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**THE EFFECT OF LOT SIZE AND PRODUCT STRUCTURE ON
MAKESPAN MINIMIZATION IN MULTILEVEL PRODUCT SCHEDULING
(Due to 3 Levels of Product Structure with Maximum
Parts Are 4 in Each Level)**

THESIS

**Submitted as Partial Fulfill of the Requirements
to Obtain the Bachelor of International
Industrial Engineering Degree**



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YOGYAKARTA**

2008

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, November 2008

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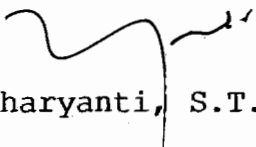
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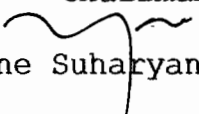
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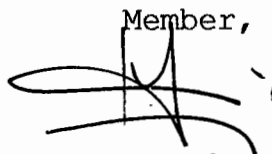
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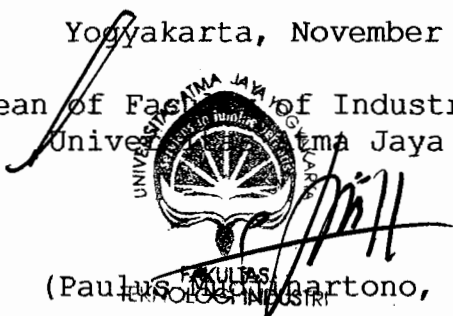

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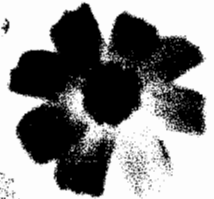
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Dedicated to:

- © My LORD, Jesus Christ and the Virgin Mary
- © Mf family : mom, dad, and my bro
- © Tiki 2004, thank you for all the sweet bitter memories
between us...



FOREWORD

Thank God because of His wonderful bless and gift, the writer is able to finish this final project as one of requirements to obtain the bachelor of International Industrial Engineering Degree in Universitas Atma Jaya Yogyakarta. With His participation, the writer could do the best effort in composing, arranging, and building this final project.

However, writer realizes that this final project could not be completed without helps, supports, and also prayers from all people involved in. In this amazing chance, writer would like to thank:

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The writer also realizes that this final project still has so much limitations and weaknesses. Therefore, all critics or suggestions are accepted in order to make this report better.

May this report is useful not only for the writer but also for the readers.

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Yogyakarta, November 2008

Writer

TABLE OF CONTENT

Title Page	i
Statement Of Work's Originality	ii
Approval	iii
Acknowledgement	iv
Foreword	v
Table Of Content	vii
List Of Tables	x
List Of Figures	xi
Abstract	xiii
CHAPTER 1 Introduction	
1.1. Background	1
1.2. Problem Statement	3
1.3. Research Objectives	3
1.4. Scope of Research	3
1.5. Research Methodology	4
1.5.1. Preparation Steps	4
1.5.2. Generating Data Process	4
1.5.3. Data Processing Step	5
1.5.4. Data Analyzing Step	5
1.5.5. Report Arrangement	5
1.5.6. Research Flowchart	6
1.6. Report Outline	7
CHAPTER 2 Literature Review	8
CHAPTER 3 Basic Theory	
3.1. Scheduling	11
3.1.1. Scheduling Definition and Benefits	11
3.1.2. Scheduling Classifications	12

3.1.3. Scheduling Terminology	15
3.2. Makespan	15
3.3. Lot Splitting	16
3.4. Bill of Material (BOM)	16
3.5. Routing File	18
3.6. Gantt Chart	19
3.7. Hypothesis testing	19
3.7.1. Statistical Hypothesis	20
3.7.2. Null Hypothesis (H_0) and Alternative Hypothesis (H_1)	20
3.7.3. Significance Level	21
3.8. Analysis of Variance (ANOVA)	23
3.8.1. Hypothesis statements	23
3.8.2. F Test	24
3.8.2.1. F Statistic	24
3.8.2.2. F Table	27
3.8.3. F statistic versus critical value in F Table	27
CHAPTER 4 Data	
4.1. Product Structure	30
4.2. Generating Routing File	34
4.2.1. Number of parts	34
4.2.2. Number of machines and operations	34
4.2.3. Setup and Run time	35
4.3. Routing File	35
4.4. Lot size	41
CHAPTER 5 Data Analysis	
5.1. Gantt chart simulation	46
5.1.1. Calculating process time for each part	47

5.1.2. Plotting the process time in Gantt chart	47
5.2. Ratio Calculation	54
5.3. Hypothesis Testing using ANOVA	58
CHAPTER 6 Conclusion and Suggestion	
6.1. Conclusion	63
6.2. Suggestion	63
References	
Appendices	



LIST OF TABLES

Table 3.1.	ANOVA Table	27
Table 4.1.	Routing File 1	36
Table 4.2.	Routing File 2	37
Table 4.3.	Routing File 3	38
Table 4.4.	Routing File 4	39
Table 4.5.	Routing File 5	40
Table 5.1.	Makespan Result	51
Table 5.2.	Lot Size Giving Minimum Makespan	54
Table 5.3.	Two Minimum Makespan Results	57
Table 5.4.	An Approximated Value of Optimum ratio	57
Table 5.5.	Optimum Ratio for 3 Level of Product Structure with Maximum 4 Parts in One Level	58
Table 5.6.	The Result of ANOVA due to Optimum Ratio for 3 Level of Product Structure with Maximum 4 Parts in One Level ($\alpha = 0.05$)	59
Table 5.7.	Table 5.8. The Result of ANOVA Due to Optimum Ratio Grouped by Number of Parts in Each BOM	62

LIST OF FIGURES

Figure 1.1.	Research Flowchart	6
Figure 3.1.	The Example of Bill of Material (Source: Nahmias, 2001)	18
Figure 3.2.	Simple Gantt Chart Demo (Source: Http://www.Barchart.Be/Ganttchart.Jsp)	19
Figure 3.3.	Hypothesis Testing at Three Different Significance Levels (Source: Levin, 1981)	22
Figure 4.1.	3 Levels of Product Structure with Maximum Parts Are 4 In Level 2 and 1 Part In Level 1	30
Figure 4.2.	3 Levels of Product Structure with the Longest Parts Are 3 In Level 1	31
Figure 4.3.	3 Levels of Product Structure with the Longest Parts Are 3 in Level 1 and 2	31
Figure 4.4.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 2 and 3 Parts in Level 1	31
Figure 4.5.	3 Levels of Product Structure with the Longest Parts Are 3 in Level 2 and 2 Parts in Level 1	32
Figure 4.6.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 2 and 2 Parts in Level 1	32
Figure 4.7.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 2 and 2 Parts in Level 1	32

Figure 4.8.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 1 and 1 Part in Level 2	33
Figure 4.9.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 1 and 2 Parts in Level 2	33
Figure 4.10.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 1 and 3 Parts in Level 2	33
Figure 4.11.	3 Levels of Product Structure with Maximum Parts Are 4 in Level 1 and 2	34
Figure 4.12.	DataFit Version 9.0.x	42
Figure 4.13.	New Project Form	42
Figure 4.14.	Lot Size and Makespan Data	43
Figure 4.15.	New Plot Icon	43
Figure 4.16.	Makespan Curve in DataFit	44
Figure 5.1.	Research Map	45
Figure 5.2.	Gantt Chart	48
Figure 5.3.	Part B Operation 1	49
Figure 5.4.	Part B Operation 1 in 2 nd Replication Process	50
Figure 5.5.	Makespan	50
Figure 5.6.	Common Makespan Pattern	53
Figure 5.7.	Optimum Ratio is Grouped By Column	59
Figure 5.8.	Optimum Ratio is Grouped By Part Number	61

ABSTRACT

Production scheduling plays important roles in production system. It directly affects the production capacity whether production capacity will inadequate or excessive which both of them can result lost. Generally, production scheduling is aimed to minimize production and labor cost that is affected by function of time which is total production time or makespan. Minimizing makespan becomes the research objective in this research that is included in the long term research project of The Production System Laboratory of Universitas Atma Jaya Yogyakarta.

Some data is used in this research. They are product structures, lot size, setup time, and run time. Product structure used is 3 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 30 and lot size evaluated are 5, 6, 10, 15, and 30. 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. Gantt chart generation is used to find makespan. Later, hypothesis testing is generated using ANOVA due to the optimum setup time - run time ratio.

Based on the whole process, it results that optimum ratio tends to be among lot size 10, 15, and 30. Another result is that the complexity of product structure (in this research is the number of parts) affects the optimum ratio among product structures. Later, it affects optimum lot size that results minimum makespan.

