

### Single Minute Exchange of Die

*Quick Change Over speed wins!*

**SMED** (*Single-Minute Exchange of Die*) is a system for dramatically reducing the time it takes to complete equipment change-overs. While Single-Minute Exchange of Die comes from the goal of reducing changeover times to the “single” digits.

The concept of the SMED system is to convert as many “internal” change-over steps (performed while the equipment is stopped) as possible to “external” (performed while the equipment is running), and to simplify and streamline the remaining steps.

Dramatically improving changeover times may be hard to imagine at first in your organization, but consider the simple example of changing a tire:

#### FOR EXAMPLE

Average person takes **15 minutes**  
to change a single tire

vs,

NASCAR pit crew  
can change **four tires in 6 seconds**

### Benefits

- **Lower Manufacturing Cost:** Faster changeovers mean less equipment downtime.
- **Smaller Lot Sizes:** Faster changeovers enable more frequent product changes.



- **Improved Responsiveness to Customer Demand:** Smaller lot sizes enable more flexible scheduling.
- **Lower Inventory Levels:** Smaller lot sizes result in lower inventory levels.
- **Smoother Startups:** Standardized changeover processes improve consistency and quality.

To learn more about this topic and how  
SCoE can help you with your

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please email us at the link below:  
[CustomerCare@SynergyResources.net](mailto:CustomerCare@SynergyResources.net)