

ABSTRACT

PT Alena Bandung Textile is a textile company which the production is made to order based. One of the fabrics produced by this company is double georgette fabric. Nowadays, the weaving department only produces 82,3% of the production target. Because of that, delivery to the customer was delayed. Besides that, the department produced defects at a high amount whereas around 3.13%.

Lean manufacturing was a method to minimize waste by creating a framework that focuses on value, reduce waste, and fulfill customer needs. To give an explanation of the weaving department production process and waste along the value stream, used Value Stream Mapping (current state) and detailed mapping Process Activity Mapping (PAM). The next step is identify seven types of waste by using a checklist and identify causes of waste using a fishbone diagram.

In this research, the waste in the weaving department are overproduction, waiting, unnecessary inventory, unnecessary motion and defect. Proposed improvements to reduce the waste are continuous flow by minimizing the buildup of work in process between processes. So that a lead time resulting in a reduction of leadtime is 492000 seconds, or about 75%. Besides that, do standard work to keep operator and machine performance so can improve the performance of the production of double georgette fabric in the weaving department.

Key words: *Lean Manufacturing, 7 Waste, Value Stream Mapping, Process Activity Mapping, Standard Work*