ABSTRAK

CV Citra Tech Footwear merupakan perusahaan industri kreatif yang bergerak di bidang Manufacture & Development serta Footwear Production. Perusahaan ini memproduksi berupa outsole sepatu. Pada proses produksinya masih terdapat *waste* terutama pada proses press outsole. Metode lean manufacturing yang digunakan adalah value stream mapping (VSM) Untuk mengurangi waste yang terjadi. Vsm bertujuan untuk menggambarkan aliran produk mulai dari masuknya bahan baku sampai produk jadi. Untuk mengidentifikasi *waste* yang paling dominan yang ada di lantai produksi perusahaan yang terjadi pada lini produksi outsole sepatu , PAM yang di gunakan untuk mengetahui VA(value add), NVA (non value add), NNVA (necessary non-value adding), untuk mengurangi waktu setup pada produksi outsole sepatu, untuk menimalisi nilai *process cycle efficiency* (PCE). Untuk meningkatkan kualitas produksi agar terget produksi tercapai. Hasil evaluasi rekomendasi diperoleh penurunan *production lead time* sebesar 19002,00 detik, peningkatan nilai *Process Cycle Efficiency* sebesar 206,07%.

Kata Kunci : Lean manufacturing , waste, value stream mapping, *Proses Activity Mapping.*

ABSTRACT

CV. Citra Tech Footwear is a creative industry company engaged in Manufacture & Development field, and Footwear production. This company produces the shoe outsole. In the producing process still, there is waste especially on the press production of the shoe outsole. The Lean Manufacturing method used is Value Stream Mapping (VSM) method to reduce the waste that occurs. Value Stream Mapping (VCM) aims to describe the flows of the products ranging from the entry of raw materials to the finished products. To identify the most dominant waste in the production floor of the company that occurs on the shoe outsole of line production, PAM is used to find out the VA (Value Add), NVA (Non-Value Add), NNVA (Necessary Non-Value Adding), to reduce the set-up time on the shoe outsole production, and to minimize the value of the Process Cycle Efficiency (PCE) to improve the quality of the products to achieve the production targets. Results of evaluation of recommendation is decreased production lead time equal to 19002,00 sec, increasing the value of Process Cycle Efficiency of 206.07%.

Keywords *: Lean Manufacturing, Waste, Value Stream Mapping, Proses Activity Mapping.*