

Intisari

PT Bali Maya Permai merupakan industri perikanan yang bergerak di bidang pengalengan ikan sarden dan tuna yang terletak di Kabupaten Jembrana, Bali. Permasalahan yang terjadi selama proses produksi adalah non-efisiensi dan *bottleneck* aliran bahan pada bagian *exhausting*, *retorting* dan saat proses pemindahan ikan dari area *thawing* menuju ruang produksi sehingga diperlukan adanya perancangan ulang tata letak fasilitas produksi. Penelitian bertujuan menganalisis efisiensi aspek-aspek tata letak fasilitas di PT Bali Maya Permai dan merancang ulang tata letak sehingga diperoleh rekomendasi tata letak yang efisien. Perancangan ulang tata letak dilakukan dengan menggunakan metode *unequal analysis facility layout problems* (UA-FLP) dan *Blocplan*. Hasil perancangan ulang tata letak dengan metode UA-FLP dan *Blocplan* diperoleh ongkos perpindahan bahan per bulan masing-masing sebesar Rp. 13.978.824.552 dan Rp. 14.497.176.006, lebih rendah dibandingkan dengan ongkos perpindahan bahan per bulan *layout* awal yaitu Rp. 19.971.536.717. Hasil perancangan ulang tata letak dengan metode UA-FLP meningkatkan efisiensi sebesar 30,01%, dan metode *Blocplan* meningkatkan efisiensi sebesar 27,41%.

Kata kunci : *blocplan*, ongkos perpindahan bahan, tata letak, *unequal analysis facility layout problems*.

Abstract

PT Bali Maya Permai is a fishing industry engaged in canning of sardines and tuna located in Jembrana Regency, Bali. Problems that occur during the production process are non-efficiency and bottlenecks of material flow in the exhausting, retorting and during the process of moving fish from the thawing area to the production room so that a redesign of the production facility layout is needed. The study aims to analyze the efficiency aspects of the facility layout at PT Bali Maya Permai and to redesign the layout so that an efficient layout recommendation is obtained. The redesign of the layout is done using the method of unequal analysis facility layout problems (UA-FLP) and Blocplan. The results of the redesign of the layout using the UA-FLP method and Blocplan obtained monthly material transfer costs of Rp. 13.978.824.552 and Rp. 14.497.176.006, lower than the cost of moving material per month of the initial layout of Rp. 19.971.536.717. The results of the redesign of the layout by the UA-FLP method increased efficiency by 30,01%, and the Blocplan method increased efficiency by 27,41%.

Keywords : Blocplan, facility layout, material handling cost, unequal analysis facility layout problems.