

## ABSTRAK

PT. Karunia Alam Segar adalah Perusahaan yang bergerak di bidang industri makanan berupa mie instant dan seasoning, pada periode agustus 2017 – januari 2018 mesin packing FPDB 1 dengan jenis rasa BPGMG (Bumbu Powder Garnish Mie Goreng) sering trouble sehingga menghasilkan *defect product* yang banyak. Berdasarkan permasalahan ini Bagaimana upaya pengendalian kualitas untuk mengurangi *defect product* packing bumbu powder garnish mie goreng mesin FPDB 1 dengan metode six sigma DMAI di PT. Karunia alam segar. Untuk mengurangi jumlah defect perlu dilakukan perhitungan COPQ, DPMO, sigma, fishbone, serta FMEA sehingga akar penyebab meningkat. jumlah *defect* diketahui presentase *defect* perbulan 7,21 % melebihi target perusahaan yang sebesar 5 %. Hasil analisa diketahui jenis defect BPGMG antara lain *defect* gembos, *defect* potongan, *defect* seal, *defect* etiket melipat, *defect* berat under dan over, sedangkan nilai DPMO atribut sebesar 12,344 dengan nilai sigma level 2,5, DPMO variabel sebesar 9,193755. Sebagai rekomendasi untuk mengurangi defect salah satunya dilakukan training kepada operator serta penjadwalan preventif maintenance.

Kata kunci : DMAI, COPQ,DPMO, sigma, fishbone, FMEA

## ABSTRACT

PT. Karunia Alam Segar is a company engaged in the field of food in the form of instant noodles and seasoning, in the period August 2017 - January 2018 FPDB 1 packing machine with the type of flavor BPGMG (Bumbu Powder Garnish Mie Goreng) often trouble resulting in a lot of defect product. Based on this problem How the effort of quality control to reduce defect product packing powder garnish fried machine FPDB 1 with method of six sigma DMAI in PT. Karunia Alam Segar. To reduce the number of defects need to be calculated COPQ, DPMO, sigma, fishbone, and FMEA so that the root cause increases the number of defects known percentage defect per month 7.21% exceeds the company's target of 5 %. The result of analysis is known defect type of BPGMG such as *defect gembos*, *defect piece*, *defect seal*, under weight *defect* and over weight *defect*, while the value of DPMO attribute equal to 12,344 with value of sigma level 2,5, DPMO variable equal to 9,193755. As a recommendation to reduce the defect one of them conducted training to operators and preventive maintenance scheduling.

Keywords : DMAI, COPQ, DPMO, sigma, fishbone, FMEA