

## Case Study 2

## SMED or Quick Changeover

[illegible]

## Changeover Time



By Hydrargyrum (enwiki) [Public domain], via Wikimedia Commons

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# Molding Changeovers

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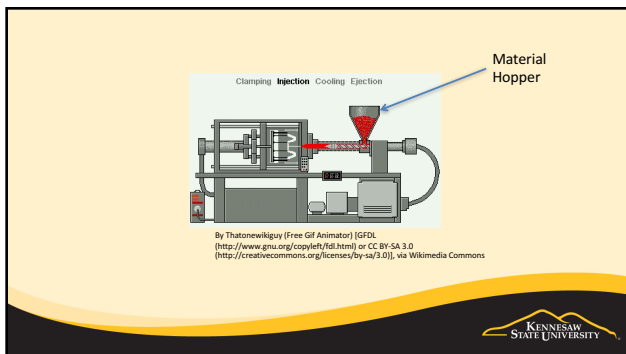
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### Results

	Before Lean	After Lean
Number of changeovers	12 / month	120 / month
Mold changeover time	6 hours	40 minutes
Material changeover time	4 hours	zero
Die changeover	8 hours	1 hour

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