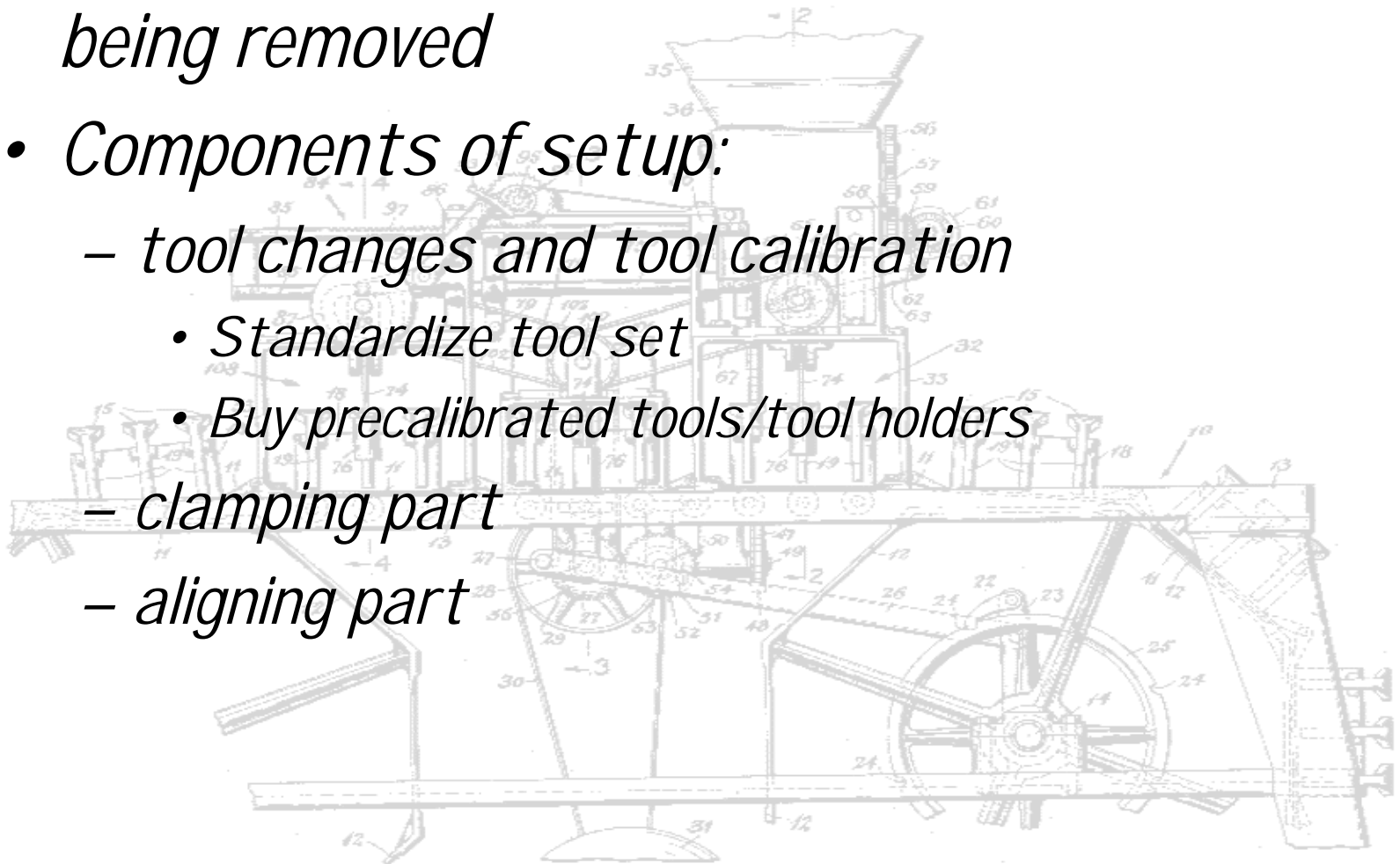


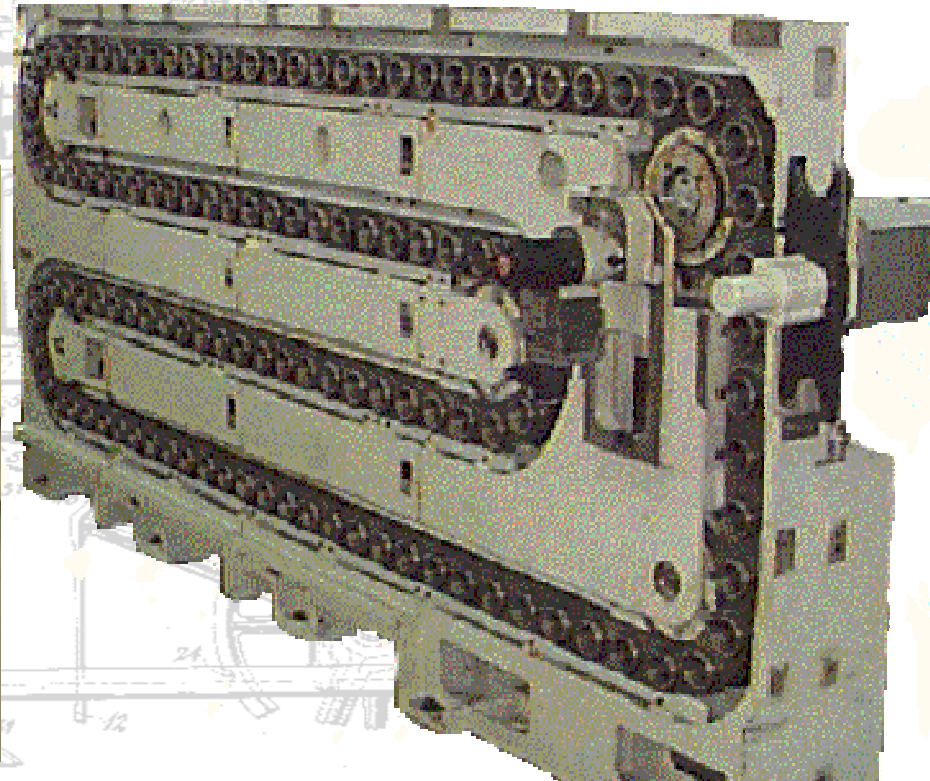
JIGS AND FIXTURES

- *Setup time is non-productive time*
- *Money is only being made while material is being removed*
- *Components of setup:*
 - *tool changes and tool calibration*
 - *Standardize tool set*
 - *Buy precalibrated tools/tool holders*
 - *clamping part*
 - *aligning part*

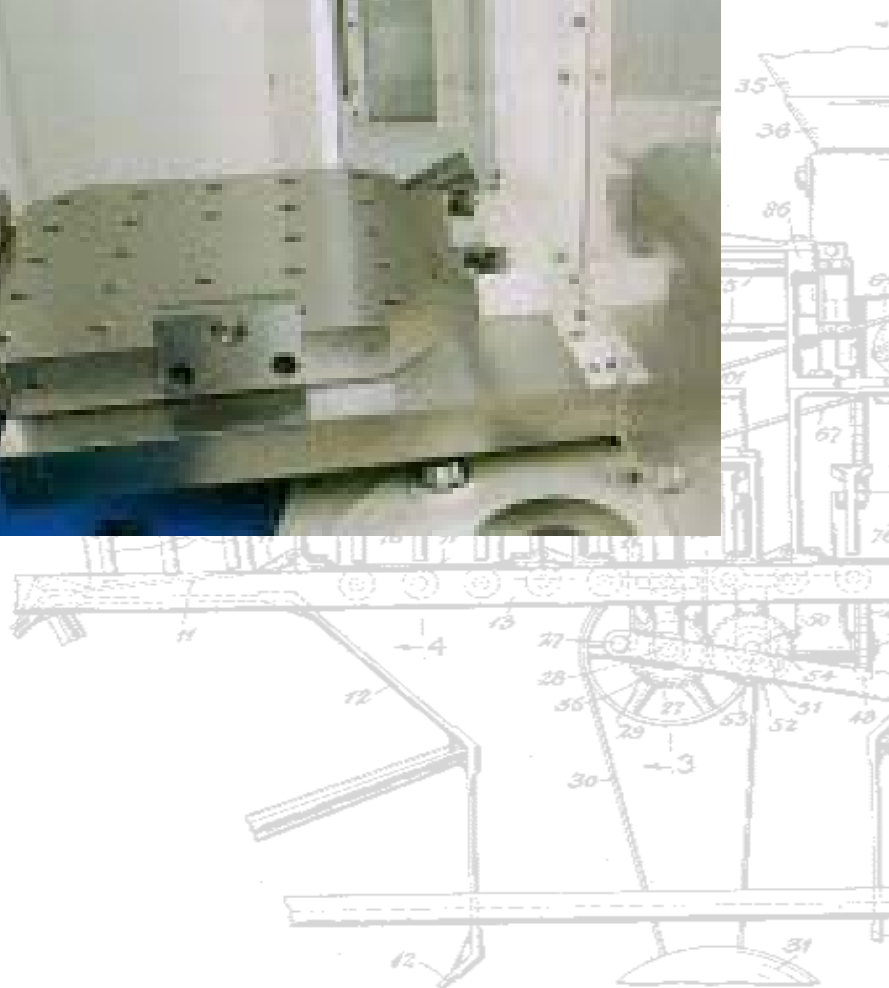


REDUCING SETUP TIME

- *Automatic Tool Changing*
 - # pockets: 10 - 184
 - Tool-tool time: 1.0 - 4.2 sec avg.



FIXTURING



JIGS

