

ABSTRAK

Waste merupakan kegiatan yang menyerap atau memboroskan sumber daya seperti pengeluaran biaya ataupun waktu tambah tetapi tidak menambah nilai apapun dalam kegiatan tersebut, setiap proses produksi memiliki peluang terjadinya *waste* seperti halnya yang terjadi di PT. Saranacentral Bajatama Tbk., untuk menghindari atau meminimalisir terjadinya *waste* tersebut maka perlu dilakukan analisis *waste*, penelitian ini menggunakan pendekatan *Lean Manufacturing* untuk mengetahui penyebab *waste* yang terjadi di proses produksi mesin *Shearing* dan *Corrugating* sehingga potensi penyebab *waste* dapat diminimalisir dan target produksi optimal. Dari data produksi PT. Saranacentral Bajatama Tbk. jumlah order produksi per bulan mencapai 160.000 lembar untuk mesin *Shearing* dan 100.000 lembar untuk mesin *Corrugating* belum dapat tercapai karena terjadinya *waste* di departemen produksi, dalam waktu 3 (tiga) bulan jumlah produk *reject* mesin *Shearing* mencapai 668 lembar dan *setting* mesin rata-rata 15 menit, sedangkan mesin *Corrugating* menghasilkan produk *reject* mencapai 798 lembar dan *setting* mesin rata-rata 8 menit, agar mampu memenuhi kebutuhan pasar sekarang pihak manajemen harus bisa meningkatkan kapasitas produksinya minimal 15 % dari output saat ini.

Berdasarkan hasil penelitian, didapatkan jenis *waste* yang paling sering terjadi di mesin *Shearing* adalah *Waiting : Setting* mesin (37,39%), *Transportation* (26,64%), *Defective parts* (23,90%) dan *Waiting : Crane* (12,06%). Sedangkan untuk mesin *Corrugating* *waste* yang sering terjadi adalah: *Waiting : Setting* mesin (38,60%), *Defective parts* (32,49%), *Waiting : Crane* (15,42%) dan *Transportation* (13,49%). *Mapping tools* yang digunakan ke dalam matriks VALSAT adalah *Process Activity Mapping* (33,62%) dan (26,09%). Setelah dilakukan perbaikan nilai *Value Added Ratio* (VAR) mesin *Shearing* bertambah (16,39%) dan untuk mesin *Corrugating* setelah dilakukan tindakan perbaikan nilai *Value Added Ratio* (VAR) bertambah (13,46%).

Kata kunci : *Lean Manufacturing*, *Waste*, *Value Stream Mapping*, *Shearing* *Corrugating*.

ABSTRACT

Waste is an activity that absorbs or wastes resources such as expenses or time added but does not add any value in the activity, each production process has the opportunity for waste as is the case in PT. Saranacentral Bajatama Tbk., To avoid or minimize the occurrence of waste, it is necessary to do a waste analysis, this study uses the Lean Manufacturing approach to determine the causes of waste that occur in the production process of Shearing and Corrugating machines so that the potential causes of waste can be minimized and optimal production targets. From the production data of PT. Saranacentral Bajatama Tbk. the number of production orders per month reached 160,000 sheets for Shearing machines and 100,000 sheets for Corrugating machines could not be achieved due to waste in the production department, within 3 (three) months the number of Shearing machine reject products reached 668 sheets and the machine settings averaged 15 minutes Meanwhile, the Corrugating machine produces reject products reaching 798 sheets and setting the machine an average of 8 minutes, in order to be able to meet market needs now the management must be able to increase its production capacity by at least 15% of the current output.

Based on the results of the study, it was found that the type of waste that most often occurs in the Shearing machine is Waiting: Machine setting (37,39%), Transportation (26,64%), Defective parts (23,907%) and Waiting: Crane (12,06%) Whereas for waste Corrugating machines that often occur are: Waiting: Machine setting (38.60%), Defective parts (32,49%), Waiting: Cranes (15.42%) and Transportation (13,49%). Mapping tools used in the VALSAT matrix are Process Activity Mapping (33,62%) and (26,09). After repairs to the value of the Value Added Ratio (VAR) of the Shearing machine increased (16.39%) and for the Corrugating machine after the corrective action the value of Value Added Ratio (VAR) was increased (13.46%).

Keywords: Lean Manufacturing, Waste, Value Stream Mapping, Shearing Corrugating.