

ABSTRACT

Line housing assy B is a line which produces assembly housing rear axle at PT Inti Ganda Perdana. The production process at the housing assy B line is experiencing obstacles which result in not achieving the target productivity. The line makes improvements to optimize the production process by producing maximum productivity. Based on the provisions for improvement from the company, there are 3 factors that need to be considered, including safety patrols, external factors, and internal factors. In internal factors, there are 4 things that affect the production process, namely safety, quality, delivery and productivity.

This research was conducted by means of genba or direct observation at the production process of line housing assy B. Observations on the production process were aimed at obtaining data on production flow, cycle time, and man power movement flow. The data is then processed and used as the basis for the improvement process. To help the data processing process, the yamazumi chart is used as a reference in the improvement process. Improvement made in line housing assy B by applying the principles of PDCA (Plan-Do-Check-Action).

Increasing productivity can be done by optimizing the number of man power line housing assy B. In the process of reducing man power, improvements are made to overcome the problems that occur in several ways, including automation of the loading process for the A19-B21 engine, autoprocessing the C2.2 engine, and manpower efficiency. power. This improvement succeeded in reducing the cycle time man power value so that there was a balance based on the yamazumi chart.

Keywords : *productivity, man power, line housing, cycle time*

INTISARI

Line housing assy B merupakan *line* pada PT Inti Ganda Perdana yang memproduksi *assembly housing rear axle*. Proses produksi pada *line housing assy B* mengalami kendala yang berakibat pada tidak tercapainya *target productivity*. *Line* tersebut melakukan perbaikan untuk mengoptimalkan proses produksi dengan menghasilkan produktivitas yang maksimal. Berdasarkan ketentuan perbaikan dari perusahaan, terdapat 3 faktor yang perlu diperhatikan, diantaranya *safety patrol*, *external factor*, dan *internal factor*. Dalam *internal factor*, terdapat 4 hal yang mempengaruhi proses produksi, yaitu *safety*, *quality*, *delivery*, dan *productivity*.

Penelitian ini dilakukan dengan cara *genba* atau pengamatan secara langsung pada proses produksi *line housing assy B*. Pengamatan pada proses produksi bertujuan untuk memperoleh data aliran produksi, *cycle time*, dan alur pergerakan *man power*. Data tersebut kemudian diolah dan digunakan sebagai dasar dalam proses *improvement*. Untuk membantu proses pengolahan data digunakan *yamazumi chart* sebagai acuan dalam proses *improvement*. *Improvement* yang dilakukan pada *line housing assy B* dengan menerapkan prinsip PDCA (*Plan-Do-Check-Action*).

Peningkatan *productivity* dapat dilakukan dengan mengoptimalkan jumlah *man power line housing assy B*. Dalam proses pengurangan *man power*, dilakukan *improvement* untuk mengatasi masalah yang terjadi dengan beberapa cara diantaranya yaitu otomasi proses *loading* mesin A19-B21, *autoprocess* mesin C2.2, dan efisiensi kerja *man power*. *Improvement* tersebut berhasil mengurangi nilai *cycle time man power* sehingga terjadi *balance* berdasarkan *yamazumi chart*.