

ABSTRACTION

GARSEL SHOES is a company engaged in the manufacturing industry in the production of shoes. Garsel shoe production has 2 parts BPA and BPB with each different product. BPA carry out production process that has been established so as to produce special shoes work or service. On the BPB makes products with 3 categories namely casual sandals, children's shoes and sports shoes. All the resulting products made to measure distance on women, men, children and adults. On the BPA and BPB has a wide range of issues related to waste and slowing down the production process. Some of the waste such as length of time waiting, the length of processing time, or length of time unemployed workers to the existence of a product. As for other waste such as stacking stuff (not half so), the length of time the process on the part of the upper/advance, the length of the raw materials come from the warehouse of raw material, the existence of stains that inspection into many times, transport finished goods to the tool warehouse use of human transport. Due to the extravagance, Garsel shoes must face the uncertainty of delay in the fulfillment of the product at any given moment. Therefore, peniliti conduct discussions with the production Division to establish the production section and grouping products are examined. Based on the results of the discussion, the author will be memngusulkan improvement with the aim of eliminating the waste production using the approach to Value Stream Mapping. After identifying the problem, explanation of process mapping process, then the proposal can be obtained from the mapping process improvement Garsel GDL code 8002 slippers that have been mapped by using Flow Charts, Fishbone method, so no more waiting and mistakes will happen to making slippers code GDL 8002. Value Stream Mapping (VSM) is mapped with a Current State Mapping, as well as the proposal of repair time with Future State Mapping. Based on the proposed production process that generated a total of workmanship before improvement as much as 02:46:07 hours total time and eliminated the work be 01:42:46 hours. The result has been done by future state mapping this can minimize the process average produced 9 pairs of sandals per day, and, after repairs to 15 pairs of sandals per day with the time fixed. Improvement with Value Stream Mapping can speed up and ease in the making, easy to understand and improve the understanding of the production systems that are running and gives an overview of the command flow of information production are also the result of the analysis and the evaluation has been carried out will improve the quality of the company because it has become a more streamlined business processes or simple, and fast.

Keywords: *Value Stream Mapping, Waste, Extravagance, Fishbone Method*