

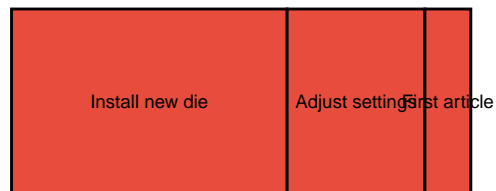
# SMED: From 130 Minutes to 50 Minutes

External activities moved to run during production

**BEFORE  
(130 min)**



**AFTER  
(50 min)**



External done  
during production

Setup Type



External



Internal