

ABSTRACT

Sandal Commet home industry is factory that producing sandals. however in fulfilling the demand from market, its production couldn't match it, reach about nearly 81, 52% of total demand. Lean Manufacturing approach is being used in order to find cause of waste occurred in the production level of sandal commet home industry.

The research began with current state drawing to map all materials and informations flow. Then detailed mapping was being conducted with process activity mapping, yielding activity presentage value added about 61%, necessary value added 35%, and non value added about 4%. The next step was to find cause of waste based on seven waste criteria with checklist tool, so we could get the biggest waste, which is waste unnecessary motion. Finally, we could know cause of waste using fishbone diagram, and 5 why.

Based on 5 why, we could eliminating waste with a good housekeeping. So, engineering design Proposal was being conducted using Lean Manufacturing tool, those are 5S (seiri, seiton, seiso, seietsu, shitsuke) in order to eliminate waste unnecessary motion.

Keywords : Home industry, Lean Manufacturing, Value Stream Mapping, Process Activity Mapping 5S, Waste Unnecessary Motion.