



# SMED Template

Processing Product A to Product B / 11 Jun 2021

Complete

Score	50%	Failed items	1	Actions	3
Changeover				Processing Product A to Product B	
Equipment				Forming press and stamping dies	
Time Equipment is Running				When forming press is stamping raw material	
Time Equipment is Stopped				When forming press is idle	
[Before SMED] Equipment Changeover Time				1 hour (average) to 3 hours (maximum)	
Production line / process				Making auto parts for different vehicles	
# of Operators					200
Date Prepared					11th Jun, 2021 1:03 PM PST
Prepared by					Otto AutoMaker
Location					Kansas, USA (39.011902, -98.4842465)

## Failed Items & Actions

1 failed, 3 actions

### Failed items

1 failed, 2 actions

#### Single-Minute Exchange of Dies (SMED) / Changeover Element / Changeover Element 2

Were we able to shorten the Time Required for this changeover element?

No

We still have to replace bolts with functional clamps and decide on the standardized settings.

Can't do | Assignee SafetyCulture Staff | Priority Medium | Due 16th Jun, 2021 2:42 PM PST |  
Created by SafetyCulture Staff

Meet with facility manager to request for functional clamps.

In progress | Assignee SafetyCulture Staff | Priority Low | Due 11th Jun, 2021 4:30 PM PST |  
Created by SafetyCulture Staff

Hold a meeting with operators to discuss standardized settings to be added.

### Other actions

1 action

#### Single-Minute Exchange of Dies (SMED) / Changeover Element / Changeover Element 2

Were we able to successfully convert this changeover element to external?  
(Meaning, it can now be performed while the equipment is running)

No

We don't have any spare plates to use. We might have to order new ones.

To do | Assignee SafetyCulture Staff | Priority High | Due 18th Jun, 2021 3:00 PM PST | Created by  
SafetyCulture Staff

Order new plates for parts standardization.

# Single-Minute Exchange of Dies (SMED)

3 actions, 1 failed, 50%

## Changeover Element

3 actions, 1 failed, 50%

### Changeover Element 1

100%

Description

Moving materials and tools

Time Required

20 minutes

Can this changeover element be performed while the equipment is running?

Yes



Photo 1

Indicate that this is an external changeover element:

External Changeover Element

### Changeover Element 2

3 actions, 1 failed, 0%

Description

Set-up

Time Required

20 minutes

Can this changeover element be performed while the equipment is running?

No

How would we be able to perform this changeover element while the equipment is running, instead of performing it only when equipment is stopped?

Add a plate to the die to standardize parts for set-up

Were we able to successfully convert this changeover element to external? (Meaning, it can now be performed while the equipment is running)

No

We don't have any spare plates to use. We might have to order new ones.

To do | Assignee SafetyCulture Staff | Priority High | Due 18th Jun, 2021 3:00 PM PST | Created by SafetyCulture Staff

Order new plates for parts standardization.

Indicate that this is an internal changeover element:

Internal Changeover Element

How can we perform this changeover element in less time?

We can use functional clamps so that fastening/unfastening clamps can be done in one movement.

### How can we make performing this changeover element easier?

We can use the SMED technique of eliminating adjustments by adding standardized settings to the equipment.

Were we able to shorten the Time Required for this changeover element?

No

We still have to replace bolts with functional clamps and decide on the standardized settings.

Can't do | Assignee SafetyCulture Staff | Priority Medium | Due 16th Jun, 2021 2:42 PM PST |  
Created by SafetyCulture Staff

Meet with facility manager to request for functional clamps.

In progress | Assignee SafetyCulture Staff | Priority Low | Due 11th Jun, 2021 4:30 PM PST |  
Created by SafetyCulture Staff

Hold a meeting with operators to discuss standardized settings to be added.

### Changeover Element 3

66.67%

Description

Centering or preparing products for processing

Time Required

20 minutes

Can this changeover element be performed while the equipment is running?

No

How would we be able to perform this changeover element while the equipment is running, instead of performing it only when equipment is stopped?

We can use the SMED technique of using intermediate or duplicate jigs. While the 1st product is being processed, we can prepare the 2nd product on a jig which can be easily attached to the equipment.

Were we able to successfully convert this changeover element to external? (Meaning, it can now be performed while the equipment is running)

Yes

Indicate that this has been converted to an external changeover element:

External Changeover Element

### Reduced Equipment Changeover Time

[After SMED] Equipment Changeover Time

20 minutes

## Appendix



Photo 1