ABSTRACT

PT . Pronesia is a company engaged in the field of convection that developed since 2003 in Bandung . PT . Pronesia since the beginning of manufacture of shirts and t-shirts until now believed to produce uniforms for some major companies in Indonesia . As the industry produces finished goods quality of these products is a major concern of the company.

In an effort to increase the satisfaction of the consumer requires that companies produce the products according to the given criteria . A large number of defects were found to be an important issue for PT . Pronesia . With an average defect reaches 6:09 % per month was well above the maximum limit of the company is equal to 2 % . Types of defects found in the form of defective seam , dirty cloth , material defects , defect embroidery and printing defects .

To overcome these problems , use six sigma method . Measures used consisted of define , measure, analyze , and improve on DMAIC . Define phase , carried SIPOC diagramming and determining the dominant defect type . Phase measure , the determination of CTQ , measurement stability and process capability . In the analyze phase , determined the root cause of the problem with the fishbone chart . Phase improve an administration proposal that an improvement of the results of the analysis on the analyze phase . Given proposal aims to improve the quality of the production process by reducing the number of defective products in the production process of the shirt . Based on the results define phase , product defects found in production in 2012 was flawed shirt seam by 44 % , 29 % dirty cloth , material defects 23 % , and the rest of the embroidery and printing defects . P control chart based on the use of performance shirt production process in 2012 is still not stable , with the point is outside the control limits . With an average DPMO 32388.234 shirt production process at the level of 3.35 sigma .

Some recommendations are given to decrease the percentage of defective shirts make the existence of such a leader line , work instructions for cutting and sewing activities , in addition to an improvement in the method of storage of raw materials .

Keywords : Convection , Fishbone charts , DMAIC