

Set-Up Reduction Worksheet

Benefits of Set-Up Reduction (Capacity)

Current Method		Example (actual case study):
Minutes per set-up	= _____ minutes	60 minutes
Number of set-ups per 8 hour shift	= _____ set-ups	1.5 set-ups
Total minutes of set-up per shift (set-up minutes x number of set-ups)	= _____ minutes	90 minutes

Using the Ball Lock System		
Minutes per set-up	= _____ minutes	8 minutes
Number of set-ups per 8 hour shift	= _____ set-ups	1.5 set-ups
Total minutes of set-up per shift (set-up minutes x number of set-ups)	= _____ minutes	12 minutes
Increased capacity per machine per shift (current method - Ball Lock method)	= _____ minutes	78 minutes
Savings per machine per shift	= _____ minutes	78 minutes
Increased capacity (number of minutes / 60)	= _____ hours	1.3 hours

Benefits of Set-Up Reduction (Profit)

Machine cost per hour	= \$ _____	\$80.00
Increased production hours per shift (increased capacity from above)	= _____ hours	1.3 hours
Savings (profit) per machine per shift (machine cost per hour x increased production hours)	= \$ _____ per machine per shift	\$104.00 per machine per shift