

ABSTRAK

PT Manufaktur Ban merupakan salah satu perusahaan manufaktur di Indonesia yang memproduksi ban. Berdasarkan data dari departemen produksi, terdapat ketidaksesuaian jumlah produksi antara kapasitas mesin Building line 11 dengan kapasitas mesin Automatic Inner & Outer Paint. Selama periode Januari – Juni 2022, rata-rata jumlah produksi yang dihasilkan oleh mesin Building sebanyak 3.780 pcs ban/hari. Sedangkan rata-rata jumlah produksi yang dihasilkan oleh mesin Automatic Inner & Outer Paint hanya sebanyak 3.069 pcs ban/hari. Pengidentifikasi pemborosan (*waste*) atau aktivitas yang tidak bernilai tambah dilakukan dengan mengintegrasikan *Value Stream Mapping* (VSM) & *Value Stream Mapping Analysis Tools* (VALSAT). Tahap analisa dilakukan dengan menyebarkan kuesioner pemborosan (*Seven Waste Relationship*) kepada responden dan dilanjutkan dengan perhitungan penilaian pemborosan. Kemudian dilakukan identifikasi *waste* lebih lanjut menggunakan metode VALSAT. Hasil analisa didapatkan *waste* yang berpengaruh adalah *transportation* dan *waiting* yang terdapat pada proses *transfer lorry* ke *storage next process*. Perbaikan yang dilakukan dengan perubahan matrix kompetensi operator untuk penambahan serviceman untuk membantu proses *transfer lorry*. Dari hasil perbaikan diperoleh penurunan waktu proses dari sebelumnya 450 detik menjadi 87 detik. Sehingga kapasitas produksi mesin mengalami kenaikan dari 1.040 pcs/shift (3.120 pcs/hari) menjadi 1.323 pcs/shift (3.969 pcs/hari).

Kata Kunci: Ban, *Waste*, *Value Stream Mapping*, VALSAT

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ABSTRACT

PT Manufacturing Tires is one of the manufacturing companies in Indonesia that produces tires. Based on data from the production department, there is a discrepancy in the amount of production between the capacity of the building line 11 machine and the capacity of the Automatic Inner & Outer Paint machine. During the period January – June 2022, the average number of production produced by Building machines was 3,780 tires/day. Meanwhile, the average amount of production produced by the Automatic Inner & Outer Paint machine is only 3,069 pcs of tires/day. Identification of waste or non-value-added activities is carried out by integrating Value Stream Mapping (VSM) & Value Stream Mapping Analysis Tools (VALSAT). The analysis phase is carried out by distributing waste questionnaires (Seven Waste Relationship) to respondents and followed by calculating waste assessments. Then further waste identification is carried out using the VALSAT method. The results of the analysis show that the influential waste is transportation and waiting which are contained in the transfer lorry process to the next storage process. Improvements were made by changing the operator competency matrix to add servicemen to assist the lorry transfer process. From the results of the improvement obtained a decrease in processing time from previously 450 seconds to 87 seconds. So that the production capacity of machines has increased from 1,040 pcs/shift (3,120 pcs/day) to 1,323 pcs/shift (3,969 pcs/day).

Keywords: Tire, Waste, Value Stream Mapping, VALSAT

