

ABSTRACT

Dedi Panuju. 038140001. “The Optimum Time Determination for Making Dished End by Using Standard Time Method on 2100 mm Diameter Sterilizer Door”. Supervised by Ir. Hj. Haniza, AS., M.T. and Ir. M. Banjarnahor.

PT. ATMINDO which located in K.L. Yos Sudarso street Number 100, Medan was established on March 24th, 1972 based on the Minister of Industry Decree Number 102 /M/SK/III/1971, concerning about the granting of licenses in manufacturing agricultural equipment, processing equipment for plantation products and boilers in North Sumatra. The work scope implemented by PT. ATMINDO is a job order. In carrying out factory activities, workers are required to have the responsibility for carrying out their duties and have expertise in their respective fields. A careful calculation and time using will support the work schedule that has been made for each work process. It was since if the work time used uncontrolled, not only work schedule will miss-hit but also the effect of the cost came up with the financial losses. The data collected in this study is the time of finishing an activity in each work unit. Furthermore, in processing and data analyze, 95/5% of the confident limit rate was obtained, so it could be determined the amount of observation needed. After the number of observations was sufficient, the cycle time could be determined. After the cycle time was obtained then the normal time could be calculated, reckoning the rating factors (adjustments according to Westinghouse) namely the factors of skill, effort, working conditions and consistency. Then, based on the normal time which was then added to the desired adjustment and looseness factors for each work element, the standard time was obtained. The standard time needed to be researched, seeing the frequent emergence of ineffective use of working time by a worker in doing his work as well as an imbalance of work time between one to another activity. From the results of the calculations on each unit of work activities in making the Dished End, the following standard times were obtained: Forklift I unit was 135.71 minutes, Marking unit was 20.62 minutes, Inspection I unit was 29.31 minutes, Cutting unit was 40.97 minutes, Crane I was 17.07 minutes, Dishing unit was 1206.08 minutes, Inspection II unit was 42.41 minutes, Crane II unit was 23.06 minutes, Flanging unit was 286.21 minutes, Forklift II unit was 34.84 minutes, Sand Blasting unit was 105.81 minutes, Crane III unit was 28.41 minutes, and Turning unit was 231.16 minutes. Thus, the total standard time to complete the manufacture of a Dished End unit on the 2100mm diameter Sterilizer Door is 2231.69 minutes.

摘要

Dedi Panuju 03.815.0001, “PENENTUAN WAKTU OPTIMAL PEMBUATAN DISHED END DENGAN METODE WAKTU STARDARD PADA STERILIZER DOOR DIAMETER 2100 MM”。根据学费Hj女士。 Haniza, AS, MT担任顾问I和Ir先生。 M. Banjarnahor担任顾问二。

PT。位于道路的ATMINDO;街道K.L. Yos Sudarso No. 100 Field于1972年3月24日根据Nobelium的工业部长法令开放。 102 / M / SK / III / 1971, 关于在北苏门答腊省颁发农业设备许可证, 种植产品加工设备和锅炉。由工作范围PT实施。 ATMINDO具有订单工作(工作订单)的特征。在负责执行职务的劳动者所要求的工厂的活动的执行, 并且在各自的领域有会员资格。小心时间的计算和使用将支持为每个工作流程制定的就业安排。因为在不控制工作时间的使用不仅会滑倒, 而且几乎不影响财务的发生损失的费用。在这项研究中收集的数据是在每个活动单位进行活动身份所需的时间。测试获得的数据均匀性的数据具有95/5%的意外限制, 以便可确定地总结所需的观察结果。在观察量满足需求之后, 因此可以确定循环时间。通过周期时间获得然后可计算正常时间, 通过计算评级因子(根据Westinghouse调整)即技能因素, 努力, 一致性和工作条件。基于正常时间, 然后加上每个元素工作所需的扩散和调整因子, 因此获得的是标准时间。需要检查的标准时间, 经常看到发生率不是工人在工作中的有效使用, 也存在与其他活动之间的工作平衡

要旨

ATMIND株式会社が引き受ける仕事の範囲は職務指示書である。工場での活動を実施するにあたり、労働者は職務を遂行する責任があり、それぞれの分野の専門知識を持っている必要がある。時間の注意深い計算と使用は、各作業プロセスに対して行われた作業スケジューリングをサポートする。作業時間の使用は管理されていない場合、欠勤するだけでなく、金銭的損失を伴うコストに大きく影響する。この研究で収集されるデータは、各作業単位で1単位のアクティビティを実行するのに必要な時間である。得られたデータは、95/5%の確信限界でデータの均一性をテストしたため、必要な観測数を決定できた。観測数が十分になったら、サイクル時間を決定でき、サイクルタイムが得られたら、評価要素（ウェスティングハウスによる調整）、すなわちスキル、労力、労働条件、一貫性の要素を考慮して、通常の間が計算できる。標準時間は、通常の間に基づいて取得され、その後、各作業要素の必要な調整係数と許容値に追加される。

