

Diagnostic Questions: Has the company studied the costs associated with downtime resulting from changeover?

Are all changeovers routinely performed in less than ten minutes?

Where necessary, is the company equipped to perform changeovers in less than three minutes (or within one machine cycle)?

Level 1 Plan	Level 2 Pilot	Level 3 Deploy	Level 4 Integrate	Level 5 Excel
<ul style="list-style-type: none"> ▪ 1 or 2 changeovers per month, regardless of customer requirements, taking as much as half a day each 	<ul style="list-style-type: none"> ▪ Management studies impact of changeovers on plant capacity and flexibility ▪ People aware of changeover needs ▪ Die change analysis and pilot changeover improvement projects begun 	<ul style="list-style-type: none"> ▪ Changeover teams active in most major areas ▪ All employees trained in quick changeover techniques ▪ Changeover times decreasing 	<ul style="list-style-type: none"> ▪ "One-touch exchange of die" implemented on bottleneck equipment ▪ Ten-minute maximum on all changeovers 	<ul style="list-style-type: none"> ▪ Changeovers done within cycle times ▪ Changeovers automated where necessary ▪ FMS used where necessary to ensure precise control