

# Analisis Pengendalian Kualitas Produksi Carica Menggunakan Metode *Seven Tools* Studi Kasus Pada CV Gemilang Kencana

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## ABSTRAK

CV Gemilang Kencana adalah perusahaan yang bergerak di bidang industri pengolahan dan pembuatan manisan carica yang berdiri sejak tanggal 10 Oktober 2013. Buah carica itu sendiri merupakan buah yang tumbuh didaerah dataran tinggi wonosobo. Dari produksi manisan carica adapun terdapat beberapa masalah pada saat proses produksinya antara lain adalah kecacatan produk kemasan seperti label miring, berat produk tidak sesuai, cup kemasan rusak/bocor, dengan total kecacatan produk sebesar 474 cup dengan kecacatan paling banyak pada tanggal 29 Februari 2023, dari kecacatan produk yang sudah dijabarkan maka dari itu dibutuhkan pengendalian kualitas untuk mengurangi kecacatan produk tersebut yaitu dengan menggunakan metode *seven tools* dalam pengendalian kualitas. Pada tabel control chart menunjukkan cacat paling banyak yaitu pada tanggal 29 dengan jumlah cacat sebanyak 43 cup sementara tingkat kecacatan paling tinggi pada tanggal 7 dengan nilai batas tengah 0,0079, batas atas 0,012692, dan batas bawah dengan nilai 0,003108. Grafik histogram menunjukkan kecacatan paling tinggi yaitu cacat cup kemasan rusak/bocor setelah itu kecacatan berat produk tidak sesuai dan paling bawah adalah label miring. Pada diagram pareto melalui pengolahan maka dibuat diagram pareto dengan hasil kecacatan paling dominan yaitu cup kemasan rusak/bocor dengan nilai 47,68%. Berdasarkan *scatter* diagram yaitu melibatkan dua variabel yaitu variabel jumlah produksi dan total kecacatan produk berdasarkan diagram *scatter* dapat dilihat bahwa bentuk sebaran memiliki korelasi atau hubungan yang positif antara jumlah produksi dengan kecacatan produk. Berdasarkan analisa *fishbone* penyebab kecacatan produk dari beberapa faktor yaitu faktor mesin, manusia, lingkungan, dan metode sehingga perusahaan melakukan tindakan pencegahan atau perbaikan untuk meminimalisir kecacatan pada saat proses produksi.

**Kata kunci:** Carica, Kecacatan, Diagram, Cup

# ***Analysis of Carica Production Quality Control Using the Seven Tools Method***

## ***Case Study at CV Gemilang Kencana***

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### ***ABSTRACT***

*CV Gemilang Kencana is a company engaged in the manufacturing and processing industry of carica sweets which was founded on October 10, 2013. The carica fruit itself is a fruit that grows in the highlands of Wonosobo. In the production of carica sweets, there are several problems during the production process, including defects in packaging products such as slanted labels, inappropriate product weight, damaged/leaky packaging cups, with a total product defect of 474 cups and the most defects occurred on February 29, 2023. From the product defects that have been described, quality control is needed to reduce these product defects by using the seven tools method in quality control. The control chart table shows the most defects, namely on the 29th with a total of 43 cups of defects while the highest level of disability is on the 7th with a middle limit value of 0.0079, an upper limit of 0.012692, and a lower limit of 0.003108. The histogram graph shows the highest defect, namely the damaged / leaky packaging cup, after that the product weight defect does not match and the lowest is the slanted label. In the pareto diagram through processing, a pareto diagram is made with the most dominant result of defects, namely damaged/leaking cup packaging with a value of 47.68%. Based on the scatter diagram, which involves two variables, namely the variable number of production and total product defects. Based on the scatter diagram, it can be seen that the shape of the distribution has a positive correlation or relationship between the amount of production and product defects. Based on fishbone analysis, the causes of product defects are from several factors, namely machine, human, environmental, and methods factors so that companies take preventive or corrective actions to minimize defects during the production process.*

**Keywords:** *Carica, Disability, Diagram, Cup*

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