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*Page 6/51*

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~~Page 7/51~~

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~~13 Aggregate~~

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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: Standardize and

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improve tooling

Step 4: Use one-touch system to eliminate

adjustments Step

5: Train

operators and

standardize work procedures

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