

**PENILAIAN EFEKTIVITAS MESIN PENERING VAKUM  
PRODUK *CHOCOLATE MILK* DAN *MALT POWDER* DENGAN  
METODE *OVERALL EQUIPMENT EFFECTIVENESS* (OEE)  
DI PT XYZ TANGERANG, BANTEN  
MAGANG**

**Martono Dwi Saputro<sup>1</sup>, Pujo Saroyo<sup>2</sup>, Satria Bhirawa Anoraga<sup>3</sup>, Suharno<sup>4</sup>**

Program Studi Agroindustri, Departemen Teknologi Hayati dan Veteriner,

Sekolah Vokasi, Universitas Gadjah Mada

Email : [1martonodwi99@mail.ugm.ac.id](mailto:1martonodwi99@mail.ugm.ac.id)

**RANGKUMAN**

PT XYZ *divisi health food* salah satu divisi yang terintegrasi dengan PT XYZ sebagai penyuplai bahan baku utama dan tambahan produk bubuk atau “*powder*” yang berlokasi di kecamatan Batu Ceper, Kota Tangerang, Banten. Proses produksi terbagi menjadi 2 *line* untuk produksi *malt powder* dan *chocolate milk powder*. Proses produksi dimulai dari ruang gudang *raw material* (GDRM) sebagai proses awal penyimpanan sebelum bahan baku di proses, dilanjutkan proses formulasi untuk menimbang resep bahan baku, ruang produksi, ruang pengayakan dan pengemasan, terakhir produk di transfer menuju gudang *finish good* (GDFG). Penelitian ini bertujuan untuk mengetahui masalah utama yang terjadi pada proses produksi dimana *achievement* produksi yang dilaporkan selalu tidak mencapai target disebabkan mesin *vacum dryer* yang digunakan bermasalah. Analisis permasalahan dengan menghitung seberapa efektif mesin produksi *vacum dryer* selama proses produksi berlangsung menggunakan metode *Overall equipment effectiveness* (OEE). Hasil penelitian menunjukkan bahwa komponen *Performace ratio* merupakan komponen yang perlu untuk dilakukan perbaikan diperkuat dengan nilai *six big losses* didapatkan nilai *Reduce speed* yang tinggi pada mesin *vacum dryer* (VD 1) sebanyak 24,1 % dan *vacum dryer* 2 (VD 2) 9,85 %. Hasil analisis FMEA menunjukkan bahwa nilai *Risk priority number* (RPN) penyebab kegagalan terbesar dengan nilai 80 yaitu *Breaker trip* dan selang alfa goma rusak. Berdasarkan hasil ini perlu untuk dilakukan perbaikan terkait dengan komponen *Six big losses* terutama *Reduce speed* dan penyebab utama terjadinya permasalahan tersebut.

Kata Kunci : *Chocolate milk powder*, *Malt powder*, *Overall equipment effectiveness* (OEE), *Reduce speed*

**ANALYSIS OF EFFECTIVENESS VACUUM DRYING MACHINE  
MILK CHOCOLATE AND MALT POWDER USING  
OVERALL EQUIPMENT EFFECTIVENESS (OEE) METHOD  
IN PT XYZ TANGERANG, BANTEN  
(INTERNSHIP)**

**Martono Dwi Saputro<sup>1</sup>, Pujo Saroyo<sup>2</sup>, Satria Bhirawa Anoraga<sup>3</sup>, Suharno<sup>4</sup>**

Program Studi Agroindustri, Departemen Teknologi Hayati dan Veteriner,

Sekolah Vokasi, Universitas Gadjah Mada

Email : [1martonodwi99@mail.ugm.ac.id](mailto:1martonodwi99@mail.ugm.ac.id)

**SUMMARY**

*PT XYZ health food division is one of the divisions that integrated with “PT XYZ” as a supplier of main raw materials and additional powder products located in Batu Ceper sub-district, Tangerang City, Banten. The production process is divided into 2 lines for the production of malt powder and chocolate milk powder. The production process starts from the raw material warehouse (GDRM) area as the initial storage process before the raw material is processed, followed by the formulation process to weigh raw material recipes, production area, sifting and packaging area, and finally the product is transferred to the finished good warehouse (GDFG). This study aims to determine the main problems that occur in the production process where the reported production achievement always does not reach the target due to the vacuum dryer machine used in trouble. Analysis of the problem by calculating how effective the vacuum dryer production machine during the production process takes place using the Overall equipment effectiveness (OEE) method. The results showed that the Performace ratio is a component that needs to be repaired, strengthened by the value of six big losses obtained a high reduce speed value on the vacuum dryer (VD 1) of 24.1% and vacuum dryer (VD 2) 9.85% . The results of FMEA analysis showed that the value of Risk priority number (RPN) was the biggest cause of failure with a value of 80, it is called Breaker trip and damaged alfaboma tube. Based on these results it is necessary to make improvements related to the six big losses component, especially reduce speed and the main cause of the problem.*

**Keywords:** *Chocolate milk powder, Malt powder, Overall equipment effectiveness (OEE), Reduce speed*