

ABSTRACT

PT Dirgantara Indonesia is a manufacturing company engaged in the aerospace industry, especially in the design and making aircraft components. Several types of aircraft programs currently active is PUMA, CN-235, NC-212 and Airbus. To do the production, required a variety of tools that are stored in warehouse tools. One of the warehouse tools that serve the borrow and return processes are Warehouse Tools Crib DPM. The high percentage of non-value added activity in the warehouse reached 80,97 % of overall process causing delays borrow and return service tools for the production department ie sheet metal forming.

The step of research started by mapping the entire flow of information and item tools that occur in the process in a warehouse Tools Crib DPM of PT Dirgantara Indonesia using the Value Stream Mapping (VSM). Further classification of all activities are made using the Process Activity Mapping (PAM). The next step is to identify the waste based on seven criteria of waste using checklist. Based on the checklist, obtained the types of waste that occurs are the waste of waiting, motion, transportation, and overprocessing, then the root causes are searched using fishbone diagrams.

Improvements that proposed, such as Warehouse Slotting, Warehouse Management System (WMS), Visual Control, 5S, Work Standarization, Cycle Counting and Warehouse KPI. From the results of the design of the proposed future state map, it can be concluded that the level of wastage that occurs decreased to be 50.22% of the total processtime in the total of 3962.89 seconds or 66.05 minutes, while the value added in the future state conditions to be 35.94%.

Keyword : Lean Warehousing, Value Stream Mapping, Process Activity Mapping, Checklist, Fishbone Diagram.