

ABSTRAK

PT. Cipta Oggi Furindo merupakan perusahaan yang bergerak dibidang manufaktur furniture. Tahun 2024 bulan Januari – Juni terdapat permasalahan pada mesin Auto Edgeband SCM Olympic K-800 yang sering mengalami kerusakan sehingga perlu dilakukannya analisa efektivitas kerja mesin menggunakan metode *Overall Equipment Effectiveness* (OEE) serta menyusun rancangan alternatif perawatan dengan *preventive maintenance policy* untuk meningkatkan efektivitas dan mengurangi biaya perawatan mesin. Hasil perhitungan nilai OEE diperoleh rata-rata sebesar 74%, yang berarti belum mencapai *standar world class* sebesar 85%. Analisis lebih lanjut melalui metode *six big losses* menunjukkan bahwa kerugian terbesar disebabkan oleh *reduce speed losses* sebesar 58,40%. Berdasarkan perbandingan antara metode *repair maintenance policy* dan *preventive maintenance policy* dengan klasifikasi A, B dan C. Klasifikasi A di ambil 20% dari harga *sparepart* paling mahal, klasifikasi B di ambil 30% harga *sparepart* paling mahal setelah kelas A dan klasifikasi C di ambil 50% harga *sparepart* yang tersisa. *Preventive maintenance policy* memiliki hasil lebih kecil pada semua klasifikasi yaitu klasifikasi A sebesar Rp. 2.149.594 dengan perawatan 6 bulan sekali, klasifikasi B sebesar 2.167.021 dengan perawatan 5 bulan sekali klasifikasi, C sebesar Rp. 1.944.890 dengan perawatan setiap 6 bulan sekali.

Kata Kunci: *Overall Equipment Effectiveness* (OEE), *Repair Maintenance Policy* dan *Preventive Maintenance Policy*

ABSTRACT

PT. Cipta Oggi Furindo is a company engaged in furniture manufacturing. From January to June 2024, issues were identified with the Auto Edgeband SCM Olympic K-800 machine, which frequently experienced breakdowns. Therefore, an analysis of machine work effectiveness using the Overall Equipment Effectiveness (OEE) method was conducted, along with the development of an alternative maintenance plan through a preventive maintenance policy to improve effectiveness and reduce machine maintenance costs. The OEE calculation results showed an average value of 74%, which does not meet the world-class standard of 85%. Further analysis using the six big losses method indicated that the largest loss was due to reduce speed losses, accounting for 58.40%. A comparison was made between the repair maintenance policy and the preventive maintenance policy, categorized into classifications A, B, and C. Classification A consisted of the top 20% most expensive spare parts, classification B consisted of the next 30% of high-cost spare parts following class A, and classification C included the remaining 50% of less costly spare parts. The preventive maintenance policy resulted in lower costs across all classifications, with class A costing Rp. 2,149,594 with maintenance performed every 6 months, class B costing Rp. 2,167,021 with maintenance every 5 months, and class C costing Rp. 1,944,890 with maintenance every 6 months.

Keywords: *Overall Equipment Effectiveness (OEE), Repair Maintenance Policy dan Preventive Maintenance Policy*