

ABSTRACT

PT Indonesian Aerospace is a company that manufactures aircraft in Indonesia and also become the world's subcontractor for aircraft such as the Airbus 320, 321 and 380. In the production process, waste activity occurs in the area of production so as to meet the demand mismatch often occurs with the resulting product demand, this is due to the long lead times in the production process ie during 2995.631 minutes or 49.92 hours.

In addressing these problems is done using Value Stream Mapping to describe the flow of value happens to do business improvements in minimizing waste with Lean Manufacturing techniques. Research phase begins with the stage Currents State Drawing conducted to identify waste, then do the Detailed Activity Mapping Process Mapping using the percentage of activities that produce value added by 14,33%, Necessary non-value added by 84,67% and non-value added at 1%. The next stage is to look for the causes of waste by using a checklist and fishbone diagrams. The method is performed in doing this repair is to 5S (seiri, seiton, sesiso, Seiketsu, Shitsuke) to eliminate all existing waste.

With the proposed implementation of 5S solution is obtained shorter Lead time ie during 2972.296 minutes with a decrease in the level of non-value added waste to 0,15%, Necessary value added by 84,84% and the value added by 15,01%.

Keywords : Lean Manufacturing, Value Stream Mapping, Process Activity Mapping, 5S