

ABSTRACT

YTN domestic industry is an industry that is engaged in the manufacture of propeller. In the production process propeller, industry YTN common household product defects, it must be re-smelting. Re smelting lead to loss of production costs. The cost of re-melting losses of Rp .54.567.000. And after implementation costs due to repeated melting of Rp. 50.444.160, thus saving the cost is Rp. 4.12284 million or 7.6% of the cost before implementation. This study uses six sigma DMAIC (define, measure, analyze, improve, and control). Value defects per opportunity (DPO) before implementation is 0.0391679 and value defects per million opportunity (DPMO) is 39 168 with a 3.26 sigma value. After the implementation of the DPO value is 0.03600173 and DPMO value is 36 002 with a value of 3.3 sigma.

Keywords: quality control, six sigma, and cost savings.