

## **ABSTRACT**

*Heating group is one of the important components that can affect the entire process of washing steel strips using HCL with concentration 33% which is heated until 85°C on the Continuous Pickling Line at PT. Krakatau Steel. On the Continuous Pickling Line, there are 11 heating groups that have not prepared their maintenance procedures. Therefore, it will be explain about making maintenance procedures on the heating group to avoid damage, So it will be work optimally.*

*There are several steps in the process of making maintenance procedures. It starts from preparing tools and materials, observing and collecting data by making observations directly in the field & collecting data in the form of catalogs, LPPM, Item Master Card (Characteristic), and manual books that are able to provide accurate data as guidelines for making maintenance procedures, applying procedures maintenance in the field, analyzing the heating group's performance after maintenance procedures are implemented.*

*The maintenance procedures that have been prepared by the observer are issued in the form of Standard Operating Procedure (SOP), Daily Checklist, and Job Ticket Stop. The applied maintenance system to the heating group is a preventive maintenance system that always do every day and every two weeks. Maintenance procedures that are implemented properly and correctly can help the heating group to avoid damage.*

*Keywords : heating group, heat exchanger, job ticket stop, daily checklist, maintenance*

## INTISARI

*Heating group* adalah salah satu komponen penting yang dapat mempengaruhi keseluruhan proses pencucian *strip* baja menggunakan HCL dengan konsentrasi 33% yang dipanaskan hingga suhu 85°C pada *Continuous Pickling Line* di PT. Krakatau Steel. Pada *Continuous Pickling Line*, terdapat 11 *heating group* yang belum disiapkan prosedur *maintenance* nya. Oleh karena itu, akan dibahas mengenai pembuatan prosedur *maintenance* pada *heating group* agar terhindar dari kerusakan serta dapat bekerja dengan optimal .

Terdapat beberapa langkah dalam proses pembuatan prosedur *maintenance* yang dilakukan. Dimulai dari menyiapkan alat dan bahan, observasi dan pengumpulan data dengan melakukan pengamatan secara langsung di lapangan & mengumpulkan data berupa katalog, LPPM, *Item Master Card (Characteristic)*, dan *manual book* yang mampu memberikan data yang akurat sebagai pedoman pembuatan prosedur *maintenance*, mengaplikasikan prosedur *maintenance* di lapangan, menganalisa kinerja *heating group* setelah diterapkan prosedur *maintenance*.

Prosedur *maintenance* yang telah disusun oleh penulis dikeluarkan dalam bentuk *Standard Operating Procedure (SOP)*, *Daily Checklist*, dan *Job Ticket Stop*. Sistem *maintenance* yang diterapkan pada *heating group* adalah sistem *preventive maintenance* yang dilakukan setiap hari dan setiap dua minggu sekali. Prosedur *maintenance* yang diterapkan secara baik dan benar dapat menyebabkan *heating group* terhindar dari kerusakan.