

## ***ABSTRACT***

*PT Kartika Naya is a printing, packaging and photo album creation. For now, the PT Kartika Naya not yet able to fulfill all the incoming request. From the results of the observations made, there are some problems on the production floor PT Kartika Naya. Problems include:*

- 1. This is reinforced by the occurrence of a data queue and the time delay transfer of material causing the material to high handling costs*
- 2. Non optimal use of Material Handling Equipment.*

*In this study used General analysis procedure as a framework for resolve problem, in which there are core data processing using the Activity Cost Determination. Activity Cost Determination is a method for defining each displacement activity displacement is converted to cost.*

*The results of the redesign has resulted in material transfer system with a flow displacement system more efficient. It can be seen from some of the things, the first decline in total waiting time ranges about 62% - 75% to the bottlenecks on the production floor would indirectly down. Second, material handling costs reduced by 42% of the total cost of the displacement of existing systems. Besides other proposal is to use plastic pallet savings after a lease is for 10% of the cost of existing pallet and plastic pallet use material that can carry up to 800 kg to compensate for the displacement capacity of the primary tool material.*

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