

ABSTRACT

PT. BIG is a company engaged in the field of textiles. The company produces textile products such as gray cloth and prayer rugs. Two kinds of products produced by PT. BIG, the product that focuses in is gray fabric. The gray fabric is a whitish fabric produced from the woven yarn. There is a problem of the lack of production quantities with the production targets set by the company. Non-conformity occurs because the amount of production does not reach the production target. Not achieving the production target occurs due to the downtime on the sizing machine that causes the activity waiting for the engine repaired or called the waste waiting.

The stages in this research is done by collecting primary data and secondary data that will be processed and produce the depiction of value stream mapping and activity process mapping current state. Then will be identified waste waiting by using fishbone diagram that will be identified again by using 5whys and 5w1h to find the root cause of the occurrence of waste waiting. Having known the root cause of not achieving the production targets obtain the proposed for improvement proposals in the form of training on maintenance and preventive maintenance.

Keywords: Waste Waiting, Lean Manufacturing, Sizing Machine