

Tabel Data – Data Downtime Bulan Februari 2018( Dalam Menit)

Jenis - Jenis Downtime													
Tanggal	Kertas Putus	Mesin Rusak	Tempat Penuh	Ganti lebar	Penanganan material cacat	Bahan Kurang + Pasang	6R/6S	Persiapan Produksi	Hot Plate kotor	order habis	Istirahat bersama	tunggu steam uap	Setting Scor Manual
1-Feb-18	33	18		20	4								
2-Feb-18			263	20	11						90		
3-Feb-18	37		50	10		3	18						
4-Feb-18													
5-Feb-18	38	4		10	7			10	5				
6-Feb-18				28		4			3	519			
7-Feb-18	25	9		20	2	4		10					
8-Feb-18	37			10	5								
9-Feb-18	27	5		20	4	5					90		
10-Feb-18				10		5	20		3				
11-Feb-18													
12-Feb-18	27	46		20	4	7		10	5				
13-Feb-18	26			20	3				9				
14-Feb-18	29	50		20									
15-Feb-18	29		115	20		7							

Tabel Data – Data Downtime Bulan Februari 2018 (Lanjutan) (Dalam Menit)

16-Feb-18											90		
17-Feb-18			100	10		3	15						
18-Feb-18													
19-Feb-18		6			3	9			10			50	
20-Feb-18	29	5		20	8	5			4				
21-Feb-18	26	6		20	8	4			4				
22-Feb-18	28	16		10		9			5				
23-Feb-18	30			20	4	3			5		90		
24-Feb-18	28			10			25						5
25-Feb-18													
26-Feb-18	32	14		20		9			3				
27-Feb-18	29	12		13	4	12							
28-Feb-18	27	200		30		4			13				
TOTAL	537	391	528	381	67	93	78	30	69	519	360	50	5

Tabel Data – Data Downtime Bulan Maret 2018 (Dalam Menit)

Jenis - Jenis Downtime												
Tanggal	Kertas Putus	Mesin Rusak	Tempat Penuh	Ganti lebar	Penanganan material cacat	Bahan kurang + Pasang	GR/6S	Persiapan Produksi	Membersihkan Hot plate kotor	Order Habis	Istirahat bersama	Setting skor manual
1-Mar-18	19	265		18	10							
2-Mar-18		14		10	8				15		90	
3-Mar-18	9		158	10	3		20					
4-Mar-18												
5-Mar-18	13	10		20	3			10	4			
6-Mar-18	2	22		20		3			4			9
7-Mar-18	13			20	5	10						
8-Mar-18	6	2		20	3				5			
9-Mar-18	8	24	133	20		21			5		90	
10-Mar-18	2		144	10	15		15					
11-Mar-18												
12-Mar-18	13	7		10					3			
13-Mar-18		18		20								10
14-Mar-18	9	3		20								
15-Mar-18	8	10		20	3+2	13						
16-Mar-18	7	10		20		5	30		5		90	

Tabel Data – Data Downtime Bulan Maret 2018 (lanjutan) (Dalam Menit)

17-Mar-18												
18-Mar-18												
19-Mar-18	6	62			6+2	13		10				
20-Mar-18	16	167		10	3+							
21-Mar-18	12	70		10				8				
22-Mar-18	20			20	10+2							
23-Mar-18	20			10				3			90	
24-Mar-18	18			10								
25-Mar-18						6						
26-Mar-18	6	45		20		6		10				
27-Mar-18	2	170		10	7							
28-Mar-18	11	140		10	15	5			3			
29-Mar-18	7	3		20	22	3	15					
30-Mar-18												
31-Mar-18	3	42		20	8		20	10				
TOTAL	230	1084	435	378	99	85	100	40	55	0	360	19

Tabel Perhitungan *Availability Ratio* Mesin *Corrugator* Bulan Februari 2018 ( Dalam Menit)

PERHITUNGAN AVAILABILITY RATIO FEBRUARI 2018										
Tanggal	working time manchine	planned downtime	adjustment shift	trouble	setup	waiting	loading time	availability losses	operating time	Availability Ratio (%)
1-Feb-18	1440	0	0	814	20	3	1440	837	603	41.88%
2-Feb-18	1440	0	0	11	20	363	1440	394	1046	72.64%
3-Feb-18	900	90	0	0	10	193	810	203	607	74.94%
4-Feb-18	0	0	0	0	0	0	0	0	0	0.00%
5-Feb-18	1440	0	10	6	18	20	1430	44	1386	96.92%
6-Feb-18	1051	0	0	0	30	7	1051	37	1014	96.48%
7-Feb-18	1440	0	10	7	10	24	1430	41	1389	97.13%
8-Feb-18	1440	0	0	21	20	15	1440	56	1384	96.11%
9-Feb-18	1440	90	0	9	20	10	1350	39	1311	97.11%
10-Feb-18	900	0	0	0	10	28	900	38	862	95.78%
11-Feb-18	0	0	0	0	0	0	0	0	0	0.00%
12-Feb-18	1440	0	10	0	20	65	1430	85	1345	94.06%
13-Feb-18	1440	0	0	3	20	15	1440	38	1402	97.36%
14-Feb-18	1440	0	0	46	20	19	1440	85	1355	94.10%
15-Feb-18	1440	0	0	0	20	189	1440	209	1231	85.49%
16-Feb-18	0	0	0	0	0	0	0	0	0	0.00%
17-Feb-18	900	0	0	0	10	198	900	208	692	76.89%
18-Feb-18	0	0	0	0	0	0	0	0	0	0.00%
19-Feb-18	960	0	10	7	0	71	950	78	872	91.79%
20-Feb-18	1440	0	0	8	20	23	1440	51	1389	96.46%
21-Feb-18	1440	0	0	9	20	27	1440	56	1384	96.11%
22-Feb-18	1440	0	0	85	10	13	1440	108	1332	92.50%
23-Feb-18	1440	90	0	7	20	21	1350	48	1302	96.44%
24-Feb-18	900	0	0	0	20	28	900	48	852	94.67%
25-Feb-18		0	0	0	0	0	0	0	0	0.00%
26-Feb-18	1440	0	10	14	20	32	1430	66	1364	95.38%
27-Feb-18	1440	0	0	0	15	24	1440	39	1401	97.29%
28-Feb-18	1440	0	0	200	20	37	1440	257	1183	82.15%
Rata - Rata										89.55%

Tabel Perhitungan *Availability Ratio* Mesin *Corrugator* Bulan Maret 2018 (Dalam Menit)

PERHITUNGAN AVAILABILITY RATIO MARET 2018										
Tanggal	working time manchine	planned downtime	adjustment shift	trouble	setup	waiting	loading time	availability losses	operating time	Availability Ratio (%)
1-Mar-18	1440	0	0	110	0	137	1440	247	1193	82.85%
2-Mar-18	1440	90	0	15	0	36	1350	51	1299	96.22%
3-Mar-18	900	0	0	0	0	180	900	180	720	80.00%
4-Mar-18	0	0	0	0	0	0	0	0	0	0.00%
5-Mar-18	1440	0	10	2	10	47	1430	59	1371	95.87%
6-Mar-18	1051	0	0	4	33	23	1051	60	991	94.29%
7-Mar-18	1440	0	0	5	20	26	1440	51	1389	96.46%
8-Mar-18	1440	0	0	0	27	6	1440	33	1407	97.71%
9-Mar-18	1440	90	0	33	25	29	1350	87	1263	93.56%
10-Mar-18	900	0	0	35	10	146	900	191	709	78.78%
11-Mar-18	0	0	0	0	0	0	0	0	0	0.00%
12-Mar-18	960	0	10	3	0	10	950	13	937	98.63%
13-Mar-18	1440	0	0	15	33	2	1440	50	1390	96.53%
14-Mar-18	1440	0	0	3	20	9	1440	32	1408	97.78%
15-Mar-18	1440	0	0	13	20	23	1440	56	1384	96.11%
16-Mar-18	1440	90	0	17	10	18	1350	45	1305	96.67%
17-Mar-18	0	0	0	0	0	0	0	0	0	0.00%
18-Mar-18	0	0	0	0	0	0	0	0	0	0.00%
19-Mar-18	1440	0	30	64	0	18	1410	82	1328	94.18%
20-Mar-18	1440	0	0	170	10	16	1440	196	1244	86.39%
21-Mar-18	1440	0	0	60	18	12	1440	90	1350	93.75%
22-Mar-18	1440	0	0	0	20	32	1440	52	1388	96.39%
23-Mar-18	1440	90	0	9	10	14	1350	33	1317	97.56%
24-Mar-18	900	0	20	4	21	23	880	48	832	94.55%
25-Mar-18	0	0	0	0	0	0	0	0	0	0.00%
26-Mar-18	1440	0	10	45	20	12	1430	77	1353	94.62%
27-Mar-18	1440	0	0	144	20	9	1440	173	1267	87.99%
28-Mar-18	1440	0	0	148	10	29	1440	187	1253	87.01%
29-Mar-18	1440	0	15	10	20	21	1425	51	1374	96.42%
30-Mar-18	0	0	0	0	0	0	0	0	0	0.00%
31-Mar-18	900	0	30	42	20	11	870	73	797	91.61%
Rata - Rata										92.88%

Tabel Perhitungan *Performance Ratio* Bulan Februari 2018

Tanggal	Operating time (Menit)	Total Production (Kg)	Stoppage (Menit)	Theoretical cycle time	Net Operating time (Menit)	Performance (%)
1-Feb-18	603	99797	0	1.05	603	173.78
2-Feb-18	1046	80753	0	1.05	1046	81.06
3-Feb-18	607	41012	0	1.05	607	70.94
4-Feb-18	0	0	0	0	0	0.00
5-Feb-18	1386	63348	5	1.05	1381	48.16
6-Feb-18	1014	67789	3	1.05	1011	70.40
7-Feb-18	1389	72001	0	1.05	1389	54.43
8-Feb-18	1384	97905	0	1.05	1384	74.28
9-Feb-18	1311	86693	0	1.05	1311	69.43
10-Feb-18	862	21706	3	1.05	859	26.53
11-Feb-18	0	0	0	0	0	0.00
12-Feb-18	1345	93434	5	1.05	1340	73.21
13-Feb-18	1402	110098	9	1.05	1393	82.99
14-Feb-18	1355	95173	0	1.05	1355	73.75
15-Feb-18	1231	89448	0	1.05	1231	76.30
16-Feb-18	0	0	0	0	0	0.00
17-Feb-18	692	49071	0	1.05	692	74.46
18-Feb-18	0	0	0	0	0	0.00
19-Feb-18	872	51011	10	1.05	862	62.14
20-Feb-18	1389	112226	4	1.05	1385	85.08
21-Feb-18	1384	93480	4	1.05	1380	71.13
22-Feb-18	1332	101274	5	1.05	1327	80.13
23-Feb-18	1302	99710	5	1.05	1297	80.72
24-Feb-18	852	63818	0	1.05	852	78.65
25-Feb-18	0	0	0	0	0	0.00
26-Feb-18	1364	97750	3	1.05	1361	75.41
27-Feb-18	1401	91017	0	1.05	1401	68.21
28-Feb-18	1183	79294	13	1.05	1170	71.16
Rata - rata						74.89

Tabel Perhitungan *Performance Ratio* Bulan Maret 2018

Tanggal	Operating time (Menit)	Total Production (Kg)	Stoppage (Menit)	Theoretical cycle time	Net Operating time (Menit)	Performance (%)
1-Mar-18	1193	89,943	0	1.05	1193	79.16
2-Mar-18	1299	94,765	15	1.05	1284	77.49
3-Mar-18	720	42,448	0	1.05	720	61.90
4-Mar-18	0	0	0	0	0	0.00
5-Mar-18	1371	103,705	4	1.05	1367	79.66
6-Mar-18	991	103,432	4	1.05	987	110.03
7-Mar-18	1389	103,343	0	1.05	1389	78.12
8-Mar-18	1407	105,031	5	1.05	1402	78.66
9-Mar-18	1263	82,353	5	1.05	1258	68.74
10-Mar-18	709	50,358	0	1.05	709	74.58
11-Mar-18	0	0	0	0	0	0.00
12-Mar-18	937	65,979	0	1.05	937	73.94
13-Mar-18	1390	84,672	0	1.05	1390	63.96
14-Mar-18	1408	108,269	0	1.05	1408	80.74
15-Mar-18	1384	101,252	0	1.05	1384	76.82
16-Mar-18	1305	109,547	5	1.05	1300	88.48
17-Mar-18	0	0	0	0	0	0.00
18-Mar-18	0	0	0	0	0	0.00
19-Mar-18	1328	96,353	0	1.05	1328	76.18
20-Mar-18	1244	95,423	0	1.05	1244	80.54
21-Mar-18	1350	101,269	8	1.05	1342	79.23
22-Mar-18	1388	108,291	0	1.05	1388	81.92
23-Mar-18	1317	106,308	3	1.05	1314	84.95
24-Mar-18	832	101,929	0	1.05	832	128.64
25-Mar-18	0	0	0	0	0	0.00
26-Mar-18	1353	86,753	0	1.05	1353	67.32
27-Mar-18	1267	90,781	0	1.05	1267	75.23
28-Mar-18	1253	92,658	3	1.05	1250	77.83
29-Mar-18	1374	96,439	0	1.05	1374	73.70
30-Mar-18	0	0	0	0	0	0.00
31-Mar-18	797	65,956	0	1.05	797	86.89
Rata - rata						80.19



Tabel Pertitungan *Quality Ratio* Bulan Februari 2018

PERHITUNGAN QUALITY RATIO FEBRUARI 2018			
Tanggal	Total production (Kg)	Total Defect (Kg)	Quality Ratio (%)
1-Feb-18	99,797	1503.57	98.49%
2-Feb-18	80,753	756.34	99.06%
3-Feb-18	41,012	780.01	98.10%
4-Feb-18	0	0	0.00%
5-Feb-18	63,348	205.57	99.68%
6-Feb-18	67,789	650.34	99.04%
7-Feb-18	72,001	286.86	99.60%
8-Feb-18	97,905	942.82	99.04%
9-Feb-18	86,693	753.89	99.13%
10-Feb-18	21,706	201.53	99.07%
11-Feb-18	0	0	0.00%
12-Feb-18	93,434	765.21	99.18%
13-Feb-18	110,098	841.27	99.24%
14-Feb-18	95,173	862.28	99.09%
15-Feb-18	89,448	1003.49	98.88%
16-Feb-18	0	0	0.00%
17-Feb-18	49,071	14.63	99.97%
18-Feb-18	0		0.00%
19-Feb-18	51,011	500.31	99.02%
20-Feb-18	112,226	1009.3	99.10%
21-Feb-18	93,480	1742.9	98.14%
22-Feb-18	101,274	1732.86	98.29%
23-Feb-18	99,710	732.89	99.26%
24-Feb-18	63,818	602.87	99.06%
25-Feb-18	0	0	0.00%
26-Feb-18	97,750	1000.98	98.98%
27-Feb-18	91,017	856.34	99.06%
28-Feb-18	79,294	92.49	99.88%
Rata - Rata			99.06%

Tabel Perhitungan *Quality Ratio* Bulan Maret 2018

PERHITUNGAN QUALITY RATIO MARET 2018			
Tanggal	Total production (Kg)	Total Defect (Kg)	Quality Ratio (%)
1-Mar-18	89,943	866.18	99.04%
2-Mar-18	94,765	1037.2	98.91%
3-Mar-18	42,448	400.21	99.06%
4-Mar-18	0	0	0.00%
5-Mar-18	103,705	1000.42	99.04%
6-Mar-18	103,432	1087.86	98.95%
7-Mar-18	103,343	876.21	99.15%
8-Mar-18	105,031	865.67	99.18%
9-Mar-18	82,353	800.21	99.03%
10-Mar-18	50,358	664.88	98.68%
11-Mar-18	0	0	0.00%
12-Mar-18	65,979	646.89	99.02%
13-Mar-18	84,672	732.01	99.14%
14-Mar-18	108,269	1069.39	99.01%
15-Mar-18	101,252	854.32	99.16%
16-Mar-18	109,547	1143.06	98.96%
17-Mar-18	0	0	0.00%
18-Mar-18	0	0	0.00%
19-Mar-18	96,353	1443.56	98.50%
20-Mar-18	95,423	876.31	99.08%
21-Mar-18	101,269	634.49	99.37%
22-Mar-18	108,291	901.98	99.17%
23-Mar-18	106,308	1301.49	98.78%
24-Mar-18	101,929	1790.22	98.24%
25-Mar-18	0	0	0.00%
26-Mar-18	86,753	765.32	99.12%
27-Mar-18	90,781	891.17	99.02%
28-Mar-18	92,658	900.21	99.03%
29-Mar-18	96,439	843.21	99.13%
30-Mar-18	0	0	0.00%
31-Mar-18	65,956	298.6	99.55%
Rata - Rata			99.01%

Tabel Perhitungan *Overall Equipment Effectiveness* Bulan Februari 2018

Perhitungan OEE Februari 2018					
No	Tanggal	Availability Ratio (%)	Performance Ratio (%)	Quality Ratio (%)	OEE (%)
1	1-Feb-18	41.88	173.78	98.49	71.67
2	2-Feb-18	72.64	81.06	99.06	58.32
3	3-Feb-18	74.94	70.94	98.10	52.15
4	4-Feb-18	0.00	0.00	0.00	0.00
5	5-Feb-18	96.92	48.16	99.68	46.53
6	6-Feb-18	96.48	70.40	99.04	67.27
7	7-Feb-18	97.13	54.43	99.60	52.65
8	8-Feb-18	96.11	74.28	99.04	70.70
9	9-Feb-18	97.11	69.43	99.13	66.84
10	10-Feb-18	95.78	26.53	99.07	25.17
11	11-Feb-18	0.00	0.00	0.00	0.00
12	12-Feb-18	94.06	73.21	99.18	68.29
13	13-Feb-18	97.36	82.99	99.24	80.18
14	14-Feb-18	94.10	73.75	99.09	68.76
15	15-Feb-18	85.49	76.30	98.88	64.49
16	16-Feb-18	0.00	0.00	0.00	0.00
17	17-Feb-18	76.89	74.46	99.97	57.23
18	18-Feb-18	0.00	0.00	0.00	0.00
19	19-Feb-18	91.79	62.14	99.02	56.47
20	20-Feb-18	96.46	85.08	99.10	81.33
21	21-Feb-18	96.11	71.13	98.14	67.08
22	22-Feb-18	92.50	80.13	98.29	72.85
23	23-Feb-18	96.44	80.72	99.26	77.27
24	24-Feb-18	94.67	78.65	99.06	73.75
25	25-Feb-18	0.00	0.00	0.00	0.00
26	26-Feb-18	95.38	75.41	98.98	71.19
27	27-Feb-18	97.29	68.21	99.06	65.74
28	28-Feb-18	82.15	71.16	99.88	58.38
Rata - Rata		89.55	74.89	99.06	64.10

Tabel Perhitungan *Overall Equipment Effectiveness* Bulan Maret 2018

Perhitungan OEE Maret 2018					
No	Tanggal	Availability Ratio (%)	Performance Ratio (%)	Quality Ratio (%)	OEE (%)
1	1-Mar-18	82.85	79.16	99.04	64.95
2	2-Mar-18	96.22	77.49	98.91	73.75
3	3-Mar-18	80.00	61.90	99.06	49.05
4	4-Mar-18	0.00	0.00	0.00	0.00
5	5-Mar-18	95.87	79.66	99.04	75.63
6	6-Mar-18	94.29	110.03	98.95	102.66
7	7-Mar-18	96.46	78.12	99.15	74.71
8	8-Mar-18	97.71	78.66	99.18	76.22
9	9-Mar-18	93.56	68.74	99.03	63.68
10	10-Mar-18	78.78	74.58	98.68	57.97
11	11-Mar-18	0.00	0.00	0.00	0.00
12	12-Mar-18	98.63	73.94	99.02	72.20
13	13-Mar-18	96.53	63.96	99.14	61.21
14	14-Mar-18	97.78	80.74	99.01	78.16
15	15-Mar-18	96.11	76.82	99.16	73.20
16	16-Mar-18	96.67	88.48	98.96	84.64
17	17-Mar-18	0.00	0.00	0.00	0.00
18	18-Mar-18	0.00	0.00	0.00	0.00
19	19-Mar-18	94.18	76.18	98.50	70.67
20	20-Mar-18	86.39	80.54	99.08	68.94
21	21-Mar-18	93.75	79.23	99.37	73.81
22	22-Mar-18	96.39	81.92	99.17	78.30
23	23-Mar-18	97.56	84.95	98.78	81.86
24	24-Mar-18	95.55	128.64	98.24	120.74
25	25-Mar-18	0.00	0.00	0.00	0.00
26	26-Mar-18	94.62	67.32	99.12	63.14
27	27-Mar-18	87.99	75.23	99.02	65.54
28	28-Mar-18	87.01	77.83	99.03	67.06
29	29-Mar-18	96.42	73.70	99.13	70.44
30	30-Mar-18	0.00	0.00	0.00	0.00
31	31-Mar-18	91.61	86.89	99.55	79.24
Rata - Rata		92.92	80.19	99.01	73.91

Tabel Struktur Organisasi PT. Kati Kartika Murni

