

## CHAPTER VI

### CONCLUSION

This chapter contains conclusions based on research objectives and useful recommendations for the next research.

#### 6.1 Summary

This study has designed an improvement of the work method for peeling garlic workers in UKM Ulak Karang. Single Minute Exchange of Die (SMED) with considering Eliminate, Combine, Re-arrange and Re-layout, and Simplify or Simplicity (ECRS) approach is used to analyze the condition. The improvements conducted are such as :

1. Re-layout the position of storage, cracking and winnowing area, machine, output area, and scaling area
2. Adding helping tools such as cutter for cutting the rope sack, hammer for cracking unpeeled garlies, “nyiru” for winnowing unpeeled garlies, and scoop for taking peeled garlies on the mat
3. Eliminating non value added activities such as waiting for the machine to be ready and stirring peeled garlies on the mat.

The result shows that set up time decreased from 7.96 hours to 4.64 hours/ day (58.29%) and production output increased from 100 Kg/ 7.96 working hours per day to 171.55 Kg/ 7.96 working hours per day (71.55%).

## 6.2 Recommendation

Recommendations for the next research are:

1. Work method improvement is not only for worker who peels garlic by machine, but also for worker who peels garlic by manual.
2. It is recommended to make Standard Operation Procedure (SOP) for the workers in UKM Ulak Karang Padang.
3. Improvement of work method is not only conducted by adding helping tools and re-layout but also designing garlic peeling machine.

