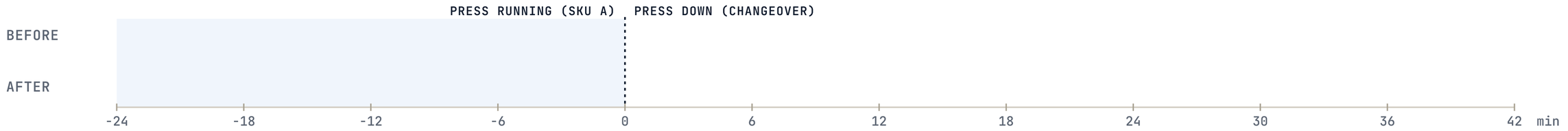
SMED CHANGEOVER WORKSHEET · CONCLUSION

EQUIPMENT	CHANGEOVER	LINE	TIMED
SHEET	OWNER	FOLLOWS	UNIT

1 CHANGEOVER GANTT: BEFORE VS. AFTER



2 STEPS & CLASSIFICATION · I = ONLY WITH THE PRESS DOWN · E = DOABLE WHILE IT RUNS

#	STEP AS TIMED · ACTUAL ORDER	MIN:S	BEFORE	AFTER	ACTION

Total with the press down (sum of I steps) External (E):

3 REMAINING INTERNAL TIME · PARETO · PHASE 2

INTERNAL STEP	MIN:S	%	CUM. %

Total internal

4 SCOPE: WHAT THIS ISN'T YET

- [ ] Convert I → E steps (sequence, $0)
- [ ] One-turn clamps
- [ ] Locating stops, no adjustment
- [ ] New die cart

● **Don't buy tooling before the floor proves it**

5 RESULT AND ACTION

Projected =

Actual (stopwatch) =

ACTION