

## **ANALISIS PENGENDALIAN PROSES STATISTIK UNTUK PERBAIKAN PROSES *FILLING* GUDEG KALENG DI PT. RISQUNA DEWAKSARA YOGYAKARTA**

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### **ABSTRAK**

Mutu telah menjadi salah satu parameter yang harus dipertahankan oleh suatu perusahaan, baik mutu dalam proses produksi maupun produk akhir. Gudeg kaleng diperoleh dari bahan baku nangka muda dan bahan tambahan lainnya. Pengisian kaleng merupakan salah satu parameter mutu dari produk, sehingga apabila proses pengisian tepat akan memberikan dampak yang baik juga terhadap mutu produk yang dihasilkan. Proses pengisian kaleng di PT. Risquna Dewaksara sering terjadi ketidaksesuaian dalam pelaksanaannya, sehingga perlu dilakukan analisis pada proses pengisian kaleng.

Metode yang digunakan pada penelitian ini, yaitu *Statistical Process Control* (SPC), kapabilitas proses dan Diagram Ishikawa. Tujuan penelitian ini adalah mengidentifikasi pengendalian proses statistik proses pengisian, menganalisis proses produksi pengisian kaleng dengan metode kapabilitas proses, dan memberikan rekomendasi perbaikan proses. Penelitian ini hanya dilakukan pada varian ayam suwir, hal ini disebabkan jumlah peminat varian tersebut paling tinggi. Penelitian dilakukan pada selama bulan Oktober hingga November 2017.

Hasil penelitian didapatkan bahwa pengendalian proses pada pengisian kaleng belum terkendali secara statistik, sehingga nilai kapabilitas yang dihasilkan belum mencapai standar, yaitu kurang dari 1,33. Nilai kapabilitas paling kecil terletak pada ayam suwir  $C_p$  0,21 dan kuah areh  $C_{pk}$  0,08. Berdasarkan hasil kapabilitas proses yang didapat, sehingga diperoleh rekomendasi perbaikan proses dengan menggunakan Diagram Ishikawa. Rekomendasi perbaikan proses adalah pembuatan sendok takar yang memiliki takaran pada setiap masakan serta adanya pembuatan SOP.

**Kata Kunci :** diagram Ishikawa, gudeg kaleng, kapabilitas proses, peta kendali, *Statistical Process Control* (SPC)

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## **ANALYSIS OF STATISTICAL FOR PROCESS IMPROVEMENT OF FILLING THE GUDEG CANS AT PT. RISQUNA DEWAKSARA, YOGYAKARTA**

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### **ABSTRACT**

Quality was been one of the parameters that must be maintained by a company, either quality in the production process and the final product. Canned gudeg were obtained from the raw materials of young jack and other additive. Filling cans was one of the parameter of quality of the product, where that the process of proper filling will give a good impact also on the quality of products produced. The process of filling cans at PT. Risquna Dewaksara often there were nonconforming in the implementation, so that the analyzed on the process of filling the cans.

The method that used in this research were Statistical Process Control (SPC), process capability and Ishikawa Diagram. The purposes of this research were to identify the quality control of the statistics of the filling process, to analyze the production process of filling the cans with process capability method, and to provide recommendations for process improvement. This research was conducted on variant of chicken suwir. The research was conducted from October to November 2017.

Based on the result of the research, it was known that the result the quality control in the process of filling cans has not been applied, so that there is often residual or deficiency caused by the different weight of each product, so that the produced capability value has not reached the standard, that is less than 1.33. The least capability value lies in the chicken suwir, namely Cp 0.21 and Cpk 0,1. Based on the results of the obtained process capability, it obtains the recommendations of process improvement by using Ishikawa Diagram. Some recommended process improvements are creating special tools that have a dose on each dish and creating Standard Operational Procedure.

Keywords : canned gudeg, control chart, ishikawa diagram, process capability, statistical process control (SPC)

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