

ABSTRACT

One of the products that are always produced by CV. The gradient is a continuous Spring guide XXX because these products have a fixed order of Astra Honda Motor (AHM). Based on the data history demand and product realization Spring guide XXX period January - November 2016, obtained the production incompetence. Therefore, observations, interviews and questionnaires were distributed to production heads, production managers and operators. Based on the results of observation, interview and questionnaire one of the dominant waste i.e. waste motion, Hence this research focus to manage the waste motion on the production process of the Spring Guide XXX using Lean Manufacturing. In the principles of Lean Manufacturing identification of value stream mapping and process activity mapping to pinpoint waste motion in the production process. Waste production time may slow motion spring guide XXX. Based on the results of the VSM and PAM obtained time caused by waste motion i.e. 708.93 seconds. In addition to a long production time, waste motion found in the production process, namely the existence of activities which can cause accidents of work because moving objects with a weight of 50-200 kg. Therefore, the cause of the problem were done waste motion using fishbone diagrams and 5Whys. Based on the results of the root of the problem waste motion, it will be proposed a draft that can manage the waste motion. The design of the proposal i.e. application of the 5S and designing MHE to move the molding. With the proposed draft, then waste motion can be diminimasi. It can be seen from the time of waste motion that is 300 seconds.

Key words : Lean manufacturing, waste motion, 5S