



## **ANALISIS *LEAN WAREHOUSING* PADA GUDANG *FINISHED GOODS* PT DAGSAP ENDURA EATORE**

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### **INTISARI**

PT Dagsap Endura Eatore adalah perusahaan yang bergerak di industri makanan olahan, khususnya produk berbasis daging seperti sosis dan nugget. Perusahaan ini menghadapi tantangan dalam proses penerimaan dan pengiriman produk akhir yang belum optimal. Hal ini berpotensi mempengaruhi daya saing perusahaan di industri makanan olahan beku yang terus berkembang pesat seiring meningkatnya permintaan global. Optimalisasi distribusi, termasuk pengiriman tepat waktu dan efisien, menjadi faktor penting untuk menjaga keunggulan kompetitif perusahaan.

Penelitian ini bertujuan untuk mengidentifikasi pemborosan (*waste*), menentukan akar penyebabnya, serta memberikan usulan perbaikan berbasis pendekatan *lean warehousing* pada penerimaan dan pengiriman produk akhir di gudang PT Dagsap Endura Eatore. Metode yang digunakan meliputi *Value Stream Mapping* (VSM), *Value Stream Analysis Tool* (VALSAT), diagram tulang ikan (*fishbone diagram*), *pareto diagram*, dan 5S (*seiri, seiso, seiton, seiketsu, dan shitsuke*).

Hasil penelitian menunjukkan adanya waktu tunggu akibat waktu *loading* yang lebih lama dibandingkan stasiun kerja lainnya, kerusakan karton, serta gerakan forklift yang tidak efisien. Usulan perbaikan mencakup Penambahan tenaga bongkar muat (TKBM) atau penggunaan *slip sheet + push-pull forklift* pada proses *loading*, penambahan jumlah karyawan pada *shift* 2 dan 3 untuk mengurangi *bottleneck* karena *waiting*, penerapan sistem *putaway* langsung pada proses penerimaan barang guna meminimalkan *waiting time* dan mencegah terjadinya *defect* karton, penggunaan sistem kanban, serta implementasi 5S untuk menciptakan lingkungan kerja yang lebih rapi dan produktif. Hasil perbaikan menunjukkan peningkatan nilai *Process Cycle Efficiency* (PCE) dari 16,5% menjadi 32%.

**Kata kunci :** *Lean warehousing*, pemborosan, gudang produk akhir

## **LEAN WAREHOUSING ANALYSIS AT THE FINISHED GOODS WAREHOUSE OF PT DAGSAP ENDURA EATORE**

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### **ABSTRACT**

PT Dagsap Endura Eatore is a company engaged in the processed food industry, particularly in meat-based products such as sausages and nuggets. The company faces challenges in the receiving and delivery processes of finished goods, which remain suboptimal. This condition can potentially affect its competitiveness in the frozen processed food industry, which continues to grow rapidly in line with increasing global demand. Distribution optimization, including timely and efficient delivery, is therefore a critical factor in maintaining the company's competitive advantage.

This study aims to identify waste, determine its root causes, and provide improvement proposals based on a lean warehousing approach applied to the receiving and delivery processes in the finished goods warehouse of PT Dagsap Endura Eatore. The methods used include Value Stream Mapping (VSM), Value Stream Analysis Tool (VALSAT), fishbone diagram, Pareto diagram, and the 5S (seiri, seiso, seiton, seiketsu, and shitsuke) methodology.

The study's results show the presence of waiting time due to longer loading times compared to other workstations, damaged cartons, and inefficient forklift movements. Proposed improvements include adding loading and unloading personnel or using slip sheets and push-pull forklifts during the loading process, increasing the number of employees in the second and third shifts to reduce bottlenecks caused by waiting, implementing a direct putaway system during goods receiving to minimize waiting time and prevent carton defects, using a kanban system, and implementing 5S to create a tidier and more productive work environment. The improvements led to an increase in Process Cycle Efficiency (PCE) from 16,5% to 32%.

**Kata kunci :** *Lean warehousing, waste, finished goods warehouse*