

ABSTRACT

The number of defective products returned makes productivity decrease, in the production of Dwi Putro stamp batik cloth in 2019-2021 the amount of cloth money returned is around 14%-20%, so it affects production productivity so that waste identification is carried out to find out the waste that has a higher influence. In this study, waste identification was carried out by finding out in advance the cycle time and production process using Value Stream Mapping for the results of the lead time obtained 74.04 minutes and MCE of 57% so that the time that did not provide added value was 43%. Identification was carried out using the Waste Assessment Model to find out what type of waste is a factor in the high waste so that overproduction is found at 22%, defects at 21.7%, and motion at 16.3%. A proposal for improvement using 5W + 1H was obtained, namely the causative factors divided into four including humans, materials, machines, and methods.

Keywords: Productivity, Value Stream Mapping, Waste Assessment Model