

ABSTRAK

KEMUNGKINAN PENERAPAN SISTEM *JUST IN TIME* PRODUKSI PADA PERUSAHAAN MANUFAKTUR

Studi Kasus Pada Perusahaan Konveksi WLK cloth di Klaten

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Penelitian ini bertujuan untuk mengetahui apakah WLK cloth di Klaten memungkinkan untuk menerapkan sistem *just in time* produksi dan mengetahui besarnya manfaat ekonomi, yaitu berupa penghematan biaya produksi jika perusahaan mampu menerapkan *just in time* produksi.

Teknik pengumpulan data yang digunakan adalah teknik wawancara dan dokumentasi. Teknik analisis data yang digunakan untuk menjawab rumusan masalah yang pertama adalah dengan membandingkan antara kondisi nyata perusahaan dengan syarat penerapan *just in time* yang meliputi organisasi pabrik, pelatihan/tim/ketrampilan, membentuk aliran/ penyederhanaan, *Kanban Pull System*, visibilitas/ pengendalian visual, eliminasi kemacetan, ukuran lot kecil dan waktu *setup* yang cepat, *total productive maintenance*, kemampuan proses, *statistical process control*, dan perbaikan berkesinambungan, pemasok. Rumusan masalah yang kedua dijawab dengan menggunakan rumus *Manufacturing Cycle efficiency (MCE)*.

Dari hasil penelitian diketahui bahwa dari sepuluh syarat peneraan sistem *just in time*, masih terdapat delapan syarat yang belum dapat dipenuhi oleh perusahaan, yaitu organisasi pabrik, pelatihan/tim/ketrampilan, membentuk aliran/ penyederhanaan, *Kanban Pull System*, eliminasi kemacetan, ukuran lot kecil dan waktu *setup* yang cepat, kemampuan proses, *statistical process control*, dan perbaikan berkesinambungan, pemasok. Di masa datang hanya syarat membentuk aliran/ penyederhanaan, eliminasi kemacetan, kemampuan proses, *statistical process control*, dan perbaikan berkesinambungan, pemasok. Hasil analisis tersebut membuktikan bahwa WLK cloth tidak memungkinkan untuk menerapkan sistem *just in time* produksi. Dari hasil perhitungan MCE diperoleh 27,46 %, artinya dalam kegiatannya perusahaan masih mengandung kegiatan tidak bernilai tambah sebesar 72,54 %. Jika WLK cloth mampu menerapkan sistem *Just In time*, maka penghematan yang akan diperoleh dalam satu tahun adalah Rp.27.617.000,00.

ABSTRACT

THE POSSIBILITY OF PRODUCTION JUST IN TIME SYSTEM

APPLICATION IN A MANUFACTURING COMPANY

A Case Study at Garment Company WLK cloth Klaten

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The aims of this research were to determine the possibility of applying production just in time system in WLK cloth Klaten and to know how much the economic advantage, that was the cost saving of production if the company was able to apply production just in time system.

The data gathering techniques which were used in this research were interview and documentation. The data analysis technique used to answer the first problem was by comparing the company's real condition with just in time application requirements which consisted of factory organization, training/team/skills, flow formation/simplification, Kanban pull system, visibility/visual control, bottleneck elimination, small lot size and fast set up time, total productive maintenance, process capacity, statistical process control, and sustainable repair, and suppliers. The second problem was answered by using manufacturing cycle efficiency (MCE) formula.

Based on the result of the research, it was known that six out of ten requirements analyzed were not fulfilled by company. They were factory organization, training/team/skills, flow formation/simplification, Kanban pull system, bottleneck elimination, small lot size and fast set up time, process capacity, statistical process control, sustainable repair, and suppliers. This result of the research proved that WLK cloth was not possible to apply production just in time system. Based on the result of the MCE calculation, it was obtained 27,46%, it meant that from the total company's activities, there were still 72,54% non-value added activities. If the company was able to apply production just in time system, the cost saving obtained by company would be as much as 27.617.000 Rupiahs.