

ABSTRACT

In globalization era, efforts world developing such its quick. It happens along with getting quick it science and technology developing. Increase emulation in world effort which gets tight cause job the world charge most actually more production factor qualified. Its main philosophy is cooperative across team function. Momentously to been remembered is becoming quick lead time, becoming competitive one firm. More fast one service costs to make customer than service that slows. Firm who can satisfy its customer with faster product hand over appealed by its competitor will can withstand and that can't therefore will ignored. So to be able to gets lead time one that is needed, one can maybe waste whatever available lessened or removes to be substituted by activity that have (value added). Method that is utilized to reduce tool commutation time this is by perform one of tool of Lean Manufacturing Concept which is (Single Minute Exchange of Dies) SMED. This concept implement can reduce time changeover until 80% of previous even maybe can more. SMED constitutes a moderation of process already walk, constituting method to reduce the duration commutation time tools, dies, or working equipment. To increase capacity, making flexible production system in faces changing requisition, press inventory, increasing quality and reducing lead time.

Key words: lead time, waste, value added, tools's replacement, dies, Single Minute Exchange of Dies (SMED), capacity, inventory

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