

ABSTRAK

PT Cipta Kreasindo merupakan perusahaan yang memproduksi berbagai aksesoris rumah, salah satunya yaitu *Spring Bed*. Dalam pelaksanaan produksinya, ditemukan beberapa kali penundaan pengiriman produk kepada pelanggan diakibatkan pembuatan produk *work in process Spring Bed* mengalami keterlambatan. Dengan menggunakan pendekatan Lean Manufacturing, dihasilkan beberapa perbaikan antara lain menerapkan system produksi menjadi *pull system*, mereduksi *waste of motion* serta *waste of inventory* sebesar 54,63 %. Perbedaan *lead time* antara *current state mapping* dengan *future state mapping* pada produksi *work in process RAM PER* pada *current state mapping* sebesar 319680 detik dan pada *future state mapping* sebesar 86400 detik atau turun sebesar 233280 detik dan untuk proses Quilt pada *current state mapping* sebesar 440640 detik dan pada *future state mapping* sebesar 236040 detik atau turun sebesar 204600 detik. Mengoptimalkan proses RAM PER sebesar 27,29% dan proses Quilt sebesar 53,97%.

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



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ABSTRACT

PT Cipta Kreasindo Gracia is a company that produces various home accessories, one of them is spring bed. In the implementation of its production, it was found several times the delay of product delivery to customers due to delays in the manufacture of work in process product. By using the lean manufacture approach, several improvements were produced including the application of a pull production system, reducing the waste of motion and waste of inventory by 54,63 %. Difference in lead time between current state mapping and future state mapping at production *work in process RAM PER* at *current state mapping* as big as 319680 second and *future state mapping* as big as 86400 second or reduce about 233280 second and for the process Quilt at *current state mapping* as big as 440640 second and *future state mapping* as big as 236040 second or reduce about 204600 second. Optimizing process RAM PER about 27,29% and process Quilt about 53,97%.

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