PENURUNAN TINGKAT CACAT P-TANK DI *LINE ASSEMBLING* 4 ALUMUNIUM RADIATOR DENGAN METODE PDCA (STUDI KASUS DI PT. DENSO INDONESIA)

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ABSTRAK

PT.Denso Indonesia adalah perusahaan manufaktur yang bergerak di bidang otomotif yang memproduksi kompressor, busi, *stick oil*, oksigen sensor, magneto, Radiator, AC bus dan lain-lain. Tingginya persaingan antar produk menuntut perusahaan memberikan yang terbaik bagi konsumennya. Kualitas merupakan salah satu jaminan yang harus diberikan dan dipenuhi oleh perusahaan kepada pelanggan. Masalah yang dihadapi oleh PT. Denso Indonesia khusus nya *line assembling* 4 alumunium radiator adalah tinggi nya tingkat cacat P-tank. Tujuan penelitian ini adalah untuk menganalisa penyebab terjadinya cacat P-tank dan merekomendasi penanggulangan untuk mencegah terulangnya cacat P-tank di lini kerja *assembling* 4 divisi Alumunium Radiator dengan menggunakan metode PDCA studi kasus dilaksanakan di PT. Denso Indonesia periode Januari 2018 – Maret 2018. Berdasarkan penelitian dan pengumpulan data dilapangan didapati tingkat NG P-tank sekitar 0,7% dengan proporsi cacat *Fitting* patah, *Scratch*, dan melengkung. Pengolahan data menggunakan *Histogram, Pareto Diagram, dan Fishbone Diagram*. Setelah dilakukan *improvement* jumlah cacat turun menjadi 0,3%.

Kata kunci : Fitting P-tank patah, Scratch, Kaizen, PDCA-8 langkah.

DECREASING THE DISABILITY LEVEL OF P-TANK IN ASSEMBLING LINE 4 ALUMUNIUM RADIATOR USING PDCA METHOD (CASE STUDY IN PT DENSO INDONESIA)

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ABSTRACT

PT.Denso Indonesia is a manufacturing company engaged in the automotive sector that produces compressors, spark plugs, stick oil, oxygen sensors, magneto, radiator, AC buses and others. The high competition between products requires companies to provide the best for their customers. Quality is one of the guarantees that must be given and fulfilled by the company to customers. Problems faced by PT. Denso Indonesia specifically the line assembling 4 aluminum radiators is a high level of P-tank defects. The purpose of this study was to analyze the causes of P-tank defects and recommend countermeasures to prevent the recurrence of P-tank defects in the assembly line 4 of the Aluminum Radiator division using the PDCA method of case studies conducted at PT. Denso Indonesia for the period January 2018 - March 2018. Based on the research and data collection in the field it was found that the NG level of P-tanks was around 0.7% with the proportion of defects in Fittings broken, Scratch, and curved. Processing data using a Histogram, Pareto Diagram, and Fishbone Diagram. After the improvement, the number of defects dropped to 0.3%.

Keywords: P-tank fittings broken, Scratch, Kaizen, PDCA-8 steps.