IESS 2015

THE 3RD INTERNATIONAL CONFERENCE
ON INDUSTRIAL ENGINEERING AND SERVICE SCIENCE

Melia Purosani Hotel - Yogyakarta, 1 - 3 September 2015

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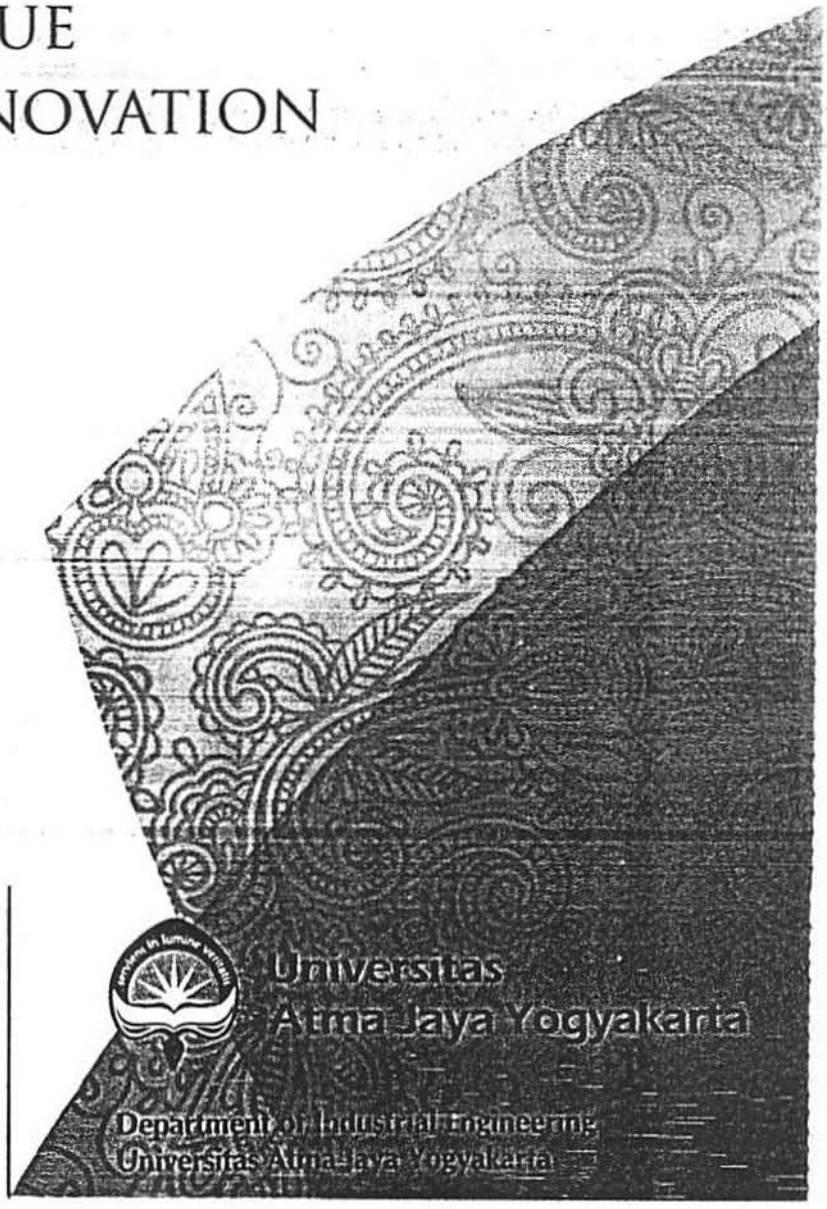

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Industrial Engineering Department, Institut Teknologi Sepuluh Nopember (ITS) Surabaya and Universitas Atma Jaya Yogyakarta - Indonesia

Supported by:
Rajamangala University of Technology Suvarnabhumi (RMUTSB) - Thailand
Universitas Islam Indonesia (UII) - Indonesia

ISSN: 2338-7939
@2015

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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. **Annisaa Novieningtyas** and Pri Hermawan. Group Model Building for Policy Making (Case Study: Beef Cattle at West Sumatra) 1
2. Pri Hermawan, **Yuliati Komar** and Soehartati Gondhowiardjo. A Network-based Collaborative Decision Making Model in Reducing Cervical Cancer Spread in Indonesia. 13
3. **Erika Fatma**. Development of Sustainable Tuna Processing Industry through System Dynamics Simulation. 20
4. **I Made Ronyastra**, I Ketut Gunarta and Udisubakti Ciptomulyono. A Multi Criteria Decision Analysis for Reinvestment Action Portfolio Selection Problem in an Indonesian Real Estate Company 27
5. **Stefanus Eko Wiratno**, Effi Latiffianti and **Kevin Karmadi Wirawan**. Selection of Business Funding Proposals Using Analytical Network Process: A Case Study at a Venture Capital Company 36

Industrial Engineering – Logistics

1. **Farida Pulansari**, Dwi Donoriyanto and Iriani. Performance Assessment Mechanism for Reverse Logistics Maturity Implementation toward Sustainable Manufacturing Systems: A Conceptual Framework 42
2. **Adi Budipriyanto**, Budisantoso Wirjodirdjo, Nyoman Pujawan and Saut Gurning. Berth Allocation Problem under Uncertainty: A Conceptual Model Using Collaborative Approach 51
3. **Nur Ulfa Hidayatullah** and Ali Musyafa. Hazop Study on Fuel Distribution System Based on Anfis Layer of Protection Analysis in Surabaya Installation Group PT Pertamina Tanjung Perak 59
4. **Ardian Rizaldi**, Meditya Wasesa and M Noviar Rahman. Yard Cranes Coordination Schemes for Automated Container Terminals: An Agent-Based Approach 66
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

1. **Wiwin Widiasih**, Putu Dana Karningsih and Udisubakti Ciptomulyono. Development of Integrated Model for Managing Risk in Lean Manufacturing Implementation: A Case Study in an Indonesian Manufacturing Company 95
2. **Joko Sulistio** and Tri Astuti Rini. A Structural Literature Review on Models and Methods Analysis of Green Supply Chain Management 103
3. **Sri Indrawati** and Muhammad Ridwansyah. Manufacturing Continuous Improvement Using Lean Six Sigma: An Iron Ores Industry Case Application 111
4. **Sri Hartini** and Udisubakti Ciptomulyono. The Relathionship 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
6 **Putu Karningsih**, Dewanti Anggrahini and Muhammad Syafi'i, Concurent Engineering Implementation Assesment. Case Study in an Indonesia Manufacturing Company 133
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 Naruphon 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
4. **Agung Sutrisno**, Indra Gunawan and Stenly Tangkuman. Modified FMEA Model for Acessing the Risk of Maintenance Waste 167
5. **Filemon Yoga Adhisatya**, **The Jin Ai** and Dah-Chuan Gong. Economic Lot Scheduling Problem with Two Imperfect Key Modules 173
6. Bupe Mwanza and **Charles Mbohwa**. An Assessment of the Effectiveness of Equipment Maintenance Practices in Public Hospitals. 179
7. Bupe Mwanza and **Charles Mbohwa**. Design of a Total Productive Maintenance Model for Effective Implementation: A case study of a Chemical Manufacturing Company 185
8. **Hafid Budiman**. Increasing Compressor Reliability with The Weibull Distribution Analysis 194
9. **Paulus Wisnu Anggoro** and Baju Bawono. Reverse Engineering Technology in Redesign Process Ceramics: Application for CNN Plate 199
10. **Endang Retno Wedowati**, Moses Laksono Singgih and I Ketut Gunarta. Integrated Production Planning and Scheduling for Mass Customization in Food Industry: A Conceptual Framework 205
11. Taufik Djatna and **Wenny Dwi Kurniati**. A System Analysis and Design for Packaging Design of Powder Shaped Fresheners Based on Kansei Engineering 213
12. Taufik Djatna and **Muhammad Raja Ihsan**. A Fuzzy Associative Memory Modeling for Production Equipment Status Assessment 220
13. Taufik Djatna and **Fajar Munichputranto**. An Analysis and Design of Mobile Business Intelligence System for Productivity Measurement and Evaluation in Tire Curing Production Line 225

14. **Sazli Tutur Risyahadi.** Scheduling Model of Harvesting Strawberry Considering Product Decay During Storage 231

15. **Chaterine Alvina Prima Hapsari,** Deny Ratna Yuniartha and Ignatius Luddy Indra Purnama. Tour and Break Scheduling for Shift Operators in Hard Disk Drive Manufacturer 239

16. **Jwannaraksu Phen.** An influence of packaging design on customer purchase intention 247

17. **Dewanti Anggrahini,** Putu Dana Karningsih and Martian Sulistiyono. Managing Quality Risk In A Frozen Shrimp Supply Chain (A Case Study) 251

18. **Anny Maryani,** Sritomo Wignjosoebroto and Sri Gunani Partiwi. A System Dynamics Approach for Modeling Construction Accidents 259

19. **Naning Aranti Wessiani** and Satria Oktaufanus Sarwoko. Risk Analysis of Poultry Feed Production Using Fuzzy FMEA 265

20. Mohamad Faisal Mohamad Sobri, **Hawa Hishamuddin,** Noraida Azura Md Darom· Disruption Recovery for a Single Stage Production-Inventory System with Optimal Safety Stock OM1

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

4. **Yuanita Handayati,** Togar Simatupang and Tomy Perdana. Value Co-Creation in Agri-Chains Network: A Hard Agent Based Simulation 298

5. **Budi Santosa** and Ade Lia Safitri. Biogeography-based Optimization Algorithm for Single Machine Total Weighted Tardiness Problem 307

6. **Gilang Almaghribi Sarkara Putra** and Rendra Agus Triyono. Proposing a Neural Network Method for Instrumentation and Control Cost Estimation of the EPC Companies Bidding Proposal 313

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

8. **Danupon Kumpanya** and Sattarpoom Thaiparnit. Parameter Identification of BLDC Motor Model via Metaheuristic Optimization Techniques 326

9. **Sinta Dewi,** Imam Baihaqi and Erwin Widodo. Modeling Strategy of Purchasing Consortium to Optimize Total Purchasing Cost Considering the Dynamic Condition of Organizaion 332

10. Taufik Djatna and **Imam Muharram Alitu.** An Application of Association Rule Mining in Total Productive Maintenance Strategy: An Analysis and Modelling for Wooden Door Manufacturing Industry 340

Industrial Engineering – Product Development

1. **Yosephine Suharyanti,** Subagyo, Nur Aini Masruroh and Indra Bastian. The Scheme of Product Development Process as a Trigger to Product Success: A Theoretical Framework 347

2. **Ishardita Pambudi Tama** and Wifqi Azlia. Development of Customer Oriented Product Design Using Kansei Engineering and Kano Model (Case study of Ceramic Souvenir) 355

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

4. **Dyah Santhi Dewi**, Bambang Syairudin and Eka Nahdliyatun Nikmah. Risk Management in New Product Development Process for Fashion Industry (Case Study : Hijab Industry) 368

Industrial Engineering – Project Management

1. **Jeyanthi Ramasamy** and Sha'Ri Mohd Yusof. A Literature Review of Subsea Asset Integrity Framework for Project Execution Phase 376
2. **Baju Bawono** and Paulus Wisnu Anggoro. Utilization Of Rapid Prototyping Technology to Improve Quality Souvenir Product 384

Industrial Engineering – Supply Chain Engineering

1. **Irwan Syahrir**, Suparno and Iwan Vanany. Healthcare and Disaster Supply Chain : Literature Review and Future Research 390
2. **Yudi Fernando** and Sofri Yahya. Challenges in Implementing Renewable Energy Supply Chain in Service Economy Era 398
3. **Araya Uengpaiboonkit**. The Marketing's Factors that Effect to Consumers Decisions of Organic Rice in Surin, Thailand 404
4. **Layung Prasetyanti** and Togar Simatupang. Proposed Framework for Service-Dominant-Logic Based Supply Chain 408
5. Taufik Djatna and **Rohmah Luthfiyanti**. An Analysis and Design of Responsive Supply Chain for Pineapple Multi Products SME Based On Digital Business Ecosystem (DBE) 416
6. **Erwin Widodo**. A Model Reflecting the Impact of Producer Substitution in Dual-Channel Supply-Chain Inventory Policy 423
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 430
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 436
9. Yoshua Perwira Hartono, **Ririn Diar Astanti** and The Jin Ai. Enabler to Successful Implementation of Lean Supply Chain in A Book Publisher 443
10. **Sutrisno** and Purnawan Adi Wicaksono. Optimal Strategy for Multi-product Inventory System with Supplier Selection By Using Model Predictive Control 450
11. Iwan Vanany, Anny Maryani and Bilqis Amaliah. Blood Traceability System for Indonesian Blood Supply Chain 457

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 464
2. Herry Christian Palit and **Debora Anne Yang Aysia**. The Effect of Pop Musical Tempo during Post Treadmill Exercise Recovery Time 470
3. **Eko Nurmianto**, Udisubakti Ciptomulyono, Suparno and Sudiyono Kromodihardjo. Manual Handling Problem Identification in Mining Industry : the Ergonomic Perspective 475
4. **Wiyono Sutari**, Murni Dwi Astuti, Yusuf Nugroho Doyobekti and Yuvie Mutiarasari. Analysis of Working Posture Effect on Muscular Skeleton Disorder of Operator in Stamp Scraping in Batik Stamp Industry 483
5. Rino Andias Anugraha, **Wiyono Sutari** and Ilma Mufidah, The Design of Working Desk of Batik Scraper by Using the Principles of Ergonomy 488

6. Budi Praptono, Yusuf Nugroho Doyo Yekti, I Gede Wisuda Pura and **Fransiskus Tatas Dwi Atmadji**. Prevention of Musculo Skeletal Disorders of Green Beans Farmer Through Application of Ergonomics in Order to Developing Manual Handling Equipment 496

7. **Manik Mahachandra**, Yassierli and Erdo Garnaby. The effectiveness of in-vehicle peppermint fragrance to maintain car drivers' alertness 500

8. Yassierli, **Manik Mahachandra** and Iftikar Sutalaksana. Fatigue Evaluation of Fuel Truck Drivers 506

9. **Ayu Bidiawati** 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 512

10. **Bernadus Kristyanto**, Brillianta Budi Nugraha, Anugrah Kusumo P and Kristanto Agung N. Head and Neck Movement: Simulation And Kinematics Analysis 518

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 525

12. Dyah Santhi Dewi and **Tyasiliah Septiana**. Workforce Scheduling Considering Physical And Mental Workload: A Case Study Of Domestic Freight Forwarding 531

Industrial Engineering – Suporting topics in Industrial Egineering

1. Hatma Suryoharyo and **Niken Larasati**. Sustainable Livelihood Framework As An Approach To Build Community Based Security 539

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 546

3. **Sri Gunani Partiwi**, Elly Agustiani and Anny Maryani. Preparation for Designing Business Strategy of Bamboo Cultivation in Bondowoso 552

4. **Yosephine Suharyanti** and Alva Edy Tontowi. Market Response as a function of Design, Competition, and Socio-political Condition: An Empirical Model 558

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 566

2. **Ratna Hidayati** and Santi Novani. A Conceptual Complaint Model for Value co-Creation Process 574

3. **Mikhael Tjhi**, Jann Hidajat Tjakraatmadja and Santi Novani. Designing value co-creation process in organic food product distribution Case study in Bandung 579

4. **Nurtami Prihadi** and Santi Novani. Value Co-Creation among Stakeholders in Solo Tourism Development: Service System Science Perspective 591

5. **Arlavianyssa Pradiva Arru** and Santi Novani. Value Co-Creation in Solo Tourism by Using Soft System Dynamics Methodology 601

6. **Rizki S. Nurfitria** and Mursyid H. Basri. Developing Clinical Pathway Model in Public Hospital as Basic Component of Casemix System 609

7. **Watcharee Phetwong** and Krisorn Sawangsire. The Development of Computer Game for Historic Sites Learning in Suphanburi. 617

8. **Lidia Mayangsari** and Santi Novani. Multi-stakeholder Co-Creation Analysis in Smart City Management: An Experience from Bandung 622

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. Simatupang and Yos Sunitiyoso. Value Co-creation Map in Collaborative Transportation 635
3. Americo Azevedo and **Maratus Sholihah**. Innovative Costing System Framework in Industrial Product-Service System Environment 642
4. **Iwan Vanany**, Udisubakti Ciptomulyono, Muhammad Khoiri, Dody Hartanto and Putri Nur Imani. Willingness to Pay for Surabaya Mass Rapid Transit (SMART) Options 649

Service Science – Service Quality

1. Agus Mansur and Rizky Destiana Hapsari. 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

Proceeding of Industrial Engineering and Service Science , 2015

An Analysis and Design of Mobile Business Intelligence System for Productivity Measurement and Evaluation in Tire Curing Production Line

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ABSTRACT

Business intelligence (BI) system as an architecture of competencies, processes, technologies, applications and practices to support productivity measurement. It obviously needs a BI that support organization to declare any production constraints that currently or already occurred in such as tire curing industry. Overall Equipment Effectiveness (OEE) is used as a quantitative productivity measurement and become the base of company continuous improvement and evaluation. The objectives of this study are to identify critical parameters of production line in effectiveness measurement and machine utilization, analyze the requirement of information system as an Android based mobile BI System and to integrate the design into a mobile system. System requirement analyzed each interdependent measure in the real world of complexity by using BPMN 2.0. These measures are part of dashboard components in the proposed BI. The acquired data from a National forefront tire industry shows the OEE in three ratio measurement of availability, performance, and quality with 78%, 82.5% and 99.8% of scorecard respectively. In order to determine the status of production, the deployment of k-nearest neighbor (k-NN) gives 67.5% of accuracy rate. The critical parameters identification results to 8 (eight) significant constraints, which calculated using distance-based RELIEF attribute selection. Eventually this approach results big four constraints to be noted: (a) mold repair, (b) mold setting, (c) green tire shortage and (d) defect cure.

Keywords: *business intelligence, tire curing, productivity*

1. Introduction

Productivity is one of the company success indicators in producing goods and improving service quality to consumers or related parties. Productivity is a measurement level to obtain the results with a variety of available resources [1]. To regain their competitiveness within the market, companies should apply the Total Production Management (TPM) for cost efficiency and higher profit margin. Most of multinational tire manufacturers are Original Equipment Manufacturer (OEM) for automotive industry; hence the critical parameters are pointed on how they produce goods with right quantity at the right place and at the right time, or termed as just-in-time [2]. Just-in-time (JIT) is now often termed as lean manufacturing that would have become issues for production strategy. Recently, business need a method to repair and reveals the problem as solution due to dynamic events and incidents in production. Core problems could be revealed using business intelligence (BI) by applying dashboard to measure and monitor performance of production. Productivity measurement within BI systems is able to combine data gathering, data storage, and knowledge management with analytical tools to present complex internal and competitive information to planners and decision makers. Some organizations use BI to gain data-driven insights on anything related to business performance. Enterprise can build business intelligent (BI) system using analytics insight to trigger business event [3]. Any measurement from analytics insight is shown at specific parameters on dashboard that reflect the definition of productivity scorecard to support decision making.

In this paper, we focus on productivity data mining using Overall Equipment Effectiveness (OEE) as indicators. OEE is an appropriate method to measure tire curing as products are discrete and able to reveals the six big losses in productivity. According to Maran et.al (2012) six constraints are divided into three categories

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which provide major influences on productivity [4]. Constraints could be minimized by predicting and determining the priority constraints to be solved from a variety of constraints that may occur during the production process. Predicting and sequencing the constraints are likely to support management to decide preventive action for coming period – especially with a mobile and friendly-practical dashboard to monitor the reports. This paper is merging the powerful business analytics and fundamental OEE measurement (using data mining) to reveal the silver lining of production and reduce business friction with mobile BI dashboard to trigger business action in real time.

Based on the motivation above, the objectives of this paper are to identify critical parameters of production line in effectiveness measurement and machine utilization, analyze the requirement of information system as a mobile BI system and to integrate the design into a mobile system. Critical parameters obtained by production constraints OEE values of some production lines. OEE production lines with the lowest value will be analyzed further in the form of predictions for the next period of production status using algorithm k-nearest-neighbor [5]. Priority is determined using RELIEF algorithm [6]. Both algorithms are used as a loss of transparency in the production process so as to facilitate efforts to reduce such losses.

2. Research Method

This paper is written in on-field experience, which all the data was acquired from one of the biggest tire multinational company in Indonesia. The facts of production activity lead to build the systematic methodology to solve the production constraints. Frequency of constraints could be minimized with anticipation and preventive action. Categorization of constraints will ease the user to determine right treatment for the constraints and computational calculation. Constraints should be prioritized and first priority or main constraints should be placed on top of all production constraints which effectively reduce total both major and minor constraints and briefly increase the production quality. All classification and sequencing result should be monitored (dashboard) to trigger management decision in order to maintain production quality. Hence, the sequences above are elaborated in the methodology explanation below.

2.1 Constraint Analysis

a. Overall Equipment Effectiveness (OEE) Measurement

OEE is a combined measurement of the effectiveness of the time (availability), machine performance (performance) and product quality (quality) [7]. The general formula used to calculate the OEE value is written in equation.

$$OEE = availability \times performance \times quality \quad (1)$$

The effectiveness of the time (availability) shows the ability of a machine to produce product production. As seen in equation (1.2), this parameter is the result of a comparison between the times spent during the production takes place with a total time available for such activities.

$$\text{Availability}=\text{Runtime/Loading Time} \quad (2)$$

Engine performance shows the ability of a machine to produce product production (performance). This parameter is the result of a comparison between the achievements of production that should result in a net time used for production activities take place. Calculation engine performance levels seen in equation.

$$\text{Performance}=\text{total production/target production} \quad (3)$$

While the level of product quality (quality) on OEE is the ratio between the total products is acceptable (good) with the total product produced. This measurement is closely related to the number of defective products (defects / scrap).

$$\text{Quality}=\text{good product/total production} \quad (4)$$

b. Prediction of Production Status

Prediction production status with k-nearest neighbor algorithm aims to predict the classification status of production in the next period. Principle of this algorithm is to find a pattern of a data set (training tuples) and the classification of data of unknown classification (unknown tuple) [5]. Classification is done by measuring the

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distance to the k nearest training tuples where item data as reference and fix data in the problem domain and unknown tuples which indicate data to be classified within the proposed solution. In this study, the closest distance is calculated by Euclidian distance (1.5).

$$dist(x_1, x_2) = \sqrt{\sum_{i=1}^{n} (x_1 i - x_2 i)^2}, x_1 = \text{training tuple}; x_2 = \text{unknown tuples} \quad (5)$$

Company's historical yields data indicate the amount of production losses caused by any constraints have different ranges. Normalization of data needs to be done so that any outcome classification has a valid value. The item of normalized data represented as v' where normalization process of data on each attribute constraints made possible using the following equation.

$$v' = \frac{v - \min_A}{\max_A - \min_A}, \; v = \text{unnormalized data}, A = \text{value on dataset} \quad (6)$$

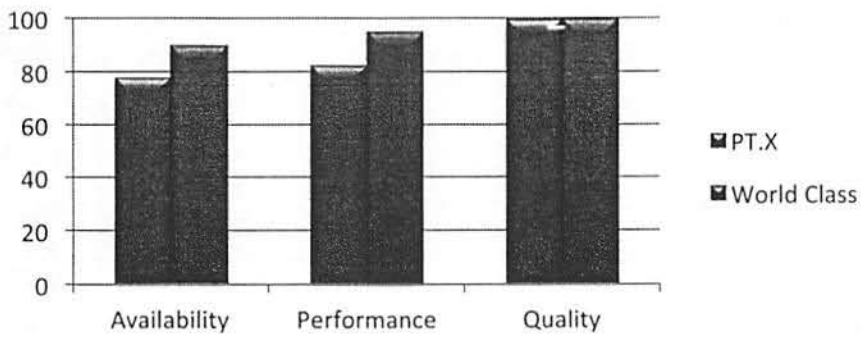
c. Production Constraints sequence

Recursive Elimination of Features or RELIEF technique in attribute selection algorithm is used to give weight to each constraint to a production status. Weight values will be sorted as priority constraints most exhibited significantly causing losses in production. RELIEF is the principle of the technique using the Euclidean distance to the data (instance) of the other data in the same attribute. Instance classified into two, namely Near-hit and Near-miss. Near-hit are the instances that are in one classification while Near-miss has a different classification [6]. In this study, the classification is determined by *k*-nearest neighbor algorithm.

3. Result and Discussion

3.1 Production Constraint Analysis

Study case was conducted using multinational tire company production data which has been collected in several weeks. The OEE was calculated using the three ratios include the level of effectiveness of the time (availability), engine performance (performance) and product quality (quality). Based on the data available, the results are shown in **Figure 1** as follows. Data was compared with world standard of OEE in manufacturing.



In relation to the six big losses components, the production constraints in tire manufacturer were directly observed on field. The result of 8 (eight) main constraints of tire manufacturing (please note that constraints were only focused on machinery issues) and explanation will be spelled out in **Table 1**. *M/C Trouble* is one of the biggest breakdowns of a machine because its failure in tire curing. *The Backward 1st Cure* and *Green Tire Shortage* are constraints caused by mismatch in scheduling or undeliverable production target which will impact the next production activities. *Mold Setting* and *Mold Repair* are some constraints that impacted the performance of production which caused by adjustments of tire size that to be cured. *Bladder Changes* is activity to change the bladder due its durability to maintain quality of tire curing which could easily downgrade quality tire or so called *defect*.

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Table 1. Six Big Losses Identification

No.	Constraints	*Six Big Losses* Category
1.	M/C Trouble	Breakdowns
2.	Backward 1st Cure	
3.	Green Tire Shortage (GTS)	
4.	Mold Setting	Setup and Adjustments
5.	Mold Repair	
6.	Cleaning Tools	
7.	Bladder Changes	
8.	Defect	Reject

As mentioned above, the constraints should be classified and sequenced in order to conclude the production and trigger management action. The classification process is using *k*-nearest neighbor (KNN) as one of data mining technique. The principle of K-Nearest Neighbor (KNN) is looking for the shortest distance between the data to be evaluated with K neighbor (neighbor) in the closest training data. K value can be determined experimentally and we used k=2 with 67,5% accuracy rate. Then do the classifier data test based learning data to obtain production status as can be seen in the **Table 2**.

This classification helped user to determine the data classification of unknown tuples. Each tuple represents daily production. The classification will be interpreted in dashboard to measure the quality of production as key performance index (KPI) i.e. 85% is classified as G or *good,* 75%-85% will be classified as A or *acceptable* and the rest will be classified as NG or *not good.* This method is the most appropriate compared to other technique which has 67.5% accuracy rate, higher than other method i.e. Naïve Bayes classifier or support vector machine (SVM).

While there are many NG classifications, there should be an in-depth analysis to identify the critical parameters of tire curing. Refer to frameworks that have mentioned above, the constraints should be sequenced or weighted to identify the most impacting constraint in tire curing. Constraints on the production of the weight calculation to determine the constraints that have the most impact on production failures. In this study the method used to calculate the RELIEF weight of each constraint. The principle of the calculation is to calculate the *miss* and *hit* each attribute to each classification [5]. This technique resulted weight and ranked to know the most affecting attribute (constraints) on the field. Graph of ranked weight is depicted in **Figure 3**.

Table 2. Classification sample of Production Status

M/C Trouble	Bladder Change	GTS	1st Cure Backward	Mold Setting	Mold Repair	Cleaning Tools	Defect Cure	Others	Classification
0,735	0,552	1,000	0,000	0,000	0,769	0,000	0,245	0,746	A
1,000	0,966	0,835	0,000	0,000	0,000	0,800	0,531	0,302	A
0,000	0,793	0,628	0,000	0,000	0,000	0,000	0,367	0,127	NG
0,295	1,000	0,728	0,000	0,000	0,308	0,000	0,327	0,444	NG
0,344	1,000	0,504	0,000	0,500	0,000	0,000	0,082	0,667	A
0,049	1,000	0,444	0,000	0,000	0,000	0,000	0,000	0,508	NG
0,328	0,188	0,813	0,000	0,000	0,000	0,000	0,000	0,413	NG
0,590	0,906	0,834	0,000	0,000	0,000	0,000	0,143	0,571	NG
0,000	0,204	0,733	0,179	0,000	0,179	0,000	1,000	0,000	A
0,098	0,463	0,382	0,000	0,000	0,000	1,000	0,347	0,000	A
0,000	0,778	0,421	0,000	0,000	0,000	0,000	0,163	0,000	NG

Note:
A = Acceptable
NG = Not Good

Those calculations above will become the core computational calculation for the monitoring dashboard of business intelligence application. The model and system architecture will explained below.

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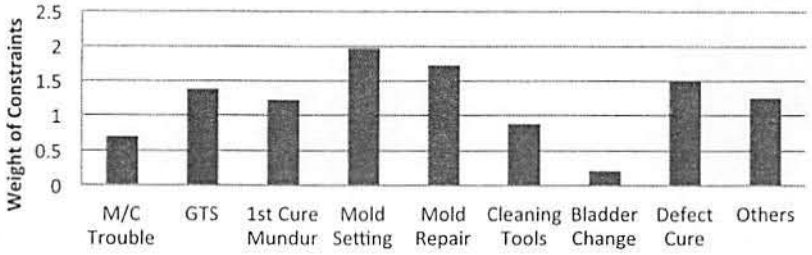

Figure 1. Critical Constraints on Tire Curing

3.2 Business Intelligence System Model and Mobile-Based Software for Productivity Evaluation

The relation of productivity measurement and business intelligence are interpreted in KPI and dashboard. The numbers that have been calculated using methods above become the parameters to determine the quality of production. The dashboard itself helps management to decide dynamic-based events that usually happens during production. All the data were collected in data warehouse from any stakeholders. Data were processed in computational exercises that consist of data mining technique to extract information and conclusion over the scattered data. The illustration of real time BI concept is **Figure 4** below.

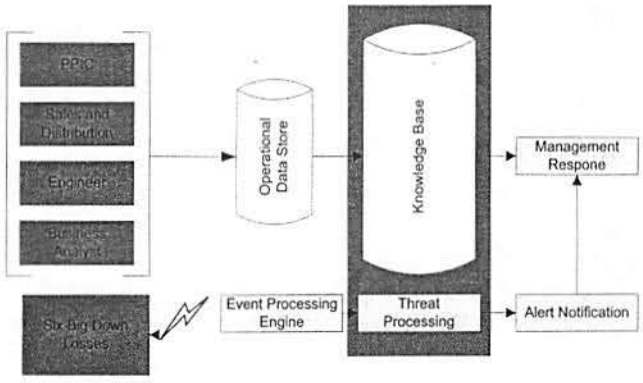

Figure 2. Business Intelligence Concept

The requirement will be elaborated using business process model. Business process model is a model to help identifying, illustrating and elaborating a problem in a business. Business process is one or more procedures to reveal business objectives, usually in the context of organizational structure that define the functional role and its relation [9]. The model is using Business Process Model Notation 2.0 that defines the process of information and become the basis of business intelligence system architecture. Business process model is illustrated in **Figure 5** below. The highlighted process is the critical business intelligence components that will translated into dashboard.

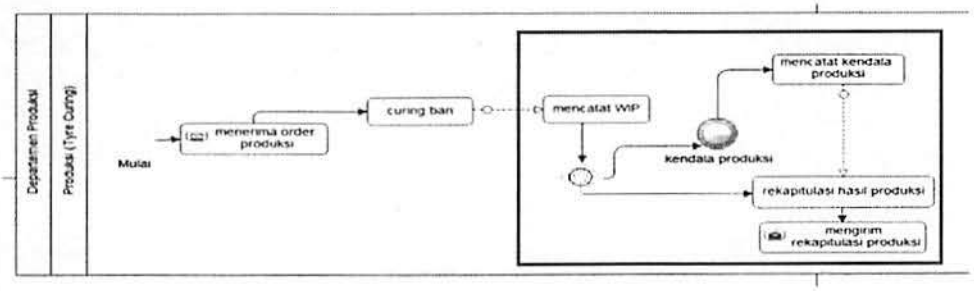

Figure 3. Process Basis Fragment of Business Intelligence

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Design an information system into mobile-based package were then compiled with object-oriented programming using Unified Modeling Language (UML). UML is used to meet the visual modeling needs in specifying, illustrating, building and documentation of software system. UML is also termed as visual language for modeling and communication in relation to a system using supporting diagram [10]. In this paper, the software was built using Android platform, which could be applied in any recent devices. The software is real-time connected to the server and other PC.

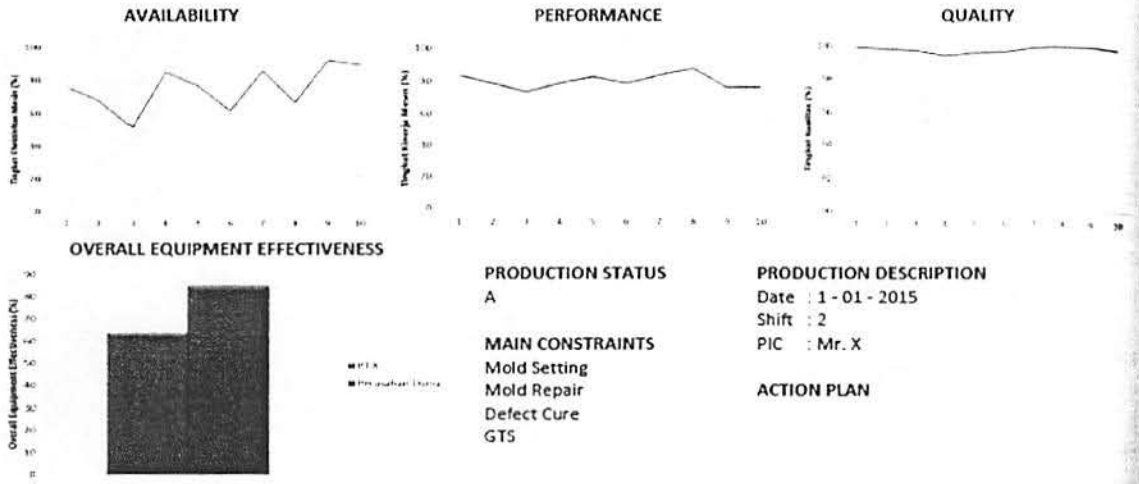

Figure 4. BI Dashboards for Productivity Measurement

4. Conclusion

This paper proposed a construction to build Android based mobile Business Intelligence application by first identifying critical parameters of production line in effectiveness measurement and machine utilization, and then by analyzing the requirement of information system as a mobile BI system and eventually by integrating the design into a mobile system. These computational exercises were elaborated as Key Performance Index (KPI) to be monitored on dashboard and likely to trigger management decision which naturally to cover the dynamic-based production events production. By compiling end to end critical factors in tire curing production, the dashboard would inform operators and management the real time situation in production line as the core of business intelligence (BI) concept. This mobile BI-system of production evaluation is the initial steps and expected to develop whole tire production process or other manufacturing company. Furthermore, in order to enhance the focal point of business intelligence and OEE as an integrated system of enterprise resource planning (ERP) with Overall Financial Effectiveness (OFE) to measure the cost reduction and asset depreciation of machinery and equipment.

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