

## Usulan penurunan persentase overweight produk di PT. Nabisco Foods dengan metode six sigma

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### Abstrak

PT Nabisco Foods is a food industry which is facing quality problem, that is product overweight. Overweight percentage existing reaches 5,44 percent meanwhile company's maximum target for overweight is only 3 percent. Six Sigma is a comprehensive methodology for quality improvement which is directly eliminating the main special sources of problem with DMAIC (Define-Measure-Analyze-improve-Control) approach. Six Sigma concept is aimed to increase process capability, reduce variation between outputs and adjust them with the target.

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Determining product O with Regular type as the main focus, research scope is limited in mixing, forming and baking area. Then the actual process capability is evaluated by measuring weight and thickness parameter of base cake. For weight parameter, level sigma is 5,04 and 99,93 percent yield. These metric value indicates that the process capability for weight parameter is quite good. On the other hand, for thickness parameter, level sigma 3,45 and 97,42 percent yield are received which points that improvement focus on process related to thickness parameter is needed. By analyzing actual process, the root causes with highest risk level are identified, one of them is the lack of correlation of temperature between oven zone. The outcome of using Taguchi method is the optimum setting that are 1 baking time in 6 menit, suhu zone 1,2 dan 3 subsequently 500, 610 and 650 F. For the last phase of Six Sigma., author recommend utilization of control chart form for monitoring process capability continuously with thickness of base cake as the parameter.