

**USULAN PERBAIKAN PENGENDALIAN KUALITAS UNTUK
MENGURANGI JUMLAH CACAT PADA DOMZ CLOTHING
MENGUNAKAN METODE SQC DAN FMEA**

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ABSTRAK

Domz Clothing adalah perusahaan dibidang industri konveksi kaos. Terdapat permasalahan kualitas kaos dengan hasil persentasenya 11,3%. Kecacatan yang terjadi diantaranya, ukuran kaos tidak presisi, jahitan obras tidak rapi, dan sablon kurang maksimal. Tujuan penelitian untuk mengidentifikasi permasalahan, melakukan pengendalian kualitas, dan mengurangi jumlah kecacatan produk kaos. Pada penelitian ini penyelesaian masalah dengan menggunakan metode SQC dan FMEA. Berdasarkan hasil menggunakan Checksheet hasil nilai terbesar yaitu jenis cacat Jahitan Obras dengan total 142 pcs dan nilai rata-rata yaitu 5%, Hasil diagram pareto pada jenis kecacatan jahitan obras produk kaos menghasilkan frekuensi tertinggi sebesar 142 defect dengan nilai kumulatif 45,5%. Berdasarkan hasil perhitungan nilai FMEA didapatkan dari nilai RPN tertinggi sebesar 210 pada jenis kecacatan sablon dengan penyebab faktor tertinggi pada lingkungan. Usulan perbaikan dengan metode 5W+1H dilakukan dengan perbaikan mesin press sablon yang diterapkan oleh operator sablon, pada faktor mesin dilakukan dengan pengecekan suhu panas dan melakukan timer pada mesin.

Kata kunci : Pengendalian kualitas, SQC, FMEA, 5W+1H

PROPOSED QUALITY CONTROL IMPROVEMENTS TO REDUCE TOTAL DEFECTS IN DOMZ CLOTHING USING SQC AND FMEA METHODS

ABSTRACT

Domz Clothing is a company in the t-shirt manufacturing industry. The t-shirts have a quality issue, with a yield percentage of 11.3%. There were several defects, including imprecise sizing of the t-shirt, untidy overlock stitching, and suboptimal screen printing. The research aims to identify issues, conduct quality control, and minimize defects in t-shirt products. This study utilizes the SQC and FMEA methods for problem-solving. According to the results obtained from the Checksheet, the most common type of defect in the overlock stitch was 142 instances, with an average occurrence of 5%. The Pareto diagram showed that the overlock stitch defect type had the highest frequency of 142 defects, making up a cumulative value of 45.5%, for t-shirt products. The FMEA value was determined based on the calculation results, which showed that the type of screen printing defect with the highest environmental factors had the highest RPN value of 210. The suggested enhancement through the 5W+1H technique involves the maintenance of the screen printing press machine operated by the screen printing operator. This maintenance includes monitoring the heat temperature and configuring a timer on the machine to ensure optimal performance.

Keywords: Quality control, SQC, FMEA, 5W+1H

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