

ABSTRACT

CV. Kembar Mekar is a business entity in a form of limited-partnership or known as CV and engages in the field of catter feed raw material cultivation, such as coffee grounds. Waste is found during the production process of grinded coffee grounds in CV. Kembar Mekar. It is indicated by data that shows distinction between the amount of production inputs and output, in which the production output amount is lesser than the inputs used.. By means of a process activity mapping or be known as PAM, motion waste places the most dominant waste along with the non-value-added total total time of 263.45 minutes or 83.65 % of production lead time. Therefore, an improvement is needed in order to minimize and even eliminate this kind of waste towards increasing production efficiency. The effort of designing an improvement proposal is executed by implementing kaizen events using lean manufacturing method. As for it, this improvement proposal design aims to minimize waste motion acitivities, such as activities occurred in raw material warehaouse and grinding workstation, in which they are related to work methods (including operator, material, and machine). By executing proposal design identification using 5W1H, belt conveyor as a material handling implementation is selected as the kaizen implementation effort with those specifications that are able to minimize motion waste, such as consistent amount of ready-to-grind coffee grounds, automatic transportation process, and also plastic and metal separator on the conveyor. This belt conveyor implementation is adequate to eliminate those non-value-added activities that possess the biggest presentation in the grinded coffee grounds production process, in which it eventually reduces lead time and also increases production efficiency for 19% towards 58%.

Key words : Lean manufacturing, kaizen, waste motion, grinded coffee grounds, work method improvement