

ABSTRACT

PT Pindad (Persero) is a BUMN company which concern on weaponry and commercial item such as air brake system of train. One part of the air brake sytem is Isolating Cock. Isolating Cock components consists of several parts, there are Baut Ventilasi, Penutup, Rumah Isolating Cock and Flens. On production system, there still some waste activity such waste motion, waste inventory and waste transportation. It will create some problem to finish the order and get delayed. To reduce it, lean manufacture must be used.

It started from collected and analyst time activity of production process, then find the root of waste problem with tools like Checklist, fishbone and 5Why. Based on analysis with that tools, waste can be reduced by improve the work area. Hence, researcher propose improvement program use lean manufacture tools which is 5S (seiri, seiton, seiso, seiketsu, shitsuke) to eliminate waste motion, waste inventory and waste transportation and reduce activity that haven't value added.

Keywords : Lean Manufacturing, Waste, 5S