

ABSTRACT

PT. Karya Kita is one of the private companies engaged in manufacturing, which produces books, newsletters, magazines, and tabloids. To complete consumer demand, the company implemented the system make to order. In meeting consumer demand, the company must maintain the quality of the product to enhance the productivity and efficiency. PT. Karya Kita producing various types of books and other printed materials that are distinguished by the name of the project. However, the type of project the most widely produced sustainably is the GMP project. Because, demand of this project is quite large and there is any data in each month in years 2013. Based on company data, defect rate in April to December 2013 is above the tolerance limits allowed by the company, that is above 3%. With the biggest defect in September with the percentage of 10% and the smallest in November with a percentage of 4.2%. Therefore, it is necessary to design an improvement to the production process in an effort to minimize waste defect.

In an effort to minimize waste defect, use lean manufacturing methods. Research phase begins with identifying the dominant cause of waste defect on the cover of the book production process GMP. Preliminary analysis done by the depiction diagram Value Stream Mapping (VSM) defines the current state on the problem that occurred, fishbone diagrams and 5W. Preliminary analysis done by the depiction diagram Value Stream Mapping (VSM) defines the current state on the problem that occurred, fishbone diagrams and 5W. The root causes of the problem of generation of waste defect that has been identified to be translated using the fishbone diagram and 5W. Settlement of the problem is done for every root causes of waste by using lean manufacturing methods and produce proposals to minimize defect existing waste, including charting future state value stream mapping is used to compare the value of cycle time and visual control.

Key Note: Lean Manufacturing, Book Cover, Waste Defect, Value Stream Mapping, Process Activity Mapping.