

ABSTRACT

PT Genta Trikarya is a manufacturing company which produces wood-based guitars. In this research, the main focus of the guitar type is on bolt-on naked series FKV type guitars. Within the production process, non-value added activities were discovered. One of the non-value added activities that discovered were motion-based activity or simply called motion waste. In order to minimize the motion waste, lean manufacturing approach will be used in this research.

First step to minimizing the motion waste is collecting primary data for value stream mapping (VSM) current state and process activity mapping (PAM). Based on mapping, the total of value added activity is 96690.87 seconds or 88.46 % from the lead time and the total of non-value added activity because of motion waste is 1864.18 seconds. Next step is identifying the cause of the motion waste using fishbone diagram and searching for root cause of the motion waste using 5 why. The method used to design one of the improvements is 5S so the motion waste could be minimized and percentage of value added time could increases.

After the design of the proposed improvements, the activity of the operator is not required movements like select, to walk, search and reach can remove. So the lead time is reduced by 1834.18 seconds or by 30.6 minutes. The time reduction obtained from remove motion waste activity during the production process.

Key word : Lean Manufacturing, VALSAT, RCA, 5S, Motion Waste