

ABSTRACT

PT. Asmar Nakama Partogi is an industry engaged in coating services or provide protection against rust, longer lasting, harder surfaces, and shiny such as zinc or nickel coating on iron used for building and construction materials. One of the several objectives to be able to streamline the production line in the production process to be more maximal, required downsizing / identification of waste production line that can be called lean. Lean is a tool that can be used to reduce waste or waste in the production process. Waste itself is something that does not provide added value for products produced by the company and desired by consumers. After observations and interviews, some of the products carried out by the company still do not meet the demand from consumers. This is one indication that there have been irregularities or wastes in the production process that took place in the company. The results of waste identification conducted will be searched for the root cause of the problem is also conducted analysis using fishbone diagrams and 5 whys. After that obtained more detailed causal factors, then the next step to make a proposal to be able to minimize defect rate with tools andon and 5W1H. The proposed design of improvements made as an effort to minimize the dominant waste defect that occurs in the production of coatings in PT. Asmar Nakama Partogi namely: Material Factor performs chemical compounds before the surfactant compounds used are exhausted, and does not interfere with other work processes; Factor Man performs procurement of timer tools to indicate the processing time being worked on.

Keyword : *Lean Manufacturing, Waste Defect, Andon, Value stream mapping, Process activity mapping.*