

ABSTRACT

CV. ASJ is a company which active in sandal industry, classification of sandals which produce customized with customer's request. In this research is conducted take focus on process production of sandals which ordered by PT. A, on the process production it is discovered that there is waste motion which influence the lead time and most of waste motion coming is from assembly kitting area. Based on occurring waste motion problem, accordingly is conducted to give improvement to minimize waste motion.

Processing data is done with Lean Manufacturing approach that are describing Value Stream Mapping (VSM) for knowing lead time, describing Process Activity Mapping (PAM) for knowing activities in process production sandal and for minimizing waste motion on assembly kitting area in process production sandal approached 5S method.

Based on Value Stream Mapping (VSM) is obtained lead time production is about 29869.8 seconds and from Process Activity Mapping (PAM) is obtained percentage of the activities of value added is about 21207.56 seconds, non value added is about 5675.26 seconds, and necessary non value added is about 2986.98 seconds. The next step is depict the fishbone diagram and 5 Why's to find the root cause of the waste motion, and based on approached 5S method is obtained designing improvement for minimizing waste motion.

Key Words: *Lean Manufacturing, Waste Motion, Value Stream Mapping, Process Activity Mapping and 5S.*