

SMED changeover analysis

All records

CURRENT CHANGEOVER
1 h 19 m
10 timed tasks · 76.0 min with the machine stopped

INTERNAL TIME NOW → AFTER
76 → 26 min
the SMED promise: 50.0 min off the stop

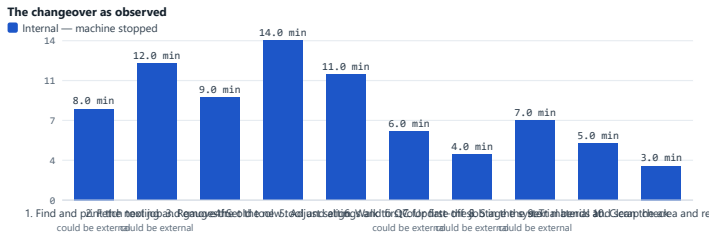
COULD MOVE OUT NOW
5 tasks
37.0 min still inside the stop for no good reason

PROJECTED CHANGEOVER
26.0 min
16.0 min above your 10-minute target

TASKS STANDARDISED
1
of 10 in the study — the job is not done until this is all of them

MACHINE STUDIED
Press brake 2
2026-07-31

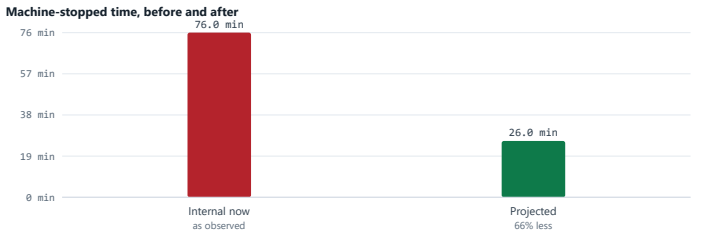
10 of 10 record(s) included. All records. Amounts in USD.



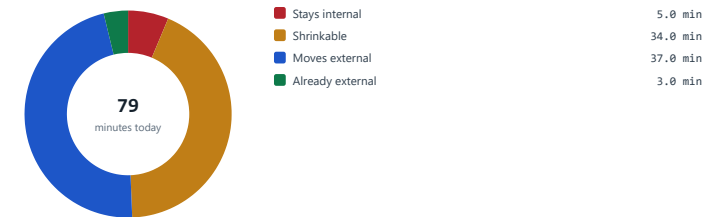
Read it top to bottom: this is the changeover as the stopwatch saw it. Every internal bar is machine downtime; every internal bar that could be external is the classic SMED finding. Read it top to bottom: this is the changeover as the stopwatch saw it. Every internal bar is machine downtime; every internal bar that could be external is the classic SMED finding.



Only tasks with a streamlined time entered appear here. Tasks that move outside the stop entirely are a separate, usually larger, win — the tiles count those. Only tasks with a streamlined time entered appear here. Tasks that move outside the stop entirely are a separate, usually larger, win — the tiles count those.



The headline of the study. The projected bar assumes every “move it out” actually moves and every streamlined time is achieved — prove it on the machine before you publish it. The headline of the study. The projected bar assumes every “move it out” actually moves and every streamlined time is achieved — prove it on the machine before you publish it.



“Moves external” costs nothing but organisation. “Shrinkable” usually costs a little tooling. What stays internal after both is the changeover you will actually have. “Moves external” costs nothing but organisation. “Shrinkable” usually costs a little tooling. What stays internal after both is the changeover you will actually have.

The changeover, task by task

#	TASK	MIN	NOW	CAN MOVE?	IMPROVEMENT	POTENTIAL	STATUS
1	Find and print the next job paperwork	8.0	Internal	Yes — move it	Print the job pack during the previous run and clip it to the machi...	—	Trialled
2	Fetch tooling and gauges from the store	12.0	Internal	Yes — move it	Changeover trolley staged at the machine before the run ends, loade...	—	Planned
3	Remove the old tool	9.0	Internal	No	Replace threaded clamps with quick-release clamps; keep the two spa...	3.0	Planned
4	Set the new tool and align	14.0	Internal	No	Standard tool heights and locating pins so the tool seats in positi...	6.0	Planned
5	Adjust settings and first-off	11.0	Internal	Partly	Pre-set the back gauge and program from the job card while the mach...	4.0	Observed
6	Walk to QC for first-off sign-off	6.0	Internal	Yes — move it	QC comes to the machine on a call — or the operator self-checks aga...	—	Observed
7	Update the job in the system	4.0	Internal	Yes — move it	Book the job at the terminal after the machine has restarted — the ...	—	Planned
8	Stage the next material at the machine	7.0	Internal	Yes — move it	Forklift delivers the next pack to the marked square beside the pre...	—	Planned
9	Trial bends and scrap check	5.0	Internal	No	—	—	Observed
10	Clean the area and return old material	3.0	External	No	Already done while the next job runs — keep it that way in the new ...	—	Standard
Total		79.0				13.0	

Implementation plan

TASK	ACTION	OWNER	OFF THE STOP	STATUS
Fetch tooling and gauges from the store	Changeover trolley staged at the machine before the run ends, loaded from a shadow board so a missing item is visible at a glance.	Setter	12.0 min	Planned
Find and print the next job paperwork	Print the job pack during the previous run and clip it to the machine — the press has no reason to stand still for paper.	Cell leader	8.0 min	Trialled
Stage the next material at the machine	Forklift delivers the next pack to the marked square beside the press before the current run finishes.	Logistics	7.0 min	Planned
Set the new tool and align	Standard tool heights and locating pins so the tool seats in position without measuring; quick clamps as above.	Maintenance lead	6.0 min	Planned
Walk to QC for first-off sign-off	QC comes to the machine on a call — or the operator self-checks against the boundary sample kept at the press.	Quality lead	6.0 min	Observed
Adjust settings and first-off	Pre-set the back gauge and program from the job card while the machine is still running the previous job; keep only the first-off bend itself internal.	Setter	4.0 min	Observed
Update the job in the system	Book the job at the terminal after the machine has restarted — the press does not need to wait for a keyboard.	Cell leader	4.0 min	Planned
Remove the old tool	Replace threaded clamps with quick-release clamps; keep the two spanners still needed on the trolley, not in the toolbox.	Setter	3.0 min	Planned
Total			50.0 min	

Changeover tasks

MACHINE	DATE	#	TASK	MIN	NOW	CAN MOVE?	AFTER	OWNER	STATUS	POTENTIAL	FLAG
Press brake 2	2026-07-31	1	Find and print the next job paperwork	8.0	Internal	Yes	0.0	Cell leader	Trialled	0.0	Move out
Press brake 2	2026-07-31	2	Fetch tooling and gauges from the store	12.0	Internal	Yes	0.0	Setter	Planned	0.0	Move out
Press brake 2	2026-07-31	3	Remove the old tool	9.0	Internal	No	6.0	Setter	Planned	3.0	—
Press brake 2	2026-07-31	4	Set the new tool and align	14.0	Internal	No	8.0	Maintenance lead	Planned	6.0	—

MACHINE	DATE	#	TASK	MIN	NOW	CAN MOVE?	AFTER	OWNER	STATUS	POTENTIAL	FLAG
Press brake 2	2026-07-31	5	Adjust settings and first-off	11.0	Internal	Partly	7.0	Setter	Observed	4.0	—
Press brake 2	2026-07-31	6	Walk to QC for first-off sign-off	6.0	Internal	Yes	0.0	Quality lead	Observed	0.0	Move out
Press brake 2	2026-07-31	7	Update the job in the system	4.0	Internal	Yes	0.0	Cell leader	Planned	0.0	Move out
Press brake 2	2026-07-31	8	Stage the next material at the machine	7.0	Internal	Yes	0.0	Logistics	Planned	0.0	Move out
Press brake 2	2026-07-31	9	Trial bends and scrap check	5.0	Internal	No	0.0	Setter	Observed	0.0	—
Press brake 2	2026-07-31	10	Clean the area and return old material	3.0	External	No	0.0	Setter	Standard	0.0	—

Notes

Sample study — replace every task with your own timings before relying on the projection.

Every figure here comes from the times you entered, and those times usually come from one observed changeover. One changeover is a snapshot, not a standard: a different operator, a different tool pair or a bad day can move every number. Observe two or three changeovers before locking the new standard, and treat the projected time as a target to prove on the machine, not a result. This is an analysis aid, not engineering advice — clamping, tooling and guarding changes must be assessed by whoever is competent for that machine.