

Set-up Analysis Chart

Step #	Work Element	Cumulative Time	Net Time	Internal	External	*Waste	Improvement Notes



***3 types of waste:**

1. Setup Waste which includes searching, finding, lining up and selectiing.
2. Replacement Waste which includes unfastening, removing, attaching and fastening.
3. Adjustment wastes which includes fine tuning, tweaking and dry runs.