

ABSTRAK

PT. Tembaga Mulia Semanan merupakan sebuah perusahaan manufaktur di bidang produksi kawat rod yang memiliki karakteristik make to order dalam produksinya. Pada pelaksanaan proses produksi ditemukan beberapa pemborosan, Tools *Value Stream Mapping* dan *process Actiity Mapping* yang digunakan untuk mengidentifikasi dan mengurangi pemborosan. Tujuan dari peneliti ini untuk mengetahui pemborosan (*waste*) pada proses produksi *Aluminium Rod* di PT Tembaga Mulia Semanan. Hasil dari penelitian ini diperoleh beberapa pemborosan (*waste*) pada proses produksi yaitu waiting dan transportation. Hasil perbaikan setelah dilakukan pengolahan data hasil yang diperoleh untuk perbaikan transportation yang awal sebesar 109.54 detik setelah dilakukan perbaikan menjadi 50,01 detik dan hasil perbaikan waste waiting yang awal sebesar 289.8 detik setelah dilakukan perbaikan menjadi 260.8 detik. Usulan perbaikan untuk aliran proses produksi aluminium rod ini mengurangi waktu menunggu pada proses aktifitas coiler yaitu pergantian pallet yang sedang berlangsung dalam proses coiler dan usulan perbaikan transportation dengan mengubah tata letak Gudang bahan baku dipindahkan ke dekat area proses produksi.

Kata kunci : *Lean Manufacturing*, VSM, *Current Value Mapping*, PAM, FSM

ABSTRACT

PT. Tembaga Mulia Semanan is a manufacturing company in the field of wire rod production which has make to order characteristics in its production. During the implementation of the production process, several wastes were found. The Value Stream Mapping Tools and Activity Mapping process were used to identify and reduce waste. The aim of this researcher is to determine waste in the Aluminum Rod production process at PT Tembaga Mulia Semanan. The results of this research obtained several wastes in the production process, namely waiting and transportation. The results of the improvements after data processing were carried out. The results obtained for the initial transportation improvements were 109.54 seconds after the improvements were made to 50.01 seconds and the initial waste waiting improvement results were 289.8 seconds after the improvements were made to 260.8 seconds. The proposed improvements to the flow of the aluminum rod production process reduce the waiting time in the coiler activity process, namely changing pallets which are ongoing in the coiler process and the proposed transportation improvements by changing the layout of the raw material warehouse to be moved to near the production process area..

Keywords : *Lean Manufacturing*, VSM, *Current Value Mapping*, PAM, FSM.