

ABSTRAK

Untuk meningkatkan produktivitas dan mempertahankan mutu menjadi fokus sebuah industri manufaktur. PT Mayora Indah Tbk menerapkan total *productive maintenance* diharapkan industri mampu menjaga dan memperbaiki kinerja mesin guna mencapai efisiensi dan efektifitas. Mesin TAM merupakan satu satunya mesin packing, jika terjadi kendala pada mesin TAM maka produksi akan sulit dipenuhi. Karena itu dilakukan penelitian yang bertujuan untuk mengetahui bagaimana kondisi *maintenance* dan bagaimana tingkat efektifitas dari mesin TAM serta dapat memberikan rekomendasi yang tepat untuk meningkatkan efektifitas mesin TAM. Dengan menggunakan metode *Overall Equipment Effectiveness* dan *Six Big losses*. Setelah dilakukan penelitian, diperoleh nilai rata-rata *Overall Equipment Effectiveness* sebesar 89%. Nilai *Performance Efficiency* menjadi yang terendah yaitu rata rata nilai sebesar 93% masih jauh dari standar OEE. *Losses* terbesar yang menyebabkan rendahnya nilai OEE tersebut adalah *Reduced speed losses* dengan nilai 14,97% dan *Idling and Minor Stopager Losses* dengan nilai 2,50%. Penyebab besarnya *Losses* terdiri dari factor mesin, manusia, metode, dan material. Untuk mengurangi kerugian tersebut perusahaan harus merevisi dan mengatur kegiatan *preventive maintenence* sesuai dengan jadwal serta *update history* pergantian part pada mesin TAM. *Devisi* produksi maupun *devisi maintenance* harus memberikan training atau pelatihan mengenai sistem kerja mesin TAM agar kemampuan teknisi dan operator mempuni.

Kata kunci: *Overall Equipment Effectiveness, Six Big Losses, Reduced speed losses, Idling and Minor Stopager Losses, Preventive Maintenence.*

ABSTRACT

To increase productivity and maintain quality is the focus of a manufacturing industry. PT Mayora Indah Tbk implements total productive maintenance, it is hoped that the industry will be able to maintain and improve engine performance in order to achieve efficiency and effectiveness. The TAM machine is the only packing machine, if there are problems with the TAM machine, production will be difficult to fulfill. Because of that, a research was carried out which aims to find out how the maintenance conditions are and how the level of effectiveness of the TAM machine is and can provide the right recommendations to increase the effectiveness of the TAM machine. By using the Overall Equipment Effectiveness and Six Big losses method. After doing the research, the average value of Overall Equipment Effectiveness was 89%. The Performance Efficiency score is the lowest, namely the average value of 93% is still far from the OEE standard. The biggest losses that cause the low OEE value are Reduced speed losses with a value of 14.97% and Idling and Minor Stopager Losses with a value of 2.50%. The cause of the magnitude of the loss consists of machine, human, method, and material factors. To reduce these losses, the company must revise and manage preventive maintenance activities according to the schedule and update the history of changing parts on the TAM machine. The production division and maintenance division must provide training or training regarding the working system of the TAM machine so that technicians and operators have the ability.

Keywords: Overall Equipment Effectiveness, Six Big Losses, Reduced speed losses, Idling and Minor Stopager Losses, Preventive Maintenance.