

ABSTRACT

PT Pindad (Persero) is a BUMN company (State Owned Enterprises) which is produce such as the train braking system (Air Brake System). One of the Air Brake System components is Isolating Cock, consist of Baut Ventilasi, Penutup, Rumah Isolating Cock and Flens components. The company have a constraint in order finishing time such as the delay in the completion of the order. Factors that cause delay in producing Isolating Cock components is the duration of the setup process. Data showed that 35% of the total processing time Isolating Cock components is spent to setup.

This problem will be solved by Lean Manufacture method using Single Minutes Exchange Of Die (SMED). Research stage begins by analyzing the stages of the setup process in the production of Isolating Cock components. The setup process that occurs are fixture setup, setup of the workpiece and tools setup. Based on observations, the amount of the initial state setup time is 146.65 minutes. Therefore, it needs improvements in order to minimize setup time.

The improvement begin by convert internal activities setup into external setup, simplification of replacement equipment, tools adjustment, and apply a parallel operation by using two operators. So the total setup time can be reduced is equal to 84.2 minutes or 57.42%.

Keywords : Lean manufacture, SMED, Setup time, Isolating Cock component