

ABSTRACT

PT. XYZ is a company that manufactures electronic components mainly of plastic material and tools for printing called molding. Company using the system make to order in production processing. Based on the information obtained, the assembly process of frequent complaints that the desired production target does not match the facts. This is because the product rejects that occur during the process of injection Hopper parts and frames ASF. And it caused a delay at the time of assembly ASF unit.

The research began with the manufacture of value stream mapping to determine the flow of information and materials that occur during production process. Lead time that occurs during the production process ASF unit is equal to 1443.26 seconds / piece, a waste of 88.84%. After detailed mapping was carried out using a process activity mapping (PAM). Then performed using the method of waste identification checklist and a search is done using root cause fishbone diagrams and 5Why. Then the proposals made using lean manufacturing methods, they are 5S and takt time.

After making repairs, then gained the lead time of 784.31 seconds / piece waste and percentage of 79.47%. There is a 9.37% reduction of waste.

Kata Kunci : ASF Unit, Lean Manufacturing, Value Stream Mapping, Process Activity Mapping