

ABSTRACT

Industri Hilir Teh PT Perkebunan Nusantara VIII (IHT PT Perkebunan Nusantara VIII) is a company that produces Goalpara tea bags but the resulting product still has waste in the process in the wrapping machine which results in the company's productivity not being maximized because the time needed to produce tea becomes more time, thereby increasing production costs. This study aims to identify and design continuous improvement for Goalpara 25 teabag products packaged at IHT PT Perkebunan Nusantara VIII using fishbone diagrams and value stream mapping which are tools in lean manufacturing that identify waste and the causes of problems through current state maps and future state maps. Improvement efforts were made by providing several simple alternative solutions to overcome problems in the goalpara 25 teabag packaging process in the form of adding operators, buying optional parts for wrapping machines and designing additional parts on the conveyor. With the proposed improvements, it can overcome defects that occur in the wrapping machine and long processing time, but can have an impact in the form of a larger packaging process cost to increase the operator's salary costs in the wrapping machine or the cost to buy optional machine parts.

Keywords: continuous improvement, goalpara 25 teabag, lean manufacturing, value stream mapping, fishbone diagram