

## ABSTRAK

PT. Petronika, Adalah salah satu perusahaan yang memproduksi bahan kimia pembantu dalam pembuatan barang-barang plastik. Produk kimia yang di hasilkan ada dua jenis yaitu Dioctyle Phtalate (DOP) dan Diisononyl Phthalate (DINP) kedua produk tersebut memiliki fungsi yang sma namun DINP memiliki kualitas yang lebih baik karna lebih mengkilap dibanding DOP.

Untuk mengetahui tingkat efektifitas mesin di lakukan pengukuran menggunakan metode OEE. Metode OEE memiliki tiga faktor utama dalam OEE yaitu Availability (A), Performance Efficiency (P) dan Quality Product (R). Jika nilai OEE belum memenuhi *ideal* OEE , maka akan dilakukan perhitungan Six big losses, kemudian dilakukan analisis menggunakan diagram fishbone.

Tingkat Efektifitas mesin Hot Oil Circulation Pump, Neutr Feed Pump dan Reaktor Agitator dapat dilihat berdasarkan nilai OEE. Rata-rata nilai OEE mesin Hot Oil Circulation Pum sebesar 69,52 % unttuk mesin Neutr Feed Pum adalah sebesar 80,22% dan untuk mesin Reaktor Agitator sebesar 75,18% hasil dari perbandingan nilai rata-rata OEE dengan nilai *Ideal*OEE ketiga mesin pada fasilitas Reaksi ketiga mesin belum memenuhi nilai *Ideal* OEE. Hasil Six big losses dan analisis fishbone diagram menunjukkan bahwa faktor terbesar yang mempengaruhi ketiga mesin pada fasilitas reaksi tersebut adalah faktor *Equipment failure(Breakdown Loss), Setup adjustment loss dan Reduce Sepeed Loss* permasalahan yang sering terjadi adalah kebocoran body mesin dan motor terbakar serta sering ganti filter.

***Kata Kunci : OEE, Six Big Losses, Fishbone Diagram***

## ABSTRACT

PT. Petronika, is one of the company that produces auxiliary chemicals, In The preparation of Plastic goods . The chemical products produced are of two types, namely Dioctyle Phtalate (DOP) and Diisononyl Phthalate (DINP) both products have the same function but DINP has better quality because it is more shiny than DOP.

To find out the machine's effectiveness level on measuring either using the OEE methods. Oee method has three main factors in the OEE, namely (a) availability, performance efficiency (P) and a quality product (R). If the value of the OEE has not been fulfilled *Ideal* The OEE calculation will be done, then the six major losses, then carried out the analysis with the fish bone diagram.

The level of effectiveness of the Hot Oil Circulation Pump, Neutr Feed Pump and Agitator reactor can be seen in the OEE value. The average value of the OEE the Hot Oil Circulation Pump was 69.52%, Neutr Feed Pump was 80.22% and the agitator reactor was 75.18%, the result of the comparison of OEE mean values with the ideal value of the third OEE engine at the facility The reaction of the three machines has not fulfilled the OEE Ideal value. The results of Six big losses and analysis of fishbone diagrams show that the biggest factor affecting the three machines in the reaction facility is Equipment failure (Breakdown Loss), Setup adjustment loss and Reduce Speed Loss problems that often occur are engine and motorbike body burns and frequent changes filter.

***Keyword: OEE, Six Big Losses, Fishbone diagrams***