

ABSTRAK

Garam konsumsi merupakan kebutuhan masyarakat yang penting untuk kehidupan sehari-hari. Proses produksi pengemasan pada PT. Garam Sampang terdapat dugaan permasalahan seperti internal *defect* dan target produksi tidak tercapai. Dugaan permasalahan diatas dapat menyebabkan pada menurunnya profit perusahaan. Berdasarkan permasalahan tersebut, maka perlu solusi untuk mengatasi permasalahan tersebut yaitu dengan menggunakan pendekatan *lean manufacturing*. Langkah awal yang dilakukan untuk perbaikan yaitu dimulai dengan menggunakan alat bantu *value stream mapping* (VSM) untuk mengetahui aliran informasi, proses produksi, material pada rantai produksi. Selanjutnya dilakukan klasifikasi aktivitas ke dalam 5 jenis yaitu transportasi (T), *delay* (D), inspeksi (I), operasi (O), dan *storage* (S) menggunakan alat bantu *process activity mapping* (PAM). Setelah itu, merancang kuesioner untuk disebar kepada kepala produksi dan beberapa operator dalam indentifikasi *waste*. Berdasarkan rekapan identifikasi terdapat empat *waste* yang terjadi yaitu *environmental*, *health and safety* (EHS) *waste*, *defect waste*, *waiting waste* dan *transportation waste*. Berdasarkan peringkat *waste* yang paling dominan terjadi akan diberikan rekomendasi perbaikan untuk diprioritaskan terlebih dahulu diperbaiki. Hasil rekomendasi perbaikan yang telah diberikan menghasilkan *future state value stream mapping*. *Future state value stream mapping* berkontribusi terhadap penurunan *lead time* sebesar 119 detik (0,94%) dan tereliminasi 2 aktivitas.

Kata Kunci : *Lean Manufacturing*, *Value Stream Mapping* (VSM), *Process Activity Mapping* (PAM), E-DOWNTIME Waste

ABSTRACT

Salt consumption is an important community need for daily life. Packaging production process at PT. Sampang salt has suspected problems such as internal defects and production targets not being achieved. The alleged problems above can lead to a decrease in company profits. Based on these problems, a solution is needed to overcome these problems, namely by using a lean manufacturing approach. The first step taken for improvement is starting with using value stream mapping (VSM) tools to find out the flow of information, production processes, materials on the production floor. Furthermore, the classification of activities into 5 types is carried out, namely transportation (T), delay (D), inspection (I), operation (O), and storage (S) using process activity mapping (PAM) tools. After that, design a questionnaire to be distributed to the head of production and several operators in waste identification. Based on the identification recap, there are four wastes that occur, namely environmental, health and safety (EHS) waste, defect waste, waiting waste and transportation waste. Based on the rank of the most dominant waste, improvement recommendations will be given to be prioritized first. The results of the improvement recommendations that have been given produce future state value stream mapping. Future state value stream mapping contributed to a 119 second (0.94%) decrease in lead time (0.94%) and elimination of 2 activities.

Keywords : Lean Manufacturing, Value Stream Mapping (VSM), Process Activity Mapping (PAM), E-DOWNTIME Waste