

Ana Silvia. NIM 160331100042. Pengukuran Kinerja Mesin Produksi “Redrying” Menggunakan Metode Overall Equipment Effectiveness (OEE) (Studi Kasus di Koperasi XYZ). Dibawah Bimbingan **Dr. Moh. Fuad FM, S.TP., M.Si dan Burhan, S.TP., MT.**

ABSTRAK

Koperasi Karyawan redrying bojonegoro (KAREB) merupakan koperasi yang memiliki salah satu bidang usaha yaitu jasa pengeringan tembakau. Produk yang dihasilkan di koperasi kareb adalah tembakau kering. Proses pengeringan tembakau di koperasi kareb terdiri dari 2 unit produksi yaitu redrying dan threshing. Penelitian ini memfokuskan pada unit produksi redrying. Mesin utama yang digunakan pada unit redrying adalah mesin redrying. Mesin ini sering mengalami kerusakan seperti down dan hasil pengeringan yang tidak memenuhi standar kualitas sehingga mengganggu proses produksi. Perlu dilakukan pengukuran kinerja mesin redrying dengan menggunakan metode OEE. Penelitian ini memiliki tujuan mengukur kinerja mesin redrying menggunakan metode OEE dan melakukan analisis dengan menggunakan diagram fishbone. Sehingga diperoleh solusi terkait kinerja produksi. Oee didapatkan dari perkalian rasio availability, rasio performance dan rasio quality. Nilai tertinggi dan terendah OEE mesin redrying Koperasi KAREB unit I dan II terdapat pada bulan Desember sebesar 83,58% dan bulan Oktober 37,86%. Adapun nilai OEE mesin redrying unit III nilai tertinggi terdapat pada bulan Januari yaitu 99,97% dan nilai terendah pada bulan Oktober yaitu 47,61%. Persentase yang memenuhi standar Internasional hanya terdapat pada unit III di bulan Januari yang lebih dari 85%. Rendahnya nilai oee pada koperasi kareb disebabkan kondisi (bulan produksi dan tidak produksi), besar kecilnya jumlah tembakau yang dikeringkan, rendahnya waktu optimal mesin beroperasi dan perbedaan dari jenis tembakau serta adanya bahan lain yang tercampur pada tembakau (seperti hewan, tali dan sebagainya).

Kata kunci: overall equipment effectiveness, kinerja mesin redrying, mesin redrying

Ana Silvia. NIM 160331100042. Performance Measurement Of “Redrying Machine” Using Overall Equipment Effectiveness (OEE) Method (Case Study At XYZ Cooperative). Supervised by **Dr. Moh. Fuad FM, S.TP., M.Si dan Burhan, S.TP., MT.**

ABSTRACT

Bojonegoro Redrying Employee Cooperative (KAREB) is a cooperative that has one of the business sectors, namely tobacco drying services. The product produced in the Kareb cooperative is dry tobacco. The tobacco drying process in the Kareb cooperative consists of 2 production units, namely redrying and threshing. This research focuses on the redrying production unit. The main machine used in the redrying unit is the redrying machine. This machine often experiences damage such as downtime and drying results that do not meet quality standards, thus disrupting the production process. It is necessary to measure the performance of the redrying machine using the OEE method. This study aims to measure the performance of the redrying machine using the OEE method and perform analysis using a fishbone diagram. So that we get a solution related to production performance. Oee is obtained from multiplying the availability ratio, performance ratio and quality ratio. The highest and lowest values of OEE for Koperasi KAREB unit I and II redrying machines were in December at 83.58% and in October 37.86%. The OEE value of unit III redrying machine, the highest value was in January, namely 99.97% and the lowest value was in October, namely 47.61%. The percentage that meets international standards is only found in unit III in January which is more than 85%. The low value of oee in the Kareb cooperative is due to conditions (months of production and non-production), the size of the amount of tobacco that is dried, the low optimal time for the machine to operate and the difference between the types of tobacco and the presence of other ingredients mixed in with tobacco (such as animals, rope and so on).

Keywords: overall equipment effectiveness, redrying machine performance, redrying machine