

ABSTRACT

PT. Bintang Kanguru is a textile manufacturing company in the field with a market share of some countries in Asia. In the last seven years of production at the company is recorded a decline of 10-25 percent. This is reinforced by the occurrence of a data queue and the time delay transfer of material causing the material to high handling costs. Parameters are used as a benchmark the proposed planning system are the minimization of material displacement movement of the time, waiting time and cost of material handling.

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 from 80% to the bottlenecks on the production floor would indirectly down. Both reduced material handling costs by 12% of the total cost of the displacement of existing systems. Besides other proposal is to use plastic pallets savings after a lease is for 9% of the existing pallette and additional design on the original box support manual capacity 400 kg to 800 kg in order to compensate for the displacement capacity of the tool material.

Keywords: *Material handling, General analysis procedure, Bottleneck*