

**PENERAPAN METODE DMAIC UNTUK MENGURANGI GALON RETUR
APKIR PADA STASIUN KERJA BONGKAR DI PT TIRTA INVESTAMA
WONOSOBO, JAWA TENGAH**

MAGANG

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RANGKUMAN

PT Tirta Investama Wonosobo merupakan salah satu pabrik Aqua grup yang bergerak dalam produksi air minum dalam kemasan dengan merk dagang Aqua. Lokasi pabrik terletak di Jalan Mangli, Desa Kejiwan, Langensari, Kejiwan, Kecamatan Wonosobo, Kabupaten Wonosobo. Pabrik ini memproduksi dua jenis produk yakni produk Aqua cup 220 ml dan Aqua galon 19 liter. Topik permasalahan yang dibahas yakni tentang pengurangan galon retur apkir pada stasiun kerja bongkar. Penulis melakukan metode penelitian DMAIC dengan mengamati proses pembongkaran hingga pengecekan galon retur. Berdasarkan hasil pengamatan dan identifikasi yang dilakukan, kriteria apkir yang paling banyak yakni pada bocor <4. Percobaan dilakukan oleh perusahaan dan mahasiswa magang, didapatkan hasil bahwa masih terdapat galon kriteria retak <4 cm yang tidak bocor, tetapi masuk ke tempat pengapkir. Hal tersebut dapat disebabkan oleh pekerja yang tidak konsentrasi karena melakukan 2 pekerjaan sekaligus dan juga tidak ada alat bantu seperti mesin *leak tester*. Analisis permasalahan juga dilakukan pada proses pengecekan penerimaan galon retur yang dapat menyebabkan jumlah galon retur apkir naik karena kesalahan dalam penerimaan galon retur. Hal tersebut dapat disebabkan karena pengecekan dilakukan di atas truk. Berdasarkan analisis permasalahan dilakukan perbaikan pada proses pengecekan penerimaan galon retur dengan melakukan *training* pekerja, pemasangan lampu, dan pemindahan tempat pengecekan. Analisis permasalahan kesalahan galon retak <4 cm belum dilaksanakan karena perusahaan masih mempertimbangkan biaya penerapan. Hasil dari perbaikan yakni angka galon apkir menurun dari data sebelum perbaikan (bulan Februari) sebesar 86,129% menjadi data setelah perbaikan (bulan April) sebesar 79,052%.

Kata kunci: DMAIC, galon apkir, inspeksi, penanganan

***APPLICATION OF THE DMAIC METHOD TO REDUCE REJECT RETURN
GALLONS IN THE UNLOAD STATION AT PT TIRTA INVESTAMA
WONOSOBO, CENTRAL JAVA***

INTERNSHIP

By:

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SUMMARY

PT Tirta Investama Wonosobo is one of the Aqua group factories that produces bottled drinking water under the Aqua trademark. The factory is located on Jalan Mangli, Kejiwan Village, Langensari, Kejiwan, Wonosobo District, Wonosobo Regency. This factory produces two types of products: Aqua cup 220 ml products and Aqua gallon 19 liters. The topic of the problem discussed is about reducing reject of the return gallons at the unloading work station. The author conducted a research DMAIC method by observing the demolition process to checking the return gallon. Based on the results of observations and identification made, the most rejected criteria are leaking <4. Experiments were carried out by companies and apprentice students, the results showed that there were still gallons of crack criteria <4 cm which did not leak, but entered the reject place. This can be caused by workers who are not concentrated because he did 2 jobs at once and also do not have tools such as a machine leak tester. Problem analysis is also carried out in the process of checking the receipt of return gallons which can cause the number of gallons of returned returns to increase due to errors in receiving return gallons. This can be caused by checking carried out on the truck. Based on the problem analysis, improvements were made to the process of checking the receipt of return gallons by conducting training worker, put the lamp, and moving the checkpoint. Analysis of the problem of crack gallon error <4 cm has not been carried out because the company is still considering the cost of implementation. The result of the improvement, namely the rejected gallon number decreased from the data before the repair (in February) of 86.129% to the data after the repair (in April) of 79.052%.

Keywords: DMAIC, gallon rejects, inspection, handling