

ABSTRAK

Penelitian ini untuk mengidentifikasi dan mengeliminasi *waste* untuk mengurangi *leadtime production* pada area produksi PRO 62 pada PT Universal Tekno Reksajaya. Penelitian ini menggunakan konsep *lean manufacturing* dengan menggambarkan aliran informasi dan material pada *value stream*. *Current Value stream mapping* dapat membantu memudahkan dalam pengambilan keputusan. *Proposed value stream mapping* dapat membantu dalam pengambilan keputusan. Hasil penelitian memperlihatkan bahwa dengan implementasi *value stream mapping*, terdapat 4 jenis *waste* yang teridentifikasi yaitu *waste product defect*, *waiting time*, *unnecessary inventory*, dan *motion*. Berdasarkan *proposed value stream mapping*, total *cycle time* berkurang dari 69,22 jam menjadi 67,72 jam atau berkurang sebanyak 1,5 jam. *Production leadtime* berkurang dari 37 hari menjadi 28 hari atau berkurang sebanyak 5 hari. Jarak *transportasi* berkurang dari 10 km menjadi 2,5 km atau berkurang sebanyak 7,5 km.

Kata Kunci : *Waste, Leadtime Production, Lean Manufacturing, Value Stream Mapping*



ABSTRACT

This research is conducted to identify and eliminate waste to reduce leadtime production in the production area PRO 62 at PT Universal Tekno Reksajaya. This research uses the concept of lean manufacturing by describing the flow of information and material in the value stream. Current Value stream mapping can help facilitate decision making. Proposed value stream mapping can help in making decisions even easier. The results of this research indicated that with the implementation of value stream mapping there are 4 types of waste identified, specifically defect waste product, waiting time, unnecessary inventory, and motion. Based on the proposed value stream mapping, the total cycle time reduced from 69,22 hours to 67,72 hours or reduced by 1.5 hours. Production leadtime has been reduced from 37 days to 28 days or reduced by 5 days. Transportation distance reduced from 10 km to 2.5 km or reduced by 7.5 km.

Keywords: Waste, Leadtime Production, Lean Manufacturing, Value Stream Mapping



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