

DAFTAR ISI

	Halaman
HALAMAN PENGESAHAN	ii
PERNYATAAN KEASLIAN DAN BEBAS PLAGIAT	iii
KATA PENGANTAR	iv
DAFTAR ISI	vi
DAFTAR TABEL	viii
DAFTAR GAMBAR	ix
ABSTRAK	xi
ABSTRACT	xii
BAB I PENDAHULUAN	1
1.1 Latar Belakang	1
1.2 Rumusan Masalah	3
1.3 Batasan Masalah dan Asumsi	3
1.4 Tujuan Penelitian	4
1.5 Manfaat Penelitian	4
1.6 Sistematika Penulisan Laporan	4
BAB II LANDASAN TEORI	6
2.1 Efektivitas Mesin	6
2.2 <i>Overall Equipment Effectiveness (OEE)</i>	7
2.2.1 Pengertian <i>Overall Equipment Effectiveness (OEE)</i>	7
2.2.2 Faktor-faktor <i>Overall Equipment Effectiveness (OEE)</i>	8
2.2.3 Perhitungan <i>Overall Equipment Effectiveness (OEE)</i>	9
2.3 <i>Six Big Losses</i>	10
2.4 Diagram Pareto	13
2.5 Diagram <i>Fishbone</i>	13
2.6 Penelitian Terdahulu	14

BAB III	METODOLOGI PENELITIAN	17
3.1	Objek Penelitian	17
3.2	Pengumpulan Data.....	17
3.3	Kerangka Penelitian.....	18
3.4	Teknik Pengolahan Data.....	18
3.5	Analisis Hasil.....	22
3.6	Kesimpulan dan Saran	22
BAB IV	HASIL DAN PEMBAHASAN.....	24
4.1	Pengumpulan data	24
	4.1.1 Data Waktu Kerja Mesin.....	24
	4.1.2 Data <i>Downtime</i> Mesin.....	24
	4.1.3 Data Target Produksi	25
	4.1.4 Data Jumlah Produksi	26
	4.1.5 Data Produk Cacat	26
4.2	Pengolahan Data.....	27
	4.2.1 Perhitungan <i>Availability Rate</i>	27
	4.2.2 Perhitungan <i>Performance Efficiency</i>	29
	4.2.3 Perhitungan <i>Quality Rate</i>	32
	4.2.4 Perhitungan <i>Overall Equipment Effectiveness</i>	33
	4.2.5 Perhitungan <i>Six Big Losses</i>	35
	4.2.6 Diagram Pareto	43
4.3	Analisis Hasil.....	47
BAB V	KESIMPULAN DAN SARAN	51
5.1	Kesimpulan.....	51
5.2	Saran	51

DAFTAR PUSTAKA

DAFTAR TABEL

Tabel 2. 1 Penelitian Terdahulu	15
Tabel 4. 1 Data waktu kerja mesin.....	24
Tabel 4. 2 Data <i>breakdown</i> mesin.....	25
Tabel 4. 3 Data <i>set up</i> mesin	25
Tabel 4. 4 Data target produksi	26
Tabel 4. 5 Data jumlah produksi	26
Tabel 4. 6 Data produk cacat.....	26
Tabel 4. 7 Data <i>operating time</i>	27
Tabel 4. 8 Data <i>availability rate</i>	28
Tabel 4. 9 Data hasil perhitungan <i>ideal cycle time</i>	30
Tabel 4. 10 Data <i>actual cycle time</i>	30
Tabel 4. 11 Data <i>performance efficiency</i>	31
Tabel 4. 12 Data <i>rate of quality</i>	32
Tabel 4. 13 Data <i>overall equipment effectiveness</i>	34
Tabel 4. 14 Rata-rata setiap faktor OEE	35
Tabel 4. 15 Data perhitungan <i>breakdown losses</i> mesin las robot 6	36
Tabel 4. 16 Data perhitungan <i>breakdown losses</i> mesin las robot 11	36
Tabel 4. 17 Data perhitungan <i>breakdown losses</i> mesin las robot 8	36
Tabel 4. 18 Data perhitungan <i>setup and adjustment losses</i> mesin las robot 6.....	37
Tabel 4. 19 Data perhitungan <i>setup and adjustment losses</i> mesin las robot 11	38
Tabel 4. 20 Data perhitungan <i>setup and adjustment losses</i> mesin las robot 8.....	38
Tabel 4. 21 Data perhitungan <i>reduce speed losses</i> mesin las robot 6.....	39
Tabel 4. 22 Data perhitungan <i>reduce speed losses</i> mesin las robot 11	39
Tabel 4. 23 Data perhitungan <i>reduce speed losses</i> mesin las robot 8.....	39
Tabel 4. 24 Data perhitungan <i>defect losses</i> mesin las robot 6	40
Tabel 4. 25 Data perhitungan <i>defect losses</i> mesin las robot 11	41
Tabel 4. 26 Data perhitungan <i>defect losses</i> mesin las robot 8	41
Tabel 4. 27 Data rata-rata <i>six big losses</i> mesin las robot 6	43
Tabel 4. 28 Data rata-rata <i>six big losses</i> mesin las robot 8	43

Tabel 4. 29 Data rata-rata <i>six big losses</i> mesin las robot 11	44
---	----

DAFTAR GAMBAR

Gambar 3. 1 Kerangka Penelitian	19
Gambar 3. 2 Kerangka Pengolahan Data	23
Gambar 4. 1 Grafik perhitungan <i>availability rate</i> mesin las robot	29
Gambar 4. 2 Grafik perhitungan <i>performance efficiency</i> mesin las robot.....	32
Gambar 4. 3 Grafik perhitungan <i>rate of quality</i> mesin las robot	33
Gambar 4. 4 Grafik perhitungan OEE mesin las robot	34
Gambar 4. 5 Persentase <i>six big losses</i> mesin las robot 6	42
Gambar 4. 6 Persentase <i>six big losses</i> mesin las robot 8	42
Gambar 4. 7 Persentase <i>six big losses</i> mesin las robot 6	42
Gambar 4. 8 Diagram Pareto Mesin Las Robot 6	44
Gambar 4. 9 Diagram Pareto Mesin Las Robot 8	45
Gambar 4. 10 Diagram Pareto Mesin Las Robot 11	45
Gambar 4. 11 Diagram <i>Fishbone</i>	46