

Lampiran 2 Data Availability, Performance dan Quality per Bulan

Data Availability

Tabel Lampiran 2.1 Rekapitulasi Data *Availability*.

Bulan	Waktu yang Tersedia	Waktu Mesin Berhenti	Waktu Mesin Beroperasi	<i>Avaibility</i>
1	630	170	460	73%
2	630	160	470	75%
3	630	190	440	70%
4	630	180	450	71%
5	630	150	480	76%
6	630	200	430	68%
7	630	170	460	73%
8	630	216	445	66%
9	630	211	470	67%
10	630	195	435	69%
11	630	155	475	75%
Average	630	182	456	71%

Data Performance

Tabel Lampiran 2.2 Data Pendukung

PC1250-8R	Nilai	Satuan
<i>Bucket Capacity</i>	6,7	m
<i>Bucket Capacity</i>	5,6	m
<i>Fill Factor</i>	1,1	
<i>Efisiensi Kerja Alat</i>	0,8	%
<i>Cycle Time Plan</i>	32	s
<i>Cycle Time Actual</i>	30	s

Tabel Lampiran 2.3 Rekapitulasi Data *Performance*

Bulan	Jumlah Produksi	Actual Production Rate	Waktu Mesin Beroperasi	Performance
1	166.466	362	460	55%
3	161.300	343	470	52%
4	138.436	315	440	47%
5	136.083	302	450	46%
7	146.198	305	480	46%
8	155.729	362	430	55%
9	115.993	252	460	38%
10	114.640	258	445	39%
11	154.309	328	470	49%
Average	147.422	456	323	49%

Data Rate of Quality

Tabel Lampiran 2.4 Rekapitulasi Data *Rate of Quality*

Bulan	Jumlah Produksi	Reduced Yield	Jumlah Cacat Produksi	Rate of Quality
1	166.466	0	0	100%
3	161.300	0	0	100%
4	138.436	0	0	100%
5	136.083	0	0	100%
7	146.198	0	0	100%
8	155.729	0	0	100%
9	115.993	0	0	100%
10	114.640	0	0	100%
11	154.309	0	0	100%
Average	147.422	0	0	100%

**Lampiran 3 Data *Overall Equipment Effectiveness (OEE)*
dan Data Six Big Losses**

Data *Overall Equipment Effectiveness (OEE)*

Tabel Lampiran 3.1 Rekapitulasi Data *OEE*

Bulan	<i>Availability</i>	<i>Performance</i>	<i>Rate of Quality</i>	OEE
1	73%	55%	100%	40%
3	75%	52%	100%	39%
4	70%	47%	100%	33%
5	71%	46%	100%	33%
7	76%	46%	100%	35%
8	68%	55%	100%	37%
9	73%	38%	100%	28%
10	66%	39%	100%	26%
11	67%	49%	100%	33%
Average	71%	49%	100%	35%

Data Six Big Losses

Tabel Lampiran 3.2 Rekapitulasi Data *SBL*

Bulan	<i>Downtime Loss</i>	
	<i>Equipment Failure Losses</i>	<i>Setup & Adjustment</i>
	%	%
1	12%	5%
3	10%	5%
4	16%	5%
5	14%	5%
7	8%	5%
8	10%	5%
9	12%	5%
10	19%	5%
11	15%	5%
Average	14%	5%

Data Six Big Losses

Tabel Lampiran 3.3 Rekapitulasi Data *SBL*

Bulan	<i>Speed Loss</i>	
	<i>Idling & Minor Stoppage</i>	<i>Reduced Speed</i>
	%	%
1	10%	6%
3	10%	6%
4	9%	6%
5	10%	6%
7	11%	6%
8	17%	6%
9	10%	6%
10	10%	6%
11	13%	6%
Average	11%	6%

Data Six Big Losses

Tabel Lampiran 3.4 Rekapitulasi Data *SBL*

Bulan	Quality Loss	
	Defect & Rework	Reduced Yield
	%	%
1	0%	0%
3	0%	0%
4	0%	0%
5	0%	0%
7	0%	0%
8	0%	0%
9	0%	0%
10	0%	0%
11	0%	0%
Average	0%	0%

