LEAN MANUFACTURING
SINGLE MINUTE EXCHANGE OF DIES
REDUCTION OF SETUP TIME

BACKGROUND
Keats Southwest was founded in 1994 at El Paso, Texas. Keats produces high precision small metal stampings used in a variety of applications including automotive, power distribution, consumer goods, medical and appliance.

PROBLEM
Longer setup times on progressive die presses.

OBJECTIVE
Develop and implement a process for reduction of setup times on progressive die presses by 50%.

METHODODOLOGY
• Single Minute Exchange of Die (SMED)
• Videotape process
• Brainstorming
• Convert internal to external elements
• Identify and eliminate waste
• Principles of 5S
• Standardize

RESULTS
Setup time reduction of 75.41 minutes, 84% from the original time.

• 4 activities were eliminated.
• 3 activities were converted from internal to external.

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