THE EFFECT OF LOT SIZE AND PRODUCT STRUCTURE ON
MAKESPAN MINIMIZATION IN MULTILEVEL PRODUCT SCHEDULING
(Due to 4 Levels of Product Structure with Maximum
Parts Are 4 in Each Level)

THESIS
Submitted as Partial Fulfillment of the Requirements
to Obtain the Bachelor of International
Industrial Engineering Degree

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2009
STATEMENT OF WORK’S ORIGINALITY

I honestly declare that this thesis which I wrote does not contain the works or parts of the works of other people, except those cited in the quotations and bibliography, as a scientific paper should.

Yogyakarta, April 2009

The Writer

Sammuel Sukamto
THESIS TITLED

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ACKNOWLEDGEMENT

Dedicated to my parents...
FOREWORD

Thank to God for His blessings and guidance that allow the writer to completely finish the long journey of this final project. This final project is the requirements to obtain the bachelor of International Industrial Engineering Degree in Universitas Atma Jaya Yogyakarta.

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The writer realizes that this final project still far from perfect. Therefore, all the critics or suggestions are accepted to make this report better.

The writer hopes that this report will be useful for all people, especially the readers.

Yogyakarta, April 2009

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# TABLE OF CONTENT

<table>
<thead>
<tr>
<th>Section</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Title Page</td>
<td>i</td>
</tr>
<tr>
<td>Statement Of Work’s Originality</td>
<td>ii</td>
</tr>
<tr>
<td>Approval</td>
<td>iii</td>
</tr>
<tr>
<td>Acknowledgement</td>
<td>iv</td>
</tr>
<tr>
<td>Foreword</td>
<td>v</td>
</tr>
<tr>
<td>Table Of Content</td>
<td>vii</td>
</tr>
<tr>
<td>List Of Tables</td>
<td>ix</td>
</tr>
<tr>
<td>List Of Figures</td>
<td>x</td>
</tr>
<tr>
<td>Abstract</td>
<td>xi</td>
</tr>
<tr>
<td><strong>CHAPTER 1 Introduction</strong></td>
<td></td>
</tr>
<tr>
<td>1.1. Background</td>
<td>1</td>
</tr>
<tr>
<td>1.2. Problem Statement</td>
<td>2</td>
</tr>
<tr>
<td>1.3. Research Objectives</td>
<td>3</td>
</tr>
<tr>
<td>1.4. Scope of Research</td>
<td>3</td>
</tr>
<tr>
<td>1.5. Research Methodology</td>
<td>3</td>
</tr>
<tr>
<td>a. Generating Data</td>
<td>3</td>
</tr>
<tr>
<td>b. Data Processing Step</td>
<td>4</td>
</tr>
<tr>
<td>c. Analyzing Step</td>
<td>4</td>
</tr>
<tr>
<td>d. Making Report</td>
<td>4</td>
</tr>
<tr>
<td>e. Research Flow Diagram</td>
<td>4</td>
</tr>
<tr>
<td>1.6. Report Outline</td>
<td>6</td>
</tr>
<tr>
<td><strong>CHAPTER 2 Literature Review</strong></td>
<td></td>
</tr>
<tr>
<td><strong>CHAPTER 3 Basic Theory</strong></td>
<td></td>
</tr>
<tr>
<td>3.1. Scheduling</td>
<td>10</td>
</tr>
<tr>
<td>3.2. Routing File</td>
<td>11</td>
</tr>
<tr>
<td>3.3. Bill of Materials</td>
<td>11</td>
</tr>
<tr>
<td>3.4. Gantt Chart</td>
<td>13</td>
</tr>
<tr>
<td>3.5. Lot Splitting</td>
<td>13</td>
</tr>
</tbody>
</table>
3.6. Hypothesis Test  14
3.7. Analysis of Variance (ANOVA)  15

CHAPTER 4 Data
4.1. Product Structure  19
4.2. Routing File  20
4.3. Lot size  26

CHAPTER 5 Data Analysis
5.1. Gantt chart simulation  28
5.2. Ratio Calculation for Minimum Makespan  34
5.3. Hypothesis Testing using ANOVA  35

CHAPTER 6 Conclusion and Suggestion
6.1. Conclusion  41
6.2. Suggestion  41

References
Appendices
LIST OF TABLES

Table 4.1. Routing Files for Replication 1 36
Table 4.2. Routing Files for Replication 2 37
Table 4.3. Routing Files for Replication 3 38
Table 4.4. Routing Files for Replication 4 39
Table 5.1. Result of Gantt chart Simulation 54
Table 5.2. Result of Optimum Ratio 57
Table 5.3. ANOVA Single Factor Test Result 57
Table 5.4. Result of Optimum Ratio 58
Table 5.5. ANOVA Single Factor test Result 59
LIST OF FIGURES

Figure 1.1. Research Flow Diagram 6
Figure 3.1. The Example of the Structure of BOM (www.feldmanengineering.com/BoMGlossary.htm) 18
Figure 3.2. The Example of Gantt Chart (Burbidge, 1971) 19
Figure 4.1. The Product Structure 30
Figure 5.1. Research Map of Production System Laboratory of UAJY 45
Figure 5.2. Gantt Chart 48
Figure 5.3. Part C Operation 1, 1st Product Structure 49
Figure 5.4. Makespan Result from the Given Example 50
Figure 5.5. Common Makespan Pattern 50
Figure 5.6. Setup time-Run time Ratio Data 53
ABSTRACT

Every company has to compete each others to survive in their business world. One of the ways is to reducing the expense cost. A good scheduling can minimize it, because production time equals with production cost. If production takes long time to be done, the production cost needed will be higher. So the scheduling which can minimize makespan is needed. Finding the effect of lot size and product structure on makespan minimization in multilevel product scheduling becomes the main theme of this research that is included in the long term research project of The Production System Laboratory of Universitas Atma Jaya Yogyakarta.

There are some data used in this research, those are product structure (BOM), lot size, setup time, and run time. Product structure used is 4 level of product structure with maximum number of parts are 4 in each level where the combinations of product structure forms are generated to fulfill that consideration. Number of item produced is 45 and lot size evaluated are 5, 9, 15, and 45. Setup time is randomly generated by random number that is varied from 5 to 10 minutes/lot, and run time is varied from 1 to 5 minutes/unit. Optimum lot size is lot size decision giving the minimum makespan. Gantt chart is simulated to obtain the makespan each product structure, lot size and replication. Optimum lot size will be evaluated using ANOVA single factor.

Based on Gantt chart simulation, there is minimum makespan for each lot size, product structure and replication. Optimum lot size resulted is lot size 9 and 15. Based on ANOVA single factor result, the conclusion is product structure complexity does not significantly affect the optimum lot size.