

ABSTRAK

Ayu Ajeng Novita Ariadi : Pengukuran Nilai OEE Pada Mesin *Single Punch Hydraulic Press* Sebagai Dasar Peningkatan Produktivitas (Studi Kasus : PT. Bondvast Indo Sukses)

PT. Bondvast Indo Sukse (BIS) merupakan industri manufaktur *furniture outdoor* yang mengalami kendala yaitu pada mesin yang digunakan memiliki tingkat *downtime* yang tinggi sehingga dalam proses produksi *woven chair* komponen *iron pipe* 24 x 0,9 x 5423 mm masih mengalami kendala yaitu mesin yang digunakan tidak bekerja secara optimal sehingga mempengaruhi tingkat *output* produksi tidak stabil. Komponen *iron pipe* 24 x 0,9 x 5423 mm merupakan bagian kaki belakang dari *woven chair*. Maka diperlukan suatu analisis untuk mengetahui tingkat efektivitas mesin dan mengidentifikasi secara jelas akar permasalahan faktor penyebabnya sehingga usaha perbaikan menjadi terfokus dengan menggunakan metode OEE menghitung 3 faktor yaitu *availability rate*, *performance rate* dan *quality rate*. Dari hasil penelitian didapatkan nilai OEE pada mesin *Single Punch Hydraulic Press* sebesar 83%. Kumulatif six big losses menunjukkan total waktu *losses* yang dipersentasekan. *Losses* tertinggi pada *reduced speed losses* dengan persentase *losses* sebesar 77,06%, tertinggi kedua pada *idle and minnor stoppage losses* dengan persentase *losses* sebesar 15,35% dan tertinggi ketiga pada *equipment failure* dengan persentase *losses* sebesar 4,56%. *Losses* yang mempunyai total waktu terlalu lama akan menyebabkan kerugian besar sehingga dapat diketahui *losses* yang menjadi prioritas utama yang harus dilakukan perbaikan adalah *reduce speed losses*, *idle and minnor stoppage losses* dan *equipment failure losses*.

Kata Kunci : *Overall Equipment Analysis (OEE), Six Big Losses, Downtime.*

ABSTRACT

Ayu Ajeng Novita Ariadi: Measurement of OEE Value on Single Punch Hydraulic Press Machine as a Basis for Increasing Productivity (Case Study: PT. Bondvast Indo Sukses)

PT. Bondvast Indo Sukse (BIS) is an outdoor furniture manufacturing industry that is experiencing problems, namely the machines that are used have a high level of downtime so that the production process of woven chair iron pipe components 24 x 0.9 x 5423 mm is still experiencing problems namely the machines used do not work optimally so that it affects the level of output production is not stable. Iron pipe component 24 x 0.9 x 5423 mm is the back leg of the woven chair. Then we need an analysis to determine the level of effectiveness of the engine and clearly identify the root causes of the factors causing it so that the improvement effort becomes focused by using the OEE method to calculate 3 factors namely availability rate, performance rate and quality rate. From the research results obtained OEE value on the Single Punch Hydraulic Press machine by 83%. The cumulative six big losses indicate the total time losses that are presented. The highest losses was reduced speed losses with percentage losses of 77.06%, the second highest was idle and minnor stoppage losses with percentage losses of 15.35% and the third highest was equipment failures with percentage losses of 4.56%. Losses which have the longest total time will cause large losses so that losses can be identified as the main priority that must be improved are reducing speed losses, idle and minoror stoppage losses and equipment failure losses.

Keywords: Overall Equipment Analysis (OEE), Six Big Losses, Downtime.