

ABSTRACT

PT. Agronesia (Rubber Engineering Industry Division) is a company engaged in manufacturing, which produces several types of products made from either synthetic or natural rubber, one of the resulting product is rubber step aspira belakang. In the production process of rubber step aspira belakang there are some activities that do not add value for neither the product its self nor the company, one of which is the 'extra' movements that is not required or can be called waste motion. In an effort to minimize such waste motion is carried lean manufacturing approach.

The first step is to collect the primary data that will be process in the current state mapping through value stream activity and process activity mapping to map the process flow that occurs and it is known that the time of non-value added activities amounted to 394.21 seconds. The next stage is to find the cause of the waste by using fishbone diagram and find out the root cause of the waste by using 5 Whys. Based on analysis using these tools, the improvement proposal design is designed by using 5S System to minimize the waste motion and increase the percentage of value added time.

Keywords: Lean Manufacturing, Waste Motion, 5S System