

**ELIMINASI PEMBOROSAN PADA PROSES PRODUKSI GULA  
KRISTAL PUTIH (GKP) DI PT. GENDHIS MULTI MANIS  
MENGUNAKAN VALUE STREAM MAPPING (VSM)**

**WAHYU PERMANA PUTRA**

(Pembimbing : Dr. Ir Rudi Tjahyono, , Dwi Nurul Izzhati, M.MT)

*Teknik Industri - S1, FT, Universitas Dian Nuswantoro*

*www.dinus.ac.id*

*Email : 512201300651@mhs.dinus.ac.id*

**ABSTRAK**

PT Gendhis Multi Manis mempunyai visi ingin menjadi perusahaan gula nasional terbaik yang mampu menjadi model percontohan dalam industri pergulaan nasional. Namun kondisi aktualnya waktu produksi Gula Kristal Putih adalah 2,79 hari, lebih lama dari standar perusahaan yaitu 2 hari. Tujuan dari penelitian dengan menggunakan tools value stream mapping adalah mengetahui value added dan non-value added dan jenis-jenis pemborosan pada sepanjang current state map kemudian dilakukan perumusan alternatif perbaikan dan hasil perbaikan tersebut dipetakan kedalam future state map. Dari hasil analisa current state map, terdapat pemborosan tipe one waste berupa pendampingan pekerja, dan tipe two waste berupa waktu menunggu bahan dari evaporator, kelebihan 1 orang tenaga kerja pemasangan pengaman tipper, gerakan tidak perlu operator tipper, kelebihan inventori sisa pagi 50-70%, pengulangan aktifitas material handling, dan defect colour GKP lebih dari 300 dan bag gula pecah. Alternatif perbaikan substitusi bahan menjadi 60% CaO dan 40% MgO, pengurangan 1 tenaga kerja di bagian tipper, penambahan alat gerobak sorong. Ada reduksi total waktu setelah perbaikan pada future state map yaitu dari 240858,72 menjadi 236830,81 detik atau 65,78 jam atau kurang lebih 2,74 hari.

Kata Kunci : Gula Kristal Putih, produksi, value stream mapping

## **THE ELIMINATION OF WASTE IN THE PRODUCTION PROCESS OF WHITE SUGAR (GKP) PT. MULTI GENDHIS SWEET USING VALUE STREAM MAPPING (VSM)**

**WAHYU PERMANA PUTRA**

(Lecturer : Dr. Ir Rudi Tjahyono, , Dwi Nurul Izzhati, M.MT)

*Bachelor of Industrial Engineering - S1, Faculty of  
Engineering, DINUS University*

*www.dinus.ac.id*

*Email : 512201300651@mhs.dinus.ac.id*

### **ABSTRACT**

PT Gendhis Multi Manis has a vision to be the best national sugar company capable of being a model model in national sugar industry. However, the actual condition of the production time of white sugar is 2.79 days, longer than the company standard is 2 days. The purpose of the research by using value stream mapping tools is to know the value added and non-value added and the types of waste along the current state map then done the formulation of alternative repair and the improvement results are mapped into the future state map. From the analysis of current state map, there is waste of one type of waste in the form of worker assistance, and the type of two waste in the form of waiting time of material from the evaporator, the excess of 1 person of the installation labor tipper, the movement does not need operator tipper, excess inventory the rest of the morning 50-70% , Repetition of material handling activity, and defect color white sugar more than 300 and bag broke sugar. Alternative materials substitution improvement to 60% CaO and 40% MgO, reduction of 1 worker in tipper part, addition of wheelbarrow. There is a total reduction of time after improvement in the future state map from 240858,72 to 236830,81 seconds or 65,78 hours or approximately 2.74 days.

Keyword : White Sugar, production, value stream mapping