

## DAFTAR ISI

LEMBAR PENGESAHAN .....	i
LEMBAR PERNYATAAN ORISINALITAS .....	ii
ABSTRAK.....	iv
<i>ABSTRACT</i> .....	v
KATA PENGANTAR .....	vii
DAFTAR ISI.....	ix
DAFTAR GAMBAR .....	xii
DAFTAR TABEL.....	xiii
BAB I.....	1
PENDAHULUAN .....	1
I.1 Latar Belakang.....	1
I.2 Perumusan Masalah.....	3
I.3 Tujuan Penelitian.....	4
I.4 Batasan Penelitian.....	4
I.5 Manfaat Penelitian.....	4
BAB II.....	5
LANDASAN TEORI.....	5
II.1 <i>Lean Manufacturing</i> .....	5
II.2 <i>Operation Process Chart (OPC)</i> .....	7
II.3 Tata Letak Pabrik ( <i>Plant Layout</i> ).....	9
II.4 <i>Value Stream Mapping (VSM)</i> .....	9
II.4.1 <i>Current State Mapping</i> .....	10
II.4.2 <i>Future State Mapping</i> .....	13
II.5 <i>Process Activity Mapping (PAM)</i> .....	14
II.6 Pemborosan ( <i>Waste</i> ).....	15
II.7 <i>Failure Mode Effect Analysis (FMEA)</i> .....	17
II.8 5W1H .....	20
II.10 <i>Continuous Flow</i> .....	20

II.11 5S.....	21
II.12 Sistem Produksi Tarik ( <i>Pull Production System</i> ).....	22
BAB III .....	23
METODOLOGI PENELITIAN.....	23
III.1 Model Konseptual.....	23
III.2 Sistematika Pemecahan Masalah .....	24
III.2.1 Tahap Pendahuluan.....	26
III.2.2 Tahap Pengumpulan dan Pengolahan data .....	27
III.2.3 Identifikasi Kebutuhan Data .....	27
III.3 Perancangan <i>Current State</i> .....	28
III.3.1 Perancangan <i>Value Stream Mapping – Current State</i> .....	28
III.3.2 Perancangan <i>Process Activity Mapping – Current State</i> .....	28
III.4 Tahap Analisis dan Rekomendasi.....	28
III.4.1 Analisis Hasil Pengolahan Data.....	28
III.4.2 Perumusan Rekomendasi.....	29
III.4.3 Tahap Kesimpulan dan Saran .....	30
BAB IV .....	31
PENGUMPULAN DAN PENGOLAHAN DATA .....	31
IV.1 Peta Kerja.....	31
IV.1.1 <i>Operation Process Chart (OPC)</i> .....	31
IV.1.2 Tata Letak Pabrik ( <i>Plant Layout</i> ) .....	34
IV.2 Data Waktu .....	36
IV.2.1 <i>Cycle Time (C/T)</i> .....	36
IV.2.2 <i>Changeover Time (C/O)</i> .....	36
IV.2.3 <i>Available Work Time</i> .....	36
IV.2.4 <i>Uptime</i> .....	37
IV.2.5 <i>Value Added Time</i> .....	37
IV.2.6 <i>Lead Time</i> .....	38
IV.2.7 <i>Customer Demand (C/D)</i> .....	38
IV.2.8 Waktu Baku ( <i>Standard Time</i> ).....	38
IV.2.9 <i>Takt Time</i> .....	40

IV.3 <i>Value Stream Mapping – Current State</i> .....	40
IV.4 <i>Process Activity Mapping (PAM)</i> .....	41
BAB V .....	43
ANALISIS DAN REKOMENDASI .....	43
V.1 Analisis Hasil Pengolahan Data.....	43
V.1.1 Analisis <i>Value Stream Mapping – Current State</i> .....	43
V.1.2 Analisis Hasil <i>Process Activity Mapping (PAM) – Current State</i> .....	44
V.1.3 Analisis Pemborosan ( <i>Waste</i> ) .....	47
V.1.4 Analisis Prioritas Pemborosan ( <i>Waste</i> ) Berdasarkan <i>Failure Mode Effect Analysis (FMEA)</i> .....	50
V.1.5 Analisis Penyebab Pemborosan ( <i>Waste</i> ).....	52
V.2 Usulan .....	54
V.2.1 <i>Continuous Flow</i> .....	54
V.2.2 5S .....	57
V.2.3 Sistem Produksi Tarik ( <i>Pull Production System</i> ) .....	61
V.2.4 <i>Value Stream Mapping – Future State</i> .....	61
V.2.5 <i>Process Activity Mapping – Future State</i> .....	63
V.2.6 Perbandingan <i>Current</i> dan <i>Future State</i> .....	66
BAB VI.....	68
KESIMPULAN DAN SARAN.....	68
VI.1 Kesimpulan.....	68
VI.2 Saran .....	68
VI.2.1 Bagi Perusahaan.....	68
VI.2.2 Bagi Penelitian Selanjutnya.....	69
DAFTAR PUSTAKA .....	70