ABSTRACT

PT Len Industri (Persero) is a manufacturing company engaged in the field of electronics by producing solar modules. Type solar modules researched in this study berfokum on the type of solar module 230 wp. In the production process module 230 wo suya in waste found defects that affect the achievement of production targets. Based on company data defect rate on statins work matrixing and terminating above the tolerance Companies, yaittu 3%. It is therefore designed an improved process terhadapat 230 wp solar module production in an effort to minimize waste defect.

In an effort to minimize waste defect, use lean manufacturing approach. The research phase begins with the collection of primary data is then processed to produce Value Stream Mapping (VSM) and Process Activity Mapping (PAM) current state useful for mapping the flow and processing time occurs. The next stage, carried identification with the dominant types of waste using the proportion of waste, whereas to identify the dominant defect penyebaba using fishbone diagrams and 5 Rev. Phase problem resolution for each root the causes of waste defct predominantly use the tools of lean manufacturing in the form of procedures, line Balacing, danvisual controlBerdasarkan use of tools of lean manufacturig, obtained the draft proposed improvements such as work instructions, procedures cleanup work environment, training systems, line balancing, visual control , appliance cleaning procedures, purchase of air conditioning and fan blowers

Keyword : *Lean Manufacturing, Waste Defect, Value Stream Mapping, Process Activity Mapping, line balacing, dan Display*