

DAFTAR ISI

<u>COVER</u>	i
<u>HALAMAN JUDUL</u>	ii
<u>LEMBAR PENGESAHAN PEMBIMBING</u>	iii
<u>LEMBAR PENGESAHAN PENGUJI</u>	iv
<u>SURAT PERNYATAAN</u>	v
<u>PERSEMBAHAN</u>	vi
<u>HALAMAN MOTTO</u>	vii
<u>KATA PENGANTAR</u>	viii
<u>DAFTAR ISI</u>	x
<u>DAFTAR GAMBAR</u>	xiii
<u>DAFTAR TABEL</u>	xiv
<u>DAFTAR LAMPIRAN</u>	xvii
<u>ABSTRAK</u>	xviii
BAB I PENDAHULUAN	1
1.1 Latar Belakang	1
1.2 Perumusan Masalah	3
1.3 Pembatasan Masalah	3
1.4 Tujuan Penelitian	3
1.5 Manfaat Penelitian	3
1.6 Sistematika Penulisan	4
BAB II TINJAUAN PUSTAKA DAN LANDASAN TEORI	5
2.1 Tinjauan Pustaka	5
2.1.1 Studi Literatur	5
2.2 Landasan Teori	8
2.2.1 Pengertian <i>Maintenance</i>	8
2.2.2 Tujuan <i>Maintenance</i>	10
2.2.3 Jenis-jenis <i>Maintenance</i>	10
2.2.3.1 <i>Planned Maintenance</i> (pemeliharaan terencana)	10
2.2.3.2 <i>Unplanned Maintenance</i> (pemeliharaan tidak terencana)	12

2.2.4 Overall Equipment Effectiveness (OEE)	13
2.2.5 Six Big Losses	16
2.2.5.1 Downtime Losses	17
2.2.5.2 Speed Losses	17
2.2.5.3 Quality Losses	18
2.2.6 Diagram <i>Fishbone</i> (Diagram Sebab Akibat)	19
2.2.6.1 Pengertian	19
2.2.6.2 Tujuan Diagram <i>Fishbone</i> (Diagram Sebab Akibat)	20
2.2.6.3 Manfaat Diagram <i>Fishbone</i> (Diagram Sebab Akibat).....	21
2.2.6.4 Langkah-langkah Diagram <i>Fishbone</i>	21
2.2.6.5 Kelebihan dan Kekurangan Diagram <i>Fishbone</i>	25
2.3 Hipotesis dan Kerangka Teori	25
2.3.1 Hipotesis	25
2.3.2 Kerangka Teori	26
BAB III METODOLOGI PENELITIAN	27
3.1 Pengumpulan Data.....	27
3.2 Teknik Pengumpulan Data	27
3.2.1 Observasi	27
3.2.2 Wawancara	27
3.2.3 Dokumentasi	27
3.3 Pengujian Hipotesa	28
3.4 Metode Analisis	28
3.5 Pembahasan	31
3.6 Penarikan Kesimpulan	31
3.7 Diagram Alir	31
BAB IV HASIL PENEITIAN DAN PEMBAHASAN	33
4.1 Pengumpulan Data.....	33
4.1.1 Gambaran Umum CV Cipta Usaha Mandiri	33
4.1.2 Profil CV Cipta Usaha Mandiri	33
4.1.3 Sistem Produksi	33
4.1.4 Proses Produksi	33

4.1.5 Pengumpulan Data.....	39
4.1.6 Data Produksi	39
4.2 Pengolahan Data	49
4.2.1 Perhitungan Nilai <i>Availability Rate</i>	49
4.2.2 Perhitungan Nilai <i>Performance Rate</i>	53
4.2.3 Perhitungan Nilai <i>Quality Rate</i>	67
4.2.4 Perhitungan OEE.....	72
4.2.5 <i>Six Big Losses</i>	75
4.2.5.1 <i>Breakdown Losses</i>	75
4.2.5.2 <i>Set-up and Adjustmen Time</i>	76
4.2.5.3 <i>Reduce Speed Losses</i>	77
4.2.5.4 <i>Idling And Minor Stoppages Losses</i>	77
4.2.5.5 <i>Reduce Yield Losses</i>	78
4.2.5.6 <i>Process Defect Losses</i>	79
4.3 Analisa dan Interpretasi	81
4.3.1 Analisa <i>Availability Rate</i>	81
4.3.2 Analisa <i>Performance Rate</i>	82
4.3.3 Analisa <i>Quality Rate</i>	85
4.3.4 Analisa OEE	87
4.3.5 Analisa <i>Six Big Losses</i>	90
4.3.6 Analisa <i>Fishbone</i> Diagram (Diagram Sebab Akibat)	91
4.3.7 Interpretasi	93
4.4 Pembuktian Hipotesa	94
4.5 Rekomendasi	94
BAB V PENUTUP	96
5.1 Kesimpulan.....	96
5.2 Saran	96
DAFTAR PUSTAKA	98

LAMPIRAN

DAFTAR GAMBAR

Gambar 1.1 Mesin di Proses Produksi	1
Gambar 2.1 Bentuk Umum dari Diagram Sebab Akibat	20
Gambar 2.2 Kesepakatan permasalahan utama	22
Gambar 2.3 Identifikasi penyebab masalah	23
Gambar 2.4 Kerangka Teori	26
Gambar 3.1 Alur Penelitian	32
Gambar 4.1 Diagram Alur Proses Produksi Kayu Lapis	34
Gambar 4.2 Mesin <i>Jumping saw</i> CV Cipta Usaha Mandiri Temanggung	35
Gambar 4.3 Mesin <i>Double Planner</i> CV Cipta Usaha Mandiri Temanggung	36
Gambar 4.4 Mesin <i>Gangrip saw</i> CV Cipta Usaha Mandiri Temanggung	36
Gambar 4.5 Proses sortir CV Cipta Usaha Mandiri Temanggung	37
Gambar 4.6 Mesin <i>Conveyor</i> CV Cipta Usaha Mandiri Temanggung	37
Gambar 4.7 Mesin <i>Press</i> CV Cipta Usaha Mandiri Temanggung	38
Gambar 4.8 Mesin <i>Cross cut</i> CV Cipta Usaha Mandiri Temanggung	38
Gambar 4.9 <i>Fishbone</i> Diagram <i>Idling and Minor Stoppage Losses</i>	92

DAFTAR TABEL

Tabel 1.2 Data Waktu Kerusakan Mesin Bulan Januari-Juni Tahun 2018	2
Tabel 2.1 <i>Study Literature</i> Penelitian	7
Tabel 2.2 Nilai <i>Overall Equipment Effectiveness</i> (OEE)	16
Tabel 4.1 Pembagian <i>Shift</i> Kerja di CV Cipta Usaha Mandiri	39
Tabel 4.2 Data Kerusakan Mesin Produksi di CV Cipta Usaha Mandiri	39
Tabel 4.3 Data <i>Total Product</i> di CV Cipta Usaha Mandiri.....	40
Tabel 4.4 Data <i>availability time</i> di CV Cipta Usaha Mandiri	40
Tabel 4.5 Data produksi mesin <i>jumping saw</i> di CV Cipta Usaha Mandiri	41
Tabel 4.6 Perhitungan <i>Total Downtime</i> mesin <i>jumping saw</i>	41
Tabel 4.7 Data produksi mesin <i>double planner</i> di CV Cipta Usaha Mandiri	42
Tabel 4.8 Perhitungan <i>Total Downtime</i> mesin <i>double planner</i>	42
Tabel 4.9 Data produksi mesin <i>gangrip saw</i> di CV Cipta Usaha Mandiri	43
Tabel 4.10 Perhitungan <i>Total Downtime</i> mesin <i>gangrip saw</i>	43
Tabel 4.11 Data produksi mesin <i>sortir</i> di CV Cipta Usaha Mandiri	44
Tabel 4.12 Perhitungan <i>Total Downtime</i> mesin <i>sortir</i>	44
Tabel 4.13 Data produksi mesin <i>conveyor</i> di CV Cipta Usaha Mandiri	45
Tabel 4.14 Perhitungan <i>Total Downtime</i> mesin <i>conveyor</i>	45
Tabel 4.15 Data produksi mesin <i>press</i> di CV Cipta Usaha Mandiri	46
Tabel 4.16 Perhitungan <i>Total Downtime</i> mesin <i>press</i>	46
Tabel 4.17 Data produksi mesin <i>cross cut</i> di CV Cipta Usaha Mandiri	47
Tabel 4.18 Perhitungan <i>Total Downtime</i> mesin <i>cross cut</i>	47
Tabel 4.19 Perhitungan <i>Availability Rate</i> mesin <i>jumping saw</i>	49
Tabel 4.20 Perhitungan <i>Availability Rate</i> mesin <i>double planner</i>	50
Tabel 4.21 Perhitungan <i>Availability Rate</i> mesin <i>gangrip saw</i>	50
Tabel 4.22 Perhitungan <i>Availability Rate</i> mesin <i>sortir</i>	51
Tabel 4.23 Perhitungan <i>Availability Rate</i> mesin <i>conveyor</i>	51
Tabel 4.24 Perhitungan <i>Availability Rate</i> mesin <i>press</i>	52

Tabel 4.25 Perhitungan <i>Availability Rate</i> mesin <i>cross cut</i>	52
Tabel 4.26 Perhitungan % jam kerja mesin <i>jumping saw</i>	53
Tabel 4.27 Perhitungan % jam kerja mesin <i>double planner</i>	54
Tabel 4.28 Perhitungan % jam kerja mesin <i>gangrip saw</i>	54
Tabel 4.29 Perhitungan % jam kerja mesin <i>sortir</i>	55
Tabel 4.30 Perhitungan % jam kerja mesin <i>conveyor</i>	55
Tabel 4.31 Perhitungan % jam kerja mesin <i>press</i>	56
Tabel 4.32 Perhitungan % jam kerja mesin <i>cross cut</i>	56
Tabel 4.33 Perhitungan <i>cycle time</i> mesin <i>jumping saw</i>	57
Tabel 4.34 Perhitungan <i>cycle time</i> mesin <i>double planner</i>	57
Tabel 4.35 Perhitungan <i>cycle time</i> mesin <i>gangrip saw</i>	58
Tabel 4.36 Perhitungan <i>cycle time</i> mesin <i>sortir</i>	58
Tabel 4.37 Perhitungan <i>cycle time</i> mesin <i>conveyor</i>	59
Tabel 4.38 Perhitungan <i>cycle time</i> mesin <i>press</i>	59
Tabel 4.39 Perhitungan <i>cycle time</i> mesin <i>cross cut</i>	60
Tabel 4.40 Perhitungan <i>ideal cycle time</i> mesin <i>jumping saw</i>	60
Tabel 4.41 Perhitungan <i>ideal cycle time</i> mesin <i>double planner</i>	61
Tabel 4.42 Perhitungan <i>ideal cycle time</i> mesin <i>gangrip saw</i>	61
Tabel 4.43 Perhitungan <i>ideal cycle time</i> mesin <i>sortir</i>	62
Tabel 4.44 Perhitungan <i>ideal cycle time</i> mesin <i>conveyor</i>	62
Tabel 4.45 Perhitungan <i>ideal cycle time</i> mesin <i>press</i>	63
Tabel 4.46 Perhitungan <i>ideal cycle time</i> mesin <i>cross cut</i>	63
Tabel 4.47 Perhitungan <i>Performance Rate</i> mesin <i>jumping saw</i>	64
Tabel 4.48 Perhitungan <i>Performance Rate</i> mesin <i>double planner</i>	64
Tabel 4.49 Perhitungan <i>Performance Rate</i> mesin <i>gangrip saw</i>	65
Tabel 4.50 Perhitungan <i>Performance Rate</i> mesin <i>sortir</i>	65
Tabel 4.51 Perhitungan <i>Performance Rate</i> mesin <i>conveyor</i>	66
Tabel 4.52 Perhitungan <i>Performance Rate</i> mesin <i>press</i>	66
Tabel 4.53 Perhitungan <i>Performance Rate</i> mesin <i>cross cut</i>	67
Tabel 4.54 Perhitungan <i>Quality Rate</i> mesin <i>jumping saw</i>	68
Tabel 4.55 Perhitungan <i>Quality Rate</i> mesin <i>double planner</i>	68

Tabel 4.56 Perhitungan <i>Quality Rate</i> mesin <i>gangrip saw</i>	69
Tabel 4.57 Perhitungan <i>Quality Rate</i> mesin <i>sortir</i>	69
Tabel 4.58 Perhitungan <i>Quality Rate</i> mesin <i>conveyor</i>	70
Tabel 4.59 Perhitungan <i>Quality Rate</i> mesin <i>press</i>	70
Tabel 4.60 Perhitungan <i>Quality Rate</i> mesin <i>cross cut</i>	71
Tabel 4.61 Perhitungan OEE mesin <i>jumping saw</i>	72
Tabel 4.62 Perhitungan OEE mesin <i>double planner</i>	72
Tabel 4.63 Perhitungan OEE mesin <i>gangrip saw</i>	73
Tabel 4.64 Perhitungan OEE mesin <i>sortir</i>	73
Tabel 4.65 Perhitungan OEE mesin <i>conveyor</i>	74
Tabel 4.66 Perhitungan OEE mesin <i>press</i>	74
Tabel 4.67 Perhitungan OEE mesin <i>cross cut</i>	75
Tabel 4.68 Perhitungan <i>Breakdown Losses</i> mesin <i>double planner</i>	76
Tabel 4.69 Perhitungan <i>Set-up and Adjustment Time</i> mesin <i>double planner</i>	76
Tabel 4.70 Perhitungan <i>Reduce Speed Losses</i> mesin <i>double planner</i>	77
Tabel 4.71 Perhitungan <i>Idling and Minor Stoppage Losses</i>	78
Tabel 4.72 Perhitungan <i>Reduce Yield Losses</i> mesin <i>double planner</i>	78
Tabel 4.73 Perhitungan <i>Process Defect Losses</i> mesin <i>double planner</i>	79
Tabel 4.74 Rekapitulasi Data Perhitungan <i>Six Big Losses</i>	79
Tabel 4.75 Rekapitulasi <i>Time Losses Six Big Losses</i>	80

DAFTAR LAMPIRAN