



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

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

The Challenge

How can we address our customer's concerns?

 What should we change to accomplish a 5-day lead time?

Our Solution **1. Internal**: 5-steps to Operational Efficiency

2. External: Regionalized Warehousing



5-step Internal Change

- Common-ized steel sections
- 2 Developed common forgings for multiple parts
- Created common die-holders and designed quick-swap die inserts for different flanges
- 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

MCI for RTC

APLL for SMMC

RTR

- Stock for RTR & IMMC
- Opened March 2010, Chicago
- Opened Nov 2011, Singapore
- <u>Planned</u>: Jan 2013, Hamburg

• 316 Parts

• 52 Parts

• 38 Parts

• 29 parts

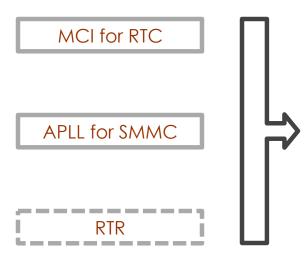
- Max. Quantity: 8182 Flanges
- Max Quantity: 8662 Flanges
- Max Quantity: 4477 Flanges
- Max Quantity: 6050 Flanges

- Common forgings for D & F parts
- Value: \$475,000
- Value: \$180,000
- Value: \$388,000

- Supplied 14,805 flanges last 12 months
- Supplied 17,138 flanges last 12 months
- Lots 1, 4, 5 & 7 of WS28478634

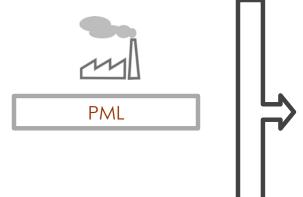


Results



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

1-DAY UPS Air Freight



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

5-DAY PO to Dock



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THANK YOU

