

ABSTRACT

CV.CJM is a private company engaged in textile in Indonesia which produces yarn into garment. CV. CJM produces a wide range of t-shirts, jackets and shirts from cutting raw materials to finished good with specified specifications by consumers in terms of materials, clothing designs, production completion times, and number of order requests. CV. CJM uses make to order production system that is, making production based on order made by customer. In addition to receiving various orders directly from customers. In addition to one of the products generated by CV. CJM is a shirt.

In 2017 it was noted that the company experienced a delay in delivering products to customers in the period July to November that exceeds the limit set for 7 days. One of the causes of delay in delivery is the defect product that exceeds the company's tolerance limit of 2.5% and defect stitches off the mark is the highest percentage defect type. Stitches off the mark causes rework activity that affects production lead time so that it becomes one of the factors of delay in delivery. Based on the description, this research will focus on minimizing waste defect due to defect product using lean manufacturing method.

The initial stage of this research was conducted by collecting primary data to be produce Value Stream Mapping (VSM) and Process Activity Mapping (PAM), which serves for mapping the flow of time and process. Identification and analysis of the root causes of waste defect problems will be identified and analyzed with Fishbone Diagram and 5 Why. The results of the research of waste defect problem can be used to determine the proposed improvements that will be made in the form of pokayoke, training, recording time sheet of breakdown machine, and machine maintenance card to minimize the waste defect in CV. CJM.

Keywords: lean manufacturing, waste defect, rework, pokayoke