ABSTRACT

PT. Kharisma Printex *is a production company that provides printing services convection pattern in gray fabric with a regional scope throughout Indonesia. In the production process of printing motifs on gray fabric found waste defects that affect the achievement of production targets. Based on the company's data, the average percentage of defect rate in the period of June 2014 - July 2015 is above the tolerance limit with 2.66% (standard tolerance limit is 2%), therefore it is need to be re-designed in an effort to minimize waste defect.*

Efforts are being made to minimize waste defect by using lean manufacturing approach. The initial stage of this research was conducted by collecting primary data to be processed to produce Value Stream mapping (VSM) and Process Activity Mapping (PAM), which serves for mapping the flow of time and process. The next stage is identifying the types of waste by using a dominant defect Pareto diagram. Then the next stage is to identify the root cause of the defect dominant waste by using Fishbone diagrams and 5 Rev. Stage of completion for each root cause of the dominant defect types of waste using lean manufacturing tools in the form of pokayoke and andon.

The draft proposal of improvements made in the form of conducting preventive maintenance, creare pokayoke and andon system in an effort to minimize dominant waste defect in the printing process motif of gray fabric in PT. Kharisma Printex.

Keywords: Lean Manufacturing, Waste Defect, Pokayoke, Andon