

ABSTRACT

PT Pindad (Persero) is a manufacturing company engaged in the manufacture of military products and some commercial products. One of the existing military products is Komodo MBDA. Within the production process, Komodo MBDA experienced delays in delivery to customers. Based on the company data that in the production process Komodo MBDA experienced delays in shipments to consumers caused by the procurement of components that are late and suspected to have defects. In the target and actual data obtained the largest gap on the front door component of 8 units, one of which is due to a production process that is not going well. In study aims focused on the production process of the front door Komodo MBDA to minimize waste motion.

Based on these problems, a draft proposal to the production process of the front door Komodo MBDA to minimize waste motion with lean manufacturing approach using 5S method. The research was conducted by collecting data which then processed for depiction of Value Stream Mapping (VSM) and Process Activity Mapping (PAM) current state so that known time from non value added activity equal to 16955 seconds. Next is the depiction of fishbone diagram and 5 Whys to find the root cause of the problem. Based on the depiction using these tools, the design proposal to overcome the waste motion with the 5S method, as well as designing storage tools using anthropometry.

The result of the proposed design using the 5S method is to select goods according to the frequency of use, the design of storage tools, the addition of hygiene tools as well as the design of hygiene equipment storage, picket schedule, work rules, visual management and 5S audit form. In the proposed draft that reduced lead time on the production process of Komodo MBDA front door based on the reduction of the simulated distance.

Key word : Waste Motion, Lean Manufacturing, 5S, Value Stream Mapping, Process Activity Mapping..