

**PENERAPAN *LEAN MANUFACTURING* UNTUK MENGURANGI
PEMBOROSAN PADA PRODUKSI BATA ABU POLOS
DI PABRIK PAVING XYZ**

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ABSTRAK

Pabrik Paving XYZ merupakan salah satu pabrik yang memproduksi bata abu polos dikawasan kranggan, Bekasi. Pada proses produksi ditemukan adanya aktivitas yang tidak memberikan nilai tambah serta ditemukan adanya produk yang cacat. Metode *lean manufacturing* dengan kuesioner *7 waste*, VALSAT, VSM, FMEA, Fishbone Diagram, dan melakukan simulasi sistem usulan digunakan agar dapat mengurangi permasalahan yang ditemukan. Berdasarkan hasil dari pengolahan data didapatkan 3 pemborosan terbesar mulai dari produk cacat dengan nilai rata-rata pembobotan sebesar 4,25, transportasi berlebih dengan nilai rata-rata pembobotan sebesar 3,75, dan produksi berlebih dengan nilai rata-rata pembobotan sebesar 3,63. Hasil simulasi usulan didapatkan persentase peningkatan rata-rata *output* produksi bata abu polos sebesar 11,2%.

Kata Kunci : *Lean Manufacturing*, Pemborosan, Proses Produksi, Simulasi

**APPLICATION OF LEAN MANUFACTURING TO REDUCE WASTE IN
THE PRODUCTION OF PLAIN ASH BRICK
AT XYZ PAVING FACTORY**

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ABSTRACT

XYZ Paving Factory is one of the factories that produces plain ash bricks in the Kranggan area, Bekasi. In the production process, there were activities that did not provide added value and defective products were found. Lean manufacturing method with 7 waste questionnaire, VALSAT, VSM, FMEA, Fishbone Diagram, and perform system simulation used in order to reduce the problems found. Based on the results of data processing, it was found that the 3 biggest wastes were from defective products with an average weighting value of 4.25, an increase in excess with an average weighting value of 3.75, and excess production with an average weighting value of 3.63. . The results of the supply simulation show the percentage increase in the average production output of plain ash bricks by 11.2%.

Keywords : *Lean Manufacturing, Waste, Production, Simulation*