

## Kajian Kesiapan Penerapan *Good Manufacturing Practices* di Koperasi Susu SAE pada Ruang Lingkup Fasilitas Sanitasi, Mesin dan Peralatan, serta Karyawan

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### ABSTRAK

Koperasi Susu SAE memproduksi susu pasteurisasi dan mensuplai susu segar ke suatu perusahaan susu nasional. Koperasi selalu mengutamakan kualitas dan mutu susu yang dihasilkan. Penerapan GMP pada ruang lingkup fasilitas sanitasi, mesin dan peralatan serta karyawan bertujuan menjaga kualitas mutu susu. Tujuan dari tugas akhir ini yaitu mengukur kesiapan penerapan *Good Manufacturing Practices* (GMP) dan mengidentifikasi penyebab ketidaksesuaian tingkatan harus pada ruang lingkup fasilitas sanitasi, mesin dan peralatan serta karyawan di Koperasi Susu SAE dengan berpedoman Peraturan Menteri Perindustrian Republik Indonesia Nomor : 75/MIND/PER/7/2010.

Tahap penelitian yang dilakukan yaitu melalui studi kepustakaan yang mengatur GMP. Wawancara dilakukan pada karyawan, manajer dan kepala produksi. Survey lapangan dengan pengambilan data yang didapat dengan pedoman yang mengatur GMP. Dievaluasi dengan menggunakan tingkat persyaratan paling tinggi yaitu tingkatan harus, dengan dianalisis 5 *why's* dan diagram ishikawa untuk mendapat sebab akibat permasalahan dan diberi saran perbaikan terhadap persiapan penerapan GMP di Koperasi Susu SAE.

Berdasarkan hasil tingkat kesiapan penerapan *Good Manufacturing Practices* (GMP) di Koperasi Susu SAE yaitu 59,10% sudah sesuai dan 40,91% belum sesuai dengan melihat tingkatan persyaratan. Dari ketiga ruang lingkup terdapat 6 aspek pada ketidaksesuaian tingkatan harus yang segera di perbaiki. Saran perbaikan yang dilihat dari analisis 5 *why's* dan diagram ishikawa pada 6 aspek yang tidak sesuai yaitu sebaiknya koperasi membuat anggaran keuangan untuk menyediakan tempat khusus pembuangan limbah, menambahkan petugas kebersihan, mengganti peralatan yang baru, menyimpan peralatan di tempat yang tertutup, menyediakan ruang makan/ pantry di unit produksi dan membuat peraturan yang tegas dalam larangan pemakaian aksesoris saat bekerja.

**Kata Kunci:** *Good Manufacturing Practices (GMP), Fasilitas Sanitasi, Mesin dan Peralatan, Karyawan.*

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## **Study of Readliness Implementation Good Manufacturing Practices in The SAE Milk Cooperative on the Scope of Sanitation Facilities, Machinery and Equipment, Employees**

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### **ABSTRACT**

The SAE Milk Cooperative produces pasteurized milk and supplies fresh milk to a national dairy company. The cooperative always puts quality and quality of milk produced. The implementation of GMP on the scope of sanitation facilities, machinery and equipment as well as employees aims to maintain the quality of milk. The objective of this final project is to measure the readiness of Good Manufacturing Practices (GMP) implementation on the scope of sanitation facilities, machinery and equipment, employees in the SAE Milk Cooperative under the Regulation of the Minister of Industry of the Republic of Indonesia Number: 75/MIND/PER /7/2010.

The stage of research conducted is through a literature study that regulates GMP. Interviews were conducted on employees, managers and production heads. The field survey was with data retrieval obtained with guidelines that regulate GMP. It was evaluated by using the highest level of requirement, that is to say a “must” level, by analyzing the 5 why's and ishikawa diagram to obtain causes and results of the problems and give advice on improvements to the preparation of GMP implementation in the SAE Milk Cooperative.

Based on the results of the level of readiness of the implementation of Good Manufacturing Practices (GMP) in the SAE Milk Cooperative, it is stated that 59.10% was appropriate and 40.91% was not in accordance with the level of requirements. From the three scopes there are 6 aspects of mismatch of the must level immediately fixed. Suggestions of improvement seen from the analysis of 5 why's and ishikawa diagrams on 6 aspects that are not appropriate were that the cooperative should make the financial budget to provide a special place of waste disposal, add cleaning personnel, replace new equipment, store equipment in a closed place, provide dining/pantry in the production unit and make strict rules in the ban on the use of accessories while working.

**Keywords:** Good Manufacturing Practices (GMP), Sanitation Facilities, Machinery and Equipment, Employees.

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