

ABSTRACT

PT DIRGANTARA INDONESIA or PT DIRGANTARA INDONESIA is a state-owned enterprises in aircraft manufacturing. In its production process, there are still some dissipation activities in the production area, one of them is waste motion of operator. To get rid of those waste motion, a lean manufacture approach must be used.

The research phase starts with collecting primary data and then process it to describe Value Stream Mapping Current State and Detail Mapping using Process Activity Mapping, so that we will know the activity percentage of value added time is 20,11%. The next phase is to find the cause of waste motion using some tools such as checklist and Root Cause Analysis with fishbone diagram. Based on the analysis using those tools, we knew the waste motion can be eliminated with gooud housekeepong. Therefore, a design phase for improvement proposal must be done using lean manufacture tools which are the 5S (seiri, seiton, seiso, seiketsu, shitsuke) in order to eliminate waste motion so that no value added activities could be eliminated and the percentage of value added time will be increased..

Keywords: PTDI, Lean Manufacturing, Value Stream Mapping, Process Activity Mapping, Waste Motion, 5S