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Lean Six Sigma Application for the Reduction of the Setup Times in a SMD Assembler

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Abstract. This paper shows that through 6 Sigma set-up times in a surface mount devices automatic assembler were reduced for all the models being run. The electronic components are mounted on PCB boards for cable signals decoders, -DVR's-. The initial condition of the process was an apparently too large downtime, close to 12 hours during model changes, because there is a large investment in the machine, management wants a significant reduction of downtime. The methodology DMAIC and other quality tools were applied and the set up was reduced to an average setup time of 8 hours.

Keywords: Lean Six Sigma, Setup time reduction