ABSTRACT

CV. XYZ is a manufacturing company in the garment industry. This study focuses on the production of instant veils. Based on company data, CV. XYZ is unable to achieve production targets resulting in delays in delivery of instant veil products in the ordering period in 2017. From these problems known the waste in the production process. With lean manufacturing approach, mapping and identification of value stream mapping and process activity mapping are performed. In the mapping of value stream mapping we get the value of lead time of instant scarf manufacture equal to 4727,55 second. And on the identification process mapping activity found the waste motion of 24% on the production of instant veils. So there needs to be an improvement to minimize waste motion that occurs in the production of instant veils. Next identify the root causes of waste motion using lean manufacturing tools, namely fishbone diagram and 5 whys. In the next stage to solve the cause of waste motion is to apply the 5S method. In the proposed improvement plan to minimize waste motion is to apply seiri, seiton, seiso, seiketsu, and shitsuke almost in all workstations. From the proposed design improvements made, then mapping the production process in the value stream mapping future state and obtained lead time results are reduced to 4561.60 seconds.

Key words : lean manufacturing, value stream mapping, process activity mapping, waste motion, 5S.