

ABSTRACT

PT. Kharisma Printex is a company engaged in painting services on grey fabric. The problem in the company is there are unachieved production target for several months. The cause of low productivity is waste that happen during production prcess. Waste that is found in production process are transportation, defect, inventory, waiting, motion, and overprocessing. This research focused on inventory waste that are seen from work in process inventory between workstation. Lean manufacturing methods are used to minimized inventory waste. Research began with the mapping of grey fabric printing process that occurs with the use of value stream mapping (VSM) and process activity mapping (PAM). Value stream mapping (VSM) and process activity mapping (PAM) is also useful to identifying waste on PT Kharisma Printex. After mapping the current state then finding the root cause of the problem using fishbone diagram and 5 whys. The dominant causes of waste inventory is minimized by implementing preventive maintenance, kanban system, and documenting machine breakdown

Key words: lean manufacturing, waste inventory, kanban, preventive maintenance.