

ABSTRAK

Periode 2018-2019, terdapat beberapa *company policy* di PT. Aisin Indonesia Automotive yaitu, pendekatan ke jumlah *man power* minimum sesuai kebutuhan pada proses produksi dan transportasi. Hasil observasi menunjukkan pemborosan pada jumlah *man power material handling* di area *assembly unit plant*. Dari perbandingan *working hours standard* dengan *working hours actual* menunjukkan waktu menganggur sebesar 11,8 jam/hari. Jika nilai 1 *man power* adalah 7,3 jam/hari, maka terdapat pemborosan sebanyak 1 *man power material handling*. Perbaikan dilakukan dengan menunakan metode *Toyota Production System* dan *Line Balancing*. Setelah pebaikan, *working hours actual* sudah mendekati nilai *working hours standard* dengan waktu menganggur sebesar 2,95jam/hari yang artinya jumlah *man power* setelah perbaikan sudah mendekati jumlah *man power standard* karena selisih tersebut tidak lebih dari 7,3 jam/hari. Dari perbaikan yang telah dilakukan dapat mengurangi jumlah operator yang bekerja sebanyak 3 orang sehingga jumlah *man power* yang bekerja sebagai operator *material handling* di area *assembly unit plant* saat ini berjumlah 7 orang.

Kata kunci : *Line Balancing, Toyota Production System, Working Hours*

ABSTRACT

For the 2018-2019 period, there were several company policies at PT. Aisin Indonesia Automotive, approach to the minimum amount of man power needed in the production and transportation process. The results of the observations show the waste in the amount of man power material handling in the assembly unit plant area. From the comparison between standard working hours and actual working hours, it shows that unemployment time is 11.8 hours / day. If the value of 1 man power is 7.3 hours / day, then there is a waste of 1 man power material handling. Improvements are made using the Toyota Production System and Line Balancing methods. After the improvement, the actual working hours were close to the standard working hours with unemployment time of 2.95 hours/day, which means that the number of man power after the repair was close to the standard man power numbers because the difference was not more than 7.3 hours/day. From improvements before, it can reduce operators who work by 3 people so that the number of man power who work as material handling operators in the assembly unit plant area currently totals 7 people.

Key words : *Line Balancing, Toyota Production System, Working Hours*