

PENERAPAN PENGENDALIAN MUTU (*QUALITY CONTROL*) PADA BIJI KAKAO KERING (Studi Di PTPN XII Jatirono, Kalibaru). *Aplication Of Quality Control On Dry Cocoa Beens(Study In PTPN XII, Jatirono-Kalibaru)*

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ABSTRACT

The cacao bean is one of export product, so the product must be really in good condition, according to the existing standards. The research method using 3-sigma with analysis tool control chart, pareto diagram, Ishikawa diagram, and process capability. Implementation of quality control adapted to SNI. Test results of water content, content of seeds broke, impurity content (seeds attached) based on control chart X-bar and R, that there is no point of being out of control limit, so the process is under the control of Statistical, but on the criterion of seeds per 100 grams contained point out of the control limit, so the process is not in statistical control. Process capability can be calculated if the process in statistical control. Value of process capability criteria water content (1,3746) mean high process capability value and criterion levels of broken grain (0,503), impurity content (0,5747) indicates the value of process capability is low, so need improvement process to improve its performance. Based on the Pareto diagram is the biggest mismatch criteria beans per 100 grams identified the cause by ishikawa diagram based on human factors, materials, machines, and methods.

Keywords: *Cause Diagram, Control Chart, Pareto Diagram, Process Capability, Quality Control*