

## ABSTRAK

Dalam dunia industri sangat diperhatikan *efisiensi capacity* produksi dimana *lead time manufacturing* pembuatan *Outsole* Sepatu dipengaruhi oleh kegiatan yang tidak bernilai tambah (*Non Value Added*) dan kegiatan yang tidak bernilai tambah tetapi diperlukan (*Necessary Non Value Added*) dimana didalamnya terdapat beberapa pemborosan yang terjadi. Kegiatan tersebut berupa bagian penyimpanan sementara di bagian *cooling room* dan proses *rework* produk cacat. Metode yang digunakan adalah *Lean Manufacturing*, tools yang digunakan adalah *Value Stream Mapping* (VSM) dan *Proses Activity Mapping* (PAM). VSM digunakan untuk mengidentifikasi aktivitas yang memiliki waktu siklus berlebih dari *takt time*, dilanjutkan dengan pemetaan *proses Activity Mapping* untuk menganalisa aktivitas yang tidak bernilai tambah (*Non Value Added*). Berdasarkan hasil penelitian dari 4110 detik *lead time* proses 3600 detik merupakan aktivitas *non-value added*. Proses *rework* dan penyimpanan bahan di *cooling room* teridentifikasi memiliki nilai terbesar penyumbang *lead time* maka *rework* harus dihilangkan. persentase *Process Cycle Efficiency* (PCE) mengalami kenaikan. Pengurangan proses bahan lembaran yang sudah jadi didinginkan ke *cooling room* dan proses *rework* dapat menghemat waktu bekerja sekitar 60 menit. Penghematan jam kerja dapat meningkatkan kapasitas produksi *outsole* sehingga produktivitas meningkat dan target pun tercapai.

Kata Kunci: *Lead Time Manufacture, Lean Manufacturing, Value Stream Mapping, Prose Activity Mapping. Process Cycle Activity.*

## **ABSTRACT**

*In the industrial world, it is very important to pay attention to the efficiency of production capacity where the manufacturing lead time for making shoe outsole is influenced by activities that are not value-added (Non Value Added) and activities that are not value-added but necessary (Necessary Non Value Added) in which there is some extravagance that occurs. These activities are in the form of temporary storage in the cooling room and the process of reworking defective products. The method used is Lean Manufacturing, the tools used are Value Stream Mapping (VSM) and Process Activity Mapping (PAM). VSM is used to identify activities that have cycle times exceeding takt time, followed by mapping the Activity Mapping process to analyze activities that are not Value Added. Based on the results of research from 4110 seconds, the process lead time of 3600 seconds is a non-value added activity. The rework process and material storage in the cooling room were identified as having the largest value contributing to lead time, so rework must be eliminated. the percentage of Process Cycle Efficiency (PCE) has increased. The reduction of the finished sheet material process is cooled to the cooling room and the rework process can save about 60 minutes of working time. Saving working hours can increase outsole production capacity so that productivity increases and targets are achieved.*

*Keywords: Lead Time Manufacture, Lean Manufacturing, Value Stream Mapping, Prose Activity Mapping. Process Cycle Activity.*