

ABSTRACT

CV. ASJ is one of the private companies engaged in the field of sandals industry, located in the city of Bandung, West Java. CV. ASJ produces men's sandals from the manufacture of insole (the center of sandals), upper (top sandals), assembly to finished good with specifications that have been determined by subcontractors in terms of material type, sandal design, time of production, and the number of orders. And then, for the sol and raw materials CV. ASJ orders to their Supplier. CV.ASJ has a problem of bringing in sandal delivery which is six times the delay of eight shipping sandals to its customers PT.A in the period of november 2015 - August 2016, and the problem is identified further using lean manufacturing tools that are value stream mapping and process activity mapping On the production floor of CV.ASJ.

Based on the result, we get lead time value of 29869,8 with VA 71% classification, NVA 19%, and NNVA 10%, and also identification of waste transportation type 23%. With the existence of waste transportation at the upper and insole departments due to the removal of distant material then identified the root cause using fishbone diagram. Proposed settlement of the cause of the removal of material far using the design of the facility layout by pairwise exchange method and design system andon to reduce the distance of material movement.

Key words : *Lean Manufacturing, Waste Transportation, Value Stream Mapping, Process Activity Mapping, Pairwise Exchange, Andon.*