BAB VI
KESIMPULAN DAN SARAN

6.1 KESIMPULAN

Berdasarkan data dan hasil pengolahan serta analisis yang telah dilakukan didapat kesimpulan sebagai berikut:

1) Peningkatan nilai Overall Equipment Effectiveness terlihat pada bulan Maret 2012. Dimana nilai OEE telah mengalami peningkatan diatas 85%, yang artinya mencapai nilai effektif.
    - Mesin Stay Fuel Tank 2 proses bending dan forming, dari nilai OEE 82% (availability 86%) menjadi 86% (availability 91%).
    - Mesin RR Cushion 5D9 proses bending 1 dan 2, dari nilai OEE 81% (availability 86%) menjadi 88% (availability 91%).
    - Mesin Brkt D38A proses bending, dari nilai OEE 83% (availability 86%) menjadi 87% (availability 91%).
    - Mesin Brkt Air Cleaner proses bending, dari nilai OEE 83% (availability 86%) menjadi 87% (availability 91%).
2) Dengan naiknya nilai dari OEE maka akan meningkatkan kapasitas produksi efektif secara otomatis :
    - Mesin Stay Fuel Tank 2 proses bending dan forming, dari ±9000 pcs menjadi ±9400 pcs.
    - Mesin RR Cushion 5D9 proses bending 1 dan 2, dari ±8200 menjadi ±8900 pcs.

- Mesin Brkt D38A proses bending, dari nilai ±13600 pcs menjadi ±14300 pcs.
- Mesin Brkt Air Cleaner proses bending, dari ±10900 pcs menjadi ±11400 pcs.

6.2 SARAN

Adapun saran-saran yang dapat diberikan berdasarkan hasil penelitian yang telah dilakukan adalah sebagai berikut:

1) Usulan perbaikan untuk mengurangi loss time yang selama ini terjadi, terutama pada cara dandori.
2) Pengurangan tersebut dapat dilakukan dengan mengelompokan menjadi *aktifitas tambahan*, dengan mengurangi atau menghilangkan aktifitas yang *tidak bernilai tambah* .Sehingga dapat kita bagi seminimal mungkin waktu yang bisa dikurangi dan dihilangkan dari 60 menit menjadi 40 menit.
3) Perlunya kerjasama dan koordinasi dari masing-masing divisi untuk menjalankan aktifitas ini, yang kemudian dapat diaplikasikan di line lain.

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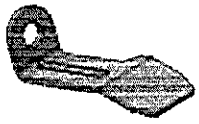
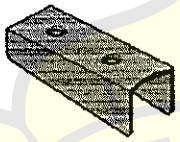
LAMPIRAN 1

GAMBAR PRODUK

Stay Fuel Tank 2:



RR Cushion 5D9 :



Brkt D38A :

Brkt Air Cleaner BZ090

LAMPIRAN 2

CHECK SHEET CYCLE TIME

*Sample check sheet bulan Oktober 2011 Stay Fuel Tank 2 (Bending):

Part Name	Stay Fuel Tank 2	CHECK SHEET CYCLE TIME		
Model	3C1			
Part No.	3C1-F8356-00	PT. SETIA GUNA SEJATI		
Process	BENDING	Approved by,	Checked by,	Issued by,
DD/MM/YY	Oct-11			

WEEK	I	II	III	IV				
Sample No.	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)
1	7.2	7.2	7.4	7.2				
2	7.3	7.3	7.2	7.3				
3	7.2	7.4	7.4	7.2				
4	7.3	7.2	7.2	7.3				
5	7.4	7.4	7.3	7.2				
6	7.2	7.2	7.2	7.3				
7	7.3	7.3	7.3	7.3				
8	7.3	7.3	7.2	7.3				
9	7.2	7.2	7.3	7.2				
10	7.3	7.3	7.3	7.3				
11	7.4	7.3	7.3	7.3				
12	7.2	7.2	7.2	7.2				
13	7.4	7.3	7.3	7.3				
14	7.2	7.2	7.2	7.2				
15	7.3	7.3	7.3	7.3				
16	7.3	7.2	7.2	7.2				
17	7.2	7.3	7.3	7.3				
18	7.3	7.3	7.3	7.3				
19	7.3	7.2	7.2	7.3				
20	7.2	7.3	7.3	7.2				
21	7.3	7.3	7.3	7.3				
22	7.4	7.2	7.2	7.2				
23	7.2	7.3	7.3	7.3				
24	7.4	7.2	7.2	7.2				
25	7.2	7.3	7.3	7.3				
26	7.3	7.2	7.2	7.3				
27	7.3	7.3	7.3	7.3				
28	7.4	7.3	7.3	7.2				
29	7.2	7.2	7.3	7.3				
30	7.4	7.3	7.2	7.3				

*Sample check sheet bulan Oktober 2011 Stay Fuel Tank 2 (Forming):

Part Name	Stay Fuel Tank 2	CHECK SHEET CYCLE TIME		
Model	3C1			
Part No.	3C1-F8356-00	PT. SETIA GUNA SEJATI		
Process	FORMING	Approved by,	Checked by,	Issued by,
DD/MM/YY	Oct-11			

WEEK	I	II	III	IV				
Sample No.	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)
1	7.2	7.2	7.4	7.3				
2	7.2	7.3	7.2	7.2				
3	7.3	7.2	7.4	7.3				
4	7.4	7.3	7.2	7.2				
5	7.4	7.2	7.3	7.2				
6	7.4	7.2	7.2	7.3				
7	7.2	7.3	7.3	7.3				
8	7.4	7.3	7.2	7.3				
9	7.2	7.2	7.2	7.3				
10	7.3	7.4	7.3	7.2				
11	7.4	7.2	7.2	7.3				
12	7.2	7.4	7.2	7.3				
13	7.4	7.3	7.4	7.3				
14	7.2	7.2	7.2	7.2				
15	7.3	7.3	7.3	7.3				
16	7.3	7.2	7.2	7.2				
17	7.2	7.3	7.3	7.3				
18	7.3	7.3	7.2	7.3				
19	7.3	7.2	7.3	7.3				
20	7.2	7.3	7.2	7.2				
21	7.3	7.2	7.3	7.3				
22	7.4	7.3	7.2	7.2				
23	7.3	7.2	7.3	7.3				
24	7.2	7.3	7.2	7.3				
25	7.3	7.2	7.3	7.2				
26	7.3	7.3	7.2	7.3				
27	7.2	7.2	7.3	7.2				
28	7.3	7.2	7.2	7.3				
29	7.2	7.3	7.3	7.3				
30	7.2	7.3	7.2	7.3				

*Sample check sheet bulan Oktober 2011 RR Cushion 5D9 (Bending 1):

Part Name	RR CUSHION 5D9	CHECK SHEET CYCLE TIME		
Model	5D9			
Part No.	5D9-XF111-00	PT. SETIA GUNA SEJATI		
Process	BENDING 1	Approved by,	Checked by,	Issued by,
DD/MM/YY	Oct-11			

WEEK	I	II	III	IV				
Sample No.	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)
1	7.8	7.7	7.7	7.9				
2	7.7	7.7	7.2	7.9				
3	7.9	7.7	7.8	7.9				
4	7.9	7.7	7.8	7.9				
5	7.9	7.7	7.8	7.9				
6	7.7	7.7	7.9	7.9				
7	7.7	7.9	7.9	7.9				
8	7.7	7.7	7.9	7.9				
9	7.7	7.9	7.7	7.9				
10	7.7	7.9	7.7	7.7				
11	7.7	7.9	7.9	7.7				
12	7.7	7.9	7.7	7.9				
13	7.9	7.9	7.9	7.9				
14	7.7	7.9	7.9	7.9				
15	7.7	7.9	7.9	7.7				
16	7.7	7.9	7.7	7.9				
17	7.7	7.9	7.7	7.7				
18	7.7	7.7	7.7	7.7				
19	7.7	7.7	7.7	7.9				
20	7.7	7.7	7.7	7.9				
21	7.7	7.2	7.7	7.9				
22	7.7	7.8	7.9	7.9				
23	7.7	7.8	7.7	7.9				
24	7.9	7.8	7.9	7.7				
25	7.7	7.9	7.9	7.9				
26	7.9	7.9	7.9	7.7				
27	7.9	7.9	7.9	7.7				
28	7.7	7.9	7.7	7.7				
29	7.7	7.9	7.7	7.9				
30	7.7	7.9	7.7	7.9				

*Sample check sheet bulan Oktober 2011 RR Cushion 5D9 (Bending 2):

Part Name	RR CUSHION 5D9	CHECK SHEET CYCLE TIME		
Model	5D9			
Part No.	5D9-XF111-00	PT. SETIA GUNA SEJATI		
Process	BENDING 2	Approved by,	Checked by,	Issued by,
DD/MM/YY	Oct-11			

WEEK	I	II	III	IV				
Sample No.	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)
1	7.7	7.7	7.7	7.9				
2	7.7	7.7	7.2	7.9				
3	7.7	7.7	7.8	7.9				
4	7.7	7.7	7.8	7.8				
5	7.9	7.7	7.8	7.8				
6	7.7	7.7	7.9	7.8				
7	7.7	7.9	7.9	7.8				
8	7.7	7.7	7.9	7.9				
9	7.7	7.9	7.7	7.9				
10	7.7	7.9	7.7	7.7				
11	7.8	7.9	7.9	7.7				
12	7.8	7.9	7.7	7.9				
13	7.8	7.9	7.9	7.9				
14	7.8	7.9	7.9	7.9				
15	7.8	7.9	7.9	7.7				
16	7.8	7.9	7.7	7.9				
17	7.7	7.9	7.7	7.7				
18	7.7	7.7	7.7	7.7				
19	7.7	7.7	7.7	7.9				
20	7.7	7.7	7.7	7.9				
21	7.7	7.2	7.7	7.9				
22	7.7	7.8	7.9	7.9				
23	7.7	7.8	7.7	7.9				
24	7.9	7.8	7.9	7.9				
25	7.8	7.9	7.9	7.9				
26	7.8	7.9	7.7	7.9				
27	7.7	7.9	7.7	7.7				
28	7.7	7.9	7.7	7.7				
29	7.7	7.9	7.7	7.9				
30	7.8	7.9	7.7	7.9				

*Sample check sheet bulan Oktober 2011 Brkt D38A (Bending):

Part Name	BRKT D38A	CHECK SHEET CYCLE TIME		
Model	D38A			
Part No.	D38A-XE511-00	PT. SETIA GUNA SEJATI		
Process	BENDING	Approved by,	Checked by,	Issued by,
DD/MM/YY	Oct-11			

WEEK	I	II	III	IV				
Sample No.	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)
1	4.9	4.8	4.7	4.8				
2	4.7	4.8	4.7	4.8				
3	4.7	4.8	4.7	4.8				
4	4.8	4.8	4.7	4.9				
5	4.8	4.8	4.7	4.9				
6	4.8	4.8	4.8	4.7				
7	4.8	4.9	4.9	4.7				
8	4.8	4.9	4.9	4.7				
9	4.8	4.8	4.8	4.7				
10	4.8	4.7	4.7	4.7				
11	4.9	4.8	4.7	4.7				
12	4.9	4.8	4.7	4.8				
13	4.8	4.8	4.8	4.8				
14	4.8	4.8	4.9	4.8				
15	4.8	4.7	4.9	4.8				
16	4.8	4.7	4.9	4.8				
17	4.9	4.7	4.9	4.9				
18	4.9	4.7	4.8	4.9				
19	4.7	4.9	4.7	4.8				
20	4.7	4.8	4.7	4.7				
21	4.7	4.8	4.7	4.7				
22	4.7	4.8	4.8	4.7				
23	4.9	4.9	4.8	4.9				
24	4.9	4.9	4.9	4.9				
25	4.7	4.7	4.9	4.8				
26	4.7	4.9	4.9	4.7				
27	4.8	4.8	4.9	4.7				
28	4.8	4.8	4.8	4.7				
29	4.9	4.8	4.7	4.9				
30	4.9	4.8	4.7	4.8				

*Sample check sheet bulan Oktober 2011 Brkt Air Cleaner BZ090 (Bending):

Part Name	BRKT AIR CLEANER BZ090	CHECK SHEET CYCLE TIME		
Model	D01N			
Part No.	BZ090	PT. SETIA GUNA SEJATI		
Process	BENDING	Approved by,	Checked by,	Issued by,
DD/MM/YY	Oct-11			

WEEK	I	II	III	IV				
Sample No.	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)	Result (second)
1	6	6.1	5.9	6.1				
2	6	6	5.9	6.1				
3	6.1	5.9	5.9	6.1				
4	6.1	5.9	5.9	6.1				
5	6	5.9	6.1	6.1				
6	5.9	5.9	6	6.1				
7	5.9	5.9	6.1	6.1				
8	5.9	5.9	6	6				
9	5.9	5.9	6.1	6.1				
10	5.9	5.9	6	6				
11	5.9	6.1	5.9	6.1				
12	5.9	6	5.9	6				
13	6.1	6.1	5.9	5.9				
14	6	6	5.9	5.9				
15	5.9	5.9	5.9	5.9				
16	5.9	5.9	6.1	6				
17	5.9	6.1	6	5.9				
18	5.9	6	5.9	5.9				
19	5.9	5.9	5.9	6.1				
20	5.9	5.9	5.9	6				
21	6.1	6.1	5.9	5.9				
22	6	6	5.9	5.9				
23	6.1	6.1	5.9	5.9				
24	6	6	5.9	6.1				
25	5.9	5.9	5.9	6				
26	5.9	6	5.9	5.9				
27	5.9	6	6.1	5.9				
28	5.9	6.1	6.1	6.1				
29	6.1	6	6	6				
30	6	6.1	5.9	5.9				