

CHAPTER VI

CONCLUSION AND SUGGESTION

This chapter contains the conclusion of the research and the suggestions on improving future research.

6.1 Conclusions

Based on the research conducted on CV. Usaha Jaya, following conclusions are obtained, Current State Value Stream Map (VSM) of the tofu production process of CV. Usaha Jaya reveals the inefficiencies caused by wastes such as long waiting time, unnecessary movements, and overprocessing. Each process is examined using FMEA to pinpoint the prioritized risk, which are the Boiling process and the Filtering process, which have the RPN score of 80 and 72 respectively. Those process then are analyzed using fishbone diagram to reveal the root cause of wastages which are the unstandardized process, old tool, poor workstation conditions, and disorganized layout. 5S method are used to improve the overall efficiency by suggesting and improved layout and workstations while also introducing a uniform and standardized operations. After implementing the 5S improvements, CV. Usaha Jaya can maximize the time resources required which can be seen from the future state value stream map, the production time can be cut by about 16 minutes (1000s). This can be achieved by reducing the amount wastes which are overprocessing in the boiling process and the filtering process. Waiting time in the boiling process and the draining process, and the unnecessary movements during the production process that caused by disorganized layout and chaotic material flow. This can be seen from the increase of 20% in the production process efficiency.

6.2 Suggestions

Suggestions for the future research are as follows:

1. After developing 5S method to improve the efficiency of the workstations, Ergonomics workstations can be developed to reduce the physical strain for the operators.
2. Furthermore, after ensuring the efficiency of the production process and streamlining the material flow using Value Stream Map, pull principle can be analyzed to further increase the production efficiency by integrating market demands into the production schedule.

