

ABSTRACT

CV.ABC Offset is one of the printing company with make to order production system. The product chosen in this research object is hanger sample. In the four months of the period the number of hanger samples did not reach the demand in January 2016 of 73%, February 2016 by 80%, June 2016 by 92%, and in August 2016 by 71%. Based on the results of field observation, there is waste inventory in the production process that affect the achievement of production realization targets. Therefore, it is necessary to design a suggestion of improvement that is useful to minimize waste inventory by lean manufacturing approach. The research begins with primary and secondary data collection processed to produce Value Stream Mapping (VSM) and Process Activity Mapping (PAM) current state. Waste that has been identified then sorted by percentage and see whether the estimated waste obtained based on field observation results similar to the results of data processing questionnaire. Next is the determination of waste inventory raised in this study. The selected inventory waste identified the root cause by using fishbone diagram and 5 whys. The next step is to design a proposal to minimize waste inventory in hanger sample production process with kanban and job rotation. The last stage is the creation of Value Stream Mapping (VSM) future state.

Key words : lean manufacturing, value stream mapping, process activity mapping, waste inventory, kanban, job rotation.