

## **ABSTRACT**

*PT Karya Kita is a company that works in printing field. The company uses maketo order system to fulfill costumer needs. The research was held into the highest demand that is GMP Project. In GMP project unfulfillment still consisted in production activity. In production process waste waiting time which is distrubing the production activity was found. Based on the problems that exist, it needs to be designed an improvement for the production process to minimize the waste waiting time.*

*The steps to minimize waste waiting time used lean manufacturing method. Firstly, it began with a value stream mapping and process activity mapping current state. Based on VSM current state, it is known cycle time is 9329.8 second. Secondly, it identified dominant causes of waste in the GMP project. There were two waste dominant causes that are: setup of plate replacement and recleaning on plate when production. After getting the dominant causes, the roots of causes were outlined by using Lean Manufacturing tools, such as fishbone-diagram and 5-why. The solution of the problem used the lean manufacturing like SMED.*

*As proposed improvements, then the description of VSM future state was done, obtained cycle time that had been reduced to 8257.69 seconds. The suggestions given to the company were addition of changeover operator, replacement parts on certain time intervals, and the making of visual-control such as poster and giving maintenance checksheet.*

*Keywords: Lean Manufacturing, Value Stream Mapping, Fishbone Diagram, 5 Why, SMED, Process Activity Mapping, Waste Waiting Time*