

ABSTRAK

Seiring dengan meningkatnya permintaan dalam dunia *automotive* agar kompetitif, mengharuskan perusahaan melakukan peningkatan kualitas dari produk yang dihasilkan termasuk pada PT Gajah Tunggal Plant TBR. pada departemen *building* yaitu proses penggabungan material pembentuk ban, atau disebut *Green tire* ini sering terkendala isu kualitas yang menyebabkan performa *quality* departemen *building* menurun, disebut *green tire hold*. Untuk mengurangi waste tersebut perusahaan menggunakan metode DMAIC (*Define, Measure, Analyze, Improve, Control*). Dari analisis yang ada penyebab isu kualitas terbanyak adalah *Sidewall Folded*, dan *Bead Gembos*. Hasilnya diketahui penyebab terjadinya *green tire hold* meliputi Faktor material meliputi material *Sidewall* yang tidak lengket dan licin terhadap permukaan *Bladder*, Faktor *man* disebabkan tidak ada referensi *setup*, Faktor mesin meliputi bearing unit yang kondisinya sudah tidak baik. diketahui presentase *green tire hold* sebesar 1,42% adapun setelah perbaikan presentase *green tire hold* dari total produksi 1,24 % atau turun 0,18 % dari total produksi *green tire*.

Kata Kunci : *Green tire, Waste, DMAIC, Six sigma*



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ABSTRACT

The increasing demand in the automotive world to be competitive, it requires companies to improve the quality of the products they produce, including PT Gajah Tunggal Plant TBR. in the Building department, namely the process of combining tire-forming materials, or called Green tires, quality issues are often constrained by quality issues that cause the quality performance of the Building department to decline, called green tire hold. To reduce waste, the company uses the DMAIC (Define, Measure, Analyze, Improve, and Control) method. . From the analysis, the causes of the most quality issues are Sidewall Folded, and Bead Gembos. The result is known that the cause of green tire hold includes material factors including Sidewall material that is not sticky and slippery to the Bladder surface, man factor due to no setup reference, engine factor includes bearing unit whose condition is not good. It is known that the percentage of green tire hold is 1.42% while after the improvement, the percentage of green tire hold from the total production is 1.24% or decreased by 0.18% from the total green tire production.

Keywords: Green tire, Waste, DMAIC, Six sigma



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