



## QUICK CHANGEOVER (SMED)

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Quick Changeover is the time between the last good piece off the current run and the first good piece off the next run.

Before Shigeo Shingo's Single Minute Exchange of Die (SMED) improvements, basic setup tasks and related time breakdowns consumed a lot of time.

3 stages of SMED:

- **Separate Internal and External Setup:** develop and implement changeover checklists; perform function checks on parts and tools; reduce transportation of tools, parts, and materials.
- **Convert Internal Setup to External Setup:** prepare operating conditions in advance; standardize functions; use intermediary jigs.
- **Streamline Internal and External Elements:** implement parallel operations; eliminate the need for adjustments; use functional clamps; mechanize functions.

**MAINTAIN A VISUAL, ORGANIZED WORKPLACE**



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