

## ABSTRAK

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Judul Laporan Skripsi : Perbaikan Pemborosan Waktu Dengan Metode VSM Pada Proses Produksi Jus *Pink Guava* (Studi Kasus Industri Jus di Tangerang)  
Pembimbing : Dr. Hasbullah, ST, MT

Industri jus adalah industri manufaktur yang fokus bergerak dibidang pengolahan minuman jus, sirup, *consentreact*, dan selai yang berasal dari bahan baku buah asli, dan salah satu produk yang paling banyak diproduksi adalah jus *pink guava*. Alur produksi jus *pink guava* yaitu preparasi *puree*, homogenisasi, *mixing*, *QC*, *filling*, penutupan botol, *capping* dan *inkjection*, *sealing*, pendinginan, pelabelan, dan penyusunan produk. Permasalahan yang terjadi adalah pemborosan waktu pada proses produksi jus *pink guava*. Tujuan penelitian ini yaitu mengetahui hasil pemetaan *current state map*, mengidentifikasi faktor penyebab pemborosan waktu, dan memberikan usulan perbaikan dan membuat hasil pemetaan *future state map*. Metode yang digunakan adalah *lean manufacturing* dengan *tools value stream mapping* dan *cause and effect diagram*. Pengolahan data yang dilakukan yaitu menghitung waktu siklus, uji keseragaman data, uji kecukupan data, waktu nornal, dan waktu baku. Dari hasil pengolahan tersebut didapatkan hasil *current state map* sebesar 10915,98 detik (75,7%) dan *future state map* sebesar 9089,6 detik (81,07%). Dan diketahui 3 jenis pemborosan yaitu *waiting*, *defect* karena produk bocor dan produk tumpah. Identifikasi faktor penyebab dengan *cause and effect diagram* diketahui 3 faktor penyebab yaitu mesin, manusia, dan material.

**Kata Kunci** : Pemborosan Waktu, *Lean Manufacturing*, *Value Stream Mapping*, *Cause And Effect Diagram*, Jus *Pink Guava*

## ABSTRACT

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Title Thesis : *Improvement of Time Wasting with the VSM Method  
Pink Guava Juice Production Process (Case Study of Juice  
Industry in Tangerang)*  
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*Juice Industry is a manufacturing industry that focuses on processing juice, syrup, concentrate, and jam drinks derived from real fruit raw materials, and one of the most produced products is pink guava juice. The production flow of pink guava juice is puree preparation, homogenization, mixing, QC, filling, bottle closing, capping and injection, sealing, cooling, labeling, and product preparation. The problem that happened was the waste of time in the production process of pink guava juice. The objectives of this research are to determine the results of the current state map, identify the factors that cause time waste, and provide suggestions for improvement and create future state map mapping results. The method used is lean manufacturing with value stream mapping and cause and effect diagram tools. Data processing is done by calculating cycle time, data uniformity test, data sufficiency test, normal time, and standard time. From the processing results, the current state map is 10915.98 seconds (75.7%) and the future state map is 9089.6 seconds (81.07%). And 3 types of waste are known, such as waiting, defects due to leaking products and spilled products. Identification of causal factors with cause and effect diagrams is known to be 3 causal factors, which are machines, people, and materials.*

**Keywords:** *Wasting Time, Lean Manufacturing, Value Stream Mapping, Cause And Effect Diagram, Pink Guava Juice*