

STUDI PENGENDALIAN MUTU PRODUK ALAS MAKANAN DI CV. SN JAYA PRIMA, PURBALINGGA

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INTISARI

Industri pengolahan kayu memiliki kontribusi strategis terhadap perekonomian nasional, termasuk CV. SN Jaya Prima yang memproduksi alas makanan dari kayu pinus untuk kebutuhan ekspor, khususnya ke Jepang. Produk ini diproduksi secara terus-menerus dan harus memenuhi standar mutu tinggi, namun sering ditemukan cacat pada tahapan pasca pengeringan seperti perataan, pembelahan, dan pemotongan. Penelitian ini bertujuan untuk mengidentifikasi jenis cacat serta menganalisis efektivitas pengendalian mutu pada tahap-tahap tersebut.

Penelitian dilaksanakan di CV. SN Jaya Prima selama 30 hari menggunakan metode *Statistical Quality Control* (SQC) dengan pendekatan *Seven Tools*, yaitu *check sheet*, *diagram pareto*, *scatter diagram*, *control chart*, *histogram*, *defect concentration diagram*, dan diagram sebab akibat. Data berupa jenis produk, jenis cacat, jumlah cacat, profil industri, populasi produk per hari, dan data kuantitatif dikumpulkan melalui observasi langsung, wawancara dengan pekerja terkait, serta dokumentasi. Analisis dilakukan terhadap 3000 sampel yang dibagi menjadi 100 sampel per hari selama 30 hari kerja pada proses perataan, pembelahan, dan pemotongan,

Hasil penelitian menunjukkan bahwa pada proses perataan tidak ditemukan adanya cacat karena hanya diberlakukan pemisahan antara *grade A* dan *B* untuk kebutuhan tipe produk. Cacat paling umum pada pembelahan adalah adanya kulit kayu (66%), sedangkan pada pemotongan adalah cacat minyak (29,73%) akibat kandungan getah alami dari kayu pinus. Peta kendali (*u-chart*) menunjukkan bahwa proses pembelahan dan pemotongan masih berada dalam batas kendali statistik, meskipun ditemukan fluktuasi pada jumlah cacat. Kesimpulannya, pengendalian mutu di CV. SN Jaya Prima telah berjalan cukup efektif, namun masih diperlukan perbaikan pada aspek bahan baku dan metode kerja untuk meminimalkan kecacatan.

Kata kunci : pengendalian mutu, *Statistical Quality Control*, cacat produksi, *Seven Tools*, produk ekspor kayu

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A QUALITY CONTROL STUDY OF FOOD PLACE PRODUCTS

AT CV. SN JAYA PRIMA, PURBALINGGA

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ABSTRACT

The wood processing industry has a strategic contribution to the national economy, including CV. SN Jaya Prima, which produces food plates made from pine wood for export purposes, particularly to Japan. This product is produced continuously and must meet high-quality standards, but defects are often found in post-drying stages such as planing, ripping, and cutting. This study aims to identify the types of defects and analyze the effectiveness of quality control in those stages.

The research was conducted at CV. SN Jaya Prima over 30 days using the Statistical Quality Control (SQC) method with the Seven Tools approach, including check sheets, pareto diagrams, scatter diagrams, control charts, histograms, defect concentration diagrams, and cause-and-effect diagrams. Data such as product types, types of defects, number of defects, industry profile, daily product population, and quantitative data were collected through direct observation, interviews with relevant workers, and documentation. The analysis was conducted on 3,000 samples, divided into 100 samples per day over 30 working days, covering the planing, ripping, and cutting processes.

The results showed that no defects were found during the planing process because only separation between grade A and B was applied for different product types. The most common defect in the ripping process was the presence of bark (66%), while in the cutting process, the most frequent defect was oil (29.73%) due to the natural resin content in pine wood. The control chart (u-chart) indicated that the ripping and cutting processes were still within statistical control limits, although fluctuations in defect quantities were observed. In conclusion, quality control at CV. SN Jaya Prima has been relatively effective, but improvements in raw materials and working methods are still needed to minimize product defects.

Keywords: *quality control, Statistical Quality Control, production defects, Seven Tools, wood export products*

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