

ABSTRAK

Waktu baku merupakan waktu kerja dengan penambahan faktor penyesuaian dan faktor kelonggaran sebagai waktu untuk menyelesaikan pekerjaan, dimana seorang pekerja telah memiliki tingkat kemampuan rata-rata. Tujuan penelitian adalah menentukan waktu baku dan menentukan kebutuhan tenaga kerja sesuai produksi perhari pada proses penanganan jambu kristal. Penelitian ini menerapkan metode *direct stop-watch time study* dan *work sampling* dengan *sampel* pengamatan yang digunakan adalah 25 pcs jambu kristal. Proses penanganan jambu kristal di *Packing House Guava* adalah *bag removing, netfoam removing, penducle cutting, dipping*, penirisan, seleksi *grade, netfoaming, wrapping, labelling* dan *packer*. Hasil waktu baku keseluruhan proses pada *shift A* adalah 11 menit dan *shift B* adalah 12 menit. Waktu baku 1 box jambu kristal pada *shift A* dengan *grade A* (23 menit), *grade B* (26 menit) dan *grade C* (47 menit). Waktu baku 1 box jambu kristal pada *shift B* dengan *grade A* (24 menit), *grade B* (27 menit), dan *grade C* (49 menit). Hasil penentuan kebutuhan tenaga kerja total pada *shift A* dengan produksi 1.024 krat (58 orang), 1.131 krat (64 orang), 1.208 krat (69 orang), 1.311 krat (71 orang), 1.403 krat (79 orang) dan 1.534 krat (83 orang). Hasil penentuan kebutuhan tenaga kerja total pada *shift B* dengan produksi 973 krat (58 orang), 1.121 krat (66 orang), 1.201 krat (71 orang), 1.301 krat (76 orang), 1.425 krat (82 orang) dan 1.583 krat (91 orang).

Kata Kunci : *Jambu Kristal, Studi Waktu, Waktu Baku*

ABSTRACT

Standard time is working time with the addition of adjustment factors and allowance factors as time to complete work, where a worker already has an average level of ability. The purpose of this research is to determine the standard time and determine the need for labor according to the production per day in the crystal guava handling process. This research applies a direct stop-watch time study and work sampling with sample observation. The crystal guava handling process at Packing House Guava is bag removing, netfoam removing, penducle cutting, dipping, draining, grade selection, netfoaming, wrapping, labeling and packer. The result of the standard time of the entire process on shift A is 11 minutes and shift B is 12 minutes. The standard time is 1 box of crystal guava on shift A with grade A (23 minutes), grade B (26 minutes) and grade C (47 minutes). The standard time is 1 box of crystal guava on shift B with grade A (24 minutes), grade B (27 minutes), and grade C (49 minutes). The results of determining the total workforce requirement in shift A with production of 1,024 crates (58 people), 1,131 crates (64 people), 1,208 crates (69 people), 1,311 crates (71 people), 1,403 crates (79 people) and 1,534 crates (83 people). person). The results of determining the total workforce requirement in shift B with production of 973 crates (58 people), 1,121 crates (66 people), 1,201 crates (71 people), 1,301 crates (76 people), 1,425 crates (82 people) and 1,583 crates (91 people). person).

Keywords: *Guava Crystal, Time Study, Standard Time*