

**STUDI FAKTOR PENYEBAB KECACATAN SEAL TERBUKA PADA  
PROSES STERILISASI SOSIS “KIMBO REDDI” DAN “VIGO” DI PT  
MADUSARI NUSAPERDANA, BOYOLALI, JAWA TENGAH (MAGANG)**

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**ABSTRAK**

PT Madusari Nusaperdana merupakan perusahaan yang berdiri pada tahun 1995 dan bergerak di bidang produk pangan olahan daging yang memiliki dua pabrik yang beroperasi di Cikarang, Jawa Barat dan Boyolali, Jawa Tengah. PT Madusari Nusaperdana menawarkan produk sosis dengan berbagai varian rasa yang telah bersertifikasi halal oleh MUI dan terdaftar oleh BPOM. Salah satu jenis produk cacat yang ditemukan saat sortasi adalah kecacatan *seal* kemasan terbuka. Sosis dengan *seal* kemasan terbuka terjadi ketika *seal* kemasan lemah, sehingga pecah saat proses sterilisasi dan isi sosis keluar dari kemasan. Produk pecah tidak memenuhi standar untuk dipasarkan, sehingga diperlukan pengendalian mutu untuk mengurangi kerugian akibat produk cacat. Penelitian bertujuan untuk mengidentifikasi penyebab terjadinya kecacatan *seal* kemasan sosis yang terbuka pada proses sterilisasi dan mempertimbangkan faktor yang mempengaruhi terjadinya kecacatan. Analisis penyebab kecacatan menggunakan metode *5 Why's* dan Diagram Ishikawa. Penyebab terjadinya kecacatan dari faktor manusia yaitu operator terlambat mengetahui kegagalan produk, faktor metode yaitu tidak ada tindakan pencegahan, dan faktor mesin yaitu lebar area kontak elektroda pada mesin *filler* tidak sesuai standar, suhu elektroda terlalu tinggi atau rendah, dan permukaan elektroda *filler* kasar. Tindakan perbaikan yang dapat dilakukan antara lain meningkatkan kegiatan pengecekan mesin, penyetelan ulang suhu standar, meningkatkan tindakan inspeksi dan ketelitian operator, meningkatkan kedisiplinan operator, dan membuat standar operasional prosedur dan *work instruction* terkait tindakan pencegahan.

Kata kunci: analisis *5 why's*, diagram ishikawa, produk cacat, *seal* kemasan

***ANALYSIS OF OPENED SEALS CAUSE FACTORS ON STERILIZATION  
PROCESS "KIMBO REDDI" AND "VIGO" SAUSAGE IN PT MADUSARI  
NUSAPERDANA, BOYOLALI, CENTRAL JAVA (INTERNSHIP)***

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***ABSTRACT***

*PT Madusari Nusaperdana is a processed meat product company that established since 1995 and has two plants operating in Bekasi, West Java and Boyolali, Central Java. PT Madusari Nusaperdana produces sausage with many varieties of flavors that have been certified halal by MUI and listed in BPOM. One type of defective product found in the process of product sorting was the broken seal where the sausage packages are opened. Sausages with an open packing seal occurred when the packing seal was weak, so that it breaks during the sterilization process and the sausage comes out from its wrapper. These broken products are automatically do not meet the marketing standard, therefore, a quality control is required to reduce the loss due to defective products. This study aimed to identify the main reason of the sausage broken seal in sterilization process and figuring out the factors that contributes to the breakage. Analysis of the causes of defect was using the 5 Why's analysis and Ishikawa Diagram. The damage on the sausage seal occurred due to the human factor which the operator was too late to find out the failure of the product; the method factor where there was no precautions against the damage; and the machine factors such as the width of the electrode contact area in the filler machine was not meeting with the standard required, the temperature of the electrode was too high or low, and the rugged surface of the electrode in the filler machine. The repairing obtained in several ways such as checking the machine more frequently, resetting the standard temperature, improving the skill and quality of the operator, improving the operator discipline, and making a standard operational procedures and work instruction that relates to the precautions against the damage.*

*Keywords: 5 why's analysis, defective product, ishikawa diagram, packaging seal*