

Analysis of Production Process Time Based on The Level of Hardness in The Production Material

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ABSTRACT

Analyzing production process time is a key strategy to enhance efficiency and productivity in manufacturing. This study investigates the relationship between material hardness and processing time across stages like cutting, forming, and finishing. Various materials, including low-carbon steel, high-carbon steel, and alloys, were tested under identical operational conditions. Material hardness was measured using Rockwell and Brinell tests, while production time was recorded for each stage. Results show that higher material hardness leads to longer process times, especially during cutting and forming, due to increased resistance and tool friction. Softer materials, though faster to process, are more prone to deformation. These findings offer valuable insights for manufacturers in selecting materials that balance mechanical properties and efficiency, helping reduce production time, boost productivity, and lower costs without compromising product quality.

KEY WORDS: *production process time, material hardness level, manufacturing efficiency, productivity, material analysis.*

1.0 INTRODUCTION

Efficiency in the production process is one of the main keys to increasing the competitiveness of the manufacturing industry in the face of increasingly tight global competition. One of the factors that affect production efficiency is the mechanical properties of the material used, including its hardness level. The hardness level of the material affects various stages of the production process, such as cutting, shaping, to finishing. Therefore, a deep understanding of the relationship between the hardness level of the material and the production process time is essential to ensure that the production process runs optimally.

Materials with high hardness levels tend to have greater

resistance to deformation, requiring greater effort in the cutting and shaping processes. On the other hand, materials with low hardness levels allow for faster production processes, but can present the risk of unwanted deformation or shape damage. This phenomenon shows a trade-off between the mechanical properties of the material and the efficiency of production time that needs to be analyzed comprehensively.

This study aims to identify the effect of the hardness level of the material on the production process time, focusing on measuring the duration of the process on various types of materials with different hardness levels. By using experimental testing methods, this study is expected to provide beneficial insights for industries in choosing optimal materials, thereby increasing productivity while reducing operational costs.

Through this study, it is also expected to find practical recommendations that can be applied in various industrial sectors, especially those related to material processing. Thus, the results of this study are expected to contribute to the development of more efficient and competitive production strategies.

1.1 Production Process Time

Production process time refers to the duration required to complete the entire production process, from start to finish. This process encompasses various stages, including preparation of raw materials, primary processing (cutting, shaping, assembly), and finishing and packaging. Production process time is a key indicator in evaluating operational efficiency in the manufacturing sector.

Factors influencing production process time include:

1. Material Type: Material characteristics, such as hardness, ductility, and wear resistance, affect process duration, particularly during cutting and shaping stages.
2. Machine and Tool Condition: Well-maintained production machines can significantly reduce process time, while dull or worn-out tools can prolong duration.
3. Product Design: Product design complexity affects the number and type of processes required, thereby influencing overall production time.
4. Operator Skill: Skilled operators can accelerate production processes by minimizing errors and increasing precision in each stage.
5. External Factors: Including raw material availability, supply chain disruptions, or unforeseen technical issues.

Effective management of production process time is crucial

for enhancing efficiency and reducing production costs. By understanding the factors influencing process time, companies can identify areas requiring improvement, such as upgrading tool quality, operator training, or product design optimization. Additionally, process time analysis aids in capacity planning and more accurate scheduling, supporting the smooth operation of manufacturing processes

1.2 Material Hardness Level

Material hardness level is a mechanical property that measures a material's ability to resist permanent deformation due to pressure or friction. Material hardness is often a critical parameter in determining material performance in various applications, particularly in the manufacturing and engineering sectors. Hardness tests are conducted to determine how resistant a material is to scratching, cutting, or shaping.

Methods for measuring material hardness include:

1. Rockwell Test: Measures the depth of penetration of a hard material on the surface of the test material using a specific scale (e.g., HRB for soft metals and HRC for hard metals).
2. Brinell Test: Uses a steel or carbide ball that is pressed onto the material's surface, with the resulting indentation diameter measured.
3. Vickers Test: Employs a small diamond pyramid that is pressed onto the material, suitable for measuring the hardness thin materials or small areas.
4. Mohs Test: Evaluates the relative hardness of a material based on its ability to scratch or be scratched by other materials, using a scale of 1 (talc) to 10 (diamond).

Factors influencing material hardness include:

1. Chemical Composition: The presence of elements in the material, such as carbon in steel, affects its hardness.
2. Production Process: Processes like heat treatment can increase hardness by altering the material's microstructure.
3. Microstructure: Grain size, phase distribution, and material defects influence its mechanical properties.

Material hardness has a direct impact on production processes. Materials with high hardness, such as high-carbon steel or ceramics, typically require specialized tools and longer processing times. Conversely, materials with low hardness are easier to cut or shape but may lack sufficient durability for specific applications. Therefore, material selection based on hardness must consider the balance between ease of processing and desired final performance.

1.3 Manufacturing Efficiency

Manufacturing efficiency is a measure of how well available resources, such as labor, machines, raw materials, and time, are utilized to produce output products according to desired quality standards. A high level of efficiency reflects a production system's ability to maximize output while minimizing waste, whether in terms of time, energy, or materials.

Factors influencing manufacturing efficiency include:

1. Production Process Design: Well-designed processes reduce waiting times, minimize unnecessary movement, and optimize workflows.
2. Machine Maintenance: Regularly maintained machines are more reliable, reduce downtime, and improve production consistency.
3. Resource Management: Efficient utilization of labor and raw

materials reduces production costs without sacrificing product quality.

4. Technology Adoption: Automation and advanced technologies accelerate production processes, increase precision, and reduce human error potential.
5. Material Quality: High-quality materials are easier to process, reduce product damage risk, and improve overall efficiency.
6. Employee Training: Well-trained employees can execute processes quickly and accurately, reducing error and waste potential.

Improving manufacturing efficiency is a top priority for many industries, as it directly impacts profitability and competitiveness. By applying manufacturing efficiency principles, companies can achieve more cost-effective, environmentally friendly, and market-demand-driven production.

1.4 Productivity

Productivity is a measure of the effectiveness in producing output (products or services) from a certain amount of input (such as labor, raw materials, or energy) within a specific time period. High productivity reflects a production system's ability to produce more with the same or fewer resources.

Factors influencing productivity include:

1. Human Resource Quality: Trained and motivated employees significantly contribute to increased productivity through efficient and innovative work.
2. Technology: The use of modern technology can increase production speed and quality, reduce errors, and optimize resource utilization.
3. Work Process: Well-designed processes, including simple and efficient workflows, can accelerate production and reduce waiting times.
4. Working Conditions: A conducive work environment, including safety, comfort, and health aspects, plays a crucial role in enhancing employee performance.
5. Resource Utilization: Optimal utilization of raw materials, energy, and time reduces waste and increases efficiency.
6. Innovation and Development: Companies that continuously innovate in processes and products can increase productivity by creating greater value.

High productivity is a primary goal for many organizations, as it directly relates to competitiveness and business sustainability. By increasing productivity, companies can achieve lower production costs, improve product quality, and better meet market demands.

1.5 Material Analysis

Material analysis is a systematic process for studying, understanding, and evaluating the properties of specific materials to optimize their use in various applications. The materials analyzed can be metals, ceramics, polymers, composites, or other materials with specific properties.

2.0 METHOD

Various analytical methods are employed to understand material characteristics. These methods can be categorized into several primary groups:

1. Mechanical Analysis: Measures strength, hardness, elasticity, and toughness of materials. Examples of tests: Tensile test,

compression test, hardness tests (Brinell, Vickers, Rockwell), and impact test.

2. Chemical Analysis: Identifies the chemical composition of materials. Examples of techniques: Spectroscopy (XRF, FTIR), chromatography, and elemental analysis (ICP-MS).

3. Thermal Analysis: Evaluates thermal properties of materials, such as melting point, thermal conductivity, and heat capacity. Examples of tests: Thermogravimetric analysis (TGA), Differential Scanning Calorimetry (DSC), and dilatometry analysis.

4. Microstructural Analysis: Observes the microstructure of materials to understand the relationship between structure and material properties. Examples of instruments: Optical microscope, electron microscope (SEM, TEM), and X-ray diffraction (XRD).

5. Electrical and Magnetic Analysis: Measures electrical and magnetic properties of materials. Examples of tests: Conductivity tests, resistivity tests, and magnetization properties.

3.0 RESULT

3.1 Impact of Hardness on Machine Time

Materials with higher hardness (e.g., steel alloys, ceramics) showed an increase in machining time by up to 30% compared to softer materials like aluminum or polymers. Tool wear increased significantly when machining high-hardness materials, further slowing the process.

3.2 Forming and Shaping Processes

High-hardness materials required more energy and longer cycle times in forming processes, such as forging or extrusion. Softer materials, such as copper or low-carbon steel, demonstrated faster forming times and better surface finishes.

3.3 Tool Selection and Wear

Carbide and diamond-coated tools were found to perform better when working with hard materials, though they increased initial costs. Improper tool selection for high-hardness materials resulted in frequent tool failures, further increasing downtime.

4.0 DISCUSSION

The result of visual test we can see on the table 1. below.

Table 1. Visual Research Results

Material	Violence (HRC)	Cutting time (second)	Formation time (second)	Completion time (second)
Aluminum	10	10	20	5
Iron	40	30	40	20
Stainless steel	60	50	60	30

Based on the data above, it is evident that there is an increase in processing time as the material hardness level increases. This phenomenon can be attributed to several factors, including:

Cutting: Materials with higher hardness require a greater cutting force, resulting in longer processing times.

Forming: The forming process for hard materials requires more

energy and time to achieve the desired shape.

Finishing: Finishing hard materials requires a more meticulous process to achieve a smooth finish.

5.0 CONCLUSION

An analysis of production processing time based on material hardness levels reveals a significant relationship between the two variables. Materials with higher hardness levels, such as stainless steel, require longer processing times compared to materials with lower hardness levels, such as aluminum. This phenomenon is observed in every stage of the production process, from cutting to forming and finishing.

This study focuses on time analysis within production processes, emphasizing strategies to minimize production time while addressing obstacles that may hinder efficiency. The objective of this journal is to contribute to the global improvement of production efficiency by providing actionable insights. Our findings underscore the importance of meticulous attention to detail in preventing defects and reducing production time. Adhering to deadlines and consistently delivering high-quality products fosters customer satisfaction and trust. For example, completing a product within three days when the expected timeframe is seven days not only exceeds customer expectations but also enhances the likelihood of repeat business. However, it is equally critical to prioritize safety and avoid compromising quality by rushing through the production process. In manufacturing, both time efficiency and product quality are paramount, as they directly influence customer satisfaction and business success. This journal aims to support production teams by offering strategies to optimize time management and achieve a balance between efficiency and quality.

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