

ABSTRAK

Dalam mempertahankan dan meningkatkan produktivitas, perusahaan dituntut agar tetap produktif untuk memenuhi kebutuhan konsumen yang semakin meningkat. Salah satu contoh peningkatan produktivitas adalah dengan mengevaluasi kinerja fasilitas produksi. Terdapat beberapa faktor yang mempengaruhi tingkat produktivitas yang dicapai, salah satunya adalah tingkat efektivitas proses produksi tersebut. Proses produksi suatu perusahaan dapat dikatakan efektif apabila kinerja pekerja dan kinerja mesin dapat berjalan dengan baik. Line smag 3 merupakan line produksi pada bagian perakitan dalam produksi kaleng. Dalam proses produksi mulai timbul masalah berupa sering terjadinya terjadi *trouble* pada mesin perakitan, sehingga berpengaruh terhadap waktu produksi serta target *output* yang sebelumnya ditentukan. Tujuan dari penelitian ini adalah untuk mengetahui bagaimana tingkat efektivitas mesin dari periode 1-12 Desember 2018 sebelum diterapkannya *schedule maintenance* dengan periode bulan 2-12 September 2019 setelah diterapkan *schedule maintenance* secara berkala satu minggu sekali dengan obyek mesin produksi yaitu mesin *seamer lanico* 5500 watt sebagai mesin perakit antara *body* dan tutup kaleng aerosol. Metode yang digunakan adalah *Overall Equipment Effectiveness*. Setelah dilakukan penelitian hasil perhitungan yang telah dilakukan pada periode desember 2018 nilai *availability rate* 80,50%, *performance rate* 79,81% , dan *quality rate* 99,71%, didapat nilai OEE 64,06%. Pada periode september 2019 nilai *availability rate* 81,50%, *performance rate* 82,63% , dan *quality rate* 99,81%, didapat nilai OEE 67,21%. Setelah diterapkannya *schedule maintenance* secara berkala. Dimana nilai OEE mengalami peningkatan 3,15%, nilai OEE tersebut belum sesuai standar global yaitu 85% namun masih dikategorikan cukup baik.

Kata kunci : proses produksi,OEE,diagram *pareto*,diagram *fishbone*

UNIVERSITAS
MERCU BUANA

**ANALYSIS OF EFFECTIVENESS IN ASSOCIATION PROCESS IN Canned
PRODUCTION WITH OVERALL METHOD
EQUIPMENT EFFECTIVNESS**

ABSTRACT

In maintaining and increasing productivity, companies are required to remain productive to meet the increasing needs of consumers. One example of increasing productivity is to evaluate the performance of production facilities. There are several factors that affect the level of productivity achieved, one of which is the effectiveness of the production process. The production process of a company can be said to be effective if the performance of workers and the performance of machines can run well. Smag 3 line is a production line on the assembly line in can production. In the production process of the nascent period was in the form of frequent occurrence happened trouble on machine assembly, so that it affects the production time as well as the output target that was previously determined. The purpose of this study was to determine how the level of effectiveness of the machine from the period 1-12 Desember 2018 before the implementation of maintenance schedule with a period of 2-12 months September 2019 after application of periodic maintenance schedule of once a week with the object of the production machine is machine seamer lanico 5500 watt as an assembly machine between the body and lid of an aerosol can. The method used is Overall Equipment Effectiveness. After doing research the results of calculations that have been done the period of December 2018 the value of availability rate of 80.50%, a performance rate of 79.81%, and quality rate of 99.71% , obtained value of OEE 64.06%. In the period of September 2019 the value of availability rate of 81.50 % , a performance rate of 82.63 % , and quality rate of 99.81 % , obtained value of OEE 67.21%. After adoption schedule maintenance is periodic. Where the value of OEE undergo an increase of 3.15%, the value of OEE are not standards globally is 85%, but is still considered quite good.

Keywords : *production process, OEE, pareto diagram, fishbone diagram*