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**Penerapan Pendekatan SMED untuk Mengurangi Waktu Pergantian dalam Proses Pengujian di Perusahaan Listrik Multinasional**

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**Implementing SMED Approach to Reduce Changeover Time in the Testing Process at an Electrical Multinational Company**

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**Abstract**—PT. XYZ is a company that produces electrical components, they make a product based on an engineer-to-order (ETO). PT. XYZ find the changeover time in the testing process is very high and still follow the time in the old factory. The focus of this research is to reduce changeover time and standardize the process. In this research, Single Minute Exchange of Dies (SMED) is a method that used in order to reduce the changeover time. Started by observing the entire changeover process from the process after the panel is tested on Post F to loading a new panel for testing on Post F. Suggested improvement proposals that can be made immediately will be implemented directly in the process. For the internal process, the improvement activities carried out are to make the activities run parallel. Then, for external activities, the improvement activities carried out are to make the activities run in parallel and change the work procedures at post F. Through Five S implementation will improve the speed changeover process. Through this improvement it can reduce the change over time by 54% and increase the number of panels that can be tested to 6 panels per work shift.  
**Keywords**— Electrical Component; SMED; Changeover Time; Five S Methodology; Process Improvement

**Abstrak**—PT. XYZ merupakan perusahaan yang memproduksi komponen listrik, mereka membuat produk berdasarkan Engineer-To-Order (ETO). PT. XYZ menemukan waktu pergantian pada proses pengujian sangat tinggi dan masih mengikuti waktu di pabrik lama. Fokus penelitian ini adalah untuk mengurangi waktu pergantian dan menstandarisasi proses. Dalam penelitian ini, Single Minute Exchange of Dies (SMED) merupakan metode yang digunakan untuk mengurangi waktu pergantian. Dimulai dengan mengamati seluruh proses pergantian dari proses setelah panel diuji pada Post F hingga pemasangan panel baru untuk pengujian pada Post F. Usulan perbaikan yang dapat segera dibuat akan diimplementasikan langsung dalam proses. Untuk proses internal, kegiatan perbaikan yang dilakukan adalah membuat kegiatan berjalan paralel. Kemudian, untuk kegiatan eksternal, kegiatan perbaikan yang dilakukan adalah membuat kegiatan berjalan paralel dan mengubah prosedur kerja di post F. Melalui penerapan Five S akan meningkatkan kecepatan proses pergantian. Melalui implementasi akan meningkatkan kecepatan proses pergantian. Melalui peningkatan ini dapat mengurangi waktu pergantian dan meningkatkan jumlah panel yang dapat diuji per shift kerja.

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