

ABSTRACT

This research discusses about the application of lean manufacturing to minimize waste in one of BUMN company. The problem that arises is tardiness in delivering the Air Brake System because one of the Distributor Valve Cover is not finished produced yet, so it can not be assembled into entiry part. In the production, discovered waste waiting time which led to the failure in production and it takes to design improvement to minimize waste waiting time.

Lean manufacturing method is used in attempt to minimize waste waiting time. This research is started with primer data collection that will be processed, and then produce Value Stream Mapping (VSM) and Process Activity Mapping (PAM) current state which is useful for mapping stream and time beforehand. The next phase is identification of waste waiting using fishbone diagram, then weighting to determine the dominant waste waiting using pareto diagram, then find the root cause using 5 Why. Solving problem for each of the root cause of waste wating time is done using manufacturing tools such as preventive maintenance, procurement tools and design of visual control.

Key Word : Lean Manufacturing, Waste, Waiting Time, Preventive Maintenance