

ABSTRACT

The garment industry is an important sector in meeting clothing needs and plays a strategic role in Indonesia's economy. One company operating in this field is PT ABC, located in Bandung Regency. PT ABC produces various types of products such as bed sheets, headscarves, pashminas, and gamis, with this study focusing on gamis products due to their higher production difficulty. However, based on production data over the past 12 months (August 2023 – July 2024), it was found that the percentage of defective products still exceeds the company's defect tolerance threshold of 2%, with the highest rate at 3.72%. These product defects are caused by various factors such as sewing errors, sizes not meeting standards, stained raw materials, and zipper or button malfunctions. This indicates that the company is still facing quality issues that require systematic attention and handling.

In this study, the House of Risk (HOR) method was used to identify risk mitigation strategies in the production process of gamis products. The HOR method consists of two phases. The first phase is used to determine risk priorities. The second phase is used to provide risk mitigation strategies. Primary data was obtained through observation, interviews, and questionnaires with 14 respondents from the production department of PT ABC, while secondary data was obtained from the company's internal documentation. The identification was conducted throughout the entire gamis production process, from raw material procurement, pattern making, cutting, sewing, accessory installation, quality control, to the finishing process.

In the first phase of the HOR, 18 risk events and 22 risk causes were identified. Among the 22 risk causes, there were 9 priority risk causes contributing to product defects, including worker carelessness, workers rushing, inconsistent quality control, and improper machine settings. The highest ARP value was obtained by the risk cause “worker carelessness” with an ARP score (4,320). Furthermore, in the second phase of the House of Risk (HOR), risk mitigation strategies were identified for the 9 priority risk causes, resulting in 10 risk mitigation strategies. These 10 risk mitigation strategies include the development of documented work instructions, the creation of inspection manuals, the implementation of a reward and punishment system, and routine maintenance of sewing machines. The highest ETD value was obtained by the risk mitigation strategy “developing documented work instructions” with an ETD score (35,514).

Keywords: House of Risk (HOR), risk mitigation, garment manufacturing.