

ABSTRAK

UD. Favourite bergerak dalam bidang produksi kaos kaki, dengan produk unggulannya yaitu kaos kaki polos hitam putih. Penelitian difokuskan pada jenis produk kaos kaki hitam putih polos SD, proses produksi kaos kaki dimulai dengan proses pengrintingan atau perajutan, penjahitan bagian bawah, penjahitan bagian atas dan pengovenan. Berdasarkan pengamatan pada proses produksi, masih ditemukan adanya masalah terkait dengan kualitas, yaitu kecacatan kaos kaki pada lini produksinya. Cacat paling banyak terjadi pada proses pengeritingan atau perajutan dengan jenis kecacatan tipis dan sobek. Berkaitan dengan permasalahan yang ada, perlu dilakukan perbaikan untuk meminimalkan jumlah cacat dan meningkatkan kualitas produk. Metode SPC (*statistical processing control*) merupakan suatu teknik statistik dimana digunakan guna memastikan suatu proses produksinya memenuhi standar. Metode lain yaitu dengan menggunakan FMEA (*failure mode and effect*) dalam mengidentifikasi serta mencegah sebanyak mungkin adanya kegagalan sehingga diperoleh usulan perbaikan sesuai dengan prioritas rekomendasi penanggulangan. Berdasarkan hasil penelitian diperoleh usulan perbaikan yaitu memberikan beban kerja sesuai kemampaun pekerja, menambah dan meletakkan tempat sampah pada setiap mesin pengeritingan, melakukan penataan bahan baku dengan menerapkan metode FIFO (*first in first out*), serta menambah waktu istirahat dan menyediakan kursi untuk setiap operator.

Kata Kunci : Kualitas, Cacat, *Statistical Processing Control*, *Failure Mode Effect Analysis*.

ABSTRACT

UD. Favourite is engaged in the production of socks, with its superior product being plain black and white socks. The research focused on the types of plain black and white socks products of SD, the sock production process starts with the process of perming or knitting, bottom sewing, top stitching and overning. Based on observations in the production process, there are still problems related to quality, namely the defects of socks on the production line. Defects are most common in the curling or knitting process with thin and torn types of defects. In relation to existing problems, it is necessary to make improvements to minimize the number of defects and improve product quality. The SPC (statistical processing control) method is a statistical technique which is used to ensure a production process meets standards. Another method is to use FMEA (failure mode and effect) in identifying and preventing as many failures as possible so that improvement proposals are obtained in accordance with the priority of countermeasures recommendations. Based on the results of the study, improvement proposals were obtained, namely providing workloads according to the ability of workers, adding and placing bins on each curling machine, arranging raw materials by applying the FIFO (first in first out) method, as well as increasing rest time and providing seats for each operator.

Keywords: *Quality, Defect, Statistical Processing Control, Failure Mode Effect Analysis.*

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