SMED observation sheet

Change-over observation, a common practice, not a standard. I = internal (machine stopped), E = external (machine running). Category: P preparation, M mounting, A adjusting / measuring, T trial.

Change-over

Machine / line	From part / tool	To part / tool	Date	Observer

Steps

No.	Step	Start	End	Duration	I / E	P / M / A / T	Improvement idea

No.	Step	Start	End	Duration	I / E	P / M / A / T	Improvement idea