ABSTRAK

Pipe pillion r.l assy merupakan salah satu komponen *part* yang berada pada bagian kerangka sepeda motor yang diproduksi oleh PT AAP. Berdasarkan *performance report delivery*, *delivery part* ke *customer* selalu mengalami keterlambatan yang dikarenakan tidak tercapainya hasil *plainning* produksi dan jumlah *leadtime* yang tinggi pada lantai produksinya. *Pipe pillion r.l assy* diproduksi oleh 9 *workstation* yang dimana terdapat 69 aktivitas dalam produksinya dari 69 aktivitas terdapat aktivitas *value added* sebesar 37 aktivitas dan 32 aktivitas *non value added* dengan jumlah *cycle time* sebesar 435,54 detik, *travel distance* sebesar 261 meter dan jumlah *lead time* sebesar 2,161 hari.Oleh karena itu harus segera melakukan evaluasi dan perbaikan terhadap proses produksi yang berlangsung. Metode yang digunakan dalam penelitian ini adalah *value stream mapping* yaitu ruang lingkup dari *lean manufacturing* untuk melihat aliran material dan informasi produk yang berjalan dari mulai dari bentuk raw material hingga produk final sampai ditangan pelanggan dimana terjadinya masalah. Tujuan penelitian ini adalah mengetahui penyebab kegagalan proses produksi dalam pencapaian target *plainning*. Setelah dilakukan analisis dengan *kaizen blitz* maka terdapat 5 faktor menyebabkan kegagalan yang harus diperbaiki yaitu, aktivitas pada setiap *workstation*, *workstation cutting celculer part pipa pillion r step k81a*, *workstation cutting celculer part pipa pillion l step*, *workstation poles* dan jarak *handling* antar *workstation*. Maka upaya perbaikan berdasarkan *forum group discussion* (FGD) adalah dengan: *improvement activity* pada setiap aktivitas *workstation* (*Workstation blank pierching*: pembuatan rak penempatan material plate pita, *workstation bending*: pembuatan *shooter*, *worstation bending hamming*: pembuatan *shooter*, *workstation marking*: pembuatan *shooter*, *workstation assemblies*: pembuatan rak wip material), *improvement workstation cutting*: pembuatan *dies proggresif* untung pemakaian proses cutting dimesin stamping, *improvement workstation poles*: menghilangkan aktivitas proses poles, *improvement* jarak *handling* antar *workstation*: perubahan *layout* mesin produksi, pembuatan *rak dies* diarea gedung 1 *departement press*. Setelah dilakukannya *improvement* dengan menggunakan *value stream mapping* dimana jumlah *cycle time* menjadi 79,82 detik atau turun sebesar 355,72 detik, jumlah *lead time* menjadi 0,202 atau turun sebesar 1,959 hari dan jumlah *travel distance* menjadi 36 meter atau turun sebesar 225 meter.

Kata Kunci: *Pipe Pillion R.L Assy. Target Plainning. Lead Time. Value Stream Mapping. Kaizen Blitz. Focus Group Discussion* (FGD).

ABSTRACT

Pipe pillion R. L ASSY is one part component that is located in the framework of the motorcycle manufactured by PT AAP. Based on performance report delivery, delivery part to customer always experienced delay due to not achieving the result of plainning production and high leadtimes number on the production floor. Pipe pillion R. L ASSY produced by 9 workstations that there are 69 activities in the production of 69 activity there is activity Value added of 37 activity and 32 activities non value added with the amount of cycle time of 435.54 seconds, travel distance of 261 meters and the number of lead time of 2.161 days. Therefore, it should immediately evaluate and repair the ongoing production process. The method used in this research is value stream mapping that is the scope of Lean manufacturing to see the flow of material and product information that runs from the raw material form to the final product until the customer's return where the problem occurs. The purpose of this research is to know the cause of the production process failure in achieving plainning. After analysis carried out with Kaizen Blitz Then there are 5 factors causing the failure to be repaired IE, activity on each workstation, workstation cutting Celculer part pipe pillion R step k81a, workstation cutting Celculer part pipe pillion l Step, workstation polishing and distance handling between workstations. Then the improvement efforts based on the Forum Group discussion (FGD) is with: improvement activity on each workstation activity (workstation blank pierching: Material placement rack of materials plate ribbon, bending workstation: shootermaking, worstation bending hamming: shootermaking, workstation marking: shootermaking, belts workstation : Material WIP shelf manufacturing), improvement Workstation cutting: Manufacture of dies Proggresif Profit cutting process in stamping machine, improvement Workstation polishing: Eliminating process activity polishing, improvement distance handling between workstations: Change of machine layout production, manufacture of rack dies in area Building 1 departement Press. After the improvement by using the value stream mapping where the number of cycle time to 79.82 seconds or down by 355.72 seconds, the number of leads time to be 0.202 or down by 1.959 days and the number of travel distance to 36 meters or down by 225 meters.

Keyword: *Pipe pillion R. L assy. Target plainning. Lead Time. Value Stream Mapping. Kaizen Blitz. Focus Group Discussion* (FGD).

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