

**PENGUJIAN KADAR AIR DAN PROTEIN
PADA PROSES PENERIMAAN BAHAN BAKU SUSU KEDELAI
DI PT OTSUKA INDONESIA, MALANG, JAWA TIMUR**

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RANGKUMAN

Validasi merupakan salah satu prinsip CPOB berupa tindakan pembuktian dan dokumentasi bahan, prosedur, proses agar selalu konsisten dengan hasil yang diinginkan. Validasi bahan baku susu kedelai bubuk di PT Otsuka Indonesia pada proses penerimaan bahan baku mencakup analisis tren data dengan menggunakan Peta Kendali dari data riwayat pengujian kadar air dan kadar protein susu kedelai bubuk. Tren data yang stabil menunjukkan kualitas bahan baku yang stabil juga sehingga variasi karakteristik produk akhirnya cenderung kecil. Data dibuat Peta Kendali I-MR untuk mengetahui data yang sesuai spesifikasi, kemudian data diukur untuk mengetahui nilai kapabilitas prosesnya. Atribut Kadar Air menunjukkan nilai Cp sebesar 2,32 dan nilai Cpk sebesar 1,19 maka kapabilitas proses berjalan sangat baik dan rata-rata proses berada di dalam batas spesifikasi. Pada atribut Kadar Protein nilai Cp sebesar 19,27 dan nilai Cpk sebesar 0,97 yang berarti kapabilitas proses berjalan sangat baik namun nilai Cpk < 1,00 menunjukkan bahwa satu variasi proses berada (dominan) pada salah satu batas spesifikasi yaitu condong ke kiri mendekati batas spesifikasi bawah (LSL).

Kata kunci : kapabilitas proses, pengawasan mutu, peta kendali, validasi

**MOISTURE AND PROTEIN CONTENT ANALYSIS
IN RAW MATERIALS RECEIVING OF SOY MILK
AT PT OTSUKA INDONESIA, MALANG, EAST JAVA**

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SUMMARY

Validation is one of the GMP principles in the form of evidence and documentation of materials, procedures, processes so that they are always consistent with the desired results. Validation of raw material for powdered soy milk at PT Otsuka Indonesia in the process of receiving raw materials includes analysis of data trend using a Control Chart from historical data on testing water content and protein content of powdered soy milk. Stable data trends indicate stable raw material quality so that the variation in the characteristics of the final product tends to be small. The data is made an I-MR Control Chart to find out the data according to the specifications, then the data is measured to determine the value of the process capability. The water content attribute shows a Cp value of 2.32 and a Cpk value of 1.19, so the process capability runs very well and the average process is within the specification limits. In the Protein Level attribute, the Cp value is 19.27 and the Cpk value is 0.97, which means the process capability is running very well, but the Cpk value <1.00 indicates that one process variation is (dominant) at one of the specification limits, which is leaning to the left approaching lower specification limit (LSL).

Keywords : capability process, control chart, quality control, validation