ABSTRAK

Untuk meningkatkan produktivitas dan mempertahankan mutu menjadi fokus sebuah industri manufaktur. PT. Ultra Prima Abadi menerapkan total productive *maintenance* diharapkan industri mampu menjaga dan memperbaiki kinerja mesin guna mencapai efisiensi dan efektifitas. Line 7 memiliki kapasitas produksi yang lebih besar dibanding line lainnya, jika terjadi kendala pada line 7 produksi akan sulit dipenuhi. Karena itu dilakukan penelitian yang bertujuan untuk mengetahui bagaimana kondisi *maintenance* dan bagaimana tingkat efektivitas dari line 7 serta dapat memberikan rekomendasi yang tepat untuk meningkatkan efektivitas mesin oven pada line 7. Dengan menggunakan metode *Overall Equipment Effectiveness* dan *Six Big losses.* Setelah dilakukan penelitian, diperoleh nilai rata-rata *Overall Equipment Efectiveness* sebesar 73%. Hasil ini masih belum memenuhi standar *world class* yaitu 85%. Losses terbesar yang menyebabkan rendahnya nilai OEE tersebut adalah *Equipment Failure Losses* dengan nilai 48% dan *Idling and Minor Stopager Losses* dengan nilai 21%. Penyebab besarnya *Losses* terdiri dari factor mesin, manusia, lingkungan, dan material. Factor mesin dan manusia merupakan faktor yang paling dominan. Untuk mengurangi kerugian tersebut perusahaan harus melakukan pemeliharaan sesuai dengan jadwal *maintenance* yang sudah ada. Devisi *maintenance* harus melakuakan diskusi untuk membuat jadwal antara kegiatan *maintenance* dan produksi. Perusahaan juga memberi pemahaman target produksi kepada pekerja guna membangun motivasi pekerja. Kemudian perusahaan harus lebih memperhatikan kenyamanan operator dalam bekerja sehingga kelelahan bisa dikurangi.

Kata kunci: *Overall Equipment Effectiveness, Six Big Losses, Equipment Failure Losses, Idling and Minor Stopager Losses,* Pemeliharaan, Line Produksi,

ABSTRACT

To increase productivity and maintain quality is the focus of a manufacturing industry. PT. XYZ has implemented total productive maintenance, it is expected that the industry will be able to maintain and improve the performance of the engine in order to achive efficiency and effectiveness. Line 7 has a greater production capacity than other lines, if there has an obstacles on line 7 then the production will be difficult to fulfill. Because of that this research it was conducted which aim for knowing how about the condition of maintenance and the efectivity rate from line 7 and also can give the right recommendation to increase effectivity of oven on line 7. By using the Overall Equipment Effectiveness and Six Big Losses methods. After doing this research, obtained average value Overall Equipment Effectiveness is 73%. This result still does not meet the world class standard which is 85%. The biggest Losses that cause this low of OEE value is Equipment Failure with a value of 48% and the Idling and Minor Stopager Losses with a value of 21%. Causes of the magnitude of Losses are from machine, humans, environmental, and material factors. Machine and humans factors are the most dominant. To reduce this losses the company must be carry out maintenance in accordance with the existing maintenance schedule. The maintenance division must be conduct discussions to make a schedule between maintenance and production activities. The company also provides understanding of production targets to workers in order to build motivation for they are. And then the company must pay more attention to the operator's comfort at work so that fatigue can be reduced.

Keywords: *Overall Equipment Effectiveness, Six Big Losses, Equipment Failure Losses, Idling and Minor Stopager Losses, Maintenance, Production Lines.*