

ABSTRAK

Industri farmasi merupakan salah satu elemen yang berperan penting dalam mewujudkan kesehatan nasional melalui aktivitasnya dalam memproduksi obat. Dalam proses produksi untuk menghasilkan produk obat tentu saja melibatkan beberapa mesin salah satunya mesin *stripping*. *Downtime* mesin *chentai* 4 yang tinggi yaitu selama 6.518 menit menandakan kurang efektifnya mesin tersebut. Dari pengolahan data yang telah dilakukan pada mesin *stripping Chentai* 4, diperoleh persentase nilai OEE sebesar 75,67 %, sehingga tidak memenuhi target OEE perusahaan sebesar 80%. Hasil perhitungan *six big losses* diperoleh bahwa *idle and minor stoppage loss* sebesar 4,67 %, menjadi variabel penyebab terbesar yang mempengaruhi nilai OEE menjadi rendah dengan proses ganti *foil* menjadi *downtime* paling lama yaitu 750 menit. Berdasarkan analisis FMEA, usulan perbaikan yang dilakukan adalah pembuatan standar jumlah *supply foil* setiap *batch*, dilakukan *training* terkait OEE dan cara penggantian *foil* yang benar, penambahan poin AM *checklist* terkait pengecekan baut *sealing*, dibuatkan SOP Cara Pemasangan *Foil*. Nilai RPN tertinggi 420 yaitu pada *potensial failure* jumlah *roll foil* berbeda setiap *batch*. Setelah dilakukan *improvement* diperoleh nilai OEE mesin *chentai* 4 bulan Juni-Agustus 2021 meningkat menjadi yaitu 82,50 % , 84,32 % , dan 84,41% sehingga memenuhi target perusahaan.

Kata kunci: *Overall Equipment Effectiveness*, *Six Big Losses*, *Fishbone diagram*, RPN, FMEA, *diagram pareto*, *improvement*.

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ABSTRACT

The pharmaceutical industry is one element that plays an important role in realizing national health through its activities in producing drugs. In the production process to produce medicinal products, of course, involves several machines, one of which is a peeling machine. The high downtime of the chentai 4 engine of 6,518 minutes indicates the engine's ineffectiveness. From the data processing that has been carried out on the Chentai 4 stripping machine, the percentage of OEE value is 75.67%, so it does not meet the company's OEE target of 80%. The results of the calculation of the six major losses are obtained that the idle and minor stoppage loss is 4.67%, being the biggest variable that affects the OEE value to be low with the foil replacement process being the longest downtime of 750 minutes. Based on the FMEA, the proposals for improvement are making a standard for the amount of supply foil in each batch, conducting training related to OEE and the correct method of replacing the foil, adding AM checklist points related to checking sealing bolts, making a SOP on how to install foil. The highest RPN value is 420, which is the potential for failure the number of foil rolls is different for each batch. After repairs were made, the OEE value of the Chentai 4 engine in June-August 2021 increased to 82.50%, 84.32%, and 84.41% so that it met the company's target.

Keyword: Overall Equipment Effectiveness, Six Big Losses, Fishbone diagram, RPN, FMEA, pareto chart, improvement.



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