

Ika Mey Saputri. NPM 220331100032. Pengukuran Efektivitas Proses *Redrying* Tembakau Melalui Penerapan Metode *Overall Equipment Effectiveness*. Di bawah Bimbingan **Dr. Banun Diyah Probawati, S.TP., M.Si., dan Mojiono, S.TP., M.Si.,**

ABSTRAK

Koperasi Karyawan Redrying Bojonegoro (KAREB) merupakan koperasi yang bergerak di bidang pengolahan tembakau dan memiliki unit produksi threshing yang berfungsi untuk memisahkan daun dan batang tembakau. Dalam proses produksi pada unit threshing masih mengalami berbagai kendala, seperti downtime mesin, penurunan kecepatan produksi, dan tingginya jumlah produk cacat, yang menyebabkan produktivitas belum optimal. Penelitian ini bertujuan untuk mengidentifikasi faktor-faktor yang menyebabkan rendahnya produktivitas, mengukur tingkat efektivitas mesin menggunakan metode Overall Equipment Effectiveness (OEE), serta memberikan rekomendasi perbaikan untuk meningkatkan produktivitas proses produksi. Metode yang digunakan adalah OEE yang terdiri atas tiga komponen utama, yaitu Availability Rate, Performance Rate, dan Quality Rate. Analisis penyebab rendahnya produktivitas dilakukan menggunakan konsep Six Big Losses dan diagram sebab akibat (fishbone diagram). Hasil penelitian menunjukkan bahwa nilai rata-rata Availability Rate sebesar 97,79%, Performance Rate sebesar 31,72%, dan Quality Rate sebesar 74,33%, sehingga diperoleh nilai rata-rata OEE sebesar 23,09%. Nilai OEE tertinggi terjadi pada bulan April 2025 sebesar 38,04%, sedangkan nilai terendah terjadi pada bulan Januari 2026 sebesar 0,03%. Nilai tersebut masih jauh di bawah standar world-class yang ditetapkan Japan Institute of Plant Maintenance (JIPM) sebesar 85%. Rendahnya nilai OEE terutama disebabkan oleh rendahnya Performance Rate akibat reduced speed losses dan idling and minor stoppages losses, serta rendahnya Quality Rate akibat tingginya jumlah produk cacat. Berdasarkan analisis fishbone diagram, faktor penyebab rendahnya produktivitas berasal dari mesin, metode, material, manusia, dan lingkungan kerja. Oleh karena itu, diperlukan perbaikan berkelanjutan untuk meningkatkan efektivitas mesin dan produktivitas proses produksi.

Kata kunci: *Overall Equipment Effectiveness, Produktivitas, Six Big Losses, Threshing, Tembakau.*

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ABSTRACT

The Bojonegoro Redrying Employees' Cooperative (KAREB) is a cooperative engaged in tobacco processing and operates a threshing unit designed to separate tobacco leaves from their stems. The production process at the threshing unit still faces various challenges, such as machine downtime, reduced production speed, and a high number of defective products, resulting in suboptimal productivity. This study aims to identify the factors causing low productivity, measure machine effectiveness using the Overall Equipment Effectiveness (OEE) method, and provide recommendations for improvements to enhance production process productivity. The method used is OEE, which consists of three main components: Availability Rate, Performance Rate, and Quality Rate. An analysis of the causes of low productivity was conducted using the Six Big Losses concept and a cause-and-effect diagram (fishbone diagram). The results show that the average Availability Rate was 97.79%, the Performance Rate was 31.72%, and the Quality Rate was 74.33%, resulting in an average OEE value of 23.09%. The highest OEE value occurred in April 2025 at 38.04%, while the lowest value occurred in January 2026 at 0.03%. These values are still far below the world-class standard set by the Japan Institute of Plant Maintenance (JIPM) of 85%. The low OEE value is primarily due to a low Performance Rate resulting from reduced speed losses and idling and minor stoppage losses, as well as a low Quality Rate resulting from a high number of defective products. Based on the fishbone diagram analysis, the factors causing low productivity stem from machinery, methods, materials, people, and the work environment. Therefore, continuous improvement is needed to enhance machine effectiveness and production process productivity.

Keywords: Overall Equipment Effectiveness, Productivity, Six Big Losses, Threshing, Tobacco.