

ABSTRACT

Special Vehicle types of Komodo MBDA is one products that produced by PT. Pindad. There are several components of the MBDA Komodo is often defecting, one of which is the front door. According to the company's data at the period of June 2016- November 2016, the number of the defect front door reach to 2 to 3 units for each month, thus exceeding tolerance the limit of defects that have been set by the company is one unit.

Based on problems that have been outlined previously required to design improvements to minimize defects using Six Sigma methods. On the six sigma method consist of five stages are define, measure, analyze, improve, and control (DMAIC). At the stage of define is done CTQ identification and mapping of the production process using SIPOC diagram. At the stage of measure is done measurement process stability and process capability. In the analyze stage determine the highest defect type in the product by using Pareto diagram and analyze the defect causal factor using fishbone diagram, and 5 why's, and determine priority for improvement proposal using FMEA.

From the results of FMEA to be performed improvent stage is done making the design of improvement proposal based on priority. A top priority proposal of improvement proposal is the form of tool for welding and other improvement proposals is displays.

The proposed tools used to further facilitate the assembly process in conduct plate door with other components of the compiler of the Komodo MBDA, by having the lock system plate assembly process so that when the door is not shifting. The proposed visual display that is use of the pause time in welding and Creat display for disciplinary operator reminder

Key Word : Defect, Six Sigma, DMAIC, CTQ