

ABSTRACT

PT. EFG is one of the biggest aerospace company in South-East Asia. They produce various types of aircraft. In a process to build an aircraft, it need hundred until thousand parts. These parts are produced by using tooling. Tool is one of important thing to be prepared before producing a parts of aircraft component. Tools consist of standard tools and special tools.

The special tools are stored at warehouse, called Tools Crib DPM in borrow-return system. The problem arise when tools crib delayed for giving the tools to the sheet metal forming. To get to know the causes of delay, all of the activities at tools crib will be identified using Value Stream Mapping (Current State). Then from identification, order picking activities have the largest delay seen from the non value added.

One of the ways to reduce delay in picking are by improving storage allocation by using throughput based dedicated or dedicated storage. Using this method, the product placement are dedicated for the product by considering the differencies of the level of activities and inventory level of the product. The level of activities can be analyze using FSN Analysis.

After improvement, the result shows that the processing time are reduced, from 1074,73 seconds to 842,60 seconds, while the value added time is increase from 61% to 76%