

ABSTRAK

Current Stream Mapping merupakan peta kondisi saat ini dalam proses produksi pembuatan *T-Shirt*. Proses penggambaran *Current Stream Mapping* merupakan hasil kondisi actual saat dilakukan observasi dan pengumpulan data proses produksi. Dari hasil *Process Activity Mapping* (PAM) pada aliran proses produksi *T-Shirt* di PT. Aye&Co dapat diketahui bahwa proses produksi *T-Shirt* terdapat 10 aktivitas *Value Added* (VA) dengan total waktu sebesar 33384 detik dengan persentase 52.48%, terdapat 4 aktivitas Non Value Added (NVA) dengan total waktu sebesar 10020 detik dengan persentase sebesar 15.75%, terdapat 16 aktivitas *Necessary but Non Value Added* (NNVA) dengan total waktu sebesar 20230 dengan persentase sebesar 31.79%. Pada saat ini proses produksi di PT. Aye&Co memiliki masalah *waste* (pemborosan) diantaranya yaitu disebabkan karena terdapat *Waiting*, *Process* dan *Motion* sehingga membuat adanya *lead time* pada saat proses produksi berlangsung. Berdasarkan Diagram Pareto aliran proses produksi *T-Shirt* di PT. Aye&Co diketahui bahwa aktivitas yang dominan terdapat pada jenis *waste Waiting* dengan persentase sebesar 47.6% dengan total waktu sebesar 14400 detik, *waste Process* dengan persentase sebesar 27.1% dengan total waktu sebesar 8200 detik dan *waste Motion* dengan persentase sebesar 10.9% dengan total waktu sebesar 3310 detik. Usulan perbaikan yang dilakukan menyebabkan berkurangnya waktu proses, yaitu pada *Process Activity Mapping* dan *lead time*. Dari hasil perbaikan pada *Process Activity Mapping* untuk waktu siklus awal 63634 detik menjadi 43234 detik, dan dari hasil perbaikan *lead time* untuk perhitungan awal 17.5261 Jam menjadi 12.0261 Jam.

Kata Kunci : *Lean Manufacturing, Produk T-Shirt, Value Stream Mapping, Process Activity Mapping* .

Abstract

Current Stream Mapping is a map of current conditions in the production process of making T-Shirts. The current stream mapping process is the result of actual conditions when observing and collecting data on the production process. From the results of *Process Activity Mapping* (PAM) on the flow of clothing production process in PT. Aye&Co can be known that the production process of clothes there are 10 *Value Added* (VA) activities with a total time of 33384 seconds with a percentage of 52.48%, there are 4 *Non Value Added* (NVA) activities with a total time of 10020 seconds with a percentage of 15.75%, there are 16 *Necessary but Non Value Added* (NNVA) activities with a total time of 20230 with a percentage of 31.79%. Currently the production process at PT. Aye&Co has waste problems such as waiting, process and motion, thus making lead time during the production process. Based on Pareto Diagram of the production process flow of Clothes in PT. Aye&Co is known that the dominant activity is in the type of waste

Waiting with a percentage of 47.6% with a total time of 14400 seconds, waste Process with a percentage of 27.1% with a total time of 8200 seconds and waste Motion with a percentage of 10.9% with a total time of 3310 seconds. Proposed repairs that are done lead to reduced processing time, namely in Process Activity Mapping, and lead time. From the improved result in Process Activity Mapping for the initial cycle time of 63634 seconds to 43234 seconds, and from the result of improved lead time for the initial calculation of 17.5261 hours to 12.0261 hours.

Keywords: Lean Manufacturing, Clothing Products, Value Stream Mapping, Process Activity Mapping.