ABSTRACT

*PT Hidup Djaya* is a business engaged in the manufacture of plastic rope, plastic rope with the results of a variety of sizes, namely 50 gr, 350 gr and 1 kg. Raw materials used for plastic strap that is Polytam PF -1000 because it is not easily broken, lint-free, easy and powerful plaited. In the production process often yield poor or defective product defective product average is 3.6% / day defective products such as flexible strap, rope brittle easily broken, therefore it is necessary to Quality Control Circles (QCC) to improve the quality of the product. Existing problems solved by the p-control chart, Pareto diagrams, and the probability of a causal diagram. Pareto diagrams are used, so that the known number of defects and the components that generate the biggest flaw. 79.1400% of the data is known contributor to disability is the size of 50 g, 1.5473% disability is the size of 350 g, and the remaining 19.3125% defect of raffia 1kg size. For the probability of the emergence of the type of defect that is 50.54% flexible strap, rope emergence of a brittle type of defect that is 49.45%. So the discussion is done for plastic strap size 50gr and 1 kg of high yang flawed. Based on a causal diagram to find the root cause of the problem is the machine, method, material, human. So that the implementation phase is done on the type of disability because it is more flexible rope straps dominating than brittle. Next made suggestions for improvement and implementation done. After the implementation of the proposal obtained by the percentage of defect repair plastic strap 50 gr of 2.9% the previous 4.5% and the percentage of defective plastic strap 1 kg of 2.9% the previous 3.7%. Thus QCC activities successfully solve problems that occur in the process of plastic rope.

**Keywords**: Quality Control, QCC, Plastic Ropes