

## Background

A leading apparel provider looking to improve alignment of capacity and materials from Raw materials through Distribution in order to provide increased value in their supply chain. Meeting the Financial plan by aligning the S&OP plan, Master Production Plan and shop floor production plan is critical in this complex environment. Needed a way to plan their supply chain and proactively look for risks to customer service, negative impact on direct cost, and the wrong mix of inventory.

## Challenges

Although the client had SAP in place, there was no effective system in place to optimize supply chain plans and align the company top to bottom. The business also needed a better way to deal with supply chain risk by proactively identifying bottleneck resources, material shortages, and orders deviating from Forecasted demand. Needed a process to manage daily plant production to insure that each area did not sub-optimize based on local incentives.

## Adexa Solution Overview

- Supply Chain Planning
- Plant Planning and Sequencing
- Predictive Analytics
- Master Data Management for SAP

Supply Chain Planning for Monthly, Weekly and Daily processes. Monthly plan to determine how to allocate and configure capacity to match demand for product families and plan long lead time items. Weekly process to plan make to stock orders. Daily plan for make to order products and items at risk of stock out.

- Plan Alignment of Capacity with Demand
- Determine when to make configuration changes to machines
- Order long lead time materials
- Provide a Master Production Schedule and determine how often to make low volume products
- Prioritize demand to meet customer demand in a way that aligns with business priorities
- Allocate capacity to business units and product lines when in oversold position

Plant Planning and Sequencing daily to determine the best sequence to coordinate the main areas of the operation to optimize total throughput and meet demands based on priority. Determine when to schedule machine changeovers to meet demands with the least cost.

- Determine the Detailed configuration of machines to meet demand
- Provide a way to follow the allocation plan when oversold
- Create an optimized sequence that groups orders to minimize changeovers and still meets required due dates.

Predictive Analytics provides visibility of the end to end supply chain and proactively identifies problem areas in the supply chain. Provides actuals to determine trends and plan reliability. Identifies the following risks

- Demands at risk for not being completed by the end of the fiscal period.
- Capacity out of balance with requirements.
- Long lead time materials expected to be below safety stock
- Production that will need to be offloaded to higher cost processes
- Unreliable suppliers with deviations to promised delivery dates
- Inconsistent Production processes that do not deliver to the supply plan