LIST OF IMAGES

Figure I.1 Defect Escalation graphic From Collecting Area to PT. Abo Farm (Period 2012) 12

Figure I.2 The Factors That Cause The Occurence of Reject 13

Figure II.1 DMAIC Cycle 21

Figure II.2 SIPOC Diagram 29

Figure II.3 Cause and Effect Diagram (Ishikawa Diagram) 30

Figure III.2 Systematics Problem Solving 45

Figure IV.1 Business Process in Farmer-PT.Abo Farm- Exporters.....47

Figure IV.2 Image Process Happens in Gatherer.....48

Figure IV.3 Pareto Diagram for Types of Defect of Beans 51

Figure IV.5 Control P- Chart for Bean's Product 57

Figure IV.6 Sigma Calculator's Display for January.....58

Figure IV.7 Sigma Level Graphs 59

Figure IV.8 Pareto Diagram for Broken Beans Types of Defect.....61

Figure IV.9 Fishbone Cause Defects Beans Parts Steam Torn Man Power Factor (1) 62

Figure IV.10 Fishbone Cause Defect No Short-Sighted in Beans Man Power Factor 65

Figure IV.11 Fishbone Chart of Disability Existence Nails Scratches on Bean's Surface Man Power Factor (1) 67

Figure IV.12 Ideal Conditions Lifting According to NIOSH 82

Figure IV.13 Ideal Conditions (Continued) What Should Filled According to NIOSH 82

Figure IV.14 Aid Proposed Mechanical Equipment (Hand Truck) 84

Figure IV.15 Form Load Beams with Handle 86

Figure IV.16 Lifting Instruction Display by Using A Form Load Beams With Handle 87

Figure IV.17 The Load Beams Without Handle 88

Figure IV.18 Lifting Instruction Display by Using a Form Load Beams Without Handle 89

Figure IV.19 Expense Form Sack 90

Figure IV.20 Lifting Instruction Display By Using a Form of Sacks 91

Figure IV.21 The Sample Of Desks Or Sustainer Which Has A Height 92

Figure IV.22 Lifting Instruction Display For All Kinds and Shape Which Has A Height Above The Table 93

Figure IV.23 Proposed Picking Process Display 102

Figure V.1 SWOT Analysis for Alternative 4 107

Figure V.2 SWOT Analysis for Alternative 1 111

Figure V.3 SWOT Analysis for Alternative 114

Figure V.4 SWOT Analysis for Alternative 2 119