ABSTRACT

PT. XYZ is a pharmaceutical manufacturing company that produces various drugs. *Based on data on product types and historical data on production in 2018, Amlodipine 5/80 mg tablet type drug was chosen because it has the third most production demand and when the drug research is being produced. Amlodipine 5 mg is a tender drug for E-catalog such as BPJS and based on shipping data, this drug has delayed delivery so the company has a penalty of 0,1% of the agreement made. Based on the problems that occur, the authors conducted a study to minimize waste inventory with the Lean Manufacturing approach, then the research begins with making a map of production using Value Stream Mapping (VSM). Based on the results of the VSM it was found that the value of Non Value Added (NVA) activity was greater Value Addded (VA), which was equal to* 70,41 *hours of total lead time of production of 151.98 hours. After that the research used Process Activity Mapping (PAM) to find out the details of production process activities and found Non Value Added (NVA) activities to have the largest percentage of 42.39% and Necessary Non Value Added (NNVA) of 11.28%. Non Value Added is a non-value-added activity that must be minimized and found selected waste, namely Waste Inventory by 90.46%. Next the researcher uses fishbone and 5 why's to identify the causes of waste inventory. To minimize waste inventory, the researcher designed a proposed Pure Kanban system. Then after the design was implemented, a Value Stream Mapping Future mapping was carried out.*

Keywords : *Lean Manufacturing, Process Activity Mapping, Fishbone, Waste Inventory, Kanban.*