

Analisis Peningkatan Produksi Dengan Penerapan 5 S (*Seiri, Seiton, Seiso, Seiketsu, Dan Shitsuke*) Pada Proses Produksi Kacamata *Custome* Di Jogja Eyewear, Sleman - Yogyakarta

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**ABSTRAK**

Jogja Eyewear Optik adalah usaha yang dirintis sejak tanggal 9 Mei 2019. Perusahaan ini bergerak di bidang optikal, yaitu menjual kacamata. Penjualan dilakukan melalui *offline store* (toko luring) dan melalui promosi *online*. Setelah mendapat pesanan dari konsumen kemudian proses produksi dilakukan (*make to order*). Dalam melakukan produksi kacamata *custome* sering terjadi kecacatan produk, bahkan hampir setiap hari. kecacatan produk terjadi akibat dari tingkat produktivitas pekerja (karyawan) rendah sehingga jumlah produk yang dihasilkan juga akan rendah, baik dari segi jumlah maupun segi kualitas, begitupun sebaliknya. Dari permasalahan tersebut perlu strategi untuk meningkatkan produktivitas kerja karyawan. Dengan meningkatkan produktivitas kerja karyawan bagian produksi di Jogja Eyewear, dengan menerapkan 5 S (*Seiri, Seiton, Seiso, Seiketsu, dan Shitsuke*).

Penerapan 5 S (*Seiri, Seiton, Seiso, Seiketsu, dan Shitsuke*) dilakukan untuk membandingkan tingkat produktivitas kerja karyawan sebelum dan sesudah penerapan 5 S. Setelah dilakukan penerapan 5 S maka dapat dilihat perbedaan bagian produksi di Jogja Eyewear. Berdasarkan grafik pengolahan data sebelum penerapan 5 S, kecacatan produk kacamata *custome* dari 12 hari terjadi kecacatan selama 7 hari dan 5 hari tidak terjadi kecacatan dengan total kecacatan kacamata *custome* sebanyak 13 unit. Sedangkan setelah penerapan 5 S, kecacatan kacamata *custome* dari 12 hari hanya terjadi 2 hari dan 10 hari tidak terjadi kecacatan dengan total kecacatan kacamata *custome* sebanyak 3 unit.

Melalui penerapan 5 S (*Seiri, Seiton, Seiso, Seiketsu, dan Shitsuke*) bagian produksi di Jogja Eyewear terlihat cukup jelas perbedaan jumlah kecacatan lebih kecil setelah penerapan 5 S dibandingkan jumlah kecacatan sebelum penerapan 5 S. Hal ini menunjukkan bahwa penerapan 5 S berpengaruh terhadap tingkat produktivitas kerja karyawan bagian produksi di Jogja Eyewear.

**Kata Kunci: Penerapan 5 S, Tingkat Produktivitas, Kacamata *Custome***

Analysis of Increased Production With the Application of 5 S (*Seiri*, *Seiton*, *Seiso*, *Seiketsu*,  
Dan *Shitsuke*) In the Production Process of Custome Glasses in Jogja Eyewear, Sleman -  
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**ABSTRACT**

Jogja Eyewear Optics is a business that was started on May 9, 2019. This company is engaged in the optical field, which is selling glasses. Sales are made through offline stores (offline stores) and through online promotions. After receiving orders from consumers, the production process is carried out (make to order). In the production of custom eyewear, product defects often occur, even almost every day. Product defects occur as a result of the level of productivity of workers (employees) is low so that the number of products produced will also be low, both in terms of quantity and quality, and vice versa. From these problems, a strategy is needed to increase employee productivity. By increasing the work productivity of employees in the production department at Jogja Eyewear, by applying the 5 S (*Seiri*, *Seiton*, *Seiso*, *Seiketsu*, and *Shitsuke*).

Application of 5S (*Seiri*, *Seiton*, *Seiso*, *Seiketsu*, and *Shitsuke*) were carried out to compare the levels of employee work productivity before and after the implementation of 5S. After the implementation of 5S, it can be seen the difference in the production section in Jogja Eyewear. Based on graph of data processing before the application of 5S, defects in custome glasses products from 12 days occurred for 7 days and 5 days there were no defects with a total of 13 units of custome glasses defects. Meanwhile, after the application of 5S, defects in custome glasses from 12 days only occurred 2 days and 10 days there were no defects with a total of 3 units of custome glasses defects.

Through the application of 5 S (*Seiri*, *Seiton*, *Seiso*, *Seiketsu*, and *Shitsuke*) production department at Jogja Eyewear it is quite clear that the difference in the number of defects is smaller after the application of 5S compared to the number of defects before the application of 5S. This shows that the application of 5S affects the level of work productivity of production employees in Jogja Eyewear.

**Keywords: Application of 5 S, Productivity Level, Custome Glasses**