

ABSTRAK

PT. Wahana Lentera Raya merupakan perusahaan *furniture* yang didirikan sejak tahun 2003. Dalam proses produksinya perusahaan ini menerapkan sistem *make to stock* yang memproduksi berdasarkan hasil *forecasting*. Beberapa permasalahan yang terjadi salah satunya adalah lamanya *proses* pembuatan produk tipe *Joy Motta V1*. Analisis *Value Stream Analysis Tools* (VALSAT) digunakan melalui pembobotan *waste* didapatkan 3 *waste* terbesar adalah *Overproduction* dengan rata-rata skor 1,25, *motion* dan *excess processing* dengan rata-rata skor 1, dan didapatkan *tools* yang digunakan adalah *Process Activity Mapping*. Pada *Process Activity Mapping Laminating* didapatkan aktivitas *operation* sebesar 81,54%, *transportation* sebesar 12,31% dan *inspection* sebesar 6,15%. *Activity Classification* digunakan untuk mengelompokkan aktivitas *value added*, *non value added* dan *necessary but non value added* dan didapatkan bahwa pada proses laminating aktivitas *value added* memiliki prosesntase 33,85%, aktivitas *necessary but non value added* sebesar 56,92% dan aktivitas *non value added* sebesar 9,23%. Hasil rekomendasi perbaikan pada *Process Activity Mapping Laminating* adalah didapatkan aktivitas *value added* sebesar 37,29%, aktivitas *necessary but non value added* sebesar 62,71% dan aktivitas *non value added* sebesar 0%

Kata Kunci: *Lean Manufacturing, Value Stream Analysis Tools (VALSAT), Root Cause Analysis*

ABSTRACT

PT. Wahana Lentera Raya is a furniture company that was founded in 2003. In its production process, this company implements a make-to-stock system that produces based on forecasting results. Some of the problems that occur are the length of the process for making a Joy Motta V1 type product. Value Stream Analysis Tools (VALSAT) analysis is used through weighting of waste, the 3 biggest waste is Overproduction with an average score of 1.25, motion and excess processing with an average score of 1, and the tools used are Process Activity Mapping. In the Laminating Mapping Activity Process, it is found that operation activity is 81.54%, transportation is 12.31% and inspection is 6.15%. Activity Classification is used to classify value added, non value added and necessary but non value added activities and it was found that in the laminating process, value added activities have 33.85% incentives, 56.92% of necessary but non-value added activities and non-value added activities. by 9.23%. The results of the recommendations for improvement in the Process Activity Mapping Laminating were obtained value added activity of 37.29%, necessary but non-value added activities of 62.71% and non-value added activities of 0%.

Keywords: *Lean Manufacturing, Value Stream Analysis Tools (VALSAT), Root Cause Analysis*