

ABSTRACT

PT. ABC is a manufacturing company engaged in the manufacture of electronic goods special refrigerators or coolers, freezers, and showcase managed by trained workforce from abroad and local people. PT. ABC has always tried to maintain the quality of their products, but in fact PT. ABC still got a defective product claims. Based on the company's data section Pre Assy during 2013 until July 2014, the number of products Inner Liner Cabinet Single Door fluctuated and exceeds the company's monthly disability standard is 0.5%.

To solve the company's problems, this study uses the Six Sigma method because it can help companies develop corrective actions systematically. Six Sigma method consists of five steps: Define, Measure, Analyze, Improve, and Control. From the Define phase is found fourteen types of defects and defect wrinkles 24.38%, 14.25% Sobek defects, defect Scratch / scratch 13.47, 12.74% dent defects become disabled are often found on the product. Measure from the phase obtained by the process capability is a process sigma level 4, 75 656 with DPMO values 584.809 and there are 7 months of production which are outside the control limits. In the Analyze phase, found seven priority improvements that were selected based on the highest RPN value in the FMEA analysis.

Next on stage Improve was proposed some improvement chosen which gives thermostat (Photo-electric cell safety preheating and heating T930004 card) on Forming machine, add a device such as lamp lights Balk or Transparent Fiberglass roof, giving Cyclone Turbine Ventilator or obligation to use earplugs, conduct training to the operators of production and quality control of product quality and safety standards, imposed a system of Reward and Punishment and make manual tools such as Display, and create a Work Instruction bigger and clear.

Keywords: Pre Assy, Inner Liner Cabinet Single Door, Quality, Six Sigma