

ABSTRAK

Proses produksi Skin Sheet memiliki alur yang kompleks dan melibatkan perpindahan material antar area kerja sehingga berpotensi menimbulkan pemborosan. Kondisi tersebut perlu dianalisis untuk meningkatkan efisiensi aliran proses dan mengurangi *lead time* produksi. Penelitian ini bertujuan menganalisis pemborosan pada proses produksi *skin sheet* di PT Dirgantara Indonesia menggunakan pendekatan *Lean Manufacturing* dengan *Value Stream Mapping* (VSM), *Fishbone Diagram*, dan *5 Why's*. Hasil penelitian menunjukkan *waste* dominan berupa *waiting*, *transportation*, dan *defect*, dengan *lead time* sebesar 258,50 hari dan waktu tunggu 255,655 hari. Usulan perbaikan berupa *Protective Handling Box* dengan *Crane-Assisted Handling*, SOP *Material Handling*, *Supermarket*, dan *Max Queue Quantity Control*, dan Papan Kontrol Visual diproyeksikan menurunkan waktu tunggu menjadi 235,655 hari dan *lead time* menjadi 238,50 hari.

Kata kunci: *Lean Manufacturing*, Pemborosan, *Skin Sheet*, *Value Stream Mapping*.

ABSTRACT

The Skin Sheet production process has a complex workflow and involves material handling between work areas, which may lead to waste. This condition needs to be analyzed to improve process flow efficiency and reduce production lead time. This study aims to analyze waste in the Skin Sheet production process at PT Dirgantara Indonesia using the Lean Manufacturing approach with Value Stream Mapping (VSM), Fishbone Diagram, and 5 Why's. The results show that the dominant wastes are waiting, transportation, and defects, with a lead time of 258.50 days and waiting time of 255.655 days. The proposed improvements, consisting of a Protective Handling Box with Crane-Assisted Handling, Material Handling SOP, Supermarket, Max Queue Quantity Control, and Visual Control Board, are projected to reduce waiting time to 235.655 days and lead time to 238.50 days.

Keywords: Lean Manufacturing, Skin Sheet, Value Stream Mapping, Waste.