

ABSTRACT

Initial identification at the company PT. Cahaya Bintang Plastindo is a high number of products reject, so that production is reduced and a lot of time is wasted. The products reject highest were produced by machines moulding number 4, number 34 and number 38 in the data of November 2019, December 2019 and January 2020. The number of rejects in machines moulding number 4 was 1,574 products, machine number 34 was 3,049 products and machine number 38 was 1,991 product. It is feared that the number of products reject will affect the value of the effectiveness of the machine. Based on the calculation of the Overall Equipment Efficiency value, if averaged, a value of 65% is found in machine number 4, 43% in machine number 34 and 34% in machine number 38. The factor in six big losses that greatly influences the low OEE value is reducing speed losses by 16.43% in machine number 4, equipment failure or breakdown by 28.82% in machine number 34 and 42.13% in machine number 38. Recommendations given are increasing preventive schedules, conducting operator training, improve the quality of raw materials and improve the quality of cooling.

Keywords: Overall Equipment Efficiency, Six Big Losses

ABSTRAK

Identifikasi awal pada perusahaan PT. Cahaya Bintang Plastindo adalah tingginya jumlah produk *reject*, sehingga produksi berkurang dan banyak waktu terbuang. Produk *reject* tertinggi dihasilkan oleh mesin *moulding* nomor 4, nomor 34 dan nomor 38 pada data bulan November 2019, Desember 2019 dan Januari 2020. Jumlah *reject* pada mesin *moulding* nomor 4 sebesar 1.574 produk, mesin nomor 34 sebesar 3.049 produk dan mesin nomor 38 sebesar 1.991 produk. Dikhawatirkan banyaknya produk *reject* akan mempengaruhi nilai efektivitas mesin. Berdasarkan hasil perhitungan nilai *Overall Equipment Efficiency* jika dirata-rata didapatkan nilai sebesar 65% pada mesin nomor 4, 43% pada nomor mesin 34 dan 34% pada mesin nomor 38. Faktor dalam *six big losses* yang sangat mempengaruhi rendahnya nilai OEE adalah *reduce speed losses* sebesar 16,43% di mesin nomor 4, *equipment failure loss* atau *breakdown* sebesar 28,82% di mesin nomor 34 dan sebesar 42,13% di mesin nomor 38. Rekomendasi yang diberikan adalah meningkatkan jadwal preventif, melakukan pelatihan operator, meningkatkan kualitas bahan baku dan meningkatkan kualitas *cooling*.

Kata kunci: *Overall Equipment Efficiency, Six Big Losses*