ABSTRAK

Penelitian ini bertujuan untuk mengidentifikasi faktor tingginya reject karton saat proses packaging dan memperbaiki faktor penyebab tingginya reject karton. Sepanjang tahun 2023 reject karton sebesar 40.999 box dengan hasil produksi 9.239.399 box. Adapun factor yang menjadi penyumbang reject karton yaitu inject print, rusak flexym, berminyak, metal, kotor/tidak simetris, robotic dan rusak DS. Adapun usulan perbaikan yang dapat dilakukan untuk mengurangi reject karton yaitu dengan mengadakan inspeksi langsung antara Head Section dan Leadershift ke supplier terkait proses pencetakkan dan kualitas karton dan mengadakan training kepada pekerja baru serta SOP (Standar Operasional Pabrik) disosialisasikan dan diiringi sanksi dan penghargaan pada karyawan. Metode yang dilakukan dengan metode seven tools : check sheet, startifikasi, histogram, scatter diagram, control chart, diagram pareto dan diagram sebab-akibat. Diperoleh hasil %kumulatif diagram pareto menunjukkan terdapat 4 jenis reject sebagai persentase terbesar (80%) dan harus diperbaiki untuk menurunkan faktor penyebab reject karton yaitu kotor/tidak simetris (37%), berminyak (16%), metal (14%), rusak flexym (11%). Reject tersebut diakibatkan dari beberapa faktor yaitu faktor metode, mesin, manusia dan material. Dari hasil analisa seven tools maka didapat nilai reject karton sebesar 40.999 box sepanjang tahun 2023 didapat nilai rata-rata proporsi pada reject karton sepanjang tahun 2023 yaitu sebesar 0.00063 dan rata-rata nilai UCL dan LCL yaitu sebesar 0.00068 dan 0.00059. Berdasarkan persentase diagram pareto, nilai reject karton tertinggi pada jenis reject kotor/tidak simetris yaitu sebesar 37%, berminyak yaitu sebesar 16%, metal yaitu sebesar 14% dan rusak flexym yaitu sebesar 11% .

Kata Kunci *: Seven tools, metode, reject, usulan perbaikan, karton, packaging.*

ABSTRACT

This research aims to identify factors that cause high levels of cardboard rejects during the packaging process and improve factors that cause high levels of cardboard rejects. Throughout 2023, cardboard rejects amounted to 40,999 boxes with a production output of 9,239,399 boxes. The factors that contribute to cardboard rejects are inject print, damaged flex, oily, metallic, dirty/asymmetrical, robotic and damaged DS. The proposed improvements that can be made to reduce cardboard rejects are by holding direct inspections between the Head Section and Leadershift to suppliers regarding the printing process and cardboard quality and holding training for new workers and socializing SOPs (Factory Operational Standards) and accompanied by sanctions and rewards for employees. The method used is the seven tools method: check sheet, starting, histogram, scatter diagram, control chart, Pareto diagram and cause-and-effect diagram. The results obtained from the cumulative % Pareto diagram show that there are 4 types of rejects as the largest percentage (80%) and must be improved to reduce the factors causing cardboard rejects, namely dirty/asymmetrical (37%), oily (16%), metal (14%), damaged flexym (11%). The rejection was caused by several factors, namely method, machine, human and material factors. From the results of the seven tools analysis, the cardboard reject value was obtained at 40,999 boxes throughout 2023. The average value of the proportion of cardboard rejects throughout 2023 was 0.00063 and the average UCL and LCL values were 0.00068 and 0.00059. Based on the percentage of the Pareto diagram, the highest cardboard reject value is for dirty/asymmetrical reject types, namely 37%, oily, 16%, metal, 14%, and damaged flex, 11%.

Keywords*: Seven tools, method, reject, proposed improvements, carton, packaging.*