

## ABSTRACT

*This final project discusses assembly scheduling one of component CN-235 aircraft specifically Outboard Flap in PT. Dirgantara Indonesia. This component has been assembly scheduling by the company using controlling tool be n the form of bar chart.number of worker in Outboard Flap CN-235 assembly department now have a four mechanic with one leader. The current problem is request from program manager that want the assembly of Outboard Flap CN-235 has been finish more faster than using time in barchart. Leader of assembly Outboard Flap hard to make decesion in assembly line. Therefore need some measurement about new time standar in bar chart and strategy increased production leves using control labor.*

*First step is measure cycle time from every work elements with notice the adaption and allowance of labor processed into a new standard in bar chart then identify every work element that can be accelerated the time process. The application of the principle of Shojinka for increase and controlling the labor when fluctuations demand used to accelerated the standard time of work elements.there is three scenario of controlling labor, which the first using 4 mechanic, 6 mechanic, and 8 mechanic.Increasing the number of mechanic from each of scenarios accelerate compeletion time than the current state that is equal to 21,23% for using 4 mechanic, 36,65% for using 6 mechanic, and 44,90% for using 8 mechanic or 8 days/unit for 4 mechanic, 7 days/unit for 6 mechanic, and 7 days/unit for 8 mechanic.*

*Key Words : bar chart, standard time, control labor, Shojinka, completion time*