Pengendalian Mutu Penutupan Kaleng Sarden Metode Sqc Dan Fmea Di CV. Pasific Harvest *(Quality Control of Sardines Cans Seaming Sqc and Fmea Methods at CV. Pasific Harvest)*

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ABSTRACT

This study aims to (1) find out the types of defects caused in the seaming process (2) identify the factors that cause defects in the seaming process, (3) provide repair solutions to minimize the occurrence of seaming defects in seaming. The method used is Seven Tools, Cp Cpk and Failure Mode Effect Analysis (FMEA). The result is that there are 3 types of defects, namely false seam with the highest defect of 1128 cans on seamer 5, sharp seam with the highest defect of 671 cans on seamer 9 and drop vee with the highest defect of 494 cans on seamer 5, which is caused by seaming roll trouble and roll settings not quite right , Minimizing solutions by changing spare parts for machines that often have trouble, checking the cleanliness of the machine at the start of each production, before taking a break, changing products, and before changing shifts, evaluating the knowledge of technicians and machine operators every 3 months, and trial first when changing suppliers and given the provision of machine settings.

Key words : Seamer Machine, Defect, *Seven Tools, Cp Cpk* and *Failure Mode Effect Analisys*.