THE 3RD INTERNATIONAL CONFERENCE ON INDUSTRIAL ENGINEERING AND SERVICE SCIENCE
Melia Purosani Hotel - Yogyakarta, 1 - 3 September 2015

PROCEEDINGS

CREATING VALUE THROUGH INNOVATION

Organized by:

Department of Industrial Engineering
Institut Teknologi Sepuluh Nopember

Universitas
Arma Jaya Yogyakarta

Department of Industrial Engineering
Universitas Arma Jaya Yogyakarta
Table of Contents

Cover page
Preface
- Welcome Speech from Conference Chair
- Welcome Message from Rector of ITS Surabaya
- Welcome Message from Rector of Universitas Atma Jaya Yogyakarta
- Keynote Speakers
- Industrial Engineering ITS
- Universitas Atma Jaya Yogyakarta

Committee
Conference Sponsor

List of Papers
Industrial Engineering - Decision Making
1. Annisa Navieningtyas and Pri Hermawan. Group Model Building for Policy Making (Case Study: Beef Cattle at West Sumatra) 1
3. Erika Fatma. Development of Sustainable Tuna Processing Industry through System Dynamics Simulation 20

Industrial Engineering - Logistics
5. Meditya Wasesa, M Noviar Rachman, Ardian Rizaldi and M Mashuri. Relocating Multiple-Tenants Logistics Center: Lesson Learned from an Air Cargo Terminal Relocation Project 74
6. Siti Nurminarsih, Ahmad Rusdiansyah and Nurhadi Siswanto. Inventory Ship Routing Problem (ISRP) Model Considering Port Dwelling Time Information 80
7. Sonny Sanjaya and Tomy Perdana. Logistics System Model Development on Supply Chain Management of Tomato Commodities for Structured Market 89
Industrial Engineering – Manufacturing system


4. Sri Hartini and Udisubakti Ciptomulyono. The Relationship between Lean and Sustainable Manufacturing on Performance: literature review 117

5. Maria Anityasari and Aulia Nadia Rachmat. Lesson Learnt from Top-Down Medium Enterprises Selection for Green Industry Pilot Project in Surabaya 126


7. Nani Kurniati, Ruey-Huei Yeh and Jong-Jang Lin. Quality Inspection and maintenance: the framework of interaction 140

Industrial Engineering – Operation management

1. Suhendi Irawan. The Effect of Choosing a Transportation Vendor and the Performance of Transportation Vendor on the Performance of Shipping Goods to Consumer: A Case Study of DB Schenker Freigh Forwarder 147

2. Jugkrit Mahoran, Sukanya Wonglakron, Sumalee Namachote and Nauphon Oanwimon. Risk Management of Village Funds in Muang District, Suphanburi Province. 152

3. Susanto Sudiro and Sha'Ri Mohd Yusof. Managing WIP buffer with combination of feeding materials scenario and conventional control theory of single type of hospital bed production 159


5. Filemon Yoga Adhisatya, The Jin Ai and Dah-Chuan Gong. Economic Lot Scheduling Problem with Two Imperfect Key Modules 173


8. Hafid Budiman. Increasing Compressor Reliability with The Weibull Distribution Analysis 194


11. Taufik Djaatna and Wenny DwI Kurniati. A System Analysis and Design for Packaging Design of Powder Shaped Fresheners Based on Kansei Engineering 213

12. Taufik Djaatna and Muhammad Raja Ihsan. A Fuzzy Associative Memory Modeling for Production Equipment Status Assessment 220

15. Chaterine Alvina Prima Hapsari, Deny Ratna Yuniarta and Ignatius Luddy Indra Purnama. Tour and Break Scheduling for Shift Operators in Hard Disk Drive Manufacturer 239
17. Dewanti Anggrahini, Putu Dana Karningsih and Martian Sulistiyono. Managing Quality Risk In A Frozen Shrimp Supply Chain (A Case Study) 251
19. Naning Arantl Wessiani and Satria Oktaufanus Sarwoko. Risk Analysis of Poultry Feed Production Using Fuzzy FMEA 265

Industrial Engineering – Operation research

1. Wahyuda and Budi Santosa. Dynamic Pricing in Electricity: Research Potential in Indonesia 276
2. Chirag Sancheti, Aditya Balu and Amit Kumar Gupta. Simulation based optimization of productivity using Flexsim 283
3. Budi Santosa and I Gusti Ngurah Agung Kresna. Simulated Annealing Algorithm to Solve Single Stage Capacitated Warehouse Location Problem (Case Study: PT. Petrokimia Gresik) 289
7. Sattarpoom Thaiparnit, Baramee Osateerakul and Danupon Kumpanya. Algorithm Design in Leaf Surface Separation by Degree in HSV Color Model and Estimation of Leaf Area by Linear Regression 320

Industrial Engineering – Product Development

3. Taufik Djatna, Luh Putu Wrasiani and Ida Bagus Dharma Yoga Santosa. Balinese Aromatherapy Product Development Based On Kansei Engineering And Customer Personality Type 362

Industrial Engineering – Project Management

1. Jeyanthi Ramasamy and Sha'Ri Mohd Yusof. A Literature Review of Subsea Asset Integrity Framework for Project Execution Phase


Industrial Engineering – Supply Chain Engineering

1. Irwan Syahrir, Suparno and Iwan Vanany. Healthcare and Disaster Supply Chain: Literature Review and Future Research

2. Yudi Fernando and Sofri Yahya. Challenges in Implementing Renewable Energy Supply Chain in Service Economy Era

3. Araya Uengpalboonkit. The Marketing’s Factors that Effect to Consumers Decisions of Organic Rice in Surin, Thailand


5. Taufik Djatna and Rohmah Lathifiyanti. An Analysis and Design of Responsive Supply Chain for Pineapple Multi Products SME Based On Digital Business Ecosystem (DBE)

6. Erwin Widodo. A Model Reflecting the Impact of Producer Substitution in Dual-Channel Supply-Chain Inventory Policy

7. Taufik Djatna and Hety Handayani Hidayat. An Optimized Supply Chain Model for Determination of Distribution Center and Inventory Level in A Coconut Water Agro-Industry

8. Slamet Setio Wigati and The Jin Ai. An Integrated Production System Model for Multi Supplier Single Buyer with Non Conforming Item and Product Warranty

9. Yoshua Perwira Hartono, Ririn Dinar Astanti and The Jin Ai. Enabler to Successful Implementation of Lean Supply Chain in A Book Publisher

10. Sutrisno and Purnawan Adi Wicaksono. Optimal Strategy for Multi-product Inventory System with Supplier Selection By Using Model Predictive Control


Industrial Engineering – Safety & Ergonomic

1. Natalie Carol Skeepers and Charles Mbohwa. A Study on the leadership behaviour, safety leadership and safety performance in the Construction industry in South Africa

2. Herry Christian Palit and Debora Anne Yang Aysia. The Effect of Pop Musical Tempo during Post Treadmill Exercise Recovery Time


5. Rino Andias Anugraha, Wiyono Sutari and Ilma Mufidah, The Design of Working Desk of Batik Scraper by Using the Principles of Ergonomy

7. Manik Mahachandra, Yassierli and Erdo Garnaby. The effectiveness of in-vehicle peppermint fragrance to maintain car drivers’ alertness

8. Yassierli, Manik Mahachandra and Iftikar Sutalaksana. Fatigue Evaluation of Fuel Truck Drivers

9. Ayu Bidlawati and Eva Suryani. Improving the Work Position of Worker’s Based on Quick Exposure Check Method to Reduce the Risk of Work Related Musculoskeletal Disorders


11. Ronny Noriyati, Wisnu Rozaaq, Ali Musyafa and Adi Supriyanto. Hazard & Operability Study And Determining Safety Integrity Level On Sulfur Furnace Unit: A Case Study In Fertilizer Industry

12. Dyah Santhi Dewi and Tyasiliyah Septiana. Workforce Scheduling Considering Physical And Mental Workload: A Case Study Of Domestic Freight Forwarding

Industrial Engineering – Suporting topics in Industrial Engineering

1. Hatma Suryoharyo and Niken Larasati. Sustainable Livelihood Framework As An Approach To Build Community Based Security

2. Ngurah Wira, Amelia Kurniawati and Umar Yunan. The Design of Best Practice on The Media Transfer Activities and Preservation Based on Knowledge Conversion with SECI Method


Service Science – Service Business Design & Strategy

1. Tri Ramadhan, Dermawan Wibisono, Reza Ashari Nasution and Santi Novani. Design of Self Service Technology on Passenger Shipping Transportation Service System in Indonesia

2. Ratna Hidayati and Santi Novani. A Conceptual Complaint Model for Value co-Creation Process

3. Mikhael Tjhi, Jann Hidajat Tjakraatmadja and Santi Novani. Designing value co-creation process in organic food product distribution Case study in Bandung


5. Arlavianysa Pradita Arru and Santi Novani. Value Co-Creation in Solo Tourism by Using Soft System Dynamics Methodology

6. Rizki S. Nurfitrina and Mursyid H. Basri. Developing Clinical Pathway Model in Public Hospital as Basic Component of Casemix System


8. Lidia Mayangsari and Santi Novani. Multi-stakeholder Co-Creation Analysis in Smart City Management: An Experience from Bandung
Service Science – Service Delivery & Operations

1. Imam Djati Widodo and Harwati Sutanto. AR MBA: Linkage Pattern of Visited Tourism Object 628

2. Liane Okdinawati, Togar M. Sinatupang and Yos Sunitiyoso. Value Co-creation Map in Collaborative Transportation 635


Service Science – Service Quality

1. Agus Mansur and Rizky Destiana Ilapsari. Analysis of the Public Transportation Service Quality on Trans Jogja Transportation 658

2. Zya Labiba and Mulih Wijaya. Improvement Quality of Industrial Training Center Through Service Quality Based on Participation Perspective 663

Service Science – Supporting topics in service science

1. Gembong Baskoro. The concept of balancing Higher Education Institution (HEI) organization towards global and regional challenges 670

2. Samhuri Ikbal Pradana, Amelia Kurniawati and Nia Ambarsari. Knowledge Management System Implementation Readiness Measurement in PDII LIPI Based On People and Organizational Structure Factors 674
An Application of Association Rule Mining in Total Productive Maintenance Strategy: An Analysis and Modelling in Wooden Door Manufacturing Industry

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**ABSTRACT**

One of the challenges in the implementation of Total Productive Maintenance (TPM) in the manufacturing industry is a slow managerial decision-making to respond the condition in the factory. This research investigates the answers of these challenges by analyzing and modeling the equipment condition and the response of actions required in a wooden door manufacturing industry. TPM implementation in this company has deployed the Overall Equipment Effectiveness (OEE) measurement as an indicator of the equipment utilization and condition. Through an analysis and modeling of the OEE value obtained from the factory, the formulation of Association Rule Mining (ARM) aims to find a rule that shows the well computed relationship between measurable indicators of OEE with the response of action required to take in certain condition of machine utilization. Results obtained from ARM accelerate the decision to establish an appropriate TPM management strategy based on the rules. The generated dynamic rules form and facilitate the process of decision-making by related stakeholders. Furthermore, relying on these rules the action taken by the company induced to a higher reliable and increasing the effectiveness of response and efficiency of time and costs.

**Keywords:** Overall Effectiveness, Association Rule Mining, Data Mining, Total Productive Maintenance

1. Introduction

As one of the global company in wooden door manufacturing industry, CII sells high-variation products that are fully exported across the world to fulfill market demand. With limited number of machine and limited production capacity, this high-variation production leads to higher changeover rate in the main factory. To adjust the production machine from one type of product to another one, the machine must be turned off which resulted to a higher downtime. Early 2015 data from maintenance department in CII shows that 33% of planning production time is the downtime. Higher percentage of downtime in this company results to a slower production rate and higher overtime.

In fact, CII management has been implemented a Total Productive Maintenance (TPM) program to maintain the factory plant and its equipment. TPM is manufacturing program designed primarily to maximize the effectiveness of equipment by participation and motivation of the entire workforce [1]. TPM strategy implemented in this company is a benchmarked strategy from another manufacturing company. But, due to lack of human resources, the implemented strategy could not significantly affect the machine performance. According to these condition, there is a necessity to perform an improvement to the TPM strategy in CII to make it fit and suit with company condition.

The strategy developed in this research to improve the TPM in CII is predictive maintenance. This research focused on predictive maintenance than other maintenance strategy, like autonomous maintenance and preventive maintenance, due to the capability of data mining technique to supports the development of predictive maintenance to improve plant and machine condition in industry [2]. Using measurable parameters when breakdown is eminent, predictive maintenance intends to make an intervention to the machine itself or related factors before harmful events may occur [3]. It mean there is a requirement of data-driven technique like data mining to process inputted data and make the prediction well targeted.

One of data mining techniques is Association Rule Mining (ARM). Actually, the prototypical application of ARM is market basket analysis to mine the sets of items that are frequently bought together at a supermarket by analyzing the customer shopping. ARM has a capability to show the dependencies between attributes and define it in association rules.
An Application of Association Rule Mining in Total Productive Maintenance Strategy: An Analysis and Modelling in Wooden Door Manufacturing Industry

[4]. ARM could clarify the relationship between the parameters and the observed variable with the intervention response that will be taken by the related stakeholder and present it in a model consisted by association rules.

Based on motivation above, the main objective of this research is to solve the problem in CII with research approach as formulated as: 1) to identify the effectiveness of used machine, 2) to develop association rules of observed variables and intervention responses, 3) to develop a model of the maintenance strategy. The maintenance strategy developed by this research aims to support the decision-making process in management of CII, and other related stakeholder like maintenance department.

2. Methodology of Research

To accomplish the research objectives, a methodology was designed with research approach. The research methodology represented in Figure 1.

The research starts with the collecting machine condition data from moulding machine as sample used equipment. Then, the collected data processed with Overall Equipment Effectiveness (OEE) method to identify machine effectiveness as presented in section 3. Afterward, using Association Rule Mining (ARM), the OEE data assigned to binary through discretization and processed with apriori algorithm to get rules of data as presented in section 4. To accomplish 3rd objective, the rules got from ARM developed to model to be evaluated and to show the association of machine condition and applied management strategy in TPM as presented in section 5.

3. Identification of Machine Effectiveness

In order to answer the first research objective, the calculation of OEE is required to identify the effectiveness of the moulding machine. The moulding machine has been chosen as research target due to its importance as component profiler that make this machine has high changeover rate. The data used in this analysis is secondary data collected from CII production department record. First, the data was processed with OEE measurement. OEE is a key performance index to measure the effectiveness of the used equipment, plant, or machine [5]. The formula of OEE is shown below.

\[
OEE = A \times P \times Q
\]

Wherein:
- \(A\) : availability (%)
- \(P_e\) : performance efficiency (%)
- \(Q_r\) : quality rate (%)

Availability means the actual available time to produce goods using a machine. Performance rate shows the products produced according to the available time. Then the quality rate concludes the good products produced along the available time into OEE score [6]. Each of the factors that compose the OEE formula can be calculated by processing production data and machine condition.

\[
A = OT + POT
\]

Wherein:
- \(OT\) : operating time (minutes)
- \(POT\) : planned operating time (minutes)
An Application of Association Rule Mining in Total Productive Maintenance Strategy: An Analysis and Modelling in Wooden Door Manufacturing Industry

\[ Pe = RRR + IRR \]  

Wherein:
- \( RRR \): real run rate (pieces/minutes)
- \( IRR \): ideal run rate (pieces per minutes)

\[ Qr = GP + TP \]  

Wherein:
- \( GP \): good product (pieces)
- \( TP \): total product (pieces)

The calculation of OEE shows that OEE of CII moulding machine only reach 51%, with availability 67%, performance 80%, and quality 98%. The comparison between the calculation result with manufacturing company average in the world and world-class standard defined by JIPM in Figure 2, shows that OEE in CII cannot reach world average mainly due to its availability. To find out the causes of this availability, a Six-Big Losses assessment was conducted using data of 12 days records as sample. Pareto chart that shows this assessment result shown in Figure 3.

Based on these assessment, main cause of availability loss in CII moulding machine (about 73%) is setup and adjustment loss usually caused by stoppage due to pre-production set-up or changeover while in production time, or in this case as adjustment time for changing cutter blade in moulding machine to fit demanded door component specification. A fishbone diagram to identify the source of the problem of setup and adjustment loss is shown in Figure 4.

OEE calculation, Six-Big Losses assessment, and source problem identification using fishbone diagram was aimed to identifying used machine condition, and provide a better visualization of current machine state. In the next phase of this research, a strategy to resolve the solution of this condition was developed using data processed in this phase and processed with ARM.

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4. Association Rule Mining

The second phase of this research is developing rules using ARM. ARM starts with mining frequent items with their support values using frequent item mining algorithm like Apriori algorithm. This algorithm works over numeric or non-numeric data because the data itself will be converted into code [4]. All of the attributes were pre-processed with discretization in a certain range. Measurable parameter like OEE measurement result was converted into antecedent code, while response activities converted into consequent code. The data of each attribute was compiled and converted into discrete binary data. Then, after combining the item-sets to combination 2-item sets up to 4-item sets, Apriori algorithm formed candidate item set, then it generated large item set consist of rules [7]. Each combination generally called as transaction.

To ease the combination process using Apriori algorithm, every attribute has been grouped into certain range and labeled through discretization. Discretization, also called binning, converts numeric attributes into categorical ones. Discretization can also help in reducing the number of values for an attribute, especially if there is noise in the numeric measurements [4]. The measurable parameter of moulding machine has been determined as rule antecedent, while response activities of CII management has been determined as rule consequent.

<table>
<thead>
<tr>
<th>Table 1 If (Antecedent) label</th>
</tr>
</thead>
<tbody>
<tr>
<td>Parameter</td>
</tr>
<tr>
<td>Setup and Adjustment per day</td>
</tr>
<tr>
<td>26-50% DT</td>
</tr>
<tr>
<td>51-75% DT</td>
</tr>
<tr>
<td>76-100% DT</td>
</tr>
<tr>
<td>Material Delay per day</td>
</tr>
<tr>
<td>26-50% DT</td>
</tr>
<tr>
<td>51-75% DT</td>
</tr>
<tr>
<td>76-100% DT</td>
</tr>
<tr>
<td>Break Down per day</td>
</tr>
<tr>
<td>&gt;1x</td>
</tr>
<tr>
<td>&gt;15 x</td>
</tr>
</tbody>
</table>

*DT=Down Time

The used attribute in antecedent code is determined according to the OEE calculation of field data. While according to the requirement analysis using fishbone diagram in previous phase, the response target has been determined into three object: the moulding machine itself, the machine operator, and the used method included the implemented production strategy. The response activities has been classified by defining the source problem into an actionable activities, as presented in Table 2.

<table>
<thead>
<tr>
<th>Table 2 Then (consequent) label</th>
</tr>
</thead>
<tbody>
<tr>
<td>Response target</td>
</tr>
<tr>
<td>Machine</td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td>Man</td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td></td>
</tr>
</tbody>
</table>

The result of discretization then has been represented in binary database. A binary database is a binary relation on the set of tids (transaction identifiers) and items [4]. If certain value in an attributes has been qualified into certain discrete range, the value will be represented as true value (1), while the rest of other range will get false value (0). The example of binary table is presented in Table 3.
An Application of Association Rule Mining in Total Productive Maintenance Strategy: An Analysis and Modelling in Wooden Door Manufacturing Industry

Table 3 Availability score represented in binary table

<table>
<thead>
<tr>
<th>Availability</th>
<th>0-40</th>
<th>40-60</th>
<th>60-90</th>
<th>&gt;90%</th>
</tr>
</thead>
<tbody>
<tr>
<td>65%</td>
<td>0</td>
<td>0</td>
<td>1</td>
<td>0</td>
</tr>
<tr>
<td>74%</td>
<td>0</td>
<td>0</td>
<td>1</td>
<td>0</td>
</tr>
<tr>
<td>53%</td>
<td>0</td>
<td>1</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>81%</td>
<td>0</td>
<td>0</td>
<td>1</td>
<td>0</td>
</tr>
<tr>
<td>55%</td>
<td>0</td>
<td>1</td>
<td>0</td>
<td>0</td>
</tr>
<tr>
<td>84%</td>
<td>0</td>
<td>0</td>
<td>1</td>
<td>0</td>
</tr>
</tbody>
</table>

To generate the rules, each antecedent has been combined with consequent, with limitation 4-set combination. The example of antecedent-consequent combination is presented in Table 4. The result of this combination is 30228 rules.

Table 4 Combination of antecedent A-P-Q and consequent X-Y-Z

<table>
<thead>
<tr>
<th>2-set combination</th>
<th>3-set combination</th>
<th>4-set combination</th>
</tr>
</thead>
<tbody>
<tr>
<td>A1→X1</td>
<td>A1-P1→X1</td>
<td>A1-P1-Q1→X1</td>
</tr>
<tr>
<td>A1→Y1</td>
<td>A1-P2→Y1</td>
<td>A1-P1-Q2→Y1</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>A3→Z3</td>
<td>A3-Q3→Y3</td>
<td>A3-P3-Q3→Z3</td>
</tr>
</tbody>
</table>

Although there are many rules obtained, most of the rules were discarded or eliminated due to their low value with rule assessment. Rule assessment is a method consists of different rule interestingness measures to quantify the dependence between the antecedent and consequent [8]. There are 4 measures used in this assessment: support, confidence, lift, and bond. As example an association rule X → Y, where X is antecedent and Y is consequent, the support (sup) of this rule is defined in (5). With |t(XY)| is a total of transaction contain both X and Y in a combination. Relative support (rsup) or support value compared relatively to the size of database was defined in (6), with |D| is a total of transaction in database.

\[
\text{sup}(X \rightarrow Y) = \frac{|t(XY)|}{|D|} \quad (5)
\]

\[
\text{rsup}(X \rightarrow Y) = \frac{\text{sup}(X \cap Y)}{|D|} \quad (6)
\]

Confidence (conf) of a rule is the conditional probability that a transaction contains the consequent Y given that it contains the antecedent X.

\[
\text{conf}(X \rightarrow Y) = \frac{\text{sup}(X \cap Y)}{\text{sup}(X)} \quad (7)
\]

Lift of a rule is a ratio of the observed joint probability of X and Y to the expected joint probability if they were statistically independent.

\[
\text{lift}(X \rightarrow Y) = \frac{\text{conf}(X \rightarrow Y)}{\text{sup}(Y)} \quad (8)
\]

Bond shows the strength of item set with comparing conjunctive (combination contain only true value) and disjunctive (total of all combination) of each transaction.

\[
\text{bond}(X \rightarrow Y) = \frac{\text{conjunct}(X \cap Y)}{\text{disjunctive}(X \cap Y)} \quad (9)
\]

Using trial and error method, the user threshold has been determined. The minimum relative support, confidence, lift, and bond used in this research is 0.2, 1, 2, and 0.2. By using this threshold, the rule assessment was resulting 83 qualified rules. Table 5 below shows the summary of top 10 qualified rules ranked by bond.

Table 5 Top 15 rules ranked by bond

<table>
<thead>
<tr>
<th>No.</th>
<th>1st Condition</th>
<th>2nd Condition</th>
<th>3rd Condition</th>
<th>Response</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>OEE 40-60%</td>
<td>OEE 60-85%</td>
<td>OEE &lt;40%</td>
<td>Management Meeting</td>
</tr>
<tr>
<td>2</td>
<td>OEE 40-60%</td>
<td>OEE 60-85%</td>
<td>OEE &lt;40%</td>
<td>Management Meeting</td>
</tr>
<tr>
<td>3</td>
<td>OEE 40-60%</td>
<td>OEE 60-85%</td>
<td>OEE &lt;40%</td>
<td>Management Meeting</td>
</tr>
</tbody>
</table>
5. Maintenance Strategy Development

Using 83 qualified rules from ARM computation, a model of maintenance strategy was developed. Basically, three types of maintenance exist, namely corrective, preventive, and predictive maintenance. In this model, the antecedent of the rules consists of measurable parameters that describe the machine condition, up to three conditions, while the consequent of the rules consists of responses to be taken if the condition in antecedent was occurred.

For instance, if condition of the machine, in this case moulding machine, was showed OEE value 40-60%, then the management should conduct a work-order evaluation. OEE with value below 60% is lower than world average OEE. Manufacturing company with high changeover rate like CII maybe has low OEE due to the current work-order. So, to prevent further decreasing in OEE value, the work-order should be evaluated.

Based on this model, improvement of TPM strategy in CII is expected. Using the model as a tool to help in decision making process, management of CII can make a decision easier to solve machine-related problems with considering the qualified rules. The implementation of ARM to develop TPM strategy is very potential. To implement ARM model to develop TPM strategy for other machine in CII or even in another manufacturing company, the management can change used attributes and data in ARM so it will generated rules that fit and suit with the machine condition itself. The advantage of this model is generated dynamic rules that always updated by the data changing comparing to other strategy development tool like Analytic Hierarchy Process that uses static data [2]. Besides that, as one of data mining technique, the implementation of ARM to the TPM is a right choice, due to its ability to handle big-data with high velocity and volume that is generated by machine condition.

6. Conclusion and Recommendation

This paper presents a novel implementation of data mining techniques to solve real industry problem especially in machine maintenance in a wooden door manufacturing industry targeting moulding machine. The OEE calculation of moulding machine shows a machine availability loss due to low effectiveness caused by high setup and adjustment loss. The deployment of ARM using a priori algorithm and generates 30228 if-then rules. Rule assessment has conducted to qualify rules using user threshold to limit support, confidence, lift, and bond value which resulted 83 qualified rules for predictive maintenance strategy. As recommendation, the model itself can be mounted to software. Using if-then rules generated by ARM, an if-else looping algorithm can be developed to mount the model to the software of mobile apps to make it more user-friendly, flexible, and increase the usability. The OEE measurement and data acquisition improved by using sensor in the machine.

7. References

An Application of Association Rule Mining in Total Productive Maintenance Strategy: An Analysis and Modelling in Wooden Door Manufacturing Industry