

## Perhitungan Efisiensi Produksi Keadaan Awal

Cycle Time Minimum = 7,17 jam  
 Produksi / Bulan mak = 20,50

Efisiensi = 53.37%  
 Work Station = 13

No	W/C Code	Activity	Task Time	Station	Idle Time
1	A3724	Hoses	6.72	I	0.45
2	A3303	Control Valve			
3	A1102	Swing Frame 1	7.15	II	0.02
4	A3405	Floor Plate			
5	A1104	Swing Frame 2			
6	A1106	Engine	7.17	III	-
7	A1106	Swing Frame 3			
8	A1108	Swing Frame 4			
9	A1109	Swing Frame 5	5.33	IV	1.84
10	A1110	Swing Frame 6			
11	A2101	Base Frame	3.17	V	4.00
12	A4111	Docking, Fuel, Oil	2.62	VI	4.55
13	A4112	C/W & Testing			
14	A3613	Sub Boom	2.24	VII	4.93
15	A5614	Install Boom			
16	R1016	Steam Washing	1.50	VIII	5.67
17	R2017	Sanding	1.50	IX	5.67
18	R4019	Painting	3.20	X	3.97
19	R5020	Decall	3.40	XI	3.77
20	R6027	Install Cab	3.14	XII	4.03
21	R7022	Install Enclosure	2.61	XIII	4.56
<b>Total Task Time</b>			<b>49.75</b>		<b>43.46</b>

## PERENCANAAN WORK STATION - 7,17

Cycle Time Minimum = 7,17 jam

Efisiensi = 84.60%

Produksi / Bulan mak. = 20,50

No	Work Station	Time Remaining	Eligible Process	Assign Task		Idle Time
				Process	Time	
1	I	7.17	1,2,4,6,11,14	1	6.72	0.45
2		0.45	2,4,6,11,14			
3	II	7.17	2,4,6,11,14	2	3.10	
4		4.07	3,4,6,11,14	3	1.82	
5		2.25	4,6,11,14	4	2.23	
6	III	0.02	5,6,11,14			0.02
7		7.17	5,6,11,14	5	1.96	
8		5.21	6,11,14	6	0.85	
9		4.36	7,11,14	7	2.32	
10	2.04	8,11,14	8	2.04		
11	IV	0.00	9,11,14			0.00
12		7.17	9,11,14	9	2.28	
13		4.89	10,11,14	10	3.05	
14	1.84	11,14				
15	V	7.17	11,14	11	3.17	
16		4.00	12,14	12	2.80	
17		1.20	13,14			
18	VI	7.17	13,14	13	2.43	
19		4.74	14,15	14	2.19	
20		2.55	15	15	2.28	
21		0.27	16			
22	VII	7.17	16	16	1.50	
23		5.67	17	17	1.50	
24		4.17	18	18	3.20	
25	VIII	0.97	19			0.97
26		7.17	19	19	3.40	0.63
27	3.77	20	20	3.14		
28	IX	0.63				4.56
29		7.17	21	21	2.61	
<b>Total =</b>				<b>54.59</b>	<b>9.94</b>	