

ABSTRACT

PT. Foximas Mandiri is a shoes manufacturing company in the field that have a market domestic and international. At this time, PT. Foximas Mandiri has not fulfilled all received orders. There is a time delay transfer of materials and layout that is not optimal, causing the material to high handling costs.

In this research using the method of General Analysis Procedure as a framework to solve the main problems at the company. Data processing for material handling systems design using the proposed Activity Cost Determination. Activity Cost Determination is a method for defining a movement activity converted into movement costs.

The result of design improvement of material handling systems shows that the design improvement is more efficient system. It can be seen from the total waiting time and transport decrease about 91.22% and 42.62% . Material handling equipment support changes from wooden pallet to plastic pallet with leasing system, and the result is the price decrease about 4%. Material handling cost calculation using the Activity Cost Determination proposal obtained material handling costs decreased by 13.58%.

Keywords: *Material Handling, General Analysis Procedure, Unit load, Bottleneck*