

## ABSTRAK

Mesin *metal sheet print* tipe MS2 melakukan *printed sheet* dalam proses produksi kemasan kaleng. Sedangkan sejak diinstall belum ada perhitungan tingkat efisiensi dan metode khusus dalam usaha peningkatan proses produksi. Perhitungan yang dapat digunakan adalah dengan nilai *Overall Equipment Effectiveness (OEE)* dan eliminasi *six big losses*. Untuk peningkatan efisiensi dari mesin MS2 tersebut dibutuhkan metode *total productive maintenance (TPM)* dan *single minute exchange dies (SMED)*. Metode TPM digunakan untuk meningkatkan nilai *avaibility* dan *quality*, sedangkan metode SMED untuk menurunkan nilai *downtime* yang terjadi pada mesin saat *startup*. Penelitian ini bertujuan menghitung nilai efisiensi OEE guna mengurangi *downtime* mesin MS2 dan mengeliminasi faktor penyebab *losses* yang tinggi dengan cara menerapkan metode TPM dan SMED, hasilnya nilai rata-rata OEE meningkat 3,37% setelah dilakukannya metode TPM dan SMED dari 39,75% menjadi 43,12%. Dan mengurangi waktu *Changeover (C/O)* sebesar 45 menit serta mengetahui *losses* terbesar diakibatkan variasi produk saat proses *startup*

**Kata Kunci** : *Printed sheet, Overall Equipment Effectiveness (OEE), Total Productive Maintenance (TPM), Single Minute Exchange of Dies (SMED)*



**ANALISIS OF PRODUCTION PROCESS EFFICIENCY ON METAL SHEET  
PRINT MACHINE TYPE1 MS2 IN CAN PACKING PRODUCTION  
WITH TPM AND SMED METHODS**

**ABSTRAC**

*MS2 type metal sheet printing machine performs printed sheets in the production process of canned packaging. Meanwhile, since it was installed, there has been no calculation of the level of efficiency and special methods in an effort to improve the production process. The calculations that can be used are with the value of Overall Equipment Effectiveness (OEE) and the elimination of six big losses. To increase the efficiency of the MS2 machine, the total productive maintenance (TPM) and single minute exchange dies (SMED) methods are needed. The TPM method is used to increase the availability and quality values, while the SMED method is to reduce the value of downtime that occurs on the machine at startup. This study aims to calculate the OEE efficiency value in order to reduce MS2 machine downtime and eliminate the factors causing high losses by applying the TPM and SMED methods, the result is that the average OEE value increases by 3.37% after the TPM and SMED methods from 39.75% to 43.12%. And reduce Changeover (C/O) time by 45 minutes and find out the biggest losses due to product variations during the startup process*

**Keyword :** *Printed sheet, Overall Equipment Effectiveness (OEE), Total Productive Maintenance (TPM), Single Minute Exchange of Dies (SMED)*

