

ABSTRACT

PT Pindad (Persero) is a company which engaged in manufacturing of military and commercial products. One of their non military product is a “Pindad Excava 200”. Based on the analysis through the comparison between amount of the production target and amount of actual production. It is known that the target can’t be achieved, The highest incapacity occurred in September 2017 the percentage is 87%. Based on the problems, the further research is needed to be done by using Lean Manufacturing approach which is a Value Stream Mapping (VSM) current state to know the production flow from the raw components turn into a finish good. Based on the results of VSM mapping obtained the result that lead time is 4567,39 minutes and there’s a time activity that has no added value is 733.54 minutes. So it is necessary to identify further by describing more detail of activities in the production process by using Process Activity Mapping (PAM) current state. Based on the mapping result, the amount time of value added activities is 388.35 minutes, the non value added activities is 23.09 minutes, the necessary non-value added is 710,45 minutes. And from the activity which is not added a value has a percentage of waste waiting is 58%. The identification of waste waiting is done by using fishbone and 5 why, so it is necessary to design a proposal in the form of Standard Operating Procedures. After performing the proposed design then map the Value Stream Mapping (VSM) status in the future obtain a result the lead time reduced to 4507,04 minutes.

Keywords: Excava 200, Waste Waiting, Lean Manufacturing, Standard Operating Procedure.