



UNIVERSITI  
TEKNOLOGI  
MARA



**SANKO PLASTICS MALAYSIA SON. BHD.**

## **INDUSTRIAL TRAINING FINAL REPORT**

**SESSION: FEBRUARY-AUGUST 2022**

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I would also want to express my gratitude to dear lecturers who guided me and other companions throughout the internship programme from the very beginning till its completion. I very appreciate their support and advice to get and complete internship in above said organization. I am extremely great full to my department staff members and friends who helped me in successful completion of this internship.

## ABSTRACT

This industrial training report of Muhammad Haziq Darwisy bin Rohaizat to undergo an industrial training for duration of 6 months which consist of 24 weeks before completing the Diploma courses. Starting industrial training on 21 February 2022 until 5 August 2022 at Sanko Plastic Malaysia Sdn Bhd which guided by Miss Hidayu binti Abdul Rani and Sir Mohd Haikal bin Mustafa.

The purpose of this program is to fulfill the course in order to complete the Diploma as well as graduate from the university. The training refers to work experience that is relevant to professional development prior to graduate. In first chapter this report is defining the term of industrial training and description on industrial training objectives. This part explains the details of objectives of industrial training report and industrial report. The corporation and its departments are described in the second chapter of the report.

In third chapter describes about the summary of the duties and various task given in weekly of industrial training activities. The next chapter explain the experience gained during the internship and a few issues encountered in the company. As for the last chapter describe the conclusion after finished the internship.

This training gives students a good experience in a real working environment. For example, the challenge to communicate with the workers and staff. At working place student need to be smart in order to choose the suitable words while communicate.

Last but not least, trainee also got opportunities to learn a lot of things. Student can learn about the other things from a subject that they learn in university. For example, they can learn about new equipment and machine that they never see and learn during their study period.

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# CHAPTER 1

## INTRODUCTION

### 1.1 Overview

Students in specified programs at all levels of higher education in Institutions of Higher Learning (IHL) are required to complete Industrial Training (IT). Industrial training programs were created to strengthen the necessary competencies in order to increase the number of graduates qualified for employment. Industrial Training (IT) is the process of exposing students to engineering work in the real world and involving them in Chemical Engineering projects before they graduate. One of the conditions for the award of a diploma in chemical engineering is that the student complete at least twenty-four (24) weeks and twelve (12) credit hours of industrial training within semester six (6) OR after passing all of the courses studied from semester one to semester five.

Industrial Manship holds the objective to introduce UiTM students to industrial culture and working environment and at the same time increases students' employability rate by enhancing their industrial skills. They also will undergo several briefings as guidance for the trainee. The duration for this internship is 24 weeks taken place starts on 21 February 2022 until 5 August 2022. It is compulsory for the student to report to the company according to the time and date stated during the Industrial Training briefing. During the internship period, student will be assigned to one (1) Lecturer Evaluation to assessing the student's performance. The logbook and finalized report should be submitted to the college via online and hardcopy due two (2) weeks after internship end.

Courses in industrial training (IT) provide students with learning chances in the workplace so they can gain real-world experience and increase market trustworthiness. The industrial training aids in producing chemical engineering technician graduates with excellent technical skill and soft skill competency when it comes to preparing the students as engineering technicians. Since all core and elective theories can be utilized in industrial

training, it is expected that students would be able to approach problems and projects given to them by supervisors in original and creative ways. Additionally, the industrial training boosts students' self-confidence and enhances their collaboration and communication abilities. Students are also required to practice engineering with a high degree of integrity, ethics, and accountability.

### **1.2 Objective Industrial Training**

The main purpose of Industrial Training (IT) is to give students learning opportunities in the world of work to gain practical experience to improve the reliability of the market. In order to prepare the students as an engineering technician, the industrial training helps to produce chemical engineering technician graduates with excellent technical skill and soft skill competency. The other objectives are:

- Mastering technical skills
- Gaining essential background knowledge
- Perfecting interpersonal skills (soft skills)
- Building a Network of Contacts

### **1.3 Industrial Training Placement**



### 1.3.1 Industrial Schedule

DAYS	WORKING TIME	OPERATING PERIOD
MONDAY-SATURDAY	<b>MORNING SHIFT</b>	
	8 a.m-10 a.m	2 hours
	10 a.m-10.10 a.m (tea break)	10 minutes
	10.10 a.m-12.00 p.m	1 hours 50 minutes
	12.00 p.m-12.40 p.m (lunch break)	40 minutes
	12.40 p.m-3.00 p.m	2 hours 20 minutes
	3.00 p.m-3.10 p.m (tea break)	10 minutes
	3.10 p.m-5.00 p.m	1 hours 50 minutes
	5.00 p.m-8.00 p.m (overtime)	3 hours
	<b>NIGHT SHIFT</b>	
	8 p.m-10 p.m	2 hours
	10 p.m-10.10 p.m (tea break)	10 minutes
	10.10 p.m-12.00 a.m	1 hours 50 minutes
	12.00 a.m-12.40 a.m (lunch break)	40 minutes
	12.40 a.m-3.00 a.m	2 hours 20 minutes
	3.00 a.m-3.10 a.m (tea break)	10 minutes

	3.10 a.m-5.00 a.m	1 hours 50 minutes
	5.00 a.m-8.00 a.m (overtime)	3 hours
SUNDAY	Weekend Holiday (If production running. Schedule follow as above)	

*Table 1.0 Production Employee Schedule*

Table 1.0 show the working schedule for production employee at Sanko Plastics Malaysia Sdn Bhd. The company run 24hours/day and 7days/week. Working on Saturday and Sunday is optional.

DAYS	WORKING TIME	OPERATING PERIOD
MONDAY-FRIDAY	8 a.m-10 a.m	2 hours
	10 a.m-10.10 a.m (tea break)	10 minutes
	10.10 a.m-12 p.m	1 hours 50 minutes
	12.00 p.m-12.40 p.m (lunch break)	40 minutes
	12.40 p.m-3.00 p.m	2 hours 20 minutes
	3.00 p.m-3.10 p.m (tea break)	10 minutes
	3.10 p.m-5.00 p.m	1 hours 50 minutes
		(TOTAL=9 hours)
SATURDAY-SUNDAY	Weekend Holiday	-

*Table 2.0 Office Staff Schedule*

Table 2.0 above show the working schedule for office member include intern student which is 5 days of working time for one week and 9 hours per day. The rest time are divided to three sections, the first one for tea break for 10 minutes from 10.00a.m until 10.10a.m. The second one is for lunch time which is 40 minutes from 12.00p.m until 12.40p.m. As for the last one is tea break 10 minutes from 3.00p.m until 3.10p.m.

**Industrial Training Schedule**

- 1. Muhammad Haziq Darwisy Bin Rohaizat
- 2. Muhammad Nabil Hakim Bin Ghazali
- 3. Muhammad Alif Bin Anas

21/7/2022

No	Training Program	Trainer	2022																													
			Feb				Mar					Apr				May				Juni				Jul					Aug			
			1	2	3	4	1	2	3	4	5	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	5	1	2	3	4
1	Orientation	Sew																														
	Production	Hendri																														
	Pallet Production																															
2	Container Production																															
	Welding Pallet																															
	Assembly and Printing																															
	QC	Sham																														
	Inspection of Pallet																															
3	Inspection of container																															
	Testing of Pallet																															
	Material Testing																															
	Maintenance	Mustaqim																														
4	Mould Maintenance																															
	Machine Maintenance																															
	Plant Maintenance																															

Sew

*Table 3.0 Industrial Training Schedule*

The figure 1.0 above show the industrial training schedule for intern student. We are divided into three department during our 6 months of internship. The three department is production, quality control (QC) and maintenance. The first 2 month I been placed in production department, the next 2 month at QC department and the last 2 month at maintenance department.

### 1.3.2 Company Supervisor Information



*Figure 1.0 Supervisor*

NAME	SEW HUAT YENG
POSITION	PRODUCTION MANAGER
CONTACT NUMBER	
EMAIL ADDRESS	

*Table 4.0 Supervisor Information*

## CHAPTER 2

### 2.1 Company Background



*Figure 2.0 Company Picture*

Incorporated on the 1st of February 2014, Sanko Plastic Malaysia is the affiliated birth-child of Sanko Co., Ltd.-a Japanese company initially founded as a textile company on the 3rd of December 1951. In 1961, it formed Sanko Kasei Co., Ltd, a company now renowned globally for being the gold standard of plastic product injection molding and for the development and manufacturing of containers and boxes for industrial and logistical use.

With a vast selection of plastic-moulded products like Plastic Containers for industrial use, Plastic Pallets and internal logistic carry systems, Sanko Plastics is heralded as the biggest plastic manufacturer in Japan and is collectively known even here in Malaysia, to have the widest variety of plastic-moulded products applicable for industries of nearly every discipline.

Since it was incorporated on the shores of Malaysia, Sanko Plastics Malaysia has grown to become one of the biggest and most trusted ISO 9001 certified manufacturers of industrial plastic containers (poly boxes) and plastic pallets, making Sanko a go-to choice for key players in heavy duty industries, the F&B industry, logistic industry, warehousing industry, and industries of other discipline, on both local and international levels.

From Sanko Plastics' first-in-Malaysia dual color technology container and SN Container that can be fitted into TP standard containers to streamline logistical efficiency to Sanko Plastics' first-of-its-kind TP standard container that allows stable stacking despite varying sizes to streamline efficiency and reduce costs, Sanko Plastics Malaysia lives and breathes efficiency, quality, and is the industry embodiment of the spirit of innovations.

Recognized as a leading pioneer in the plastic injection moulding industry, Sanko Plastics' is heralded as the foremost champions by virtue of our uncompromising commitment to quality, innovation and drive to best serve our customers and their best interests. Currently, Sanko has 27 manufacturing plants, 9 branches and 63 sales offices throughout Japan.



*Figure 3.0 Plant Layout*

## 2.2 Company History



*Figure 4.0 Sanko Tokyo Head Office*

December 1951	Established Sanko Spinning Co., Ltd. with capital of 1.1 million yen. Established the head office in Wakamiya-cho, Gifu City and the factory in Kagashima, Gifu City to plan the manufacture and sale of hair core yarn spinning
April 1952	Kagamishima factory started operation
February 1961	Sanko Kasei Co., Ltd. Established a capital of 8 million yen. Plans to manufacture and sell plastic products by constructing a head office in Wakamiya-cho, Gifu City and a factory in Inazawa City, Aichi Prefecture.
May 1962	Started full-scale operation of one large injection molding machine at Sanko Kasei Inazawa Factory
January 1968	Built head office factory in Niiza, Saitama



August 1970	Built new factory in Ichinoseki, Iwate
March 1975	<p>Completion of a jumbo factory specializing in super-large, molded products of the Synthetic Resin Division on the premises of the head office factory.</p> <p>The world's largest 1,500-ounce super-large injection molding machine was newly installed at the factory, 1,200 ounces was relocated from the Gifu factory, and the total injection volume of all factories was 10,231 ounces.</p>
September 1984	Completed Sanko Nagoya Building at 3-chome, Chiyoda, Naka-ku, Nagoya
June 2001	Completion of Kansai No. 2 Factory
March 2007	Aggregated Tohoku Technology Department at Sanko Kasei Mold Factory (former Sanko Seiki Tohoku Factory)
November 2016	Built Hiroshima factory in Mihara, Hiroshima
November 2020	Sanko Real Estate Building completed
November 2021	Sanko Co., Ltd. merged with Hakko Co., Ltd.
May 2022	Completion of Yokkaichi Sales Office

*Table 5.0 Company History*

### **2.3 Company Quality Policy**

As an industry of plastic pallet, distribution equipment and containers, Sanko Plastics Malaysia Sdn. Bhd. Has established Quality Policy below to manufacture and provide products that satisfy the costumers based on basic concept which widely contribute to the society through development, production and sales of same products.

1. Always provide products that gain satisfaction and trust of customers based on Quality First.
2. Develop and improve products that comply with legal regulation as well as taking customers requirement in advance.
3. Build the quality in all processes from development, manufacturing in factory until delivery to customers.
4. Promote continuous improvement through Management Review, internal audit and others to ensure validity of Quality Management System.
5. Continuously review the “Quality Policy” and maintain its appropriateness.

## 2.4 Organization Chart

### Organization Chart

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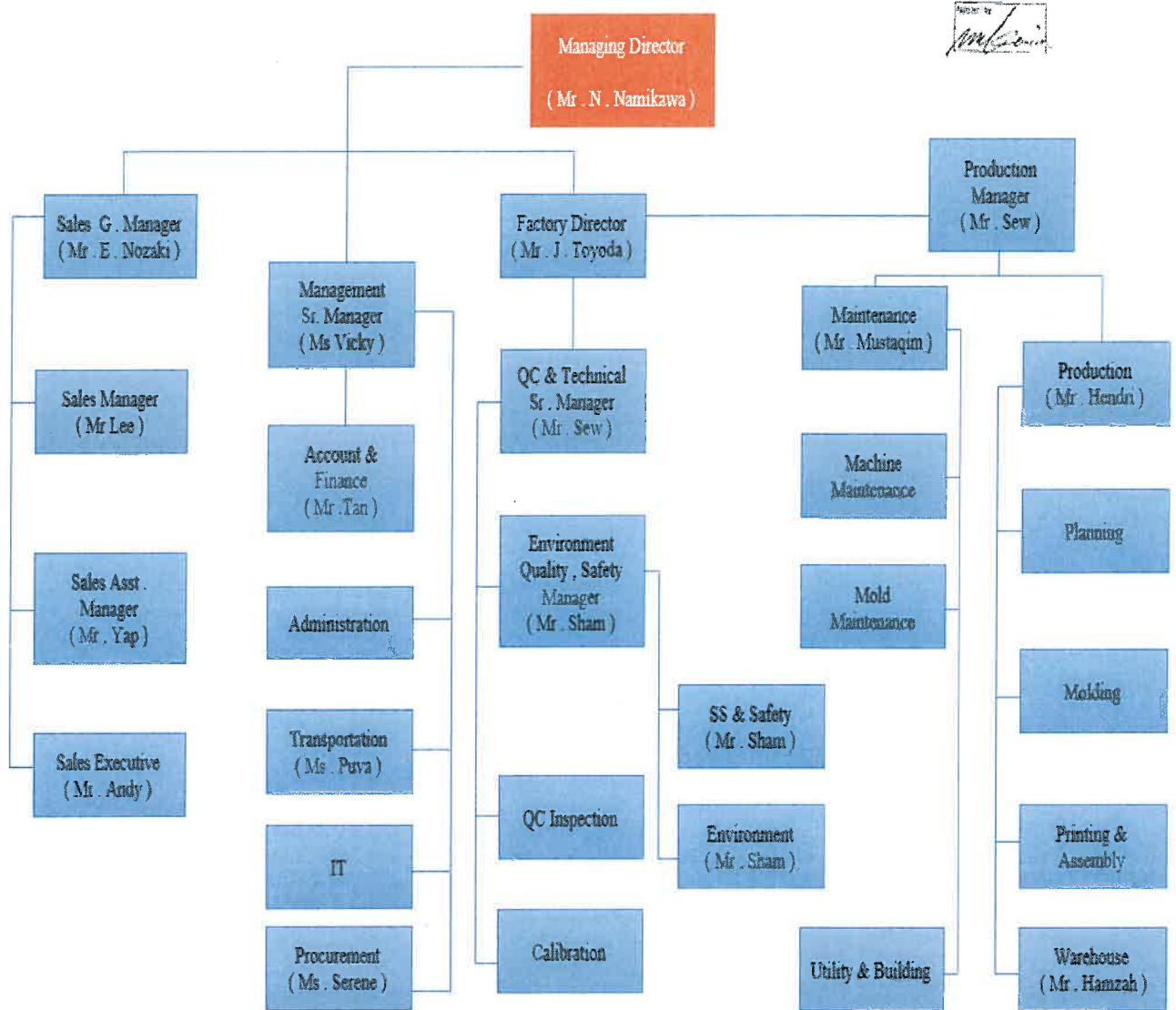


Figure 5.0 Organization Chart

## 2.5 Main Product/Service Provided to the Client

### 2.5.1 Plastic Pallet

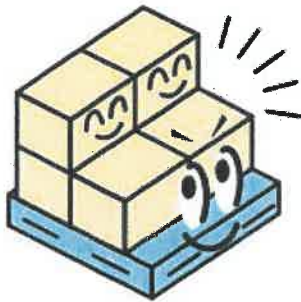
Since Sanko introduced plastic injection pallets into the Japanese market in 1970 for the first time, we have been continuously introducing epoch making plastic pallets into the Japanese market, such as, the LX pallet by developing our technology and investing in new facilities. The plastic pallet makes workplace safer, more hygienic, and reduces total cost.

#### Advantage of plastic pallet



Hygienic

Strong durability and does not corrode. It is washable and does not breed neither fungus nor bacteria.



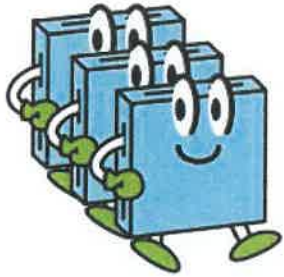
Excellent Safety

Different from wooden pallet, no prickle nor burr, so no damaged to loaded cargo.



Recyclable

All plastic pallets are recyclable and very environmentally friendly.



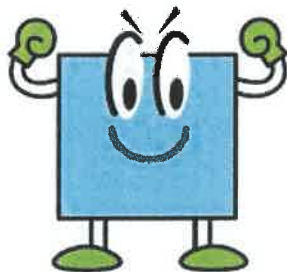
It is manufactured under strict quality control, accurate and uniformed in dimensions and weight.

Uniformed, High Quality and High Accuracy



Grommets are located at all points to prevent slippage.

Non-slippery



Durable and resistant to water and chemicals. Due to long life span, the overall cost is lower than the cost of the wooden pallet.

Low Cost

**Example of plastic pallet**

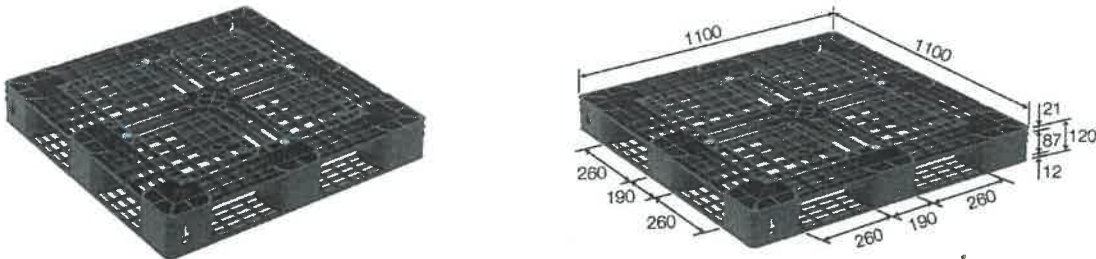


Figure 6.0 Example of Plastic Pallet

<b>Product name</b>	D4-1111-11
<b>External dimensions</b>	1100 x 1100 x 120 mm
<b>Hue</b>	<div style="background-color: black; color: black; display: inline-block; padding: 2px;">Play black</div> Play black <ul style="list-style-type: none"> <li>*The color is a reference sample. It may differ from the actual product.</li> </ul>
<b>Material</b>	Recycled PP
<b>weight</b>	5.8kg

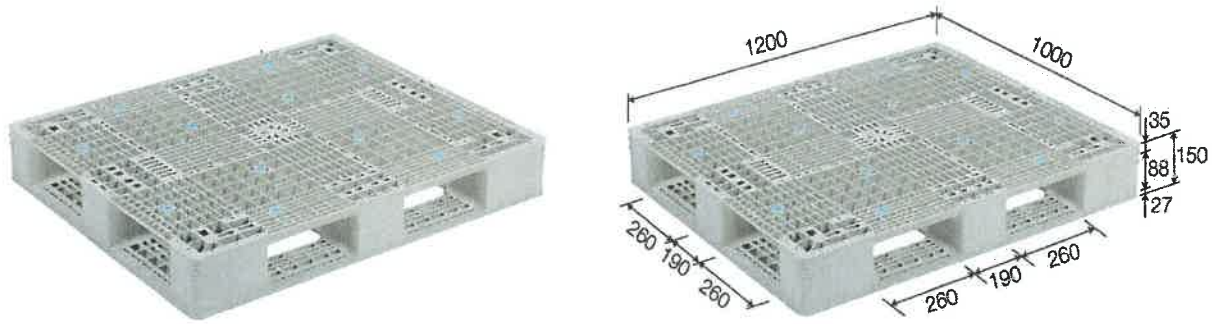


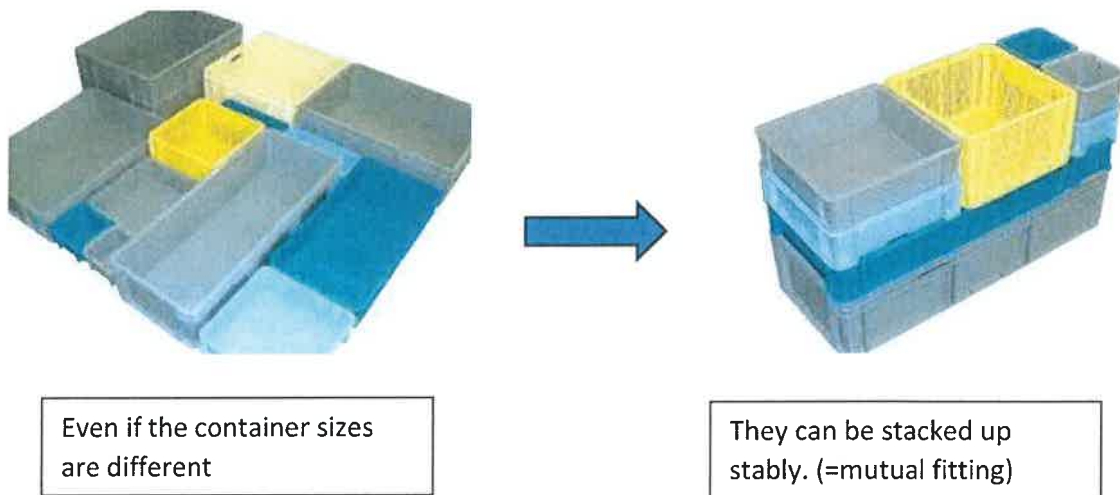
Figure 7.0 Example of Plastic Pallet

<b>Product name</b>	GT-1012-D4
<b>External dimensions</b>	1200 x 1000 x 150 mm
<b>Hue</b>	<p>A Gray</p> <p>A Gray</p> <ul style="list-style-type: none"> <li>*The colour is a reference sample. It may differ from the actual product.</li> </ul>
<b>Material</b>	PP
<b>weight</b>	16.8kg

## 2.5.2 PLASTIC CONTAINER

SANKOTP Container Series is mainly used in storage and transportation of auto parts. It is designed based on TP standard so that any container in this series can fit each other, and thus contributes to efficient storage and transportation.

TP containers are standardized in bottom shape and height size. Any TP containers of different volume sizes can fit each other and thus offer stable stacking.





## Example of Plastic Container

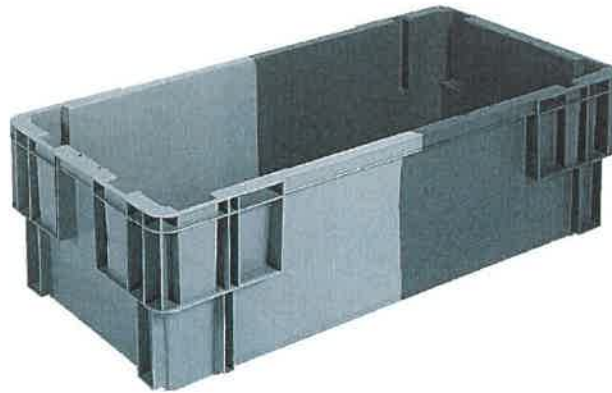


Figure 8.0 Example of Plastic Container


<b>Product name</b>	SN container B # 160
<b>External dimensions</b>	1100 x 550 x 330 mm
<b>Inside dimension</b>	1028 x 478 x 320 mm
<b>Effective inner dimension</b>	1010 x 460 x 310 mm
<b>Compressive load</b>	27.0kN (2750kgf)
<b>Hue</b>	 Light gray Gray / light gray <ul style="list-style-type: none"><li>*The color is a reference sample. It may differ from the actual product.</li></ul>
<b>Material</b>	PP



Figure 9.0 Example of Plastic Container

<b>Product number</b>	205202
<b>External dimensions</b>	670 x 503 x 195 mm
<b>Inside dimension</b>	635 x 468 x 180 mm
<b>Effective inner dimension</b>	626 x 458 x 170 mm
<b>Compressive load</b>	44.4kN (4530kgf)
<b>Hue</b>	<p>Light gray</p> <p>Light gray</p> <ul style="list-style-type: none"> <li>*The color is a reference sample. It may differ from the actual product.</li> </ul>
<b>Material</b>	PP

**Product Usage**



Figure 10.0 Product Usage on Logistic



Figure 11.0 Product Usage on Industry

# CHAPTER 3

## OVERVIEW OF THE TRAINING

### 3.1 Introduction

During 24 weeks of the training, variety of jobs are provided. Sanko Plastic Malaysia has several department in order to make the company running smoothly. They have production, quality control, maintenance, and printing department. During my internship period, I have been experiencing all the department. Lot of new thing and knowledge can be gained. During the 6 months on internship, I have been departing to production department for the first 2 month. Then, the next to 2 months on quality control department and the last 2 month in maintenance department.

### 3.2 Summary of the Training and Experience Gained

**Task 1:** Change Mould, operator, welding pallet, and printing pallet. (Production Department)

Under production department have 3 different type of work which is change mould, operator for each machine (A01, A02, A03, B01, B02, B03, B04) and printing. Change mould will be done by technician. I already experience all the work type. For change mould, help technician by following his order and guide like open drain valve, insert host and what not. As for the operator insert grommet, cut gate runner, flashing, wrapping and labelling. Lastly, printing help make paint by following the procedure. For example, 20g of paint mix with 1.2g thinner and 5.5g retardant thinner.

**Task 2:** Inspection report, and material testing. (Quality Control Department)

When new material coming from supplier, the material must undergo incoming process which is material testing. The material testing have a several test which is bending test, tensile test, charpy test, melting flowrate testing and density test. After the material successfully tested, it will allow to go to pallet and container production to be use as raw material. When the product is ready it will go to inspection to check the quality of the product. For example, no short-short and flashing.

**Task 3:** Repair Mould (Maintenance Department)

If the product has short-short or flashing, it can be the mould has problem. So, the mould needs to be check by maintenance staff. Usually this happen because mould has leaking, the heater not working well and has material stuck inside the mould. Each mould has their own procedure to open and repair the mould. All the leaking oil must be removed properly to have a very good quality of product.

**3.2.1 Weekly Activity**

WEEK	ACTIVITY
1	<ul style="list-style-type: none"><li>• Round plant</li><li>• Change mould</li><li>• Operator</li><li>• Clean leaking oil at machine</li><li>• Learn about injection moulding machine</li><li>• Learn on how to control crane and robot</li></ul>

2	<ul style="list-style-type: none"> <li>• Do mould change checklist report</li> <li>• Change could</li> <li>• Learn more about injection moulding machine</li> <li>• Do 5s</li> <li>• Operator</li> <li>• Meeting with factory director Mr. Jun Toyoda. Share about background and history of company</li> </ul>
3	<ul style="list-style-type: none"> <li>• Do mould change checklist report</li> <li>• Help maintenance department.</li> <li>• Learn about forklift</li> <li>• Do material impact test</li> </ul>
4	<ul style="list-style-type: none"> <li>• Help change mould for machine A-01 (LX-1012-D4- D4-1212)</li> <li>• Clean spilled material at material tank A, tank B and tank C</li> <li>• Learn about welding machine</li> <li>• Welding pallet LX-1012-D4</li> <li>• Operator</li> </ul>
5	<ul style="list-style-type: none"> <li>• Welding pallet</li> <li>• Do mould change checklist report</li> <li>• Help technician change mould</li> <li>• Top up material</li> </ul>

6	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Do stock check</li> <li>• Operator</li> </ul>
7	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Learn more about welding machine</li> </ul>
8	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Operator</li> </ul>
9	<ul style="list-style-type: none"> <li>• Do mould change checklist report</li> <li>• Change department to Quality Control (QC)</li> <li>• Do inspection report</li> <li>• Continue welding pallet LX-1012-D4</li> </ul>
10	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Operator</li> <li>• Do inspection report</li> </ul>
11	<ul style="list-style-type: none"> <li>• Eid Mubarak leave</li> </ul>
12	<ul style="list-style-type: none"> <li>• Operator (mould no: D4-812SPM, and D4-19111-6N)</li> <li>• Do inspection report</li> </ul>

13	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Operator (mould no: D4-1111-11 and D4-1111-6N)</li> <li>• Do inspection report</li> </ul>
14	<ul style="list-style-type: none"> <li>• Operator (mould no: D4-1113W-2SPM and D4-812SPM)</li> <li>• Do inspection report</li> </ul>
15	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Help printing department</li> <li>• Operator</li> <li>• Do inspection report</li> </ul>
16	<ul style="list-style-type: none"> <li>• Operator (mould no: TP 332 and SN Container C#38F)</li> <li>• Do inspection report</li> </ul>
17	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> </ul>
18	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> </ul>
19	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> </ul>
20	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-</li> </ul>



	D4
21	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Do tensile and bending test</li> </ul>
22	<ul style="list-style-type: none"> <li>• Continue welding pallet LX-1012-D4</li> <li>• Help maintenance department</li> <li>• Help change mould</li> <li>• Help printing department</li> <li>• Learn more about injection moulding machine</li> <li>• Follow supervisor go to Department of Environment (DOE) and Jabatan Keselamatan dan Kesihatan Pekerja (JKKP)</li> <li>• Help change mould at plant b for machine B04 (TP4-4 to TP330lid)</li> </ul>
23	<ul style="list-style-type: none"> <li>• Do industrial training report</li> <li>• Schedule waste training</li> <li>• Follow Cik Sham (QC Assistant Manager) do safety inspection</li> </ul>
24	<ul style="list-style-type: none"> <li>• Submit logbook and industrial training report</li> </ul>

*Table 5.0 Weekly Activity*

## **CHAPTER 4**

### **DETAILS OF EXPERIENCES**

#### **4.1 Introduction**

After 23 weeks at Sanko Plastic Malaysia, lot of new things has been done. From production department to quality control department and lastly maintenance department. At production department, all the machine and equipment has been explored and learned. For example, learn about injection moulding machine, kawata machine and robot. It's quite complicated but not impossible to understand on how the machine working. In quality control department, a lot of stage must be past before shipping the product. Start from incoming inspection, ongoing inspection, and final inspection. All the inspection needs to be recorded in a report. At last department which is maintenance department more information has been gained about all the mould at this company. Every mould has different ways to operate and to maintain their effectiveness. It is important to ensure the product on the best condition.

#### **4.2 Details of experience gained**

During the internship period lot of experience has been gained. Firstly, lot of big machines at the company. The biggest machine is moulding injection machine, its very fun to learn on how the machine works. The machine is using hydraulic system in order to move the mould. The best part is when to change mould because so many things can be learned and hands on. Start from control crane and insert crane hook into the mould. The crane hook is very heavy, the weight is around 10kg. In order to insert the crane hook, need to climb the mould that have height around 3m. After that the mould will be lift to machine. While inserting the mould, there have a lot of safety procedure need to be followed. For example, wear safety shoes, ear plug, glove and safety helmet. Besides, before taking off the crane,

need to ensure the auto clamp is properly inserted. If not, the mould will fall out and can cause a serious damage and injuries to the machine and technician. The mould change instruction will be state on the next subtopic.

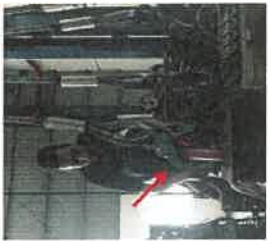
Besides, experience to become an operator. It is very hard to be an operator for 8 hours of working. This is because the pallet is very heavy around 7-18kg per pieces depends on the type of pallet. Each pallet needs to insert grommet and cut the gate runner, the amount of grommet also depends on the type of the pallet and customer order. The operator needs to catch the cycle time of the machine to avoid the outgoing product from the machine stuck at the conveyer. Then the product needs to be arranged and wrap before send to warehouse. Normally only one person at one machine.

Lastly, experience to drive a forklift. Driving forklift is way to different compared to driving a car. This is because the wheel can rotate until 180 °. The forklift is used to pick up product and material to send to product storage and material storage. This is a very valuable skill to be gained.

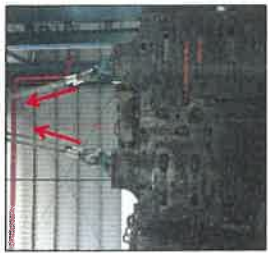
#### **4.2.1 Duties and task performed**

##### **Task 1: Change mould (Production)**

Every week will have mould change activity, what mould will be replaced on the machine is depends on the order. Normally 3 times a week. Before insert a mould into a machine, the mould needs to be check by the maintenance employee to ensure the mould in a good condition and ready to run. All employee that are responsible to change the mould need to wear safety shoes, ear plug, safety helmet and glove. All the equipment and tools need to be prepared beside the machine. For example, Allen key, spanner, water host, and hydraulic host. Here is the procedure for mould change activity: 1) Mould up



STEP 1: INSTALL HOOK LOCK WITH LATCH



STEP 2: INCREASE TENSION OF CRANE. LIFT UP AND MOVE THE MOULD TO BE MOUNTED ON MACHINE



STEP 3: BE CAREFUL NOT TO CLAMP THE MOULD HEATER WIRE / HYDRAULIC AND COOLING HOSE.



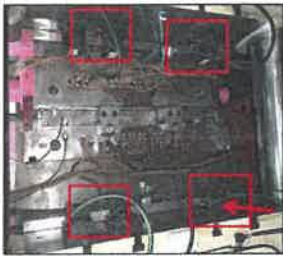
STEP 4 ALIGN THE LOCATION RING



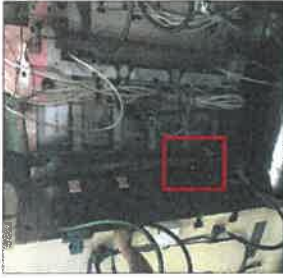
STEP 5: ALIGN THE MOULD



STEP 6: CHECK THE POSITION MOLD ALIGNMENT



INFO: CLAMPING USAGE AND POSITION BASED ON MOLD DESIGN



STEP 7: PUSH AUTO CLAMP. ENSURE RED LIGHT SENSOR



STEP 8: SETTING AUTO CLAMP



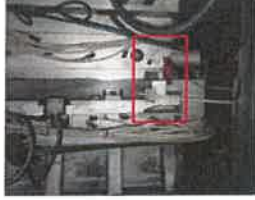
STEP 9: PUSH CLAMP UNTIL GREEN LAMP POP UP



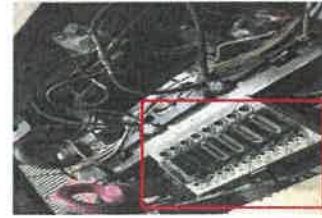
STEP 10: REMOVE THE HOOK AND WIRE ROPE



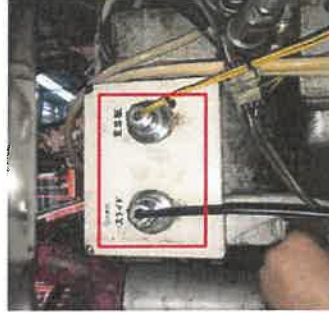
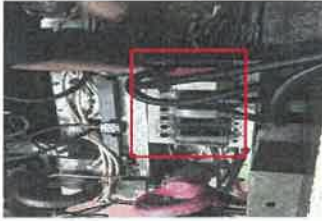
STEP 11: OPEN SAFETY LOCK



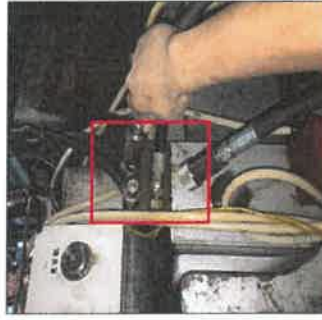
STEP 12: OPEN THE MOULD



STEP 13: CONNECT THE MOULD HEATER. FOLLOW NUMBERING (WIRE WITH CONNECTOR)

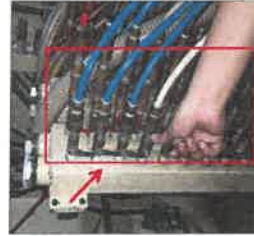
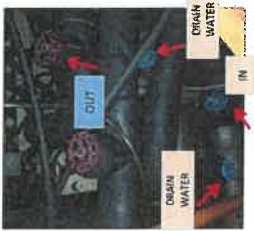
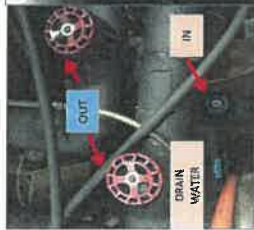
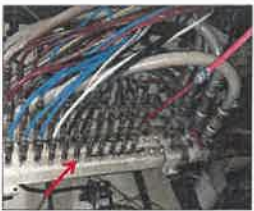


STEP 14: CONNECT SLIDER CORE AND EJECTOR CONNECTOR LIMIT SWITCH SIGNAL



STEP 15: CONNECT ALL HYDRAULIC CORE AND SLIDER / EJECTOR PIN



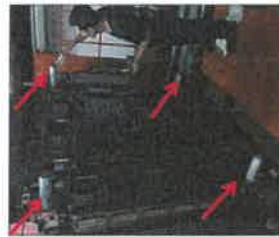


STEP 16: CONNECT ALL COOLING HOSE  
(IN AND OUT) MOLD AND MACHINE  
(CORE AND CAVITY)

STEP 17: MOVING SIDE OPEN WATER  
IN /OUT AND CLOSE DRAIN WATER

STEP 18: FIXED SIDE  
OPEN WATER IN /OUT  
AND CLOSE DRAIN  
WATER

STEP 19: OPEN THE WATER



STEP 20: CLEAN UP MOLD USE  
COTTON (MOVING AND FIX SIDE)

STEP 21: GREASE UP THE  
MOLD

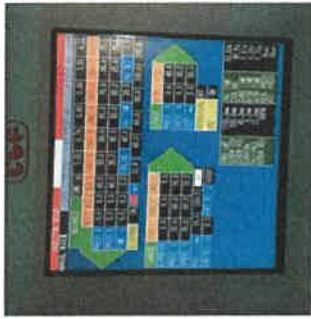
STEP 22: CLOSE THE  
MOLD  
(USED MOLD SLOW  
SPEED)

STEP 23: INSPECT  
INSIDE AND OUTSIDE  
MOULD

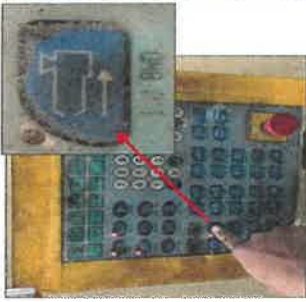
STEP 24:  
COMPLETE FOR  
MOLD SET UP.  
CONTINUE NEXT  
PROCESS,  
MACHINE  
PARAMETER  
SETTING.

Figure 12.0 Mould Up Procedure

## 2)Mould Down



STEP 1: SET POSITION MIN 40. FOR REDUCE MATERIAL



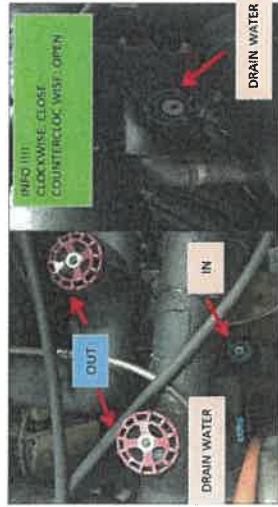
STEP 2: PRESS BACKWARD NOZLE



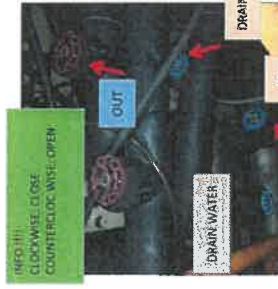
STEP 3: REMOVE ROBOT SPACE



STEP 4: TURN OFF ALL HEATER GH & MH



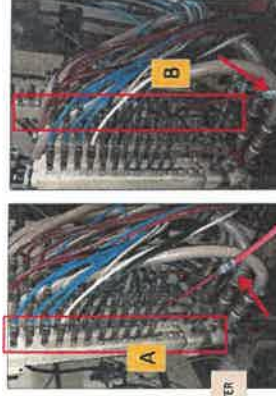
STEP 5: MOVING SIDE CLOSE WATER IN /OUT AND OPEN DRAIN WATER



STEP 6: FIXED SIDE CLOSE WATER IN /OUT AND OPEN DRAIN WATER



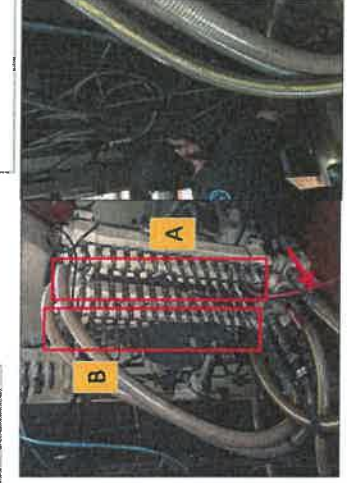
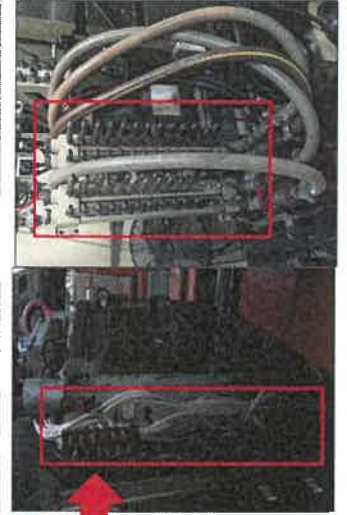
STEP 7: CONNECT DRAIN HOSE WITH AIR HOSE INTO IN (BOTH A AND B) AT FIX SIDE



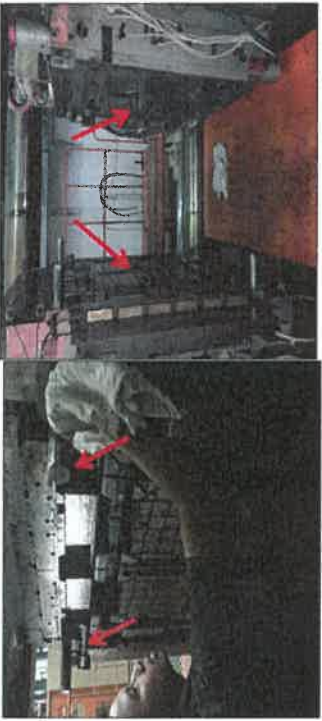
STEP 8: CLOSE THE WATER



STEP 9: TAKE OUT ALL COOLING HOSE MOLD AND MACHINE



STEP 10: CONNECT DRAIN HOSE WITH AIR HOSE INTO IN (BOTH A AND B) AT



STEP 11: CLEAN UP MOLD USE COTTON (MOVING AND FIX SIDE)



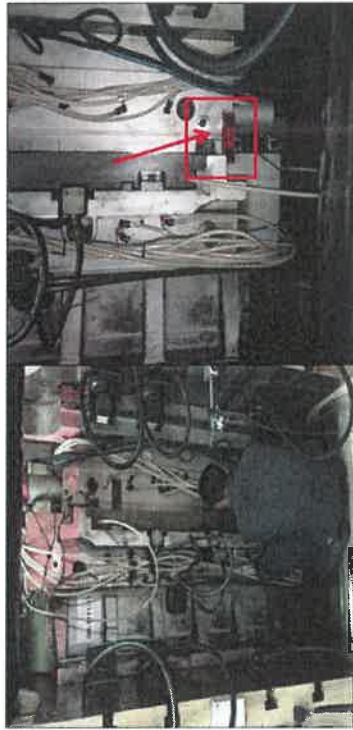
STEP 12: GREASE UP THE MOLD



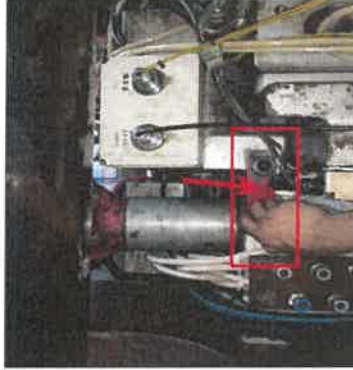
STEP 13: SPAY ANTI RUST THE MOLD



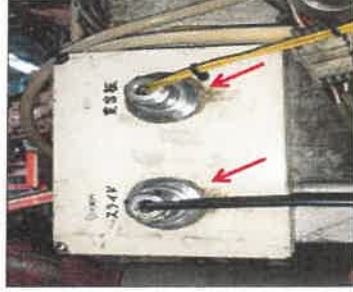
STEP 14: CLOSE THE MOLD (USED MOLD SLOW SPEED)



STEP 15: INSTALL SAFETY LOCK (FRONT SIDE)



STEP 16: TAKE OUT SLIDER CORE AND EJECTOR CONNECTOR LIMIT SWITCH SIGNAL



STEP 17: TAKE OUT ALL HYDRAULIC CORE AND SLIDER / EJECTOR PIN



STEP 18: TAKE OUT ALL HEATER CONNECTOR







STEP 19: INSTALL THE WIRE ROPE AND INCREASE THE TENSION OF ROPE



STEP 20: SAVE SETTING DATA



STEP 21: SETTING AUTO CLAMP . FERRO PRESSURE MOLDING CLOSE



STEP 22: PUSH UNCLAMP UNTIL RED LAMP POP UP



STEP 23: ENSURE ALL HOSE, CONNECTOR, AUTO CLAMP ALL OPEN. REOPEN MOLDING



STEP 24: PULL AUTO CLAMP



STEP 25: LIFT UP AND MOVE THE MOLD AT MOLD AREA



STEP 26: ALLOCATED MOLD AT MOLD AREA AND CENTRE WOOD



STEP 27: OPEN ALL WIRE ROPE.

Figure 13.0 Mould Down Procedure

## Task 2: Operator (Production Department)

Next task is to become an operator. Operator scope of works is cut gate runner, insert grommet (the amount of grommet is depending on the customer's order), flashing (if have), arrange product (depends on the quantity set at the label), wrapping or tie up or both, put round sticker (depends on the order) and put label. 10 minutes before back time need to do 5s around their workplace.



CUT GATE  
RUNNER



INSERT  
GROMMET



CUT  
FLASHING



- ARRANGE  
PRODUCT
- PUT LABEL
- TIE
- WRAPPING



TYPE OF  
GROMMET:  
RN70×14.5

*Figure 14.0 Operator Scope of Work*

### Task 3: Welding Pallet LX1012-D4 (Production Department)

Welding pallet is a process where there are two types of pallets which is top and bottom need to be welding to produce one pallet. The weight for bottom pallet is around 11kg and the top pallet is around 14kg. After the welding process finish., employee need to remove flushing. After that, the pallet will go to the other machine to insert grommet. After finished, the pallet will send to printing area to do a printing works.

Pallet LX1012-D4:

Tools:



BOTTOM



TOP



Custom Scrapper

Procedure:



STEP 1: Switch on the machine and wait for the temperature reach 220°C



STEP 2: Arrange pallet (top+bottom) at the inlet of the machine



STEP 3: Wait for melting process 50sec and welding process 30sec



STEP 4: Flashing



STEP 5: Arrange product 10pcs/set



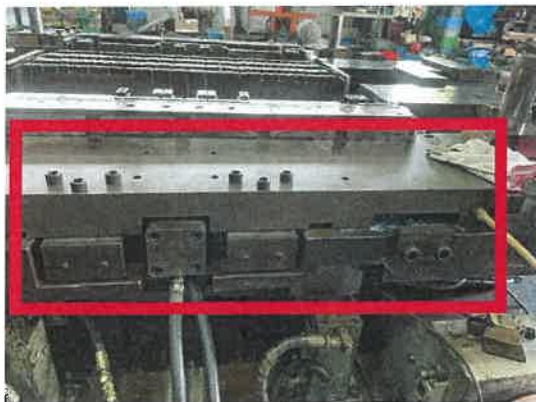
STEP 6: Send to grommet installation machine to install grommet



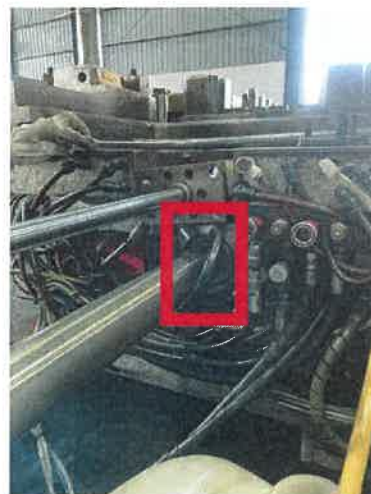
Step 7: Send to printing area to do printing and wrapping

#### Task 4: Change Hydraulic Host (Maintenance Department)

If a mould have any problem, the mould will be send to maintenance department to check and investigate the problem occur. There is a problem occur at mould R4-1111-5. The task given is to help maintenance employee to find the problems. After observe for each part, we found that there is a hydraulic oil leaking at mould slider core insert. So, the problem is hydraulic host leaking. The mould is using a hydraulic system. The function of hydraulic oil is to move the slider core. When the hydraulic host leaking, the slider core will not moving and not open because of pressure drop. It cause the product stuck in the mould. The action taken is open every part of the mould to change the leaking hydraulic host, wipe all the leaking oil and apply new grease oil.



Core slider cannot open and moving because of pressure drop



Hydraulic host leaking

*Figure 15.0 Core Slider and Hydraulic Host*

### Task 5: Material Testing (Quality Control Department)

Every new material arrived, it needs to undergo several testing's which is Charpy test, density/specific gravity test, and tensile test. First, sample of material need to be prepared.

The task given is to do a material testing of material PP Black. Here is the procedure to do all the material testing.

#### Material Sample:

1. Insert the material into the material tank.



2. Remove other material inside a nozzle and wait until the color of the material fully black.



3. Push forward nozzle button to bring the nozzle insert the moulding machine.



4. Push semi auto button and start first shot to avoid overpack. After done first shot, continue with fully auto injection process.



FIRST SHOT



SHOT AFTER FULLY AUTO

*Figure 16.0 Material Sample Procedure*

### **Charpy Test:**

The Charpy impact test, also known as the Charpy V-notch test, is a high strain-rate test that involves striking a standard notched specimen with a controlled weight pendulum swung from a set height. The impact test helps measure the amount of energy absorbed by the specimen during fracture.



*Figure 17.0 Charpy Test Machine*

1. Prepare the material sample
2. Switch on the charpy impact machine
3. Set present angle to 0
4. Start free swinging angle input to get the average of angle
5. Set label for the test (name of material)
6. Set the width to 8mm
7. Measure the thickness of the sample by using micrometer (3.996mm)
8. Put the sample at the center
9. Push hammer release button
10. Check the result

### **Density/specific Gravity Test**

Density is the mass per unit volume of a material. Specific gravity is a measure of the ratio of mass of a given volume of material at 23°C to the same volume of deionized water. Specific gravity and density are especially relevant because plastic is sold on a cost per pound basis and a lower density or specific gravity means more material per pound or varied part weight.



Figure 18.0 Density Test Machine

1. Prepare the material sample
2. Make sure the water level upper the iron plate
3. Place sample on testing board to measure weight in air , press ENTER key to memory
4. Place sample into water to measure weight in water, press Enter key to memory.

Density value will be displayed.

### Tensile Test:

ASTM D3039 tensile testing is used to measure the force required to break a polymer composite specimen and the extent to which the specimen stretches or elongates to that breaking point. Tensile tests produce a stress-strain diagram, which is used to determine tensile modulus.



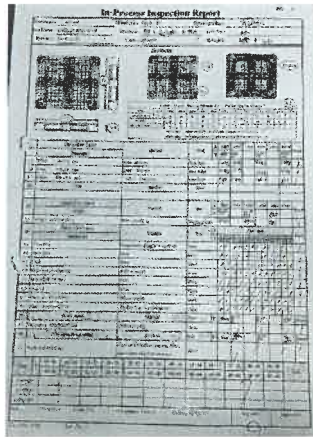
Figure 19.0 Tensile test Machine

1. Set up the type of test to tension test for machine condition
2. Insert the sample material details (sample name, lot no.) in sample information
3. Measure the thickness and width of sample material by using micrometer.
4. Insert the thickness and the width of the sample material
5. Set up the load calibration to zero kgf
6. Put the sample at tensile testing machine
7. Start the testing until the sample material have reached the maximum extension elongation
8. Repeat step 6 and step 7 for other sample material



## Task 6: In-Process Inspection Report (Quality Control)

In-Process Inspection Report is a process to ensure the product condition achieve the quality standard. This inspection needs to be done every day. Every day the person in charge need to measure the width, long, height and weight of the pallet. After that the appearance of the pallet need to be inspect too. For example, the color part, short shot, flash, sink mark, crack, oil stain and burn mark. If everything is okay, the product is ready to be sold.



## MATERIAL TEST RESULTS

ANGLE  $\alpha' = 149,4$

IMPACT TESTER			
Date 22, 7, 29			
CHARPY JIS-K7111			
Hammer: 4,00J		a: 150	
WR: 2,147Nm		a': 149,4	
Label: PP KITARAN			
No.	A	B	ak
	cm*		KJ/m*
1	0,3192	140,7	5,859
2	0,3192	139,8	6,531
3	0,3192	140,7	5,859
Ave. 0,3192		140,4	6,083
Max. 0,3192		140,7	6,531
Min. 0,3192		139,8	5,859
CV: 6,36%		Dev.	0,387

Charpy Test

## Tension test RESULT

Machine name	RTC Series	Test type	Tension
Load full scale	200 kgf	Load cell rating	10 kN
Load range	10 %RO	Extensometer rating	20 cm
Extensometer range	Not used	Test speed	10,0 mm/min
Chart speed	OFF	Machine rigidity	0 mm/kgf
Point data load (Load)	0 10 20	Point data strain (Elongation)	0 2 4
kgf	30 50 100	mm	6 8 10
Elastic modulus	Interval	Initial sample length	Distance
Load	Pitch	1 kgf	50 mm
Elong adjust	No	Origin of elongation	Start
Use SS curve	Yes	Break point	0,5 N
Test date	2020/09/28	Temperature	23,4 C
Humidity	47,9 %RH	Sample name	PP Black Recycle
Lot No	PP In Grade A	Preparation	
Operator		User	Sham
Comment 1		Comment 2	
TestID=0046	Width	Thickness	Maximum point
Test No	mm	mm	Load
			Stress
			MPa
			Load
			MPa
			Elongation
			mm
			Strain
			%CL
1	9,8500	3,9710	80,049
			20,009
			80,049
			20,009
			499,99
			699,99
2	9,8470	3,9840	80,090
			19,980
			80,090
			19,980
			499,56
			698,72
3	9,8760	3,9910	79,195
			19,853
			79,195
			19,853
			499,33
			698,67
Average	9,8743	3,9720	79,778
			19,947
			79,778
			19,947
			499,56
			699,12

Tensile Test

### **4.3 Problem encountered and approach adopted for solving problem**

There are several problems encountered during the internship period. Firstly, less task related to the course learned in the university given. Most of the time used to do a welding pallet and operator. Welding pallet work is arranged pallet in the inlet of the machine then wait for melting and welding process, after finish, do flashing by using scrapper. Almost 4 months doing the same task. Operator work is to stay at one machine and wait the product come out from the machine, then cut gate runner, insert grommet, flashing (if have), arrange product and wrapping or tie up. More than a month been doing this work. Don't have much time to learned about the moulding injection machine such as how much raw material used to produce one pallet, how to set machine and how to control robot. After informing the supervisor the task given not related to the course learning outcome, 3 weeks before the end of internship period the supervisor allow intern student to do logbook, report and learn anything student want to know. Its very rushing to learn everything.

Secondly, communication barrier. Since the company is a Japanese company, the general manager, managing director and factory director is a Japanese people. Some of them can't speak English fluently. Every morning will have a production meeting that will be led by Mr. Jun Toyoda (factory director), the factory director cannot speak English fluently. so, it is hard to understand the information given. After the production meeting done, supervisor will repeat the information given by using English and Malay language.

Lastly, new employee does not undergo induction process. For example, briefing about safety, scope of work and action should take when emergency happen. This is very important thing to be focus on for new employee because they are not familiar with the company plant so if emergency happen such as explosion they will panic and do not know what should be done. Besides, the target for production not following a proper cycle time for

each product and machine. The cycle time for pallet that have 15 grommet and pallet have 5 grommet is same. Thus, after finish insert grommet, operator need to arrange the product, put label, wrapping or tie or both and put sticker (depends on order). The cycle time set for each pallet does not fit with the amount of work need to be done by the operator.

#### **4.4 Professional and ethical issues**

During my internship at Sanko Plastic Malaysia Sdn Bhd, here are some professional and ethical issue occur in the company. Firstly, the work loaded to the intern student are the same as the permanent employee. As I mentioned at problem encountered, most of the time are used for welding pallet and become as an operator. Even they make a schedule for intern student which is 2 months in production department, 2 months in maintenance department and 2 months in quality control department, its not function. Almost 4-month intern student do a welding pallet no matter what department they are in. Thus, the normal production quantity for welding pallet per day is 50pcs, but they ask us to do more than that which is 100pcs per day. The weight for the pallet is 11kg for bottom and 14kg for top, after welding top and bottom the weight is 24kg/pcs. To do 100pcs per day was very unacceptable. Because of that I am facing a health issue which is lower back pain. After having a health issue, I do not follow the production target but the amount of the production always more than 50pcs per day.

Besides, intern student has become an operator for one month straight because lot of workers resign and run away. So, we need to replace their position as an operator. The cycle time given are the same as the permanent operator even we never do this kind of work before. To stand for 8 hours and to lift a very heavy pallet every day for one month was such a horrible experience. The weight of pallet is around 8-17kg depends on the type of the pallet.

One pallet we need to cut a gate runner, insert grommet, cut flashing, arrange pallet, put label, and wrapping. Usually, one pallet was not done yet the new pallet already coming. So, we need to do our work extremely fast and very rushing. I'm supposedly run an experiment for material testing when I was at QC department, but during that time I'm only do welding pallet and operator. Sometimes intern student need to replace operator for their rest time.

To conclude, all the issue above happens because of poor management and shortage of workers. The company should improve their management and hire more workers. They cannot use intern student to cover the shortage of workers problem. Thus, the amount of work given to the employee was to much.

#### **4.5 Health, environment, and sustainable aspects**

Environmental health and sustainability professionals ensure our communities and environments are safe and healthy. Biological, chemical, and physical hazards pose challenges to our planet and to people. We can study these hazards and help prevent or reduce damage to the environment and human health.

From where we work to what we do, we can have a career in environmental health and sustainability that fits our passion. At Illinois State, we can focus on public health, industrial hygiene, or environmental protection. This can lead us to an exciting career in:

- Food protection
- Water and wastewater management
- Indoor and outdoor air quality control
- Pollution prevention
- Occupational health
- Industrial hygiene

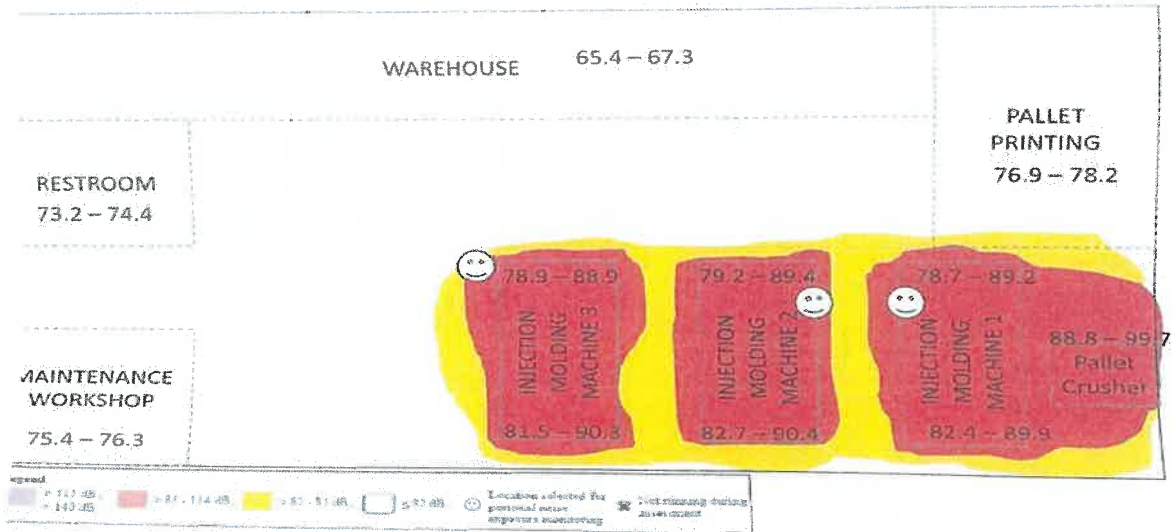
At Sanko Plastics Malaysia there are several actions taken in order to control health, environment, and sustainable aspects.

### **Health**

To control the health of every employee, noise risk assessment has been done once a year at Sanko Plastics Malaysia. A noise risk assessment is carried out to ensure the health and safety of workers exposed to noise risks. Noise Risk Assessment is more than just taking measurements of noise – it includes many other things. Additionally, Noise Risk Assessment helps identify the sources of noise risk and how it affects the employees. The results derived from the Noise Risk Assessment are further evaluated and used to develop preventive measures or corrective actions in order to reduce the long-term effects of noise exposure.

A Noise Risk Assessment usually includes:

- Identifying the noise risks and the people around who are likely to be affected.
- A reliable assessment of employees' exposures and compare the exposure with the exposure action values and limit values.
- Determining what a company or organization should do to comply with the law; for example, noise-control measures or hearing protection requirements
- Identifying any employees who need to be protected with health surveillance and whether any are at particular risk.



Noise Mapping

**SANKO PLASTICS (MALAYSIA) SDN BHD**  
 Date of Assessment: 12th September 2021  
 Report No: HQ/PLM/001/2021-001



Dosimeter Fitting on Workers

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Summary of Hearing Assessment for Workers that Suffered Hearing Loss/ Hearing Impairment  
 Company: Sanko Plastics Malaysia Sdn. Bhd.  
 Reference Audiometric Testing Report: Amcen Lab Sdn Bhd [AMT/2112/005C]  
 Date of Ear Examination: 3rd March 2022

No	Name	IC	Baseline Audiometry	Diagnosis	Employer's Action	Employee's Action	Notification to DOSH
1	ABDUL JAMIR AHMAD	820922-06-5537	15/12/2021	Bilateral Mild Hearing Loss (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
2	AZRI BIN ANASARI	911123-11-6155	15/12/2021	Left Ear Mild Hearing Loss (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
3	CHUNG SEE EHN	80518-08-6142	15/12/2021	Right Ear Mild Hearing Impairment (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
4	MAMAZAH BINTI ABU BAKAR	650404-10-6675	15/12/2021	Right Ear Mild Hearing Impairment (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
5	RHAIKUL ADZAHAR ABDUL AZIZ	801213-10-5167	15/12/2021	Bilateral Hearing Impairment (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
6	MAHAMAN MASU	89334646	15/12/2021	Bilateral Mild Hearing Impairment (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
7	MOHD AFU HARAL	975028-03-5349	15/12/2021	Right Ear Mild Hearing Loss (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
8	MOHD BAHARD BIN ABDUL GHANI	740724-06-5675	15/12/2021	Right Ear Mild Hearing Loss (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
9	SEW HUI YENG	650901-08-5023	15/12/2021	Bilateral Hearing Loss (Non-Occupational)	Refer and Retrain	Compliance to PHP	No
10	SHAM SUKRY RAMLI	830415-11-3727	15/12/2021	Bilateral Mild Hearing Loss	Refer and Retrain	Compliance to PHP	No

Summary of Hearing Assessment for

Figure 21.0 Noise Risk Assessment

## ENVIRONMENT

The most essential component of ISO 14001 is the identification and assessment of major environmental factors, particularly during the planning stage. One of the most important success elements in establishing an ISO 14001 EMS is having a solid understanding of the environmental aspects and implications. An part of an organization's activities, products, or services that has or could have an influence on the environment is referred to as a "environmental aspect" in the language of ISO 14001 standards. For example, one of the environmental aspects of car washing may be a cleaning agent that has potential for water pollution (this pollution is the environmental impact).



At Sanko Plastics Malaysia have several components that could give negative impact to the environment which is hydraulic oil, glove use to change mould and grease oil. To avoid the component from giving impact to the environment, Sanko Plastic Malaysia has their own waste storage. The waste storage is far from working area and have a proper ventilation system for volatile waste. Inside the waste storage have a jumbo bag to collect the glove and 200L drum to collect spill hydraulic oil. All the waste will be disposed before 180 days.





*Figure 22.0 Waste Storage*

## SUSTAINABLE

In order to sustain in this industry, Sanko Plastic Malaysia have made a proper schedule waste. The improper management of scheduled wastes lead to the contamination of ground water and surface water, air pollution which caused adverse effect on the environment and human health. Besides, to ensure that the wastes are disposed safely without causing any harm to the public and environmental health. Lastly, to ensure industrial companies abide to the Environmental Quality Act (1974). Here is a schedule waste in Sanko Plastics Malaysia:

WASTE	CODE AND DESCRIPTION
	<ul style="list-style-type: none"> <li>• Code: <b>SW 306</b></li> <li>• Description: Spent hydraulic oil</li> <li>• Example: Spent hydraulic oil</li> <li>• Typical source: Hydraulic equipment and Machine</li> </ul>
	<ul style="list-style-type: none"> <li>• Code: <b>SW 312</b></li> <li>• Description: Oily residue from automotive workshop, service station oil or grease interceptor</li> <li>• Example: Oily sludge</li> <li>• Typical source: Workshop</li> </ul>



	<ul style="list-style-type: none"> <li>• Code: <b>SW 409</b></li> <li>• Description: Disposed container, bags or equipment contaminated with chemical, pesticides, mineral oil or scheduled waste</li> <li>• Example: Empty paint container</li> <li>• Typical source: Printing</li> </ul>
	<ul style="list-style-type: none"> <li>• Code: <b>SW 409</b></li> <li>• Description: Rags, plastics, paper or filter contaminated with scheduled waste</li> <li>• Example: Glove, cotton rags</li> <li>• Typical source: Production</li> </ul>

*Table 6.0 Schedule Waste*

## CHAPTER 5

### CONCLUSIONS

#### 5.1 Conclusion

Throughout the 24 weeks of industrial training in Sanko Plastics Malaysia Sdn Bhd, I have gained a lot of skills and experience. All the staff here has providing me a good guided and opportunities.

During the internship program, I have learned lot of new skill especially social skills. To communicate with someone older and foreigner is not an easy thing. Not all foreigners can speak English fluently. i has experienced the reality while working in industry. What I can say is that is not easy and very challenging. Become an operator was a very horrible experience, the tiredness and mentally challenging will not be forgotten. Even though, I am able to follow professional ethics in completing all the orders and task given.

To conclude, I admit that I am very satisfied to finish my internship program at this company. All the employee was very friendly and easy to get in touch. I hope that the management can be improved for a better working environment.

## 5.2 Suggestion and Recommendations

As for the suggestion and recommendation, I suggest Sanko Plastics Malaysia to hire more employee for production department. Only one person for one machine was not enough. It will affect the mental health of their employee. The prove is every week have workers run away and resign. This is because of the workload was too much.

Besides, the management need to properly calculate the cycle time for each machine so their employee not too burdened. They need to consider the number of workers they have to set a production target and sales. If not, they will keep losing workers and it will affect the production department. Because of that, people who are not related to production need to the production works.

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# APPENDIX

