

ABSTRACT

PT Jusindo Sumber Prakarsa is a garment company which the production system is make to order. One of the products of this company is Polo Tee. In the process of production, production targets per day reached 624 pieces, but the sewing department can achieve an average production of 447 pieces per day. Lead Time production for the polo tee is 32043,33 seconds or 8,90 hours. Total waste is 93.9% of the lead time. Wastage includes a delay 90,3%, transportation 3,4%, and inspection 0,2%.

Therefore, lean manufacturing methods used to minimize waste. The steps is to make an overview of using value stream mapping (current state), detailed mapping using process activity mapping (PAM) to reveal the details about waste that occurs on a production polo tee, and identify 7 types of waste by using a checklist and identify the causes of waste using a fishbone diagram.

The final stage is to make recommendations for improvements by using Future State Design to get solutions about waste problem. Recommendations for the problem are the applications of continuous flow, Full Work method, one-piece flow system, and reduce the number of lots. Obtained a shorter lead time 6091.35 seconds or 1.69 hours and can reach production targets.

Key word: lean manufacturing, value stream mapping, process activity mapping, full work, polo tee, PT Jusindo Sumber Prakarsa