ANALISIS KESEIMBANGAN LINTASAN DAN KESELAMATAN KERJA PADA BAGIAN PRODUKSI DI PT HAKAYA INDOMAS II

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Abstract
The monetary crisis that happened in Indonesia since 1997 have not had a significant impact to Indonesian entrepreneurs especially the furniture exporters since the price of their products have become much higher even though the raw materials have been also very expensive. In order to survive and compete with other exporters which also running furniture business, it was needed to do analysis and improvement in the working processes. This paper is taking a case study in PT Hakaya Indomas II which is one of furniture-base companies that producing bedroom set. one of their family products is dresser. The company had a problem of inconvenient working condition such as hot temperature, dusty, noisy and dirty. It has been found that many workers unwilling to wear working costume and safety guard that have been prepared by the company. There was also another case occurred, such as lack of danger warning sign and unbalanced workers allocation which caused a bottle neck. Based on the problems, it has been done some proposed improvements and some of them have been successfully implemented. Some of the suggested improvements were that attaching the danger warning signs in some risky working areas, intensive usage of safety guard staffs, and intensively supervising the worker performance. To solve the unbalanced workers allocation in certain working elements and to reduce bottle neck, it has been proposed a new worker allocation and arrangement by using Line Balancing Method supported by Quantitative Systems Software. As a result, there was an arrangement of 32 working elements into 14 workstations and 6 doubled workstations. In addition, the amount of workers needed also has been reduced from 34 to 24 so that there was an efficiency of 10 persons. Finally, the balanced delay has also been reduced from 85.27802% to 16.74349% in the daily capacity of 48 set.

Keywords: Line Balancing Method, safety guard, danger warning signs, balanced delay

1 PENDAHULUAN

Untuk menghadapi persaingan yang semakin ketat, perusahaan harus mampu berproduksi secara efektif dan efisien. Suatu perusahaan dapat dikatakan berjalan dengan baik apabila dapat meningkatkan kualitas produk yang dihasilkan, memberikan ketepatan waktu pengiriman, dan menekan biaya produksi, sehingga memiliki harga yang bersaing. Seiring dengan perkembangan ilmu pengetahuan dan teknologi yang pesat maka kemampuan produksi dalam jumlah dan kualitas yang relatif tinggi dapat dicapai dalam waktu yang relatif singkat. Akan tetapi, hal ini juga meningkatkan resiko atau bahaya dalam bekerja. Oleh karena hal itu, maka perlu pula diperhatikannya keselamatan dan kenyamanan kerja.

PT. HAKAYA INDOMAS II adalah perusahaan manufaktur yang bergerak di bidang pembuatan bedroom set. Perusahaan ini ingin meningkatkan keselamatan dan kesehatan kerja pada karyawannya dan untuk mencegah terjadinya kecelakaan kerja, terutama di bagian pembahan. Jenis kecelakaan yang sering terjadi pada bagian ini adalah tangan operator sering terluka, karena pada bagian ini ada mesin potong, seperti mesin cut arm saw dan mesin cross cut sehingga diperlukan fasilitas yang memenuhi keselamatan kerja dimana harus memperhatikan keinginan operator sehingga suasana nyaman dan aman dapat tercipta.