

**PENENTUAN PENYEBAB RAW MATERIAL LOSS PADA LINI
PRODUKSI MALKIST M06 DI PT MEGA GLOBAL FOOD INDUSTRI,
GRESIK, JAWA TIMUR
MAGANG**

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RINGKASAN

Pelaksanaan magang dilakukan pada 06 Januari 2020 – 06 April 2020 di PT. Mega Global Food Industry yang berlokasi di Jalan Raya Tenaru no. 18 RT. 02 / RW. 01 desa Cangkir, Kec. Driyorejo, Gresik 611177 Jawa Timur, Indonesia. PT Mega Global Food Industry (PT MGFI) merupakan industri yang memproduksi biskuit yaitu Kokola. Penulis selama magang ditempatkan di departemen produksi di bagian foreman *wrapping* yang bertugas mengawasi jalan proses produksi di bagian *wrapping*. Terdapat permasalahan di *line* M06 berupa banyaknya *Raw Material Loss (RM Loss)* yang terjadi pada proses produksi bulan Februari dan Maret 2020. Penulis melakukan analisa data menggunakan rumus *%yield* (efisiensi) untuk mengetahui nilai *RM Loss* dan menentukan penyumbang tertinggi menggunakan diagram Pareto. Analisis penyebab permasalahan dilakukan menggunakan *seven tools* yaitu *diagram ishikawa*. Hasil analisa data *%yield* bulan Februari dan Maret sebesar 95,11%. Hasil analisa menggunakan diagram pareto penyumbang *RM Loss* tertinggi berada pada *waste area packing & bongkaran* pada bulan Februari dan Maret sebesar 42%. Hasil analisa menggunakan *diagram ishikawa* terdapat 5 masalah dengan masalah terbanyak pada bagian mesin. sehingga permasalahan utama terdapat pada mesin *wrapping*. Setelah dilakukan analisa diperoleh rekomendasi paling efektif untuk mengurangi *RM Loss* yaitu Membuat SOP mengenai preventive maintenance, persiapan produksi dan pergantian batch dan menyesuaikan speed mesin *wrapping* dengan jalur conveyor agar tidak terjadi penumpukkan malkist.

Katakunci : *diagram ishikawa*, diagram pareto, efisiensi, persentase *yield*, *RM*
Loss,

**DETERMINATION OF THE CAUSE OF RAW MATERIAL LOSS IN
MALKIST M06 PRODUCTION LINE IN PT MEGA GLOBAL FOOD
INDUSTRI, GRESIK, EAST JAVA
INTERNSHIP**

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SUMMARY

The Apprentice implementation is conducted on 06 January 2020 – 06 April 2020 at PT. Mega Global Food Industry located at Tenaru Highway No. 18 RT. 02/RW. 01 Village Cups, Kec. Driyorejo, Gresik 611177 East Java, Indonesia. PT Mega Global Food Industry (PT MGFI) is a biscuit-producing industry called Kokola. The author during the internship was placed in the production department in the foreman wrapping section which is tasked with supervising the production process path in the wrapping section. There are problems in the line M06 in the form of a number of Raw Material Loss (*RM Loss*) that occurred in the production process in February and March 2020. The author conducts data analysis using the % yield formula (efficiency) to determine the value of *RM Loss* and determines the highest contributor using Pareto diagram. Analysis of the cause of the problem is done using *seven tools* namely Ishikawa diagram. The results of data analysis % yield in February and March amounted to 95.11%. The results of the analysis using Pareto diagram of the highest *RM Loss* donor is located on the Waste packing area & Bongkaran in February and March for 42%. The results of analysis using Ishikawa diagram are 5 problems with the most problems on the machine. So the main problem is in the wrapping machine. After analysis is obtained the most effective recommendation to reduce *RM Loss* is to make SOP about preventive maintenance, production preparation and batch turnover and adjust the speed of wrapping machine with conveyor lines so as not to occur the shedding of malkist.

Keywords: efficiency, ishikawa diagram, pareto diagram, percentage yield, *RM*
Loss