

## **ABSTRACT**

*PT Dirgantara Indonesia (Persero) is a company engaged in the aerospace industry, especially in the design and manufacture of aircraft components. PT Dirgantara Indonesia has a warehouse raw material metal is used as a place to store the raw materials to make aircraft components. Raw material metal will be produced in precutting shop. But the warehouse raw material metal is often experienced delays in issuing material from warehouses, the delay can be seen from the time of service that exceeds predetermined time based on the KPI of the warehouse that is for two days. Services raw material is often too late, a lot going on sheet material. Delay of service Process caused by waste of motion.*

*The first step is to map the flow of material and information in the warehouse with the current state of design. Then identify the cause waste by 7 waste. Furthermore searched the root cause of the problem by using fishbone diagrams.*

*Proposed improvements to minimize process time of raw material service, using Lean concepts with appropriate application of lean tools, including warehouse slotting and visual control. Thereafter, it will be made future state design. In the design state future decrease total processing time by 15,05% of the total time the process 1326,51 seconds to 1126,51 seconds. In addition, an increase in the percentage of value added time from 15,88% to 18,69%.*

*Keywords: Waste Motion, Lean, Lean Tools, Fishbone Diagram, Process Time*