ABSTRACT

PTPN VIII Ciater is one of the companies engaged in food production, namely tea. PTPN is the largest tea company in Indonesia. The production of this company is orthodox black tea. In 2011 to 2015 the company can not produce meet the target because there are problems that waste that can affect productivity. After searching waste using checklist waste, found the biggest waste in the milling area is waste motion is about 66%, resulting in a long lead time by 11650,967 seconds with non-value added by 11,04%. Based on the existing waste motion problem, the proposed improvement to reduce waste motion by using lean manufacturing approach.

The first step is to collect the data. Then the data is processed and mapping the flow of materials and information using VSM and PAM. After that look for the cause of motion problems by using the fishbone diagram and find the root problem using 5 Why's. In solving these problems, then performed the design stage by applying the 5S, designing tools and product redesign to eliminate the existing waste motion so as to eliminate non-value added activity. From the proposed design, is obtained shorter lead time by 10385,200 seconds with non-value added value by 0,19% and value added by 69,52%.

Key word : *PTPN, Value Stream Mapping, Process Avtivity Mapping, Waste Motion, Lean Manufacturing,* 5S