

ABSTRACT

This research focuses on the production process of cadet bread. Based on company data, the realization of CV. Sri Rejeki has not been able to reach the targeted production demand in October, November, and December in 2020. In the production process, there are activities that are not added value, namely operators looking for work aids that are categorized as waste motion in several work areas. Based on the problems that occur, an improvement design is needed to minimize the waste motion that occurs using a lean manufacturing approach.

The initial stage in this research is mapping and identification of Value Stream Mapping (VSM) and Process Activity Mapping (PAM). The next stage is to identify the root causes of waste motion using lean manufacturing tools, namely Fishbone Diagram and 5 Why's.

The recommendation for improvement given related to the identified waste is the application of 5S to minimize waste motion by designing a tool box that can reduce operator movement in the work area. From the proposed improvements made, then mapping the production process to the value stream mapping future state and the result is that the lead time is reduced to 23065.49 seconds.

Keywords: Lean Manufacturing, Waste Motion, 5S System