

ABSTRAK

PENDEKATAN *LEAN MANUFACTURING* MENGGUNAKAN METODE *COST INTEGRATED VALUE STREAM MAPPING* GUNA MENGURANGI WASTE DI LANTAI PRODUKSI BULU MATA PALSU (Studi Kasus : PT. Hyup Sung Indonesia)

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PT. X merupakan industri manufaktur yang memproduksi bulu mata palsu. Pada perusahaan terdapat permasalahan yang mengakibatkan terjadinya permasalahan output. Ketidakstabilan pada output produksi dikarenakan adanya permasalahan waste dalam proses produksi bulu mata palsu. Seperti adanya produk *defect*, *waiting process* dan *Inappropriate processing*. Dari permasalahan yang dihadapi PT. X, maka dibutuhkan suatu penyelesaian untuk mengurangi pemborosan dilantai produksi dengan menggunakan pendekatan *lean manufacturing*. Dengan mengintegrasikan metode *Activity Based Costing* (ABC) di dalam aliran *Value Stream Mapping* (VSM), menghitung hasil waste terbesar dengan metode *Value Stream Analysis Tools* (VALSAT) dan menggunakan *Root Cause Analysis* (RCA) kemudian, mengusulkan rekomendasi perbaikan. Rekomendasi perbaikan yang diberikan antara lain, penerapan *continuous flow*, penggabungan kerja, dan pengiriman bahan baku seminggu sekali. Hasil dari perbandingan antara *current* dan *future cost integrated value stream mapping* adalah *production lead time* berkurang dari 0,5 hari menjadi 0,36 hari, kemudian *total value added cost* dari Rp. 2.049 menjadi Rp. 1.561 dan untuk *total non value added cost* dari Rp. 12.754 menjadi Rp. 11.243 selanjutnya untuk *travel distance* dari 99 meter menjadi 79 meter.

Kata kunci: *lean manufacturing; value stream mapping; activity based costing; value stream analysis tools*

ABSTRACT

LEAN MANUFACTURING APPROACH USING COST INTEGRATED VALUE STREAM MAPPING METHOD TO REDUCE WASTE IN FALSE EYELASHES PRODUCTION FLOOR (Case Study : Pt. Hyup Sung Indonesia)

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PT. X is a manufacturing industry that produces false eyelashes. In the company there are problems that result in output problems. Instability in production output is due to waste problems in the false eyelashes production process. Such as product defects, waiting process and inappropriate processing. From the problems faced by PT. X, then a solution is needed to reduce waste on the production floor using a lean manufacturing approach. By integrating the Activity Based Costing (ABC) method in the Value Stream Mapping (VSM), calculating the largest waste using the Value Stream Analysis Tools (VALSAT) method and using Root Cause Analysis (RCA) then, proposes recommendations for improvement. The recommendations for improvement include the application of continuous flow, work combinations, and delivery of raw materials once a week. The result of the comparison between current cost integrated value stream mapping and future cost integrated value stream mapping is that the production lead time is reduced from 0.5 days to 0.36 days, then the total value added cost from Rp. 2.049 to Rp. 1.561 and for the total non value added cost of Rp. 12.754 to Rp. 11.243 then for the travel distance from 99 meters to 79 meters.

Keywords: *lean manufacturing; value stream mapping; activity based costing; value stream analysis tools*