

## Abstrak

Penelitian ini bertujuan menganalisis kinerja waktu standar pada proses produksi di UD Rahmat Food Industri dengan menerapkan pendekatan studi gerak, studi waktu, dan diagram Ishikawa. Data diperoleh melalui observasi, wawancara, dan dokumentasi di lini produksi keripik singkong. Analisis studi gerak dilakukan menggunakan diagram alir dan peta aliran proses yang menghasilkan nilai *value-added time* (VAT) peta metode sekarang sebesar 99% dan metode usulan sebesar 100%. Studi waktu memberikan hasil waktu standar untuk lima aktivitas utama; pengupasan 50 menit 53 detik, pemotongan 7 menit 45 detik, perendaman 2 menit 31 detik, penggorengan dan inspeksi 6 menit 15 detik, serta pengemasan 1 menit 12 detik. Diagram Ishikawa mengidentifikasi enam faktor utama penyebab ketidakefisienan: manusia, mesin, metode, material, pengukuran, dan lingkungan kerja. Hasil penelitian menunjukkan perlunya penetapan SOP tertulis, perawatan preventif mesin, dan pencatatan produksi harian. Usulan skema perencanaan proses produksi berbasis model IPO2 (*Input, Process, Output, Outcome*) diharapkan dapat meningkatkan efektivitas, efisiensi produksi, serta meminimalisasi pemborosan pada UD Rahmat Food Industri.

Kata Kunci: studi gerak, studi waktu, diagram Ishikawa, waktu standar, keripik singkong, efisiensi produksi, UMKM.

### ***Abstract***

*This study aims to analyze the standard time performance in the production process at UD Rahmat Food Industri using motion study, time study, and the Ishikawa diagram. Data were collected through observation, interviews, and documentation in the cassava chips production line. Motion study analysis used flow diagrams and process flow charts, revealing a current method value-added time (VAT) of 99% and 100% for the proposed method. Time study produced standard times for five main activities: peeling (50 minutes 53 seconds), slicing (7 minutes 45 seconds), soaking (2 minutes 31 seconds), frying and inspecting (6 minutes 15 seconds), and packing (1 minute 12 seconds). The Ishikawa diagram identified six key factors causing inefficiency: manpower, machine, method, material, measurement, and working environment. Results indicate the need for written SOP implementation, preventive machine maintenance, and daily production recording. The proposed production planning scheme based on the IPO2 (Input, Process, Output, Outcome) model is expected to enhance production effectiveness and efficiency, while minimizing waste in UD Rahmat Food Industri.*

*Keywords: motion study, time study, Ishikawa diagram, standard time, cassava chips, production efficiency, SME.*