

CHAPTER 8

CONCLUSION AND SUGGESTION

8.1. Conclusion

Based on the data analysis, the research is considered to be successful in reducing the production time of Setiawan Mebel. With the chair production time that is reduced from average of 638.71 seconds/product completed reduced by 7.82% to 638.71 seconds/product completed. And the table production time that is reduced from average of 798.64 seconds/product completed reduced by 9.58% to 722.13 seconds/product completed

It can be concluded that the implementation of 5S lean manufacturing method on Setiawan Mebel is successful in reducing the time needed to produce the products. Thus hopefully reduce/minimize the amount of complaint by the customer because of late product completion and/or delivery.

8.2. Suggestion

For the implementation of 5S, one of the stages is Shitsuke which focuses on Long term implementation of 5S by disciplining the workers and management in doing the 5S steps. Because of that the author would like to suggest to the company to implement checklist on things to be noticed before or during production that will help the company keep the level of organization. The checklist in Table 8.1. is developed based on the observation result from this research. The inspection should be done weekly at the start of the week in order to keep the organizational level.

Table 8.1. Checklist 5S

Lembar Checklist Tempat Produksi		
Kriteria	Ya	Tidak
Apakah ada penumpukan sisa kayu yang dapat menghambat pekerjaan?		
Apakah ada alat kerja yang berserakan?		

Table 8.1. (Continued)

Apakah ada alat kerja yang dapat membahayakan yang dibiarkan begitu saja?		
Apakah ada alat dan bahan baku tidak diletakkan pada tempat yang seharusnya?		
Apakah ada objek yang tidak diperlukan berada di dalam area kerja?		

When any of the answer in the checklist is “ya” then the company and workers should work to eliminate the “abnormalities” that is found. The author would also like to introduce new SOP that will help in maintaining the organization level of the company in Table 8.2.

Table 8.2. Proposed Standard Operation Procedure (SOP)

Standar Operasional Prosedur di Setiawan Mebel	
No.	Aktifitas
1	Pekerja yang bekerja di sebuah area atau mesin bertanggung jawab atas kebersihan dan kerapian tempat kerja tersebut terkecuali untuk sisa kayu.
2	Pembersihan tempat kerja dilakukan minimal 2 kali dalam 1 minggu tergantung tingkat kebersihan dan ketersediaan pekerja.
3	Pelatihan 5S dilakukan sebaiknya minimal 1 kali dalam 1 tahun untuk mengingatkan pekerja dan pimpinan akan tanggung jawab mereka dalam 5S dan manfaatnya bagi mereka, dilaksanakan sebaiknya pada awal tahun pada bulan januari agar mudah diingat dan bisa dilakukan secara teratur.
4	Demarkasi area kerja diperbarui setidaknya 1 kali dalam 1 tahun atau dilakukan saat demarkasi sudah mulai pudar.
5	Pekerja membuang sisa pekerjaan di tempat yang sudah disediakan untuk mencegah penumpukan sisa produksi yang akan susah dibersihkan.

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