

“REDUCING MACHINE SET-UP TIME”

In November 2006 the NSW region TPM³ Lean Learning Group met for the seventh time for the year to again share learning’s on the road to Operational Excellence. Representatives from Masterfoods, General Mills, Pfizer, Cormack Packaging, Monroe Springs, Ansto, Ingal Civil, Huhtamaki, NCI Packaging and Sanitarium Health Foods were participants in an interactive discussion and sharing of learning’s on Reducing Machine Set-Up Time.

Discussion amongst the group firstly focused on the challenges everyone was facing at their respective sites and the need for a reduction in the time lost due to machine set-ups and changeovers. Common issues raised included the:

- The demand for small lot sizes
- Rapid response times to meet customer demands
- The need to keep inventory down
- Multiple SKU’s

Amongst the group it was highlighted that typically 10 to 40% of machine time was being taken up by Set-Ups or Changeovers.

To understand the opportunities to reduce these times the 3 parts of Set-Up Downtime Reduction were briefly discussed:

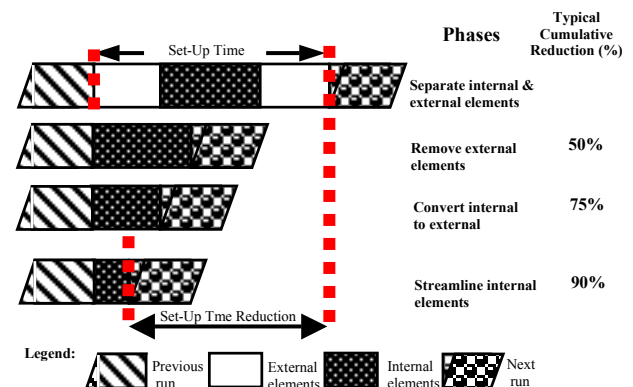
- Schedule Optimisation (Set-Up Impact Reduction)
- Simplification (Set-Up Time Reduction)
- Sustainability (Work Area Management)

The focus of the meeting became Set-Up Time Reduction – those changes which can be made to reduce the time between the last quality product of a run and the first quality product of the next run, running at optimal rate.

It was at this point that the group was introduced to the 4 Phase Process of Set-Up Time Reduction.

Set-Up Time Reduction

Set-up Time Reduction 4 Phase Process



Examples were given from sites which had achieved reductions by use of this four phase process – with a minimum of 50% reduction in set-up / changeover time being achieved in a 12 week period of improvement activity.

After some discussion and networking time half way through the meeting, the group was challenged to put the theory they had learnt into practice by participating in the “Run-a-Muck” Set-Up / Changeover Time Reduction activity.



After being shown how to run the simple printing operation by the highly skilled TPM³ Navigators the group was split into 3 teams to see who could determine the shortest changeover time achievable. By analysing each of the elements in the changeover and separating internal and external elements the teams were asked to calculate their reduced changeover time.



One team boldly predicted a time of less than 60 seconds – from an original time of 14 minutes demonstrated by the TPM³ Navigators. This time was not only achieved but also bettered.

Once again an informative and fun time was had by all who attended. Being the last meeting for the year, we wish to thank all those who have supported the NSW region TPM³ / Lean Learning Group meetings throughout the year.



For further information about TPM³ – Australasian Lean or future TPM³ – Australasian Lean Learning Group Meetings in 2007 contact Keith Saul, NSW / QLD Regional Manager on 0418 663 563.