REDUCING DEFECT ON BOTTLING PROCESS OF MESRAN SUPER SAE 20W/50 USING SEVEN-STEP METHOD
(Case Study In PT PERTAMINA Lubricating Unit Of Cilacap)

THESIS
Submitted as Partial Fulfill of the Requirements to Obtain the Bachelor of International Industrial Engineering Degree

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INTERNATIONAL INDUSTRIAL ENGINEERING PROGRAM
FACULTY OF INDUSTRIAL TECHNOLOGY
UNIVERSITAS ATMA JAYA YOGYAKARTA
YOGYAKARTA
2009
A BACHELOR OF
INTERNATIONAL INDUSTRIAL ENGINEERING THESIS
On
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DEDICATION

Dedicated to:

My God
Always Blessed me and give me Power every time

My family in Cilacap
Beloved Mother, Beloved Father, and My Sister
Always Support and Prayer me

My Lovely Sweetheart "Fifi"
Thanks for leaving me when I really need your support
you broke my heart
you always make me sad
but I will love you forever and ever

My Best Teacher Mr. Hadi Santono, S.T., M.T.
And Mrs. M. Chandra Dewi, S.T., M.T.
Always give me direction and advice in Final Task

And all of my friend . . . .
Always give me time to play everything,
FOREWORD

This final report is one of the prerequisite to finish the undergraduate study program in Industrial Engineering Department, Industrial Technology Faculty, Atmajaya Yogyakarta University.

I am so grateful to many people who encouraged, and help me to finish this final report. On this opportunity, I would like to thank:

1. God Almighty, for His blessing and guidance.
2. Mr. Paulus Mudjihartono, S.T., M.T., as the Dean of Industrial Technology Faculty, Atmajaya Yogyakarta University.
3. Mr. Parama Kartika Dewa SP, S.T., M.T., as the Head of Industrial Engineering Department, Industrial Technology Faculty, Atmajaya Yogyakarta University.
4. Mr. Hadi Santono, S.T., M.T., as the Head of International Class of Industrial Engineering, with those never ending break through.
5. Mr. Hadi Santono, S.T., M.T., as first adviser, who had spent plenty of time to give guidance, direction, inputs and correction in writing this final report.
6. Mrs. M. Chandra Dewi, S.T., M.T., as first adviser, who had inputs and correction in writing this final report.
7. Mr. Oscar, Mr. Catur, Mr. Ari, ans Mr. Ambulan Sukarno as field adviser thank you for the input, the idea, and warm welcome.
8. Mr. Sakri Sunarso and his big family who changes me in the way of life.
9. My parents, thanks for supporting my life. Dad, your junior now ready to take over you. Mom, you’ll proud of me.

10. My sister who always support me. Thanks for everything.

11. Mun-mun thanks for the support and advice, ninis a.k.a fierce doctor, iche for your program, and all my friends in 45 white dragon squad.

12. My friends TIKI Batch 2004, finally, we’re in the same level. Thank you.

13. All those who haven’t mentioned, thank you.

I realize that this final report has not perfect but I hope that this final report can be useful and can be developed in a further research.

Yogyakarta, December 2009
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PT PERTAMINA (PERSERO) Lubricating Unit of Cilacap produces almost the PERTAMINA’s lubricant. The products cover the requirement of customer need from automotive and industrial. The main process is filling lubricating oil to the bottle and it process is in Lithos Department. By the observation the writer identify the defects, they are test induction sealer, no aluminum foil, un sticky aluminum foil, damaged cap, bottle & cap not equal, oblique cap, broken bridge cap, and empty bottle & micro hole. Because of product competitions, the defects become the company concern.

This research use Seven-Step Method based to reduce the defects. The improvement suggestion covers man, material, inventory, and material inspection.

By the end of research, the most significant defect product of lubricant in PT PERTAMINA (PERSERO) Lubricating Unit of Cilacap is no aluminum foil nonconformity and oblique cap nonconformity. The sources or factors that cause the defect are materials and man. The implementation conducted in August, 2009 and the result is decreasing the nonconformities of defect product.