

ABSTRACT

PT Pan Panel is one of the companies which move in the furniture matter. Products which produced by PT Pan Panel are really variation , one of them is cupboard product. It has some important components which need long assembling process , the important about leaf of door. To accelerate the assembling process , we need good and accurate work's step. But in fact , that good and accurate work's steps still ignore by many people . Because this reason, we need correction activity of work's method .

The work's method correction with Maynard Operation Sequence Technique (MOST) have important role to minimize time's process , to identify the movement element and combine the movement to be the systematic process. The beginning work's method layout and the proposal work's method used to identify the movement's element with left and right hand chart and also flow process chart. After that , based on the movement's element we can do standard time accounting .

The beginning work's method research result show the standard's time on the part of dowel: 2,16 minutes with standart ouput 194 dowel/day, the door I: 4.54 minutes with standart ouput 194 dowel/day , the door II: 3,17 minutes with standart ouput 132 door/day, glass door :2,59 minutes with standart ouput 142 door/day and door press activity :1,31 minutes with standart ouput 319 door/day. After do the work's method correction with eliminate and mix the movement's element , so that we get the standard's time on the part of dowel :1,57 minutes with standart ouput 267 dowel/day, the door I: 3,64 minutes with standart ouput 115 door/day, the door II:2,72 minutes with standart ouput 154 door/day, glass door :2,67 minutes with standart ouput 157 door/day and door press activity:1,26 minutes with standart ouput 331 door/day. The result of the proposal work's method , we get the shorter time's process .

The key words :Work's method , layout , left and right hand chart , flow process chart , MOST .