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# Proceeding

**6<sup>th</sup> INTERNATIONAL SEMINAR ON INDUSTRIAL  
ENGINEERING AND MANAGEMENT (6<sup>th</sup> ISIEM)**

*"Sustainable innovation on enhancing  
industrial management, technology, and information"*



Harris Hotel Batam Center, Batam, Indonesia  
February 12<sup>th</sup> - 14<sup>th</sup>, 2013

Organized by:



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# Proceeding

**The 6<sup>th</sup> International Seminar  
on Industrial Engineering and Management (6<sup>h</sup> ISIEM)**

Harris Hotel Batam Center, Batam, Indonesia  
February 12<sup>th</sup> – 14<sup>th</sup>, 2013

**Organized by :  
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Indonesian Industrial Engineering  
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# FOREWORD

In this 6<sup>th</sup> International Seminar on Industrial Engineering and Management (ISIEM) Seminar issues is **Sustainable on Enhancing Industrial Management, Technology, and Information**, and wide area of Industrial Engineering including Quality Engineering, Supply Chain Management, Production System, Operation Research, Decision Support System, Ergonomics, Artificial Intelligent, Industrial Management, and Entrepreneurship.

All of papers received were review by a peer of reviewers and published for 55 papers from various Indonesian University and abroad, and be presented by 52 presenters.

Historical, the ISIEM is an annual seminar event organized by 6 universities that run Industrial Engineering Department, which are Triskati University Jakarta, Atmajaya Catholic University Jakarta, Tarumanagara University Jakarta, Esa Unggul University Jakarta, Al-Azhar Indonesia University Jakarta, and Pasundan University Bandung. The seminar took different places annually in all over Indonesia.

I would like to thank you to all committees for the efforts, all Reviewers, Mr. Predeep Nair from Schneider Manufacture Batam, Prof. Dr. Rosnah Mohd. Yusuff from Department of Mechanical and Manufacturing Engineering Universiti Putra Malaysia, Prof. Frits Blessing from Rotterdam University/Rotterdam Business School, for the Keynote Speeches, all Participants to join the Seminar, and everybody who helped us to make this seminar happen.

At last, enjoy your stay in Batam and have a good Seminar.

Ir. Wahyukaton, MT.  
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Chairman of Committee

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# AGENDA

## **Day 1 (February 12<sup>th</sup>, 2013)**

Opening ceremony

Gala Dinner

Keynote #1

Mr. Pradeep Nair

Plant General Manager PT Schneider Electric Manufacturing Batam

## **Day 2 (February 13<sup>th</sup>, 2013)**

Keynote #2

**Prof Rosnah Mohd Yusuff**

Department of Mechanical and Manufacturing Engineering, Faculty of Engineering, Universiti Putra Malaysia

*"Innovations In Manufacturing For Sustainable Growth"*

Coffee Break

Parallel Session #1

Lunch

Keynote #3

**Prof. Frits Blessing**

DINALOG & Rotterdam University of Applied Sciences

*"I Have To Change To Stay The Same"*

Coffee Break

Parallel Session #2

## **Day 3 (February 14<sup>th</sup>, 2013)**

**Tour to Singapore**

# TABLE OF CONTENT

Foreword  
Committee  
Reviewer  
Agenda  
Table Of Content

## QM – Quality Engineering & Management

No	Title and Author	Page
1	Design Of Water Quality Model To Support The Indonesian Healthy Project <b>Ratih Setyaningrum, Dwi Eko Waluyo</b>	QM – 1
2	Analysis Service of Satisfaction of Intercity Bus With IPA and CSI Method <b>Dyah Rachmawati L, Trismi Ristowati, Mohammad Khoeruddin</b>	QM – 6
3	Quality Analysis Using Fmea Method On Assembly Processes Of Washing Machine (Case Study In Panasonic Manufacturing Indonesia) <b>Rifa Arifati, Ardika Rismayana</b>	QM – 11
4	Pre Travelling Service Quality Analysis at Rail Station Commuter Jakarta-Bogor <b>Pudji Astuti, Winnie Septiani, Amal Witonohadi</b>	QM – 16
5	Integrating Kansei Engineering And Customer Relationship Management To Improve Service Quality: A Case Study At Shopping Mall In Surabaya <b>Markus Hartono, Rosita Meitha, Grandy Ongkowijoyo</b>	QM – 21
6	The Impact Of Perceived Service Quality on Customer Satisfaction And Loyalty: Case Study at Supermarket in Surabaya <b>Rosita Meitha Surjani, M.Arbi Hadiyat, Vanessa Gautama</b>	QM – 27
7	Quantitative Approach to Measure Process Connectivity in Balanced Scorecard Model <b>Vivi Triyanti</b>	QM – 34
8	Path Analysis To Assess Interaction Among Tracer Study Factors <b>Vivi Triyanti</b>	QM – 42
9	Consumer Preferences and Quality Perception of Imported and Domestic Apple in Surabaya <b>I Gede Agus Widyadana, Tanti Octavia, Herry Christian Palit, Dick Felix Wibowo</b>	QM – 48

## SCM – Supply Chain Management

No	Title and Author	Page
1	Knowledge Management System Model in DKI Jakarta Rice Supply Chain <b>Dadang Surjasa, Dedy Sugiarto, Binti Solihah, Nirdukita Ratnawati</b>	SCM – 1
2	A Design Experiment To Evaluate The Effect Of Demand Pattern Into The Lot Sizing Performance <b>Arum Sari, Ulista Feriana</b>	SCM – 9
3	Supply Chain Management Performance Measurements in Oil Company <b>Tiena Gustina Amran</b>	SCM – 15

## SCM – Supply Chain Management

No	Title and Author	Page
4	Applying Netlogo Simulation Model To Balance The Upstream Palm Oil Supply Chain <b>Syarif Hidayat, Mas'ud Ridwan</b>	SCM – 24
5	Hybrid Model For Supplier Selection, Procurement, And Production <b>Catur Kurniawan, Nur Hildawati</b>	SCM – 32
6	The Design Of Multi Role Web Based Supply Chain Simulation Game For Learning <b>Armand Omar Moeis, Rama Raditya, Akhmad Hidayatno</b>	SCM – 41
7	Performance Analysis Of Green Supply Chain Management In Pt Tirta Investama Subang <b>Agus Purnomo</b>	SCM – 48
8	Model For Supply Chain Network Design with Profit Balancing Consideration <b>Harwati, Muhammad Ridwan Andi Purnomo</b>	SCM – 56
9	The Influence of Supply Chain Management to Product Quality at PT XYZ in Jakarta <b>Andi Wijaya, Richard Andrew</b>	SCM – 62
10	Production Planning Control to Minimize Production Cost <b>Nunung Nurhasanah, Riyana Susanti</b>	SCM – 67
11	Measurement Supply Chain Performance Using Metric of SCOR Model (Case Study : Automotive Component Manufacturing) <b>Nofi Erni</b>	SCM – 75
12	Designing Green Supply Chain Management In Cocoa Agroindustry : Problem Identification And Profiling <b>Iphov Kumala Sriwana, Yandra Arkeman, Dahrul Syah, Marimin</b>	SCM – 81
13	Spare Parts Distribution Route Planning with Saving Matrix Method at PT.XYZ <b>Iphov Kumala Sriwana, Sylvia Madusari, Nurulita Aulia Sari</b>	SCM – 90

## OR – Operation Research

No	Title and Author	Page
1	Crashing Project Schedule Network with Methods Selection <b>Ismail H. Asrul</b>	OR – 1

## ER – Ergonomics

No	Title and Author	Page
1	The Analysis of The Effect on Physical Environment Factor for Noise and Luminous to Accuracy Score on Reading and Colors Matching <b>Wahyukaton</b>	ER – 1
2	Optimum Design of 1-DOF Anthropomorphic Thumb Considering Grasping Motion for Indonesian Low-Cost Prosthetic Hand <b>Tyo Prasetyo, Susy Susmartini, Ilham Priadythama</b>	ER – 7
3	The Cutting Ampoule Design Inovation to Develop Safety and Helath Patient <b>Yuwono B Pratiknyo, Anita Purnamayanti</b>	ER – 13



## ER – Ergonomics

No	Title and Author	Page
4	Design Measurement for Manufacturing Ergonomic Value of an Automotive Part Using The Total Ergonomic Approach Model <b>Tiena G. Amran, Nataya Charoonsri Rizani, Herawan Setio</b>	ER – 19
5	Train Derailments In Indonesia - A Study Using Human Factors Analysis and Classification System <b>Citra Wanurmarahayu, Hardianto Iridiastadi</b>	ER – 29
6	Designing Workbench on The Sawmill Station to Reduce Physical Load at Surya Mas Factory <b>Lamto Widodo, Andres, Fransisca Lipin</b>	ER – 35

## DSS – Decision Support System and Artificial Intelligence

No	Title and Author	Page
1	Database Management System Application (Case Study: Twisbless) <b>Raymond Bahana, Hans Kristian</b>	DSS – 1
2	A Design Of Learning Management System Using Adaptive Recommendation Method <b>Jinsuk Yang, Kyoungsu Oh, Sangjun Lee</b>	DSS – 9
3	Customer Relationship Management Information System Development In PT. Citra Van Titipan Kilat <b>Fransiskus Adikara, Ricky Fauzi</b>	DSS – 14
4	Occlusion Detection Of Virtual Target For Augmented Reality <b>Gyeyoung Kim , Changjin Suh, Sangjun Lee, Soowon Lee</b>	DSS – 21
5	The Emergence of User Requirement Risk In Information System Development for Industry Needs <b>Fransiskus Adikara, Benhard Sitohang, Bayu Hendradjaya</b>	DSS – 27
6	A Progress in Business Intelligence Implementation in CRM (Customer Relationship Management), SCM (Supply Chain Management) And Quality Management <b>Rina Fitriana, Marimin, Taufik Djatna</b>	DSS – 34
7	Evaluation of The VRP Completion with Developing Hybrid Genetic Algorithm Using Fuzzy Logic Controller Model <b>Yogi Yogaswara</b>	DSS – 44
8	Proposed Of Decision Policy Model Development For City Logistics Stakeholders <b>Yogi Yogaswara, B. Kombaitan, Idwan Santoso</b>	DSS – 54

## PS – Production System

No	Title and Author	Page
1	Optimization of A Shock Absorber Assembly Line Using Simulation <b>Iwan A. Soenandi</b>	PS – 1
2	Design of Lean Production System Using Integrated Value Stream Mapping Approach <b>Yadrifil, Irvanu Rahman, Faisal Akbar</b>	PS – 6

## PS – Production System

No	Title and Author	Page
3	Identification Performance And Machine Failure of Manufacturing System Based On OEE And FMEA Methods (Case Study On PT. APF) <b>Jazuli, Angga Laksitama, Adelia Dini Meinawati</b>	PS – 12
4	Automated Multi-View Visual Inspection and Grading System For Shrimp <b>Yudha Prasetyawan, Putu Dana Karningsih, Lucky Sabrina Adluna</b>	PS – 18
5	Maintenance Task Design And Spare Part Inventory Policy For An Evaporation Sub System <b>Yudha Prasetyawan, Weny Yuliana Sari</b>	PS – 26
6	Analysis of Factors Affecting Throughput Rate in Flexible Manufacturing System with Automated Guided Vehicle System <b>Teuku Yuri M. Zagloel, Romadhani Ardi, Lusyane Eko Tantri</b>	PS – 33
7	Insertion Heuristic for The Single Row Layout Problem in Flexible Manufacturing Systems <b>Tjutju Tarlih Dimyati</b>	PS – 40
8	Optimization Of MIDI Synthesizer On The Illustration Of Movie Music <b>Pandan Pareanom Purwacandra, Ferry Wahyu Wibowo</b>	PS – 46
9	Implementation Theory of Constraint on CFM56-3 Aircraft Engine Maintenance <b>Untung Mahargo B. P., Hardianto Iridiastadi, E. Nina S. Y., Zulfa F. I</b>	PS – 52
10	The Implementation Of Lean Six Sigma Method in Production Process of Underwear Rider R333B at PT. XYZ <b>Johnson Saragih, Rahmi Maulidya, Diana Jane Halim</b>	PS – 60
11	The Effect Of Demand Behavior Of Automotive Glass Manufacturer On Cost of Good Sold And Logistics Performance Through System Dynamics Approach <b>M. Nurman Helmi</b>	PS – 66
12	The Proposed Layout Design Using Factory Systematic Layout Planning Method at PT. Jasa Laksa Utama <b>Lina Gozali, Silvi Ariyanti, Leowendo Putrajaya</b>	PS – 72
13	Remodelling The Maintenance Performance Management System <b>Rivan Syamsurijal Biya, Triwulandari S. Dewayana, Nora Azmi</b>	PS – 77
14	Analysis of Outer Tube Casting Product Reject Using Computer Aided Engineering <b>Ahmad Juang Pratama</b>	PS – 84
15	Solving Assembly Line Balancing Problem Using Genetic Algorithm Technique with Partitioned Chromosome <b>Nora Azmi, Iman Yahya Azzubaidi, Sumiharni Batubara</b>	PS – 91
16	Production Scheduling Optimisation Using Genetic Algorithm in PT. Progress Diecast <b>Lily Amelia, Aprianto</b>	PS – 99
17	Applying Theory of Constraint and Bottleneck Scheduling Approach to Solve Production Capacity Problem <b>Sumiharni Batubara, Rahmi Maulidya, Mega Rahma Pertiwi</b>	PS – 106
18	Improvement Of Kanban System Based On Theory of Constraint <b>Rahmi Maulidya, Iveline Anne Marie, Kevin</b>	PS – 112

## IM – Industrial Management

No	Title and Author	Page
1	Customization of Open Source Enterprise Resource Planning System <b>Muhammad Ridwan Andi Purnomo, Luthfina Ariyani</b>	IM – 1
2	The Technology Implementation in Academic Processing to Achieve Effectiveness and Efficiency Of Information (A sharing from The Private University in Bandung) <b>Elizabeth Tiur M.</b>	IM – 7
3	Description and Review Existing Knowledge Management Framework, System, Technology and Architecture <b>Riya Widayanti</b>	IM – 13
4	Implementation of Evaluation Model and Supplier Performance Scorecard in Selecting Supplier <b>Johan Oscar Ong, Merry Erliani</b>	IM – 28
5	The Marketing Mix Strategy Based On Consumer Behavior Analysis at Taxi Max Cipaganti In Surabaya <b>Esti Dwi Rinawiyanti, Rosita Meitha, Ira Mayasari</b>	IM – 39
6	Catastrophe Model for Analyzing Behaviour of Development Policies In Indonesia <b>Dadan Umar Daihani</b>	IM – 47
7	Understanding Accounting Franchise, Guidance by Franchisor and Going Concern of Franchise Company in Bandung <b>Liza Laila Nurwulan, R. Mochammad Noch, Elsaf Kurniawan</b>	IM – 56
8	Five V's in Customer's Perspective <b>Richard Andrew, Andi Wijaya</b>	IM – 66
9	Services Improvement with Triz and TOPSIS Method <b>Feliks Prasepta S.Surbakti, Lenard</b>	IM – 74
10	Defining The Collaborative Key Performance Indicators in Performance Management <b>Marsellinus Bachtiar</b>	IM – 81
11	Designing Map Strategy Performance Measurement Functional Units Organization Method Based on The Balanced Scorecard (Case Study XYZ University) <b>Ahmad Chirzun, Mohamad Sulkhan</b>	IM – 88



# CERTIFICATE

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## THE PROPOSED LAYOUT DESIGN USING FACTORY SYSTEMATIC LAYOUT PLANNING METHOD AT PT. JASA LAKSA UTAMA

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### ABSTRACT

*PT. Jasa Laksa Utama is a manufacturing company that produces conveyors for material handling in mining coal industry. The great development in this similar industries that cause emerging PT. Jasa Laksa Utama to continue expanding in order to enhance productivity and effectiveness to meet the desires and customer satisfaction. But things happen in the real situation are still barriers that prevent optimal productivity of the company. This is because they lack of good plant layout that exist today, especially in the production. Using Systematic Layout Planning methods based on the comparison of the calculation of the Material Handling Planning Sheet (MHPS) initial plant layout with Material Handling Evaluation Sheet (MHES) proposed layout would be advised to the company. It is expected that the proposed plant layout design can better lead to increased productivity and efficiency of the PT. Jasa Laksa Utama.*

**Key words:** Systematic Layout Planning, Material Handling Planning Sheet (MHPS), Material Handling Evaluation Sheet (MHES).

### 1. INTRODUCTION

PT. Jasa Laksa Utama is one of the manufacturing company that producing a material control, namely the manufacture of conveyor which focused on the removal of coal. To remain competitive and produce products in accordance with the desires of consumers, these companies should have the line of the production process effectively and efficiently.

PT. Jasa Laksa Utama required layout in accordance with the process of working to achieve the production process, because during the production process running on PT. Jasa Laksa Utama assessed as having shortages caused by the process of repetition that does not comply with the order of the production process.

In this research, data collection will be cycle time, operation mapping, routing sheet, MPPC (multi-product process chart), calculate area, MHPS calculation (material handling planning sheet), followed by the processing of data, such as the manufacture of FTC (from to chart), ARD (area relationship diagram), AAD (area allocation

diagram), MHES (evaluation sheet material handling), and manufacturing layouts to support systematic layout planning aimed at proposing improvements in the production plant layout.

### 2. THEORETICAL BACKGROUND

The layout is a major cornerstone in the industrial world. Factory layout can be defined as a procedure for setting the factory facilities to support the smooth production process. In general, the layout of a well-planned plant will also determine the efficiency and in some cases will also maintain the viability or success of the industry's employment.

Plant Lay Out Method

#### 1. Form To Chart

From To Chart is sometimes also referred to as trip frequency chart or travel chart is a commonly used conventional techniques for factory layout planning and material movement in a production process is very useful technique for the conditions in which a lot of items that flow through the area such as job shop, machining workshop, office

and others. From to chart will show the total of the weight of the load to be moved, the material displacement distance, volume or combinations of these factors.

## 2. Activity Relationship Diagram

Activity relationship diagram is a block diagram showing the relationship approach activity, which shows each activity as a single activity model (no suppression chamber).

## 3. Making Area Allocation Diagram

Area Allocation Diagram is a tool that is closest to the actual layout of the plant, which will make the allocation of facilities in activities such as the production plant, office, plant service, warehouses and dormitories and other facilities.

## 4. Preparation of Material Handling Evaluation Sheet

It is a calculation sheet that will result in the total costs required to transfer each material on the production floor.

## 5. The depiction of a New Map Of The Production Department

Making a depiction in accordance will result the analysis of the AAD to be proposed as a design improvement.

## 3. DATA PROCESSING AND ANALYSIS

Processing begins to test the adequacy and uniformity of data from each process that occurs in the production to get the standard time. After obtaining the time process then will be continued by making a map of operating process, manufacturing process flow chart and making routing sheet (calculating the number of machines). The next sheet is a table comparing the number of machines needed in theoretical and actual number of machines (Table 2).

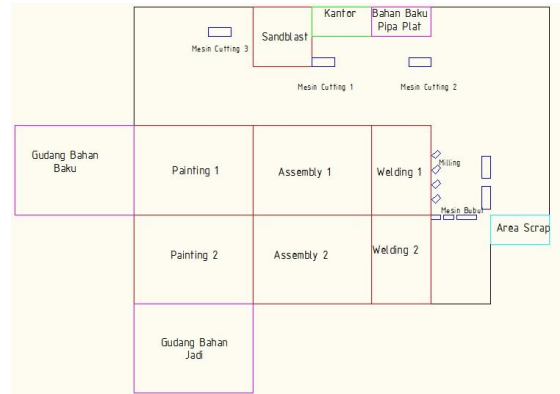


Figure 1 : Beginning Lay out of the factory

Table 1. Multi Product Process Chart for Hopper

Nama proses	Shell	Rib	Liner	Stiffener	Jumlah mesin teoritis
Raw material	(S1)	(S2)	(S3)	(S4)	-
Marking	(O1)	(O4)	(O6)	(O8)	-
Cutting	(O2)	(O5)	(O7)	(O9)	3
Drilling	(O3)				2
Fit Up	(C1)	(C2)	(C3)	(C4)	-
Welding	(A1)	(A1)	(A1)	(A1)	2
Assembly	(A2)	(A2)	(A2)	(A2)	2
Finishing	(O10)	(O10)	(O10)	(O10)	2
Painting	(O11)	(O11)	(O11)	(O11)	2
Checking	(CS)	(CS)	(CS)	(CS)	-
Fiinish goods	(SS)	(SS)	(SS)	(SS)	-

Tabel 2. Number of Lack, Excess and broken machine

No	Machine Name	Number of Theoretical Machine	Rounding Up number of theoretical machine	Number of active machine	Number of Back up Machine	Lack number of machine	Excess machine	Number of broken machine
1	Cutting Machine	2.38	3	3	0	0	0	0
2	Milling Machine	2	2	4	0	0	2	0
3	Work Bench 1	1.72	2	2	0	0	0	0
4	Work Bench 2	1.72	2	2	0	0	0	0
5	Work Bench 3	1.72	2	2	0	0	0	0
6	Sandblast Room	1.86	2	1	0	1	0	0

It can be seen that there is a shortage for 1 sandblast room machine and the excess of 2 milling machines.

After making the comparison, it will be followed by calculating the area required based on the number of machines required theoretically totaling 3467 m<sup>2</sup>. Furthermore, calculating the cost of the transfer will be made of material that occurs in the production of the initial layout intended as a comparison with the cost of removal of material proposed layout plan.

Then the next step is made from to chart based on cost, from to chart inflow and outflow from to chart as the basis for manufacturing area relationship diagram. Here is the result of the creation inflow ARD, ARD outflow along with the degree of importance.

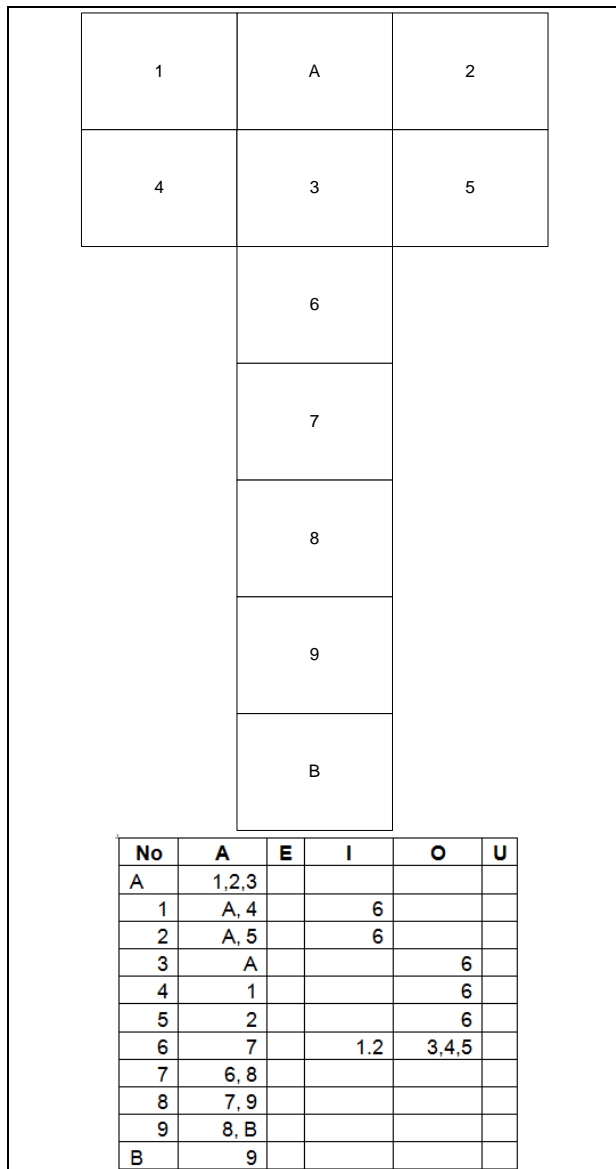


Figure 2 ARD Inflow

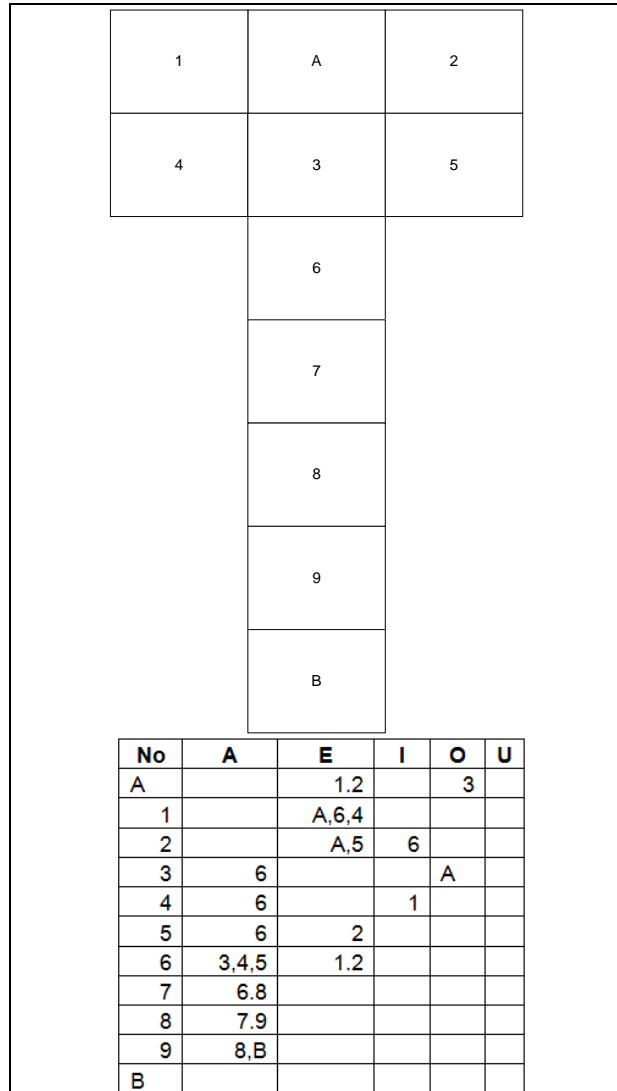


Figure 3 ARD Outflow

After making ARD based on *inflow* and *outflow*, then will continue making AAD for *inflow* and *outflow* with material movement calculation. Following picture is about figure of AAD *inflow* and AAD *outflow*.

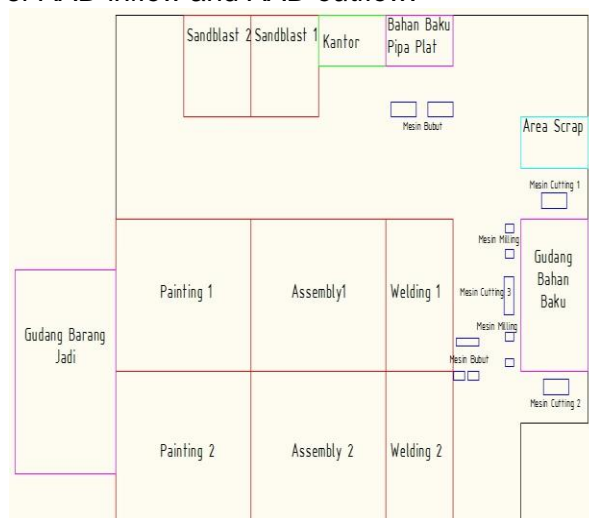


Figure 4 AAD inflow

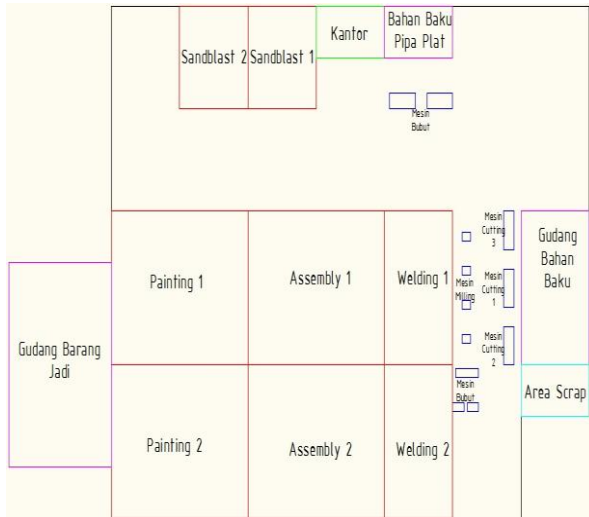


Figure 5 AAD outflow

Following table is comparison about cost material movement from the existing lay out with AAD inflow and AAD outflow.

Lay out type alternative	Movement Frequency per day	Total Cost Movement per day
Current MHPS	286	Rp 945.193,82
MHES Inflow	286	Rp 817.790,24
MHES Outflow	286	Rp 782.553,96

From above comparison table will obtain the information that material handling cost based on MHES outflow is more efficient than existing MHPS and MHES inflow or in other words calculating the *material handling cost* at MHES outflow result the small cost. Because of that, from this three lay out

alternatives will be chosen as the best lay out based on AAD outflow by PT Jasa Laksa Utama (Figure 6). The result will reduce the number of material handling cost Rp 162.639,86 compare to existing material handling cost. Following figure describe the new lay out based on AAD outflow.

#### 4. CONCLUSION

1. The Location of warehouse and cutting machine is too far, and location each cutting machine is separated too long.
2. Inefficient location between warehouse and cutting machine cause deviation in work processing map and reduce the productivity factory performance.
3. After relay out the location between warehouse and cutting machine will result the reducing material handling cost as Rp162.639,86.

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Attachment

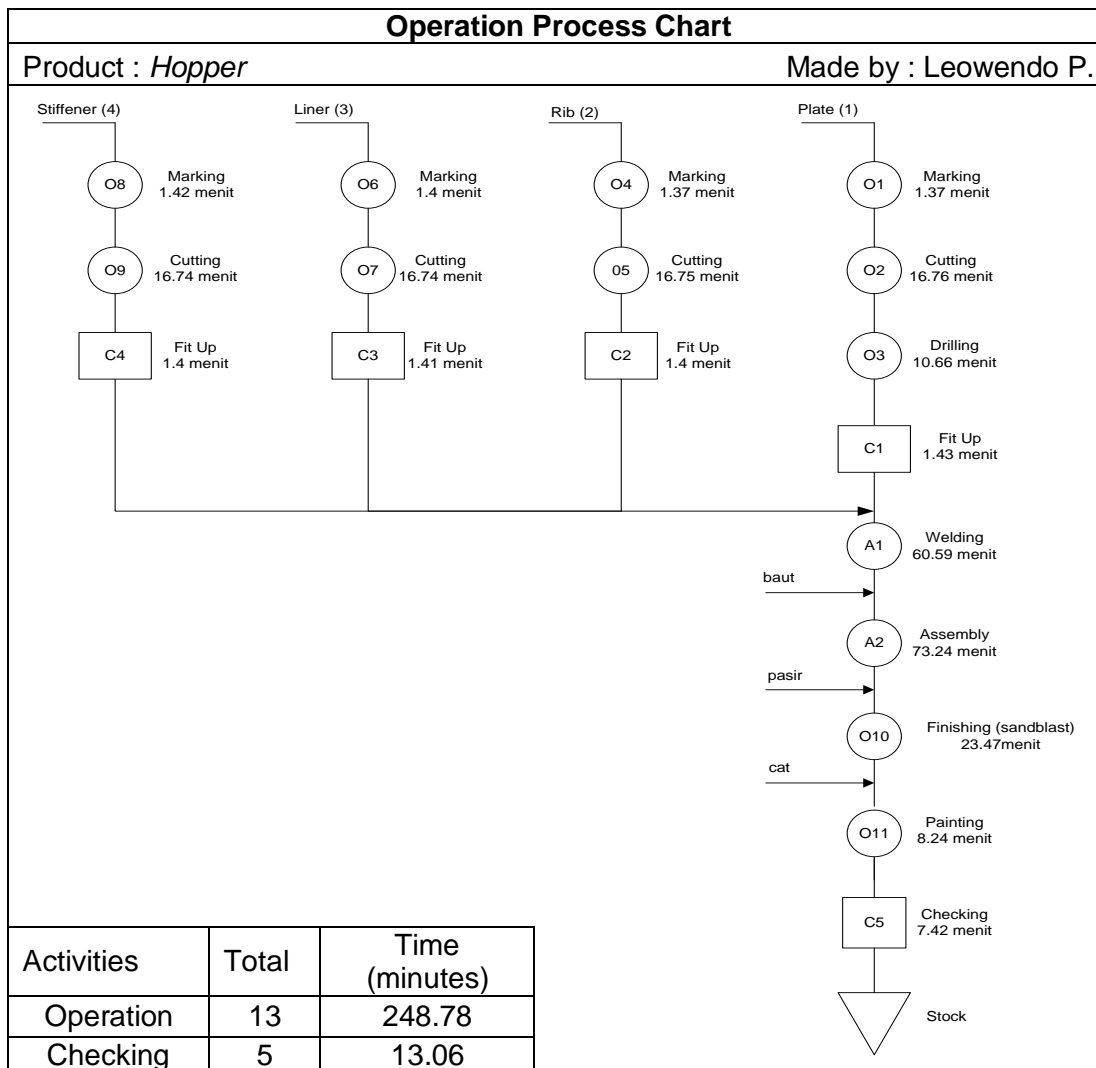


Figure.2 Peta Operation Process Chart for Hopper

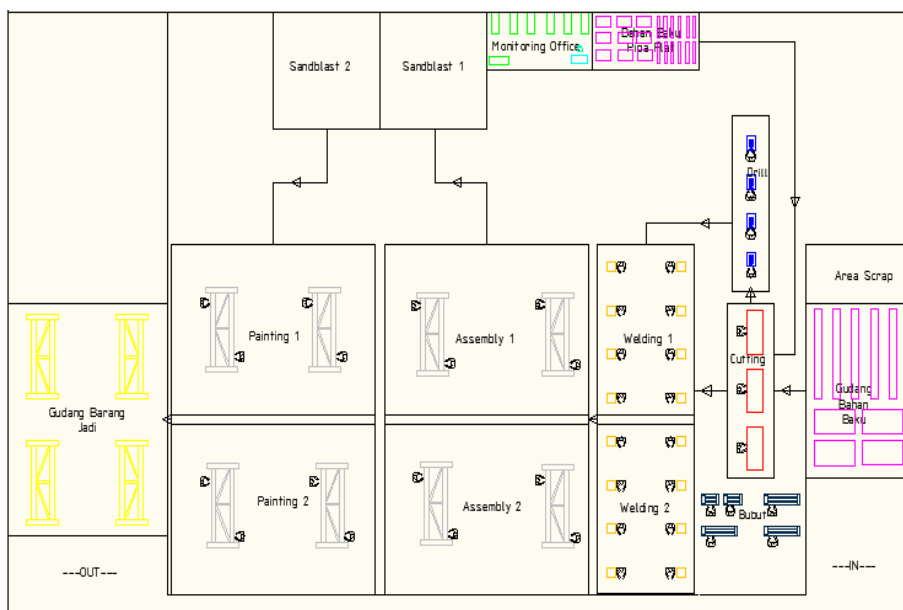


Figure 6 Plant lay out based on AAD Outflow