ABSTRACT

PT Pindad (Persero) is a manufacturing company producing military and non-military products. Excava200 is nonmilitary product produced by PT Pindad (Persero). In 2017, production of Excava200 achieved 37% from production target. To find out the cause of the difference between actual production and target production, it is needed creating Value Stream Mapping (VSM) and Process Activity Mapping (PAM) obtained lead time 4797.4 minutes. It is more than the company's target which is 3870 minutes. The next step is to identify waste, obtained the biggest waste is waiting waste which is 86%. The causes of waiting waste are inspection process and waiting material from warehouse. In this research, focused on waiting material activity, which is caused by taking material that taking too much time. An effort will be made to minimize waiting waste on taking material activity from the warehouse with Lean Manufacture. The solution to minimize cause of the problem is by designing improvement using lean manufacturing tools which are material classifying, layout planning and display making. Based on the distance simulation of operator, time is reduced by 20.36 minutes from the current state.

Keywords: Waste Waiting, Lean Manufacturing, Material Classifying, Layout Planning