

***Application of Kaizen to Increase Productivity of Tofu Production Using Six Sigma Methods at UD. Mulya Jaya, Situbondo Regency; Supervisor
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ABSTRACT

The industrial sector in Indonesia which is experiencing rapid development is the manufacturing industry sector. The tighter industrial competition has resulted in every manufacturing company needing to maintain its position by increasing productivity. UD. Mulya Jaya is one of the manufacturing industries (factories) that produce soybean commodity tofu. The existence of a high level of production requires this manufacturing industry to carry out the production process properly so that the results produced are in accordance with consumer expectations. Even though the production process has been carried out well, it is undeniable that defects and waste are still found in the production process. This study aims to analyze the waste that occurs in tofu production lines to increase production productivity of tofu business. This research uses quantitative descriptive with the method of: (a) Six Sigma (DMAIC) method and (b) proposed improvements through the application of Kaizen 5W + 1H. The results of this study indicate that: (1). On the production line tofu UD. Mulya Jaya has 8 types of waste, namely Defect, Overproduction, Waiting, Not Utilizing Employees Knowledge Inventories, Transportation, Motion, and Excess Processing, (2). The DPMO value obtained is 35013.81215 and the sigma level value is 3.31 sigma, which means that in producing 1000000 opportunities the product will experience a defect of up to 35,014 products. (3). The most dominant cause of waste in the tofu production process is defect waste in acidification and printing with a score of 3. (4). Recommendations for improvements given using the application of kaizen are providing training to employees, repairing equipment mechanism, buying Ph meter and LATOHU (automatic tofu cutting tools), making SOPs related to production processes, and always controlling the workplace.

Keywords: Productivity, Six Sigma, Kaizen