ABSTRACT

PT. Brahma Binabakti is a company engaged in the field of oil palm plantations to produce crude palm oil. The oil palm fruit must pass through several stations, namely the weigh station, the unloading ramp station, the loading ramp station, the sterilizer station, the threashing station, the press station, the clarification station. The content of oil losses at the press station at the beginning of the process is 12.67%, while the standard oil losses for press machines is 3.8%. The purpose of the analysis is to determine the cause of oil losses, the amount of losses caused by the initial start of the press, and eliminate oil losses at the start of the press.

The problem solving method used in the study is the quality control circle. The stages of the method include, (1) data collection (2) setting targets (3) causal analysis (4) countermeasures plan (5) implementing countermeasures (6) evaluating results (7) standardization.

The conclusion from the analysis of the main causes of oil losses at the start of the press are (1) there is no container for crude palm oil and oil palm fibers that still contain 12.67% oil (2) the amount of loss every day for the beginning of the process is 11.75 kg . The existence of a quality control circle can reduce losses of 11.75 kg of crude palm oil to 0 kg.

Keywords : Quality control circle, PDCA, Pressing station

INTISARI

PT. Brahma Binabakti adalah perusahaan yang bergerak di bidang perkebunan kelapa sawit untuk menghasilkan *crude palm oil.* Buah kelapa sawit harus melewati beberapa stasiun yaitu stasiun timbangan, stasiun *unloading ramp,* stasiun *loading ramp,* stasiun *sterilizer,* stasiun *threashing,* stasiun *press,* stasiun *clarification.* Kandungan *oil losses* di stasiun *press* saat awal proses yaitu 12,67%, sedangkan standar *oil losses* mesin press adalah 3,8%. Tujuan analisa adalah untuk mengetahui penyebab *oil losses*, besar kerugian yang disebabkan oleh *start* awal mesin *press*, dan menghilangkan *oil losses* pada *start* awal mesin *press*.

Metode penyelesaian masalah yang digunakan dalam penelitian adalah *quality control circle*. Tahapan metode tersebut meliputi, (1) pengambilan data (2) penetapan target (3) analisa sebab akibat (4) rencana penanggulangan (5) melaksanakan penanggulangan (6) evaluasi hasil (7) standarisasi.

Kesimpulan dari analisa penyebab utama *oil losses* pada *start* awal mesin press adalah (1) tidak ada alat penampung *crude palm oil* dan serabut kelapa sawit yang masih mengandung 12,67% *oil* (2) jumlah kerugian setiap hari untuk awal proses adalah 11,75 kg. Adanya *quality control circle* dapat menurunkan kerugian 11,75 kg *crude palm oil* menjadi 0 kg *crude palm oil*.

Kata Kunci : Gugus Kendali Mutu, PDCA, Stasiun *press*