

ABSTRACT

Waste is defined as any operation or activity that has no added value, in this study there is a waste defect that occurs in CV XYZ. Waste defect is a waste that occurs due to the inconsistency of a product. In the last six months it is known that CV XYZ has the highest demand on the child flower veil model. Based on the target data and production realization occurring in January 2019 – March 2019 It is known that the target of the child's flower veil production cannot be fulfilled. One of the causes of unfulfilled production targets because of found defective products that exceed the limit of the company's tolerance by 1%. Defective products with the highest percentage are at the wrong head circumference size. The defective product requires additional time to process the rework. Based on the explanation, this research focuses on minimizing defective products and increasing value added by using the Lean Manufacturing method.

The initial stage in the study was done by identifying the Fishbone diagram to know the root cause of the type of defect. Data retrieval in the form of existing data on the production process of child flower veil that will be described with Value Stream Mapping (VSM) as well as Process Activity Mapping (PAM) that serves to map the process flow and know the value of non value added Happen. Proposed repairs made in the form of a pokayoke of AIDS. The results of this research can be used as an alternative improvement proposal to minimize the waste defect that occurred in CV XYZ.

Keywords: waste defect, lean manufacturing, value stream mapping, process activity mapping, Pokayoke