

## DAFTAR ISI

|  |      |
|--|------|
| PERNYATAAN KEASLIAN .....                                  | ii   |
| SURAT KETERANGAN PENELITIAN.....                           | iii  |
| LEMBAR PENGESAHAN PEMBIMBING.....                          | iv   |
| LEMBAR PENGESAHAN PENGUJI.....                             | v    |
| HALAMAN PERSEMBAHAN .....                                  | vi   |
| HALAMAN MOTTO.....   | vii  |
| KATA PENGANTAR .....                                       | viii |
| ABSTRAK.....   | x    |
| DAFTAR ISI.....  | xi   |
| DAFTAR TABEL.....  | xiii |
| DAFTAR GAMBAR.....   | xiv  |
| DAFTAR LAMPIRAN.....                                       | xv   |
| BAB I PENDAHULUAN.....                                     | 1    |
| 1.1 Latar Belakang .....                                   | 1    |
| 1.2 Rumusan Masalah .....                                  | 3    |
| 1.3 Batasan Masalah.....                                   | 3    |
| 1.4 Tujuan Penelitian .....                                | 4    |
| 1.5 Manfaat Penelitian .....                               | 4    |
| 1.6 Sistematika Penelitian .....                           | 4    |
| BAB II KAJIAN LITERATUR.....                               | 6    |
| 2.1 Kajian Induktif .....                                  | 6    |
| 2.2 Kajian Deduktif.....                                   | 10   |
| 2.2.1 <i>Lean Manufacturing</i> .....                      | 10   |
| 2.2.2 <i>Value Stream Mapping (VSM)</i> .....              | 11   |
| 2.2.3 <i>Parreto Diagram</i> .....                         | 15   |
| 2.2.4 <i>Root Cause Analysis (RCA)</i> .....               | 15   |
| 2.2.5 <i>Failure Mode and Effect Analysis (FMEA)</i> ..... | 17   |
| BAB III METODE PENELITIAN .....                            | 21   |
| 3.1 Tempat dan Obyek Penelitian .....                      | 21   |
| 3.2 Jenis Data .....                                       | 21   |
| 3.3 Metode Pengumpulan Data.....                           | 22   |
| 3.4 Alur Penelitian .....                                  | 23   |
| BAB IV PENGUMPULAN DAN PENGOLAHAN DATA.....                | 26   |

|                      |  |    |
|----------------------|--|----|
| 4.1                  | Profil Perusahaan .....  | 26 |
| 4.2                  | Visi dan Misi Perusahaan.....  | 28 |
| 4.3                  | Permintaan Produksi .....  | 28 |
| 4.4                  | Proses Produksi .....  | 31 |
| 4.5                  | Identifikasi <i>Waste</i> .....  | 33 |
| 4.6                  | <i>Current Value Stream Mapping</i> .....                                  | 39 |
| 4.7                  | <i>Cause Effect Diagram Waiting time</i> .....                             | 43 |
| 4.8                  | <i>Cause Effect Diagram Defect</i> .....                                   | 45 |
| 4.8.1                | <i>Cause Effect Diagram Defect Berlubang</i> .....                         | 45 |
| 4.8.2                | <i>Cause Effect Diagram Defect Retak</i> .....                             | 46 |
| 4.8.3                | <i>Cause Effect Diagram Defect Merayang</i> .....                          | 47 |
| 4.9                  | <i>Cause Effect Diagram Transportation</i> .....                           | 48 |
| 4.10                 | <i>Failure Mode and Effect Analysis (FMEA)</i> .....                       | 49 |
| 4.10.1               | <i>Failure Mode and Effect Analysis (FMEA) Waiting Time</i> .....          | 51 |
| 4.10.2               | <i>Failure Mode and Effect Analysis (FMEA) Defect</i> .....                | 53 |
| 4.10.3               | <i>Failure Mode and Effect Analysis (FMEA) Transportation</i> .....        | 57 |
| 4.11                 | <i>Future Value Stream Mapping</i> .....                                   | 59 |
| 5.1                  | Identifikasi <i>Waste</i> .....  | 61 |
| 5.2                  | <i>Cause Effect Diagram Waste Waiting Time</i> .....                       | 63 |
| 5.3                  | <i>Cause Effect Diagram Waste Defect</i> .....                             | 63 |
| 5.3.1                | <i>Cause Effect Diagram Berlubang</i> .....                                | 63 |
| 5.3.2                | <i>Cause Effect Diagram Retak</i> .....                                    | 64 |
| 5.3.3                | <i>Cause Effect Diagram Merayang</i> .....                                 | 65 |
| 5.4                  | <i>Cause Effect Diagram Waste Transportation</i> .....                     | 65 |
| 5.5                  | Perbaikan Berdasarkan <i>Failure Mode and Effect Analysis (FMEA)</i> ..... | 66 |
| 5.5.1                | Perbaikan untuk <i>Waste Waiting Time</i> .....                            | 66 |
| 5.5.2                | Perbaikan untuk <i>Waste Defect</i> .....                                  | 69 |
| 5.5.3                | Perbaikan untuk <i>Waste Transportation</i> .....                          | 70 |
| BAB VI PENUTUP ..... |  | 71 |
| 6.1                  | Kesimpulan .....   | 71 |
| 6.2                  | Saran.....   | 73 |
| DAFTAR PUSTAKA ..... |  | 74 |

## DAFTAR TABEL

|   |    |
|---|----|
| Tabel 2. 1 <i>Material Symbol VSM</i> .....                                   | 12 |
| Tabel 2. 2 <i>Information Symbol VSM</i> .....                                | 14 |
| Tabel 2. 3 Penentuan Nilai <i>Severity</i> .....                              | 18 |
| Tabel 2. 4 Penentuan Nilai <i>Occurance</i> .....                             | 19 |
| Tabel 2. 5 Penentuan Nilai <i>Detection</i> .....                             | 20 |
| Tabel 4. 1 Data Permintaan Wajan Bulan Juli 2018.....                         | 29 |
| Tabel 4. 2 Rekapitulasi Hasil Kuesioner 7 Pemborosan.....                     | 33 |
| Tabel 4. 3 Data Produk Cacat Bulan Juli – Agustus di Pencetakan .....         | 36 |
| Tabel 4. 4 Operator Stasiun Kerja .....                                       | 40 |
| Tabel 4. 5 <i>Available Time</i> .....  | 40 |
| Tabel 4. 6 Jumlah <i>Lead time</i> dan <i>Cycle Time</i> .....                | 41 |
| Tabel 4. 7 <i>Failure Mode and Effect Analysis Waiting time</i> .....         | 51 |
| Tabel 4. 8 <i>Faliure Mode and Effect Analysis Waste Defect</i> .....         | 53 |
| Tabel 4. 9 <i>Faliure Mode and Effect Analysis Waste Trasnportation</i> ..... | 57 |

## DAFTAR GAMBAR

|   |    |
|---|----|
| Gambar 2. 1 <i>Pareto Diagram</i> .....                                 | 15 |
| Gambar 2. 2 <i>Fishbone Diagram</i> .....                               | 17 |
| Gambar 3. 1 Alur Penelitian .....                                       | 23 |
| Gambar 4. 1 <i>Flowchart</i> Proses Pembuatan Wajan .....               | 31 |
| Gambar 4. 2 Diagram Pareto <i>Waste</i> di SP Aluminium.....            | 34 |
| Gambar 4. 3 Gambar Kapasitas Produksi setiap Area Kerja .....           | 35 |
| Gambar 4. 4 <i>Current Value Stream Mapping</i> Pembuatan Wajan.....    | 42 |
| Gambar 4. 5 <i>Cause Effect Diagram</i> <i>Waiting time</i> .....       | 44 |
| Gambar 4. 6 <i>Cause Effect Diagram</i> Berlubang .....                 | 46 |
| Gambar 4. 7 <i>Cause Effect Diagram</i> Retak .....                     | 47 |
| Gambar 4. 8 <i>Cause Effect Diagram</i> Merayang.....                   | 48 |
| Gambar 4. 9 <i>Cause Effect Diagram</i> <i>Waste</i> Transportasi ..... | 49 |
| Gambar 4. 10 <i>Future Value Stream Mapping</i> .....                   | 59 |
| Gambar 5. 1 Gambaran Kapasitas Produksi Sebelum Perbaikan .....         | 67 |
| Gambar 5. 2 Gambaran Kapasitas Produksi Setelah Perbaikan 1 .....       | 68 |
| Gambar 5. 3 Gambaran Kapasitas Produksi Setelah Perbaikan 2 .....       | 69 |

## DAFTAR LAMPIRAN

|   |    |
|---|----|
| Lampiran 1. Kuesioner Pengidentifikasian <i>Waste</i> ..... | 77 |
| Lampiran 2. Dokumentasi Proses Produksi.....                | 80 |