ABSTRAK

UD. Tinof merupakan perusahaan manufactur yang memproduksi berbagai jenis tas khususnya tas ransel. Dalam aliran proses produksi pembuatan tas memungkinkan terjadinya waste, maka diperlukan penanganan untuk menetukan *waste* dan mengidentifikasi aktivitas non value added. Jenis *waste* yang terjadi yaitu *Defect, Inventory, waiting, Transportasi dan Motion*.

Untuk melakukan langkah perbaikan diterapkan metode *Lean six sigma* dengan menggabungkan antara konsep *lean thinking* dan *six sigma*. Serta *tool lean six sigma* yang dipakai pada penelitian ini adalah *Big Picture Mapping, Diagram Pareto, Fishbone Diagram, Failure Mode* and *effect Analysis*. Tool yang digunakan diatas akan mendukung hasil tahapan *improve* untuk menentukan prioritas perbaikan terhadap *waste* terkritis berdasarkan prioritas nilai RPN tertinggi yang didasari dari penyebaran kuisioner serta pemberian rekemendasi perbaikan terhadap perusahaan .

Setelah dilakukan perhitungan maka didapat 3 waste terkritis yaitu *Defect, Waiting* dan *Motion* dan dibuatkan rencana perbaikan terhadap 3 *waste* tersebut serta didapatkan identifikasi kegiatan-kegiatan dalam value stream terdiri dari VAA (*value added activities*)sebesar 20% NVAA (*Non Value Added Activities*) 10 % dan 70 % nya merupakan kegiatan-kegiatan yang termasuk dalam NNVAA (*Necessary But Non Value Added Activities*).

Kata Kunci: *Lean Six Sigma, Waste Terkritis, Defect, Waiting, Motion*

ABSTRACT

UD. Tinof is manufactur company which produces various kinds of bags especially a backpack. In the process flow of the production of the bag allow for waste, it is necessary to determine the handling of waste and identify non-value added activities. Types of waste that occur are Defect, inventory, waiting, transportation, and Motion.

To perform corrective measures implemented Lean Six Sigma methods to combine the concepts of lean thinking and six sigma. As well as lean six sigma tools used in this study is the Big Picture Mapping, Pareto Diagram, Fishbone Diagram, Failure Mode and effect Analysis. Tool that is used to support the results of stages to improve prioritize improvements to waste too critical on a priority basis based on the highest RPN value of distribution of questionnaires and providing improvements to the company's plans.

After calculation of the importance of the three waste too critical of the Defect, Waiting and Motion and made improvement plan to the 3 waste as well as obtained the identification of the activities in the value stream consists of VAA (value added activities) of 20% NVAA (Non-Value Added activities) 10% and 70% of them are activities that are included in NNVAA (But Necessary non-Value Added Activities).

Keywords: Lean Six Sigma, Waste Too Critical, Defect, Waiting, Motion