

ABSTRACT

Study of Small Scale Tapioca Factory Performance Using Overall Equipment Effectiveness (OEE) method

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One of the main problems in tapioca industries is the quality of tapioca. That is often not good, this is caused by the low quality of raw material. The low quality of tapioca causes the selling prices tapioca become lower and the tapioca flour shelf life is shorter. In addition to problems caused by raw materials, low productivity of machinery or equipment also incur losses for the company. These are in six factors are called as six big losses. One of indicator which could be used to measure the performance of tapioca industry by using *Overall Equipment Effectiveness* (OEE) methode.

The study was conducted by survey method in the field. Data was collected in two ways. The primary data retrieval from the observationing, recorded, and directed field measurements. The secondary data was obtained from the records in PD. Semangat Jaya to complete the primary data. Company Documentation was collected in a data processing including data on the number of production companies, loading time, operation time, defect amount, total downtime.

Based on the research is obtained data the average *overal equipment effectiveness* (OEE) from tapioca processing in PD. Semangat Jaya 56,82% which is arranged by average availability values 84,08%, performance 69,19%, and quality 97,56%. The OEE value is still under the minimum world standard 85%, arranged by availability values 90%, performance 95%, and minimum quality 99%. The conclusion of this research is the tapioca processing in PD. Semangat Jaya have to be reset the plant performance and improve the quality of raw materials used.

Keyword : Cassava, Tapioca, Avaibility, Performance, Quality