

**ANALISIS *LEAD TIME* PRODUKSI KAYU MANIS *CASSIA*
BROKEN CHIP EKSPOR PADA PT SUMATERA
TROPICAL SPICES PADANG PARIAMAN**

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ABSTRAK

Proses produksi *Cassia Broken Chip* di PT Sumatera Tropical Spices masih memiliki aktivitas yang berpotensi memperpanjang *lead time* produksi dan memengaruhi kesiapan produk untuk kegiatan ekspor. Penelitian ini bertujuan menganalisis aliran proses produksi, mengidentifikasi aktivitas *Value Added* (VA), *Necessary Non Value Added* (NNVA), dan *Non Value Added* (NVA), serta menyusun usulan perbaikan untuk mengurangi *lead time* internal perusahaan. Metode penelitian menggunakan *Value Stream Mapping* (VSM) melalui penyusunan *Current State Mapping* dan *Future State Mapping*, serta perhitungan *Process Time* (PT), *Waiting Time* (WT), *Lead Time* (LT), dan *Process Cycle Efficiency* (PCE). Hasil *Current State Mapping* menunjukkan *Process Time* sebesar 74,5 hari, *Waiting Time* sebesar 28 hari, *Lead Time* sebesar 102,7 hari, dan PCE sebesar 72,53%. *Waiting Time* terutama berasal dari *RM Sorted* selama 3 hari dan *Finished Goods Inventory* selama 25 hari. Usulan *Future State Mapping* diarahkan pada pengurangan waktu penyimpanan bahan baku dari 70 menjadi 60 hari melalui pengelompokan bahan baku berdasarkan kadar air sehingga bahan dengan karakteristik kadar air yang berbeda dapat dikelola sesuai kondisi dan kebutuhan proses produksi. Usulan tersebut menghasilkan *Lead Time* sebesar 92,7 hari dan PCE sebesar 69,57%. Meskipun PCE mengalami penurunan secara matematis, *Lead Time* berkurang 10 hari sehingga mempercepat aliran produksi dan memberikan tambahan *buffer* waktu dalam menghadapi ketidakpastian proses ekspor.

Kata Kunci : Serpihan *Cassia*, Waktu Tunggu, Efisiensi Siklus Proses, Pemetaan Aliran Nilai.



ANALYSIS OF PRODUCTION LEAD TIME FOR EXPORT CASSIA CINNAMON BROKEN CHIPS AT PT SUMATERA TROPICAL SPICES, PADANG PARIAMAN

ABSTRACT

The production process for Cassia Broken Chips at PT Sumatera Tropical Spices involves activities that potentially extend production lead times and affect product readiness for export. This study aims to analyze the production process flow, identify Value-Added (VA), Necessary Non-Value-Added (NNVA), and Non-Value-Added (NVA) activities, and formulate improvement proposals to reduce the company's internal lead time. The research employs Value Stream Mapping (VSM)—specifically Current State Mapping and Future State Mapping—alongside calculations for Process Time (PT), Waiting Time (WT), Lead Time (LT), and Process Cycle Efficiency (PCE). Current State Mapping results indicate a Process Time of 74.5 days, Waiting Time of 28 days, Lead Time of 102.7 days, and PCE of 72.53%. Waiting Time stems primarily from the "Sorted Raw Material" stage (3 days) and "Finished Goods Inventory" (25 days). The proposed Future State Mapping focuses on reducing raw material storage time from 70 to 60 days by categorizing raw materials based on moisture content, allowing materials with differing moisture characteristics to be managed according to specific production conditions and requirements. This proposal results in a Lead Time of 92.7 days and a PCE of 69.57%. Although the PCE mathematically decreases, the Lead Time is reduced by 10 days, thereby accelerating the production flow and providing an additional time buffer to handle uncertainties in the export process.

Keywords: *Cassia Broken Chip, Lead Time, Process Cycle Efficiency, Value Stream Mapping.*