

## Chapter 6

### CONCLUSION AND RECOMMENDATION

#### 6.1. Conclusion

1. The most significant defect product of lubricant in PT PERTAMINA (PERSERO) Lubricating Unit of Cilacap is no aluminum foil nonconformity and oblique cap nonconformity.
2. The sources or factors that cause the defect are responsibility of supplier in material's problem and default setting machine on man's problem. The problem for oblique cap is no operator of man's problem.
3. The implementation conducted in August, 2009 and the result is decreasing the nonconformities of defect product 0.886% from 0.967% become 0.101%.
  - a. The improvement suggestion of material problem is send a memo to the supplier for increasing their product quality.
  - b. The improvement suggestion of man problem is the default machine setting cannot be fixed but if the material problem can be solution so it will be the solution of man problem also.
  - c. The improvement suggestion of material problem for oblique cap is company has to indeed while inspect the purchasing material. And for the oblique cap problem is add or place 2 operators in capping machine

## **6.2. Recommendation**

The suggestions are reduce the nonconformity percentage as the production impact of "Broken Bridge Cap nonconformity" in the future and make a supplier rating and selection.



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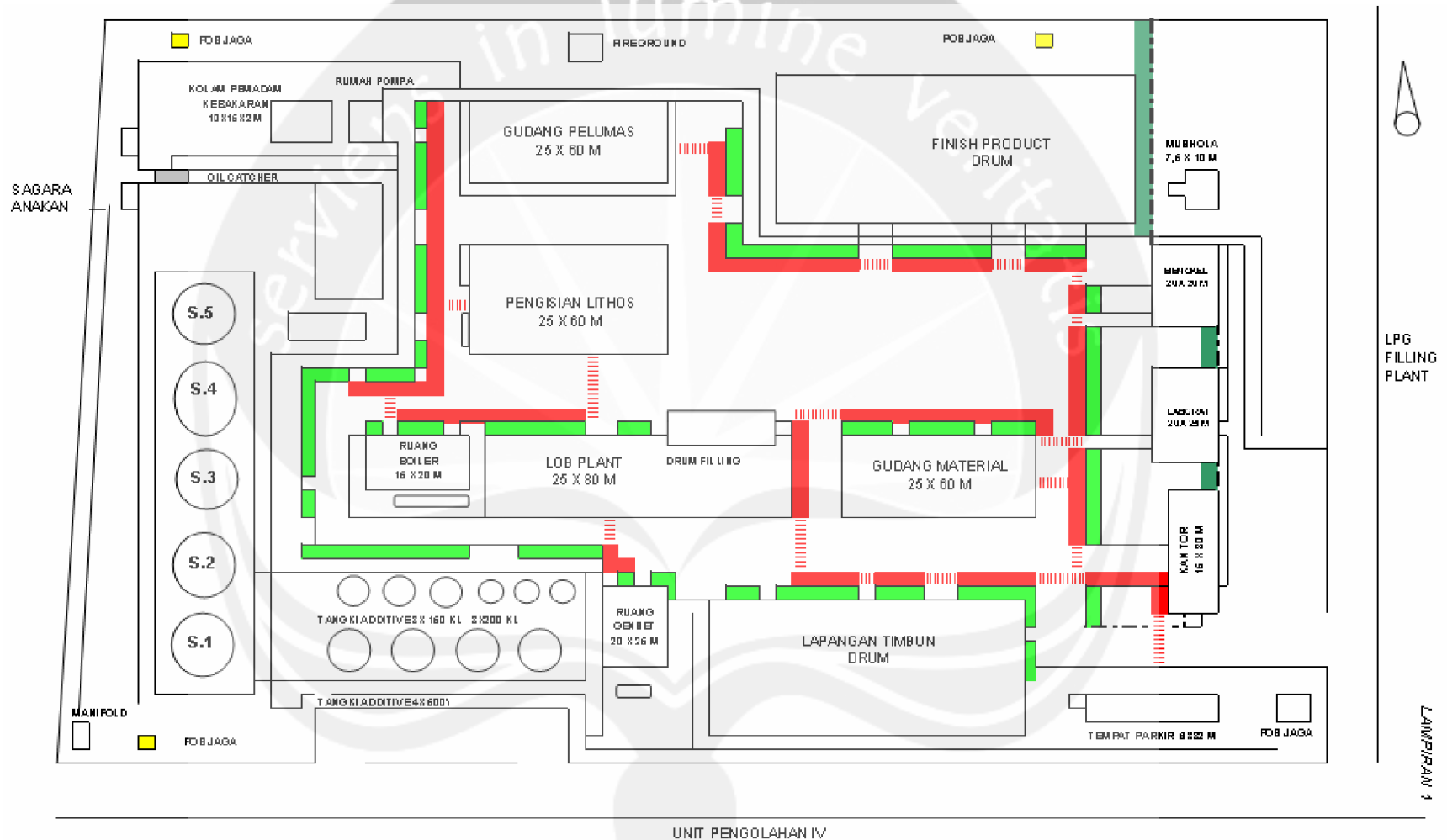
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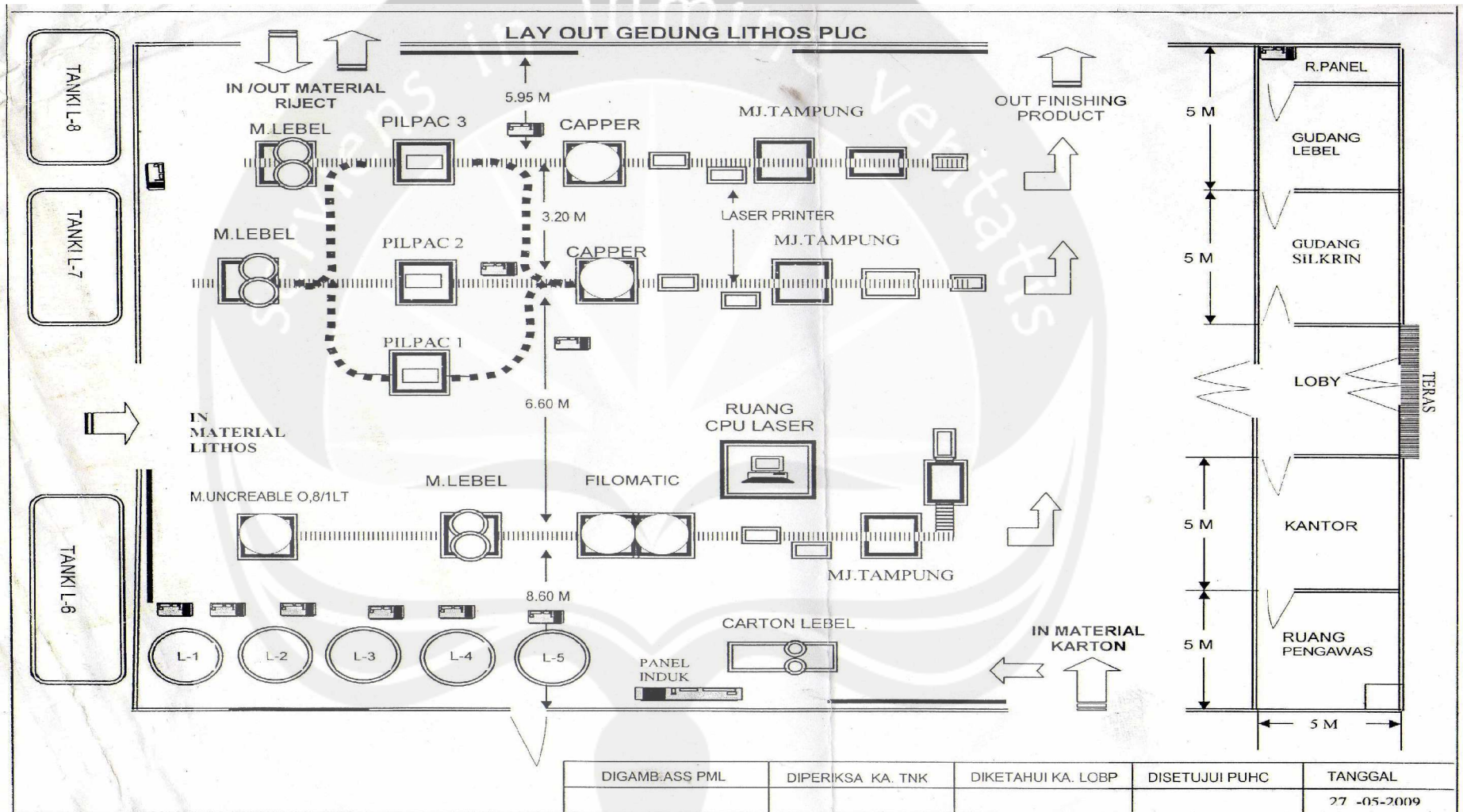
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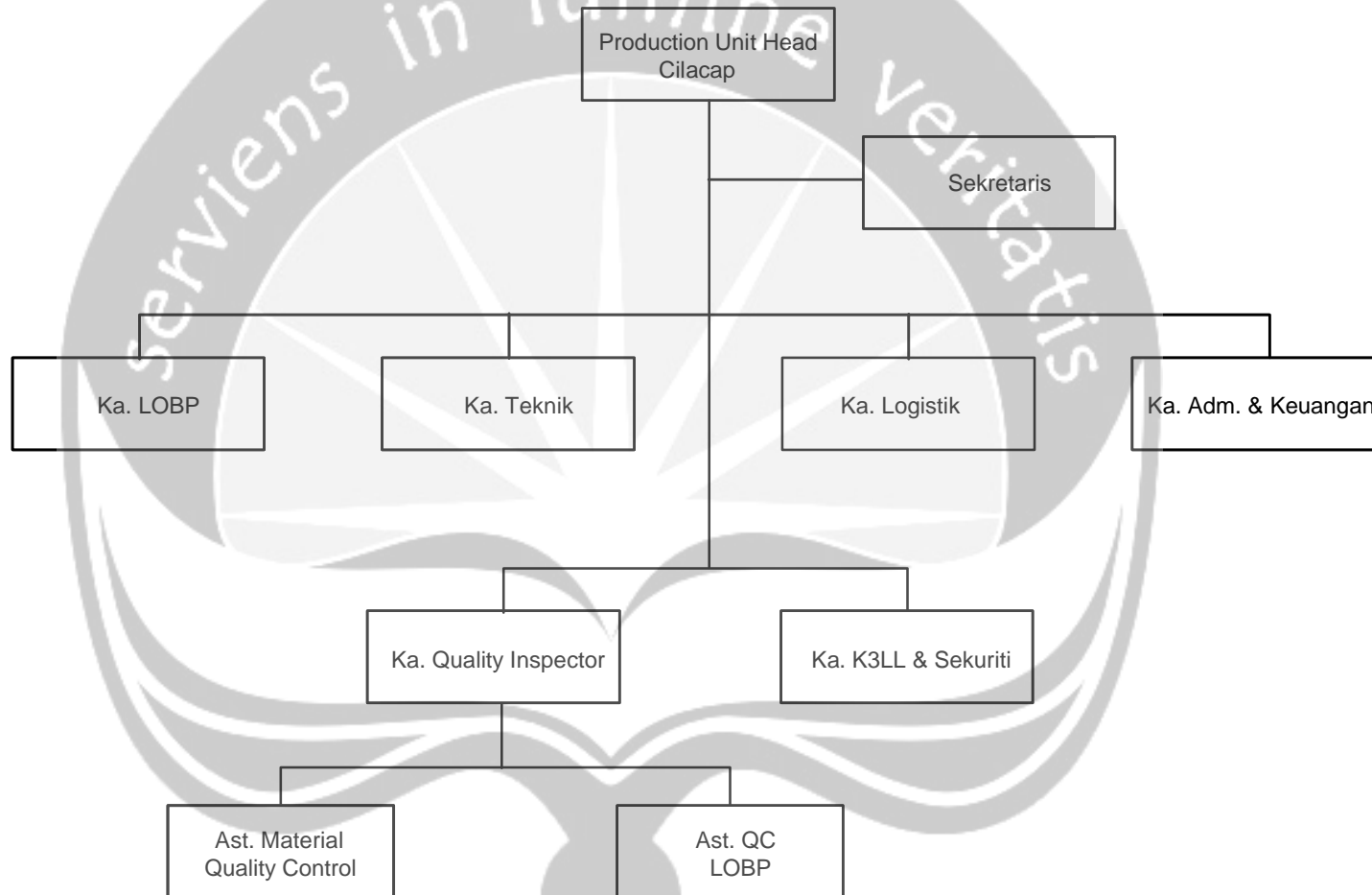
Appendix 1. Layout of PT PERTAMINA (PERSERO) Lubricating Unit Cilacap



## Appendix 2. Layout of Lithos Department



Appendix 3. Organization Structure in PT PERTAMINA (PERSERO) Lubricating Unit Cilacap



# Appendix 4. Check List in Lithos Department

CHECK LIST RUSAK TUTUP PENGISIAN LITHOS																														
TANGGAL	JENIS PRODUK				NO. BATCH FILL				UK. KEMASAN				HOLDING TANK				MESIN													
09-09-09	MECRAN SUPER				01044 094				90 x 1				03				PILOMATIC													
Kode Pemasok →																														
	07.00 - 08.00	08.01 - 09.00	09.01 - 10.00	10.01 - 11.00	11.01 - 12.00	12.01 - 13.00	13.01 - 14.00	14.01 - 15.00	15.01 - 16.00	16.01 - 17.00	17.01 - 18.00	18.01 - 19.00	19.01 - 20.00	20.01 - 21.00	21.01 - 22.00	22.01 - 23.00	23.01 - 24.00	24.01 - 01.00	01.01 - 02.00	02.01 - 03.00	03.01 - 04.00	04.01 - 05.00	05.01 - 06.00	06.01 - 07.00	PT SANLIT IP	PT BUMIMULIA	PT ABADI P	PT DYNAPLAST	PT PRIMA K	
Tes Induction Sealer											2	1	1	1	1	1	1								6	2				8
Tidak ada aluminium foil											3	7	3	6	3	7	2								28	3				3
Al foil tidak melekat																														
Tutup dol																														
Tutup & botol tidak sesuai																														
Tutup miring											6	8	5	7	5	9	3							37	6				4	
Brige -- Cap patah												5	2	7	3	8	1							27					27	
Btl kosong & Mata ikan												2	1	1	1	2								7					7	
Jumlah Prod (doos)											128	229	229	229	192	229	101													13
ngan :																														
an Perbaikan Yang Dilakukan :																														
Jam	Ketidaksesuaian										Tindakan Perbaikan										Hasil									
SL : SANLIT IP, -BM : BUMIMULIA IL, -DP : DYNAPLAST Tbk, -PK : PRIMA KALPAS, -AB : ABADI																				Ass. Quality Control				Ka. Quality Inspector						



## Appendix 5. Recommendation Memo to Supplier

### IMPROVEMENT MEMO

Number : 21/ Plastic / MQC / VI/ 2009



PACK TYPE : Plastic DB TO : PT SANLIT IP  
 TYPE : 1Litre Red DATE : 02.06.2009  
 DOCUMENT PASS NUMBER : 0841 CALL NUMBER : 313/F10415/2009-S7

NO.	RECOMMENDATION	JOB DESCRIPTION
1	CAP AND ALUMINUM FOIL NOT STICK (FILLOMATIC MACHINE)	1. IMPROVE THE QUALITY OF PRODUCT
<b>PROPOSED BY</b> Observer  <u>RIZKY DESTAMA PUTRA</u>		<b>ADVISOR</b> Ka. Quality Inspector  <u>FX AMBULAN SUKARNO</u>
<b>APPROVAL</b> PUH Cilacap  <u>AGUS ASMAWANTO</u>		



## Appendix 6. Recommendation Memo to Lithos Department

### **IMPROVEMENT MEMO**



Number : 27/ Plastic / MQC / VII/ 2009

PACK TYPE : Plastic DB  
TYPE : MESRAN 20W/50 , 1 Litre

TO : Head of Lithos Dept.  
DATE : 09.06.2009

NO.	RECOMMENDATION	JOB DESCRIPTION
1	ADD 2 OPERATOR IN CAPPING MACHINE (FILLOMATIC MACHINE)	OP 1. TAKE AND PUT THE PRODUCT OP 2. FIXED THE PRODUCT
<b>PROPOSED BY</b> Observer  <b><u>RIZKY DESTAMA PUTRA</u></b>		<b>ADVISOR</b> Ka. Quality Inspector  <b><u>FX AMBULAN SUKARNO</u></b>
<b>APPROVAL</b> PUH Cilacap  <b><u>AGUS ASMAWANTO</u></b>		

## Appendix 6. Official Statements



Cilacap, 30 Juni 2009  
No. 202 / F10415/2009-S8

Lampiran : -  
Perihal : **Pelaksanaan Kerja Praktek**

Kepada Yth :  
**Dekan  
Fakultas Teknologi Industri  
Universitas Atma Jaya Yogyakarta  
Jl. Babarsari No. 43  
Yogyakarta**

Sesuai dengan Surat dari Kami No. 0296/L102/2009-S8 tanggal 22 Mei 2009 perihal ijin kerja praktek untuk mahasiswa Universitas Atma Jaya Yogyakarta yang melaksanakan kerja praktek di PT. Pertamina ( Persero ) Production Unit Cilacap - Pelumas , dengan ini kami informasikan bahwa mahasiswa yang tercantum dibawah ini :

Nama : **Rizky Destama Putra**  
Nim : 4153  
Jurusan : Teknik Industri

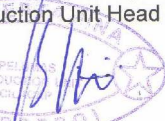
Telah selesai melaksanakan kerja praktek di PT. Pertamina ( Persero ) Production Unit Cilacap - Pelumas terhitung mulai tanggal 01 s/d 30 Juni 2009.

Selama melaksanakan kerja praktek di PT. Pertamina ( Persero ) Production Unit Cilacap - Pelumas, mahasiswa tersebut menjalankannya dengan baik, sesuai dengan prosedur / aturan yang berlaku.

Semoga pengetahuan yang didapat selama melaksanakan kerja praktek dapat bermanfaat serta menambah pengetahuan / wawasan baru khususnya untuk jurusan Teknik Industri.

Demikian kami sampaikan, atas perhatiannya diucapkan terima kasih.

PT. PERTAMINA (Persero)  
Production Unit Head Cilacap

  
**Agus Asmawanto**

 St/Is

Production Unit Cilacap - Pelumas