

**OPTIMISATION OF MACHINE CLEANING AND SETUP TIME IN PT.
SOHO INDUSTRI PHARMASI**

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STATEMENT BY THE AUTHOR

I hereby declare that this submission is my own work and to the best of my knowledge, it contains no material previously published or written by another person, nor material which to a substantial extent has been accepted for the award of any other degree or diploma at any educational institution, except where due acknowledgement is made in the thesis.

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ABSTRACT

OPTIMISATION OF MACHINE CLEANING AND SETUP TIME IN PT. SOHO INDUSTRI PHARMASI

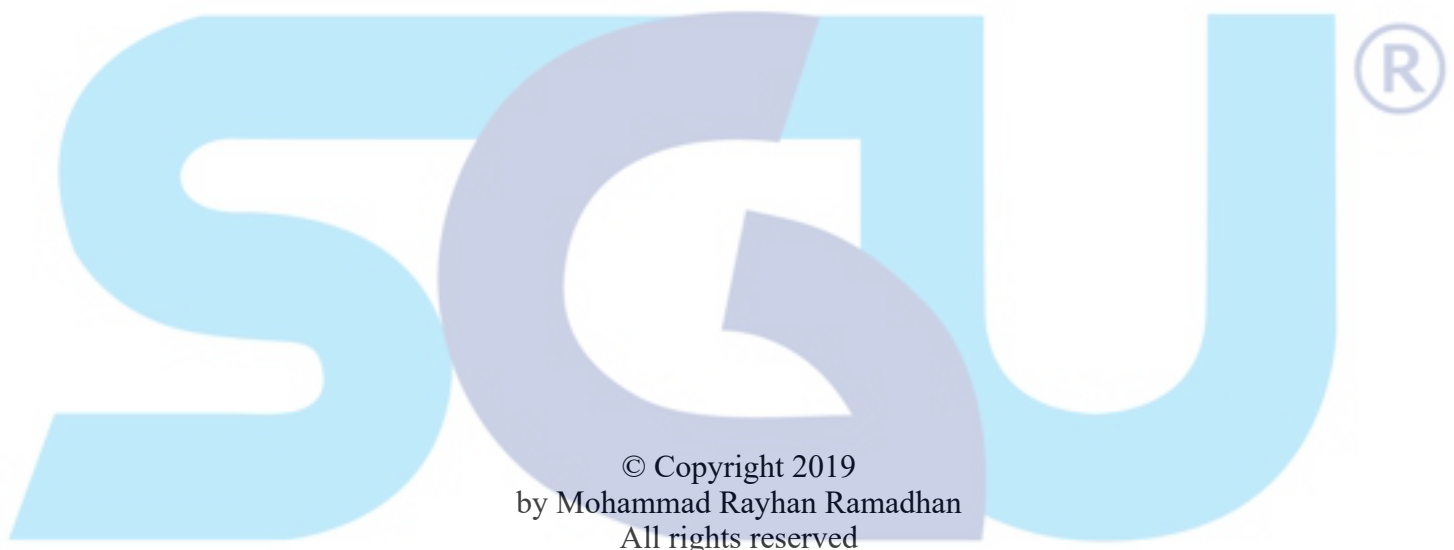
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PT. Soho Industri Pharamasi is a pharmaceutical company producing medicines and vitamins. Amongst all the product range, Fitkom vitamin is one of the products that has the highest and most consistent demand. Weekly production for this product goes up to a maximum of 18 batches weekly, with 240,000 tablets in each batch. When production exceeds 14 batches, an overtime on Saturdays and Sundays is necessary to achieve the weekly target. This is because during every production, a machine cleaning and setup procedure is necessary after every 6 batches of production. A machine cleaning and setup procedure means that the machine will remain idle for a total time of 11 hours. The objective if this research will be to reduce the overall machine cleaning and setup time to eliminate overtime even during full weekly capacity production of 18 batches. To do this, a Single Minute Exchange of Die will be the desired methodology to reach a machine cleaning and setup time target of 3 – 4 hours. The development process included research on the company's current condition, the collection of historical data, and the development of an improvised standardized machine cleaning and setup procedure.

Keywords: Machine Cleaning Time, Machine Setup Time, Overtime, Single Minute Exchange of Die



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DEDICATION

The author dedicates this work to his family, friends,
and all the teachers and lecturers that have taught him in the past



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