

ABSTRACT

CV. ASJ is a subcontractor company that receives orders from various companies to produce sandals, especially men's sandals. CV. ASJ has a daily target to produce 500 pairs of sandals per day. However, production targets are often not achieved because production floor can only produce 400 pairs of sandals. In the process of producing sandals found workup process of goods in process (WIP) on several work stations. The buildup is indicated as waste (waste) inventory that makes the lead time of production to be long so that daily production targets are not achieved. Based on the problem of waste inventory that occurred, the design of the proposed improvement to reduce the cause of inventory waste in the production process of sandals by Lean Manufacturing method approach. Identification the root cause of inventory waste problem is done by depiction of fishbone diagram. Furthermore, design of proposed improvements to reduce the causes of waste inventory by applying pull system using kanban in assembly preparation department, upper manufacturing department and insole manufacturing department and line balancing in the process of making upper and assembly sandals process.

Keywords: lean manufacturing, inventory waste, value stream mapping, line balancing, kanban.