

ABSTRACT

PT BIG is a company engaged in the field of textiles that produces grey fabrics. In the production process of grey fabrics, an activity that does not have value added in the form of Waste Motion is found i.e. the movements of the operator that does not give value added to products such as the activity of looking for tools and walking away to pick up the material. This leads to a longer production time. So with lean manufacturing approach, identification of the main cause factor of the movements the operator should not have done in the production process of grey fabrics is carried out by using Fishbone diagrams and 5Why tools as well as providing a proposal for improvements to eliminate/reduce Waste Motion. The proposed improvement done is using the 5S method as an effort to eliminate/reduce Waste Motion in the work area. The research result showed that the lead time can be reduced with the proposed improvement of 5S is 382.81 seconds. Reduced time occurs on the activity of finding the pattern card, looking for pattern card inspection tool, walking away to pick up the cardboard, and looking for tool for grey fabrics inspection.

Keywords: Waste Motion, Lean Manufacturing, 5S