

ABSTRACT

One of the products at PT. Suzuki Indomobil is the APV. Furthermore, in this study, if it is mentioned that APV has the highest defect value, namely 1053 defects compared to other products in the period May 2020 to July 2020, where in the Welding production line which has a dominant defect value and sha compared to other workstations. Problems in welding, among others, are defect dansha so that it requires a solution to overcome these problems. The purpose of this study is to design work tools / procedures that can reduce dansha defects in reducing dansha defects on the results of welding body parts at PT. Suzuki Indomobil Motor Tambun II and Making improvement proposals that can be used to minimize or eliminate factors that cause waste defect dansha on Welding Part Body Mobil APV at PT. Suzuki Indomobil Motor. Because Quality is "Quality is a measure of product ability to live up to the average consumer expectations about it" and knowing the problems of the study, it can be seen using the Pareto Diagram where the diagram can display the number of dansha defects that occur and what percentage are obtained from the dansha defect in the APV unit to determine the proposal of this study using the FMEA approach at the predecessor stage to determine the root of the problem using the defect dansha data and several factors from the SIPOC diagram, continue to enter the fishbone diagram then after the causal factors are known it will be enter into the FMEA approach where to find out which priority factors are problematic starting from the RPN value where the highest value is two factors, namely the method and man factors. So that entering the analyze stage, we find out the root of the problem using 5 reasons where it can be seen what is the root cause of the four factors. So that a suggestion is obtained in the form of improving the work procedure of the welding department by designing an inspection checksheet in the welding process for the problem factor of the method while the proposed improvement of the man factor is by making a visual display warning poster. The next stage is to analyze and discuss the research that has been done. Then the final stage is to draw a conclusion that gets the proposed improvement design to overcome problems in the welding process that cause defects of dansha to the method and man factors, namely inspection checksheet on parts in the welding process. So the suggestion from this research is to evaluate the causes of the dansha defect and implement the proposed repair periodically so that it can minimize the dansha defect effectively and efficiently.

Keyword : *Dansha, Fishbone, 5 Why's*, and FMEA.