ABSTRACT

This study focus on waste identification and analysis, that occurs in the shoes manufacturing at. PT. Asia Dwimitra Industry with the approach of Lean concepts and tools used are Value Steam Mapping. Value Stream Mapping is one of the tools of lean manufacturing concept that focuses on designing the process flow map production, starting from the entry of raw materials to the delivery of product to consumers. The data were collected from observation, interviews and brainstorming with the production team and the supporting team. The results showed there are three types of waste in the line production i.e : Inventory, Over processing and Rework that would affect the numbers of NOS Metrics such as First Time Through (FTT), Built to Schedule (BTS), Lead Time and Productivity. Also the result found that by designing the Future Value Stream Mapping using pull systems and change the inventory models with supermarket system can reduce the production lead time of 2.18 days to 1.75 days.

***Keywords**: Lean Manufacturing, Waste, Value Stream Mapping, NOS Metrics*

ABSTRAK

Penelitian ini fokus pada identifikasi dan analisa pemborosan yang terjadi pada proses pembutan sepatu pada PT. Asia Dwimitra Industri dengan pendekatan konsep *Lean*. *Tools* yang digunakan adalah *Value Stream Mapping* yang merupakan salah satu *tools* dari konsep *lean manufacturing* yang menitikberatkan pada pembuatan peta aliran proses produksi mulai dari masuknya bahan baku sampai pada pengiriman hasil produksi kepada konsumen. Data penelitian didapatkan dari observasi, wawancara dan *brainstorming* dengan tim produksi dan tim support produksi. Hasil penelitian menunjukan bahwa ditemukan 3 jenis pemborosan yaitu *inventory*, *over processing* dan *rework* yang tentunya mempengaruhi angka NOS *Metrics* seperti *First Time Through* (FTT), *Built to Schedule* (BTS), *Lead Time* dan Produktivitas. Perancangan *Future Value Stream Mapping* dengan menggunakan sistim tarik (*pull system*) dan merubah model *inventory* dengan sistem supermarket dapat mengurangi *lead time* produksi dari 2,18 hari menjadi 1.75 hari.

Kata Kunci: *Lean Manufacturing, Waste, Value Stream Mapping, NOS Metrics*