

ABSTRACT

With varied type and quantity of velg that have to be produced PT Pakoakuina, and with many process that have to be throughout for a kind of product, because of that, it needs some functionable tools in balancing quantity and variation product type that have been produced. Heijunka, in this case, contain worktime, production quantity per day, and quantity that have to be produced per day, so that can increase the efficiency and effectiveness of working. Heijunka is also considering time arrival of the truck that contain velg which will be deliver to the warehouse, worktime that be used in heijunka ddedided slot is worktime of Kanban Boy which to know responsibilities of working, based on the activity it did. From the result of operating file that exist, it because the balancing of quantity from the velg that exist.

Based from the counting and (pengolahan) files that exist, we can get the equal slot from heijunka pst PAKO 1 is 60 slots, it based from the worktime of kanban boy and time cycle from every velg that exist, for PAKO 1 KPK (smallest (kelipatan persekutuan)) is 6, it is used as based in deciding how many slots with (nilai/perhitungan) : $n \times \text{KPK}$. By seeing the worktime of kanban boy that 20.3 minutes, so that can be decided the time of (pengambilan) with $n=2$. And we can get the average (selang) waktu process is 21.5 minutes. For PAKO 2, with score of $\text{KPK}=3$ then the time that we can get is 38.33 minutes, based on overall worktime of kanban boy , the time that should be used is 32.85 minutes, it is because, the time that needed by the kanbay boy is 30.23 minutes.

Heijunka is also functioned in minimalize the inventory based on the arrival time and the departure of the truck, it is seemed that in one day, for the (persediaan) that only need 1537 units spaces. With this matter, then it can decrease the production cost that exist. It is on the making the warehouse, so that the profit margin of the company will be nicely increase.