

ABSTRACT

CV. XYZ is a manufacturing company engaged in the textile industry. On CV. XYZ often occurs delays in the delivery of production, especially for men's shirts, while this delay occurs due to the occurrence of waste in the production process, one of which is motion waste. Waste Motion is a movement or activity that does not provide added value and can slow down the production process so that the lead time becomes longer. Waste motion can be caused by poor workstation layout, poor method design, large batch sizes, reorientation of materials, and poor workplace organization. The problem solving approach used in this final project is the Lean Manufacturing approach. In collecting data, it is done by direct observation. The results of the final project show that there is a difference in lead time before and after the proposed improvement plan, which is 151.08 seconds. The result of the final project is a proposed application of the 5S method (Seiri, Seiton, Seiso, Seiketsu and Shitsuke).

Keywords: Lean Manufacturing, Value Stream Mapping, Process Activity Mapping, Waste Motion, 5S