

## ABSTRACT

*Observations made on the bread industry of MEKAR SARI 99 Bakery showed that in the baking activity of the oven, the oven operator complained about the parts of the body that were sick as a result of the work and fatigue that arose after the activity in the oven. That is because the posture is not ergonomic on the activity of inserting and removing the baking pan into the oven. After analyzing using Nordic body maps, pain results dominated the results of the questionnaire recapitulation, which was 37.50%, ranked second, which was pains by 32.14%, ranked third, which was rather painful by 25%, and finally was feeling very sick by 3.57%. This shows that the two workers who worked at the roasting process work station experienced many complaints of pain in the body. Body posture analysis of roasting oven operators by using REBA calculation, the final value is +11 and the bread pan transfer operator is +9. This value indicates that the activity of inserting and removing the pan in the oven has a very high risk and must immediately apply changes and has a high risk and must immediately apply changes.*

*To overcome these problems, we need a working tool in the process of moving the baking pan. The aim is to improve posture and reduce the workload experienced by operators using ergonomics analysis. The analysis shows that after using the proposed to improve the operator's working conditions and increase productivity, a REBA value of +3 is obtained. This value indicates that the resulting risk is low, changes may be needed. For RWL value, the decision shows a decline from RWL value, where the existing condition has RWL value of 1.24. After using the proposal, the RWL value becomes 0.947, so that the transportation conditions fall into the safe category.*

**Keywords:** MEKARSARI 99 BAKERY, EASNE, REBA, RWL, Ergonomis.