ABSTRAK

Industri baja sebagai salah satu industri pendukung pembangunan infrastruktur di Indonesia menjadikannya salah satu industri strategis. Dengan melihat pembangunan di Indonesia yang terus meningkat, perusahaan memiliki tantangan untuk memenuhi permintaan baja untuk kebutuhan dalam negeri. Maka dari itu perusahaan membutuhkan kinerja mesin yang optimal demi memenuhi permintaan baja dari konsumen. Manajemen perawatan yang baik akan meningkatkan penggunaan mesin secara optimal. Penelitian ini membahas pengukuran produktivitas mesin *Continuous Picking Line* (CPL) dengan menggunakan Metode *Overall Equipment Effectiveness* (OEE). Pengukuran dilakukan dengan mengukur *Availability, Performance,* dan *Quality*. Penelitian dilakukan pada Bulan Januari-Desember 2019, berdasarkan perhitungan yang dilakukan diperoleh hasil nilai rata-rata OEE sebesar 79.26%. Hal ini membuktikan bahwa kinerja mesin *Continuous Picking Line* (CPL) belum mencapai standar ideal yakni ≥85%. Penyebab nilai *Overall Equipment Effectiveness* (OEE) yang rendah adalah factor dari *Reduced Speed Losses* dan *Iddling and Minor Stoppages Losses* dengan persentase sebesar 18% dan 7.76%. Penyebab kemudian dianalisis menggunakan diagram sebab akibat yang disebabkan oleh faktor manusia, metode, lingkungan, material, dan mesin.

Kata kunci : *Overall Equipment Effectiveness, Six Big Losses, Diagram Pareto, Diagram Sebab Akibat*

ABSTRACT

The steel industry as one of the supporting industries for infrastructure development in Indonesia makes it one of the strategic industries. By seeing the development in Indonesia that continues to increase, the company has a challenge to meet the demand for steel for domestic needs. Therefore the company needs optimal machine performance to meet the steel demand from consumers. Good maintenance management will increase the optimal use of the machine. This research discusses the measurement of the productivity of the Continuous Picking Line (CPL) machine by using the Overall Equipment Effectiveness (OEE) Method. Measurements are made by measuring Availability, Performance, and Quality. This research was conducted in January-December 2019, based on calculations made the results obtained an average value of OEE of 79.26%. This proves that the performance of the Continuous Picking Line (CPL) machine has not reached the ideal standard of ≥85%. The cause of the low Overall Equipment Effectiveness (OEE) value is a factor of Reduced Speed Losses and Iddling and Minor Stoppages Losses with a percentage of 18% and 7.76%. The causes are then analyzed using a causal diagram caused by human factors, methods, environment, materials, and machines.

Keywords : *Overall Equipment Effectiveness, Six Big Losses, Pareto Chart, Fishbone Chart*