

ABSTRACT

The purpose of a manufacturing industry is to produce goods that can be purchased commercially. But it is not uncommon to find wastes done by a company. Ineffective and efficient production processes lead to inefficient production. Lean manufacturing helps companies become competitive and reduce waste that occurs in the operation process. This study aims to reduce waste that occurs in the cart horse stamp coffee industry, taking into account waste using the Waste Relationship Matrix (WRM) method, the Waste Assessment Questionnaire (WAQ) and using analysis using 5W + 1H, Movement Study and Fishbone. Identification carried out and carried out by the production process uses the Activyti Mapping (PAM) Process.

Keywords: Lean Manufacturing, Waste Relationship Matrix (WRM), Waste Assessment Questionnaire (WAQ), Process Activation Mapping (PAM).