

## ABSTRAK

Perusahaan Trafo adalah perusahaan yang bergerak dalam bidang industri manufaktur atau perakitan trafo tenaga (*Power Transformer*) bertegangan tinggi. Kondisi saat ini adalah proses pengerjaan produksi silinder *winding* 500 Kv masih relatif lama, khususnya pada proses pemasangan strip silinder, sehingga menyebabkan waktu operasi menjadi lama dan kurang produktif. Penyebabnya adalah belum adanya waktu standar target *output* yang jelas di setiap subproses produksinya. Salah satu cara mengetahui apakah suatu aktivitas produksi sudah berjalan dengan baik dan efisien adalah dengan pengukuran kerja. Pengukuran waktu standar dalam penelitian ini akan dilakukan dengan menggunakan metode *stopwatch* dan metode *Maynard Operation Sequence Technique (MOST)*. Berdasarkan hasil pengolahan data hasil pengukuran dengan metode *Stopwatch* diperoleh Waktu Siklus ( $W_s$ ) = 90.02 menit, Waktu Normal ( $W_n$ ) = 99.92 menit, Waktu Baku ( $W_b$ ) = 102.92 menit, kapasitas produksi/*output* per hari = 13 unit /hari. Sedangkan hasil pengukuran dengan *MOST* diperoleh Waktu Siklus ( $W_s$ ) = 80.20 menit, Waktu Normal ( $W_n$ ) = 80.20 menit, Waktu Baku ( $W_b$ ) = 82.61 menit, kapasitas produksi/*output* per hari = 16 unit /hari. Dari hasil analisa perhitungan waktu, baik waktu siklus, waktu normal serta waktu baku, bahwa dengan metode *MOST* menghasilkan pengukuran waktu standar yang lebih cepat dibandingkan dengan metode *stopwatch*. Metode yang direkomendasikan kepada perusahaan adalah penggunaan metode *MOST* karena perhitungan waktu standar/baku lebih cepat dan lebih produktif serta dapat memudahkan dalam penjadwalan *loading* produksi.

Kata kunci : Pengukuran Waktu, *Maynard Operation Sequence Technique (MOST)*, Waktu standar, *Stopwatch*.

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## **ABSTRACT**

*Transformer Company is a company engaged in manufacturing or assembling high-voltage Power Transformers. The current condition is that the production process of 500 Kv winding cylinders is still relatively long, especially in the process of installing cylindrical strips, causing long operating times and less productive. The reason is that there is no clear standard time for output targets in each production subprocess. One way to find out whether a production activity is running well and efficiently is by measuring work. Standard time measurements in this study will be carried out using the stopwatch method and the Maynard Operation Sequence Technique (MOST) method. Standard time measurements in this study will be carried out using the Maynard Operation Sequence Technique (MOST) method. Based on the results of data processing The measurement results with the Stopwatch method obtained Cycle Time ( $W_s$ ) = 90.02 minutes, Normal Time ( $W_n$ ) = 99.92 minutes, Standard Time ( $W_b$ ) = 102.92 minutes, production / output capacity per day = 13 units / day. While the results of measurements with MOST obtained Cycle Time ( $W_s$ ) = 80.20 minutes, Normal Time ( $W_n$ ) = 80.20 minutes, Standard Time ( $W_b$ ) = 82.61 minutes, production / output capacity per day = 16 units / day. From the results of the analysis of the calculation of time, both cycle time, normal time and standard time, that with the MOST method produces a standard time measurement that is faster than the stopwatch method. The recommended method for companies is the use of the MOST method because standard / standard time calculations are faster and more productive and can facilitate the scheduling of production loading.*

*Keywords : Time Measurement, Maynard Operation Sequence Technique (MOST), Standard time, Stopwatch.*

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