

ABSTRACT

The research aims to identify wastes in CV Saha Perkasa Gajah Mada using a value stream mapping method and propose improvement using cause and effect diagram.

Observations and interviewing techniques were used to understand the entire production process, representing both information flow and material flow. Which is used to develop *Big Picture Mapping*. This research identifies waste based on the concept of seven wastes. Closed questionnaires were distributed to respondents involved in the production process to find out the major types of waste. Value stream mapping tools are used to map value stream in detail. Cause and effect diagram analysis is used to determine the root causes of waste.

The results of identification waste show that in the production of batik cap tulis, the major types of waste to eliminate include excessive transportation, waiting, defect, inappropriate processing, overproduction, and unnecessary inventory. In the production of batik printing, the major types of waste to eliminate include excessive transportation, overproduction, unnecessary inventory, inappropriate processing, and defect. Based on the analysis of the causes of waste using cause and effect diagram the proposed improvements are given redesigning the layout of production area, checking raw material regularly, checking equipment before using it, training the employee, and applying just in time purchasing.

Keywords: Waste, value stream mapping, big picture mapping, cause and effect diagram