

ABSTRACT

Midsized scale Industrial in the field of metal forming in Indonesia start trusted by local consumer and abroad to produce the part component from a product, although defect rate and its variability specification still be high relative

This matter experienced of by Metal PT.ARTO representing manufacturing business in the field of metal of forming, where in this time company trusted by its partner contractor to produce the slider component. Slider component is the part of product handle of frying appliance which is the form of the metal obtained by through bending process, which during the time company own the specialization to process material bending which form of material is plate. Technological type at new production process recognized cause the result from production process of disagree with size measure of specification wanted by consumer and also own the variability which high enough. Dimension variability of slider component cause the instability from product handle when assembling by means of frying handle, though technical quality aspect from product wanted by stable handle. As company solution conduct the reworking of its production process. This research aim to to look for the cause factor of the happening of defect, measuring storey; measure the level of capability and effectivity of the reworking process to reduce the defect, determining vital CTQ from handicapped cause factor as especial priority of repair, and look for the alternative way to repair slider component. To realize it conducted by cycle of trouble-shooting activity with the step Make a Potret, Evaluation, Therapy, and Application (PETA). In phase make a potret done by a identifying, measurement of ability production process in this time, and analyse to object of taken as project make-up of quality found by a especial priority of repair, at phase evaluate done by a cause analysis of the happening of defect found by a most having an effect on factor dominantly through brainstorming, at therapy phase done by a forms plan the treatment to reduce defect, and at application phase done by make control mechanism of production process with simulate the process by making experimental design.

Result from research obtained by evidence that reworking is not effective in reducing defect even variability of slider dimension mount equal to 7,81 % from value of early, defect factors caused by its style of spring back, influence form of the stopper, form and dies size measure, apart to punch in to machine dies, and operator mistake. Vital CTQ of defect cause is process bending 3 angle 97° with the contribution 63,65 %. Repair method recommended by use overdies, form the new stopper at the machine, arranging setting punch in to dies and give the specialized training to operator.

Keyword : PETA, CTQ (critical to quality), Slider, Reworking, Spring Back, Brainstorming, Dies, Stopper, Bending