

## **ABSTRACT**

PT. Pindad (Persero) is a State Owned Enterprises engaged in main equipment weaponry system and commercial products. One of the resulting product is excavator heavy equipment "Pindad Excava 200". Based on the actual and production targets data year 2017 and 2018, there is an incompleteness number of production targets. Based on these problems, further research is done using Value Stream Mapping (VSM) current state to know the flow of production process. Based on the result of VSM current state, there are activities that has no value added which is 657,41 minutes. From these results then the Process Activity Mapping (PAM) is mapped to find out in detail the activities in production process. Based on the result of PAM current state, the percentage of necessary non value added activities are 14,59%, and non value added are 0.88%. From activity that has no value added, there is waste motion in excava 200 painting zone with a percentage of 6,3%. In this study will design an improvement using 5S in painting zone excava 200 products.

Keywords: Excava 200, Lean Manufacturing, Waste Motion, 5S.