

## **ABSTRACT**

*Based on the observation, there are waste motion problems on the company's production floor. This waste causes the production process to be long and can hamper the whole process. So this study aims to minimize the cause of waste and minimize waste itself by using lean manufacturing approach. Waste motion problems occur in the process of looking for components in the workstation finishing causes the time to prepare components to be long. Research begins by collecting and processing data in the form of operator movement, assembly process time, and time to prepare components. Then the waste motion identification is done by using lean manufacturing approach which consists of value stream mapping and activity mapping process. Then performed root analysis problems that appear on the workstation finishing used SIPOC, cause effect diagram, and 5why. After the root cause of the waste motion was found, the design of the 5S (Seiri, Seiton, Seiso, Seiketsu, and Shitsuke) improvements resulted in the design of the shelf and the component cabinets, working procedure order in the form of checklist sheet according to the assembly process, and the movement of the operator more short and concise in assembly process.*

*Key words : lean manufacturing, waste motion, value stream mapping, 5 S, fishbone, 5 why, Motion Waste.*