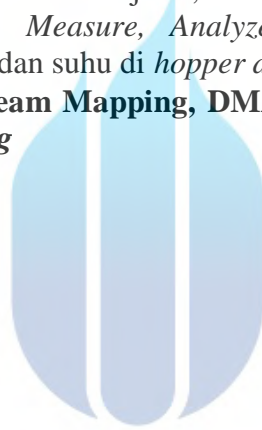**ABSTRAK**

PT. Suzuki Indomobil Motor merupakan perusahaan otomotif terkemukaka di Indonesiayang menghasilkan produk berupa mobil dan motor, fenomena kualitas yang terjadi selama bulan Januari 2019 di PT. Suzuki Indomobil Motor terdapat tingginya defect *silver streak* di *section injection molding* sebanyak 169 pcs *garnish back door license* yang berda pada mesin injeksi A02. Dengan fenomena tersebut maka penelitian ini bertujuan untuk mengetahui proses *injection molding* menggunakan *value stream mapping* dan meningkatkan kualitas produk *garnish back door license* dengan metode DMAIC (*Define, Measure, Analyze, Improve, Control*). Hasil yang diperoleh menunjukkan bahwa terdapat *changeover time dies* di mesin A02 yang tinggi yaitu sebesar 57.15 menit dengan nilai uptime dan diperoleh jenis *defect* tertinggi dengan menggunakan diagram pareto yaitu *defect silver streak* dengan persentase sebesar 43%. Maka dari rekomendasi yang diperoleh dengan menggunakan *value stream mapping* untuk meminimalisir *changeover time dies* mesin A02 yaitu dengan melakukan pemanasan dies terlebih dahulu sebelum dies naik ke mesin injeksi, dan rekomendasi yang diperoleh dari metode DMAIC (*Define, Measure, Analyze, Improve, Control*) yaitu dengan pengontrolan stok material dan suhu di *hopper dryer*.

Kata Kunci   : Value Stream Mapping, DMAIC (*Define, Measure, Improve, Control), Injection Molding*

ABSTRACT

PT. Suzuki Indomobil Motor is a leading automotive company in Indonesia that produces products in the form of cars and motorcycles, a quality phenomenon that occurred during January 2019 at PT. Suzuki Indomobil Motor there is a high silver streak defect in the injection molding section with 169 back door license garnishes that are attached to the A02 injection engine. With this phenomenon, this study aims to determine the injection molding process using value stream mapping and improve the quality of the garnish back door license products using the DMAIC method (Define, Measure, Analyze, Improve, Control). The results obtained showed that there was a changeover time dies on the Machine A02 that was as high as 57.15 minutes with uptime values and the highest type of defect was obtained using the pareto diagram namely silver streak defect with a percentage of 43%. So from the recommendations obtained by using the value stream mapping to minimize the changeover time dies of the Machine A02, namely by heating the dies first before dies go up to the injection machine, and recommendations obtained from the DMAIC method (Define, Measure, Analyze, Improve, Control) that is by controlling the stock of material and temperature in the hopper dryer.

Keywords: Value Stream Mapping, DMAIC (Define, Measure, Improve, Control), Injection Molding

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