

ABSTRACT

PT. Perkebunan Nusantara is one of the state-owned companies engaged in the plantation sector with various businesses and commodities. One of the plantations cultivated by PT. Perkebunan Nusantara is a tea plantation. This research is conducted on orthodox production, because orthodox production process continuously, then needed good process flow so that can produce tea effectively and maximal. In this process found transportation waste in a sorting area that affects workers and performance. Therefore, a useful improvement is needed to minimize waste transportation in the sortation area by lean manufacturing approach. Research phase begins with primary and secondary data collection so as to produce current state mapping that is value stream mapping and process activity mapping useful to give information about flow of existing process, next step that is identifying waste transportation with fishbone diagram and 5 whys. Furthermore, the results of such analysis can be made to minimize waste transportation in the company.

Key words : Lean Manufacturing, Waste Transportation, Value Stream Mapping, Process Activity Mapping, Material Handling System.