

## DAFTAR ISI

|                                                |             |
|------------------------------------------------|-------------|
| <b>LEMBAR PENGESAHAN .....</b>                 | <b>i</b>    |
| <b>LEMBAR PERNYATAAN ORISINALITAS .....</b>    | <b>ii</b>   |
| <b>LEMBAR PERSEMBAHAN .....</b>                | <b>iii</b>  |
| <b>ABSTRAK .....</b>                           | <b>iv</b>   |
| <b>ABSTRACT .....</b>                          | <b>v</b>    |
| <b>KATA PENGANTAR.....</b>                     | <b>vi</b>   |
| <b>DAFTAR ISI.....</b>                         | <b>vii</b>  |
| <b>DAFTAR GAMBAR.....</b>                      | <b>x</b>    |
| <b>DAFTAR TABEL .....</b>                      | <b>xi</b>   |
| <b>DAFTAR SINGKATAN DAN LAMBANG .....</b>      | <b>xii</b>  |
| <b>DAFTAR ISTILAH .....</b>                    | <b>xiii</b> |
| <b>DAFTAR LAMPIRAN .....</b>                   | <b>xv</b>   |
| <b>BAB I PENDAHULUAN.....</b>                  | <b>1</b>    |
| I.1 Latar Belakang .....                       | 1           |
| I.2 Perumusan Masalah .....                    | 3           |
| I.3 Tujuan Penelitian .....                    | 4           |
| I.4 Batasan Penelitian .....                   | 4           |
| I.5 Manfaat Penelitian.....                    | 4           |
| I.6 Sistematika Penulisan.....                 | 4           |
| <b>BAB II TINJAUAN PUSTAKA.....</b>            | <b>6</b>    |
| II.1 <i>Lean</i> .....                         | 6           |
| II.2 <i>Lean Manufacturing</i> .....           | 6           |
| II.3 <i>Waste</i> .....                        | 6           |
| II.4 Diagram SIPOC .....                       | 9           |
| II.5 <i>Lean Manufacturing Tools</i> .....     | 10          |
| II.5.1 <i>Value Stream Mapping (VSM)</i> ..... | 10          |

|                                                    |           |
|----------------------------------------------------|-----------|
| II.5.2 <i>Process Activity Mapping</i> (PAM) ..... | 14        |
| II.5.3 <i>Fishbone Diagram</i> .....               | 15        |
| II.5.4 5 <i>Why's</i> .....                        | 17        |
| II.5.5 5W1H .....                                  | 17        |
| II.5.6 <i>Takt Time</i> .....                      | 18        |
| II.5.7 Keseimbangan Lini Produksi .....            | 18        |
| II.6 Pengukuran Waktu Kerja .....                  | 21        |
| II.7 Pengujian Data .....                          | 21        |
| II.7.1 Uji Keseragaman Data .....                  | 21        |
| II.7.2 Uji Kecukupan Data .....                    | 22        |
| <b>BAB III METODE PENELITIAN .....</b>             | <b>24</b> |
| III.1 Model Konseptual .....                       | 24        |
| III.2 Sistem Pemecahan Masalah .....               | 26        |
| III.2.1 Tahap Pendahuluan .....                    | 27        |
| III.2.2 Tahap Pengolahan Data .....                | 28        |
| III.2.3 Tahap Analisis .....                       | 29        |
| III.2.4 Tahap Kesimpulan dan Saran .....           | 30        |
| <b>BAB IV PENGUMPULAN DAN PENGOLAHAN DATA.....</b> | <b>31</b> |
| IV.1 Pengumpulan Data .....                        | 31        |
| IV.1.1 Objek Penelitian .....                      | 31        |
| IV.1.2 Diagram SIPOC .....                         | 32        |
| IV.1.3 Data Pengamatan Waktu Siklus .....          | 37        |
| IV.2 Pengolahan Data .....                         | 40        |
| IV.2.1 Pengukuran Waktu .....                      | 40        |
| IV.2.2 Uji Keseragaman Data .....                  | 40        |

|                                                                                   |           |
|-----------------------------------------------------------------------------------|-----------|
| IV.2.3 Uji Kecukupan Data .....                                                   | 42        |
| IV.2.4 <i>Value Stream Mapping Current State</i> .....                            | 43        |
| IV.2.5 <i>Process Activity Mapping Current State</i> .....                        | 44        |
| IV.2.6 Identifikasi dan Analisis Penyebab <i>Waste Waiting</i> .....              | 44        |
| IV.3 Rancangan Usulan Perbaikan Terhadap Akar Penyebab <i>Waste Waiting</i> ..... | 47        |
| IV.3.1 Usulan Perbaikan dengan Melakukan Penyeimbangan Lini .....                 | 48        |
| IV.3.2 Usulan Perbaikan dengan Pemberian Pelatihan dan Sertifikasi Menjahit ..... | 52        |
| IV.4 <i>Value Stream Mapping Future State</i> .....                               | 53        |
| IV.5 <i>Process Activity Mapping Future State</i> .....                           | 54        |
| <b>BAB V ANALISIS</b> .....                                                       | <b>55</b> |
| V.1 Analisis Kelebihan dan Kerurangan .....                                       | 55        |
| V.2 Analisis Perbandingan <i>Current State</i> dengan <i>Future State</i> .....   | 56        |
| <b>BAB VI KESIMPULAN DAN SARAN</b> .....                                          | <b>58</b> |
| VI.1 Kesimpulan .....                                                             | 58        |
| VI.2 Saran .....                                                                  | 58        |
| <b>DAFTAR PUSTAKA</b> .....                                                       | <b>60</b> |