

ABSTRAK

Pabrik beton *precast* XYZ mempunyai suatu kendala, yakni sering mengalami tidak tercapainya target produksi yang telah direncanakan, hal tersebut terbukti dikarenakan rata-rata realisasi produksi kurang dari rata-rata target rencana KPS (kapasitas) normal dan RKAP (rencana kerja anggaran perusahaan) yang telah ditetapkan oleh perusahaan. Maka perlu dilakukan perbaikan dalam proses produksi dengan cara mengeliminasi kegiatan-kegiatan non value added dengan menggunakan tool VALSAT, serta memberikan usulan perbaikan guna meningkatkan kapasitas realisasi produksi. *Value Stream Analysis Tool* (VALSAT) merupakan tool yang dipergunakan untuk mengetahui lebih lanjut dari kegiatan *value added* dan *non value added* pada value stream (aliran proses produksi) dengan cara menggambarkan aliran produksi dengan *value stream mapping*, lalu mengidentifikasi seluruh aktivitas pada setiap lini produksi dan mengklasifikasikannya kedalam aktivitas *operation*, *transportation*, *inspection*, *storage*, dan *delay*, selanjutnya mengeliminasi aktivitas-aktivitas yang tidak bernilai tambah dengan menggunakan *process activity mapping*. Terdapat selisih perbedaan dari *process activity mapping (current state)* dengan *process activity mapping* usulan perbaikan, seperti *total cycle time (current state)* sebesar 499,1 menit, sedangkan *total cycle time* (usulan) perbaikan sebesar 498,33 menit dengan selisih keduanya sebesar 0,77 menit, dan *moving time (current state)* sebesar 39,69 menit, sedangkan *moving time* (usulan) sebesar 39,28 menit. Perbedaan selisih waktu tersebut menambah efisiensi proses produksi.

Kata kunci : Identifikasi aktivitas, VALSAT, *Process Activity Mapping*, 5 *Why's*.

ABSTRACT

XYZ precast concrete plant has a problem, which is often experiencing the achievement of planned production targets, it is proven because the average production realization is less than the average normal planned KPS (capacity) plan and RKAP (corporate budget work plan) that has been determined by the company. So it is necessary to make improvements in the production process by eliminating non-value added activities using the VALSAT tool, as well as providing proposed improvements to increase production capacity. Value Stream Analysis Tool (VALSAT) is a tool used to find out more about value added and non value added activities in the value stream (production process flow) by describing production flow with value stream mapping, then identifying all activities on each production line and classify it into operation, transportation, inspection, storage, and delay activities, then eliminate activities that have no added value by using process activity mapping. There is a difference between the process activity mapping (current state) and the process activity mapping of the proposed improvements, such as the total cycle time (current state) of 499,1 minutes, while the total cycle time (proposed) for improvements is 498,33 minutes with a difference of 0,77 minutes, and the moving time (current state) was 39,69 minutes, while the moving time (proposed) was 39,28 minutes. The difference in time difference increases the efficiency of the production process.

Keywords : Activity Identification, VALSAT, Process Activity Mapping, 5 Why's.