

ABSTRAK

Unit electric forklift tipe reach truck ETV 112 merupakan peralatan yang digunakan dalam perpindahan material dalam gudang *raw material*. Ketersediaan peralatan *electric forklift* untuk perpindahan material merupakan hal yang harus diperhatikan oleh berbagai perusahaan untuk memperlancar aliran barang dan menjaga produktivitas agar tidak terganggu karena adanya keterlambatan aliran barang. PT Raya Indo Fortuna merupakan perusahaan yang bergerak di bidang jasa maintenance forklift dan pengadaan spare parts forklift serta pengadaan unit handpallet. Ketersediaan peralatan electric forklift tersebut harus ditunjang dengan adanya proses maintenance yang tepat. Oleh karena itu perlu dilakukan analisa untuk mengukur tingkat keefektifan mesin tersebut dengan menggunakan metode Overall Equipment Effectiveness (OEE). Perhitungan OEE di pengaruhi oleh availability rate, performance efficiency, dan rate of quality. Dari hasil penghitungan, maka didapatkan rata-rata nilai *Availability* 78.98% ,nilai *Performance* 97.57%, dan nilai *Quality* 98.84% sehingga nilai OEE rata-rata sebesar 76.16%, Dimana hasil akhir menunjukkan bahwa nilai ideal OEE belum tercapai dari seharusnya nilai standar yang ditetapkan adalah 85% atau lebih, hal ini diakibatkan dari rendahnya nilai availability rate, yang disebabkan tingginya waktu breakdown peralatan tersebut.

Kata Kunci : *Electric forklift, Overall Equipment Effectiveness, breakdown, maintenance*

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ABSTRACT

Unit type electric forklift ETV 112 reach truck is an equipment used in the movement of materials in raw material warehouse. Availability of equipment for the electric forklift material movement is something that must be noticed by various companies to expedite the flow of goods and maintain productivity in order not to deteriorate due to the delay in the flow of goods. PT Indo Raya Fortuna is a company engaged in the service and maintenance of forklift and forklift spare parts procurement unit providing handpallet. The availability of electric forklift equipment must be supported with the proper maintenance process. Therefore, it needs to be analyzed to measure the effectiveness of the machine using the Overall Equipment Effectiveness (OEE). OEE calculation is influenced by the availability rate, performance efficiency, and the rate of quality. From the results of the calculation, then the average value obtained Availability 78.98%, 97.57% Performance value, and thus the value of Quality 98.84% OEE values by an average of 76.16%, where the final results showed that the ideal value of OEE has not reached the standard value should be set is 85% or more, this is due to the low value of the availability rate, which is due to the high time of the equipment breakdown.

Key Word : *Electric forklift, Overall Equipment Efectiveness, breakdown, maintenance*

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