



## Optessa Scheduling Enables On Time Deliveries

### Problem

A manufacturer of roof liners found it a challenge to ensure on time deliveries to the auto OEM plants. The roof liner plant consisted of 2 production lines producing about 50 distinct SKUs for different vehicle models and interior colors. Production cycle times vary by SKU and changing a model or color on a line requires setup time. Each order has an associated delivery date and time provided by the OEM.

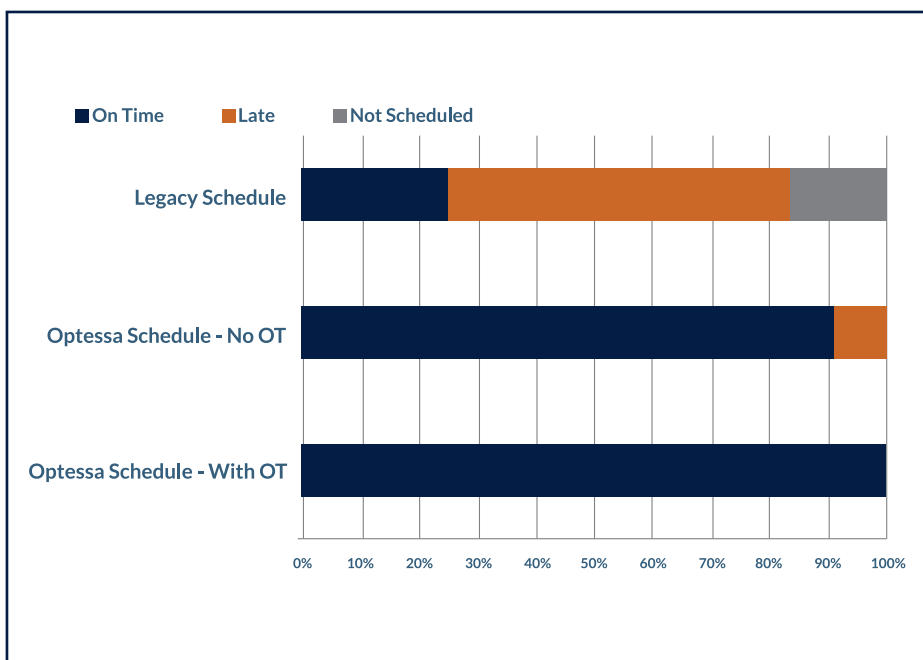
### Legacy Schedule

The existing scheduling process, which was mainly based on scheduling by due date, resulted in 58% late orders and 17% of the orders remaining unscheduled as shown below. Unplanned overtime was required to deliver all orders.

### Optessa Schedule

For the same problem, Optessa generated a schedule with 90% on time deliveries and no unscheduled orders by optimizing and reducing the number of setups - hence increasing production batch sizes without any added overtime.

Optessa also enables the user to apply an automatically generated smooth over time profile - which, in this case, scheduled 100% of the orders on time and completely eliminated late orders, as can be seen in the chart.



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