



# PRADEEP METALS LIMITED

ISO 9001:2008 | AD2000-MERKBLATT W0 | PED 97/23/EC | CRN



# CASE STUDY: ACHIEVING 5-DAY LEAD TIMES



## Challenging Ourselves

### Long Lead Times

- Our initial engagement with Emerson started with a 90-day delivery lead time (45d transit / 45d steel)
  - Rosemount wanted 10days TAKT time plus transit
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### Customer Pressures

- Stringent customer demand due to Rosemount's competition forced them into faster deliveries
  - Rosemount approached PML with their need for shorter lead-times
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### The Challenge

- How can we address our customer's concerns?
  - What should we change to accomplish a 5-day lead time?
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### Our Solution

1. **Internal:** 5-steps to Operational Efficiency
2. **External:** Regionalized Warehousing



## 5-step Internal Change

- 1 Common-ized steel sections
- 2 Developed common forgings for multiple parts
- 3 Created common die-holders and designed quick-swap die inserts for different flanges
- 4 Rationalized Jaw sizes to reduce CNC set-up time and facilitate small batch production
- 5 Increased CNC machining capacity since 2005
  - Turning Centers: 3 → 16
  - Vertical Machining Centers: 0 → 6



## Regional Warehouse (“Supermarket”)

### PML

- Stock for RTR & IMMC
- 316 Parts
- Max. Quantity: 8182 Flanges
- Common forgings for D & F parts

### MCI for RTC

- Opened March 2010, Chicago
- 52 Parts
- Max Quantity: 8662 Flanges
- Value: \$475,000
- Supplied 14,805 flanges last 12 months

### APLL for SMMC

- Opened Nov 2011, Singapore
- 38 Parts
- Max Quantity: 4477 Flanges
- Value: \$180,000
- Supplied 17,138 flanges last 12 months

### RTR

- Planned: Jan 2013, Hamburg
- 29 parts
- Max Quantity: 6050 Flanges
- Value: \$388,000
- Lots 1, 4, 5 & 7 of WS28478634



# Results

MCI for RTC

APLL for SMMC

RTR



- A,B & C parts stored in Kanban quantities at warehouse

**1-DAY** UPS Air Freight



PML



- D & F parts stored as common forgings
- 24h manufacturing turnaround
- 3d air freight

**5-DAY** PO to Dock



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**THANK YOU**

