

ANALISIS PRODUKTIVITAS PADA PENERAPAN

METODE 6S DI INDUSTRI TEKSTIL

STUDI PADA PT APAC INTI CORPORA, BAWEN, SEMARANG

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INTISARI

Industri tekstil merupakan salah satu industri prioritas nasional serta memiliki nilai ekspor yang menguat tiap tahunnya. Padatnya jumlah pesaing dalam industri tekstil mengharuskan suatu perusahaan menerapkan metode manajemen untuk mengurangi biaya produk dan pemborosan agar dapat bersaing di pasar domestik dan internasional. Lingkungan kerja merupakan tempat yang potensial mempengaruhi proses produksi. Salah satu metode atau teknik dari konsep *lean* yang digunakan untuk mengatur lingkungan kerja adalah 6S.

Metode 6S menciptakan standarisasi, pengorganisasian dan penyederhanaan lingkungan kerja, reduksi pemborosan dari aktivitas yang tidak diperlukan, sehingga kualitas, keefektifan dan efisiensi, serta keamanan meningkat. Berhasil atau tidaknya penerapan 6S dalam meningkatkan produktivitas (keefektifan dan efisiensi) diukur melalui salah satu pendekatan alat ukur yaitu *overall equipment effectiveness*.

Hasil dari penelitian ini menunjukkan adanya perbaikan kondisi lingkungan kerja yang menyebabkan peningkatan persentase *overall equipment effectiveness* sejak diterapkan metode 6S. Peningkatan nilai OEE menandakan adanya kenaikan produktivitas melalui reduksi *losses* yang meliputi *breakdown* dan *reduced speed*. Selain itu, hasil dari nilai OEE dan kuantifikasi 6S menunjukkan bahwa perusahaan perlu melakukan *improvement* untuk mencapai visinya sebagai *world class company*.

Kata Kunci: 6S, 5S, produktivitas, *overall equipment effectiveness*, *photo analysis*, kuantifikasi.

**PRODUCTIVITY ANALYSIS ON APPLICATION
OF 6S METHOD IN THE TEXTILE INDUSTRY**

STUDY ON PT APAC INTI CORPORA, BAWEN, SEMARANG

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ABSTRACT

Textile industry is one of the national industry's priorities and the value of exports has strengthened each year. The density amount of competitors in the textile industry requires a company to apply management methods to reduce costs and waste products in order to compete in domestic and international markets. Work environment is potentially affect the production process. One of the methods or techniques of lean concepts which are used to regulate the working environment is 6S.

6S method creates standardization, organizing and simplifying the work environment, reducing waste from activities that are not needed, so the quality, effectiveness and efficiency, as well as increased security. Success or failure of the implementation of 6S in increasing productivity (effectiveness and efficiency) were measured by measuring instrument approach that is overall equipment effectiveness.

Results from this study demonstrated an improvement in working conditions led to an increase in the percentage of overall equipment effectiveness since applied the 6S method. Increased OEE value indicates an increase in productivity through the reduction of losses, which includes the breakdown and reduced speed. In addition, the results of OEE values and quantification of 6S indicates that the company needs to make improvement to achieve its vision as a world class company.

Keywords: 6S, 5S, productivity, overall equipment effectiveness, photo analysis, quantification.