

**IMPLEMENTASI *LEAN MANUFACTURING* DALAM PENINGKATAN
EFISIENSI PROSES PRODUKSI JERSEY PADA CV. *SEVEN BRAVE*
*INDUSTRIES***

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ABSTRAK

CV. *Seven Brave Industries* adalah UMKM di Sumedang yang bergerak di industri konveksi. CV. *Seven Brave Industries* memiliki permasalahan mengenai keterlambatan dalam proses produksi jersey. Tujuan dari penelitian ini adalah untuk mengetahui pemborosan yang terjadi serta menentukan usulan perbaikan dalam mengatasi pemborosan (*waste*) dengan menggunakan pendekatan *Lean Manufacturing* dan metodenya *Value Stream Mapping*. Penelitian ini menggunakan metode deskriptif dengan pendekatan kuantitatif. Hasil dari penelitian yang dilakukan, diperoleh beberapa pemborosan yaitu *waiting* dan *motion*. *Waiting* berasal dari pengeringan yang membutuhkan waktu yang cukup panjang selama 202 detik. Sedangkan *motion* selama 402,5 detik berasal dari aktivitas yang tidak diperlukan seperti membuang sisa potongan kain, mengikat pola baju sesuai dengan bagian, dan mengecek hasil jahitan. Berdasarkan *Current State Value Stream Mapping*, didapat *Value Added* (VA) sebesar 3.261,9 detik dan *Non-Value Added* (NVA) sebesar 880 detik sehingga total *lead time* sebesar 4.141,9 detik. Setelah dilakukan usulan perbaikan dalam *Future State Value Stream Mapping*, didapat *Value Added* (VA) sebesar 3.059,9 detik dan *Non-Value Added* sebesar 477,5 detik sehingga total *lead time* sebesar 3.537,4 detik.

Kata Kunci: *Lean Manufacturing, Waste, Value Stream Mapping, Lead Time*

***IMPLEMENTATION OF LEAN MANUFACTURING IN IMPROVING THE
EFFICIENCY OF THE JERSEY PRODUCTION PROCESS AT CV. SEVEN
BRAVE INDUSTRIES***

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ABSTRACT

CV. Seven Brave Industries is an UMKM in Sumedang engaged in the convection industry. CV. Seven Brave Industries has a problem with delays in the jersey production process. The purpose of this study is to find out the waste that occurs and determine improvement proposals in overcoming waste using the Lean Manufacturing approach and the Value Stream Mapping method. This study uses a descriptive method with a quantitative approach. As a result of the research conducted, several wastes were obtained, namely waiting and motion. Waiting comes from drying which takes a long time of 202 seconds. Meanwhile, the 402.5-second motion comes from unnecessary activities such as throwing away the remaining pieces of fabric, tying the shirt pattern according to the parts, and checking the stitching results. Based on the Current State Value Stream Mapping, the Value Added (VA) was 3,261.9 seconds and the Non-Value Added (NVA) was 880 seconds, resulting in a total lead time of 4,141.9 seconds. After the proposed improvement in the Future State Value Stream Mapping, the Value Added (VA) was obtained by 3,059.9 seconds and Non-Value Added was 477.5 seconds, resulting in a total lead time of 3,537.4 seconds.

Keywords: Lean Manufacturing, Waste, Value Stream Mapping, Lead Time