TIME AND MOTION STUDIES IN SMALL AND A LARGE SCALE RICE MILLING PROCESS

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ABSTRACT

The objective of this research is to establish a better working method using the indication of more effective and efficient time, standardized systems and working method and determine standard time. The research was to determine the performance difference between small and large scale rice mills. The research method used in the research is to observe the motion of an operator to a machine or a tool that is used for time calculation. Observations made by recording the operator while they are working using a camcorder and analyze the time and motion from the recorded video. Motions were analyzed and grouped according to the cycle and type of motion. Average time of each motion adjusted with Westinghouse rating and allowances to obtain the standard time. Standard time of each 100 kg paddy or rice at the small scale rice mill A is 192.05 seconds for paddy drying, 379.17 seconds for husking and 1056.02 seconds for polishing. Standard time of each 100 kg paddy or rice at small scale rice mill B is 314.83 seconds for paddy drying, 279.35 seconds for husking and 425.51 seconds. Standard time of each 100 kg paddy or rice at the large scale rice mill is 335.7 seconds for drying, 169.36 seconds for husking, 306.55 seconds for polishing and 260.86 seconds for packaging.

Keywords: Rice mill, Time Study, Motion study, Standard Time