

*Quality Control of Analysis Cigar Wrapper Raw Materials  
Using the Failure Mode and Effect Analysis (FMEA) Method  
(Case Study at CV Dwipa Nusantara Tobacco, Jember)  
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**ABSTRACT**

*CV Dwipa Nusantara Tobacco Jember is a company engaged in cigar tobacco processing and relies heavily on the consistency of raw material quality sourced from local suppliers and tobacco warehouses. In its production process, several quality issues are still encountered, such as torn and perforated leaves, uneven color, and damage caused by thrips infestation, which may reduce product quality. This study aims to analyze the quality control of wrapper tobacco raw materials and to identify the factors causing quality deterioration. The method used is a descriptive quantitative approach. The analytical techniques applied include Failure Mode and Effect Analysis (FMEA) to determine risk priority levels based on the Risk Priority Number (RPN), as well as Fault Tree Analysis (FTA) and the Ishikawa Diagram to identify the root causes of failures. The results show that there are three main types of failures, namely torn and perforated leaves, uneven color, and damage due to thrips, with a total RPN value of 400.9 and a critical RPN value of 44.54 as the threshold for prioritizing corrective actions. High-risk failures are influenced by human, method, material, environmental, and handling system factors, indicating the need for improvements in quality control, handling processes, and pest control to maintain the consistency of wrapper tobacco quality.*

**Keywords:** *Failure Mode and Effect Analysis (FMEA), Fault Tree Analysis (FTA), Ishikawa Diagram, quality control, wrapper tobacco.*