

**ABSTRACT**

**OPTIMIZATION OF PRODUCTION PROCESS  
THROUGH LEAN MANUFACTURING PRINCIPLES TO  
IMPROVE EFFICIENCY**  
*(Case at Sari Sedap Cracker Factory in Ciamis District)*

**By:**

**Regina Nabila Berliana S**

**213402033**

**Guide I**

**:Edy Suroso**

**Guide II**

**:Alicia Deana Santosa**

*This study aims to optimize the production process through lean manufacturing principles to improve efficiency at Sari Sedap Cracker Factory, Ciamis District, using a quantitative descriptive approach and case study. Data were obtained through direct observation, to measure the time of each activity in the production process and identify the categories of Value Added (VA), Non Value Added (NVA), and Necessary Non Value Added (NNVA), and analyze waste based on the Seven Waste concept, so that motion, transportation, overprocessing, and defect activities were found. By implementing autonomous maintenance, training workers, and adding supporting facilities, the production flow becomes smoother and the process time can be optimized so that the production process becomes more structured, faster, and more efficient.*

**Keywords:** *Lean Manufacturing, Seven Waste, Value Added, Non Value Added, Necessary but Non Value Added, Efficiency, Process Cycle Efficiency*

**ABSTRAK**

**OPTIMALISASI PROSES PRODUKSI  
MELALUI PRINSIP *LEAN MANUFACTURING*  
UNTUK MENINGKATKAN EFISIENSI  
(Kasus pada Pabrik Kerupuk Sari Sedap di Kabupaten Ciamis)**

Oleh:  
**Regina Nabila Berliana S**  
**213402033**

**Pembimbing I                   :Edy Suroso**  
**Pembimbing II                :Allicia Deana Santosa**

Penelitian ini bertujuan mengoptimalkan proses produksi melalui prinsip *lean manufacturing* guna meningkatkan efisiensi di Pabrik Kerupuk Sari Sedap, Kabupaten Ciamis, dengan menggunakan pendekatan deskriptif kuantitatif dan studi kasus. Data diperoleh melalui observasi langsung, untuk mengukur waktu setiap aktivitas dalam proses produksi dan mengidentifikasi kategori *Value Added* (VA), *Non Value Added* (NVA), serta *Necessary Non Value Added* (NNVA), serta menganalisis pemborosan berdasarkan konsep *Seven Waste*, sehingga ditemukan aktivitas *motion*, *transportation*, *overprocessing*, dan *defect*. Dengan penerapan *autonomous maintenance*, pelatihan pekerja, dan penambahan fasilitas pendukung, maka alur produksi menjadi lebih lancar dan waktu proses dapat lebih optimal sehingga proses produksi menjadi lebih terstruktur, lebih cepat, dan lebih efisien.

**Kata kunci:** *Lean Manufacturing, Seven Waste, Value Added, Non Value Added, Necessary But Non Value Added, Efisiensi, Proses Cycle Efficiency*