

Set-Up Reduction Worksheet

Current Method

Example

Minutes per set-up	= _____ minutes	60 minutes
Number of set-ups per 8 hour shift	= _____ set-ups	3 set-ups
Total minutes of set-up per shift (set-up minutes x number of set-ups)	= _____ minutes	180 minutes

Using Lenzkes MQ Clamps

Example

Minutes per set-up	= _____ minutes	30 minutes
Number of set-ups per 8 hour shift	= _____ set-ups	3 set-ups
Total minutes of set-up per shift (set-up minutes x number of set-ups)	= _____ minutes	90 minutes
Saving per machine per shift (increased production hours)	= _____ minutes = _____ hours	90 minutes = 1.5 hours

Savings

Example

Machine cost per hour	= \$ _____	\$ 80
Increased production hours per machine per shift (from above)	= _____ hours	1.5 hours
Savings (profit) per machine per shift (machine cost per hour x increased production hours)	= \$ _____	\$ 120 per machine per shift
Savings per machine per day (saving per machine per shift x number of shifts)	= \$ _____	\$ 120 x 3 shifts = \$ 360
Savings per machine per year (Savings per machine per day x 250 days)	= \$ _____	\$ 90,000 per machine per year