

ABSTRAK

PT. Superex Raya Aluminium Extruders merupakan perusahaan yang bergerak dibidang industry Aluminium dengan hasil produksinya berupa *Door lock*, Kunci, Tangga, *Royal Sink*, *Royal Kitchen Set*, Tangga Lipat Tengcki Air dan Kusen Aluminium kebutuhan dalam negeri maupun luar negeri. Dimana dalam produksinya tidak lepas dari masalah yang berhubungan dengan efektifitas mesin/peralatan yang diakibatkan oleh *six big losess* (enam kerugian terbesar). Oleh karna itu untuk mempertahankan kualitas produk serta ke efektifan dan efisinsi kinerja mesin/pealatan.maka perusahaan harus melakukan pemeliharaan mesin dan peralatan secara rutin agar tidak mengulangi masalah tersebut. Dari hasil perhitungan OEE mesin *Extrusion Press 2* selama periode Januari 2014 – Desember 2014 diperoleh nilai *Overall Equipment Effectiveness (OEE)* berkisaran antara 80,50% - 104,68% dengan nilai rata-rata OEE adalah 98,14% Kondisi ini menunjukkan bahwa kemampuan mesin *Extrusion Press 2* dalam mencapai target dan dalam pencapaian efektivitas penggunaan mesin/peralatan sudah mencapai standar kelas dunia karna nilai OEE lebih dari 85%. Factor Six big losess terhadap nilai OEE pada mesin *Extrusion Press 2* adalah *Reduce Speed Losess* sebesar 43,75%, disusul dengan *idling and Minor Stoppegas losess* sebesar 8,42%, *Reduced Yield/Scrap Losess* sebesar 0,03%, *Set Up/Adjustment Losess* sebesar 2,02% dan *Breakdown Losess* sebesar 1,71%.

Kata Kunci : *Overall Equipment Effectiveness (OEE), Sig Big Losess, Breakdown Losess, Set Up And Adjustment Losess, Reduce Speed Losess, Idling And Minor Stoppegas, Rework Losess, Yield Scrap Losess.*

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ABSTRACT

Superex Behavior Aluminium Extruders is that of the company engaged in Industries with the result Aluminium production "door lock, keys , Tangga, Royal Screaming, Royal Kitchen sets, household as much water and Carpentry Tengcki Aluminium requirements of the land and overseas. In the production is not free Where from the problem related to effectiveness machine/equipment which resulted by *six big losses* (six biggest loss). By therefore, to maintain quality products and to largely ineffectual and engine *performance*, notably transport efficiency, is/pealatan.maka company must keep the charge machinery and equipment regularly so that it will not repeat this problem. From result calculation OEE machine injections molding Extrusion Release 2 during the January 2014 - December 2014 , the *overall Equipment Effectiveness (OEE)* berkisaran between 80.50 % - 104.68 % with value price OEE was 98.14 percent this condition has shown that the capability machine *injections molding Extrusion Trousers 2* to reach target and in the achievement usage effective machine/equipment has already reached world class standard because the OEE more than 85 percent. Factor Six big losses to OEE to the engine injections molding Extrusion Release 2 is *Reduce Speed Losses* of 43.75 percent, followed by *idling and Minor Stoppegas losses* of 8.42 percent, *Reduced-yielding/Kliping Losses* of 0.03 percent, *Set Up/Adjustment Losses* of 2.02 percent and *Breakdown Losses* of 1.71 percent.

Key words : *Overall Equipment Effectiveness (OEE), Six Big Losses, Breakdown Losses, Set Up And Adjustment Losses, Reduce Speed Losses, Idling And Minor Stoppegas, Rework Losses, higher-yielding Kliping Losses.*

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