

ABSTRACT

CV. Iso Rubber is a semi-finished goods manufacturing company of compound that supplies compound to the consumer directly or become a supplier to the advanced company that makes the tyre intact. To produce a product in the form of a compound, this company conducts production activities that are compiled through a variety of production activities ranging from chemical weighing rubber weighing, Mixing, milling and cooling, forming and Cutting and end with packing. A company should increase its effectiveness and efficiency in the production process, so that the company is able to excel in certain areas compared to similar competitor companies, however, in CV. Iso Rubber has a problem that is Between the workload and the number of operators on the workstation. Caused by the lack of reality division of work on each workstation. So that the efficiency of production department CV. Iso Rubber can be said is very low. To overcome and increase the efficiency of the researcher, we strive to improve production department by performing workload measurement with full Time equivalent (FTE) method. From the initial calculation result with the number of workers 16 people obtained FTE value in the production Department of Chemical raw material weighing of 0.28 which means the workload underload, weighing rubber raw materials by 0.44 which means the workload Underload, a mixing of 1.98 which means overload workload, milling and cooling of 0.88 meaning underload workload, forming and cutting of 2.00 which means overload workload, and a packing section of 1.00 that It means a normal workload. After the proposed number of workers to 14 workers with the recalculation of FTE values in which the chemical raw materials weighing parts & rubber, mixing, milling and cooling, forming and cutting, packing with the number of workers Overall have FTE value of 1.18, 1.09, 1.07, 1.09, 1.00 which are all belonging to the normal workload. And there is an increase in the FTE balance value about 10.89% which was originally 52.72% to 67.39. And for production trajectory there was an increase in the line efficiency value from 46.17% to 50.67% and a decrease in idle time from 2594.83 seconds to 1945.28 seconds, decreasing the balance delay from 53.82% to 49.33% as well as the Smoothnes index value of 1154.88 of 919.

Keywords: CV. Iso Rubber, workload, Full Time Equivalent, production track

