

ABSTRAK

Salah satu sumber daya yang berperan penting dalam kegiatan produksi yaitu pekerja. Pekerja berperan secara langsung dalam keberlangsungan proses produksi, oleh karena itu perlu mendapatkan perhatian agar proses produksi dapat berjalan dengan optimal. Salah satu upaya yang dapat dilakukan yaitu dengan memberikan beban pekerjaan sesuai dengan kemampuan pekerja. CV. Daya Reksa Presindo merupakan salah satu perusahaan yang beroperasi dalam membuat *spare part* motor yaitu *Stay Side Cover*. Saat ini perusahaan memiliki 10 operator untuk memproduksi *Stay Side Cover*. Kegiatan produksi *Stay Side Cover* mengalami permasalahan yaitu tidak tercapainya target permintaan pelanggan. Meskipun perusahaan saat ini menerapkan jam kerja lembur, akan tetapi masalah tersebut belum dapat terselesaikan. Penelitian ini dilakukan untuk mengetahui tingkat waktu produktif pekerja, tingkat beban kerja fisik, serta merancang kebutuhan operator optimal pada proses produksi *Stay Side Cover*. Metode yang digunakan yaitu metode *Work Sampling* dan *Work Load Analysis (WLA)*.

Hasil penelitian menunjukkan bahwa persentase waktu produktif terbesar didapatkan sebesar 88% (operator *Blank-piercing* dan *Bending-1*) sedangkan persentase waktu produktif terendah sebesar 45% untuk operator transportasi. Terdapat 8 operator dengan nilai beban kerja fisik diatas 100% (operator *shearing*, *Blank-piercing*, *Bending-1*, *Bending-2*, dan *Final Inspection dan Packing*). Sementara 2 operator lainnya yaitu operator pemisahan nilai beban kerja fisik sebesar 93% dan operator transportasi sebesar 66%. Berdasarkan hasil rancangan kebutuhan operator optimal diperoleh hasil yaitu perlu dilakukan penambahan 2 orang operator serta dilakukan pembagian ulang aktivitas kerja.

Kata Kunci: beban kerja fisik, *work load analysis*, *work sampling*

ABSTRACT

One of the resources that has an important role in production activities is workers. Workers play a direct role in the sustainability of the production process, therefore it needs to get attention so that the production process can run optimally. One effort that can be done is to provide workloads in accordance with the ability of workers. CV. Daya Reksa Presindo is one of the companies that operates in making motorcycle spare parts namely Stay Side Cover. The company currently has 10 operators to produce Stay Side Cover. Stay Side Cover production activities experienced a problem that is not achieving the target customer demand. Even though the company currently applies overtime hours, the problem cannot be solved yet. This research was conducted to determine the level of productive time of workers, the level of physical workload, and to design optimal operator needs in the production process Stay Side Cover. The method used is the Work Sampling and Work Load Analysis (WLA) methods.

The results showed that the highest percentage of productive time was 88% (Blank-piercing and Bending-1 operators) while the lowest percentage of productive time was 45% for transportation operators. There are 8 operators with physical workload values above 100% (shearing, Blank-piercing, Bending-1, Bending-2, and Final Inspection and Packing operators). While the other two operators, namely the separation of physical workload value operators by 93% and transportation operators by 66%. Based on the results of the design of the optimal operator needs obtained results that need to be added by 2 operator and the redistribution of work activities.

Keywords: physical workload, work load analysis, work sampling