

## ABSTRACT

Performance in production can affect how well the results are produced. At PT XYZ which is engaged in the food sector it is very important to produce products in accordance with existing standards before being traded. One of them is the production of product X, to get optimal results requires a good performance in the production itself. Where do the evaluation and increase the performance of machines on the production line of product X.

To do the evaluation here using the Overall Equipment Effectiveness (OEE) method and then proceed with the Overall Throughput Effectiveness (OTE). The purpose of this study is to measure the effectiveness and overall performance of the production system of product X, and to determine the losses generated in the production process with six big losses. The OTE calculation here is based on factory-level subsystems in the company itself and by comparing actual productivity with productivity that can be achieved. Whereas OEE is a measurement of effectiveness by multiplying the availability rate, performance efficiency, and quality rate.

From this research, the average OEE value for the entire production line of product X is 87.38% with the lowest OEE value on the E machine and the OTE value is 85.5%. With OTE values still below the company's standards, further calculations are carried out to determine the dominant losses with six big losses. Where the effectiveness of the engine is affected by two losses, namely idling and minor stoppages loss and reduced speed loss.

With OTE values that are still below the company's standards, further research needs to be done on the calculation of six big losses. For knowing what factors influence the dominant losses in the production process with fishbone diagram analysis.

Keywords: Overall Equipment Effectiveness, Overall Throughput Effectiveness, Six Big Losses