

**PERBAIKAN METODE KERJA PRODUKSI PADA BAGIAN ICE
CUTTING PT. UBS SURABAYA DENGAN MENGGUNAKAN
METODE LEAN MANUFACTURING**

**Opik Taofik Hidayat¹⁾ dan Yunia Dwie Nur
Cahyanie²⁾** Program Studi Teknik Industri,
Fakultas Teknik, Universitas PGRI Adibuana
Surabaya opicktaufi491@gmail.com

ABSTRAK

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The place of research was carried out at a gold jewelry manufacturing factory located in Surabaya. The constraint in this company is the ice cutting production section, that is, there is still some waste. By controlling the productivity that can be done, namely by improving the employee performance system. The purpose of this research is to improve the production process with the intention of speeding up time to be faster and more efficient. Technical analysis of data in this study using the Value Stream Mapping method to find out the actual production process flow and Fishbone Diagram to find out the root problems that arise and make improvements to what are the problems that cause waste. The first thing to do is to use Value Stream Mapping with current state value stream mapping analysis to find out the process flow before repairs. Then make improvements in the form of minimizing things that do not add value to the ice cutting production process to get process cycle efficiency values with expected future state analysis. Value stream mapping is carried out in an effort to minimize waste to increase value added activity. This is followed by the explanation that has been described from the VSM method into a fishbone diagram more clearly and the recommended solutions.

Keywords: Work System, Lean manufacturing, VSM, Fishbone Diagram