

Praktik kerja di PT. SOHO indsutri pharmasi periode 5 September - 28 Oktober 2022, identifikasi potensi improvement yield bahan kemas pada produksi liquid = Internship at PT. SOHO industri pharmasi September 5th - October 28th 2022 period, potential improvement identification of packaging material yield in liquid production

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Abstrak

Database reject rate packaging material liquid PT. SOHO Industri Pharmasi periode Januari – Oktober 2022, reject tertinggi sebesar 6,23% dengan defect yang ditemukan paling banyak pada bahan kemas cap dan box produk. Persentase yield penting dalam produksi farmasi untuk mengurangi kerugian dari proses. Tujuan identifikasi potensi improvement yield bahan kemas pada produksi liquid adalah verifikasi yield bahan kemas primer dan sekunder, identifikasi masalah terkait reject, identifikasi dan implementasi improvement yield. Data yang digunakan bersifat kuantitatif dengan sumber data primer. Penelitian ini bersifat observasional. Pengamatan dilakukan selama minimal setengah ukuran batch. Data yang dikumpulkan berupa reject box dan cap, kemungkinan penyebab reject, frekuensi terjadinya reject, besaran output, dan sisa baik. Berdasarkan kelompok kemungkinan penyebab yang terjadi akan dibuat fishbone diagram untuk analisis faktor penyebab terkait dan analisis potensi improvement. Tidak ditemukan sisa baik cap dan box selama pengamatan. Reject cap terbanyak yaitu cap miring pada CJ 2 dan cap penyok pada CJ 3, sedangkan reject box terbanyak yaitu carton side flap robek. Investigasi masalah yang ditemukan terkait cap pada mesin CJ 2 yaitu posisi pemberat, bottle holder, dan setting mesin. Sedangkan pada mesin CJ 3 yaitu botol jatuh dan menyangkut sehingga cap penyok. Investigasi masalah yang ditemukan terkait box yaitu perbedaan karakteristik reject box, box dari supplier berbeda warna, perbedaan setting mesin dan jenis mesin cartoning. Perbaikan yang dilakukan terkait cap pada mesin CJ 2 yaitu mengubah posisi pemberat cap berada disamping, mengencangkan baut pada bottle holder, dan rekomendasi settingan. Sedangkan pada mesin CJ 3 yaitu mengubah posisi pisau pendorong, membuat tumpul mulut starwheel. Perbaikan yang dilakukan terkait box yaitu standardisasi bahan kemas dan penyusunan buku panduan cartoning.

..... Database of liquid packaging material reject rate PT. SOHO Industri Pharmasi for period January – October 2022, the highest reject was 6.23% with the most defects found in the packaging material for caps and boxes. Yield percentage is important in pharmaceutical production to reduce process losses. The purpose of identifying potential improvement yields for packaging materials in liquid production is to verify the yields of primary and secondary packaging materials, identify problems related to rejects, identify and implement improved yields. The data used is quantitative with primary data sources. This research is observational. Observations were made for at least half the batch size. The data collected is in form of reject boxes and caps, possible causes of rejets, frequency of rejects occurrence, amount of output, and remaining good. Based on the grop of possible causes that occur, fishbone diagrams will be made for analysis of related casual factors and analysis of potential improvements. No remains of both cap and box were found during the observation. The most reject cap were slanted cap on CJ 2 and dented cap on CJ 3, while the most reject boxes were torn carton side flaps. Investigation of problems found related to the cap on the CJ 2 were the position of the ballast, bottle holder, and machine settings. Whereas on the CJ 3, the bottle fell and got

stuck so that cap was dented. Investigation of problems found related to boxes were differences in reject boxes characteristics, different colors boxes from suppliers, differences in machine settings and types of cartoning machines. Improvements made regarding the cap on CJ 2 were changing the cap weight position to the side, tightening the bolts on the bottle holder, and recommending settings. Whereas on CJ 3 were changing the pusher blade position, blunts the mouth of starwheel. Improvements made regarding boxes are standardization of packaging materials and preparation of cartoning guidebooks.