ABSTRACT

PT. Agronesia Division Inkaba is the company that production products that use rubber as raw materials. This company uses the make to order system to complied customer order. One of the products which has high levels of ordering is Rb. Joint Strip. The company set a target of every part of the production Rb.Joint Strip to complied ordering of customer. But the target can't be achieved that is 100% complete target. Target that can't achieved is 6,18% in making of compound, 6,17% in vulcanization compound, and 18,75% in extrude compound. This is happen because some of waste in the production process Rb.Joint Strip. Than the company make weight test and the result of high level of waste is waiting time.

Research phase begins with the making of current state mapping, this phase did to identify waste waiting. In the first phase make value stream mapping to know the flow of material and information on the production process Rb.Joint Strip and lead time 156315.71 sec/batch. After that the process activity mapping did to get detail mapping and persentage of aktivities, that is operation 35%, delay 33%, transportation 8%, storage 21%, inspection 3%. Then the calculation of overall equipment effectiveness did to get efectiveness value each machine of Rb. Joint Strip Production. And then the calculation of 6 big losses did to get primary problem. The problems is breakdown losses. The Cause of waste from Rb.Joint Strip production machines is unavailable spare part, failure of mulk silinder, the longest of administration time, restrictiveness of maintenance employee skill, different priority of set up machine, and process of cutting compound multiple times. And then solving problems do with lean lean manufacturing tools such as Total Productive Maintenance it is like preventive maintenance, andon system, design of visual control, and application of autonomous maintenance.

Keywords: Rb. Joint Strip, *Lean Manufacturing*, *Value Stream Mapping*, *Process Activity Mapping*, *Overall Equipment Effectiveness, 6 big losses*