

ABSTRACT

PT. Sansan Saudaratex Jaya is a company that engaged in the field of textile and garment industry that produces a wide range of products such as jackets, shirts, pants and etc. The research will be focused on the production of shirt. In fact, defects in production greatly affects the quality of the product. Based on the problem, the result of this research will give an improvement proposal that are able to reduce the defects rate in shirt production for this company by using Lean Manufacturing method.

The Initial stage of research conducted in this study is collecting primary data and secondary data that will be obtained from the company and from the observations made during the research took place. After searching the data, then processed to the depiction of Value Stream Mapping (VSM) and Process Activity Mapping (PAM) current state in order to know about the time of each activities performed by the operators. The time of the activity carried out includes Value Added Time is 11024.39187 seconds, Necessary-Non Value Added Time is 77.26379709 seconds, and Non-Value Added Time is 552.6989039 seconds. After the depiction stage of VSM and PAM, next will be the depiction using Fishbone and 5Whys which aims to see the root cause of the problem. Then, the research will do an improvement to reduce the defects by making a sewing tool prototype and creating work instructions that have been adapted to the conditions that exist in the company.

Keyword : Lean Manufacturing, Defect, Value Stream Mapping, Process Activity Mapping, Fishbone Diagram, 5Whys.