ABSTRAK

Indonesia merupakan negara Muslim terbesar di dunia. PT SUKORINTEX merupakan Pabrik sarung tenun dengan merk dagang WADIMOR, perusahaan ini memiliki beberapa departemen yaitu Departemen Persiapan, Departemen *Weaving* I dan II, Departemen *Finishing*, dan Departemen *Packaging*. Mesin kanji pada Departemen Persiapan merupakan mesin yang berguna untuk menutup/menidurkan bulu dan memberikan semacam lapisan terhadap gulungan benang sebelum ditenun agar serat dari benang menutup agar benang tidak gampang putus ketika di tenun di Departemen *Weaving*. Berdasarkan data *speed loss* diatas mesin kanji 1 kehilangan sebesar 13.182 kodi dalam 3 bulan, mesin kanji 2 kehilangan 32.846 kodi dalam 3 bulan, mesin kanji 3 kehilangan sebesar 5.863 kodi dalam 3 bulan, mesin 4 kehilangan 6285 kodi dalam 3 bulan dan mesin kanji 5 kehilangan 42.207 kodi dalam 3 bulan. *Speed loss* merupakan salah satu *losses* dari *six big loss* Penelitian ini bertujuan untuk mengetahui akar penyebab dari *speed loss* dan mengetahui cara teknis dari untuk meminimasi *speed loss*. Penelitian ini menggunakan metode *five whys analysis* kemudian diperkuat menggunakan metode FMEA. Sebelum dilakukan analisis menggunakan *five whys analysis* dan FMEA, melakukan identifikasi apakah *speed loss* merupakan *losses* terbesar dari *six big losses*. Berdasarkan hasil analisis menggunakan *five whys analysis* dan FMEA, didapatkan akar masalahnya adalah sanggan kendor, mesin *overload*, mesin *error*, sanggan kress cucuk, dan uap drop. Selanjutnya didapatkan rekomendasi usulan dari akar permasalahan tersebut berupa penggantian bahan penanda kress, menyempurnakan SOP, dan meningkatkan kedisiplinan operator dan setelah dilakukan penerapan rekomendasi usulan selama 5 hari didapatkan penurunan *speed loss* 7 menit dan jika dikonversikan menggunakan *ideal run rate* didapatkan tambahan sebesar 10,22 kodi.

Kata kunci: *six big losses*, *speed loss*, *five whys analysis*, FMEA

ABSTRACT

Indonesia is the largest Muslim country in the world. PT SUKORINTEX is a woven sarong factory with the trademark WADIMOR, this company has several departments, namely Preparation Department, Weaving Department I and II, Finishing Department, and Packaging Department. The starch machine in the Preparation Department is a machine that is used to cover / lay down feathers and provide a kind of coating to the spools of yarn before weaving so that the fibers from the yarn cover so that the yarn does not break easily when weaving in the Weaving Department. Based on the speed loss data above sizing machine 1 lost 13,182 kodi in 3 months, sizing machine 2 lost 32,846 kodi in 3 months, sizing machine 3 lost 5,863 kodi in 3 months, sizing machine 4 lost 6285 kodi in 3 months and sizing machine 5 lost 42,207 scores in 3 months. Speed loss is one of the losses from six big losses. This study aims to determine the root cause of speed loss and to know the technical way to minimize speed loss. This research uses the five whys analysis method and then strengthened using the FMEA method. Before doing the analysis using five whys analysis and FMEA, identify whether the speed loss is the largest of the six big losses. Based on the results of the analysis using five whys analysis and FMEA, it was found that the root of the problem is sanggan kendor, *machine overload, machine error,* sanggan kress cucuk, *and steam drop. Furthermore, a recommendation is obtained from the root of the problem in the form of changing the stress marker material, improving the SOP, and increasing operator discipline and after implementing the recommendations for 5 days, a 7 minute reduction in speed loss is obtained and if converted using the ideal run rate, an additional 10.22 scores are obtained.*

Keywords: six big losses, *speed loss*, *five whys analysis*, FMEA