ABSTRACT

PT XYZ Farma is a pharmacy company with one of its product namely LVP products. In the series of LVP production processes, it is necessary to carry out a 14-day WIP storage process as one of the requirements to ensure that consumers can get the best quality of the product. In the storage process carried out at WIP Warehouse, it was identified that there was inappropriate storage due to lack of shelves for WIP pallet storage. Based on these problems, a study was conducted aimed at optimizing the allocation of storage shelves in GWIP. By using the concept of lean manufacturing, identification of the causes of the problem is done at GWIP by using tools such as VSM, PAM, and 5Whys. Based on the identified problems, namely the allocation of storage shelves into staging racks due to the staging process, then the work standardization design is carried out on GWIP by calculating standard time and simplifying the work in the form of application design. The result of the proposal given is that with the application design and standard time calculation, the staging process can be removed and the 54 returns to its normal functioning as a storage rack, so that pallet storage does not occur outside the storage rack again. The results of this proposal are illustrated in a simulation using FlexSim software. Based on the simulation conducted, it was found that there was no pile in the GWIP after improvement.

Keywords: warehouse, lean manufacturing, work standardization, standard time, application design, FlexSim simulation.