

## Analysis Of Operational Management Functions In Ud. Aneka Plastic

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### Abstract.

*UD. Aneka Plastic is wrong one company engaged in the plastics industry. Destination this research is for describe managementoperational with explain function managementoperational on UD. Aneka Plastic. Method study used is qualitative and purposive sampling with conducted interviews with 3 informants. Test validity data which used is triangulation source. Results study this show thatthe company has a capacity that is not excess and could produce product in accordance with Requestbuyers, strategic location so easy to reach by supplier and power work, system location which notice security and safety employee, good product quality and difficult for competitors to imitate, as well as method production which clear. Besides that, have scheduling regarding production, namely Master Production Detailed Schedule , Detailed Short-Term Schedule withhave system management maintenance machine, and Staff Schedule which clear so that company could carry out production activities smoothly. Supervision operational in company showed with delivery of goods fulfilled, stock storage in sufficient warehouse, have potential suppliers, and could control inventory with good. Structureorganization, job description , vision and mission, as well as SOPs written and clearly required by the company. Motivation, more employee involvement, and rewards are also necessarynoticed for employee. Facility supporter also need added so that atmosphere in company no boring .*

**Keywords:** Management operational, Management Function Operational

## 1. INTRODUCTION

The plastics industry is one of the industries that growing in Indonesia. According to the Director of Chemical Industry The foundation of the Ministry of Industry, Tony Tandum, in 2013, total plastic needs Indonesia is 3.8 million ton and grow 10% every year (business.temponline, 28/11/2013). Wrong one factor trigger increase needs plastic caused by the more many sector industry other which need product plastic for packaging product or as complement packaging. Rope raffia is one of the products from the processing of recycled plastic which no friendly environment. Rope raffia this many used by person home and person manufacturer. Development industry plastic is sector which not enough strategic for support growth national economic development and contribute important for the national economy. Plastic waste in Indonesia occupy rating second producer rubbish domestic, that is 5.4 million ton per year (antaranewsonline, 4/2/2014). Quality results production rope raffia very variety depending on the company's operational processing. For example, UD Nirvana Plastic, which is one of the rope manufacturers raffia in Bogor, West Java, is capable of producing 20 tons of rope every month, because the price is cheap especially on the rope raffia black which reach 60% from total sale (portalinvestasionline, 1/10/2016). Quality of rope production raffia could strengthened by fact which there is on CV. Melindo Jaya which located in Village rice field jaten, Regency Karanganyar, Java Middle. Industry the produces two types of raffia rope, namely super raffia and raffia rope raffia KW 3. Consumers complain about the results of raffia rope production which is more than 1 g/m, while the specific weight of the raffia rope which there is in market moment this is 0.9 gr/m. height Request and existence complain on CV. Melindo make company this increase quality production because satisfaction consumer not yet fulfilled. Satisfaction become an important component in the raffia rope industry (DH Darmono, 2015).

Difficulty of raw materials obtained in making rope raffia also could Becomes Thing which need noticed so that does not hinder the production process because usually goods which used as ingredient raw making rope raffia are *recycled* goods or directly from plastic waste Thing this strengthened by fact that Putranto, CV owner. dian in harmony in Tangerang, Banten, say that he difficulty in look for plastic waste raw materials. Besides In addition, the difficulty lies in the quality of the plastic waste in the lower needs standard. However, he attempted for maximizing rubbish plastic which is at in lower quality standard the (opportunity.kontanonline, 3/10/2011). In in era industrialization which Keep going develop, use equipment machine the more relate close with quality management operational company for help plan, implement, and

operate planning source power his company. As stated by Heizer and Render (2011), management operation is series activity which produce score in form goods and service with change input Becomes outputs. To create effective operational management and efficient, could is known through function management operational as follows:

**a. Planning Operational ( *Operations plans* )**

Planning operation shared Becomes five category, that is capacity planning, location, *layout* , quality, and method production.

**b. Scheduling Operational ( *Operations schedule* )**

Manager develop list or timetable for get and use source power production. Scheduling indicates what products will be produced, when the production process is carried out, and the resources to beused.

**c. Supervision Operational ( *Operations control* )**

Operational supervision regarding material management and quality control. Material management consists of five fields, namely transportation, warehousing, inventory, selection supplier, and purchase ingredient raw for production .

UD. Aneka Plastic is wrong one company which move in field industry plastic, which located in Jl. Merdeka in Padangsidempuan. Reason The company chose this location, because it was located in industrial area so easy to reach by supplier and power work. Company this stand up on year 1979 until now, starting from producing plastic bags which then switch for produce rope raffia. This research has been approved by Mien Suseno as director main from UD. Aneka Plastic. The phenomenon that occurs at PT. The current Plastic Quail is machine which sometimes experience damage could hinder the company's operations so as to produce output which no in accordance with standard quality which owned by the company. In addition, companies that sometimes have difficulty in obtaining raw materials because not getting enough plastic scraps from suppliers.

Then, another phenomenon is the quality of the raffia produced UD. Aneka Plastic good and difficult imitated by competitors. Operational management is important for product quality, such as the production of appropriate raffia rope with company standards and *quality control* owned company. Raffia rope products with the best quality and minimum defects in the resulting raffia rope products, as well as accuracy time in produce could Fulfill Request consumer so that satisfaction consumer will increase. Company prioritize quality in produce rope raffia, which get away to hand buyer must which in accordance with *quality control* company. In accordance with the vision and mission of the company, namely: get turnover as much as possible with Keep going look for order and promote product through website and social media. Like which has explained in on, that there is a number of the thing that become a problem within the company, so that researchers interested in doing this research to analyze operational management at UD. Aneka Plastic with function operational management, because companies sometimes have a malfunction in the machine and have difficulty getting rote plastic from supplier because is goods *recycle* . Besides that, Thing which interesting is company has a good quality raffia rope product and is difficult to imitate by competitors.

## II. METHOD

This research uses descriptive qualitative method, because could show situation and condition real which occurred regarding the operational management applied in the within the company, describe operational management with use results Interview, and analyze management operational with function management operational in UD. Aneka Plastic. Subject in study this is management operations at UD. Aneka Plastic. Objects in this study is Director Main, Supervisor part Production, and Production employees at UD. Aneka Plastic. Data source primary in study this is results Interview which obtained by direct from parties which interviewed. On study this, researcher To do Interview with give a number of question about dimensions function management operational to informants which has chosen by researcher for knowing management operational in UD. Aneka Plastic. Source data secondary in study this is book and journal which related with study, as well as documents which there is on company. Document company in the form of raffia rope production data and shift schedule work on employees. Method determination informant which used in study this is technique *purposive sampling* . Technique *purposive sampling* is technique taking

sample data sources with certain considerations, for example people the which considered most know about what which ourexpert, or maybe him as the ruler, so it will makes it easier for researchers to explore objects or situations social which researched (Sugiyono, 2011, pp.218-219). Researcher using this technique with the aim that informants who chosen really appropriate because they know and understand the most about the needs of the data needed by researchers. In solution study this, so researcher more formerly choose informant as source person in providing the required information.

The informants who chosen by researcher, that is: Mien Suseno as Director Main UD. Aneka Plastic, Ayu Sabarwati as Supervisor part Production UD. Aneka Plastic, and Sriani as Employee part Production UD. Aneka Plastic. In study this, method collection data which used is a semi-structured interview, where in implementation more free and allow for find problems more openly where the parties party which interviewed requested opinion and idea (Sugiyono, 2011, p.233). In study this, use three stages in analyze data, that is reduction data, presentation data, and conclusion. Data reduction means summarizing, selecting Thing main one, focus on things the important one, looking for themes and patterns. Thus, the data that has been reduced will give description which more clear, make it easier for researchers to collect data next, and look for it when needed (Sugiyono, 2011, p.246). Presentation of data can be done in the form of a description short, chart, connection between category, *flowchart*, and the like. Most often used to present data in study qualitative is with text which character narrative. With serve data, so will make it easy for understand what which occur, plan future work based on what has been understood the (Sugiyono, 2014, p.246). Conclusion in study qualitative is is findings new which had never existed before. Findings can be a description or picture of an object that was previously still dim or dark so that upon examination it becomes clear, can be a causal or interactive relationship, hypotheses or theory (Sugiyono, 2014, p.246). Data testing method used in research this is source triangulation. According to Sugiyono (2011, p. 274), source triangulation means to get data from source which different with technique that same.

### III. RESEARCH RESULTS AND DISCUSSION

Management Operational is process which used by an organization in order to obtain materials and ideas for defined product, the process of converting it into a products, and processes that provide end products to users. Management operational refers to on product main company. Based on the interviews that have been conducted, it was found that information which same about UD. Aneka Plastic in carry out the production process, namely plastic memorization in the form of the sheet is chopped by chopping machine into parts which more small. Then, parts small the given color with *mixer*. After given color, parts small the entered into in pellet machine service/ATT to make plastic ore. The plastic ore is processed further into rafua rope products which are ready to be packaged. From ore plastic the, selected where which good and appropriate used for produce rope so that quality rope raffia which has been produced according to with the standards you have company and could satisfying consumer. Ore plastic Those who have passed the selection are entered into the machine rope so that Becomes rope raffia. After Becomes rope raffia, entered to in machine packaging for packed. The number of employees who carry out the production process is 50 person. Average time used to produce 1 a roll of raffia rope is about 45 minutes to 1 hour. String of raffia produced there are red, green, blue, and red. For black raffia rope produced as much as about 2 tons as inventory in the warehouse. Manufactured raffia rope packed into three sizes, namely 1 kg, kg, and kg. Buyers often place orders for raffia rope that is colored than black raffia. Rope production process raffia use ingredient raw which quality good. Ingredient raw which used is plastic *PVC shrink*, rote plastics and dyes. The color used by the company are imported goods purchased through dye distributors which is located in the Padangsidempuan area. In addition, the dye that owned by UD. Aneka Plastic has been patented so it doesn't could imitated by competitors. Quality ingredient raw which used of course give influence to quality product rope raffia. UD. Aneka Plastic no have Standard Operating Procedure (SOUP) by written and structure the organizational also not written.

*Job description* in the company is also not written. Thing this of course influence understanding parties in in company about part what which they do and how do it. However, director main with helped by supervisor permanent direct employee as should be. Company To do briefing every month very for guide

employee. The company instills *quality ownership* to all employees, so that they realize the importance of the quality of a product offered by the company. So, everyone in the company is aware of the importance of the quality of the product which is generated. The transformation process from raw materials to finished goods is on UD. Aneka Plastic is short, simple, and efficient in the sense of not spending a lot of time. Starting from the process of entering raw materials to in the *finishing process*, namely producing ready-made raffia packed. Equipment which is used by the company in the process of transformation is, machine chopper, *mixer*, machine pellet services/ATT, machine rope, and machine packaging. Most of those machines are *made in Taiwan*. In using machines, the company of course does *maintenance* on machines which are used. The company has a system of maintenance management, planned and unplanned. For the character of planned maintenance, the company plans maintenance to prevent damage to the machine and for repair of parts which are damaged on the machine. For prevention, the company does inspection, setup, and lubrication on the machine. The company also adds spare parts to repair the damage. Small damage which there is on the machine. For repair, the company does demolition on the machine to check whether the parts inside the machine are available which are broken, which is called *maintenance breakdowns*. Then, repairs due to damage are carried out if parts are found inside the machine that are indeed damaged. This is done by the company every day by checking the condition of the machine.

UD. Aneka Plastic also does system management maintenance of the machine by no planned, which means when in an emergency / *emergency*, the company immediately handles the machine which suddenly experiences damage by replacing damaged parts with spare parts which are available. Then, when the damage is critical and cannot be tolerated, so the machine which is damaged is brought to the workshop for repair and the company uses other machines, namely the *back-up* of these machines. This matter is usually indicated by the production of raffia not in accordance with standard, for example color rope raffia rather faded and raffia rope produced is thicker or coarser than standard which is owned by the company. The production process which is conducted by UD. Aneka Plastic is continuous, so that the machine keeps going and the possibility of machine damage is really big. Informants disclose that customers always want the order fast sent. However, if the company produces a soaring buyer demand in meaning exceed capacity output which is produced by the company per day, then the company will ask the buyer where the order they which most *urgent* / needed and the rest will be sent follow. The company only backs off a number of days in sending the order which got many, but not until late so that the request of the buyer is not fulfilled. UD. Aneka Plastic does not have a manager operational alone. The main director who also takes on a role in terms of this. The main director also takes office as manager operational. The main director plans, schedules, and controls the entire operational process of the company. The main director has a supervisor which directs employees with arranging the production process of rope raffia and the main director also makes scheduling shifts for employees so that employees know when they start and end the production process. Besides that, with the existence of scheduling, employees know the product where which more formerly produced and know they are placed in the machine where. Every day Saturday, scheduling for employees is arranged for the next week. The main director on UD. Aneka Plastic also does supervision operational with controlling the production result of rope raffia before getting away to the hand of the buyer, is in accordance with QC (*quality control*) which is owned by the company.

Based on the information provided by the informants, analysis results regarding operational management in UD. Aneka Plastic already do function management operations effectively and efficiently. However, weakness- weakness which there is in the company is sometimes machine which experiences damage must be repaired at least around half o'clock and if more than half an hour, then the employee is transferred to the machine other so that no unemployed. Will but, which becomes weakness is that the scheduled time has been postponed for repair of machine which is damaged and machine that experiences damage is known from the quality of the output produced is not according to standard. In addition, the raw materials used by UD. Aneka Plastic are goods *recycle*, so that no could order in accordance with amount which is targeted by the company. However, weaknesses which are owned by the company this could be overcome by the company. Weaknesses other which are owned by the company is not having SOP, organizational structure, and *job description* by written. This causes the company no have a clear legal basis or reference. Then, structure organization and *job desc* which no written cause decline understanding about tasks which are done parties in the company, Besides that, motivation work on the company not enough, the company only tell employees who make mistakes to learn with employees which performs well. In addition, the company does not have an operational manager, a

financial manager, and manager HR separately. All held by director main, where Thing this could cause confusion in decision making. In addition, the company does not have vision and mission which clear, which most important for company is to get a lot of turnover so that could hire employee in accordance with regulation government. This shows that the company only just do business without thinking destination period long.

### **Function Management Operational**

Through information from informants, the planning process operational in UD. Aneka Plastics, customized with a lot Request and order which got from buyer. The operational process run by UD. Aneka Plastic runs efficiently. Existing capacity planning in UD. Aneka Plastic has conducted with good, with To do production which customized with ability machine and employee has To do his job with as well as possible so as not to have his salary cut (affected) *shock therapy* ). Process planning capacity ( *capacity planning* ) this also customized by request buyer and ability machine for produce output which in accordance with Request buyer. Capacity machine which owned by the company in one hour is 1 roll of raffia rope which weighs 1 kg. Within a day, the company produces raffia as much as 5 to 6 tons. Company do production from morning to the next day, do not stop, keep in touch until the next day, starting from Monday pk. 08.00- Saturday pk 16.00. Capacity planning at UD. Aneka Plastic is suitable with the capabilities of existing machines and if there is a request buyer where Thing this cause company must produce overload normal, then company usually produce by overtime employees and send goods which truly needed buyer more formerly. Based on theory Ebert & Griffin (2006), planning about the location ( *location planning* ) has an impact on production costs and flexibility, site planning becomes something Thing which make an impact for company.

Strategic location and easily accessible by suppliers and buyers are needed in setting up a company so that no Secrete fund which many and difficult reachable. PT. Puyuh Plastic which is located on Jl. Merdeka in Padangsidempuan, is at in area industry so that easy reachable by industry other and buyer. The company also already has a lot of suppliers, good from area Padangsidempuan nor from area outside Padangsidempuan. Supplier the could reach company because strategic location so easy to find. Company send order buyer with use truck or the buyer can pick it up directly at the company. Usually those who take it directly to UD. Aneka Plastic is which is at in area area Padangsidempuan. Results of analysis regarding site planning state that location where UD. Aneka Plastic is at has in accordance, that is is at in area industry SIER, so that easy reachable, good supplier and customer. Based on theory Ebert & Griffin (2006), company should use some layout arrangement ( *layout* ), which covers facility productive, non-productive, nor supporting facilities. It is intended to be able to provide safety and comfort to all *stakeholders* in company nor person outside which come to company.

*Layout planning* in UD. Aneka Plastic styled by director main with helped by leader peak company, namely the father of the president director. According to all informant, composing system location on company already comfort and safety taken into account. So, from room work which there is company, already have AIR CONDITIONING, computer, and table accompanied with atmosphere which calm. In addition, in the production workspace, the distance between machines is already taken into account so that security and safety employee already guaranteed and Thing this no obstruct other operational activities. In addition, the pick-up point raw materials are in the warehouse behind the production room and in room work production also there is *forklift* so that make it easier for employees to pick up goods Facilities Supporters such as restrooms have also been divided so as not to stall time, like room small for office own administration, there is also a restroom for supervisors itself, and also the restroom for employees is there alone. In this case, it is proven that in taking raw materials and activity production could walk fluent because already organized efficiently so it doesn't take too long could inhibit activity production.

The parking lot at UD. Aneka Plastic is also spacious and because UD. Aneka Plastic is in an industrial area, so transportation is not a problem. It shows that the parking area has been effective because it provides satisfaction for everyone including *stakeholders* UD. Aneka Plastic. However, at UD. Aneka Plastic does not have any facilities make atmosphere company Becomes different. For example, There is a canteen or cafe. Even though this includes *support facilities* , but if the company implements this, then This is an

advantage for the company because with Thing this, so *stakeholders* company no will feel bored and of course this can also arouse spirit work para *stakeholders* .

Based on theory Ebert & Griffin (2006), that planning quality ( *quality planning* ) must confirmed that product the in accordance with standard quality company. Through the information provided by the informant, The quality owned by UD. Aneka Plastic is good, it fits with desire buyer, have something in the form of *valuethat* other companies don't have so it's hard to emulate by competitors. Besides that, rope raffia for sale with price affordable in accordance with the quality provided. According to source person which interviewed by researcher, that is sources 1-3, said that quality is number one. So, the raffia rope sold by UD. Aneka Plastic is weaker, strong, and has a bright, attractive, and always consistent. This is because of the dye used by company is goods import. Then, the weight it is certain, for example, if one roll of raffia is valued at 1 kg, so the weight certain 1 kg. Besides that, rope the raffia no shrink, not wet, the length from end to end is certain same. When compared to other raffia ropes, a definite buyer will have 1000 meters of plastic rope. This is not necessarily implemented by other companies. Then, according to sources 1-3, other things which distinguish UD. Aneka Plastic with rope raffia company other is because the packaging use *PVC shrink* , no just put in plastic and tied. So, it looks neater and the logo is also made big and inside the logo that, there is colors that reflect colors that only have UD. Aneka Plastics.

Source person 3 (Employee Part Production) also say that every one roll rope raffia which already After production, it is taken 1 meter long and then weighed because the weight of the 1 meter long rope can't be more from 0.5 gram agar result not too thick. In terms of color, if the resulting color is far from the standard owned, then the raffia rope is not used. That matter done to prevent non-standard goods so that no until get away to hand buyer. So, Thing this prove that UD. Aneka Plastic have *quality control* which good, so that no disappointing buyerand this is what causes UD. Aneka Plastic has a good reputation in the eyes of the public, so that even location company no close with market, but because which take precedence company this is quality, so that always according to the buyer's request, so many people who know UD. Aneka Plastics.

Based on the theory of Ebert & Griffin (2006), that in planning system operational, needed manager which can identify each stage of production and method special for To do that. UD. Aneka Plastic no have manager operational separately. All operational responsibilities are held by director main which understand whole stages production with helped by supervisor for direct para employees in assisting the production process. Employees directed to be able to produce with high quality resultsgood. Many of the employees can do more than one Duty in in To do process production on company. Planning method production ( *production methods planning* ) carried out by the company is the method conveyor belt because each worker makes the product individually complete, from raw materials to final products. So, each part of the finished product, is placed on the tire walk and moved to the place work next. The work is completed in the same production room. Which need noticed in Thing this is so that no until occur accumulation on one part so that no until there is a bottleneck in the production process. accumulation on one part so that there is no bottleneck in the process production. Besides that, product which produced generated by continuous because activity production Keep going conducted every day, except day Sunday, no by seasonal. In addition, there are no breaks in the production process. So, The chopped results from the chopping machine are processed continuously until they become string of raffia. Pauses exist only when employees take a break, but Thing this permanent show that company apply continuous because permanent involve conveyor in process production.

Based on the theory of Ebert & Griffin (2006), that managers develop a list or schedule in obtaining and use source power production. Scheduling indicates what products to produce, when to processproduction is performed, and resources are used. Inschedule worker, manager must can consider efficiency.Scheduling will product where which more formerly produced, when is the process production, and resources which used by UD. Aneka Plastic conducted with gather all employee on day Saturday for schedule for next week's production activities. Thing this conducted so that every employee knowing they in which machine and if there are employees have certain needs, employees must report to company a week previously so that activityproduction no hampered. If on day H where employees should be working, but suddenly there is a

need important, so company will pointing employee other for replace employee which no enter. If the company does not get a replacement in this case, then machine forced turn off (no production). Will but very rare company experience Thing this. Results analysis show that scheduling, good from *Master Production schedule* , *Detailed Short-Term schedule* , and *Staff Schedule* already could walk with good and fluent.

Based on theory from Ebert and Griffin (2006), *Operations Control* concerning management material and control quality. Management material consist from five field, that is transportation, warehousing, purchase, supplier selection, and inventory control. UD. Aneka Plastic send source power or goods so to producer and buyer use truck. Truck which owned by company there is three. Like which said by source person 1 and 2, namely the owner and supervisor of the production division of UD. Aneka Plastics, that company send goods in a day at most two tons, because the truck doesn't fit. So, if there is a buyer's demand that exceeds two tons, then usually the company asks which buyers order they which most *urgent* /needed so that companies can prioritize delivery of goods goods which *urgently* . Like which said by source person 3 (Production Division Employees), the main thing to pay attention to the company in this case is to ensure all machines could walk so that could Keep going To do activity production. In Thing this, company already effective in respond Request buyer which changed.

In terms of warehousing, if there is an excess of finished goods which have not been sold, it will be automatically saved to warehouse, but company confess that seldom very the company is experiencing it, as it has been said by source person 1 (Owner UD. Aneka Plastics). Then, according to resource person 3, namely employees of the production division of UD. Aneka Plastics, say that company have Sufficient stock in the warehouse so that if the buyer wants the goods, the company is ready. For example for rope raffia black which his request more a little than rope color, then 2 tons of black raffia are produced for preparation in warehouse. Thing this show that what the company is doing is effective and efficient because it produces according to demand and has Sufficient stock so it doesn't take time when there is buyers who want a certain stock. In the company, there are 5 service pellet machines/ATT so that the total amount of plastic ore that can be produced in a day about 20 tons. This plastic ore can saved in warehouse for produced Becomes rope on the next day. For raw materials, the company has stock which enough in warehouse, because although company confess sometimes difficulty get ingredient raw because the raw materials used are *recycled goods* , but the company always takes the offered goods by trusted suppliers as long as it complies with company standard and the price is affordable even though it's not currently need. Thing this conducted so that ingredient raw which there is in warehouse always available for process production.

In Thing purchase, could proved with results analysis following. Source person 1-2, that is owner and supervisor UD. Aneka Plastics, state that when company accept goods especially if goods the originated from suppliers which new, the company entered into an agreement up front that if the goods that will be accepted cannot be used by the company, then goods will returned to supplier which concerned (director). So, automatic goods received must match what the company expects and needs. Company no limit existence delivery ingredient raw from suppliers, but if there are certain raw materials that are still a lot of stock, for example, too much plastic stock, the company will notify the supplier so that did not send the raw materials. The most important in this purchase thing is goods received by the company have standards that match the needs of the company at a price that matches the quality offered. Goods that have been received will be *screened* for see is goods that condition good and could worn. If any item is found to be unsuitable, then the item will be *packed* and returned. the item checked to know who sent and when the goods are sent to the company. So, this shows that the company selects the goods to be worn for produce goods with effective so that The resulting output is good because of the raw materials used already tested quality, like which said by source 1 (Owner UD. Aneka Plastics).

In Thing election supplier, suppliers which trusted by UD. Aneka Plastic originated from area Padangsidimpuan nor outside city, from various type city, such as Kudus, Malang, and many more. Quantity of ingredients The number of raw materials sent by the supplier is *random* and no limit. Because ingredient raw which sent is a *recycled* raw material , so we can't be sure that the company needs how many raw materials then request or order from suppliers in order to send according to the amount required by company. company only receive raw materials sent supplier, how many even the amount. By because that, every time

there is offer ingredient raw from supplier, so company want to buy it provided ingredient raw the in accordance with standard company d an have price affordable. sometimes company no get post ingredient raw same very or can also in a day get delivery five to ten times delivery from the supplier. Usually certain suppliers who are outside city which send ingredient raw very in quantity a lot because the supplier rents trucks. So, the truck must used to transport orders in large quantities large/to the full so that the supplier does not experience loss.

For inventory control, UD. Aneka Plastic every day To do checking to ingredient raw which will worn for process production, is enough for produce 5 until 6 ton rope raffia per day. If inventory has decreased although there is still enough, usually company To do booking ingredient raw to supplier though later amount ingredient raw which obtained does not match the amount desired by the company. Will but, every time there is offer ingredient raw from supplier, company always buy it so that supply Raw materials in the warehouse are still sufficient. This applies to ingredient raw which character *recycle*, that is rote plastic. However, for raw materials such as *PVC shrink* and dye, company can order direct from supplier. For dye, because use goods import, so the company orders directly from distributors in area Padangsidempuan. Company also To do checking to goods so which ready marketed to hand consumers to ensure that no goods arrive undelivered and stuff This is done by the company so that buyer satisfied with service which offered by company. For semi-finished goods, if plastic ore which produced still remaining, so goods half so is stored in the warehouse for the next day. In producing plastic ore, the company produces more many from rope raffia, because have machine pellet service/ATT as much 5 machine, and in produce roperaffia per day, the company produces 5 to 6 tons. So, remainder from ore plastic which not yet produced saved inin warehouse for produced on days next. Thing this conducted by company so that time which used more efficient.

Quality control in question is control of product quality or what we usually talk about QC ( *Quality Controls* ). According to study which conducted by researchers, equipment which worn by UD. Aneka Plastic to make raffia rope is a chopping machine, *mixer* , pellet services/ATT, rope machines, and packaging machines. Machines selected according to function. For companies, quality is not determined by machine which used, which most important is how company use machines and what kind of raw materials are used by company, whether the raw materials are of good quality or no. In Thing ingredient raw, company use good quality raw materials, such as *PVC shrink plastic* for packaging so that the product looks neater and also imported dye. Some of the machines used it is *made in Taiwan* . In this case, the company already apply by effective. According to source person 1 (Owner UD. Aneka Plastics), company no once use people who are experts in quality to solve problem quality. Company use own workforce, because everything is based on knowledge and experience, such as an old and experienced supervisor more understand in Thing quality. Then, employee also doing what which order by supervisor and the results must be good, so that no product returned to employees for repair. Supervisor also teach that quality from something product that important for the survival of the company. So, more supervisors responsive in responding to problems that occur, such as in terms of the engine and the quality of the output produced company. In this case, the supervisor must report to company owner. Besides, of course the owner of the company also take decision which appropriate and related with activity operational company so that activity operational survive for the sake of the company's survival. So, everyone person in in company have will for create product rope raffia which quality.

Company embed *quality ownership* to the employees with method if employee produce output that cannot pass QC ( *quality control* ) owned by the company, then the employee's salary the cut as penalty ( *shock therapy* ) and lessons for employees. In addition, once a month UD. Aneka Plastic stage briefing for employee for wake up employee that if quality output which generated no in accordance with standard company, so sales will automatically decline and this has an impact on employee also. In Thing this, company already do it effectively so that employees are aware the importance of quality. The company has a standard that rope produced must be limp, flexible, strong, have color consistent, and weigh the same. Besides, the length of the roperaffia should not exceed 0.5 grams per meter so that the results not too thick. With this standard, then if there is a product that do not match, the company will definitely fix it and control



production methods starting from machines, raw materials, until source power man company so that company always produce consistent products according to standards. Buyers when going to buy raffia rope produced by UD. Aneka Plastic already knows very well about quality provided and the price is in accordance with the quality. Company give quality which best. Price rope raffia weighing 1 kg is Rp 27,000.00. However, naturally The price is adjusted to the dollar price from year to year year. In this case, the company produces effective because have standard which clear. In Thing *operations control*, the company has implemented it by good and effective.

#### IV. CONCLUSION AND SUGGESTION

##### Conclusion

1. In in UD. Aneka Plastics, could identified that the operational management function has been carried out with good, start from planning operational, scheduling operational, until supervision operational. So, for planning operational, capacity ingredient raw on UD. Aneka Plastic no until advantages and company could arrange capacity machine, power work, and production with Correct. In addition, the company's location is strategic and the location can reachable by industry other, supplier, as well as workforce. Then, the layout on the company already notice convenience and safety for *stakeholders* company. Quality product company have uniqueness and *value* which no could imitated competitors and satisfying buyer. Then, the company's production method is efficient because have standard which clear.

2. For scheduling operational, *Master Production Schedule* which owned company already clear, that is the company can determine which product to more formerly produced and when company will produce that product. Then, for *the Detailed Short-term schedule*, company could have activity proper daily routine to do. Besides that, in terms of *Staff Schedule*, employees within the company could understand distribution *shift* work they with good.

3. In Thing supervision operational, company have good quality control, namely having Good QC (*quality control*). Moreover, in terms of material management, the company has transportation sufficient to deliver the goods to the manufacturer nor consumer and company could Fulfill buyer requests so that buyers always find the goods they ordered must be delivered on time time which properly. Then, company also could keep sufficient stock of raw materials in the warehouse and stock goods so even no until advantages which produced. In addition, the company buys raw materials which quality listen price which in accordance so that produce quality product which best. Company also has many reliable suppliers from the region Padangsidempuan nor outside city. In Thing control inventory, company also To do checking ingredient raw, goods half so, and goods so so that no until deficiency ingredient raw for production and in terms of delivery of goods, also not there are goods that have not been produced so that demand buyer no fulfilled.

4. Company no have structure organization, *job description*, and SOP in writing so it doesn't have standards/rules nor base law which clear.

5. Company no have vision and mission which clear, so that impressed only company only just operate business without want to develop his business so that Becomes company that big.

##### Suggestion

Although by whole, function management operational and control quality management operational on UD. Aneka Plastic already applied with good. However, there are some things that need to be considered for companies, such as:

1. Company should recruit person for made a number of manager part, like manager finance, manager marketing, manager HR, and manager production so that no burdensome director main in decision-making.

2. Company should have *job description* by written for prevent confusion on all parties in the company in understanding what which they do.

3. Provide facility which support like canteen, cafe, or other things because of the atmosphere in the place work is one thing that is very necessary in enhancement performance all person in in company.

4. Employee by no direct also need noticed in in To do his obligations, like give appreciation simple for those who managed to give good performance and succeeded in producing quality products with quality

which in accordance with which expected company.

5. Involvement employee especially in Thing production also need for more upgraded so that no only operate order from supervisor just, but company should grow their enthusiasm to continue learning more about activity operational company. So, if there is employees who want to provide advice as a solution which hinder activity operational company, so Thing that could become consideration for supervisor nor company.

6. Companies need to provide motivation, such as praise and words of encouragement to employees who are work and employees who provide high performance good. Thing this aim so that employee could cultivate *self-confidence* in themselves, so that level error employee in To do production could decrease and could produce good and consistent product quality, as well as in accordance with company standards.

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