

PENGENDALIAN KUALITAS CACAT PRODUK WAJAN MENGGUNAKAN METODE *LEAN SIX SIGMA* DI SP ALUMINIUM

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ABSTRAK

SP Aluminium ialah tempat pengolahan aluminium yang dileburkan menjadi peralatan rumah tangga seperti wajan, dandang, panci, dan lainnya. Penelitian ini berfokus pada bagian produksi, yang mana jumlah cacat produk yang terjadi tiap harinya bisa mencapai puluhan wajan yang tidak lolos dari *Quality Control (QC)*, bentuk produk cacat yang terjadi seperti bolong jarum, retak, ketebalan dan juga ketipisan. Permasalahan yang dihadapi oleh SP Alumunium ialah cacat produksi wajan tersebut masih tergolong tinggi. Tercatat pada hari Jumat, 1 juni 2022 jumlah produksi wajan yang di cetak 1.848 wajan, dengan produk yang tidak lolos *qc* 370 wajan, dan poduk mati 30 wajan. Kemudian pada tanggal 6 juni 2022 jumlah produksi wajan yang di cetak 1.713 wajan, dengan produk yang tidak lolos *qc* 265 wajan, dan poduk mati 73 wajan dengan tipe yang berbeda. Cacat produk terjadi diakibatkan oleh beberapa faktor yaitu dari manusia, alat, bahan baku, metode, dan lingkungan. penelitian ini menggunakan metode *Lean Six Sigma*, yang mana dalam metode *Lean Six Sigma* untuk mengidentifikasi *Waste* dan juga pengendalian cacat produk wajan yang terjadi. Hasil penelitian ini ialah upaya pengendalian cacat produk yang diakibatkan dari manusia, alat, bahan baku, metode, dan lingkungan, yaitu seperti pemberian alat *stopwatch*, *thermometer*, kain lap, dan pencahayaan.

Kata kunci: Lean Six Sigma.

QUALITY CONTROL OF PAN PRODUCT DEFECTS USING THE LEAN SIX SIGMA METHOD IN SP ALUMINUM

ABSTRACT

SP Aluminum is where aluminum is processed and melted down into household appliances such as pans, boilers. This research focuses on the production department, where the number of product defects that occur every day can reach tens of pans that do not pass the Quality Control (QC), the shape of the defective products that appear, such as needle holes, cracks, thickness, and thinness. The problem faced by SP Aluminum is that the frying pan production defects are still relatively high. It was recorded that on Friday, June 1, 2022, the number of pans produced was 1,848, with products that did not pass the QC, 370 pans, and 30 pans that failed. Then on June 6, 2022, the number of pans produced was 1,713, with products that did not pass the QC 265 pans and 73 pans with different types of non-performing products. Product defects occur due to several factors: humans, tools, raw materials, methods, and the environment. This study uses the Lean Six Sigma method, which is the Lean Six Sigma method for identifying waste and controlling defects in frying pan products. The results of this study are efforts to prevent product defects caused by humans, tools, raw materials, methods, and the environment, namely the provision of stopwatches, thermometers, rags, and lighting.

Keywords: Lean Six Sigma.

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