

CHAPTER 7

ANALYSIS AND IMPROVEMENT OF PRINT CHANGE SET-UP TIME USING THE SINGLE-MINUTE EXCHANGE OF DIES (SMED) METHOD (Case Study: PT. XYZ)

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1.1 Introduction

Productivity is one of the performance indicators of a production process. Manufacturing companies are required to increase the productivity of their production processes sustainably to save production costs and improve quality and company competitiveness [1]. In manufacturing companies, one of the problems encountered on the production floor is mould/dies exchange problems. To reduce machine downtime, mould changes need to be carried out in the shortest possible time using an effective and efficient method. One of the methods used for analyzing and improving the technique of changing the mould is the Single-minute Exchange of Dies (SMED) method. SMED is a technique developed in lean manufacturing studies where mould changes need to be done in the shortest possible time (single-minute) [2].

This research case study was conducted at PT. XYZ, It is company a manufacturing that produces children's toys. In 2012 and located in East Java, the company started its production activities by making various household products. In 2014, the company had grown to date and expanded its