

ABSTRACT

PT. Progressio Indonesia (Pronesia) is a company that works in convection field which produces various kinds of products such as t-shirts, jackets, shirts, pants, etc. The research that is conducted take focus on shirt product. In shirt production process, it is discovered that there is waste motion that affects lead time. Based on this occurring waste motion problem, this research is conducted to give a solution to minimize waste motion in shirt production process, lean manufacturing approach will be used in this research.

The initial stage of research conducted a primary data collection which is then processed to the depiction of Value Stream Mapping (VSM) and Process Activity Mapping (PAM) current state, in order to know the Value Added Activity is about 2152.84 seconds, Necessary Non Value Added Activity is about 36143.3 seconds, and Non Value Added Activity is about 89.73 seconds. The next stage is the depiction of fishbone diagram and 5Why's for finding the root cause of the problem. Next redesign proposed improvements to overcome waste motion by implementing 5S, as well as designing the layout of the storage Work In Process in accordance with the reach of the operator.

Keywords : Lean Manufacturing, Waste Motion, Value Stream Mapping, Fishbone Diagram, 5Why's, Takt time, Ergonomi, 5S