

**Penerapan Metode Six Sigma untuk Perbaikan Kinerja Proses Penggulungan
Teh Hijau Di PT. Candi Loka Ngawi (Application of Six Sigma Method to
Improve the Performance of Green Tea Rolling Process at Pt. Candi Loka Ngawi)**
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ABSTRACT

PT. Candi loka is a food-manufacturing company with green tea. Noting quality aspects is one of the keys so that a company can properly meet consumer needs and thrive in the industrial competition of the age of globalization. The green tea production process that is carried out every day is still not controlled in each process. This study used the six sigma method to improve performance and minimize defect in the rolling process. The calculation result using the Six Sigma method obtained an average DPMO (Defect Per Million Opportunity) value of 156756 and a sigma value of 2.51. For the performance of the rolling process was obtained Cp value of 0.20 and Cpk 0.19 so that the performance of the rolling process could be said to be capable of producing products according to the specifications but the rolling process could also be said to be unoptimal and still require repairs. The factor that cause defect that are a priority for repair are before the machine stops the tea leaves have been removed, the performance is lowered, and the volume of tea leaves rolled less with optimal rolling time.

Key words : FMEA, Green Tea, Rolling Process, Six Sigma