

Dial-in Number: 209 647-1075

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Integrated Supply Chain

This webcast deals with how to assign and initiate a supply chain integration initiative. The target audience is senior leaders and the director or vice president of supply chain management and/or purchasing. The duration is less than one hour.

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Objectives

- ➔ Why is supply chain integration important to your company?
- ➔ What are the basics of working on supply chain integration?
- ➔ How do you organize for supply chain integration?
- ➔ What are the tools of supply chain integration?
- ➔ How can you build the “muscle” to help your suppliers improve?

Supply Chain Integration Defined

- An approach that seeks to coordinate and harmonize all elements of a supply chain from raw material to finished product in order to achieve higher levels of overall performance and reduced cost.

Key Elements of Integrated Supply Chain

- Planning and control
- Work structure
- Organization structure
- Product flow facility structure
- Information flow facility structure
- Management methods
- Power and leadership structure
- Risk and reward structure
- Culture and attitude

According to Wikipedia - http://en.wikipedia.org/wiki/Supply_chain_management - supply chain integration consists of these elements.

Why is it important?

- High speed production
- Low volume, high mix
- Cost reduction
- Customer performance

Roadmap

	Stage One Stabilization	Stage Two Integration	Stage Three Sustaining
Leadership & Culture	1.1.1 Strategic Planning Process 1.1.2 Leadership Communication Process 1.1.3 Organizational Performance Review Process 1.1.4 Continuous Improvement Management Process 1.1.5 Workforce Development Integration Process	1.2.1 Supply Chain Integration Process	1.3.1 New Product Startup Process
Workforce Development	2.1.1 Job Skills & Cross-Training Certification Process	2.2.1 Continuous Improvement Process	
Operational Excellence	3.1.1 Kaizen Process 3.1.2 6S Visual Workplace Process 3.1.3 Quick Changeover/SMED Process	3.2.1 Material Management Process 3.2.2 Production Planning Process 3.2.3 Development Process	
Business Results	4.1.1 Inventory Turns 4.1.2 Sales/Employee 4.1.3 On-Time Delivery 4.1.4 Parts per Million		4.3.1 Process Maturity 4.3.2 Quick Ratio

Certification Level

Bronze OTD 90-94.9%, PPM<15,000

Silver OTD 95-98.9%, PPM<10,000

Gold OTD 99-100%, PPM<2,500

SEA Criteria

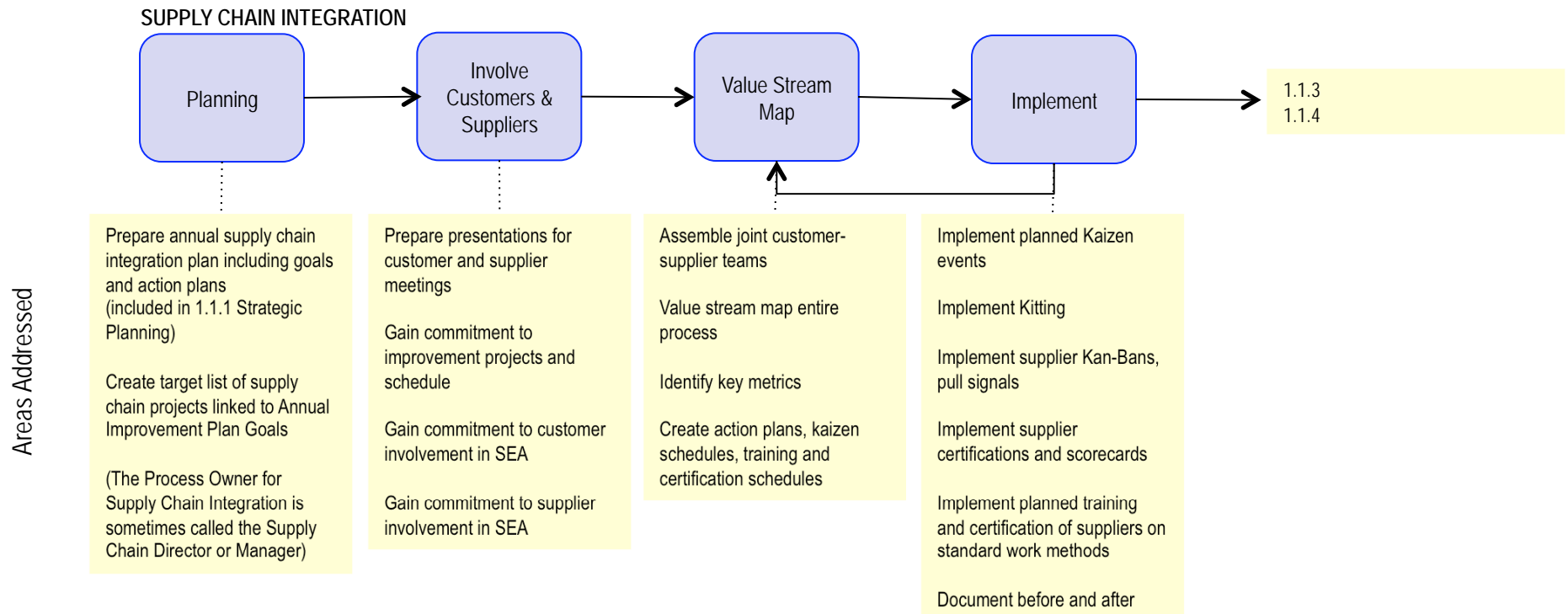
1.2.1 Supply Chain Integration Process – How do senior leaders select supply chain improvement projects? How does your organization integrate its customers and suppliers into its improvement strategies? How do you qualify suppliers in quality, delivery and ability to respond to pull signals? How do you integrate suppliers into your lean strategies such as in supplier-managed inventory, min-max, consumption-based ordering, pull signals? How does your organization make use of teaming agreements to drive alliances that improve supply chain performance?

What are the basics?

- Identify Process Owner for 1.2.1
- Develop an annual plan
- Involve customers and suppliers
- Value Stream Map the entire supply chain
- Identify key metrics
- Schedule Kaizen events and improvement projects
- Implement lean improvements and certify suppliers to standard work methods
- Keep a good record of before and after

1.2.1 Supply Chain Integration Process

Purpose: : to integrate customer and supplier efforts to increase performance and reduce cost for the entire supply chain



1.2.1 Supply Chain Integration Process – How do senior leaders select supply chain improvement projects? How does your organization integrate its customers and suppliers into its improvement strategies? How do you qualify suppliers in quality, delivery and ability to respond to pull signals? How do you integrate suppliers into your lean strategies such as in supplier-managed inventory, min-max, consumption-based ordering, pull signals? How does your organization make use of teaming agreements to drive alliances that improve supply chain performance?

How do you organize?

Champion
Process Owner
Supply Chain Integration

Champion
Value Stream

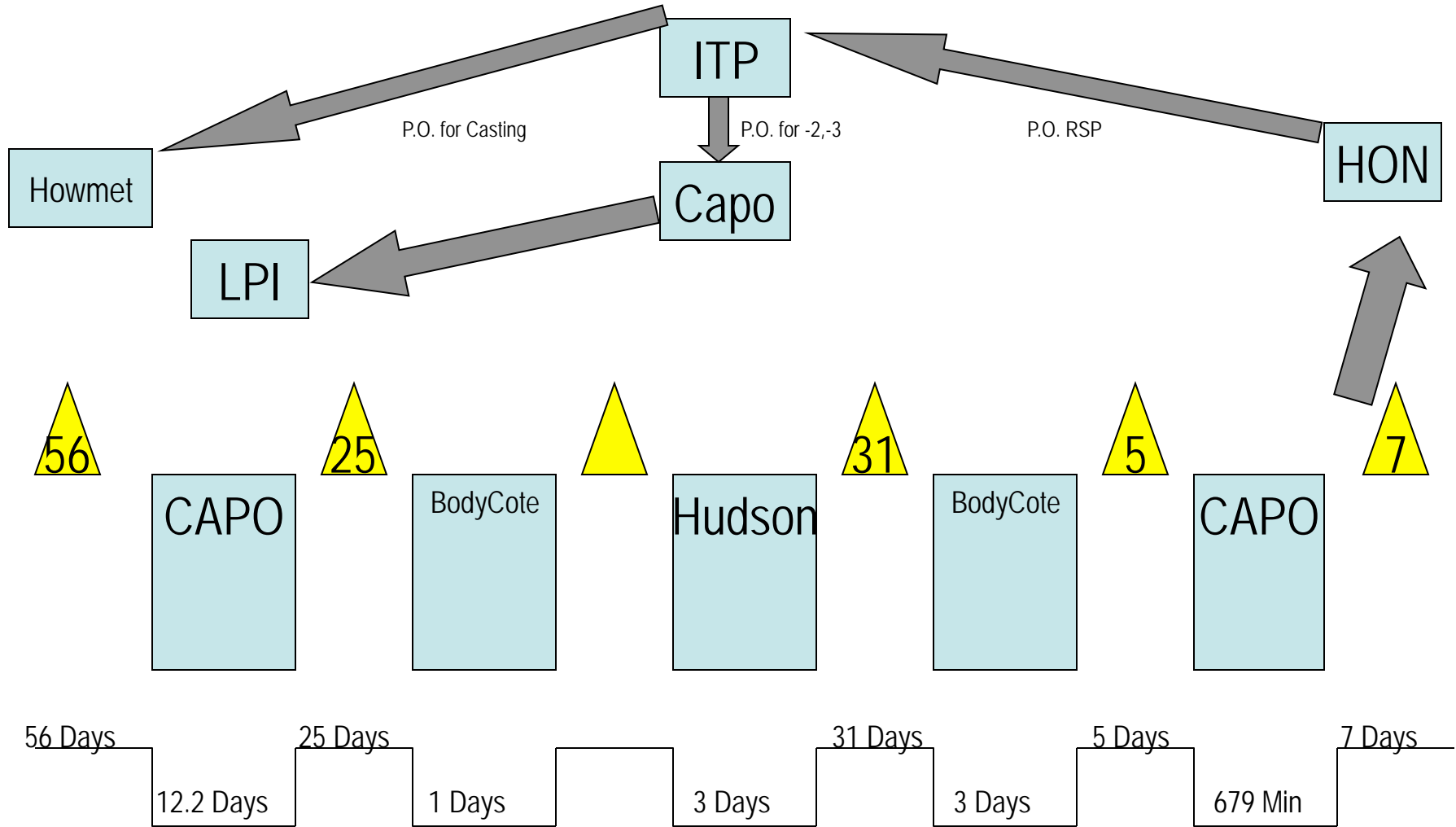
Process Owners

Master Trainers

Tools of Supply Chain Integration

- Value Stream Mapping
- Goals and Metrics
- Kaizen
- Standard Work

Top Level Current State



Quoted Lead Time: 14 Weeks

Actual Lead Time: 26 Weeks

Target Lead Time: 4 Weeks

The “Goal”

→ Takt Time = 1 part per day

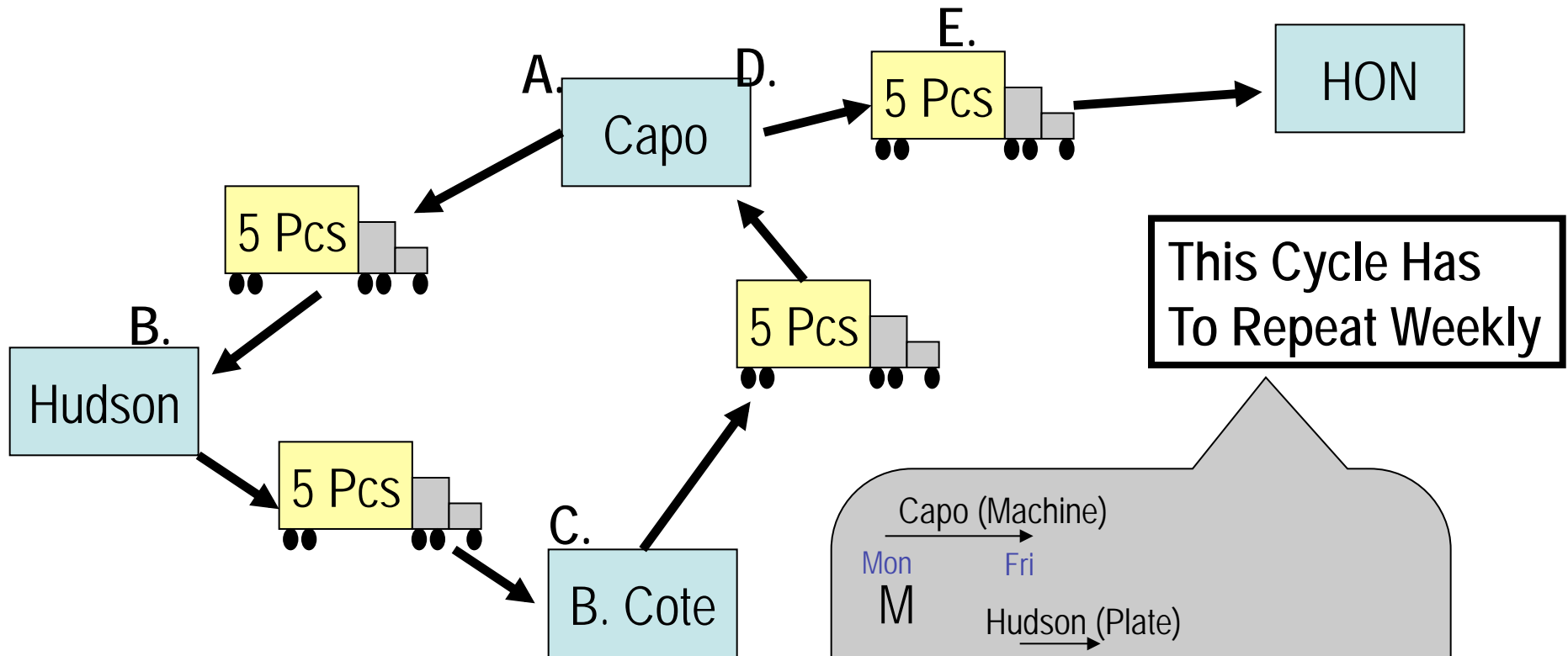
→ or 5 per week
Target Lead Time = 4 Weeks

→ Weekly Shipment = (5) -2's

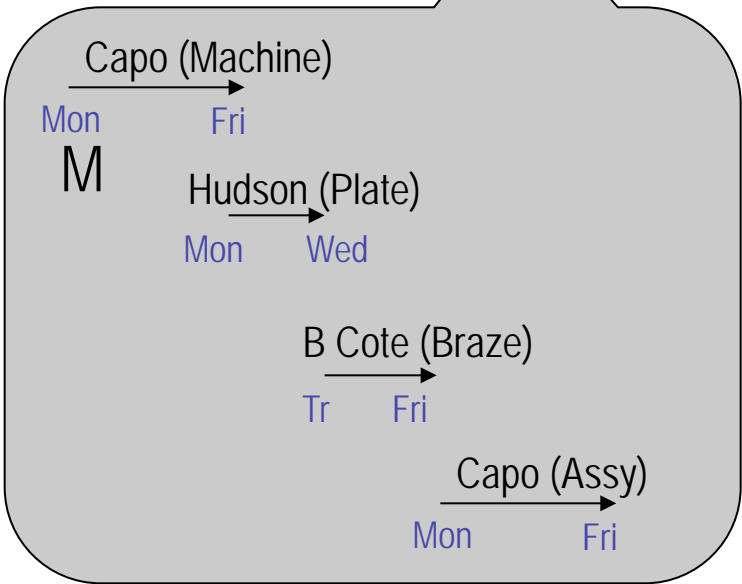
then (5) -3's Mixed Model alternating weekly.

Distribution Cycle

Target 4 Weeks Lead Time



- A. Capo – Initial Machine
- B. Hudson – Plates
- C. B Cote – Brazes
- D. Capo – Assembly
- E. Capo – Ships to HON



FMEA Analysis

PROCESS FAILURE MODES AND EFFECTS ANALYSIS (FMEA)																
Item	NGV 2 7 NGV 3 Vacuum Brazing					FMEA Original Date:			1-Oct							
Process Responsibility	Capo industries, Bodycote & Hudson Plating					FMEA Revision Date:			23-Oct							
Core Team	Honeywell - Ken & John, Capo - Rich, Bodycote - Fred 7 Kevin, David & Donna - Hudson															
Process Function Requirement	Potential Failure Mode (FM)	Potential Failure Effects (FE)	S E V	Potential Causes / Mechanism of Failure	O C C	Current Process Controls Prevention	Current Process Controls Detection	D E T	R P N	Action Recommended	Responsible	Actions Taken	P S E V	P O C C	P D E T	P R P N
Vacuum Braze	Excessive Seal Gap Before Braze	Rework Gap by rolling seal fitting it to the machine casting	5	Improper seal fitting, wrong seal, seal movement after fitting	7	None	Inspection	5	175	Standard work for gap measurement, fixed process rolling seal to casting	Rich - Capo	Control plan in place for Capo and Bcote - Routers changed and Standard Measurement in place 10/12				
	Seal Position after braze violates drawing - height from data out of tolerance	Scrap Seal, Rework and machine casting, braze new seal	7	Seal Movement, seal not set correctly, stress relief of sheet metal, inadequate fixture or tooling	5	Attempting to control with weights on a somewhat flat surface.	Inspection	3	105	Build fixturing, received dwg from ITP their tooling	Rich - Capo	Have part of dwgs from ITP				
	Excessive braze gap - post braze	Scrap Seal, Rework and machine casting, braze new seal	7	Gap was wrong before braze, seal movement due to stress relief	3	Checking gap with gauges prior to braze	Inspection	3	63	Limit set at .003 for Capo, .005 for Bcote	Leo - Bcote	Control plan in place for Capo and Bcote				
	Excessive Braze puddles on part, in seal and honeycomb	Rework and clean part. If in Honeycomb - Scrap Seal, Rework and machine casting, braze new seal	5	Excessive Gap, Excessive application of braze mtl	3	Checking gap with gauges prior to braze	Inspection	3	45	Standard Process developed and documented	Kevin - Bcote	None				
Handling Shipping	Damaged Honeycomb	Rework Honeycomb - Scrap Seal, Rework and machine casting, braze new seal	5	Handling - shipping containers inadequate	3	None	Inspection	1	15	Investigating Rotable containers	Rich - Capo John - HON	None				
Handling Shipping	Unable to braze due to missing seal	Delay	3	Seal misplaced at Bodycote, seal not sent by Capo	1	Matched sets process in place. Paperwork shipper in place	Inventory control, visual inspection	1	3	Maintain seal and part in matched sets using rotatable container	Rich - Capo John - HON					

Building the Muscle

- Process Owners
- Master Trainers
- Kaizen Leaders
- Kaizen Co-leaders
- SMEs

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Thank You



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