

ABSTRAK

PT Kencana Gemilang merupakan perusahaan yang bergerak dalam produksi peralatan elektronik rumah tangga yang dalam proses produksinya, *planning* produksi sering tidak tercapai. Penelitian ini dilakukan hanya pada bagian pembuatan *part* plastik dan pengamatan dilakukan pada mesin *Injection Moulding Machine* dengan data yang digunakan adalah data Juni – November 2015.

Tingkat produktivitas dan efisiensi mesin diukur dengan menggunakan metode *Overall Equipment Effectiveness* (OEE) sesuai dengan prinsip *Total Productive Maintenance* (TPM). Pengukuran dilakukan dengan menghitung tingkat *Availability Rate*, *Performance Efficiency*, dan *Rate of Quality Products*. Perhitungan tersebut untuk mengetahui besarnya kerugian pada mesin dan dikenal sebagai *six big losses*. Penelitian ini juga mengukur adanya pengaruh penerapan pilar TPM terhadap OEE.

Hasil dari penelitian ini menunjukkan bahwa selama periode Juni – November 2015 diperoleh nilai rata-rata OEE sebesar 70,18%. Hal ini membuktikan bahwa mesin *Injection Moulding* masih belum mencapai keadaan ideal karena nilai yang diperoleh lebih rendah dari standar ideal yaitu $\geq 85,0\%$. Penyebab rendahnya nilai OEE *idling and stoppages losses* memiliki *total time losses* sebesar 543,202 jam dengan rata-rata 14,26%. Penelitian ini juga membuktikan bahwa penerapan pilar TPM tidak berpengaruh terhadap OEE.

Kata kunci: Efisiensi, *Overall Equipment Effectiveness*, *Total Productive Maintenance*, *Six Big Losses*

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ABSTRACT

PT Kencana Gemilang is a company engaged in the production of household electronic equipment in the production process, production planning is often not achieved. This research was conducted only in the manufacture of plastic parts and observations were made at the machine Injection Moulding Machine with the data used is data from June to November, 2015. Levels of productivity and efficiency engine measured using Overall Equipment Effectiveness (OEE) in accordance with the principles of Total Productive Maintenance (TPM).

Measurement is done by calculating the level of Availability Rate, Performance Efficiency and Rate of Quality Products. The calculation to determine the amount of loss in the engine and is known as the six big losses. This study also measured the effect of the application of TPM pillar of the OEE.

The results of this study indicate that during the period from June to November, 2015 that the average value of OEE is 70.18%. This proves that the Injection Moulding machine has not yet reached the ideal state because the value obtained is lower than ideal standard is $\geq 85.0\%$. The cause of the low value of OEE due to the influence idling and stoppages losses have total time losses 543.202 hours with an average of 14.26%. The study also proved that the implementation of pillars TPM does not affect on OEE.

Keyword: Efficiency, Overall Equipment Effectiveness, Total Productive Maintenance, Six Big Losses

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