ABSTRAK

Minuman teh dalam kemasan botol merupakan salah satu produk *fast moving consumer goods* yang tumbuh begitu pesat di Indonesia. Salah satu produk teh dalam kemasaan adalah Frestea. Frestea merupakan produk unggulan dari PT. Coca Cola Amatil Indonesia. Untuk memenuhi kebutuhan frestea PT. Coca Cola Amatil Indonesia mengembangkan pabrik barunya. Line produksi yang diakuisisi dari PT. San Miguel Indonesaia Foods & Beverage yang beroperasi sejak 2013. Penelitian ini bertujuan untuk mencari penyebab nilai *overall equipment effectiveness* pada Line 1 Cikedokan Plant yang belum mencapai target yang telah ditetapkan, dan menemukan solusi untuk menyelesaikan permasalahan yang terjadi sehingga dapat meningkatkan *overall equipment effectiveness* dengan menggunakan eliminasi *six big losses* sehingga didapatkan *losses* apa saja yang menjadi faktor rendahnya nilai *overall equipment effectiveness.* Rendahnya nilai *overall equipment effectiveness* disebabkan oleh tingginya nilai *losses downtime* dan *setup and adjusment*. Sehingga menyebabkan rendahnya nilai faktor penunjang *overall equipment effectiveness* yaitu *availability* dan *performance effciency*. Sehingga nilai *overall equipment effectiveness* menjadi rendah. Selanjutnya pada penelitian untuk mencari akar permasalahan yang ada digunakan beberapa metode, antara lain *diagram pareto, analisa cause and effect diagram (fishbone diagram), root cause analysis (why-why analysis).* Hasilnya ditemukan beberapa permasalahan pada Mesin, Metode, dan *Man*. Untuk mengatasi masalah-masalah tersebut digunakan beberapa metode antara lain: *improvement card, periodic maintenance, spare part control, implementasi 5R,* dan *one point lessons*. Dari perbaikan yang dilakukan didapatkan nilai *overall equipment effectiveness* naik. Hal ini disebabkan turunnya nilai *downtime losess*. Metode-metode perbaikan yang dilakukan diatas terbukti mampu mengurangi tingginya nilai *six big losses* sehingga mampu meningkatkan nilai *overall equipment effectiveness*.

Kata Kunci : *Overall Equipment Effectiveness, Six Big Losses, Diagram Pareto, Analisa Cause And Effect Diagram, Root Cause Analysis*

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ABSTRACT

Drink tea in bottles is one of the Fast Moving Consumer Goods products is growing in Indonesia. One of the bottled tea products are frestea. Frestea is a product of PT. Coca Cola Amatil Indonesia. To fulfill the market demand of frestea,PT. Coca Cola Amatil Indonesia develop new plant. Production line acquired from PT. San Miguel Indonesia foods and beverage start operating since 2013. This research aims to find the cause of the value of Overall Equipment Effectiveness at line 1 Cikedokan plant which has not reached the targets and find solutions to resolve the problems that occur so as to increase Equipment Effectiveness by using Six Big losses elimination to obtain losses what the causes of low the value of overall Overall Equipment Effectiveness. Low value of the overall Equipment Effectiveness due to the high value of Losses Downtime and Setup And Adjusment. This causing the low value of the factors supporting Overall Equipment Effectiveness is Availability and Performance Effciency, so the value of Overall Equipment Effectiveness is low. Further research to find the root of the problem used several methods, such as Diagram Pareto, Analisa Cause And Effect Diagram (Fishbone Diagram), Root Cause Analysis (Why-Why Analysis). Result found several problems on the machine, the method and man. To fix these issues used several methods, among others : Improvement Card, Periodic Maintenance, Spare Part Control, Implementasi 5R, and One Point Lessons. From the improvements there are the value of Overall Equipment Effectiveness values obtained increased. This is due to the falling value of Losses Downtime amounted . Methods of improvements made over proven to reduce the high value of the Six Big Losses so as to increase the value of Overall Equipment Effectiveness.

Key Words: Overall Equipment Effectiveness, Six Big Losses, Diagram Pareto, Analisa Cause And Effect Diagram, Root Cause Analysis

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