

## **ABSTRACT**

*PT. Perkebunan Nusantara VIII. Ciater is one of the state-owned (State-Owned Enterprises) company operating in the plantation sector throughout Indonesia. In one of the process of making tea powder in PT. Perkebunan Nusantara VIII. Ciater is in the packing process carried out the policy of storing tea powder in a tilt before the packing process. This resulted in the retention policies idle time and idle time in the packing process. In the existing condition of storage process resulted in idle time 164008.07 minutes, balance delay 85.63%. line efficiency 14.37. smoothest index 66956 for packing process of tea powder BOP I as sample by using 4 operators. In order to achieve the purpose of minimizing the idle time in the packing process it is proposed to use a mixed model, that do the packing process without doing tea powder storage. The resulting tea powder will be directly inserted into the packing process. After changing the packing process by removing the inclined chest using mixed model and generate idle time 940.70 minutes. balance delay 30.78%. line efficiency 69.22. smoothest index 678 and packing roses are done sequentially based on the working time of each tea powder using 1 operator.*

*Keywords : Mixed Model. Idle Time. Balance Delay. Line Efficiency. Smoothest Index*