

BAB VI

KESIMPULAN DAN SARAN

6.1 KESIMPULAN

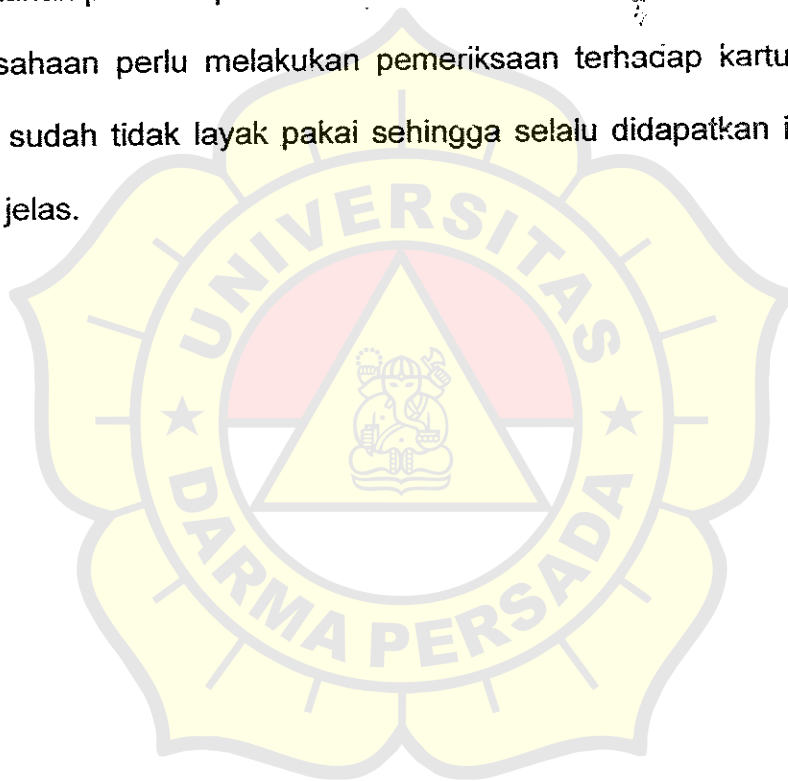
Berdasarkan hasil pengolahan dan analisis data yang telah dilakukan, maka dapat diambil kesimpulan sebagai berikut :

1. Kebutuhan kuantitas kartu kanban sangat mempengaruhi aliran informasi dari lini awal sampai finishing pada pembuatan kijing pick up ini, apabila kuantitas kanban yang diperlukan kurang maka tentunya akan terjadi bottleneck dari lini produksi tersebut sehingga diperlukan peramalan yang akurat.
2. Di dalam menentukan kuantitas kanban untuk 6 periode ke depan dari komponen-komponen pendukung kijing pick up diperoleh rata-rata hasil untuk komponen wire cowl sebanyak 8 unit kartu, glass front door sebanyak 7 unit kartu, glass right door sebanyak 8 unit kartu, silencer roof sebanyak 6 unit kartu, instrument sebanyak 8 unit kartu, cluster finish sebanyak 6 unit kartu, glass windshild sebanyak 6 unit kartu, head kamp left sebanyak 6 unit kartu, head lamp pright sebanyak 7 unit kartu dan fender liner sebanyak 8 unit kartu.

6.2 SARAN

Berdasarkan hasil kesimpulan maka penulis mencoba memberikan saran-saran yang dapat bermanfaat bagi perusahaan tempat dimana penulis melakukan penelitian sebagai berikut :

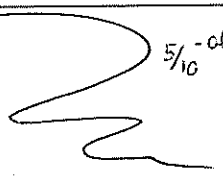
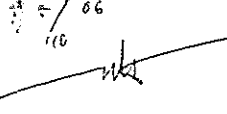

1. Aktivitas pengukuran kuantitas kanban untuk kedepannya perlu dikaji lebih mendalam sehingga akan didapatkan hasil yang sesuai dengan kebutuhan pada lini produksi.
2. Perusahaan perlu melakukan pemeriksaan terhadap kartu kanban yang sudah tidak layak pakai sehingga selalu didapatkan informasi yang jelas.

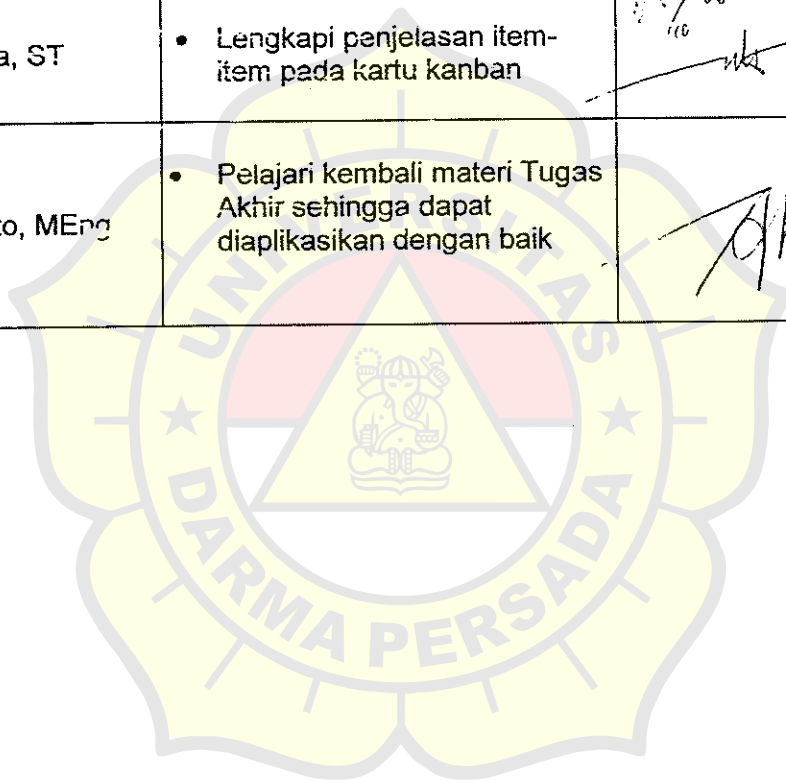


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- Baroto Teguh, “ **Perencanaan dan Pengendalian Produksi**”, Ghalia Indonesia, Jakarta, Cetakan pertama, 2002.
- Gaspersz Vincent, “ **Production Planning and Inventory Control. Berdasarkan Pendekatan Sistem Terintegrasi MRP II dan JIT Menuju Manufakturing 21**”, Jakarta, Gramedia Pustaka Utama, 2002
- Kusuma Hendra, “**Perencanaan dan Pengendalian Produksi**”, Andi Yogyakarta, Cetakan kedua, 2002.
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- Suzaki Kiyoshi, “ **Tantangan Industri Manufaktur**”, PQM, Jakarta, 2002.

LEMBAR PERBAIKAN

Nama	Perbaikan	Paraf
Ir. Budi Sumartono, MT	<ul style="list-style-type: none">• Penulisan abstrak pada daftar isi belum tercantum• Buat histogram pada bab V• Bab V analisis dan pembahasan diuraikan	 5/10 - 06
Ade Supriatna, ST	<ul style="list-style-type: none">• Lengkapi penjelasan item-item pada kartu kanban	 5/10 - 06
Ir. Atik Kurnianto, MEng	<ul style="list-style-type: none">• Pelajari kembali materi Tugas Akhir sehingga dapat diaplikasikan dengan baik	 5/10 - 06





KANBAN SYSTEM JOB CLEARANCE

(Between Production Control Division and Assy Production Division at Sunter I)

0	JOB DESCRIPTION	P I C		REMARKS
		PCD	Prod'n	
PRODUCTION PREPARATION STATE				
	1. Master List of Kanban Maintenance	●		
	2. Min / Max List Making	●		
	3. Kanban Adjustment (data Transfer)	●		
	4. Kanban Making. Color labelling & Bagging		●	
	5. Part Label Making		●	
	6. Part Label maintenance		●	
	7. Box spec requirment list	●	●	
	8. Delivery System (Kanban Schedule, Jundate, Junbiki Del. Time, Box Spec, Cycie Issue & other) Negotiation	●	●	
	9. PCI Making & MLOK Maintenance	●		
	10. PCI Follow Up	●		
TRIAL PREPARATION STATE				
	1. Part Order Arrangement	●		
	2. Kanban & D/N (Del. Note) making	●		
	3. Part Receiving		●	
	4. Delay Delivery Information	●		
	5. Catch -Up Schedule of Delay Delivery	●		
	6. Out Standing Order Follow Up	●		
	7. Trial Report	●		
DAILY JOB (SVP STATE)				
	1. Kanban Operation		●	
	a. Delivery Note Sign & Stamp		●	
	b. Kanban Collecting & Posting		●	
	c. Kanban Reading		●	
	d. Kanban Control & analizis (Daily)		●	
	e. Request for loss kanban (for refleccment)		●	
	f. Loss kanban Making		●	

- g. Setting Order (+/- Kanban)
- h. Additional / emergency order requirement to Supplier (fax & phone)
- i. Making D/N for additional Order
- j. Send & fax for additional order
- k. Critical part pulling (caused by Prod'n)
- l. Supplier Delivery Time Control ()
- m. Catch up Schedule of Delay / shortage (in case Supplier problem)
- n. Outstanding order follow up
- o. Part shortage analysis & report (in case Cripple & Line Stop)
- p. Monthly Delivery report and meeting Arrangement
- q. KBS old data Deletion

2. Damage part and Repair Parts

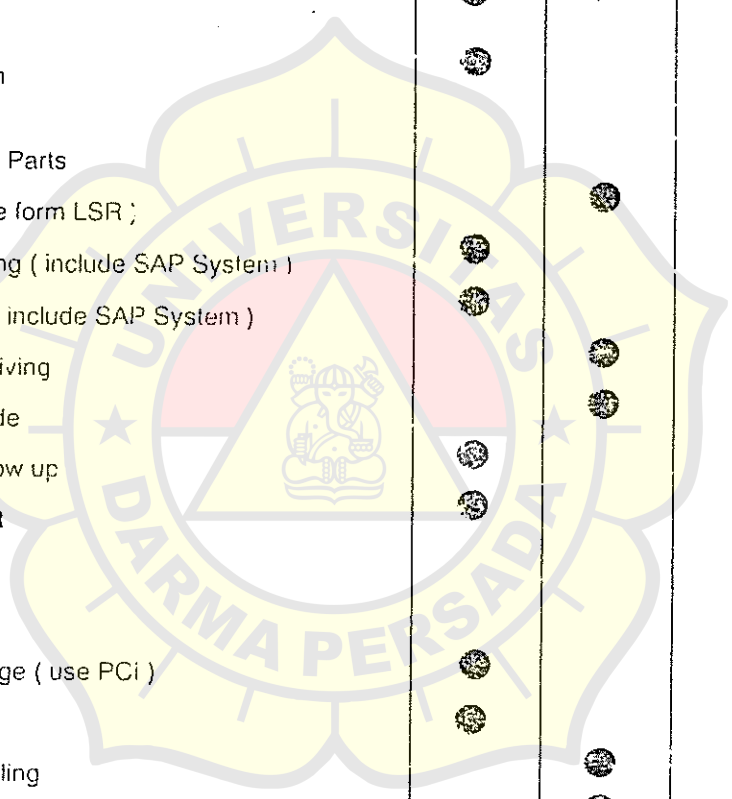
- a. Part requirement (Use form LSR ;
- b. Additional Order Making (include SAP System)
- c. Repair Order Making (include SAP System)
- d. Part & Del. Note Receiving
- e. Part Supply to Line Side
- f. Delivery Order & Follow up
- g. Monthly Report of LSR

3. Delivery System Change

- a. Delivery System Change (use PCI)
- b. MLOK maintenance
- c. Kanban Print Out, Labelling
- d. Setting Order

4. Part Location Change

- a. Part change Location Information
- b. MLOK maintenance
- c. Kanban Print Out, Labelling
- d. Setting Order



7 MONTHLY JOB


1. Total Activity Schedule of Kanban Inventory and Adjustment

2. Kanban Inventory

- a. Schedule of Kanban Inventory
- b. Circulation (Data) / list Print Out
- c. Kanban Inventory
- d. Analysis & cross check
- e. Kanban Print Out
- g. Setting Order
- h. Summary & report

3. Kanban Monthly Meeting

- a. Material Preparation
- b. Invitation

Note :  Job responsibility

Jakarta, November 12, 2001

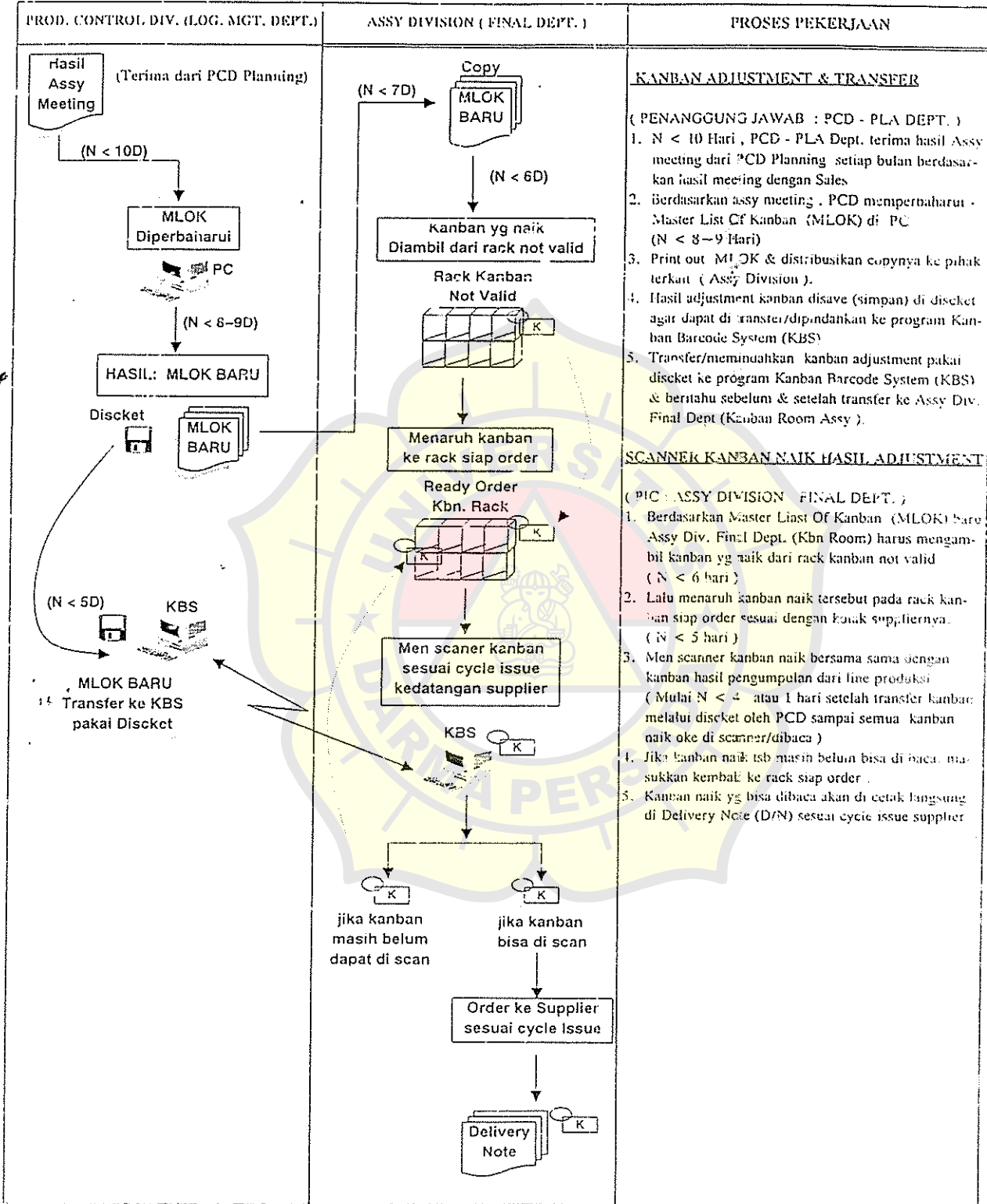
ASSY PRODUCTION DIVISION			PRDUCTION CONTROL DIVISION		
Div. Head	Exc. Coordinator	Dept. Head	Div. Head	Exc. Coordinator	Dept. Head
Sarwono	K. Takemasa	I Nyoman WA	I Made Dara MT.	T. Uchitani	Sapuranno

by A. Hasin in accordance with local sinter assembly

PCD - LMD	ASSY DIVISION - FINAL DEPT.	
	SIHIT RED	SIHIT WHITE

STANDAR OPERASIONAL PROSES (SOP)

KANBAN ADJUSTMENT, TRANSFER & READING (UNTUK KANBAN NAIK)



DIDISTRIBUSIKAN KEPADA :

- TAM ASSY DIVISION (AD) - Bapak 2, Yakernasa -> Sersan -> > M. Lisa I.F
- TAM PRODUCTION CONTROL (PCD) - Bapak 2, I Made Dama -> E. Uchiani -> Saparatu
- FILE

FROM
NTC

63102-0B010-A

FOR
06/WELDING

R/B SPEC
A1

PANEL SUB-ASSY. WINDSHIELD HEADER. INNER

UN. NO
10-MB

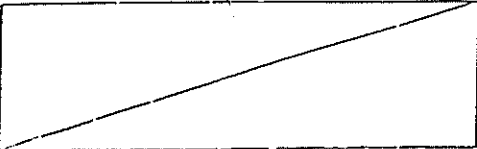
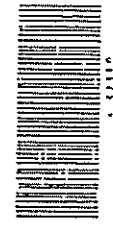
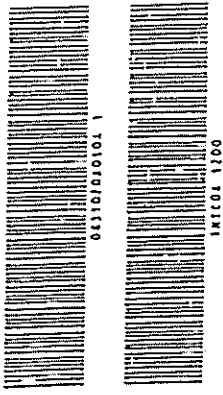
PCS/KBN
120

312 MB

SPCL CODE
47180-

KBN NO
0

KBN TYPE
TEMPORARY



FROM
S/P

4

61161-0B010-B

FOR
06/WELDING

R/B SPEC
A1

PILLAR, FR BODY, INNER RH

UN. NO
9-SH

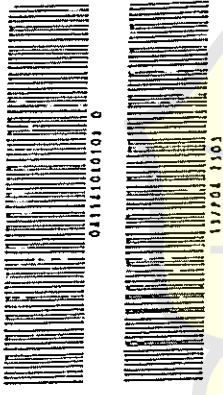
PCS/KBN
250

411 SH51

SPCL CODE
24630

KBN NO
3/3

KBN TYPE
CYCLIC



SAMPLE KANBAN



PT. TOYOTA-ASTRA MOTOR
WELDING PLANT

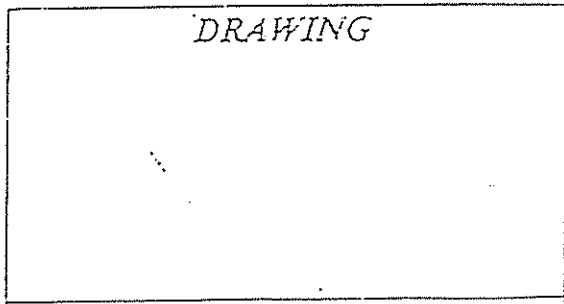
MODEL
ROUTING

5107
T2571BT1TT1S

INTERNAL KANBAN

53102-0B010

GRILLE RADIATOR S/A



OM:

SUPPLY TO :

27

MINIMUM STOCK

23 PCS