

ABSTRAK

Salah satu produk yang dihasilkan oleh PT. Megasari Makmur adalah produk Biosol 25 mL. Produk biosol adalah pembersih lantai untuk menghilangkan kotoran dan mengharumkan ruangan. Produksi Biosol di mesin demar terdapat permasalahan yaitu adanya produk *defect* pada periode Maret – Agustus 2022 mengalami hasil rata – rata persentase *defect* sebesar 3.7% sehingga melebihi standar perusahaan sebesar 2.0%. Tujuan penelitian ini adalah mengetahui jenis *defect* tertinggi sampai terkecil, mengetahui faktor penyebab terjadinya *defect* dan memberikan usulan perbaikan untuk mengurangi jumlah *defect*. Untuk meningkatkan kualitas peneliti menggunakan metode DMAIC dan FMEA. Hasil yang telah dianalisis terdapat 4 jenis *defect* dan hasil persentase kumulatif seperti *seal* bocor 43%, *overlap* 67%, *foil* melipat 89% dan nomor *batch* buram 100%. Perhitungan RPN yang telah diketahui menggunakan metode FMEA terdapat seperti belum tersedia alat bantu pengecekan hasil *sealing* skor 192, pengecekan kondisi *forming* skor 180, dosing kotor skor 175 dan perawatan *print head* 175. Setelah diketahui penyebab dan skor tertinggi pada nilai RPN maka dapat diberikan usulan perbaikan seperti pembuatan alat bantu pengecekan hasil *sealing* dan membuat Instruksi Kerja (IK) alat bantu, membuat *form checklist kondisi forming*, membuat *checkseet cleaning dosing* kotor dan membuat *checkseet* perawatan *print head* dan *roll* penarik pita.

Kata kunci :Pengendalian Kualitas, *Defect*, DMAIC, FMEA.

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ABSTRACT

One of the products produced by PT. Megasari Makmur is a 25 mL Biosol product. Biosol products are floor cleaners to remove germs and scent the room. Biodiesel production in demar machines has a problem, namely the presence of defect products in the period March - August 2022 experienced an average result of the percentage of defects of 3.7% so that it exceeded the company's standard of 2.0%. The purpose of this study is to find out the highest to smallest types of defects, find out the factors that cause defects and provide suggestions for improvements to reduce the number of defects. To improve the quality of researchers using DMAIC and FMEA methods. The results that have been analyzed are 4 types of defects and cumulative percentage results such as 43% leaking seals, 67% overlap, 89% folding foil and 100% opaque batch number. RPN calculations that have been known using the FMEA method include the availability of tools to check the sealing score of 192, check the condition of forming a score of 180, gross dosing of a score of 175 and maintenance of print head 175. print head and roll puller tape. After the cause and the highest score on the RPN value are known, improvements can be given such as making sealing results checking tools and making Work Instructions (IK) tools, making checklist forms for forming conditions, making chekseet cleaning dosing dirty and making chekseet maintenance print head and roll pulling bands.

Keywords : Quality Control, Defect, DMAIC, FMEA.

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