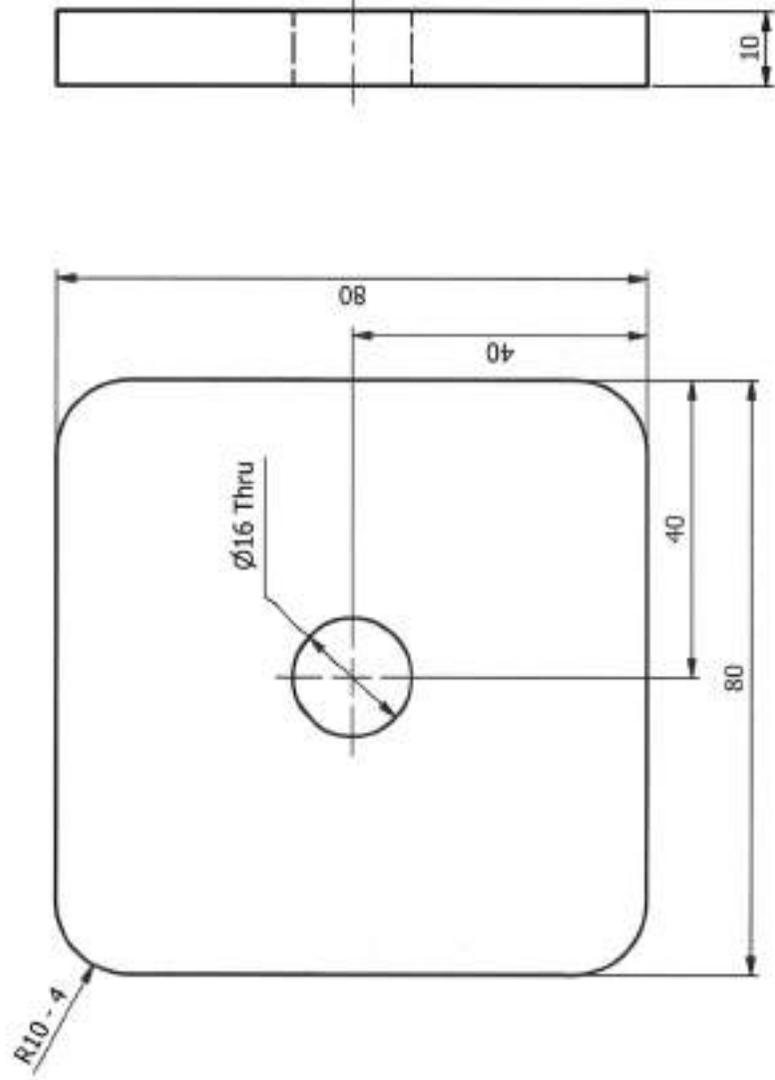
6	Locked Base	Hollow 3mm	80 x 40 x 40	4	
No	Description	Material	Dimension	Qty	Remark
Scale	1 : 1	Checked			
Finish	Cutting	Approved			
Tolerance	Middle	HRC			
		Roughness			
		Hard			
		Sign			
No.	Revision	Date			
Accour	0.5 - 1	3 - 6	16 - 30	30 - 120	120 - 315
Fine	+0.05	+0.08	+0.1	+0.15	+0.2
Middle	+0.1	+0.1	+0.2	+0.3	+0.5
Rough	+0.15	+0.2	+0.5	+0.8	+1.2
					+2
					+3
File name : C:\Users\A212862\Documents\rev_2023-7-27_Holo Assy\06_2023-7-27_Upper Assy\Locked Base.dwg					
<p>ASTRA POLYTECHNIC Jl. Gaharu Blok F3 No.1 Lippo Cikarang, Cikatu - 17530 telp. (021)-651955, fax. (021)-6519821</p> <p>Jig Welding Universal Locked Base</p> <p>Assy no. B-JW-SA-01 Dwg no. B-JW-SA1-PRT-006 No order : Origin : Deburan all sharp edge 0.3</p>					
					A4
					9 of 14



6	Hollow Support Frame			Hollow 3mm	200 x 40 x 40	12	
No	Description			Material	Dimension	Qty	Remark
Scale	1 : 2	Hard	Roughness	Checked / Approved			
Finish	Cutting		N7 (√)	<i>[Signature]</i>			
Tolerance	Middle	HRC		<i>Rina</i>			
4				<i>Rina</i>			
3				21.7.23			
2				Designed			
1				<i>[Signature]</i>			
No.	Revision	Date	Sign				
Accur	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 515	515 - 1000	1000 - 2000
Fine	+0.05	+0.05	+0.1	+0.15	+0.2	+0.3	+0.5
Middle	+0.1	+0.1	+0.2	+0.3	+0.5	+0.8	+1.2
Rough	+0.15	+0.2	+0.5	+0.8	+1.2	+2	+3
File name : C:\Users\B201002\Documents\2023-24\Aster\Asap\Wor_2023-24\Lower Assembly Support Frame.dwg							
Title				ASTRA POLYTECHNIC			
Jig Welding Universal				Jl. Gaharu Blok F3 No.1 Lippo Cikarang, Cibatu - 17530			
Hollow Support Frame				Telp. (021)-6519555, fax. (021)-6519821			
Asy no.				Dwg no.			
B-JW-SA-02				B-JW-SA2-PRT-006			
No order :				Origin :			
Deburred all sharp edge 0.3				A4			
				11 of 16			



7	Hollow Support Holder			Hollow 3mm	138 x 40 x 40	8	
No	Description			Material	Dimension	Qty	Remark
Scale	1 : 2	Hard	Roughness	Checked / Approved			
Finish	Cutting		N7 (▽)	<i>[Signature]</i>			
Tolerance	Middle	HRC		<i>Rina</i>			
				<i>21.9.23</i>			
				Designed			
				<i>[Signature]</i>			
				<i>Aziz</i>			
				<i>[Signature]</i>			
No.	Revision	Date	Sign				
Accur	0.5 - 3	3 - 6	6 - 30	30 - 120	120 - 315	315 - 1000	1000 - 2000
Fine	+0.05	+0.05	+0.1	+0.15	+0.2	+0.3	+0.5
Middle	+0.1	+0.1	+0.2	+0.3	+0.5	+0.8	+1.2
Rough	+0.15	+0.2	+0.5	+0.8	+1.2	+2	+3
Title:				ASTRA POLYTECHNIC			
Jl. Gaharu Blok F3 No.1 Lippo Cikarang, Cibatu - 17530				Telp. (021)-651955, Fax. (021)-6519821			
Title:				Jig Welding Universal			
Hollow Support Holder				Hollow Support Holder			
Assy no.				Dwg no.			
B-JW-SA-02				B-JW-SA2-PRT-007			
No order :				Origin :			
Deburred all sharp edge 0.3				A4			
1.2 of 1.6				1.2 of 1.6			



8	Shoes Foot		SS41	80 x 80 x 10	6	
No	Description		Material	Dimension	Qty	Remark
Scale	1 : 1	Hard	Checked Approved			
Finish	Mill		<i>[Signature]</i>			
Tolerance	Middle	HRC	Rina			
			21.7.23			
			Designed			
			<i>[Signature]</i>			
			Aziz			
			21.7.23			
			21.7.23			
No.	Revision	Date	Sign	Title		
Accurf	0.5 -> 3 -> 4 -> 6 -> 30 -> 120	120 - 315	315 - 1000	ASTRA POLYTECHNIC		
Fine	±0.05	±0.1	±0.15	Jl. Galuh Blok F3 No.1 Lippo Cikarang, Cibatu - 17530		
Middle	±0.1	±0.2	±0.3	telp. (021)-6519555, fax. (021)-6519821		
Rough	±0.15	±0.2	±0.5	Jig Welding Universal		
			±0.8	Shoes Foot		
			±1.2	Asy no. B-JW-SA-02		
			±3	Dwg no. B-JW-SA2-PRT-008		
No. of Revision				No order : Origin :		
1				Deburred at sharp edge 0.3		
2				A4		
3				1.3 of 1.4		
4						

File name : C:\Users\K2023002\Documents\2023-2024\Lower Assy Shoes Foot.dwg

