

# Visualisasi Efektifitas Mesin Cetak JCMCO-51, JCMCO-39 dan STV-51 menggunakan Parameter Overall Equipment Effectiveness pada Bulan Juni 2022 di PT. Guardian Pharmatama = Visualization of the Effectiveness of JCMCO-51, JCMCO-39, and STV-51 Tableting Machines using Overall Equipment Effectiveness Parameters in June 2022 at PT. Guardian Pharmatama

Fira Nabilla, author

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## Abstrak

Dalam melakukan peningkatan produktivitas di area kerja PT. Guardian Pharmatama, TPM (Total Productive Maintenance) dapat digunakan sebagai penerapan pemeliharaan. Untuk mengukur tingkat keberhasilan penerapan TPM dapat digunakan metode overall equipment effectiveness (OEE). OEE merupakan cara mengukur tingkat keberhasilan penerapan TPM yang melibatkan 3 aspek utama, yaitu Availability, Performance Efficiency, dan Rate of Quality. Hasil yang visualisasi nilai OEE pada mesin JCMCO-51, JCMCO-39, dan STV-51 menunjukkan bahwa nilai OEE masih dibawah standar JIPM. Faktor yang dapat mempengaruhi OEE adalah nilai Availability, Performance, dan Quality. Pada ketiga mesin cetak, didapatkan nilai Availability dan Performance yang dibawah standar JIPM. Availability dipengaruhi oleh durasi unplanned shutdown, durasi running, dan durasi mesin stop, sedangkan performance dipengaruhi oleh penggunaan speed aktual dibawah speed standar. Rata-rata speed yang digunakan ketiga mesin kurang dari speed standar. Kegiatan over planned shutdown yang terdapat pada hasil visualisasi perhitungan OEE ketiga mesin pada bulan Juli 2022 ini adalah kegiatan 5R dan kegiatan set-up. Penentuan parameter durasi standar dan evaluasi pada kegiatan tersebut diperlukan untuk mengurangi waktu over planned shutdown. Perlu dilakukan evaluasi dan standarisasi durasi kegiatan yang termasuk 5R dan set-up agar dapat mengurangi durasi over planned shutdown secara aktual dan diharapkan dapat meningkatkan efisiensi waktu serta perlunya pengkajian lebih lanjut mengenai perbedaan speed aktual dengan speed standar pada master data.

.....In increasing productivity in the work area of PT. Guardian Pharmatama, TPM (Total Productive Maintenance) can be used as a maintenance application. To measure the level of TPM implementation, the Overall Equipment Effectiveness (OEE) method can be used. OEE is a way to measure the success rate of TPM implementation which involves 3 main aspects, namely Availability, Performance Efficiency, and Rate of Quality. The results of visualizing the OEE value on the JCMCO-51, JCMCO-39, and STV-51 engines show that the OEE value is still below the JIPM standard. Factors that can affect OEE are Availability, Performance, and Quality values. On the three printing machines, the Availability and Performance values were obtained which were below the JIPM standard. Availability is affected by unplanned shutdown duration, running duration, and engine stop duration, while performance is affected by the use of actual speed below the standard speed. The average speed used by the three machines is less than the standard speed. The overplanned shutdown activities contained in the visualization results of the OEE calculations for the three engines in July 2022 are 5R activities and set-up activities. Adjustment of standard duration parameters and evaluation of these activities is needed to shorten the planned stop time. It is necessary to evaluate and standardize the duration of activities including 5R and set-up to reduce the actual planned

shutdown duration and is expected to increase time efficiency and the need for further studies regarding the difference between actual speed and standard speed in the master data.