ABSTRACT

CV Wira Utama is one of the private manufacturing companies engaged in garment. CV Wira is a garment factory that accepts various apparel orders and has gained the trust of various vendors or clients, one of which is a shirt from Hugo's company. Based on data obtained from the company, delays in shipping occur almost every month during 2018. This is a problem that needs to be carried out further research on the production process of shirts at CV Wira Utama using a lean manufacturing approach. The research began by mapping the current state value stream mapping and continued with mapping the current state activity mapping process. Based on the mapping, information was obtained that some waste occurred with value added activities of 1875.56 seconds, non value added (NVA) of 8251,8 seconds, and non but necessary value added (NNVA) activities of 31623.39 seconds, which in this study will focus on waste waiting. Next is to identify the root causes of waste waiting using cause and effect diagrams. The dominant factors that cause waste waiting can be minimized by designing proposed improvements using preventive maintenance and *single minute exchange of dies*. Then analyze the strengths and weaknesses of each proposed improvement, and do a future state VSM mapping to obtain a lead time decrease of 21880.2 seconds.

Keywords: Lean Manufacturing, Waste Waiting, Value Stream Mapping, Process Activity Mapping, Single Minute Exchange of Dies.