

ABSTRACT

The problems that often appear in any of the factory unit is the lack of production from the target of company. Occurs due to lack of balance in the workload of work stations, so that the bottleneck at the work station.

In this research, carried out repair work on the track system packaging unit in PT Sanbe Farma LVP Sterile Preparation Plant is felt still experience problems in balancing track. It can be inferred from the lack of production of the target company in a work shift is 250 boxes where each box contains 24 softbag. On the conveyor 1 and shelter automatic leak tester is included with the packaging can be the bottleneck that is characterized by the accumulation of soft bags are waiting in line to be processed by a work station in front of him. It can also be seen sharing the workload is still uneven, where it can be seen clearly by the operator on the observation that many unemployed while on the other hand, there are operators who work non-stop as the operator visual inspection and automatic leak tester operator . In addition to the above two can be seen also that the long production cycle times caused by the distance between the stations far enough. The data used is the operator and the entity processing time and distance per unit of packaging machinery from PT Sanbe Farma. Data were processed using a komputer simulation method using the software ProModel 2001. Based on the results of processing, using komputer simulation methods can increase production from eksisting enterprise systems. Haltersebut seen from the increased production of 194 boxes increased to 239 boxes, 45 boxes more than the eksisting system..

Keyword: Workload Balance, Bottleneck, ProModel, 2001, Komputer Simulation