ARRANGING THE NUMBER OF MANPOWER USING FIVE STEPS OF THEORY OF CONSTRAINT ON THE POP MIE'S PACKAGING LINE AT PT INDOFOOD CBP SUKSES MAKMUR TBK NOODLE DIVISION

ABSTRACT

On the Pop Mie's packaging line at PT Indofood CBP Sukses Makmur Tbk Noodle Division, there are seven work stations with different composition of manpowers at each station. With the regulation of manpower according to condition exist, there is still a bottleneck of products at the sixth work station because the number of products produced from the previous stations isn't able to be resolved by the number of manpowers available at the station. Then the number of manpowers is arranged by applying the five main steps in identifying the constraints of the Theory of Constraint method. Balanced allocation of manpowers based on these conditions is two manpowers at the first station, one manpower at the second to fifth station. Eleven manpowers at the sixth station and two manpowers at the seventh station.

Keyword : theory of constraint, the number of manpowers, line balancing.