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How to improve setups
(from Figure 16.4 in
Heizer/Render text).

Step 1: Separate setup
into preparation and
actual setup, doing as
much as possible while
the machine/process is
operating. Step 2: Move
material closer and
improve material
handling Step 3:

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Standardize and
improve tooling Step 4:
Use one-touch system to
eliminate adjustments

Step 5: Train operators
and standardize work
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only one predecessor is
simply the EF of that
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