

ABSTRACT

Labor is one of the factors that play a role in the smooth running of the production process, especially for the industrial production process is still dominated by the work that is done manually by humans. PT Sunan Rubber is one of the semi-finished rubber processing industry in Palembang. Overall, this industry employs a lot of manpower to run the production process. In the packing process crumb rubber is a trajectory that consists of several parts, which must be passed in order. The final part of this process (preparation into the Metal Box) require a longer processing time, often resulting in queues of products in the previous section. So that the packing process is not optimal. In addition, the achievement of target data quality objectives in 2013, it appears that the process of packing is not able to meet the set targets, with an average percentage of 6.18% was not achieved.

Measurement of work with work sampling has one goal is to determine the standard time, so it is known that the number of operators required in the packing process. The results of these studies, gives an overview of the standard time required in each section of packing, and the average performance of 83,83 % operators productive during the observation. In addition, based on the time standard, required 29 operators, or additional 8 operators in the process of packing. In addition, because of the limitations of the machine/tool, the proposal to do now is to increase by 5 operators with the result that the company has not met the target in 2014. However, based on the calculation results of the standard time, additional operators can make increased production.

Keywords: Packing Process, Work Sampling, Standard Time, Number of Operator.