

## **ABSTRACT**

*CV. Marasabessy is a manufacturing company in the shoes industry. This research focuses on the production of boots shoes. Based on company data, in 2018, boots production only reached 59,37% of the total target. In order to find out the causes of production failure, identification of waste was carried out, this research focused on waste motion, while other waste was examined by other researchers. In the description of Value Stream Mapping (VSM) Current State, the lead time for boots production is 7165,13 seconds and in the description of Process Mapping (PAM) Current State there is a 63,06 % waste motion . The cause of the existence of waste motion is the activity of searching for tools (equipment) work and components of raw materials. So there needs an improvement to reduce the waste motion that occurs in the production process of boots shoes. The solution to the root causes of using lean manufacturing tools is 5 whys by classifying and identifying the root causes of waste motion. The next step to solve the causes of waste motion is to apply the 5S. On the proposed design improvement to reduce waste motion is to apply seiri, seiton, seiso, seiketsu and shitsuke almost on all workstations. From the proposed draft improvements made, a description of the production process of boots in the Value Stream Mapping (VSM) Future State and the lead time results were reduced to 4998,83 seconds.*

*Keywords: Lean Manufacturing, Value Stream Mapping, Process Activity Mapping, Waste Motion, 5S.*