

ABSTRACT

PT. Multi Rezekitama is the company that active in manufacture especially production paint and stationery. Free and global competition claim PT. Multi Rezekitama for more improving its company competitiveness in order not to be shoved aside by business competition. PT. Multi Rezekitama face internal matter in production time efficiency issue, where existence of work that cannot be done on time that have been promised to costumer and its causing low production time efficiency.

Looking from the real condition, so we have to make a new production process proposal to increase the company performances so that the company can give the service more properly to customer. To get a sketch of the existing production process and also to a new improvement, the first step of improvement is understanding the production process existing and measurement of cycle times along with its efficiency. From the data, later then it will be analyzed by considering aspect of human resource, technology and facility and also the work environment.

The Improvement proposal are compose based on the activity analysis and streamlining so that we will have a better efficiency value than the existing condition. Improvement proposal of production process which have been compose to analysis that has conducted, give the new changes to production process existing, and give influences to increase the efficiency value, effectiveness and also process adaptabilities.

Following table is comparison data of the existing and proposal of production process.

PROSES	SUB PROCESS	Existing			Proposal			Cycle Time Efficiency		% Increasing of Efficiency
		RVA	BVA	NVA	RVA	BVA	NVA	Existing	Proposal	
Pra Produksi	Ekspedisi	57.575	12.602	5.505	57.575	6.381		0.7607	0.9002	15.49
	Staf dan administrasi	37.43	4.012	4.502	31.635	4.012		0.8147	0.8875	8.20
Produksi	Milling	35.385	0.894	10.24	34.385	0.563		0.7607	0.9839	22.69
	Mixing	830.83	0.245	9.15	829.7	0.245		0.9888	0.9997	1.09
Finishing	Filtering	26.169	7.42		25.162	3.71		0.7791	0.8715	10.60
	Scalling, Packing Handling	12.433	1		6.793	0.5		0.9256	0.9314	0.63
Average								0.8383	0.9290	9.784

From the table we can see the improvement that have done can make a throughput time descent. Milling have the highest throughput time descent around 22.69 %.