

**ANALISIS PENYEBAB *DEFECTS PACKAGING* MENGGUNAKAN
DIAGRAM *FISHBONE* DI PT MAYA FOOD INDUSTRIES,
PEKALONGAN, JAWA TENGAH**

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RINGKASAN

PT Maya Food Industries merupakan perusahaan yang bergerak di bidang pengalengan ikan. *Defects packaging* merupakan permasalahan yang tidak diinginkan oleh perusahaan karena akan menimbulkan kerugian dan mempengaruhi citra perusahaan. Tujuan penulisan laporan ini untuk mengetahui penyebab *defects packaging* di PT Maya Food Industries. Metode yang digunakan yaitu Diagram Pareto untuk mengetahui prioritas masalah dan Diagram *Fishbone* untuk menganalisis penyebab *defects packaging*. Hasil dari laporan ini yaitu persentase kecacatan kaleng yang terjadi selama 23 Januari sampai 8 Maret 2019 sebesar 0,0034% dari total produksi. Jenis-jenis kecacatan kaleng, diantaranya penyok dalam, penyok, bocor, gores, selip, kotor, *print* tidak stabil, leker, karat, kembang, rusak klik, dan rusak *seam*. Berdasarkan Diagram Pareto, 3 prioritas masalah kecacatan, yaitu penyok dalam 44,5%; penyok 31,6%; dan bocor 13,8%. Berdasarkan analisis Diagram *Fishbone* penyebab *defects packaging*, diantaranya penumpukan kaleng pada sambungan antara meja pengemasan dengan konveyor, keranjang menindih kaleng, operator tidak mematuhi SOP, metode pengeluaran kaleng menyebabkan kaleng tertekan, *body* dan tutup kaleng penyok, pengaturan mesin berubah karena getaran, operator salah melakukan pengaturan mesin *seamer*, dan saus terlalu banyak.

Kata Kunci: *Cacat, Kemasan, Pengalengan, Penyok, Bocor*

ANALYSIS OF DEFECTS PACKAGING CAUSES USING FISHBONE DIAGRAMS IN PT MAYA FOOD INDUSTRIES, PEKALONGAN, CENTRAL JAVA

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SUMMARY

PT Maya Food Industries is a canning fish company. Defects packaging is not desired by the company because it will cause losses and affect to the company's image. The purpose of writing this report was to find out the causes of defects packaging at PT Maya Food Industries. The method used was Pareto Diagram to find issues priority and Fishbone Diagrams to analyze the causes of defects packaging. The results of this report were the percentage of disabilities that occurred during January 23 to March 8, the percentage was 0.0034% of total production. The types of defects packaging were severe dents, dents, leaks, scratches, slippage, dirty, unstable printing, plugs, rust, bloating, broken clicks, and broken seams. Based on Pareto Diagram, the three highest priority problems were severe dents 44,5%; dent 31,6%; and leaked out 13,8%. Based on the analysis of Fishbone Diagram that causes defects packaging were the buildup of cans in between packaging tables with conveyors, the basket topped cans, the operator does not follow the SOP, the can dispensing method causes the cans pressed, dented body and lid, machines settings change due to vibration, the operator makes a wrong machine settings, and too much sauce.

Keywords: Defects, Packaging, Canning, Dent, Leaked