

PERANCANGAN *LEAN MANUFACTURING* PADA PRODUKSI *REAR BAR TRD* PT LAKSANA TEKHNIK MAKMUR

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ABSTRAK

PT Laksana Teknik Makmur (LTM) perlu memperhatikan proses produksinya untuk meminimalkan pemborosan. Salah satu jenis produk yang diproduksi adalah *rear bar TRD*. Pada produksi ini terdapat jenis *waste* lainnya seperti *waste of transportation, waiting, defect, inventories, over processing, dan motions*. Permasalahan *waste* tersebut ditimbulkan akibat proses produksi yang kurang terkontrol seperti kesalahan tata letak fasilitas, alur proses berantakan, kurangnya alat bantu *material handling*, terdapat barang tidak terpakai di area produksi, *defect*, proses yang dikerjakan di vendor luar perusahaan, dll. Selain itu terdapat juga aktivitas yang tidak bernilai tambah seperti *waiting, rework, dan perpindahan barang yang berlebih*. Permasalahan tersebut membuat *cycle time* produksi menjadi 123782 detik. Untuk mengurangi *cycle time* dan menghilangkan *waste* dilakukan penerapan metode *lean manufacturing* yaitu *kaizen, 7 waste kuesioner, BPM, VALSAT, PAM, perancangan tata letak fasilitas, dan fishbone diagram*. Dengan menggunakan metode tersebut ditemukan usulan perbaikan sehingga *waste* produksi dapat dihilangkan, *cycle time* dapat dikurangi menjadi 7727 detik, waktu NNVA dari 9589 detik menjadi 2314 detik, dan menghapus waktu NVA sebesar 108780.

Kata kunci: *Lean manufacturing, waste, cycle time, PAM, BPM, VALSAT*

**DESIGN OF LEAN MANUFACTURING IN PRODUCTION OF REAR BAR
TRD PT LAKSANA TEKHNİK MAKMUR**

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ABSTRACT

PT Laksana Teknik Makmur (LTM) needs to pay attention to its production process to minimize waste. One type of product that is produced is the TRD rear bar. In this production there are other types of waste such as waste of transportation, waiting, defects, inventories, over processing, and motions. These waste problems are caused by uncontrolled production processes such as facility layout errors, messy process flows, lack of material handling tools, unused goods in the production area, defects, processes carried out at vendors outside the company, etc. In addition, there are also non-value-added activities such as waiting, rework, and excess movement of goods. These problems make the production cycle time to 123782 seconds. To reduce cycle time and eliminate waste, lean manufacturing methods are applied, namely kaizen, 7 waste questionnaires, BPM, VALSAT, PAM, facility layout design, and fishbone diagrams. By using this method, proposed improvements are found so that production waste can be eliminated, cycle time can be reduced to 7727 seconds, NNVA time from 9589 seconds to 2314 seconds, and remove NVA time of 108780.

Keywords: *Lean manufacturing, waste, cycle time, PAM, BPM, VALSAT*