

## **ABSTRACT**

*PT Muawanah Al-Masoem is a company that produces mineral water, company produced consists of several types of packaging, from 240 ml, 330 ml, 600 ml, 1500 ml, and 19 l. In the production process of mineral water gallon. there is a problem that is amount of production realization that can't reach the production target. Percentage of realized production quantities that didn't reach the target occurred at 11 months except in July. Unfulfilled production targets are due to waste waiting that occurs in the gallon production process. This study aims to determine the factors that lead to the occurrence of waste waiting and design the proposed improvement of each problem. Therefore there is need for improvement to minimize waste waiting. Improvement found by lean manufacturing method and kaizen implementation which begins by creating Value Stream Mapping (VSM) and Process Activity Mapping (PAM). Next do identification using fishbone diagram, pareto diagram, 5 why's and 5W1H. Based on the results of identification, the proposed improvements are replacing the storage area of the pallet into gravity flow rack, application of material handling equipment, determining the number of safety stock and reorder point. The proposed improvement plan can minimize waste waiting and produce new working methods, production process flow becomes shorter and the production lead time becomes shorter ie at the existing lead time production condition of 625.60 seconds, after the improvement of lead time production decreases to 222.62 seconds.*

**Key Word:** *Lean Manufacturing, Waste waiting, Value Stream Mapping, and Process Activity Mapping.*