

## OPTIMIZATION FRENCH FRIES PRODUCTION USING THE JUST IN TIME METHOD IN THE INVENTORY MANAGEMENT COST SYSTEM AT THE CORAL (BAR AND RESTO) IN FODO VILLAGE, GUNUNGSITOLI CITY

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### Abstract

*This research is motivated by the consequences of the raw material ordering method which is still subjective, namely based on visual estimates without a structured system. This results in The coral experiencing a decrease in revenue and losses. The purpose of this study is to find out how the inventory management system at The coral in Fodo Village, Gunungsitoli City, To find out the application of the Just-In-Time method in the potato raw material inventory management system increases the efficiency of producing French fries, To find out how the effectiveness of the Just-In-Time method in reducing raw material waste and ensuring optimal raw material availability for producing French fries at The coral. This study uses a quantitative research approach, namely a research method that emphasizes objective measurements and statistical analysis of numerical data to test the established hypothesis. This study uses a company method approach and a just-in-time method that aims to test the independent and dependent variables between the company method and the just-in-time method. Thus, from the comparison of the two methods above, it can be concluded that purchasing raw potato raw material inventory using the just-in-time method at The coral can minimize raw material inventory according to production needs, to avoid damage to raw material stocks that affect the quality of raw materials such as potatoes that are easily damaged.*

**Keywords:** Seasonal Cycle, Raw Material Supplier Cooperation, Raw Material Quality, Inventory Purchasing, The Coral

### INTRODUCTION

Optimization is a systematic process aimed at finding the most optimal system solution by considering various constraints and variables. This is done to increase efficiency, reduce operational costs, or maximize output using the fewest resources. Production is the process of creating an output by managing various usable inputs. (N. Hadi, 2022), Production usually means making goods or services or increasing their utility value and benefits. According to (Rosmasari & Jatiningrum, 2021) One of the benefits of optimizing the production process

is reducing total costs, particularly storage costs. Furthermore, using this technique has been shown to increase profitability because all demand can be met without reducing sales.

Researchers conducted direct field observations at The Coral in 2024. The collected data was then analyzed to support this research. Data collection was conducted systematically every month, drawing on the researchers' experience working at the restaurant for three years. This provided researchers with a deeper understanding of the operational conditions and inventory management system in place.

Based on data on potato raw material purchases and usage at The Coral, an imbalance between purchases and usage is evident. In January, a 50 kg purchase was made, with only 28 kg used, leaving a 22 kg excess stock. Meanwhile, in February, a 30 kg purchase was made, with 28 kg used, leaving a 24 kg excess stock. This situation indicates that during that period there was an excess of raw material inventory, which potentially increased storage costs, the risk of quality degradation, and waste. This fact strengthens the research background to review the inventory management system to make it more efficient, for example through the implementation of the Just-In-Time method.

This excess inventory creates several problems. First, raw materials stored for too long are at risk of spoilage or deterioration, which can affect the taste and quality of the resulting French fries. Second, this excess inventory creates additional inventory costs, such as storage costs and potential raw material waste. In the production process, the quality of French fries is greatly influenced by the choice of raw materials, especially the type of potato used. Potatoes with a high starch content will produce crispier French fries that won't become soggy after frying. Furthermore, cutting technique and frying temperature also play a crucial role. Uniform cutting and frying at the correct temperature will produce evenly cooked and attractive products.

## **LITERATURE REVIEW**

### **Production optimization**

According to (Rosmasari & Jatiningrum, 2021) Optimization strategies in the production process are crucial for reducing total costs, particularly storage costs. This method also increases a company's profitability by reducing the risk of lost sales. Optimization is the process of finding the best solution within a system by considering various variables and existing constraints. The goal of optimization is to increase efficiency, reduce costs, or maximize output with limited resources. Production is the process of transforming inputs into outputs that have value and can meet customer needs. (Imtinan et al., 2021) This activity includes all efforts to create or increase the benefits of a good or service so that it can be used and provide added value. (N. Hadi, 2022).

According to Rosmasari & Jatiningrum (2021) The goal of production optimization is to create a production process that is efficient, effective, and responsive to market needs. By optimizing resource use, companies can reduce waste, lower production costs, and increase productivity. Ultimately, production optimization not only plays a role in improving operational performance but also supports the achievement of competitive advantage and overall business sustainability.

### ***Lean Manufacturing Just In Time***

According to Setiawan & Rahman (2021) One of the goals of lean manufacturing is to reduce the amount of waste in business operations. This approach focuses on reducing production lead times. Lean Manufacturing is a management approach that aims to reduce waste in the production process through the implementation of strategies such as Just-In-Time (JIT) and Value Stream Mapping. The manufacturing industry plays a vital role in the global economy, particularly in driving economic growth, creating jobs, and improving social welfare.

Setiawan & Rahman (2021) revealed that there are main principles in lean manufacturing, namely: (1) Determining Value, (2) Mapping the Value Stream (Value Stream Mapping), (3) Creating Flow, (4) Using a Pull System, (5) Continuous Improvement (Kaizen).

The relationship between Lean Manufacturing and Just in Time is very close because they complement each other in creating a lean and efficient production system. Just in time is not only a method of inventory control, but also a crucial part of the Lean system that emphasizes smooth workflow, minimal disruption, and adaptability to actual demand. In the context of Lean, Just in time functions to ensure that each step in the production process only runs when there is demand, and does not produce unnecessary excess. (Setiawan & Rahman, 2021).

According to (Rahmadani et al., 2024) The Just-In-Time method is considered to increase productivity, reduce waste, and encourage overall product quality improvements in the Indonesian MSME industry. (Lorenza et al., 2024), the Just-In-Time method is a management approach intended to improve operational efficiency, reduce wasted time, and increase productivity.

### **Inventory Management**

According to (SN Hadi et al., 2020) Inventory is crucial to business operations, both in manufacturing and trading. In manufacturing companies, raw materials are essential to ensuring the smooth running of production processes.

There are several main objectives that inventory management in a company wants to achieve according to (Lorenza et al., 2024):

1. To maintain inventory availability in industrial companies, inventory management is responsible for ensuring that raw materials or products are available when needed. This allows production and sales to continue running smoothly.
2. Inventory costs can be reduced by implementing good inventory management, especially for costs related to storage, handling, and insurance of goods.
3. By maintaining a balance between the availability and demand of goods to prevent unwanted shortages or accumulation, inventory management also aims to prevent shortages or excess stock.
4. Organized inventory management can improve operational efficiency because production and sales processes can run smoothly without disrupting the availability of limited materials or products.

However SN Hadi et al., (2020) states that there are several problems that are often unidentified in inventory management, such as first, when the company's stock is greater

than actual production needs, it is called overstock. Second, stock shortages, also known as stockouts, occur when inventory is insufficient to meet customer demand, especially when demand increases. Third, waste is the result of inefficient raw material management, such as damage, expiration, or spoilage.

### **Inventory Cost**

According to O. Oktaviani, 2021, raw material inventory costs can be defined as the total financial costs incurred by a company to obtain, store, and manage raw materials, semi-finished goods, and finished products that will be used in the production process or redistributed to meet market demand or customer demand.

The impact of excess inventory and shortage of inventory according to (Rosmasari & Jatiningrum, 2021) that is :

1. Excess inventory can increase storage costs and increase the likelihood of obsolescence or damage to goods. This situation can indirectly negatively impact an organization's overall profitability.
2. Production and sales can be disrupted if there is a shortage of raw materials. This situation can lead to lost revenue opportunities and the company's inability to meet market demand. Ultimately, this can damage the company's reputation and consumer confidence.

### **RESEARCH METHODS**

According to (Ali et al., 2022) Quantitative research relies on empirical facts that can be measured numerically. In this study, quantitative methods were used to determine the extent to which the Just-In-Time method helped manage inventory and optimize French fries production at The Coral, Gunungsitoli City. Researchers collected data such as the quantity of raw materials purchased, sales frequency, monthly production volume, and the level of material wastage during the production process.

This quantitative descriptive study aims to see the differences between predetermined variables and evaluate how the implementation of the Just-In-Time method affects stock management and French fries production at The Coral, Gunungsitoli City.

Researchers use two types of data: primary data and secondary data. Referring to the opinion (Rukhmana, 2021) Primary data is the primary information collected directly by researchers during research activities. This data comes from informants or respondents who are closely related to the variables being studied and is obtained through various methods, such as interviews, field observations, and questionnaires. Primary data is crucial for both qualitative and quantitative research because it can provide valid, relevant, and appropriate information about the phenomenon being studied. Data collection was carried out through observation, interviews, and documentation, all conducted directly at The Coral company.

## RESULTS AND DISCUSSION

### Results

**Table 1 The Coral Raw Material Data**

No	Month	Initial inventory (kg)	Purchase (kg)	Usage (kg)	Ending inventory of raw materials remaining
1	January	-	50	28	22
2	February	22	30	28	24
3	March	24	20	36	8
4	April	8	50	36	22
5	May	22	20	36	6
6	June	6	50	45	11
7	July	11	40	45	6
8	August	6	50	36	20
9	September	20	20	36	4
10	October	4	50	28	26
11	November	26	50	36	40
12	December	40	40	46	34

Source: The Coral's further processed raw material data.

The table above shows the monthly purchase of potato raw material inventory during 2024. This purchase of raw material inventory was carried out to meet production needs and avoid raw material stock shortages during the French fries production process.

French fries sales vary from month to month. This is due to seasonal production fluctuations. The lowest sales figure is 56 servings, the average maximum is 72 servings, and the highest is 92 servings.

The use of potato raw materials for French fries production varies each month. Where the lowest raw material use occurs in January, February, October with an average of 28 kg, the maximum raw material use occurs in March, April, May, August, September, November with an average of 36 kg, and the highest raw material inventory use occurs in June, July, and December at 45-46 kg. The utilization statistics above show that the total use of potato raw materials at The Coral is 436 kg.

From this data, we found that the lowest ending inventory was in September, at just 4 kg, while the highest ending inventory was in November, at 40 kg. To determine the average inventory and inventory costs for 2024 based on the data in the table above, the following formula can be used.

Processing the data is intended to determine the efficiency of the inventory of raw materials for French fries based on company policy. (Syamsudin et al., 2021) by:

1. Calculate the average purchase of raw materials (Q)

$$Q = \frac{\text{Total penggunaan bahan baku}}{\text{Frekuensi Pesanan}}$$

$$Q = \frac{436}{12 \text{ bulan}} = 36,33 \text{ kg/bulan } Q = 36.33 \text{ kg / month}$$

The average efficient purchase of raw material inventory is 36.33 kg to meet needs.

2. Calculating total inventory cost (TIC)

$$C = \left(\frac{Q}{2}\right) + OTI \left(\frac{D}{Q}\right)$$

Information :

O : Storage costs

Q: Use of raw materials for each order

D : Use of raw materials 2024

$$\begin{aligned} TIC &= \left(\frac{36 \text{ kg}}{2}\right) + Rp \ 15.000 \left(\frac{436 \text{ kg}}{36 \text{ kg}}\right) \\ &= 18 + Rp. 15,000 = Rp. 15,018 \\ &Rp. 15,018 \times 12,111 = 181,882 \\ TIC &= Rp. 181,882 \end{aligned}$$

Based on the calculation results, it can be seen that the total inventory costs during 2024 amounted to IDR 181,882 from the results. Efficiency of Company Data Calculation. With the following data details:

Table 4.1 Efficiency of company data calculation

No	Component	Mark
1	Total raw material usage	436 kg
2	Total inventory cost in 2024	Rp. 181,882

Source: Processed by Researchers

**Discussion**

**The raw material inventory system implemented at The Coral**

Based on the results of the researcher's analysis and observations, The Coral implements a traditional inventory system and relies on estimates or forecasts without a systematic strategy. This statement is in line with the statement of The Coral's owner, Mr. Bazaru Zebua, who stated: "We usually buy potatoes based on estimates only, Ridho. When stocks start to run low, we order more from the supplier. There is no specific schedule, it depends on how quickly the stock runs out. Sometimes when there are lots of visitors, the potatoes run out quickly. But when there are fewer visitors, the stock can last longer. We have also had excess stock due to inaccurate estimates."

From this statement, it can be seen in more depth that the ordering of raw materials, especially potatoes, by the company to the managing supplier did not pay any attention at all to the amount of use or the amount of stock remaining in the warehouse.

This situation certainly has its impacts and consequences, particularly on increased inventory costs for the company. In line with Lean Manufacturing theory, which emphasizes the elimination of waste, The Coral actually inadvertently creates waste due to the lack of a

systematic inventory management method. This statement aligns with the results of an interview with the business owner, who explained that: "If there is excess stock, there is long storage of raw materials, so potatoes often rot because they cannot be stored for long. Ultimately, they are thrown away and that is a loss. Conversely, if there is a shortage of stock, we are forced to buy at the market suddenly at a higher price and sometimes the quality is also inferior."

### Just-In-Time inventory system

*Just in time* The aim is to reduce storage costs, avoid waste, and ensure optimal raw material quality. In the context of perishable raw materials like potatoes, JIT implementation is particularly relevant because it can prevent losses due to spoilage.

The following is the method that researchers use to calculate the optimal order quantity and total inventory costs using the Just in Time Hayundra method. (Syamsudin et al., 2021)).

- a. Determining the Optimal Delivery Amount of Raw Materials Using the JIT Method

$$na = \frac{Q}{2a}$$

Information :

Q = Total raw material requirements

a = Average inventory of raw materials

$$na = \frac{436 \text{ kg}}{2 \times 36,33 \text{ kg}}$$

$$na = \frac{436 \text{ kg}}{72.66} = 6 \text{ times delivery}$$

So the optimal number of just in time deliveries in one year is 6 deliveries. This can reduce shipping costs and excess stock of raw materials which can result in damage.

- b. Determining the Optimal Order Quantity of Raw Materials Using the JIT Method

$$Qn = \sqrt{n \cdot Q}$$

Information :

n = Number of raw material deliveries

Q = Optimal order quantity

$$Qn = \sqrt{6 \times 436}$$

$$Qn = 2.44 \times 20.88 = 50.94$$

$$Qn = 50 \text{ kg}$$

So the optimal quantity of raw material orders using the just in time method for seasonality is 50 kg each time the potato raw material inventory is delivered.

- c. Determining the Frequency of Ordering Raw Materials Using the JIT Method

$$N = \frac{Qn}{n}$$

Information :

$Q_n$  = Optimal raw material order quantity

$N$  = Optimal number of shipments during a period

$$N = \frac{50}{6} = 8.33 \text{ times ordering}$$

$$N = 8 \text{ orders}$$

So the optimal frequency of ordering raw materials using the just-in-time method is 8 orders.

d. Calculating Raw Material Inventory Costs

$$TJIT = \frac{1}{\sqrt{n}}(T)$$

Information :

$T$  = Total cost of raw material inventory

$N$  = Optimal number of shipments

$$TJIT = \frac{1}{\sqrt{6}}(\text{Rp } 181.882)$$

$$= 1 \times \text{Rp. } 181,882 = = \text{Rp. } 74,541 \frac{181.882}{2,44}$$

So by using the just in time method, the raw material inventory cost is lower, namely IDR 74,541 compared to the traditional method, the inventory cost is IDR 181,882.

The implementation of the Just in Time method at The Coral has significant potential to improve inventory cost efficiency. By minimizing stock, reducing storage costs, and preventing losses due to damaged materials, which can be seen from the previous storage cost of Rp 181,882 and the just in time calculation of Rp 74,541. With this, The Coral can increase profitability while maintaining product quality. These results indicate that the transition from a traditional system to a Just in Time system is a strategic step for this restaurant.

**Effectiveness of Just-In-Time inventory method**

The effectiveness of implementing the Just-In-Time method in the context of inventory management can be seen in how well it achieves its primary goal: reducing costs and waste without disrupting production. Just-in-time focuses on meeting raw material needs "just in time," preventing excess inventory from sitting idle in the warehouse.

Prior to Just-in-Time data calculation, The Coral used a traditional, forecast-based inventory system. This system resulted in high storage costs because potatoes were often purchased in large quantities and stored for too long. As a result, potatoes were susceptible to spoilage and quality loss, increasing inventory costs not only from storage but also from losses from spoiled materials.

By implementing just-in-time (JIT) processes, The Coral can order potatoes more frequently in smaller quantities to meet daily or weekly production needs. This method reduces holding costs because raw materials don't need to be stored in the warehouse for extended periods.

The effectiveness of just-in-time (JIT) in reducing storage costs depends heavily on collaborative relationships with suppliers and accurate demand data. The Coral needs to maintain close communication with its potato suppliers to ensure timely delivery. Furthermore, the restaurant needs accurate sales records to predict daily demand and avoid stockouts that could hamper service.

Overall, based on the data calculations above, the implementation of the Just in Time method at The Coral has the potential to be highly effective in reducing potato raw material storage costs. With minimal inventory and just-in-time ordering, the restaurant can save on warehouse costs, reduce losses due to excess ingredients, and improve service quality. Successful implementation of Just in Time will have a direct impact on cost efficiency and business profitability without sacrificing product quality.

## CONCLUSION

From the results of this study, researchers can conclude that:

1. Raw material inventory at The Coral is still managed manually and traditionally, without a defined accounting standard. This system results in prolonged storage and the risk of losses due to potato spoilage when stocks are overstocked, as well as lost sales when stocks run out. These findings provide a crucial basis for research proposing improvements through the implementation of Just-In-Time methods for more efficient inventory management.
2. The implementation of the Just in time method at The Coral has significant potential in increasing inventory cost efficiency. By minimizing stock, reducing storage costs, and preventing losses due to damaged materials, it can be seen from the calculation of previous company data of Rp 181,882 and with the calculation of just in time data it can be seen at Rp 74,541 with a difference of Rp 107,341. By using the just in time method, The Coral can increase profitability while maintaining product quality. These results indicate that the transition from a traditional system to a Just in time system is a strategic step for this restaurant.
3. The effectiveness of just-in-time (JIT) in reducing storage costs depends heavily on collaborative relationships with suppliers and accurate demand data. The Coral needs to maintain close communication with its potato suppliers to ensure timely delivery. Furthermore, the restaurant needs accurate sales records to predict daily demand and avoid stockouts that could hamper service.

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