

Changeover performance report

All records

CAPSULEM8

CM8-289 · Changeover Tracker
August 9, 2026

CHANGEOVERS LOGGED
12
3 machines in this filter

AVERAGE CHANGEOVER
24.4 min
target 20 min · goal 10 min

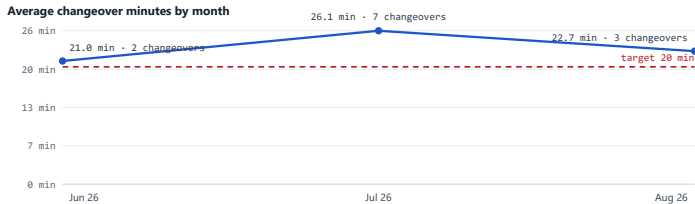
BEST VS WORST MACHINE
15.3 vs 35.3 min
CNC mill 1 best · Assembly line B worst

FIRST-OFF RIGHT FIRST TIME
58.3%
7 of 12 approved without adjustment

TOTAL CHANGEOVER TIME
4.9 h
12 changeovers · 7 over target

BIGGEST DELAY REASON
Tooling not ready
18.0 min lost over 3 changeovers

12 of 12 record(s) included. All records. Amounts in USD.



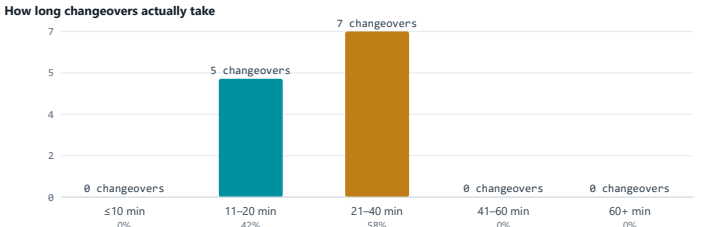
Each point is the mean of every changeover logged that month. The dashed line is your target. A falling line with a steady count is real improvement; a falling line with a collapsing count usually means people stopped logging. Each point is the mean of every changeover logged that month. The dashed line is your target. A falling line with a steady count is real improvement; a falling line with a collapsing count usually means people stopped logging.



Most of what appears here happened before the machine stopped — tooling not staged, paperwork not printed, a setter still on another job. That is external work sitting inside the stop, and it is the cheapest thing on this page to fix. Most of what appears here happened before the machine stopped — tooling not staged, paperwork not printed, a setter still on another job. That is external work sitting inside the stop, and it is the cheapest thing on this page to fix.



The machine at the top of this chart is where the next hour of production is hiding. A machine that sits still at the same average, changeover after changeover, is not having a bad run — it has a cause nobody has removed. The machine at the top of this chart is where the next hour of production is hiding. A machine that sits still at the same average, changeover after changeover, is not having a bad run — it has a cause nobody has removed.



The spread matters more than the mean. An average of 22 minutes made of twelves and forties is two different processes sharing one number — and only one of them needs fixing. The spread matters more than the mean. An average of 22 minutes made of twelves and forties is two different processes sharing one number — and only one of them needs fixing.

Changeover log

DATE	MACHINE	FROM → TO	TYPE	PLANNED	ACTUAL	VARIANCE	EFFICIENCY	FIRST-OFF	ADJUST.	DELAY REASON
2026-08-04	Injection press 3	Closure 8 → Cap — white	Material	20.0	17.0	-3.0	117.6%	✓	0	—
2026-08-03	CNC mill 1	Spacer 14 → Bracket 44-A	Clean-down	15.0	18.0	+3.0	83.3%	—	1	First-off failures
2026-08-01	Assembly line B	Frame 6 door → Frame 4 door	Tooling	30.0	33.0	+3.0	90.9%	✓	0	Material not staged
2026-07-24	Injection press 3	Cap — natural → Closure 8	Full	20.0	22.0	+2.0	90.9%	—	1	Paperwork or program
2026-07-21	Assembly line B	Frame 2 door → Frame 6 door	Full	30.0	38.0	+8.0	78.9%	—	3	Tooling not ready
2026-07-19	CNC mill 1	Spacer 12 → Spacer 14	Settings	15.0	13.0	-2.0	115.4%	✓	0	—
2026-07-12	Injection press 3	Cap — blue → Cap — natural	Tooling	25.0	24.0	-1.0	104.2%	✓	0	—
2026-07-10	Assembly line B	Frame 4 door → Frame 2 door	Tooling	30.0	34.0	+4.0	88.2%	✓	0	Tooling not ready
2026-07-07	CNC mill 1	Bracket 44-B → Spacer 12	Tooling	15.0	16.0	+1.0	93.8%	✓	0	—
2026-07-02	Assembly line B	Frame 2 door → Frame 4 door	Tooling	30.0	36.0	+6.0	83.3%	—	2	Tooling not ready
2026-06-30	Injection press 3	Cap — white → Cap — blue	Material	25.0	28.0	+3.0	89.3%	—	2	First-off failures
2026-06-29	CNC mill 1	Bracket 44-A → Bracket 44-B	Settings	15.0	14.0	-1.0	107.1%	✓	0	—
Total				270.0	293.0					

By machine

MACHINE	CHANGEOVERS	AVERAGE ACTUAL	BEST	WORST	OVER TARGET	FIRST-OFF RATE	TOTAL MINUTES
Assembly line B	4	35.3	33.0	38.0	4	50.0%	141.0
Injection press 3	4	22.8	17.0	28.0	3	50.0%	91.0
CNC mill 1	4	15.3	13.0	18.0	0	75.0%	61.0
All machines	12	24.4			7	58.3%	293.0

Changeover log

DATE	MACHINE	SHIFT	FROM	TO	TYPE	PLANNED	ACTUAL	SETTER	FIRST-OFF	PASSED	FIRST TIME	ADJUST.	DELAY	DELAY DETAIL	VARIANCE	AGAINST TARGET	EFFICIENCY
2026-06-29	CNC mill 1	Early	Bracket 44-A	Bracket 44-B	Settings	15.0	14.0	J. Okonkwo	Yes			0.0	None	—	-1.0	Within target	10
2026-06-30	Injection press 3	Early	Cap — white	Cap — blue	Material	25.0	28.0	A. Mensah	No			2.0	First-off	Colour streaking on the first two shots	3.0	Over target	8
2026-07-02	Assembly line B	Late	Frame 2 door	Frame 4 door	Tooling	30.0	36.0	P. Varga	No			2.0	Tooling	Jig still fitted to the rework bench	6.0	Over target	8
2026-07-07	CNC mill 1	Day	Bracket 44-B	Spacer 12	Tooling	15.0	16.0	J. Okonkwo	Yes			0.0	None	—	1.0	Within target	9
2026-07-10	Assembly line B	Early	Frame 4 door	Frame 2 door	Tooling	30.0	34.0	P. Varga	Yes			0.0	Tooling	Jig fetched from the rework bench again	4.0	Over target	8

DATE	MACHINE	SHIFT	FROM	TO	TYPE	PLANNED	ACTUAL	SETTER	FIRST-OFF	PASSED FIRST TIME	ADJUST.	DELAY	DELAY DETAIL	VARIANCE	AGAINST TARGET	EFFICIENCY
2026-07-12	Injection press 3	Night	Cap — blue	Cap — natural	Tooling	25.0	24.0	A. Mensah	Yes		0.0	None	—	-1.0	Over target	10
2026-07-19	CNC mill 1	Early	Spacer 12	Spacer 14	Settings	15.0	13.0	L. Duarte	Yes		0.0	None	—	-2.0	Within target	11
2026-07-21	Assembly line B	Late	Frame 2 door	Frame 6 door	Full	30.0	38.0	S. Bekele	No		3.0	Tooling	Locating pin damaged, replacement not on the board	8.0	Over target	7
2026-07-24	Injection press 3	Early	Cap — natural	Closure 8	Full	20.0	22.0	A. Mensah	No		1.0	Paperwork	Program revision not loaded at the machine	2.0	Over target	9
2026-08-01	Assembly line B	Early	Frame 6 door	Frame 4 door	Tooling	30.0	33.0	P. Varga	Yes		0.0	Material	Hinge pack still in goods-in	3.0	Over target	9
2026-08-03	CNC mill 1	Night	Spacer 14	Bracket 44-A	Clean-down	15.0	18.0	L. Duarte	No		1.0	First-off	Surface finish out on the first part after the clean-down	3.0	Within target	8
2026-08-04	Injection press 3	Day	Closure 8	Cap — white	Material	20.0	17.0	A. Mensah	Yes		0.0	None	—	-3.0	Within target	11

Notes

Sample log covering six weeks across three machines. Assembly line B has lost time to tooling that is not staged in three of its four changeovers — that is the action, not a faster setter. Replace every entry with your own before circulating this.

This log measures what somebody recorded. Changeovers nobody logs are exactly the ones worth seeing — the four-hour recovery on a night shift, the second attempt nobody wanted to write down — and their absence flatters every figure on this page. Treat a suspiciously tidy log as a reporting problem before you treat it as a result. Planned minutes are your own standard, not an independent measurement, and an average built on a handful of changeovers moves with a single bad day.