ABSTRACT

PT Dirgantara Indonesia (Indonesian Aerospace Inc.) is the first aircraft industry in Indonesia. PT Dirgantara Indonesia has one of the division that focuses on the delivery of Airbus aircraft in cooperation with Airbus Company that is Program Spirit, under the Division of Program Management & Planning. Types of products examined in this study focuses on the product Door FS Root A320. In the production process Door FS Root A320, was found waste waiting that affect the achievement of production targets. Based on the data that has been processed, obtained 23% of waste waiting . So, that must to design an improvement over the production process Door FS Root A320 in an effort to minimize waste waiting.

In an effort to minimize waste waiting, the method used Manfacturing Lean approach. The first phase begins with the collection of data both primary and secondary data then processed so that produce a picture of the flow production process and be equipped with time production process that can be described by Value Steam Mapping (VSM) and Process Activity Mapping (PAM) current state. The next stage, identify the type of waste waiting with fishbone diagram later identified back with 5why to find the root cause of waste waiting. Phase solving problems solved by using lean manufacturing tools. And then obtained the result for design improvement such as training about maintenance for maintenance operator , and preventive maintenance scheduling

Key Word: Lean Manufacturing, Waste Waiting, Value Stream mapping, Process Activity Mapping, Overall Equipment Effectiveness.