

c. Blur Print Results

In this type of disability, four factors affect it: the method, human, material, and machine factors. Figure 5 shows fault tree defects resulting from print blur.

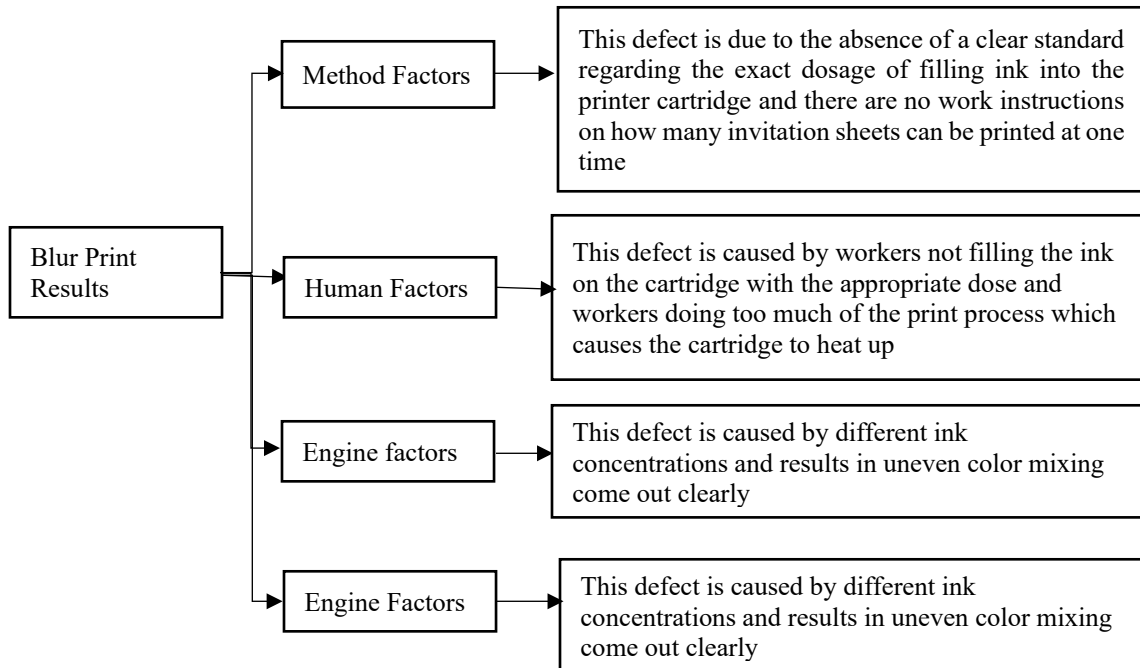


Figure 5 Fault Tree Defect Prin blur Results

4. Improve

Recommendations for proposed improvements from three types of defects that occur in invitation products are carried out using the 5W +1H method to determine the improvements that can be made to defects that arise in CV XYZ. The following is a 5W+1H analysis of three types of defects in invitation products. (Tables 6- 8)

Table 6 for 5W+1H Improvement of Untidy Screenprinting Defects

Factor	What	Where	When	Why	Who	How
Human	Lack of Focus	Screen printing process	When workers make a swipe gesture	Smoking while doing work	Bag workers. production	Applying rules if you're doing work shouldn't be while doing anything else, like smoke.
Method	The friction technique is not constant	Screen swiping process	At the moment when Rake shifts screen printing ink	Workers do not lift non-existent constant	Bag workers. production	Set the swipe technique one time towards the bottom and two times towards the top.
	The ink is too watery	Screen printing ink ran mixing	During the mixing process n screen printing ink	Thinner gave too much		The mixing process of screenprinting ink and thinner is carried out in a ratio

Material		process	with Thinner		Bag workers. worker	of 1: 1
	The afdruk process is less than perfect	The process of mixing ran the drug afdruk	At the time of the mixing process n sensitizers and emulsions	The dose of the sensitizer and emulsion does not fit		The process of mixing afdruk drugs, that is, sensitizers and emulsions, is carried out in a ratio of 1: 1

Table 7 for 5W+1H Repair of Untidy Fold Defects

Factor	What	Where	When	Why	Who	How
Human	Lack of Focus	The process of folding invitation blank	At the time, the worker folds the invitation blank into two parts	Smoking and chatting too much while doing work	Bag workers. Production and bag. Designer	Applying rules if you are doing work should not be while doing other things, such as smoking and focusing too much on chatting
Milieu	Lack of lighting	In the work environment	At the time, the worker folds the invitation blank into two parts	The work environment is not bright enough so that the reference line on the invitation letter is not visible clear	Bag workers. Production and bag. Designer	Checking the lights and replacing the lights in the work environment

Table 8 for 5W+1H Rectification of Blurred Print Defects

Factor	What	Where	When	Why	Who	How
Human	Too many print invitations	Invitation print process	When workers carry out the print process	Cartridge getting hot	Bag workers. Designer	Provide work instructions on how many invitation sheets should be printed in one time
	The volume of ink is not filled according to the dose	Ink refilling process	At the time, the worker refills the ink on Cartridge	Does not fill the ink with the right dose		Provides clear standards and instructions on ink fill dosing

Machine	Cartridge hot	Invitation print process	When workers carry out the print process	Cartridge fatigue due to too many print invitations at one time	Bag workers. Designer	It gives a pause every 10 minute after printing the invitation for as many as 100 sheets
	The ink has not been mixed well			The volume of ink that is still too concentrated and the volume of ink which is lacking		Filling the ink on the cartridge after printing the invitation as much as 200 sheets
Material	Ink concentration	Invitation print process	When workers carry out the print process	Too many print invitations	Bag workers. Designer	Refilling the ink on the cartridge with the right dose

6. Conclusion

The types of *defects* that most often occur during the invitation creation process are as follows:

Untidy Invitation Folds: The position of the invitation folds is not precise with the existing reference lines on the invitation paper stamps, resulting in the invitation being tilted.

Untidy Screen printing Results: The spilled ink print on the invitation letter makes the printed writing blurred and shaded, so the paper is not visible.

Blurred Print Ink: The lack of thickness of the print on the invitation letter causes the writing to become blurred and striped so that the report is not visible.

The level of process capability based on DPMO and Sigma values shows that the average sigma value is 3.95, with possible damage of 7,612,321 products for every one million productions, where the sigma level achieved is still far from the desired target of 6 sigma and 3.4 DPMO.

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Biographies

Nazaruddin is an assistant professor Industrial Engineering Department at Industrial Engineering Department, Faculty of Science and Technology, Sultan Syarif Kasim State Islamic University Riau, Indonesia

Fitra Lestari is an Associate Professor and Head of the Industrial Engineering Department at Sultan Syarif Kasim State Islamic University, Indonesia. He finished his PhD project with major area in Supply Chain Management at Universiti Teknologi Malaysia. He is currently a member of IEOM and has published a number of articles in international journals about Supply Chain Management, Logistics and Performance Measurement.

Muhammad Rizki is an assistant professor Of Industrial Engineering Department at Industrial Engineering Department, Faculty of Science and Technology, Sultan Syarif Kasim Riau State Islamic University, Indonesia

Muhammad Isnaini Hadiyul Umam is an assistant professor of Industrial Engineering Department at Industrial Engineering Department, Faculty of Science and Technology, Sultan Syarif Kasim State Islamic University Riau, Indonesia

Muhammad Luthfi Hamzah is an assistant professor Information System Department at Information System Department, Faculty of Science and Technology, Sultan Syarif Kasim State Islamic University Riau, Indonesia