

ABSTRACT

Lean manufacturing is a method of continuous efforts in identifying and eliminating the waste that occurs in a manufacturing company. PT. Perkebunan Nusantara VIII Ciater is a company that produces the plantation commodities and one of them is a commodity of tea. This study focused on the production of orthodox tea because the first quality of tea which produced is still less than the third quality of tea, so the company has not maximized the production of superior quality tea and has not reached the desire of the customer. Excess processing waste was found in sorting process which is an important process in producing good quality teas. Based on these problems required a design improvements to minimize excess processing waste with lean manufacturing approach. An initial stage in this research is treating primary and secondary data obtained to create a picture of the current state of value stream mapping and process activity mapping. The next stage of identifying the cause of the problem using fishbone diagram and 5 whys. Stage design of the proposed improvement using kaizen and standardized work. The last stage is mapping the future state of value stream mapping and process activity mapping as a picture given the draft proposal.

Keywords: Lean manufacturing, waste excess processing, kaizen