

STUDI PENGENDALIAN MUTU *MEUBEL/FURNITURE*
(*HOUSE HOLD FURNITURE*)
DI CV. KARYA WAHANA SENTOSA, BUNGAS, JETIS, BANTUL
YOGYAKARTA

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INTISARI

Pengendalian mutu digunakan untuk membantu menyeragamkan kualitas suatu barang, sehingga dapat menekan sekecil mungkin kerugian yang disebabkan oleh penolakan barang terjual. Studi pengendalian mutu ini dilakukan di CV. KWaS *Furniture* yang berada di Jl. Imogiri Barat Km 17, Dusun Bungas, Kecamatan Jetis, Kabupaten Bantul, Yogyakarta, dimana pengambilan data dilakukan pada bulan Mei, Juni, Juli dan Agustus 2007. Penelitian ini bertujuan untuk mengetahui produk mebel (*House hold furniture*) yang dinyatakan dalam batas-batas kendali secara statistik berdasarkan bagan pengendali, untuk mengetahui jenis cacat terbanyak yang berpengaruh terhadap kualitas *furniture*, serta mengetahui faktor-faktor dalam proses produksi yang paling berpengaruh terhadap kualitas *furniture*.

Metode pengumpulan data dilakukan dengan dua cara yaitu riset lapangan dan riset pustaka. Riset lapangan merupakan usaha pengumpulan data yang dilakukan secara langsung di lapangan dengan cara wawancara, dokumentasi yang berupa foto-foto proses produksi yang dilakukan oleh perusahaan dan observasi. Sedangkan riset pustaka merupakan usaha untuk menambah informasi dengan literatur-literatur yang berhubungan dengan masalah yang dibahas seperti pengendalian mutu, bagan pengendali kualitas, atribut dan literatur-literatur lain yang berkaitan. Data yang diperoleh kemudian dihitung persen cacat, rata-rata persen cacat, standar deviasi, bagan pengendali dan kurva kerja.

Hasil penelitian menunjukkan bahwa bagan pengendali kualitas cacat plot untuk tanggal 16 Juni-15 Juli 2007 tidak terkendali secara statistik, sedangkan cacat teknis tanggal 16 Juli-15 Agustus 2007 masih terkendali dimana jenis cacat yang terjadi selama proses produksi masih dapat dikendalikan. Empat jenis cacat yang paling banyak terjadi adalah cacat kayu melengkung (pada satu modul) sebesar 25,64%, cacat sambungan laminasi kurang rapat (pada modul TOP) sebesar 23,08%, cacat presisi bor tidak tepat (kayu ngeplin antar modul) sebesar 15,38%, cacat warna bambu tidak cerah sebesar 10,26%. Cacat tersebut disebabkan oleh faktor bahan baku, mesin, lingkungan dan manusia.

Kata Kunci : Pengendalian mutu, *furniture*, Cacat Plot, Cacat Teknis dan Bagan Pengendali Kualitas.

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**THE QUALITY CONTROL STUDY OF MEUBEL/ FURNITURE
(HOUSE HOLD FURNITURE)
AT CV. KARYA WAHANA SENTOSA, BUNGAS, JETIS, BANTUL
YOGYAKARTA**

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ABSTRACT

Quality control is used to standardize quality of a product, so as to minimize the loss caused by the rejection of sold products. This Quality Control study held in CV. KWaS Furniture located in Jl. Imogiri Barat Km 17, Dusun Bungas, Kecamatan Jetis, Kabupaten Bantul, Yogyakarta, and its data collecting process was done in May, June, July and August 2007. This research, however, aimed to identify household furniture product which was stated in limit-limit control statistically according to plan control, to identify the majority types of defect which brought an influence on the quality of the furniture, and to identify factors in the production process that was most influential to the quality of the furniture.

Moreover, the methodology of data collecting was done in two ways. They were field research and library research. Field research is a process of data collecting that is done directly in the field of research by interviewing, documenting pictures of production process done by the factory, and then observation. While library research is a process to add information through books related to the topic of quality control, quality control figure, attribute, and other books. The collected data was next counted on the subject of percentage of defect, average of defect percentage, deviation standard, control figure, and operation characteristic curve.

The result showed that control chart of defect plot quality on 16 June-15 July 2007 was uncontrolled statistically, while technical defect on 16 July –15 August 2007 were still under control in which the type of defects occurred during the production process were still under control. Four most occurring defects types were bending defect in one modul in amount of 25, 64%, laminated joint less intimated contact in TOP modul about 23, 08%, the imperfection of drill precision ngeplin wood in one modul on amount of 15, 38%, the defect on the brightness of the bamboo around 10, 26%. Those defects were caused by raw material aspect, machine, environment and human themselves.

Key words : Quality control, furniture, plot defect, technique defect, and quality control figure.

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