

## THE PROPOSED LAYOUT DESIGN USING FACTORY SYSTEMATIC LAYOUT PLANNING METHOD AT PT. JASA LAKSA UTAMA

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### ABSTRACT

*PT. Jasa Laksa Utama is a manufacturing company that produces conveyors for material handling in mining coal industry. The great development in this similar industries that cause emerging PT. Jasa Laksa Utama to continue expanding in order to enhance productivity and effectiveness to meet the desires and customer satisfaction. But things happen in the real situation are still barriers that prevent optimal productivity of the company. This is because they lack of good plant layout that exist today, especially in the production. Using Systematic Layout Planning methods based on the comparison of the calculation of the Material Handling Planning Sheet (MHPS) initial plant layout with Material Handling Evaluation Sheet (MHES) proposed layout would be advised to the company. It is expected that the proposed plant layout design can better lead to increased productivity and efficiency of the PT. Jasa Laksa Utama.*

**Key words:** Systematic Layout Planning, Material Handling Planning Sheet (MHPS), Material Handling Evaluation Sheet (MHES).

### 1. INTRODUCTION

PT. Jasa Laksa Utama is one of the manufacturing company that producing a material control, namely the manufacture of conveyor which focused on the removal of coal. To remain competitive and produce products in accordance with the desires of consumers, these companies should have the line of the production process effectively and efficiently.

PT. Jasa Laksa Utama required layout in accordance with the process of working to achieve the production process, because during the production process running on PT. Jasa Laksa Utama assessed as having shortages caused by the process of repetition that does not comply with the order of the production process.

In this research, data collection will be cycle time, operation mapping, routing sheet, MPPC (multi-product process chart), calculate area, MHPS calculation (material handling planning sheet), followed by the processing of data, such as the manufacture of FTC (from to chart), ARD (area relationship diagram), AAD (area allocation

diagram), MHES (evaluation sheet material handling), and manufacturing layouts to support systematic layout planning aimed at proposing improvements in the production plant layout.

### 2. THEORETICAL BACKGROUND

The layout is a major cornerstone in the industrial world. Factory layout can be defined as a procedure for setting the factory facilities to support the smooth production process. In general, the layout of a well-planned plant will also determine the efficiency and in some cases will also maintain the viability or success of the industry's employment.

Plant Lay Out Method

#### 1. Form To Chart

From To Chart is sometimes also referred to as trip frequency chart or travel chart is a commonly used conventional techniques for factory layout planning and material movement in a production process is very useful technique for the conditions in which a lot of items that flow through the area such as job shop, machining workshop, office

and others. From to chart will show the total of the weight of the load to be moved, the material displacement distance, volume or combinations of these factors.

2. Activity Relationship Diagram  
Activity relationship diagram is a block diagram showing the relationship approach activity, which shows each activity as a single activity model (no suppression chamber).
3. Making Area Allocation Diagram  
Area Allocation Diagram is a tool that is closest to the actual layout of the plant, which will make the allocation of facilities in activities such as the production plant, office, plant service, warehouses and dormitories and other facilities.
4. Preparation of Material Handling Evaluation Sheet  
It is a calculation sheet that will result in the total costs required to transfer each material on the production floor.
5. The depiction of a New Map Of The Production Department  
Making a depiction in accordance will result the analysis of the AAD to be proposed as a design improvement.

**3. DATA PROCESSING AND ANALYSIS**

Processing begins to test the adequacy and uniformity of data from each process that occurs in the production to get the standard time. After obtaining the time process then will be continued by making a map of operating process, manufacturing process flow chart and making routing sheet (calculating the number of machines). The next sheet is a table comparing the number of machines needed in theoretical and actual number of machines (Table 2).

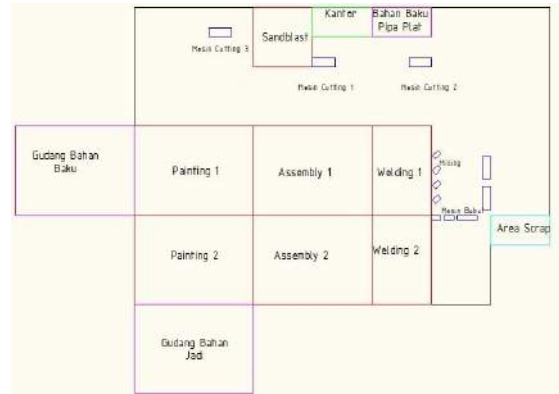


Figure 1 : Beginning Lay out of the factory

Table 1. Multi Product Process Chart for Hopper

| Nama proses   | Shell | Rib   | Liner | Stiffener | Jumlah mesin teoritis |
|---------------|-------|-------|-------|-----------|-----------------------|
| Raw material  | (S1)  | (S2)  | (S3)  | (S4)      | -                     |
| Marking       | (O1)  | (O4)  | (O6)  | (O8)      | -                     |
| Cutting       | (O2)  | (O5)  | (O7)  | (O9)      | 3                     |
| Drilling      | (O3)  |       |       |           | 2                     |
| Fit Up        | (C1)  | (C2)  | (C3)  | (C4)      | -                     |
| Welding       | (A1)  | (A1)  | (A1)  | (A1)      | 2                     |
| Assembly      | (A2)  | (A2)  | (A2)  | (A2)      | 2                     |
| Finishing     | (O10) | (O10) | (O10) | (O10)     | 2                     |
| Painting      | (O11) | (O11) | (O11) | (O11)     | 2                     |
| Checking      | (C5)  | (C5)  | (C5)  | (C5)      | -                     |
| Fiinish goods | (S5)  | (S5)  | (S5)  | (S5)      | -                     |

Tabel 2. Number of Lack, Excess and broken machine

| No | Machine Name    | Number of Theoretical Machine | Rounding Up number of theoretical machine | Number of active machine | Number of Back up Machine | Lack number of machine | Excess machine | Number of broken machine |
|----|-----------------|-------------------------------|---|--------------------------|---------------------------|------------------------|----------------|--------------------------|
| 1  | Cutting Machine | 2.38                          | 3   | 3                        | 0                         | 0                      | 0              | 0                        |
| 2  | Milling Machine | 2                             | 2   | 4                        | 0                         | 0                      | 2              | 0                        |
| 3  | Work Bench 1    | 1.72                          | 2   | 2                        | 0                         | 0                      | 0              | 0                        |
| 4  | Work Bench 2    | 1.72                          | 2   | 2                        | 0                         | 0                      | 0              | 0                        |
| 5  | Work Bench 3    | 1.72                          | 2   | 2                        | 0                         | 0                      | 0              | 0                        |
| 6  | Sandblast Room  | 1.86                          | 2   | 1                        | 0                         | 1                      | 0              | 0                        |

It can be seen that there is a shortage for 1 sandblast room machine and the excess of 2 milling machines.

After making the comparison, it will be followed by calculating the area required based on the number of machines required theoretically totaling 3467 m<sup>2</sup>. Furthermore, calculating the cost of the transfer will be made of material that occurs in the production of the initial layout intended as a comparison with the cost of removal of material proposed layout plan.

Then the next step is made from to chart based on cost, from to chart inflow and outflow from to chart as the basis for manufacturing area relationship diagram. Here is the result of the creation inflow ARD, ARD outflow along with the degree of importance.

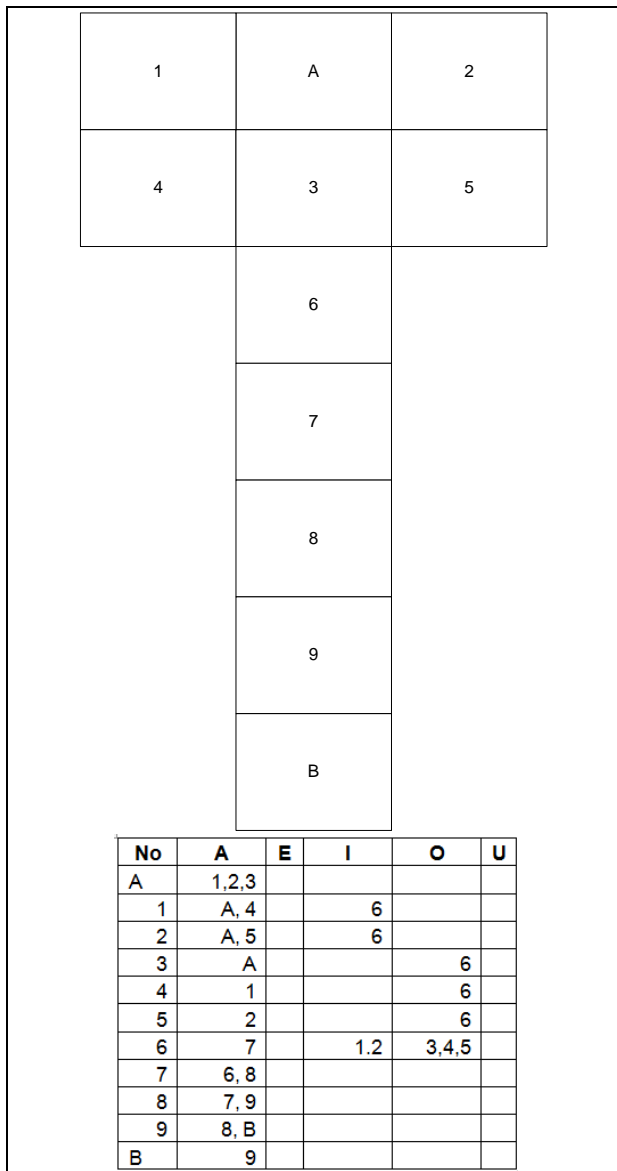


Figure 2 ARD Inflow

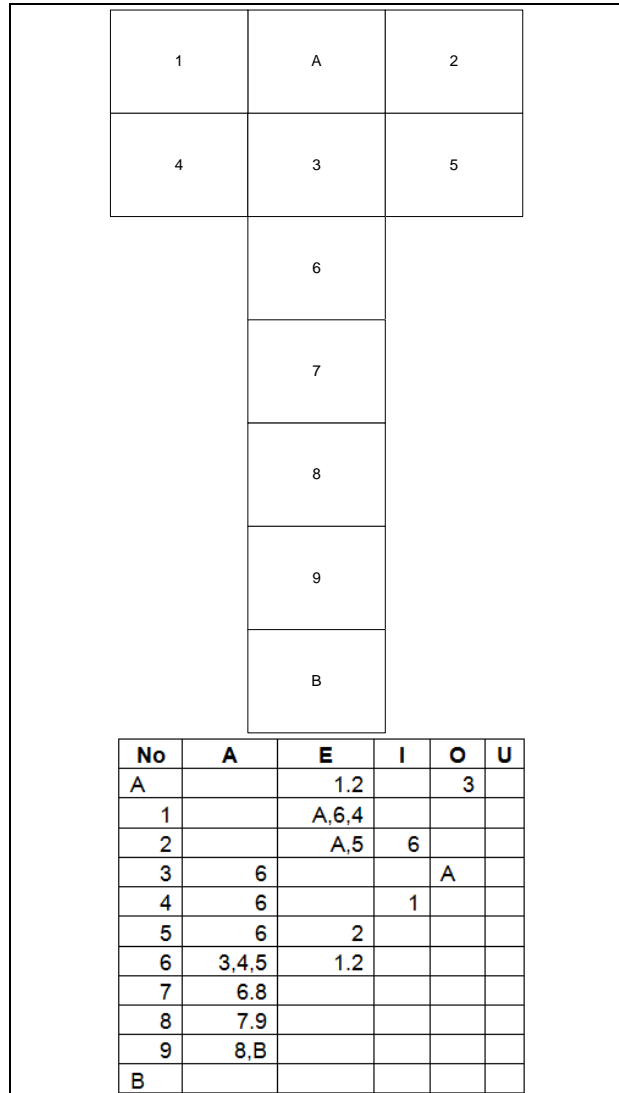


Figure 3 ARD Outflow

After making ARD based on *inflow* and *outflow*, then will continue making AAD for *inflow* and *outflow* with material movement calculation. Following picture is about figure of AAD *inflow* and AAD *outflow*.

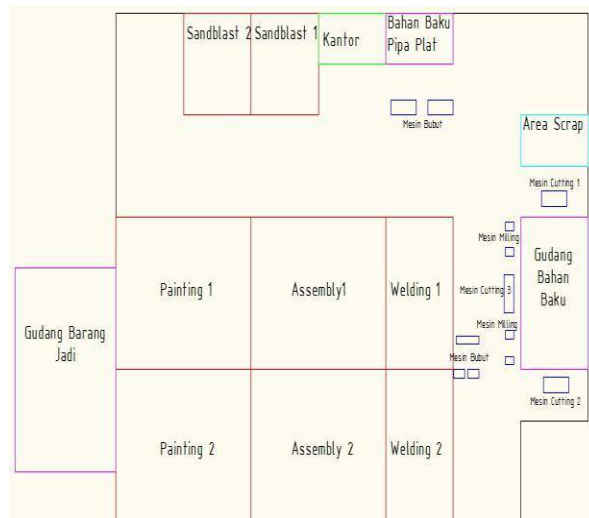


Figure 4 AAD inflow

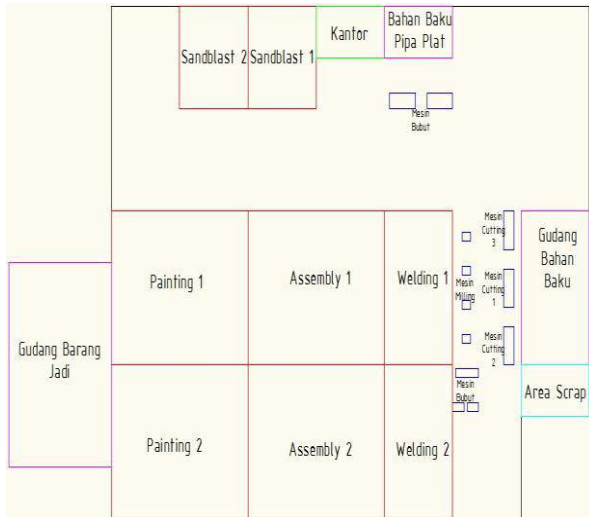


Figure 5 AAD outflow

Following table is comparison about cost material movement from the existing lay out with AAD inflow and AAD outflow.

| Lay out type alternative | Movement Frequency per day | Total Cost Movement per day |
|--------------------------|----------------------------|-----------------------------|
| Current MHPS             | 286                        | Rp 945.193,82               |
| MHES Inflow              | 286                        | Rp 817.790,24               |
| MHES Outflow             | 286                        | Rp 782.553,96               |

From above comparison table will obtain the information that material handling cost based on MHES outflow is more efficient than existing MHPS and MHES inflow or in other words calculating the material handling cost at MHES outflow result the small cost. Because of that, from this three lay out

alternatives will be chosen as the best lay out based on AAD outflow by PT Jasa Laks Utama (Figure 6). The result will reduce the number of material handling cost Rp 162.639,86 compare to existing material handling cost. Following figure describe the new lay out based on AAD outflow.

#### 4. CONCLUSION

1. The Location of warehouse and cutting machine is too far, and location each cutting machine is separated too long.
2. Inefficient location between warehouse and cutting machine cause deviation in work processing map and reduce the productivity factory performance.
3. After relay out the location between warehouse and cutting machine will result the reducing material handling cost as Rp162.639,86.

#### 5. REFERENCE

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Attachment

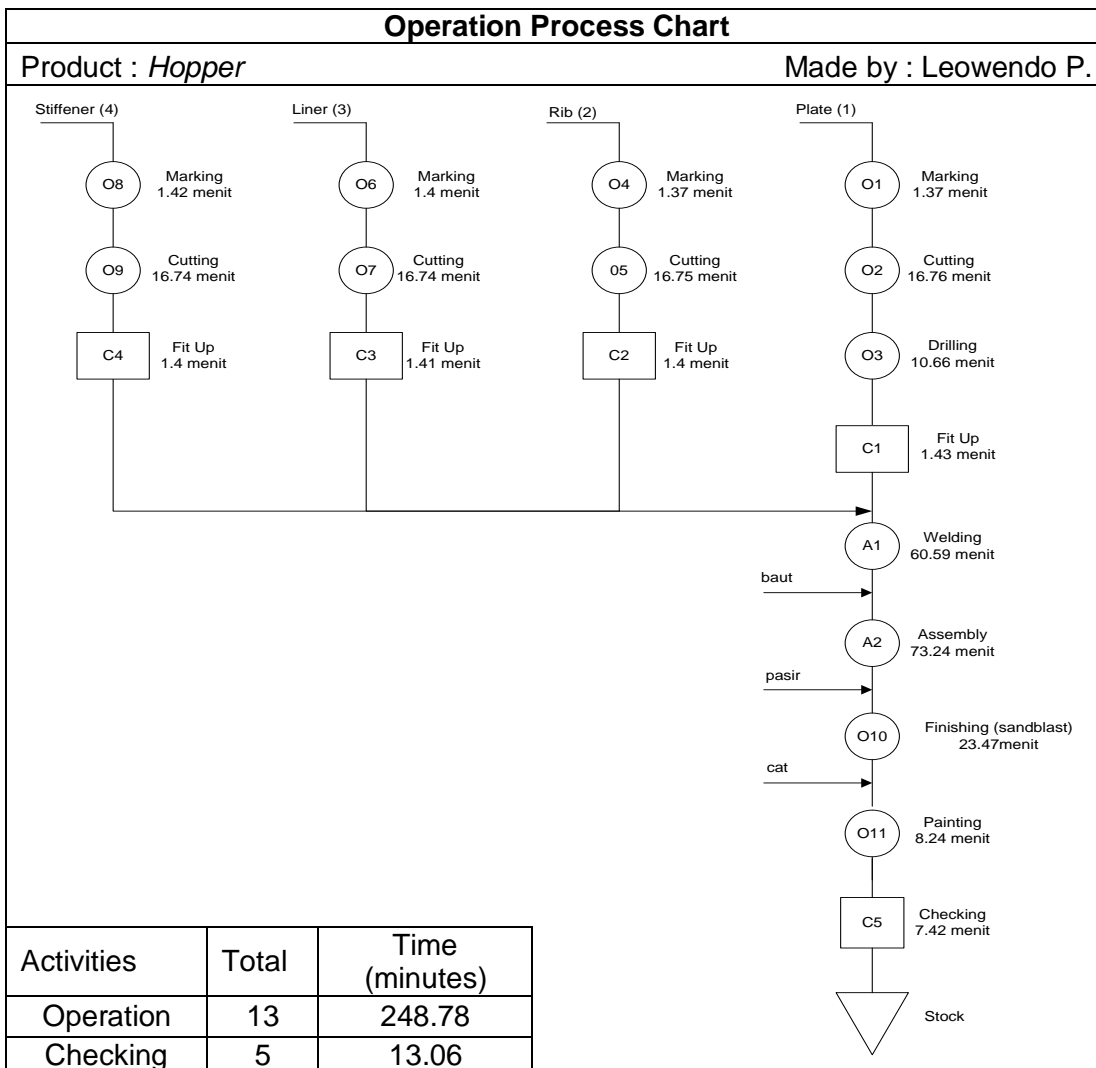


Figure.2 Peta Operation Process Chart for Hopper

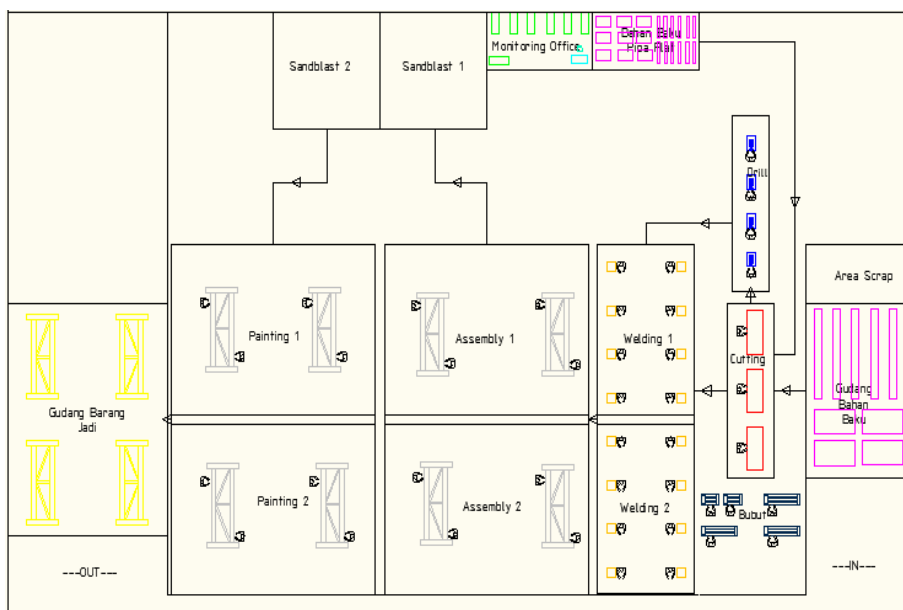


Figure 6 Plant lay out based on AAD Outflow