

ANALYSIS THE IMPLEMENTATION OF GOOD MANUFACTURING PRACTICE (GMP) IN THE JAMPI SARAS COMMUNITY WARENG WONOSARI VILLAGE, GUNUNG KIDUL, YOGYAKARTA

Ernasari ^{1*}, Author ²,

(TNR 12, Centered & Bold, Full name, corresponding author marked with “**”))

¹Affiliations' name and address,Indonesia, postal code

²Affiliations' name and address, country, postal code

³ Affiliations' name and address, country, postal code

* E-mail: ernasari1900070031@webmail.uad.ac.id

ABSTRACT

Background The Jampi Saras Community produces various kinds of instant herbal medicine. Instant herbal medicine products are expected to have a guaranteed quality management system so that they are safe for consumers in order to meet beverage quality needs by implementing Good Manufacturing Practices. This research aims to determine the ability of the Jampi Saras Community to implement GMP. **Methodology:**This research applies a qualitative approach using descriptive qualitative type data. Data collection was carried out through interviews, observation and documentation methods.The results obtained from this research are that the first aspect which is assessed as the environment or location has met the requirements, the building has the results of not meeting the GMP requirements, the sanitation facilities aspect has the results of meeting the GMP requirements, the production machinery and equipment has the category of meeting the requirements, the maintenance and sanitation program has the category have not met the requirements, employees get a category that meets standards and the production process gets a category that meets GMP requirements Overall, **Conclusion:**. The results of this research show that the Jampi Saras Community received a good quality category. Of the seven aspects that were categorized as sufficient to meet the requirements, they include production process, employees, production machines or equipment, business location. To improve product quality, Jampi Saras needs to attend seminars related to GMP and carry out improvement programs in aspects of maintenance and sanitation programs, improving building facilities in stages so that they can meet good GMP standards.

Keywords: Good Manufacturing Practice, Herbal and Drink quality

INTRODUCTION

Food and Drink are main human needs that cannot be separated from human existence. Industries that engaged in the food sector are required to improve a good quality management system in order to create products that are safe for consumers. The production process is an important part of ensuring good and safe product results. Food safety also affects competitiveness in product marketing (Hapsari and Kurniawanti 2022).

There are many kind of beverage products that available in Indonesia, one of them is herbal medicine also known as *Jamu*. *Jamu* product is one of traditional products that easy to find on the market. The materials used to make *jamu* have to be presented from natural and fresh ingredient, so it need to be kept hygienic and safe in order to produce high quality of *jamu* products. Herbal medicine products with good quality and safety for consumption by every age will support producer to compete in national and

international markets. The challenge of product competition in the market encourages business actors to improve quality by applying the GMP method (Rina Fitriana, 2020). Beverage products are widely distributed in Indonesia, which is signature traditional herbal medicine.

Good Manufacturing Practice (GMP) is a guideline in providing directions to ensure products are processed properly in order to ensure product quality properly and safely. The *Jampi Saras Community* is a joint business group in the village of Wareng. The community produces instant herbal medicine which has many benefits for the body's health. The application of GMP is important in the process of herbal medicine to improve instant herbal medicine products into superior competitive products in the city of Yogyakarta. The Jampi Saras Community carry out the process of making instant herbal medicine that meets the requirements according to GMP standards so that instant herbal medicine products are safe for consumption (*Warkoyo, Damat, and Winarsih 2019*).

MATERIALS AND METHODS

The research method used in this research is qualitative research, which is a research method that analyzes more phenomena that occurred. Qualitative research with a descriptive approach used by researcher's acts as the main tool that creates, analyzes, studies, and interprets data in a triangulation (combined) way from multiple data sources. Qualitative research with a descriptive approach, aims to examine the information material obtained by describing or presenting factual data, and draws related conclusions (Galang 2016)

Standar of CCOB permen number.75 of 2010 Observation (Observation) is a method of collecting data by using the senses not only the eyes but also listening, smelling, tasting, touching, including one form of observation. Observations that will be carried out focus on observing facilities, equipment, locations and product loading processes as well as sanitation employee hygiene (Bambang Suhardi, Maria Kadita 2018).

Presentation of data in research is carried out by displaying data from the results of researchers using standard assessment data requirements tables, information and

observations on research objects in the standards for implementing GMP that have been obtained and then explained with narratives that are easy for readers to understand. (Anhar 2016)

The assessment that will be carried out by researchers is on the aspects of GMP standards as follows

1. Processing Suggestion Environment
The processing facility environment is a location that must be far from polluted environments, free from bushes or pest nesting areas, and open spaces must not be used for processing and production sites must be clean. (Rina Fitriana 2020)(Bambang Suhardi and Riska dkk 2020)
2. Buildings and Facilities
Buildings and facilities are solid and strong buildings. While the facilities that must be are toilets, hand washing facilities and adequate equipment such as easy to wash and durable.(Desi Listianingsih 2018)
3. Equipment and Sanitation Activities
Equipment and sanitation activities are equipment that must be safe, easy to clean and durable and according to its function. Sanitation activities in equipment is to maintain food safety from bacteria. (Surya, Rosiawan, and Hadiyat 2013)
4. Sanitary facilities and activities
Sanitary facilities and activities are facilities that are owned must remain clean and durable because facilities such as toilets, hand washing and maker facilities as well as gloves to maintain food safety.(Agustin 2020)
5. Pest Control System
A pest control system is a way to ensure the protection of tools, equipment and the environment to keep it safe from insects.(Rudiyanto 2016)
6. Employee Health and Hygiene
employee Health and Hygiene is employee personal hygiene, implementation of sanitation and hygiene and protection of employees when they are sick so they do not come to work(Ristyanadi and Hidayati 2012)
7. Production process
The production process is the initial process of entering materials, selecting

materials, cleaning materials, cooking materials, material production processes, and product packaging and product labeling. (Hapsari and Kurniawanti 2022)

Table 1. Level of assessment

No	Assment	Information
1.	must	Requirements that indicate if not met will affect the product directly
2.	should	quirements that indicate if they are not met have the potential to impact product safety
3.	can	Persyaratan yang mengindikasi apabila tidak dipenuhi mempunyai yang kurang berpengaruh terhadap keamanan produk

Sumber : Permen no.75 tahun 2010

The table above is used for the assessment of the Jampi Saras community in implementing GMP which has been carried out with predetermined aspects.

RESULTS AND DISCUSSION

Observation and data collection carried out by researchers is by means of observation and method of scoring, which method is a standard assessment of GMP

Table 2. Reseachr Result

NO	Aspects of <i>Good Manufacturing Practices</i> (GMP)	Results	
		Fulfil	No
1.	Environment or location	✓	
2.	Building		✓
3.	Sanitation Facilities		✓
4.	Maintenance and sanitation program		✓
5.	Employee	✓	
6.	Machinery or Equipment	✓	
7.	Production process	✓	

Source: Primary Data, 2023

Based on the results of the GMP implementation assessment in the Jampi Saras community, instant herbal medicine production (*jamu*) received sufficient marks for food quality management.

Figure 1 Environment



Processing facility environment that meets GMP standards is a clean production environment, proper waste processing and not in a natural disaster area (Surya, 2013).

On the environmental aspect, the suggestion and processing of instant herbal medicine (*jamu*) gets an average which is categorized as sufficient because on the environmental aspect it is quite far from other industrial locations and is not easily inundated with water. The environment with roads that have been paved and drainage that runs smoothly. Buildings and Physical Facilities that are correct in meeting GMP standards are to have a building consisting of main rooms and complementary rooms. The contribution of the floor is strong and non-slip, the contribution of the walls is durable and easy to clean and non-absorbent. The contribution of the roof can protect the room from causing cane. The door contribution works well with plastic curtains. The window contribution is durable, 1m distance from the floor and ventilation can control the temperature. Adequate warehouse construction can provide

effective protection for food (Ristyanadi and Hidayati 2012).

In terms of physical facilities, the Jampi Saras community categorized as lacking because there are several facilities that do not suit the GMP standard requirements, such as roofs that do not use ceilings, window construction, warehouse construction, lighting and minimal ventilation in the instant herbal medicine business belonging to the Jampi Saras community.

Good Sanitary Equipment and Activities is equipment made of strong materials, safe and easily corroded and low maintenance. Tools are cleaned after use, separate the use of tools according to the type of material and wash hands before carrying out the production process (Rudiyanto 2016).

In terms of equipment, the instant herbal medicine (*jamu*) business does not have too many tools. There are only a few production equipment for making instant herbal medicine, such as a large face as filter basin, etc. Production equipment is safe to use for the production of instant herbs. The assessment of this aspect gets an average good score.

Sanitation Facilities and Activities are public places and food, hand washing and toilet facilities, equipment and supplies cleaning facilities. All existing facilities are cleaned and tidied up after use to maintain safety from dust and bacteria (Bambang Suhardi, Riska Permana Sari, and Pringgo Widyo Laksono 2020).

In the Aspect of Assessment of Sanitation Facilities and Activities in the community, a good standart permen no.75 of 2010 is obtained or categorized as sufficient for the standard of good manufacturing practice. The facilities for production activities in the Jampi Saras business are sufficient, such as having sufficient material suppliers, good business waste disposal advice, washing facilities for materials and tools also exist. There are also employee hygiene facilities such as bathrooms, hand washing stations and masks.

Figure 1 facilities



Pest Control System is control carried out by ensuring equipment and equipment is clean after use. Production room that free from insects. Separation of places for storing types of materials (Rina Fitriana 2020)

In the aspect of the community pest control system, it gets an average or is categorized as sufficient because two standard elements of pest control are enough to deter rats or insects to keep product safety in a safe condition.

Employee Health and Hygiene is to use special disposables when carrying out production to protect the product so that it remains safe. Maintaining health issue by giving time off, washing hands before and after carrying out the production process. Cleaning again after using the toilet in the worker's place (Agil Putra Bimantara and Triastuti 2018).

In the Health and Hygiene Aspects, instant herbal medicine business employees get a must meet the standards of candy no. 75 of 2010 or are categorized as sufficient by the standard of good manufacturing practice. Health and hygiene requirements have been carried out by instant herbal medicine businesses such as washing hands before and after product production. Sick employees are prohibited from coming to work.

The production process is carried out with the appropriate process from the beginning of the incoming material. Materials are cleaned, processed according to SOP (herbal medicine) and the product has been processed into the appropriate product (herbal medicine) (Hapsari and Kurniawanti 2022).

In the production aspect, this instant herbal medicine business gets an average of good standar no.75 of 2010 or is categorized as good because all the production process lines are in accordance with GMP standards. The flow of the production process is already good, such as from the beginning of receiving

materials, carrying out the washing of herbal raw materials. Then proceed with making herbal medicine by grating all the ingredients and then filtering then the filtered water is heated then mix the granulated sugar, stir to make it into instant herbal powder. After staying one night. The next day it can be packaged into bottles. Ready to be marketed. The Jampi Saras Community has carried out the production process well from receiving materials to packaging in accordance with the requirements of GMP.

Figure 3 production process



Figure 4 production proses



Figure 5 product jamu



Figure 6 product jamu



CONCLUSION

The Jampi Saras Community in the instant herbal medicine business shows that the readiness of the Jampi Saras community is sufficient to be able to implement good manufacturing practices (GMP) to maintain the food quality of instant herbal medicine products that are good for consumers. The GMP standards applied by the Jampi Saras community are quite compliant based on CPPOB Ministry of Industry Regulation no. 9 of 2010. The Jampi Saras Community implements GMP aspects in accordance with Ministry of Industry Regulation no. 9 of 2010, the scope used in the research is the environment or location, factory physical buildings, sanitation facilities, maintenance and sanitation programs, machinery and equipment, employees and production processes that are capable of implementing GMP. However, there are 2 aspects of GMP that do not meet GMP standards and need to be improved

ACKNOWLEDGEMENT

Thank you to the Jampi Saras Community, Wareng Village, Wonosari sub-district, Gunung Kidul Regency, for agreeing to become partners in this research.

REFERENCES

- Agil Putra Bimantara, and Rr. Juni Triastuti. 2018. "Penerapan Good Manufacturing Practices (GMP) Pada Pabrik Pembekuan Cumi-Cumi (Loligo Vulgaris) Di PT. Starfood Lamongan, Jawa Timur." *Journal of Marine and Coastal Science* 7(3): 111–19.
- Anhar, Adha Panca Wardanu dan Muh. 2016. "Penerapan Good Manufacturing Practice (GMP) Pada Kelompok Usaha Bersama (Kub) Wida Mantolo Kecamatan Benua Kayong." *Teknologi Pangan : Media Informasi dan Komunikasi Ilmiah Teknologi Pertanian* 7(1): 8–16.
- Bambang Suhardi, Maria Kadita, Pringgo Widyo Laksono. 2018. "Perbaikan Proses Produksi Dengan Standar Cara Produksi Pangan Yang Baik (CPPB) Dan Work Improvement in Small Enterprise

- (Wise) Pada Industri Kerupuk Sala.” *Jurnal Simetris*: 9(1): 579–86.
- Bambang Suhardi, Riska Permana Sari, and Pringgo Widyo Laksono. 2020. “Perbaikan Proses Produksi Pada IKM Tahu Sari Murni Mojosongo Menggunakan Metode Good Manufacturing Practice (GMP) Dan Work Improvement In Small Enterprise (WISE).” *Jurnal INTECH Teknik Industri Universitas Serang Raya* 6(1): 88–98.
- Desi Listianingsih, R.Azizah. 2018. “Analisis Kualitas Tahu Takwa Dengan Pendekatan Good Manufacturing Practices(GMP).” (May): 281–90.
- Fahma, Fakhrina, Wahid A Jauhari, and Pungky Nor Kusumawardhani. 2012. “Perancangan Standard Operating Procedures (SOP) Pengolahan Pasca Panen Rimpang Tanaman Obat Dan Identifikasi Good Manufacturing Practices (GMP) Di Klaster Biofarakan Karanganyar.” *Prosiding SNST Ke-3 Fakultas Teknik UWH, Semarang*: 6–11. <https://core.ac.uk/download/pdf/236431384.pdf>.
- Hapsari, Yaning Tri, and Kurniawanti. 2022. “Pendampingan Penerapan Good Manufacturing Practice (GMP) Pada Usaha Jamu.” *Jurnal Abdimas Madani dan Lestari (JAMALI)* 04(September): 96–105.
- Purnaningsih, Ninuk, Titi Mawasti, and Yudhistira Saraswati. 2017. “Analisis Kebutuhan Pendampingan Dan Kompetensi Pendamping Pelaku Usaha Industri Jamu.” *Jurnal Jamu Indonesia* 2(2): 68–85.
- Ratining Indah, Iman Santoso dan Riska Septifani. 2023. “Determination Of Risk Minimization Strategy For Herbal Drink Production With GMP Approach Using Scoring And AHP.” : 63–74.
- Rina Fitriana, Wawan Kurniawan dan Jaguline Glenadys Sirregar. 2020. “Pengendalian Kualitas Pangan Dengan Penerapan Good Manufacturing Practices (GMP) Pada Proses Produksi Dodol Betawi (Studi Kasus UKM Mc).” *Jurnal Teknologi Industri Pertanian* 30(1): 110–27.
- Ristryanadi, Bhiastika, and Darimiyya Hidayati. 2012. “Kajian Penerapan Good Manufacturing Practice (GMP) Di Industri Rajungan PT.Kelola Mina Laut Madura.” *Agrointek* 6(1): 55–64.
- Rudiyanto, Heru. 2016. “The Study of Good Manufacturing Practices (GMP) and Good Quality Wingko Based on SNI-01-4311-1996.” *Jurnal Kesehatan Lingkungan* 8(2): 148.
- S, Bachtiar. 2010. “Meyakinkan Validitas Data Melalui Triangulasi Pada Penelitian Kualitatif.” *Teknologi Pendidikan*: 46–62.
- Shannon, Bowen dan. 2019. “Metode Penelitian.” *An Integrated Approach to Communic*: 27–35.
- Soeprapto, Farhan, and Retno Adriyani. 2009. “Penilaian GMP Dan SSOP Pada Bagian Pengolahan Makanan Di Katering X Surabaya Dengan Metode Skoring Sebagai Prasyarat Penerapan HACCP.” *The Indonesian Journal of Public Health* 6(1): 30–37.
- Warkoyo, Warkoyo, Damat Damat, and Sri Winarsih. 2019. “Dampak Penerapan GMP Dan SSOP Terhadap Kualitas Minuman Kunyit Asam SMUD SMK Muhammadiyah 2 Malang.” *JAPI (Jurnal Aktes Pengabdian Indonesia)* 4(1): 57.
- Agustin, Meilan. 2020. “Penerapan Good Manufacturing Practices (GMP) Pada Usaha Pembuatan Bawang Goreng (STUDI KASUS PADA IKM JAKARTA PUSAT).” *Jurnal KALIBRASI - Karya Lintas Ilmu Bidang Rekayasa Arsitektur, Sipil, Industri* 3(1): 37–46. <https://ejournal.borobudur.ac.id/index.php/teknik/article/view/640>.
- Bambang Suhardi, and Riska dkk. 2020. “Perbaikan Proses Produksi Pada IKM Tahu Sari Murni Mojosongo Menggunakan Metode Good Manufacturing Practice (GMP) Dan Work Improvement In Small Enterprise (WISE).” *Jurnal INTECH Teknik Industri Universitas Serang Raya* 6(1): 88–98.
- Desi Listianingsih, R.Azizah. 2018. “Analisis Kualitas Tahu Takwa Dengan Pendekatan Good Manufacturing Practices(GMP).” (May): 281–90.
- Hapsari, Yaning Tri, and Kurniawanti. 2022. “Pendampingan Penerapan Good Manufacturing Practice (GMP) Pada Usaha Jamu.” *Jurnal Abdimas Madani*

- dan *Lestari (JAMALI)* 04(September): 96–105.
- Ristyanadi, Bhiastika, and Darimiyya Hidayati. 2012. “Kajian Penerapan Good Manufacturing Practice (GMP) Di Industri Rajungan PT. Kelola Mina Laut Madura.” *Agrointek* 6(1): 55–64.
- Rudiyanto, Heru. 2016. “The Study of Good Manufacturing Practices (GMP) and Good Quality Wingko Based on SNI-01-4311-1996.” *Jurnal Kesehatan Lingkungan* 8(2): 148.
- Surya, E, M Rosiawan, and Mochammad Arbi Hadiyat. 2013. “Perancangan Good Manufacturing Practices (GMP) Dan Budaya Kerja 5S Di PT. Indo Tata Abadi, Pandaan.” *Jurnal Ilmiah Mahasiswa Universitas Surabaya* 2(1): 1–18.
- Farisi, D. (2022). Penerapan Good Manufacturing Practices pada Usaha SirupPala di Kabupaten Aceh Selatan. *Jurnal Sosial Teknologi*, 2(5), 425–430. <https://doi.org/10.36418/jurnalsostech.v2i5.335>
- Galang. (2016). Metode Penelitian Kualitatif dalam Bidang Bimbingan dan Konseling. *Jurnal Fokus Konseling*, 2(2). <http://ejournal.stkipmpringsewu-lpg.ac.id/index.php/fokus/a>
- Hapsari, D. (2022). Pendampingan Penerapan Good Manufacturing Practice (GMP) Pada Usaha Jamu. *Jurnal Abdimas Madani Dan Lestari (JAMALI)*, 04(September), 96–105. <https://doi.org/10.20885/jamali.vol4.iss2.art6>
- Herdhiansyah, D. (2022). Penerapan Sistem GMP (Good Manufacturing Practices) pada Usaha Mikro Tahu Tempe Benjo di Desa Lambusa Kabupaten Konawe Selatan. *Warta Industri Hasil Pertanian*, 39(1), 9. <https://doi.org/10.32765/wartaihp.v39i1.6639>
- Isnaini, D. (2014). Kajian Strategi Pengawasan Dan Pengendalian Mutu Produk Ebi Furay PT. Bogatama Marinusa. *Journal of Fisheries Resources Utilization Management and Technology Universitas Diponegoro*, 2(5), 15–20.
- Masrifah. (2015). Kesesuaian Penerapan Manajemen Mutu Ikan Pindan Bandeng (Chanos chanos) Terhadap Standar Nasional Indonesia. *MANAJEMEN IKM: Jurnal Manajemen Pengembangan Industri Kecil Menengah*, 10(2), 163– 172. <https://doi.org/10.29244/mikm.10.2.163-172>
- Nwaiwu, D. (2017). Assessment of HACCP Safety System and Good Manufacturing Practices in a Multi-product Soft Drink Bottling Plant. *Current Journal of Applied Science and Technology*, 24(3), 1–12. <https://doi.org/10.9734/cjast/2017/37310>
- Rina, Wawan, D. (2020). Pengendalian Kualitas Pangan Dengan Penerapan Good Manufacturing Practices (GMP) Pada Proses Produksi Dodol Betawi (Studi Kasus UKM Mc). *Jurnal Teknologi Industri Pertanian*, 30(1), 110–127. <https://doi.org/10.24961/j.tek.ind.pert.2020.30.1.110>
- Riska, R. I. dan. (2023). *Determination Of Risk Minimization Strategy For Herbal Drink Production With*

*GMP Approach Using Scoring
And AHP. 63–74.*

Ristyanadi, D. (2012). Kajian
Penerapan Good Manufacturing
Practice (GMP) Di Industri
Rajungan PT. Kelola Mina Laut
Madura. *Agrointek*, 6(1), 55–64.

Rizki, D. (2019). Analisa Penerapan
Good Manufacturing Practices
(GMP) Dan Sanitation Standard
Operating Procedures (SSOP)
Produk Roti (Studi Kasus: M
Bakery and Cake). *Skripsi
Universitas Islam Negeri Sultan
Syarif Kasim Riau*, 1–141.