

Abstract

PT Buana Intan Gemilang is one of the companies engaged in the textile manufacturing industry. Currently PT Buana Intan Gemilang has problems in the production of gray fabric, which has not been able to meet the target realization of consumer demand in a timely manner. Waste transportation found in the production process that occurs on the production floor, which affects the achievement of production realization targets.

Based on company data, the realization target of grey fabric production in January to October of 2016 only reached 74%. Therefore it is designed a suggestion of improvement that is useful to minimize waste transportation on the production floor with lean manufacturing approach.

The research phase begins with collecting primary data, and secondary data. Then the data processed to produce Value Stream Mapping (VSM), and Process Activity Mapping (PAM) which provides information on the flow of production process information and materials on the production process gray fabric. The next step is to identify the root cause of waste transportation using fishbone diagram, and 5 why. The problem solving stage for each root cause of waste transportation can apply material handling principle system. By applying the material handling principle system, it can be proposed in the form of allocation of material handling equipment for each area, procurement of material handling equipment maintenance for a certain period, and application of material handling principles on production floor to reduce delivery time from production floor into inspection with the result that inspection is not hampered.

Keywords : Lean Manufacturing, Waste Transportation, Value Stream Mapping, Process Activity Mapping, Sistem Prinsip-Prinsip Material Handling