

## **ABSTRACT**

*Rumah Batik Komar is one of batik producer that work from raw material into a garmen product such as garmen and clothing according to customer's order. Rumah Batik Komar making the batik stamping tools by them self and the tools is placed in a warehouse when not used. The unique of the stamping tools make there's only 1 tools for 1 pattern and going to be grouped with the similar group of pattern such as Kembanggede and Campurbawur. On November 2015, the order picking process on warehouse activity taking up to 89,33% of total process time making the production delayed because of lateness of delivering stamp to production workshop. For the proposed improvement, done by lean warehousing approach to reduce waste and delay time which is a non value added activity. Start by mapping all the process and activity using Value Stream Mapping and Process Activity Mapping. After waste identified, the root cause will be found using root cause analysis by 5Whys and Fish-bone method. The proposed improvement is warehouse slotting using the similarity of pattern and visual control using zonafication and codification. Based on the future state design, improvement happened is increasing of value added activity percentage from 3,7% into 31,9%. Total process time reduced from 7127,22 second or 118,8 minute into 918,32 second or 15,3 minute.*

*Keywords : Lean Warehousing, Tooling Warehouse, Warehouse Slotting, Visual Control*