ABSTRACT

Micro, Small, and Medium Enterprises (MSME) are types of businesses owned and managed by individuals or groups on a small to medium scale. Roti Anisa is an MSME engaged in the food industry, especially bread production. The standard tolerance for defects is set at 5 pieces per bale for one bale containing 800 pieces of bread. However, in reality, the number of defective products exceeds the established tolerance standard and defective products are not repaired. If defects occur continuously and in large quantities, they can certainly cause losses. The solution is to conduct research using the Statistical Quality Control (SQC) method to analyze the factors causing defects and Failure Mode and Effect Analysis (FMEA) to identify and evaluate potential failures that occur so that they can provide suggestions for improvement. The results of this study are that of the three types of defects that occur, deflated and machine-cut defects are the highest types of defects that must be repaired immediately. The main factor causing this defect is due to the method factor caused by worker errors when placing the bread in the horizontal flow pack machine. Proposed improvements that can be made are to apply SOP and implement a manual andon system.

Keywords: *bread, defect, FMEA, quality, SQC*