



Impact Learning Partners
Capability That Stays

Impact Learning Partners presents:

SMED

Single Minute Exchange of Die

Reduce Changeovers to Single Digits.
Unlock Capacity Without Buying New
Machines.

SMED – Single Minute Exchange of Die

Meet your Instructor:



Bjorn Vikard

Co-Founder & Lead Facilitator, CDLM™
Amazon Best Selling Author

Request In-House Delivery

Tell us your team size, seniority level, and the leadership gap you are addressing. We will propose the right delivery format, programme depth, and timeline.

CDLM is delivered as:

- Corporate in-house programmes
- Executive development tracks
- Leadership pipeline initiatives



The Hidden Profit Killer in Your Factory

Your machines don't just stop. They bleed.

Every changeover:

- Stops production
- Delays customer deliveries
- Forces larger batch sizes
- Builds excess inventory
- Reduces flexibility

You don't need new equipment.

You need faster, smarter changeovers.

And that's exactly what this SMED Training delivers.



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info@impactlearningpartners.org

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What Are Your Changeovers Actually Costing You?

Run this calculation now. It takes 90 seconds.

Step 1 – Changeovers per week: ___

Step 2 – Average changeover duration (minutes): ___

Step 3 – Machine hourly operating cost (\$): ___

Weekly changeover cost = (Step 1 × Step 2 ÷ 60) × Step 3 = \$ ___

Annual changeover cost = Weekly cost × 50 weeks = \$ ___

SMED typically reduces changeover time by 40–60%.

Conservative annual saving at 40% reduction = \$ ___

That number is your business case.

This programme gives you the system to capture it – without capital investment.

The Core Transformation

From Costly Downtime to Competitive Advantage

This program transforms companies that struggle with long, unpredictable changeovers into operations that achieve documented, repeatable changeovers – with before/after time studies and financial impact calculated at every stage.

Participants learn to calculate time savings, convert improvements into measurable financial impact, and increase machine availability without capital investment.

Who This Training is For:

Manufacturing leaders, plant managers, operational excellence teams, production supervisors, and cross-functional Kaizen teams in companies that require:

- More flexibility
- Shorter lead times
- Lower inventory
- Increased uptime
- Higher variant capability

If your customers demand more variation, smaller orders, and faster response – this program is designed for you.



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The 5-Segment SMED System

1. Identify Internal vs. External Steps

Map the process using video analysis, spaghetti diagrams, work element sheets, and data collection.

→ You will be able to distinguish every element of a changeover and categorise it correctly – the foundation step most plants have never done systematically.

2. Convert Internal to External Steps

Apply the guiding principle: Only do what can ONLY be done while the machine is stopped – when it is stopped.

→ You will be able to redesign changeover sequences to move preparation offline – often eliminating 30–50% of downtime in this step alone.

3. Reduce Internal Set-Up Time

Use ECRS, 5 Why root cause analysis, and 5S to improve remaining internal tasks.

→ You will be able to diagnose root causes of slow internal steps and design targeted countermeasures, not workarounds.

4. Reduce External Set-Up Time

Improve preparation, staging, material flow, and standard checklists.

→ You will be able to design staging layouts and preparation checklists that eliminate last-minute scrambles permanently.

5. Standardize and Sustain

Create SOPs, implement audits, track KPIs, and repeat the cycle for continuous improvement.

→ You will be able to build a governance structure that sustains gains and identifies regression before it becomes loss – turning SMED from a project into an operating standard.

What Makes This SMED Program Different

Unlike traditional changeover workshops, this program provides:

- Structured Loss Intelligence → Loss Eradication → Loss Prevention methodology
- Cross-functional team formation and workload alignment
- Formal RACI role clarity and project governance
- Skills matrix integration (Competence Gap Review)
- Visual PDCA-based team boards
- KPI tracking and sustainability audits

This ensures SMED becomes embedded into the operating system of the plant – not treated as a one-time event.

Financial visibility is built into the system, allowing teams to quantify downtime cost, prioritize initiatives strategically, and track measurable savings over time.



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Measurable Business Impact

Organisations implementing this structured SMED system often achieve:

- 30–70% reduction in changeover time
- Increased machine availability
- Reduced lead time
- Lower inventory levels
- Improved responsiveness
- Unlocking hidden capacity without capital expenditure

What Your Plant Looks Like in 90 Days

Within 90 days of programme completion:

Your changeover times on the pilot machine are documented, reduced, and trending lower each week.

Your team has a financial dashboard showing cumulative time and cost savings.

At least one additional machine has been scoped for SMED using your internal team – no external support required.

Your supervisors are leading changeover reviews, not just observing them.

Changeover improvement is on the weekly production agenda – not waiting for a consultant visit.

This is not a vision statement. It is the 90-day outcome your team will plan on Day 3 of the programme.

Request In-House Delivery

Share your production context – number of changeovers, machine types, and team size – and we will tailor the programme scope to your operation before we propose.

