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UNIVERSITI
TEKNOLOGI
MARA

KURODA

INDUSTRIAL TRAINING FIELD REPORT

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ACKNOWLEDGEMENTS

Praise to the one and the almighty Allah SWT because I managed to write this full industrial training report.

This report outlines the duties of an internship that undergo at Kuroda Precision Malaysia (KPM), Bukit Raja, Selangor through Minda Jaya Resources as an employee agent. KPM is a company that provide high quality stator for DYSON vacuum and hairdryer product which is one of the worldwide brands. There are four department which is Press, department that creating the product from coil, Offline, department that confirm the product quality, Quality control, department that ensure the product quality is meet the customer satisfaction and Maintenance, department that ensure all equipment and important tools are always in top condition.

As duty as an operator, all the production quality should be monitored from time to time and responsible to inform technician or leader whenever there is problem occurred. Within four months of training, there is so much to learn and experienced in this company, the biggest things that to be experienced is to work 12 hours and six days a week also rotating shift for each week.

I take this opportunity to say thank you to my precious parents, family and my beloved members who helped me and always giving me ideas and support while I am completing this report. I also would like to thanks all of the lecturers in UiTM Pasir Gudang, especially the lecturers in Chemical Engineering Department that had helped me in giving a guide in writing this industrial training report and sharing all their knowledge with me while I am a student in there.

1.0 INTRODUCTION

Industrial Training (CHE353) is a final subject that need to be taken by diploma student of Chemical Engineering (EH110). The Industrial Training is important for student to applied all the theories learned during semester 1 until semester 5 in a real working environment. The students are free to choose the company to undergoes the Industrial Training according to the allowance provided, location of the company and the relevance to career path. During the Industrial Training, student will be able to perform the basic engineering practice and improving their career skills such as communication skill, leadership skill and problem solving skill. Students also be able to learn about the work ethics, disciplinary, punctuality and have a high level of integrity. All of these skill will be needed when the student want to pursue their career in the future. The duration for Industrial Training is 14 weeks with 7 credit hours.



Figure 1.1 : Location of Kuroda Precision Malaysia via Google Map



Figure 1.2 : Kuroda Precision Industries (M) Sdn. Bhd factory view

2.0 CONTENT

2.1 Organization Chart and History of the Company

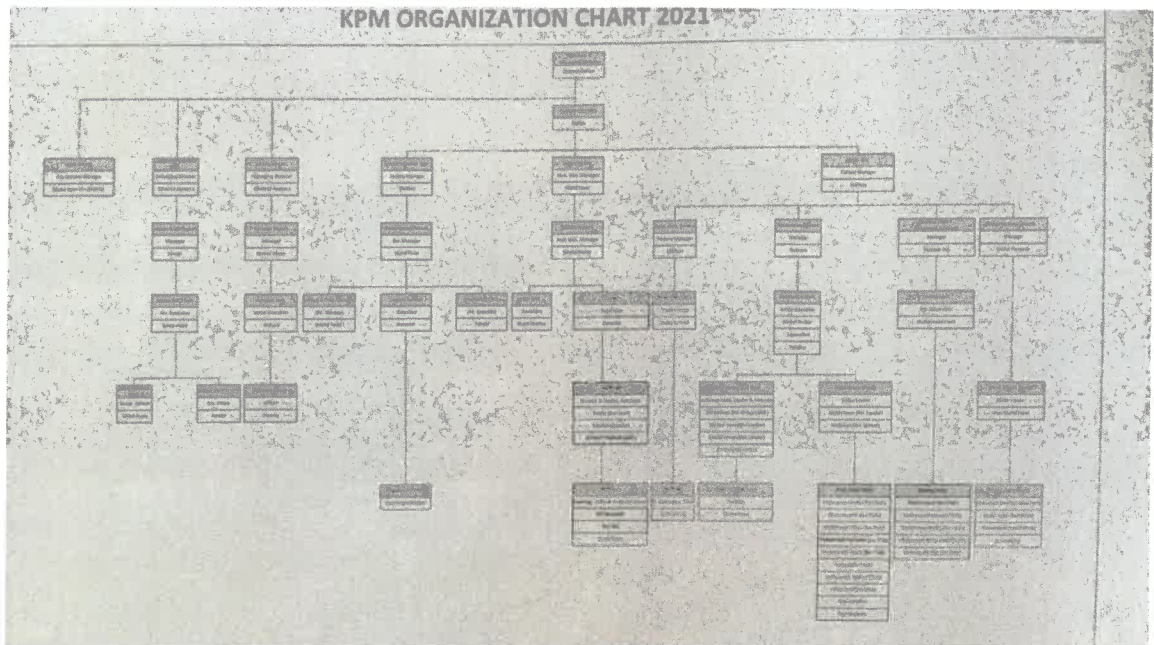


Figure 2.1.1 : Kuroda Precision Industries (M) Organization Chart

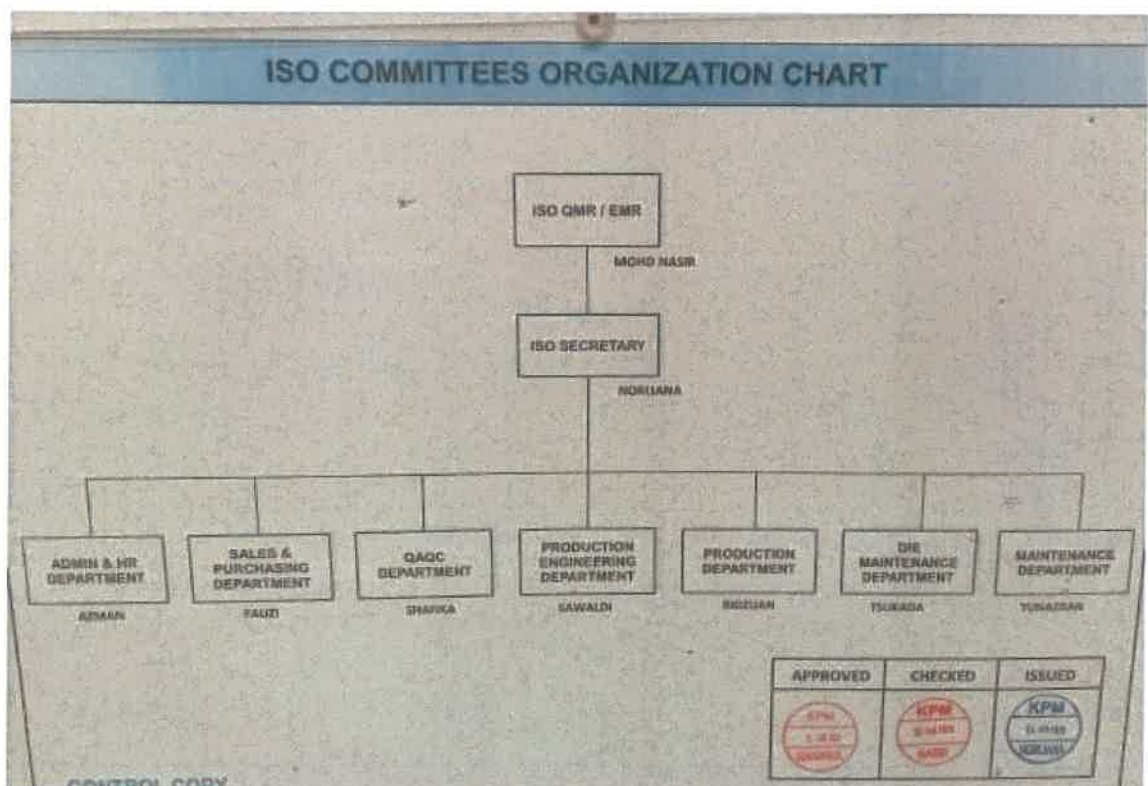


Figure 2.1.2 : ISO Organization Chart

KURODA

Figure 2.1.3 : Organization Logo

Kuroda Precision Industries (M) LTD or its short name KPM is first established during 1996. Kuroda Precision Industries is a factory that produce tool and die equipment. In 1997 Kuroda Precision Industries produce motor core lamination for Iphone vibrate plate. During this present time Kuroda Precision Industries is running model V10 stator product for DYSON vacuum and the products made will be send to DYSON customer.



Figure 2.1.4 : Sample Die

Kuroda Precision Industries main activity is producing tool and die equipment and precision stamping on 40 to 60 ton pressed equipped with laser welding system. Kuroda also do maintenance service for progressive die and manufacturing tool and die components for motor and transformer lamination. The picture above shows one of DIE sample with 4 four rows and 8 laser units that had inside the Kuroda Factory. There are 26 DIE contain inside the factory following using alphabet from DIE A to DIE Z.

2.2 PROCESS FLOW

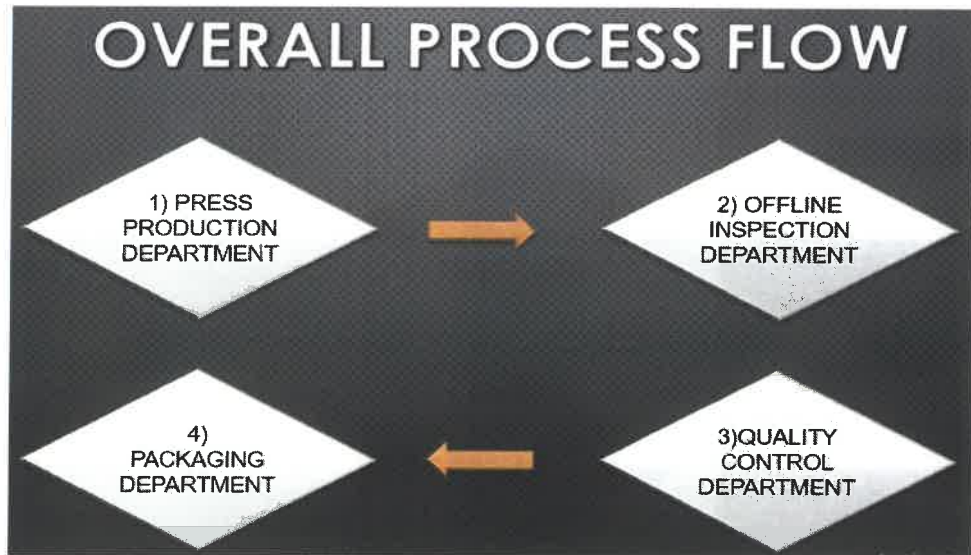


Figure 2.2.1 : Overall Process Flow in KPM Factory

In Kuroda Precision Industries (M), there are four department which are Press Production Department, Offline Inspection Department, Quality Control Department and Packaging Department.

Press production department is a department where the product "V10" was been produced from the coil. The products then will be observe by using microscope to find whether there is an NG (not good) products or not. The NG product will then separate from OK products. All of the OK product need to be peel off the extra layer before send it to Offline inspection department. In Offline inspection department, the products will be cut using stack height adjustment to make sure the height of the product is precise. Then, the product will be inspect by using microscope and V10 Inspection Automation machine to spot whether there is any NG on the product. Then the will be put into a tube and sent to the Quality control department. In Quality control department, the product quality will be observe to make sure that all the product is meet the customer requirement. Then the product will be sent into a Packaging department to put it into dryer before been export to the customers.



Figure 2.2.2 : Press Production Department



Figure 2.2.3 : Offline Inspection Department



Figure 2.2.4 : Quality Control Department



Figure 2.2.5 : Packaging Department

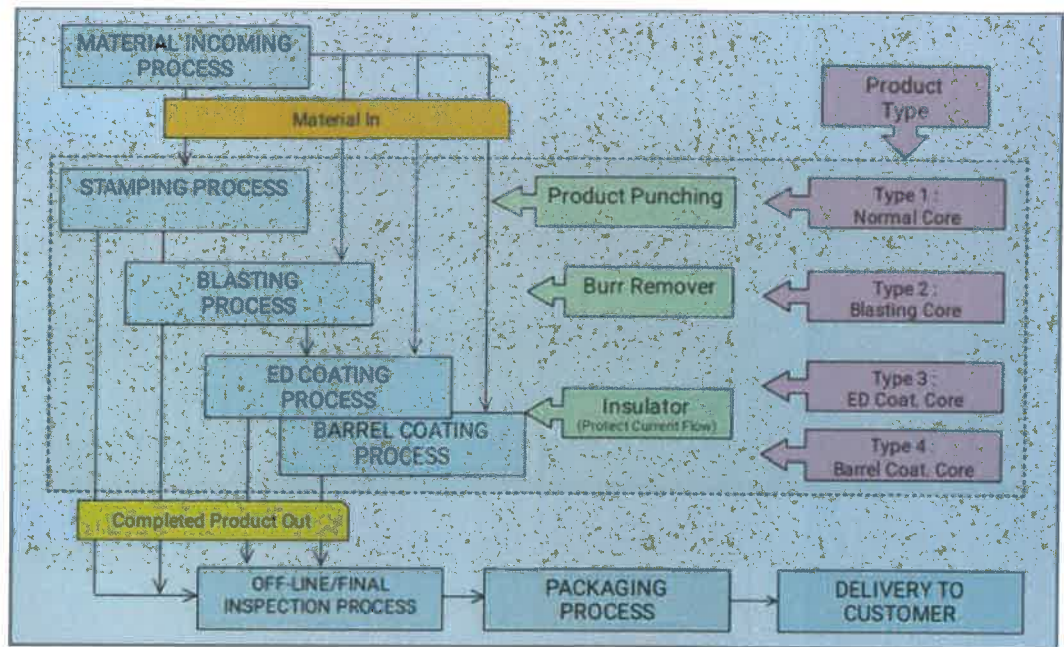


Figure 2.2.6 : Flowchart of Product Exportation

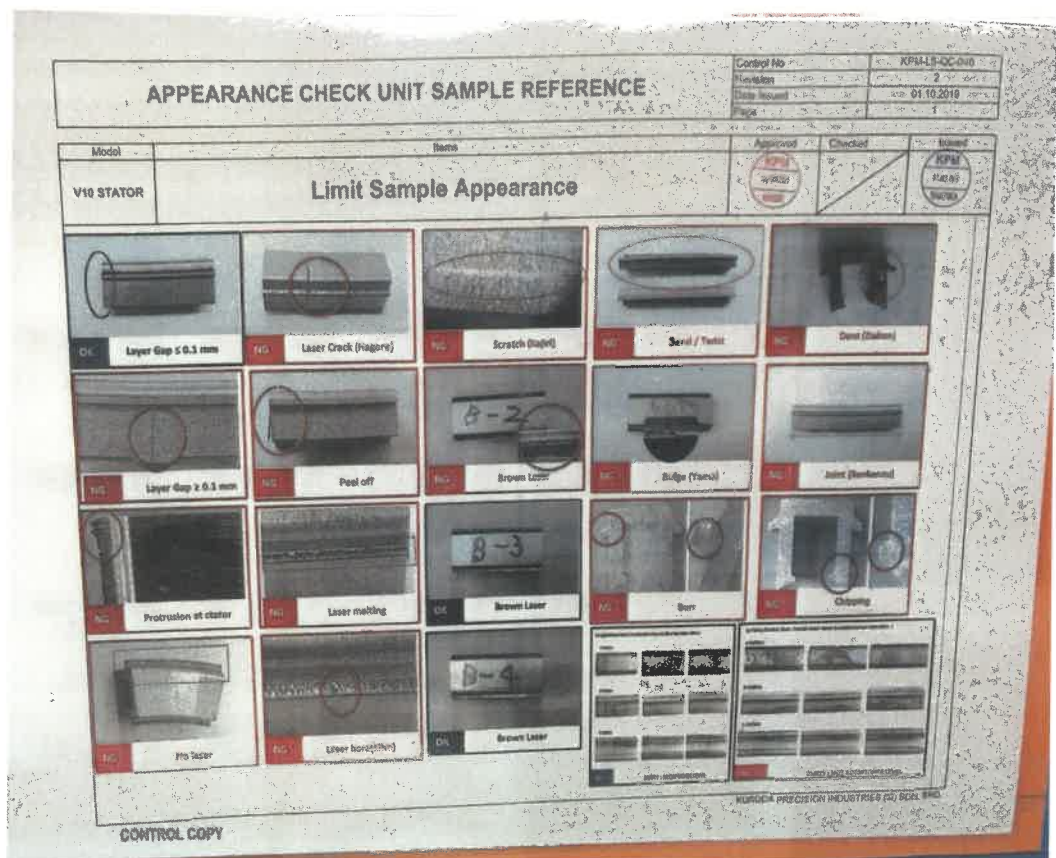


Figure 2.2.7 : Type of NG Products

2.3 Daily/ Weekly Activity

<p>Week 1 (21/3/2021 - 26/03/2021)</p>	<ul style="list-style-type: none"> - All of the students were given a introduction to the company by HR executives. The content of the introduction was the to explain about the background of the Kuroda Precision Industries (M) and review the flow of production process. The training were also conducted during this week to make sure that the student understand the works in each departments. The students were also been exposed to the SOP and 5S off all departments.
<p>Week 2 (29/03/2021- 2/04/2021)</p>	<ul style="list-style-type: none"> - Training at offline department - This week, the students have to be trained at offline department under the supervision of Ms. Asma, the leader of offline department. - The training for this week consist of visual (to identify the NG products while memorizing the types of NG products), stack height adjustment (how to cut the product into desire height), making barcode (to categorize the DIE of the products) and appearance check (to observe NG products).
<p>Week 3 (5/04/2021 – 9/04/2021)</p>	<ul style="list-style-type: none"> - This week, the students still undergoes the same training at offline department with additional training and less supervision. The purpose is to make sure that students will be able to work independently. - The additional training was CV inspection, where the students need to identify over and minus product that still acceptable by using the tool 'stack height master'. The OK products reading are in range of 21.850 to 22.150.
<p>Week 4 (12/04/2021- 16/04/2021)</p>	<ul style="list-style-type: none"> - This week the student learn how to using the V10 Inspection Automation Machine. All the products that go into the machine will be separated to 2 types which are NG products and OK products.

	<ul style="list-style-type: none"> - The OK product will be insert into tube and before that the products will need to be observe by using microscope and straightness jig to make sure that the product is not an NG products.
Week 5 (19/04/2021-23/04/2021)	<ul style="list-style-type: none"> - This week, I was transferred to the Press Production Department. This is a production department where it only focusing on production of V10 products. - There are 14 machine which are called as Line. I was transferred to become an operator of Line 10 with the pair of DIE K and DIE F. - I learned about how to remove peel off from the product and also how to write a lable on Press Transfer Card and QC Inspection Transfer Card.
Week 6 (26/04/2021-30/04/2021)	<ul style="list-style-type: none"> - This week, I learned how to read a thickness of the coil for model V10 material. This thickness have to be write down every time the coil changed. - I also learned how to paste the coil lable material on V10 Model Press Department book for DIE K and DIE F at Line 10. And also continue to train on how to write a lable transfer card and read thickness of the coil.
Week 7 (3/05/2021-7/05/2021)	<ul style="list-style-type: none"> - This week, I undergoes training on how to cleaning DIE under the guidance of Press Department Technician and under supervision of Mr. Faizal, the Senior Leader Technician of Press Department. - Cleaning DIE is required to stabilize the DIE and the lifelong of DIE to be operate. This also important to avoid NG Dakon (dents) on products. - I also learned how to avoid laser melting on the product by wiping the pair mirror of laser unit because of the oil stain on the surface of the mirror.
Week 8 (10/05/2021-14/05/2021)	<ul style="list-style-type: none"> - Hari Raya Eid Fitri Celebration

Week 9 (17/05/2021-21/05/2021)	<ul style="list-style-type: none"> - The Head of Engineering Department explain about how to handle the chemical substance such as Blanking Oil. The operator were required to wear a gloves and safety spectacles when handling the chemical substance. - There are also safety equipment on every line such as safety helmet, safety glasses and safety earplug to make sure that the safety of the employees.
Week 10 (24/05/2021-28/05/2021)	<ul style="list-style-type: none"> - I learned about how to Open DIE for Regrinding. This is required when the stroke of DIE has reached its limit and need to be change to its DIE pair. - Open DIE also can be performed when there is quality problem on the product that make the press machine unable to continue its production.
Week 11 (31/05/2021-4/06/2021)	<ul style="list-style-type: none"> - This week I learned on how to setting DIE into Press machine. Setting DIE is performed after the Open DIE has been completed. - First step is to insert the DIE clamp into DIE. After that, insert pil tube, vaccum hose tube, scrap hose pilot, air supply for ODD, fiber laser unit and lastly laser unit cap in front of laser unit. - Then, inching the coil and check whether there is a problem and lastly check the Bara and product if there is a NG or not on the products.
Week 12 (7/06/2021-11/06/2021)	<ul style="list-style-type: none"> - I learned how to setting coil in Press machine for this week. - Firstly, the operator need to wear glove because the coil is sharp. Then, the coil need to be cut in one loop and take off the sticker lable on the coil and paste it on Press department book. - After that, insert the coil until the Press machine cutter and add stopper to make sure coil unable to move. Inching 1 round and push the coil until it touch the end of the DIE and the open feeder.

<p>Week 13 (14/06/2021-18/06/2021)</p>	<ul style="list-style-type: none"> - This week I learned how to do all the checklist on the Press machine equipment by Press department technician. The checklist is daily check card of Press machine, Laser Box monitoring, 5S cleaning checklist and Press machine output graph. - I also undergoes training for Laser Brown NG to decreased the laser brown NG. This NG happened because of the oil stain or excess oil on the ODD that make the laser unit unable to work properly.
<p>Week 14 (21/06/2021-25/06/2021)</p>	<ul style="list-style-type: none"> - This week, I learned on how to update stroke for Open DIE for Regrinding. The stroke can be updated by the operator by observing the stroke count on the machine control box. - If the stroke count is already reached 900000, the DIE need to be change.
<p>Week 15 (28/06/2021-2/07/2021)</p>	<ul style="list-style-type: none"> - The supervisor of Press department, Ms. Tuhaizu, ask the press operator to update non NG product and can be use product on yellow plastic. This products then will be observe by Ms. Tuhaizu to confirm whether the product still can be use or not. - I also learned to counting the balance coil for press department because of inventory press stock count for end of the month. - The offline department will count the product box made from the Press department.
<p>Week 16 (5/07/2021 – 9/07/2021)</p>	<ul style="list-style-type: none"> - Due to the MCO, the factory are closed and the student were given the task from the supervisor, Ama bin Maruf. The task is to conduct a research on Blanking Oil. - The Blanking Oil is one of the chemical used in Press department, this oil is a lubricant for the coil. I search the Safety Data Sheet (SDS) of Blanking oil and know about the hazard and how to handle this chemical.

<p>Week 17 (12/07/2021-16/07/2021)</p>	<p>- The factory is also closed during this week so the supervisor, Ama Bin Maruf give the student one more task which is to do a research on the V10 product and I found out that this V10 product is actually one of the vaccum product that been developed by Dyson. It is called as Dyson Cyclone V10 vaccum. However there are not much that can be learned due to the limited resources. So, I asked the supervisor to do the logbook and industrial training report during this week.</p>
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Table 2.3.1 : Weekly Activity



Figure 2.3.1 : Press Department Machine Control Box

The machine control box is use to on and off press machine. The machine control box is also use to control the movement of the press machine and SPM (speed per minute) of the stamping machine.



Figure 2.3.2 : Fastec Controller

Fastec Controller is used to control the laser welding process. It is also used to control the layer setting of product and the length of product.



Figure 2.3.3 : Laser Box

The laser box is used to produce a laser and control its voltage, temperature, and joules (mon).



Figure 2.3.4 : Uncoiler Machine

The uncoiler machine is use to supply coil into the press machine (DIE).

The working hours at Kuroda Precision Industries (M) is a 12 hours shift. There are two shift which are shift A and shift B. Shift A is as a normal shift, the working hours is from 8.00 in the morning until 8.00 in the night. Meanwhile, the shift B is a night shift, the working hours is from 8.00 in the night until 8.00 in the morning. Kuroda Precision Industries (M) factory operate everyday from Monday to Sunday. However, the workers can choose whether to go to work or not on Sunday. During 12 hours shift, there are three time break for rest/lunch at 10.00 am – 10.20 am, 12.00 pm – 12.40 pm and 4.00 pm – 4.20 pm. This time break is also the same for night shift. On Friday, the afternoon break is longer than usually break because to give time for muslim employees to pray. During fasting month, the factory start operate and end work 1 hour earlier than normal working hours. This is to ensure that muslim employee can iftar on time.

Days	Start Shift	First Break	Second Break	Third Break	End Shift
Monday - Thursday	8.00am	10.00am- 10.20am	12.00pm- 12.40pm	4.00pm- 4.20pm	8.00pm
Friday	8.00am	10.00am- 10.20am	12.00pm- 1.40pm	4.00pm- 4.20pm	8.00pm
Saturday - Sunday	8.00am	10.00am- 10.20am	12.00pm- 12.40pm	4.00pm- 4.20pm	8.00pm

Table 2.3.2 : Normal Working Hours

Days	Start Shift	First Break	Second Break	Third Break	End Shift
Monday - Thursday	7.00am	10.00am- 10.20am	12.00pm- 12.40pm	4.00pm- 4.20pm	7.00pm
Friday	7.00am	10.00am- 10.20am	12.00pm- 1.40pm	4.00pm- 4.20pm	7.00pm
Saturday - Sunday	7.00am	10.00am- 10.20am	12.00pm- 12.40pm	4.00pm- 4.20pm	7.00pm

Table 2.3.3 : Working Hours During Fasting Month

2.4 Description of Task Assigned

2.4.1 Press Department Standard of Procedure

In this section will be showing of the different training and project that I had been through on press department such as product collection, setting coil, Open DIE for regrinding, setting die after regrinding, cleaning DIE and laser adjustment.

Control No.	KPM-SP-PR-048	Standard Operation Procedure	Approver	RIDZUAN	MOHD SHUKOR	TUHAZU
Rev. No.	01		30.08.2020	Page: 1/1		
Model	ALL MODEL					
Drawing No.	NIL					
Process Name	SETTING COIL IN DIE (DYSON)					

1) REQUIRED TOOLS (ALAT-ALAT YANG DIPERLUKANI)

- Coil Cutter
- Glove
- Allen key 5mm

2) SAFETY MEASURE (LANGKAH LANGKAH KESELAMATAN)

- Make sure the machine is not operating.
Pastikan mesin tidak beroperasi.
- Make sure the glove is always worn during the process.
Pastikan gloves sentiasa dipakai ketika melakukan proses ini.

3) PROCEDURE (CARA KERJA)

- Cut the beginning of the coil in 1 loop and the ends of the coil in straight pieces (Figure 1)
Potong 1 gelang awal dan satu hujung lurus dan hujung yang lain lurus (Gambar 1)
- Insert coil into the die until the cutter comes out the butt of the material.
Masukkan coil ke dalam die sehingga pengira keluar belakang bahagian hadapan die.
Masukkan coil ke dalam die sehingga pengira keluar belakang bahagian hadapan die.
- Loosen the screws of the cutter curves use allen key 5mm (Figure 2).
Longgarkan skru di hujung cutter menggunakan allen key 5mm (Gambar 2).
- Direct the Operation Selector in Inch (Inching) and switch on Slide Operation Mode.
Arahkan Seleksi Operasi ke arah Inch (Inching) dan alihkan Seleksi Operasi ke Slide Operation Mode.
- Direct Slide Adjustment to -A (Down) and press up to Die Height Low reading (Figure 3).
Arahkan Slide Adjustment ke -A (Down) dan tekan sehingga bacaan Die Height Low (Gambar 3).
- Off Switch Slide Operation Mode and move the press machine to a level (360 degrees).
Alihkan Seleksi Operasi Slide dan gesarkan mesin press ke paras (360 degree).
- Contact 1 round inching material and lightly tighten the screw to cut the material part.
Hubung 1 gelang inching dan ketatkan skru dengan ringan untuk memotong bahagian material.
Masukkan coil ke dalam die until fitted on the stopper coil (Figure 2).
Masukkan coil ke dalam die sehingga sesuai pada penutup coil (Gambar 2).
- Direct the Operation Selector Switch to Inch (Inching) and on Slide Operation Mode Switch.
Arahkan Seleksi Operasi ke arah Inch (Inching) dan alihkan Seleksi Operasi ke Slide Operation Mode Switch.
- Move the Slide Adjustment to -A (Down) and press up to Die Height Low reading (Figure 3).
Arahkan Slide Adjustment ke -A (Down) dan tekan sehingga bacaan Die Height Low (Gambar 3).
- Off the Slide Operation Mode and move the press machine to a level (180 – 170 degrees).
Alihkan Seleksi Operasi Slide dan gesarkan mesin press ke paras (180 – 170 degree).
- Point the Feeder Switch to Feed (Figure 4).
Arahkan Seleksi Feeder ke arah Feed (Gambar 4).
- During inching make sure the ends of the coil don't get caught up to Cutter Die (Figure 5).
Semasa melakukan proses inching, pastikan hujung coil tidak caught sehingga sampai ke Cutter Die (Gambar 5).
- Move the press machine to level (0 degrees) and switch On Slide Operation mode.
Gesarkan mesin press ke paras (0 degree) dan alihkan Seleksi Operasi ke Slide Operation mode.
- Set Slide Adjustment to +A (Up) and press up to Die Height High reading.
Arahkan Slide Adjustment ke +A (Up) dan tekan sehingga bacaan Die Height High.
- Off Switch Slide Operation mode.
Alihkan Seleksi Operasi ke Slide Operation mode.
- Machine ready to operate.
Mesin sudah siap beroperasi.
- Off the Slide Operation mode.
Pastikan alihkan Seleksi Operasi ke arah Slide Operation mode.

CONTROL COPY




Figure 1 (Gambar 1)




Figure 2 (Gambar 2)




Figure 3 (Gambar 3)




Figure 4 (Gambar 4)




Figure 5 (Gambar 5)

Figure 2.4.1 : SOP of Setting Coil



Figure 2.4.2 : Setting coil using inching method and position while setting coil in Dyson V10 press machine (DIE)

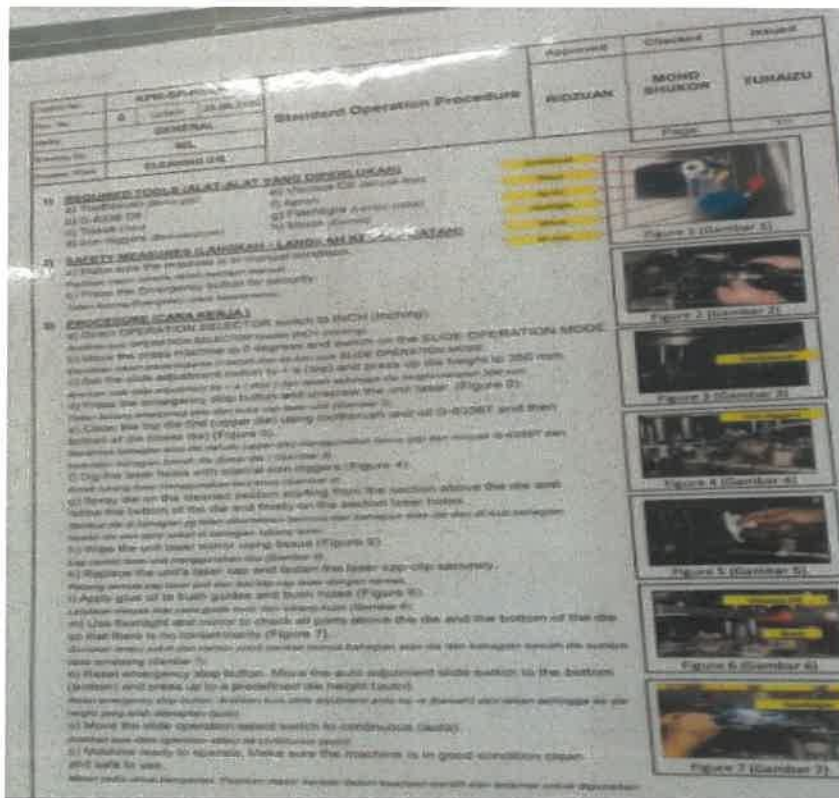


Figure 2.4.3 : SOP of Cleaning DIE



Figure 2.4.4 : Cleaning DIE bucket with toothbrush and huge brush with punching oil as lubricator

Cleaning DIE is necessary when coil has finish on press machine (DIE) and need to be clean so that the DIE can stabilize and avoid NG on V10 product model.



Figure 2.4.5 : Cleaning DIE Mirror

The mirror is used to so that the operator can see the upper surface of DIE to brush the dirt off easily.

2.4.2 Product Collection and Transfer

Case No.	KPM-SP-PR-038	Standard Operation Procedure	Approved	Checked	Issued	
Rev. No.	0		30.06.2020	RIZLIAN	MOHD SHUKOR	TUHAZU
Model	Dyson (V10)					
Company No.	NIL					
Process No.	PRODUCT COLLECTION AND TRANSFER			Page	1/1	

- 1) **REQUIRED TOOLS / ALAT-ALAT YANG DIPERLUKAN**
 - a) Product Box (Figure A) (gambar A)
 - b) Transit Box (Figure B) (gambar B)
 - c) Glove (Figure C) (gambar C)
 - d) Finger cot (Figure D) (gambar D)
- 2) **SAFETY MEASURES / LANGKAH - LANGKAH KESELAMATAN**

a) Make sure the work area is clean and safe.
Pastikan kawasan kerja adalah bersih dan selamat.
- 3) **PROCEDURE / CARA KERJA**
 - a) Set up box product 4 pcs per role (Figure 1).
Sediakan box product 4 pcs untuk setiap role (Gambar 1).
 - b) Make sure each box has ANTI RUST 1 pcs and has an expiration date.
Pastikan setiap box mempunyai ANTI RUST 1 pcs dan ada tarikh luput.
 - c) The anti rust should be changed 2X in a month.
Anti rust hendaklah ditukar setiap 2x dalam sebulan.
 - d) Take product from machine using glove (Figure 2).
Ambil product dari mesin menggunakan glove (Gambar 2).
 - e) Insert product into transit container (Figure 3).
Masukkan product ke dalam bekas transit (Gambar 3).
 - f) Before removing peel off, make sure glove is included finger cot is used first (Figure 4).
Sebelum proses buang peel off pastikan glove beserta finger cot dipakai terlebih dahulu (Gambar 4).
 - g) The process of removing the peel off by hand (Figure 5).
Proses membuang peel off menggunakan tangan (Gambar 5).
 - h) Make sure no more peel off.
Pastikan tiada lagi peel off.
 - i) Separate the coils in the box provided (Figure 6).
Ajarikan besi dalam box yang disediakan (Gambar 6).
 - j) Product set into box product (Figure 7).
Masukkan product ke dalam box product (Gambar 7).
 - k) Insert a press transfer card into each box (Figure 8).
Masukkan press transfer card ke dalam setiap box (Gambar 8).
 - l) Make sure the product is taken offline every 2 hours by the operator or technician (Figure 9).
Pastikan product diambil offline oleh operator atau technician setiap 2 jam (Gambar 9).




























Figure 2.4.6 : Product Collection SOP



Figure 2.4.7 : Microscope Check Section

Before collecting V10 product first the operator needs to check the appearance all four rows condition of V10 product model before collecting it.



Figure 2.4.8 : Product Collection Box

After confirming the appearance check of V10 product model condition is good and free from NG (Not Good) the operator can carry the tray and pour it into the tray box containing verzone anti rust to keep the product safe and free from rust. Make sure that the operator is wearing gloves while holding V10 product model.



Figure 2.4.9 : Peel off tray box after appearance check on microscope section

After appearance check and V10 product model is free from NG the operator can pour into four of these boxes according to row 1 until row 4. After that the operator can remove the peel off from V10 product model and put it below the box.

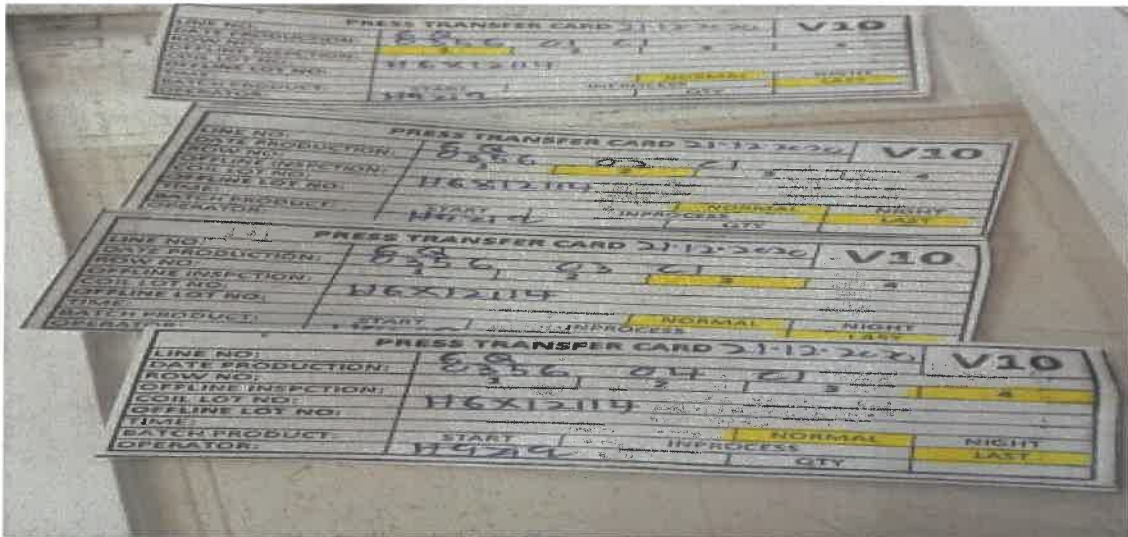


Figure 2.4.10 : Press Transfer Card Label

After completing removing peel off from V10 product model. The operator needs to write label card that need to stick to the box to be send to the offline department.

2.4.3 Open DIE for Regrinding



Figure 2.4.13 : Counter Stroke

Open DIE for regrinding is required when the stroke is already reaching its limit. As shown in the diagram above the counter stroke has reach about nine thousand which require open DIE for regrinding for the press machine to change its DIE pair to continue production without harming the life shelf of DIE.

V10 RUNNING MACHINE STROKE					DATE
					SHEET
					NO.
MACHINE NO	DIE NO	RESULT	START STROKE	UPDATE STROKE	STROKE RUNNING
1	DIE N DIE S		9,999,700	10,078,600	626,900
2	DIE L DIE A		31,795,500	32,458,400	660,900
3	DIE I DIE O		46,667,300	47,229,200	566,100
4	DIE D DIE Y		62,998,000	63,719,100	721,100
5	SHT 1A SHT 2A/2B		13,950,500	14,578,200	627,700
6	DIE P DIE Q		83,534,100	84,410,900	876,800
7	DIE K DIE H		61,685,000	61,927,200	242,200
8	DIE G DIE E		75,667,000	76,082,300	415,300
9	DIE R DIE U		80,947,200	81,647,200	700,000
10	DIE T DIE K		55,329,000	55,550,100	221,100
11	DIE J DIE T		39,901,800	40,227,100	325,300
12	DIE M DIE W		46,468,900	46,894,400	425,500
13	DIE Z DIE B		116,341,100	116,741,900	400,800
14	DIE C DIE V		86,47,000	87,47,000	100,000

Figure 2.4.14 : Maintenance V10 Running Machine Stroke Record

Every open DIE for regrinding requires the notice from the maintenance department. Every time when closing the factory, the maintenance will round machine to machine and line to line to update the stroke on every press machine in order to tell the operator or the technician to open the DIE for regrinding or not. The purpose of maintenance record V10 stroke machine on press machine DIE is to aware that the DIE ODD need to be grind or not so that the DIE is not damaged and can be used for a long time.



Figure 2.4.15 : Sample of DIE that need to be grind

Inside the maintenance station the DIE will be grind so that the punch of DIE ODD will be sharp and able to cut the coil to avoid chipping occurrence on V10 model product. Inside the maintenance station is also where the technician sends the DIE that has been opened to send it to the maintenance station.

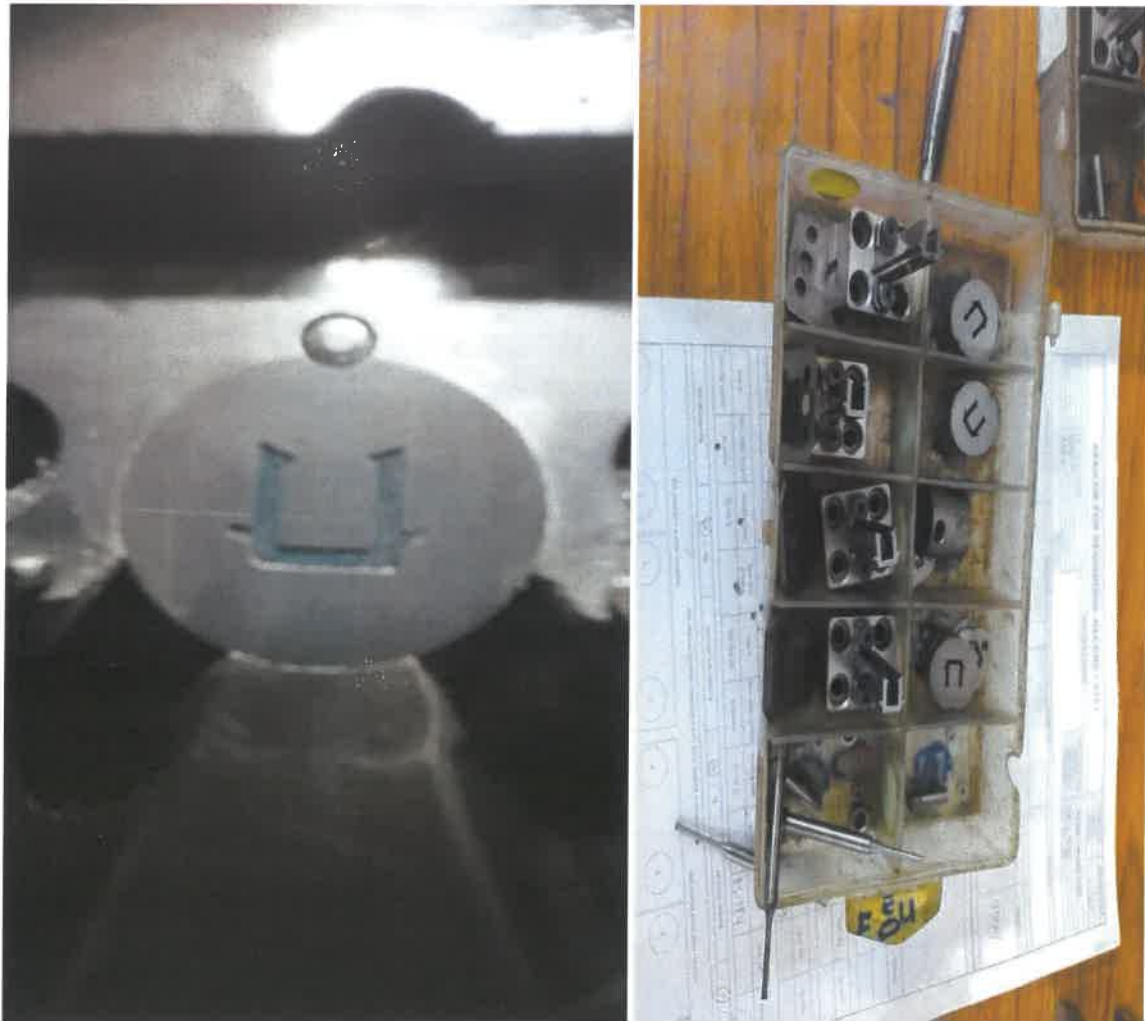


Figure 2.4.16 : Sample of ODD inside DIE

Inside every DIE there is an ODD where the product of V10 model is formed when press stamping machine is punching and laser welding is shooting to form one V10 product model every second. The ODD must be taken care carefully to avoid production interference because without the ODD the press machine DIE is unable to operate producing products and can't make production.

During MCO, the Kuroda Precision Industries (M) factory have to shut down the operation to prevent virus Covid-19 to spread. The supervisor, Ama Bin Maruf have assigned us a task to do when I at home. The task is to find the information of Blanking Oil or Punching Oil. This Blanking oil is a one chemical use in machine to produce the V10 products.



Figure 2.4.17 : Sample of Blanking Oil



Figure 2.4.18 : Blanking Oil Container

Blanking oil is used to increase the shelf life of punch and die. The blanking oil can stabilize the cutting process of product and most importantly the blanking oil is important to control the quality of product to avoid NG dakon and twist etc. The blanking oil drop to machine is about two to five seconds per drop.

3.0 CONCLUSION

During the Industrial Training at Kuroda Precision Industries (M) LTD, its technician and operator department have long been exposed to various activities and tasks in this company indirectly, trainees also must know every responsibility and role in the company. Exposure to real working environment is good for student as trainers, especially to open the minds and brains to be more creative and highly knowledgeable, students can also identify and address issues that often arise in real work situations. It will further enhance the student's ability to think, learn independently and solve problems effectively and more importantly can produce creative work and quality.

During training in operator department coach can identify some strengths and weaknesses of the company. However, this drawback can be overcome and repaired. Principles of organization and administrative functions play an important role in creating a robust organizational planning, coordination and control is essential to coordinate all tasks. An organization must be established and excellent efficient and effective decision-making and planning, and this is the main principle in the management of an organization. Through the Industrial Training, the training objectives have been achieved during the training conducted for 17 weeks. Therefore, it can be concluded that all the exposure that has been given to the trainees during training is very useful and should be exploited in the future. Such training also will produce graduates who are knowledgeable and a great personality.

However, it is recommended that the Industrial training duration week to be extended because of the Kuroda Precision Industries (M) factory was closed during the MCO due to the increase in Covid-19 cases. The students are also recommended to accept to do the training related to the diploma programme because the chemical engineering scope of the training I receive at Kuroda Precision Industries (M) is limited.