

ABSTRAK

Biro Pabrik Kantong berada dibawah Department Distribusi dan Transportasi yang bertanggungjawab atas pengadaan keperluan kantong semen untuk delapan packing plant di PT Semen Padang. Dalam proses produksinya, BPK menggunakan beberapa mesin dimana mesin utamanya adalah mesin Bottomer. Mesin ini memiliki kapasitas produksi sebanyak 12.000 helai kantong per jam, namun pada kenyataannya mesin ini sering mengalami kegagalan pencapaian kapasitas tersebut disebabkan karena sering mengalami kerusakan (breakdowns), sehingga berdampak pada jumlah output yang dihasilkan.

Permasalahan tersebut akan diteliti dengan menganalisis efektivitas mesin menggunakan metode Overall Equipment Effectivines (OEE). Setelah nilai OEE diketahui, akan dilakukan analisis terhadap six big losses yang terdapat pada mesin.

Berdasarkan hasil pengolahan data, nilai pencapaian OEE mesin Bottomer dibawah OEE yang ditetapkan standart JIPM, dimana OEE tertinggi mesin ini sebesar 74.69% sedangkan standart yang telah ditetapkan adalah 85%. Faktor penyebab rendahnya nilai OEE tersebut adalah karena tingginya nilai six big losses. Hasil penelitian yang sudah dilakukan menunjukkan tingkat kerusakan mesin (breakdown) dan penurunan kecepatan mesin (reduced speed losses) merupakan faktor terbesar penyebab rendahnya nilai OEE pada mesin Bottomer.

Kata kunci : Overall Equipment Effectivines (OEE), Total Productive Maintenance (TPM), Six Big Losses

ABSTRACT

Bureau of Bags Factory is under the auspices of Distribution and Transportation Department that responsible in procurement purposes for cement's bag of eight packing plants in PT. Semen Padang. In its production process, the Bureau uses some machines in which the main machine is a machine named Bottomer. The production capacity of this machine is 12,000 pieces of bags over an hour, but in reality these machines often failed to achieve these capacities due the process caused of often damaged (breakdowns), so the impact is on the amount of output produced later.

These problems will be investigated by analyzing the effectiveness of the machine using the method of Effectiveness Overall Equipment (OEE). After the values of OEE are known, this research will conduct analysis of six big losses that contained on the machine.

Based on the results of data processing, value attainment of OEE for this Bottomer machine defined under the standard of JIPM, where the highest OEE of this machine only by 74.69%, while the standard that has been set is 85%. The causing factors of OEE's low values are due to the high value of the six big losses. The results of this research indicated that the level of engine malfunction (breakdown) and reduced speed losses of this machine are the biggest factors causing low OEE value in Bottomer machine.

Keywords: Overall Equipment Effectiveness (OEE), Total Productive Maintenance (TPM), Six Big Losses