ABSTRAK

Permasalahan pada penelitian ini terjadinya kerusakan pada mesin *Oven, Mixer, Bread Slicer, Profeer, Depositor, Breadline, Vakum Sealer*. IKM belum melakukan penjadwalan perawatan terencana pada mesin produksi. Tujuan penelitian ini adalah untuk menentukan keandalan mesin dalam beroprasi sesuaifungsi yang di inginkan untuk suatu priode waktu tertentu pada IKM New Prima Bakery dan untuk melakukan perancangan penjadwalan perawatan mesin pada IKM New Prima Bakery. Penelitian ini adalah penelitian kuantitatif dengan metode yang digunakan adalah *Reliability Engineering* dan *Maintenance Value Stream Mapping* (MVSM). Data yang digunakan adalah data sekunder yang didapatkan dari IKM NEW Prima Bakery, yaitu data kerusakan mesin *Oven* memiliki rata-rata waktu operasi sekitar 584 jam diantara 5 kerusakan , mesin *Bread Slicer* memiliki rata-rata waktu sekitar 1460 jam diantara 2 kerusakan, mesin *Proofer* memiliki rata-rata waktu operasi sekitar 1460 jam diantara 2 kerusakan, mesin *Breadline* memiliki rata-rata waktu operasi sekitar 1460 jam diantara 1460 jam diantara 2 kerusakan , mesin *Vakum Sealer* memiliki rata-rata waktu operasi sekitar 2920 jam diantara 1 kerusakan, Mixer memiliki rata-rata waktu operasi sekitar 1460 jam diantara 2 kerusakan. Perancangan penjadwalan perawatan mesin yang akan dilakukan di IKM New Prima Bakery adalah melakukan penjadwalan *Priventive Maintenance* untuk menghindari terjadi *downtime* saat produksi telah dimulai dengan system perawatan mesin yang terjadwal yaitu oven 13 kali, mixer 12 kali, proofer 7 kali, depositor 6 kali, breadline 6 kali bread slicer 5 kali, vacccum sealer 4 kali dalam satu tahun.

Kata Kunci: *Reliability Engineering,* Perawatan Mesin, *Maintenance Value Stream Mapping*

ABSTACT

The problem in this study was damage to the Oven, Mixer, Bread Slicer, Profeer, Depositor, Breadline, Vacuum Sealer. SMIs have not scheduled planned maintenance on production machines. The purpose of this study is to determine the reliability of the machine in operating according to the desired function for a certain period of time at IKM New Prima Bakery and to design machine maintenance scheduling at IKM New Prima Bakery. This research is quantitative research with the methods used are Reliability Engineering and Maintenance Value Stream Mapping (MVSM). The data used is secondary data obtained from IKM NEW Prima Bakery, namely the Oven machine damage data has an average operating time of about 584 hours between 5 damages, the Bread Slicer machine has an average time of about 1460 hours between 2 damages, the Proofer machine has an average operating time of about 1460 hours between 2 damages, the Breadline machine has an average operating time of about 1460 hours between 2 damages, the Breadline machine has an average operating time of about 584 hours between 5 damages, the Bread Slicer machine has an average operating time of about 1460 hours between 2 damages, the Proofer machine has an average operating time of about 1460 hours between 2 damages, the Breadline machine has a rat. Namely oven 13 times, mixer 12 times, proofer 7 times, depositor 6 times, breadline 6 times bread slicer 5 times, vacccum sealer 4 times in one year.

Keywords: *Reliability Engineering, Machine Maintenance, Maintenance Value Stream Mapping*