

ABSTRAK

Analisa Pengukuran Nilai OEE (*Overall Equipment Effectiveness*) Pada Aktivitas Perbaikan di Mesin AU L302 Sebagai Upaya Meminimalisasikan Jumlah Loss Produk Di PT.XYZ

PT XYZ yang merupakan perusahaan manufaktur dengan produk yang di hasilkan yaitu bearing sebagai produk utama. *Overall Equipment Effectiveness* (OEE) merupakan suatu metode yang digunakan untuk mengukur efektivitas suatu mesin atau peralatan. Untuk mendapatkan nilai OEE maka di perlukan perhitungan 3 (Tiga) rasio yaitu *Availability Ratio*, *Performance efficiency*, dan *Rate of Quality*. *Total Productive maintenance* (TPM) sebenarnya sudah di terapkan namun pada pelaksanaanya hasilnya belum optimal, yang dapat di lihat dari adanya salah satu mesin yang belum tercapainya target produksi. Penelitian ini di lakukan pada mesin AU L302. Data yang digunakan dalam penelitian ini terdiri dari data selama satu semester dari arsip serta wawancara langsung dengan operator di line AU L302 tentang kendala-kendala yang menyebabkan tingginya loss product. Hasil perhitungan OEE bulan November 2014 – April 2015 menunjukkan bahwa efektivitas mesin AU L302 masih rendah yaitu berkisar antara 55,27 % sampai 59,79 %, sangat jauh di bandingkan dengan standa yang ditetapkan dunia. Rasio yang belum ideal adalah *Availability rasio* dan *Performance efficiency*. Penyebab utama rendahnya nilai rasio dari mesin AU L302 adalah waktu *setup* mesin yang tidak standar, *waiting time* karena lamanya menunggu selama proses perbaikan mesin, *waiting material supply*, dan gangguan-gangguan kecil yang menyebabkan mesin tiba-tiba berhenti beroperasi.

Kata kunci : *Overall Equipment Effectiveness, Total Productive Maintenance, Setup, Availability, Performance, Rate of Quality.*

ABSTRACT

Analysis Measurement Value OEE (*Overall Equipment Effectiveness*) In Repair Activity in Machine AU L302 For Effort Minimize Total Loss Products On PT.XYZ

PT.XYZ which is a manufacturing company with a product that is produced is bearing as the main product. Overall Equipment Effectiveness (OEE) is a method used to measure the effectiveness of a machine or equipment. To get the value of OEE it needs the calculation of 3 (Three) ratio is Availability Ratio, Performance efficiency, and Rate of Quality. Total Productive Maintenance (TPM) has actually been applied, but the results are not optimal implementation, which can be seen from the presence of one of the machines that have not achieved the production targets. The research was conducted on the machine L302 AU. The data used in this study consisted of data during one semester of archives and interviews with operators in line AU L302 of the constraints leading to high product loss. OEE calculation results in November 2014 - April 2015 shows that the effectiveness of the AU L302 engine is still low and it ranged between 55.27% to 59.79%, very much in comparison with the established standards of the world. The ratio is not ideal Availability ratio and Performance efficiency. The main cause of the low value of the ratio of machine setup time AU L302 is a machine that is not standard, the waiting time due to the long wait during the repair process machine, waiting material supply, and the small annoyances that cause the engine suddenly stopped operating.

Keyword : *Overall Equipment Effectiveness, Total Productive Maintenance, Setup, Availability, Performance, Rate of Quality*

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