

## **ANALISIS KECACATAN PRODUK MANISAN CARICA DENGAN METODE *SEVEN TOOLS* DI CV YUASAFOOD BERKAH MAKMUR WONOSOBO**

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### **Abstrak**

CV Yuasafood Berkah Makmur adalah perusahaan yang memproduksi manisan buah carica. Pengendalian kualitas pada proses produksi yang dilakukan perusahaan hasilnya belum maksimal, karena masih ditemukan produk cacat pada produk akhir. Selain itu belum ada dokumentasi jumlah produk cacat sehingga belum diketahui kecacatan masih berada dalam batas kendali atau tidak. Penelitian dilakukan dengan pengumpulan data (25 Juni 2018 – 24 Juli 2018) produk cacat di stasiun pengemasan manisan carica dan menganalisis menggunakan metode *seven tools*. Tujuan penelitian adalah untuk mengetahui jenis kecacatan produk manisan carica cup mini (130 gram), mengetahui jumlah produk cacat, menganalisa jumlah produk cacat masih berada dalam batas kendali atau tidak terkendali, mengetahui penyebab produk cacat dan memberi solusi perbaikan.

Jumlah produk cacat kemasan bocor 245 cup (0.2624%) dan produk terdapat bahan asing 10 cup (0.0107%) dari total seluruh produk 93.360 cup. Produk cacat yang berada di luar batas kendali terjadi di 5 titik pada hari ke-2, 3, 16, 25 dan 26, sehingga dapat disimpulkan jumlah produk cacat telah berada di luar batas kendali. Produk cacat kemasan bocor dipengaruhi faktor manusia, mesin, metode, dan lingkungan. Produk cacat karena ada bahan asing disebabkan faktor manusia, metode, dan lingkungan. Solusi perbaikan sebaiknya perlu dilakukan rotasi antar pekerja produksi, perlu dilakukan perawatan mesin setiap sebulan sekali, dibuat SOP waktu *sealing* cup, ditambahkan *blower fan*, dilakukan pergantian *shift* pekerja, dilakukan sosialisasi dan evaluasi penerapan SOP, dan perlu dilakukan pembersihan ruang produksi saat jam istirahat.

**Kata kunci** : pengendalian kualitas, produk cacat, *seven tools*

## **ANALYZE OF DEFECT PRODUCT CARICA COCKTAIL USING SEVEN TOOLS METHOD IN CV YUASAFOOD BERKAH MAKMUR WONOSOBO**

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### **Abstract**

CV Yuasafood Berkah Makmur is a company which produces carica cocktail. Quality control of production process has not been optimized because defective products were still founded and there was no documentation of count of defective products. In that case, the company didn't know either the defective product is still on control or not. The research was conducted by collecting data (June 25th, 2018 - July 24th, 2018) on packaging station and then analyze the data using seven tools method. The purpose of the research was to find out the type of small cup carica cocktail (130 grams)'s defect, to find out the number of defective products, analyze the number of defective products either still in control or in uncontrolled limit, to find the causes of the defect, and provide solutions for improvement.

There were 245 cups (0,2624%) of leaked packaging and 10 cups (0,0107%) of products that contain foreign material within 93.360 cups of total products. The defective products which were out of the control limit occur in 5 different days. They were on the 2nd, 3rd, 16th, 25th, and 26th days. So it can be concluded that the number of defective products were out of control. Leaked packaging defect are caused by human, machine, method, and environmental factors. Contaminated products is caused by human factors, methods and environment. The solutions to solve the problem are the production employees should be rotated, do monthly machine treatment, create SOP at sealing cup process, add fan blowers, add shifts of employee, socialize and evaluate the SOP implementation, and clean up the production room during recess.

**Key words:** quality control, defect product, seven tools

