

ABSTRACT

STP RUBBER is a company that move in rubber and iron production. In Processing the business STP RUBBER try to give the best service so it can stand in a competitive business. In processing the business, STP RUBBER has three business process principal: order, production and delivery process. This time, the processes especially production process should be repaired. Based on the company historical order data from January to September 2007, percentage for order that can not be finished is 56,02% and 57,6% from that is because of production process. As a company that has mission to give the best service to customer, so needed a continuous improvement. Designing and improving the production process with Business Process Improvement Method in non-effective side is one of the solution to improve the production process.

In reality, it needs a suggestion production process to improve company performance in giving the best service to its costumers. The steps to achieve the improvement production process are understanding production process and measuring cyclic time and its efficiency. After getting the information, analytic in considering SDM aspect, facilities & technology and also existing information.

Improvement suggestion production process will be arranged by activity analysis and streamlining to get the efficiency value better than existing so it will give the changes to production process existing that influence the improvement efficiency value and effective process.

Below are the comparison between production process existing and the suggestion based on rubber production and iron production:

Production Process on Rubber

No	Nama Aktivitas	Eksisting			Usulan		
		Jumlah Aktivitas	Waktu Siklus (menit)	Efisiensi	Jumlah Aktivitas	Waktu Siklus (menit)	Efisiensi
1	Penggilingan	6	68,2	0,73	4	53,65	0,93
2	Pencetakan	11	31,67	0,71	8	24,07	0,93
3	Finishing	6	9,93	0,55	4	7,05	0,78
4	Quality Control	5	5,07	0,26	4	3,58	0,37
5	Pergudangan	5	6,92	0,45	3	3,85	0,80
6	Pergudangan Produk Reject	5	6,93	0,44	3	3,75	0,82
	Total	38	128,72		26	95,95	

Production Process on Iron

No	Nama Aktivitas	Eksisting			Usulan		
		Jumlah Aktivitas	Waktu Siklus (menit)	Efisiensi	Jumlah Aktivitas	Waktu Siklus (menit)	Efisiensi
1	Pencetakan	6	15,55	0,77	4	12,69	0,94
2	Pembentukan	7	23,67	0,69	5	17,79	0,92
3	Penyambungan	16	75,86	0,86	11	67,44	0,96
4	Penghalusan	4	39,07	0,89	3	37,56	0,92
5	Pengecatan	8	796,85	0,99	7	499,38	0,99
6	Pembuatan mur dan baut	8	28,36	0,92			
7	Perakitan	6	51,02	0,93	3	47,68	0,99
8	Pergudangan	6	11,41	0,79	4	9,79	0,92
Total		61	1041,79		37	692,33	

Key word : Redesign, *continuous improvement*, *Business Process Improvement*, *streamlining*.