

ABSTRACT

PT. LG Electronics Indonesia, a company that produce electronic goods is supposed to meke continuous improvements to have more efficient business activities. Lean Manufacturing is a kind of continuous improvement. Although the company has implemented Lean program, there still are problems occurred in LCD TV Production Floor. The problem faced is not achieving the UPH (Units Per Hour) target which is 450 units per hour and not achieving the target cycle time of 8 seconds at several work stations.

The problem is analyzed through Line of Balance data that shows maximum and minimum cycle time chart that is achieved by each work station on LCD TV Production Floor. The maximum cycle time that exceeds the target time of eight seconds is identified using the criteria of 8 waste as defined by Toyota, which are Overproduction, Excess Motion, Transportation Waste, Non-Value Added Activities, Waiting Waste, Defect Waste, Excess Inventory, and Underutilized People. Cause-effect diagram was also used to find root causes and impacts of the problems.

Results of data analysis through Line of Balance indicates that there are five types of waste contained in the LCD TV Production Floor. This five types of waste are Excess Motion, Non-Value Added Activities, Waiting Waste, Defect Waste, and Underutilized People. After identifying the inefficiencies that occurred, made some suggestions that can be implemented in the company's LCD TV Production Floor. The result of this implementation can reduce cycle time which is exceed the target time of eight seconds, so the LCD TV Production Floor can achieve the UPH target and increase productivity.

Keywords: Lean Manufacturing, Criteria 8 Waste, UPH