Lulun Riskiana, 12312064, **Analisis Minimasi *Waste m*elalui Pendekatan *Lean Manufacturing* Pada Proses Produksi Pabrik AMDK K3PG**, Manajemen, Fakultas Ekonomi, Universitas Muhammadiyah Gresik, Agustus, 2016.

Abstraksi

Penelitian ini bertujuan untuk mengidentifikasi dan meminimasi aktivitas penyebab *waste* yang ada pada lini produksi cup, memperpendek *lead time* melalui pendekatan *Lean Manufacturing* agar mampu menjaga efektifitas waktu siklus produksi pabrik AMDK K3PG. Melakukan penyebaran kuisioner pada sembilan responden dan identifikasi penyebab *waste* dengan *fishbone diagram*. Selanjutnya upaya minimasi penyebab *waste* menggunakan *improvement* 5W 1H, mengidentifikasi aktivitas *non value added* yang termasuk aktivitas *waste* melalui *value stream mapping* serta dilakukan *detail mapping* dengan *value stream analysis tools* (VALSAT). Hasil pembobotan kuisoner diperoleh waste dominan urutan teratas adalah *waste defect* prosentase sebesar 18,91%, *detail mapping tools* menunjukkan posisi tertinggi ditempati *process activity mapping* dengan nilai sebesar 91,3. Pada *current state value stream* mapping area produksi cup *lead time* sebesar 4320 detik dan *cycle time* sebesar 60 detik, setelah usulan perbaikan pada *future state value stream* mapping dapat melakukan minimasi waktu dengan hasil *lead time* 4010 detik dan *cycle time* sebesar 50 detik, sehingga adanya minimasi waktu dengan mereduksi non value added pada aktivitas *packaging*, yang termasuk *waste time* sebesar 310 detik.

Kata kunci : *Lean manufacturing, Waste, Value stream mapping, Value stream analysis tools, fishbone diagram,* 5W 1H.

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Abstract

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This study aims to identify and minimize waste any activity causes the production line cup, shortening lead through Lean Manufacturing approach to be able to maintain the effectiveness of the production cycle time factory AMDK K3PG. Distributing questionnaires in nine respondents and identifying the causes of waste with a fishbone diagram. Further efforts cause waste minimization using 5W 1H improvement, identify non-value added activities that include activity waste through value stream mapping and conducted detailed mapping with value stream analysis tools (VALSAT). The results of the questionnaire obtained by weighting the top of the dominant waste is waste defect percentage of 18.91%, detail mapping tools shows the highest position occupied process mapping activity with a value of 91.3. In the current state value stream mapping production area of cup lead time of 4320 seconds and a cycle time of 60 seconds, after the proposed improvements to the future state value stream mapping can do minimization of time with the results of lead time 4010 seconds and a cycle time of 50 seconds, so the minimization of time by reducing the non-value added activity packaging, which includes waste time of 310 seconds.

Key Words: Lean manufacturing, Waste, Value stream mapping, Value stream analysis tools, fishbone diagrams, 5W 1H.