

ABSTRAK

PT. PLT merupakan industri yang bergerak di bidang *flexible packaging*. Hasil produk jadi di PT. PLT yaitu gulungan plastik film dalam bentuk kemasan plastik. Kemasan plastik biasanya digunakan untuk mengemas produk oleh perusahaan penyedia makanan, minuman, sabun, obat-obatan, dan lain lain. Jenis produksi yang dilakukan di PT. PLT adalah *make to order*. (TPM) *Total Productive Maintenance* merupakan kegiatan yang bertujuan untuk memaksimalkan efisiensi penggunaan alat, memanfaatkan sistem pemeliharaan preventif yang dirancang pada semua peralatan. *Six Big Losses* merupakan enam kerugian yang diakibatkan kegagalan peralatan, penyetelan dan penyesuaian, pemalasan dan berhenti kecil, kecepatan berkurang, cacat proses, dan hasil berkurang. Permasalahan yang terjadi adalah penurunan nilai OEE pada mesin *printing rotogravure* dengan seri cerutti 4. Sebab dari penurunan nilai OEE adalah *downtime losses* sebesar 16.865 menit dari total jam kerja 41.760 menit periode Oktober 2021. Penyelesaian masalah dalam penelitian ini menggunakan analisis *Six Big Losses*, dan *Overall Equipment Effectiveness*(OEE) sebagai parameter kesuksesan produktivitas mesin. Hasil setelah dilakukannya perbaikan adalah peningkatan nilai murni waktu kerja mesin cerutti 4, peningkatan nilai rata rata *Overall Equipment Effectiveness*(OEE) sebesar 9,1% , penurunan *downtime losses* sebesar 17% pada periode Juni-Agustus 2022 sebagai bentuk pengendalian peneliti mengusulkan beberapa *checksheet*, *work instruction* dan usulan perbaikan penyimpanan silinder.

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

KARAWANG

ABSTRACT

PT. PLT is an industry engaged in the field of flexible packaging. The results of finished products at PT. PLT is a roll of plastic film in the form of plastic packaging. Plastic packaging is usually used to package products by companies providing food, drinks, soap, medicines, and others. The type of production carried out at PT. PLT is made to order. (TPM) Total Productive Maintenance is an activity that aims to maximize efficiency in the use of tools, utilizing a preventive maintenance system designed for all equipment. The Six Big Losses are the six losses that result from equipment failure, adjustments and adjustments, small idling and stops, reduced speed, process defects, and reduced yields. The problem that occurs is the decrease in the OEE value on the rotogravure printing machine with the Cerutti 4 series. The reason for the decrease in the OEE value is downtime losses of 16,865 minutes from the total working hours of 41,760 minutes for the October 2021 period. Problem-solving in this study uses Six Big Losses analysis and Overall Equipment Effectiveness (OEE) as a parameter of machine productivity success. The results after the repairs were an increase in the pure value of Cerutti 4 machine working time, an increase in the average Overall Equipment Effectiveness (OEE) value of 9.1%, a decrease in downtime losses of 17% in the June period -August 2022 as a form of control the researcher proposes several checksheets, work instructions and suggestions for improving cylinder storage..

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

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