

ABSTRACT

PT Len Industries (Persero) is a manufacturing company which is engaged in the field of electronics and electrical equipment. PT Len Industries (Persero) uses the strategy of make to order to meet the needs of its customers. The solar module is one of the products produced by PT Len industries (Persero). In the project by 2015 PT Len industries (Persero) is not capable of fulfilling customer requests within the time allowed and caused delays on delivery to the customer. This delay is suspected because there is waste that occurs in the process of production of Solar Modules. Value Stream Mapping and Process Activity Mapping is made to identify the waste that occurs in the process of production of Solar Modules. Based on identification with Takt time, Value Stream Mapping and Process Activity Mapping is well known that the presence of waste in the production Process. One of the identified waste is waste waiting. The first step to determine the root of the problem is to use a fishbone diagram. There is the root of the problem of waste waiting is a production trajectory balance less well, unknown life part that is used, and there is no schedule for routine maintenance. Based on the root of the problem gained then made proposals to address the waste that occurs with the use of the concept of line balancing and total productive maintenance. Based on the results of the proposals that were made then described the future Value Stream Mapping to compare with Value Stream Mapping in the current conditions.

Keyword : Waste waiting, lean, Value Stream Mapping, Process Activity Mapping, Takt time, Diagram fishbone, Line balancing, Total Productive Maintenance.