

**IDENTIFIKASI PENYEBAB DAN PENANGANAN *REJECT CUP* POLOS  
DI DIVISI NOODLE PT INDOFOOD CBP SUKSES MAKMUR Tbk  
SEMARANG, JAWA TENGAH**

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**Abstrak**

PT Indofood CBP Sukses Makmur Tbk Divisi *Noodle* Semarang merupakan perusahaan yang bergerak di bidang pembuatan *mie instant* yang siap saji dan dikemas bersama bumbu dan minyaknya. Perusahaan ini berlokasi di Jalan Tambak Aji II/8 Kelurahan Tambak Aji Kecamatan Ngalian, Kota Semarang. Struktur organisasi di PT Indofood CBP Sukses Makmur Tbk Divisi *Noodle* Semarang di pimpin oleh seorang *Branch Manager* yang bertugas memimpin dan mengarahkan seluruh kegiatan perusahaan. PT Indofood menerapkan GMP (*Good Manufacturing Practices*), 5S, serta pengendalian mutu dalam setiap melakukan proses produksi. Temuan lapangan ketika magang berlangsung yaitu *reject cup* polos saat proses *moulding*. Ada lima kriteria *reject cup* polos meliputi bibir atas rapuh, pusat bawah rapuh, bibir atas tidak rata, dinding kasar, keliling pusat coak. Pengamatan di lapangan selama 25 hari pada Bulan Februari 2019, diperoleh hasil pengamatan persentase frekuensi *reject cup* polos bibir atas rapuh sebesar 43 %, pusat bawah rapuh sebesar 19%, bibir atas tidak rata sebesar 16%, dinding kasar 14%, keliling pusat coak sebesar 7%. Presentase *reject cup* polos selanjutnya di identifikasi menggunakan diagram pareto serta diagram *fishbone* untuk mengetahui penyebab dan penanganan. Kriteria *reject cup* polos yang menjadi penyebab terbesar meliputi bibir atas rapuh, pusat bawah rapuh, bibir atas tidak rata. *Reject cup* polos bibir atas rapuh dan pusat bawah rapuh disebabkan oleh faktor manusia, mesin, metode, dan material. Bibir atas tidak rata disebabkan karena faktor manusia dan mesin.

**Kata kunci : Diagram pareto, Diagram Ishikawa, *Reject cup***

## CAUSE IDENTIFICATION AND HANDLING OF PLAIN REJECT CUP NOODLE DIVISION IN PT INDOFOOD CBP SUKSES MAKMUR Tbk SEMARANG, JAWA TENGAH

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### Abstract

PT Indofood CBP Sukses Makmur Noodle Division Semarang was a company engaged in the manufacture of instant noodles that were ready to be served and packed with spices and oils. The company was located on Tambak Aji II /8 Street, Tambak Aji Village, Ngalian District, Semarang City. The organizational structure at PT Indofood CBP Sukses Makmur Tbk Noodle Division was led by a Branch Manager who helps lead and direct all company activities. PT Indofood implements in company include GMP (Good Manufacturing Practices), 5S, and controls quality in every production process. The problem during the internship was plain rejecting cup during the moulding process. There are five criteria for plain reject cup; top brittle lips, brittle middle lower, uneven upper lip, rough wall, around the center of coak. Observation in the field for 25 days in February 2019, obtained results from the evaluation that the percentage frequency of plain reject cup with the brittle upper lip by 43%, brittle bottom center by 19%, uneven upper lip by 16%, rough wall 14%, circumference of coak center by 7 %. The plain reject cup percentage was then analyzed using fishbone diagrams and pareto diagrams. Criteria for plain reject cup which was the cause of fragile upper lip issue, bottom middle was brittle, upper lip was not flat. The plain reject cup of the brittle upper lip and the brittle bottom center was caused by human factors, machinery, methods, and materials. The uneven upper lip was due to human and machine factors.

**Keywords:** Pareto diagram, Ishikawa diagram, *Reject cup*