

ABSTRACT

Overall Equipment Effectiveness (OEE) is the metric by which Unilever PC measures the ability of a line to produce the target output on a given period of time. Among the company's 9 production lines, Superline scored the lowest OEE average for the year 2014 at 77.17%. This study aimed to improve Superline's OEE through changeover reduction with the application of Single-Minute Exchange of Die (SMED) and 5S. 5 problems were found: underutilized workers on changeovers, highly-manual adjustment processes, high number of parts involved, non-standard pieces and tools, and the deteriorating condition of the machines. 13 alternative courses of actions were proposed in this study, targeting the 5 factors stated above. The researcher concluded that through a series of engineering design interventions on the machines and an alignment of the workers to the standard changeover process, the changeover can be theoretically reduced by up to 50%.