



ABSTRACT

Delivery capacity of PT Pakoakuina Motor Cycle for PT Astra Honda Motor was decreased on October 2018. This is because the Sales Forecast on October exceeds the production capacity of PT Pakoakuina Motor Cycle. After being reviewed from the loading and capacity aspect per day in all processes, apparently the machining process is the lowest. The machining capacity become the lowest due to the output of MD1-MD2 production line doesn't reach the company target. This is has an impact on efficiency and performance. MD1-MD2 line is a production line that process drilling holes for valve hole and drilling with tapping at velg disc hole.

To overcome that problem needed research and improvement in the MD1-MD2 production line. As for research method and improvement obtained from the examination of actual condition in the production line, cause and effect analysis, direct interview and planning tackling effort. This research and improvement include five main discussion among others changing rule supply material, accelerate machine's auto process, relayout store OP, manufacturing jig for BHTP dimension's check and accelerate loading unloading time at locator part.

Overall, this improvement has resulted in an increase in output of 41 pcs velg in one day. Moreover, this improvement has succeeded in increasing the efficiency by 95 % and the performance by 90 %.

Keywords : Output, Efficiency, Performance.



INTISARI

Kapasitas *Delivery* PT Pakoakuina *Motor Cycle* untuk PT Astra Honda Motor mengalami penurunan kapasitas pada bulan Oktober 2018. Hal ini dikarenakan *sales forecast* bulan Oktober melebihi kapasitas PT Pakoakuina *Motor Cycle*. Setelah ditinjau dari segi *loading* dan *capacity* perhari dalam semua proses, ternyata kapasitas *machining* terendah. Kapasitas *Machining* terendah dikarenakan oleh *output* dari lini produksi MD1-MD2 tidak mencapai target perusahaan. Hal ini berdampak terhadap *efficiency* dan *performance*. Lini MD1-MD2 sendiri merupakan lini produksi yang memproses pelubangan pada lubang pentil serta pelubangan dan penguliran pada lubang cakram *velg*.

Untuk mengatasi permasalahan tersebut diperlukan penelitian dan *improvement* dilini produksi MD1-MD2. Adapun metode penelitian dan *improvement* ini diperoleh dari analisa kondisi yang ada dilapangan, analisa sebab akibat, studi literatur, *interview* secara langsung dan merencanakan upaya penanggulangan. Penelitian dan *improvement* ini mencakup 5 pokok bahasan diantaranya penggantian *rule suplay* material, mempercepat proses auto mesin, *relayout store* OP, pembuatan *jig* untuk pengecekan dimensi BHTP dan mempercepat waktu bongkar pasang *part* bagian *locator*.

Secara keseluruhan, *improvement* ini telah menghasilkan peningkatan *output* sebanyak 41 pcs *velg* dalam satu hari. Selain itu, *improvement* ini telah berhasil meningkatkan *efficiency* sebesar 95 % dan *performance* sebesar 90 %.

Kata kunci : *Output, Efficiency, Performance.*