

**ANALISIS EFEKTIVITAS MESIN PRESS MANUAL MENGGUNAKAN  
METODE *OVERALL EQUIPMENT EFFECTIVENESS* (OEE) PADA  
PRODUKSI TEMBAKAU DI GUDANG WEDIBIRIT PT PERKEBUNAN  
NUSANTARA X, KLATEN, JAWA TENGAH**

Oleh :

Hafidh Alauddin Budiono, Satria Bhirawa Anoraga, Iman Sabarisman, Ratih

Hardiyanti

**ABSTRAK**

PT Perkebunan Nusantara X merupakan perusahaan yang bergerak dalam bidang pengolahan tembakau, khususnya pengolahan tembakau jenis VBN. PTPN X hanya menggunakan mesin pres manual dalam proses produksinya. Tujuan penelitian ini adalah untuk mengetahui efektivitas mesin Press Manual serta mengetahui *Six big losses* yang paling dominan. *Overall Equipment Effectiveness* (OEE) adalah salah satu metode untuk menentukan tingkat keefektifan penggunaan mesin atau peralatan. OEE dikenal sebagai salah satu aplikasi program dari *Total Productive Maintenance* (TPM). Metode penelitian yang dilakukan oleh penulis menggunakan penelitian kuantitatif. Teknik pengumpulan data yaitu observasi partisipatori, wawancara, dan dokumentasi. Analisis ini menemukan bahwa hasil rata-rata OEE Mesin Press Manual PTPN X sebesar 76% rendahnya nilai *Quality Rate* dipengaruhi oleh banyaknya *Rework Product* yang memiliki nilai sebesar 20% dengan presentase terhadap *Losses* lainnya sebesar 87%. Usaha perbaikan yang perlu dilakukan adalah dengan pendataan mesin, perbaikan mesin dan penambahan mesin press baru, serta meningkatkan kualitas dan kuantitas *output* melalui optimasi proses produksi tembakau, dan mengurangi kemungkinan *Six big losses*.

Kata kunci: *Availability Rate, OEE, Performance Rate, Quality Rate, Six big losses*.

**EFFECTIVENESS ANALISYS OF MANUAL PRESS MACHINE USING  
OVERALL EQUIPMENT EFFECTIVENESS (OEE) METHOD ON  
TOBACCO PRODUCTION AT WEDIBIRIT WAREHOUSE PT  
PERKEBUNAN NUSANTARA X, KLATEN, CENTRAL JAVA**

By :

Hafidh Alauddin Budiono, Satria Bhirawa Anoraga, Iman Sabarisman, Ratih  
Hardiyanti

**ABSTRACT**

PT Perkebunan Nusantara X is a company engaged in the field of tobacco processing, especially processing of VBN type of tobacco. PTPN X uses manual press machines in its production process. The purpose of this research was to find out the effectiveness of the Manual Press Machine and find out the most dominant of the Six big losses. Overall Equipment Effectiveness (OEE) is a method for determine the effectiveness of the use of a machine or equipment. OEE was known as one of the application programs from Total Productive Maintenance (TPM). The research method conducted by the author was included as a quantitative research. The data collection techniques were participatory observation, interviews, and documentation. From the analysis, it found that the average result of OEE for PTPN X Manual Press Machine was 76%, the low value of Quality Rate was influenced by the number of Rework Products that had a value are 20% with a percentage of other Losses by 87%. PTPN needs to do some improvement regarding the recording machines, repairing machines, adding new press machines, increase the quality and quantity of output through optimization of the tobacco production process, and further reduce the possibility of Six big losses.

Keywords: Avalibility Rate, OEE, Performance Rate, Quality Rate, Six big losses.