

## **ABSTRACT**

Lean Manufacturing is a method used to increased productivity and costs reduction by minimizing waste in the production process. This study describe the use of lean manufacturing with Single Minutes Exchange Of Dies tools on the PSR's production floor in PT XYZ, which is engaged in automotive manufacture form making of car tires. Research stage begins by analyzing waste using mapping tool and identification causes of waste in workstation curing. The next stage is analyzing every step of machine setup that occurs are workpiece setup, mold setup, curing setup, and finishing setup. Based on observations, the amount of the initial state setup time is 194,05 minutes. The improvement begin by convert internal activities setup into external setup, reduction of operator displacement activity, elimination of adjusment, and apply a parallel operation by using two operators. So the total setup time can be reduced is equal to 127,41 minutes.

Keywords : Lean manufacture, SMED, Setup time, Workstation curing.