ABSTRACT

PT Sanbe Farma Cimareme Unit III is one of the manufacturing industry engaged in the pharmacy that produces infusion. R125 machine is one of the filling machine of 500 ml infusion products that must always be ready to use because it will affect production targets and company revenue. Due to the high frequency of failure on the R125 machine in 2017 of 184 times failures causing the low value of machine effectiveness, it is necessary to implement activities that can improve the effectiveness of R125 machine. In this research the activity to be applied is Total Productive Maintenance (TPM) which aims to improve the effectiveness of R125 machine. Prior to implementing TPM, firstly done the analysis by using Overall Equipment Effectiveness (OEE) method to analyze the existing condition of R125 machine effectiveness. Based on the calculation of R125 machine effectiveness in the period of January-December 2017 using OEE method obtained OEE value of 13.847%. The value of the OEE has not reached the standard of World Class Standards at 85%. Then do analysis of Six big loss that cause low value of OEE. Factors of Six big loss that most affect the value of OEE on machine 125 is Idling and Minor Stoppage Loss and Set-up and Adjustment Loss which is equal to 42.68% and 28.16% of the total Six big Loss. Then do analysis by using a cause-effect diagram (fish bone) to determine the cause of the occurrence of Six big loss factors that most affect the value of OEE by considering the human factors, environment, methods, materials / spareparts, and machinery.

Keywords : Total Productive Maintenance (TPM), Overall Equipment Effectiveness (OEE), Effectiveness, Cause-Effect Diagram (Fish Bone), Downtime.