

ABSTRACT

This study aims to analyze the causes of not achieving the effectiveness of the Rolling Machine as indicated by the standard OEE World Class values.. After it is known that the biggest contributor to loss time in each loss is caused by production equipment that lacks maintenance and is damaged so that it hampers the production process and the many machines that die due to the absence of repair (goods) so that it can disrupt the running of the production process. The company must arrange preventive maintenance activities according to the schedule and update the history of changing tools on the Rolling Machine. The production and maintenance division must provide training or training regarding the working system of Rolling Machines so that technicians and operator have the ability. In the research in February, March and April, it was stated that the OEE value of rolling machines was affected on average by 82.48% Availability, 61.85% Performance, and 89.95% Quality. The average OEE score is 45.32% so that World Class standards have not been achieved. Based on the results of data processing, Six Big Losses were dominant on Rolling Machines for the period February, March and April 2023, namely Reduced Speed Losses had an average of 18.17% and Breakdown Losses had a total value of 15.67% The lack of OEE values is analyzed using Six Big Losses, Pareto Diagrams, and Fishbone Diagrams to determine the cause of the problem.

Keywords : OEE, Six Big Losss, Preventive Maintenance, Fishbone Diagram, Pareto Diagram

ABSTRAK

Penelitian ini bertujuan untuk menganalisa penyebab tidak tercapainya efektivitas Mesin Rolling yang ditunjukkan dengan standar nilai *OEE World Class*. Setelah diketahui penyumbang losses time terbesar pada masing-masing losses yang disebabkan karena peralatan produksi yang kurangnya perawatan dan mengalami kerusakan sehingga menghambat proses produksi serta banyaknya Mesin yang mati akibat perbaikan maintenance sehingga dapat mengganggu jalannya proses produksi. Perusahaan harus mengatur kegiatan *preventive maintenance* sesuai dengan jadwal serta update history pergantian tools pada Mesin Rolling. Divisi produksi maupun divisi *maintenance* harus memberikan training atau pelatihan mengenai system kerja Mesin Rolling agar kemampuan teknisi dan operator mumpuni. Pada penelitian bulan Februari, Maret dan April menyebutkan nilai *OEE* mesin Rolling dipengaruhi rata-rata oleh *Availability* 82,48%, *Performance* 61,85%, dan *Quality* 89,95%. Nilai rata-rata *OEE* 45,32% sehingga belum tercapainya standar *World Class*. Berdasarkan hasil pengolahan data *Six Big Losses* yang dominan pada Mesin Rolling periode bulan Februari, Maret dan April 2023 yaitu *Reduced Speed Losses* memiliki rata-rata sebesar 48,53% dan *Breakdown Losses* memiliki total nilai sebesar 15,67%. Kurangnya nilai *OEE* dianalisis menggunakan *Six Big Losses*, *Diagram Pareto*, dan *Diagram Fishbone* untuk mengetahui penyebab masalahnya. Dari pengolahan data yang didapat Langkah perbaikan yang dilakukan Perusahaan.

Kata Kunci : *OEE*, *Six Big Losses*, *Preventive Maintenance*, *Diagram Fishbone*, *Diagram Pareto*

