Abstract

The high efficiency of the production line and time efficiency of the production process to determine the extent of production owned by the company. This study was conducted to improve the processing time employee in completing the work by using the Methods Time Measurement (MTM). Movement is less efficient work can be eliminated so that the time to complete a job becomes shorter. In addition, the line carried a balance Ranked Positional Weights method that can balance the workload so that the efficiency of the production line Assembling Line B on the Main line can be increased. The results showed an increase of increase of 2.03% on the movements of the operator and increase the efficiency of production lines by 1.65% due to workload balancing so that the reduced number of work stations by 7 work station work station was originally numbered 66 to 59 work stations. The high efficiency of the production line, the higher the level of productivity.

Keywords: production lines, movement work, enhancement, efficiency