

ABSTRACT

CV. Wira Utama is a garment industry located in Cimahi. The product examined in this study is a shirt. Based on production data from January to December 2018 there were delays in sending shirts to customers due to the failure of production targets. The problem is indicated by the presence of waste in the shirt production process. An approach that can be used to minimize waste is a lean manufacturing approach. Value stream mapping and process activity mapping are used to map the flow of the production process and identify movements that do not add value to the shirt production process. In making PAM, non-value added (NVA) activity has the largest percentage, which is 82,9%, while the percentage of value-added (VA) activity is 4,9% and necessary but non-value added activity (NNVA) is 12,2%. In the manufacture of PAM, waste motion was 1,14%. So it is necessary to do a design proposal to minimize waste motion. The next step is identifying the root causes of waste motion by using Fishbone diagram and 5 why's. Next, design the proposal by applying the 5S method. Based on the results of the design improvements that have been made by applying the 5S method, then map the value of the future state mapping stream so that the decrease in lead time is 28.420,78 second to 28.106,30 second.

Keywords: Lean Manufacturing, Value Stream Mapping, Process Activity Mapping, Waste Motion, 5S