

**ANALISIS PEMBOROSAN DALAM PROSES
PRODUKSI ROSTER DI IKM ALEXA PROFIL**

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ABSTRAK

Proses produksi roster di IKM Alexa Profil masih menghadapi berbagai permasalahan yang ditandai dengan adanya aktivitas pemborosan (waste) yang menurunkan efisiensi kerja serta meningkatkan biaya produksi. Permasalahan utama yang dihadapi adalah tingginya tingkat pemborosan pada proses produksi, yang menyebabkan penurunan efisiensi, peningkatan biaya operasional, dan penurunan produktivitas. Penelitian ini bertujuan untuk mengidentifikasi jenis pemborosan yang paling berpengaruh serta memberikan usulan perbaikan untuk meminimalkan pemborosan tersebut agar proses produksi menjadi lebih efisien dan bernilai tambah.

Dalam mencapai tujuan tersebut, penelitian dilakukan melalui observasi langsung ke lapangan, wawancara dengan pemilik dan pekerja, serta pengumpulan data waktu proses produksi. Metode Lean Manufacturing digunakan sebagai pendekatan utama, dengan alat bantu analisis seperti Value Stream Mapping (VSM), Waste Assessment Model (WAM), Waste Relationship Matrix (WRM), dan Fishbone diagram. Penilaian dilakukan dengan membandingkan aktivitas yang bernilai tambah (VA), tidak bernilai tambah (NVA), dan perlu tetapi tidak bernilai tambah (NNVA), serta pemetaan hubungan antar pemborosan untuk menentukan prioritas perbaikan.

Hasil penelitian menunjukkan empat pemborosan dominan, yaitu defect sebesar 35,11%, motion 25,91%, transportation 20,88%, dan waiting 10,04%. Usulan perbaikan yang diajukan meliputi penerapan SOP produksi untuk mengurangi produk cacat, penataan ulang layout menjadi satu arah, penggunaan hand truck untuk mengurangi aktivitas manual, serta pembagian kerja paralel guna menghilangkan waktu tunggu. Efektivitas perbaikan dibuktikan melalui peningkatan nilai Process Cycle Efficiency (PCE) dari 66% menjadi 82%.

Kata Kunci: *efisiensi produksi, IKM Alexa Profil, Lean Manufacturing, pemborosan, Value Stream Mapping, Waste Assessment Model.*

ABSTRACT

The production process of roster at IKM Alexa Profil still faces several problems characterized by the presence of *waste* activities that reduce work efficiency and increase production cost. The main issue faced by this enterprise is the high level of *waste* occurring throughout production, leading to reduced efficiency, increased operational costs, and lower productivity. This research aims to identify the most significant types of *waste* and propose improvements to minimize them, thereby enhancing the overall efficiency and value-added in the production process.

To achieve these objectives, the study was conducted through direct field observation, interviews with owners and workers, and collection of production time data. *Lean Manufacturing* was employed as the primary approach, utilizing analytical tools such as Value Stream Mapping (VSM), *Waste* Assessment Model (WAM), *Waste* Relationship Matrix (WRM), and *Fishbone diagram*. Activities were assessed by classifying them into value-adding (VA), non-value-adding (NVA), and necessary but non-value-adding (NNVA) categories. The relationship between different types of *waste* was also analyzed to determine priority areas for improvement.

The research findings identified four dominant types of *waste*: *defect* (35.11%), *motion* (25.91%), *transportation* (20.88%), and *waiting* (10.04%). The proposed improvements include implementing a Standard Operating Procedure (SOP) to reduce product *defects*, reorganizing the production *layout* into a one-way flow, using hand trucks to minimize manual handling, and applying parallel task distribution to eliminate *waiting* times. The effectiveness of these improvements is demonstrated by the increase in Process Cycle Efficiency (PCE) from 66% to 82%.

Keywords: IKM Alexa Profil, *Lean Manufacturing*, production efficiency, Value Stream Mapping, *Waste* Assessment Model,