ABSTRACT

This study aims to measure the value of the effectiveness of equipment, find the root causes of problems and provide suggestions for improvement. The study was conducted on a Draw machine which has the highest breakdown rate. This research begins by measuring the achievement value of overall equipment effectiveness (OEE), then identifying the six big losses that occur. The results showed that the average OEE value on the draw frame was 28.422%, the effectiveness value was classified as very low because the standard OEE value for world-class companies was ideally 85%. The biggest factor influencing the low value of OEE is the performance rate with a factor of six big losses in Equipment Failure Losses of 47.177% of all time losses. The proposed corrective action is to prepare autonomous maintenance equipment, provide training for operators and maintenance technicians as well as supervise operators regarding machine maintenance.

Keywords: OEE, *Six Big Losses, Total Productive Maintenance, Fishbone.*

ABSTRAK

Penelitian ini bertujuan untuk mengukur nilai efektivitas peralatan, mencari akar penyebab masalah dan memberikan usulan perbaikan. Penelitian dilakukan pada mesin *Drawing* yang selama ini memiliki tingkat *breakdown* yang tertinggi. Penelitian ini dimulai dengan mengukur pencapaian nilai *Overall Equipment Efectiviness* (OEE) kemudian mengidentifikasi *six big losses* yang terjadi. Hasil penelitian menunjukan bahwa rata-rata nilai OEE pada mesin *drawing* sebesar 28,422% nilai efektivitas ini tergolong sangat rendah karena standar nilai OEE untuk perusahaan kelas dunia idealnya adalah 85%. Faktor terbesar yang sangat mempengaruhi rendahnya nilai OEE adalah *performance rate* dengan faktor presentase *six big losses* pada *Equipment Failure Losses* sebesar 47,177% dari seluruh *time loss*. Tindakan perbaikan yang diusulkan adalah menyiapkan perlengkapan *autonomus maintenance*, memberikan training bagi operator dan teknisi *maintenance* serta melakukan pengawasan terhadap operator tentang perawatan mesin.

Kata Kunci: OEE, *Six Big Losses, Total Productive Maintenance, Fishbone.*