

ABSTRACT

Abstract - PT Genta Trikarya is guitars manufacturing company. In this research, the main focus of the guitar type is bolt-on FKV guitars type. There are non-value added activities on the production process. One of the non-value added activities are waiting activity of operators and waiting for blackout or simply called waiting waste. In order to minimize the waiting waste, lean manufacturing approach will be used.

First step is collecting primary data for current state mapping with value stream mapping and process activity mapping. Based on mapping, the lead time is 109590.27 seconds with the value added activity is 96892.91 seconds or 88.41 % from the lead time. The cause of the waiting waste is determined using fishbone diagram then ranked the causes to find the dominant factors of waiting waste. The root cause of the dominant factors are determined using 5 why tool. 5W1H analysis is used to choose the proper improvement plans. The method used to design one of the improvements is line balancing so the waiting waste could be minimized.

The improvement plans to reduce the waiting waste are provide the timer for drying racks and tables, provide the generator-set, and line balancing. Based on the improvement plans, the determined lead time is 102331.78 seconds with the value added activity is 96892.94 seconds or 94.68 % from the lead time.

Key Word : Lean Manufacture, Waiting Waste, VSM, PAM, Line Balancing