

ABSTRAK

Penelitian ini membahas tentang identifikasi serta eliminasi *waste* di industri otomotif untuk meningkatkan produktivitas serta mengoptimalkan sumber daya yang ada pada proses produksi. Tujuan dilakukannya penelitian ini adalah untuk mengidentifikasi *waste* pada proses produksi, proses identifikasi *waste* dilakukan dengan metode *waste assessment model* dengan tujuan menyederhanakan pencarian permasalahan dan obyektifitas penelitian, selanjutnya untuk menentukan *tools* yang tepat dalam melakukan analisis dan eliminasi *waste* secara lebih detail digunakan metode *value stream analysis tools*. Hasil dari penelitian ini adalah teridentifikasi 3 *waste* terbesar di finishing line yaitu *waste defect* dengan persentase 20.61% kemudian *waste over production* dengan persentase 16.3 % serta *waste inventory* dengan persentase 15.3 % berdasarkan metode *waste assessment model*. Selanjutnya berdasarkan metode *value stream analysis tools*, *process activity mapping* menempati urutan pertama dengan persentase 32.96%. Rekomendasi perbaikannya adalah penggabungan *quality control* inspeksi 1 dan *quality control sampling* inspeksi *crack* pada proses produksi fly wheel dan big hub dengan *relay* line finishing big hub serta menerapkan konsep FIFO pada penempatan dan pengambilan produk WIP. Metode *waste assessment model* dan *value stream analysis tools* menjadi salah satu usulan dalam mengidentifikasi serta mengeliminasi *waste* di finishing line PT Asian Isuzu Casting Center.

Kata kunci : *waste assesment model*, *waste relationship matrik*, *waste assessment questionnaire*, *value stream analysis tools*.

ABSTRACT

This research discusses the identification and elimination of waste in the automotive industry to increase productivity and optimize existing resources in the production process. The purpose of this research is to identify waste in the production process, the waste identification process is carried out by using the waste assessment model method to simplify the search for problems and research objectivity. furthermore, to determine the appropriate tools for analyzing and eliminating, waste in more detail the value stream analysis tools method is used. The results of this study were identified the 3 largest wastes in the finishing line, namely, defect waste with a percentage of 20.61 %, waste overproduction with a percentage of 16.3%, and waste inventory with a percentage of 15.3%. The result was conducted based on the waste assessment model method. Furthermore, based on the value stream analysis tools method, the activity mapping process ranks the first with a percentage of 32.96%. The recommendation is affiliated quality control inspection 1 and quality control sampling crack inspection in the fly wheel and big hub production processes with the big hub finishing line re layout and applying the FIFO concept in the placement and collection of WIP products. The waste assessment model and value stream analysis tools method is one of the suggestions in identifying and eliminating waste in the finishing line of PT. Asian Isuzu Casting Center.

Keyword : waste assesment model, waste relationship matrik, waste assessment questionnaire, value stream analysis tools.