

## LIST OF IMAGES

Figure I.1 Defect Escalation graphic From Collecting Area to PT. Abo Farm (Period 2012) .....	12
Figure I.2 The Factors That Cause The Occurence of Reject .....	13
Figure II.1 DMAIC Cycle.....	21
Figure II.2 SIPOC Diagram .....	29
Figure II.3 Cause and Effect Diagram (Ishikawa Diagram) .....	30
Figure III.2 Systematics Problem Solving .....	45
Figure IV.1 Business Process in Farmer-PT.Abo Farm- Exporters.....	47
Figure IV.2 Image Process Happens in Gatherer.....	48
Figure IV.3 Pareto Diagram for Types of Defect of Beans .....	51
Figure IV.5 Control P- Chart for Bean’s Product .....	57
Figure IV.6 Sigma Calculator’s Display for January.....	58
Figure IV.7 Sigma Level Graphs .....	59
Figure IV.8 Pareto Diagram for Broken Beans Types of Defect.....	61
Figure IV.9 Fishbone Cause Defects Beans Parts Steam Torn Man Power Factor (1) 62	
Figure IV.10 Fishbone Cause Defect No Short-Sighted in Beans Man Power Factor 65	
Figure IV.11 Fishbone Chart of Disability Existence Nails Scratches on Bean’s Surface Man Power Factor (1) .....	67
Figure IV.12 Ideal Conditions Lifting According to NIOSH .....	82
Figure IV.13 Ideal Conditions (Continued) What Should Filled According to NIOSH 82	
Figure IV.14 Aid Proposed Mechanical Equipment (Hand Truck).....	84
Figure IV.15 Form Load Beams with Handle .....	86
Figure IV.16 Lifting Instruction Display by Using A Form Load Beams With Handle 87	
Figure IV.17 The Load Beams Without Handle .....	88

Figure IV.18 Lifting Instruction Display by Using a Form Load Beams Without Handle	89
Figure IV.19 Expense Form Sack.....	90
Figure IV.20 Lifting Instruction Display By Using a Form of Sacks.....	91
Figure IV.21 The Sample Of Desks Or Sustainer Which Has A Height.....	92
Figure IV.22 Lifting Instruction Display For All Kinds and Shape Which Has A Height Above The Table.....	93
Figure IV.23 Proposed Picking Process Display .....	102
Figure V.1 SWOT Analysis for Alternative 4 .....	107
Figure V.2 SWOT Analysis for Alternative 1 .....	111
Figure V.3 SWOT Analysis for Alternative .....	114
Figure V.4 SWOT Analysis for Alternative 2 .....	119