


## References

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## Appendix A

### A- Feasibility study

#### A.1 Economic feasibility

##### Hardware Requirement

- Two new pc's with following features
- P IV machine, speed 2,8 GHz, 1 GB Ram, 80 GB Hard Disk
- 2 hand held scanners
- 20 IP scanners
- 20 Display boards (Can be use existing display boards)
- 1 Network Switch
- 1 Application Server with O/S (Can use existing application server in the Contourline )
- 1 Bar Code Printer

##### Software requirement

- JDK 1.5
- SQL Server 2000 ( Can use existing licensed copy)
- JCO connector ( Can download as open source )
- JDBC-ODBC connection ( provided free of charge)

##### Development Cost

Task	Days	Daily rate/Rs	Cost/Rs
Requirement definition	25	2,000.00	50,000.00
System & Software design	30	4,000.00	120,000.00
Implementation & unit testing	30	5,000.00	150,000.00
System integration & testing	20	5,000.00	100,000.00
System installation	10	3,000.00	30,000.00
User training	7	2,000.00	14,000.00
<b>Total</b>			<b>464,000.00</b>

##### Hardware Cost

- Two pc's  
HP machines with license      Rs 65000.00 X 2      = Rs.130,000.00
- 2 Hand held Scanners      Rs. 30,000 X 2      = Rs. 60,000.00
- 20 IP Scanners      Rs. 40,000 X 20      = Rs.800,000.00
- 1 Network Switch      Rs. 65,000 X 1      = Rs. 65,000.00
- 1 Bar Code Printer      Rs. 125,000 X 1      = Rs.125,000.00

##### Total Cost

Rs.1,180,000.00 (one million and fifty five thousand LKR only)

## **A.2 Technical feasibility**

- Java - All developers has the knowledge in development
- SAP - All developers has the knowledge in development

## **A.3 Legal feasibility**

Company is having SQL server 2000 licensed version.

All the other software using to the projects are open source.

## **A.4 Alternative feasibility**

In MAS Active current production confirmation system operates by confirming Line IN/OUT bundles. Bundle may contain 10~20 pieces of garments. So the confirmation process tracks the bundle in/out by scanning each bundle ID (Barcode). By thinning the size of bundle we can get close to track single peace flow.

Disadvantages of using existing production confirmation system:

- It generate huge no of bundle IDs (Barcodes) and required to confirm operation 10 and 20 (Line In/Out) for each bundle.
- That will generate huge burden to current SAP system and printing barcodes for each garment is no way benefited in terms of cost.
- Needs lot of man hours to generate, print barcodes.
- Adds unnecessary sorting, handling and movements due to barcodes.
- Cost of printing and maintenance of barcode printers will goes up
- Gathers unnecessary records directly in SAP system.
- Need more resources than existing process.
- No way of locating issues with in the bundles and alarm system for issues

Advantaged

- Tested and proven system.

## **Cost benefit and analysis**

- Enables to find the real production process in Contourline
- More specific reports can be generated for the user levels.
- Sophisticated decision making ability due to correct and sensitive data
- Remove the staff from report generation and use them in a productive work.
- Reduce manual data entry work

# Appendix B

## B-Existing system use cases and descriptors

### B.1 Use cases

#### B.1.1 Bundle guide creation

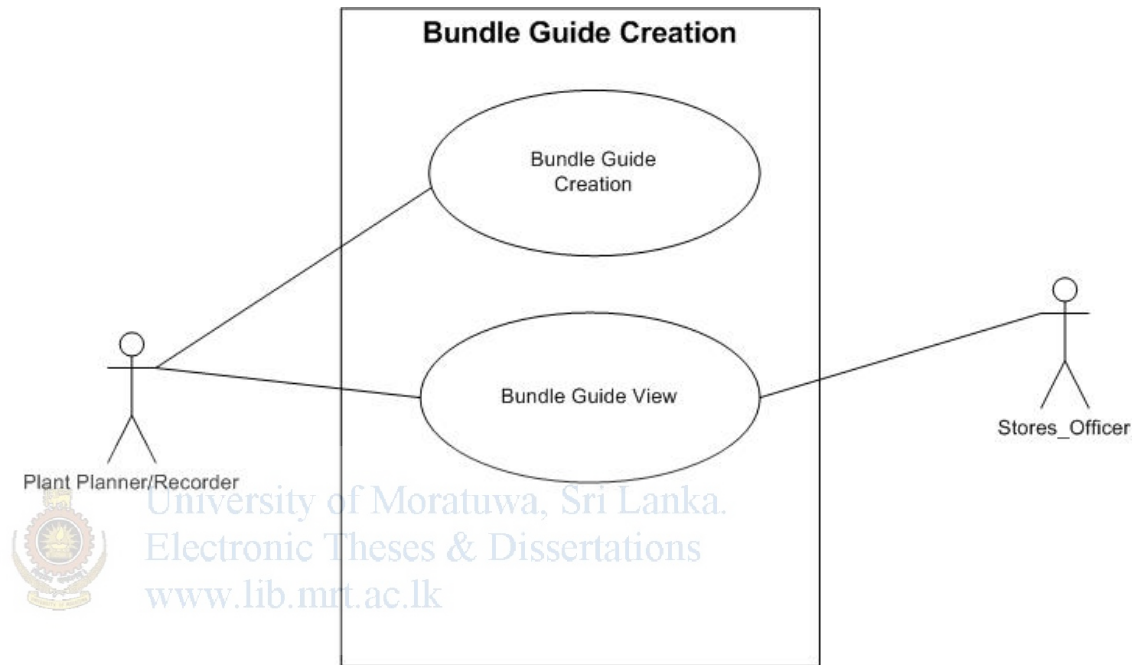


Figure B.1 Bundle guide creation current system.

### B.1.2 Material requisition/ Picklist generation

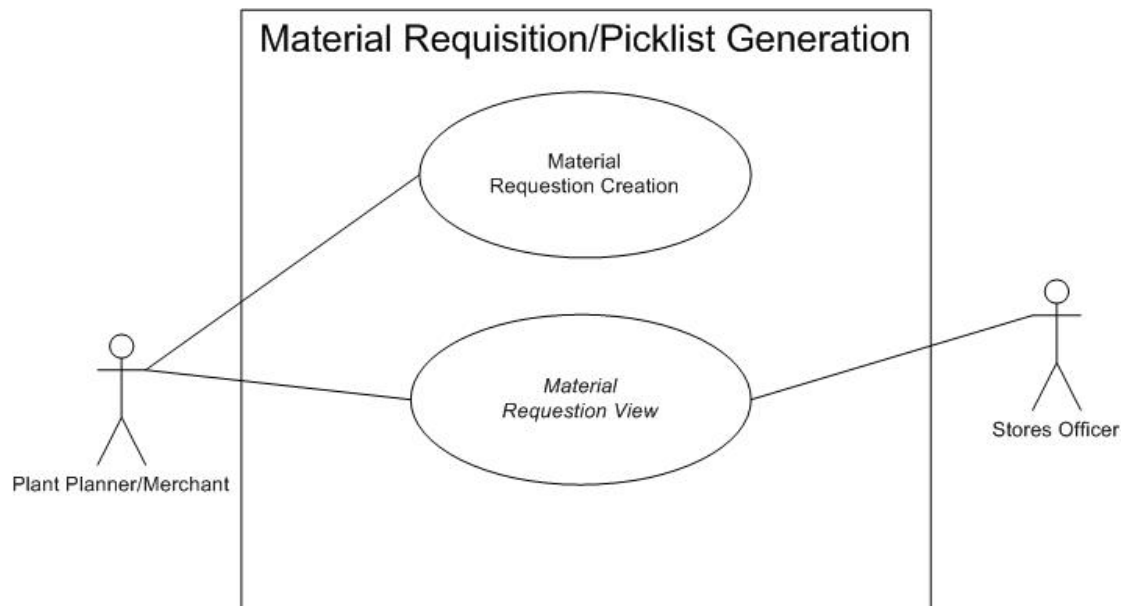


Figure B.2 Material requisition current system

### B.1.3 Sewing /Packing RM issue

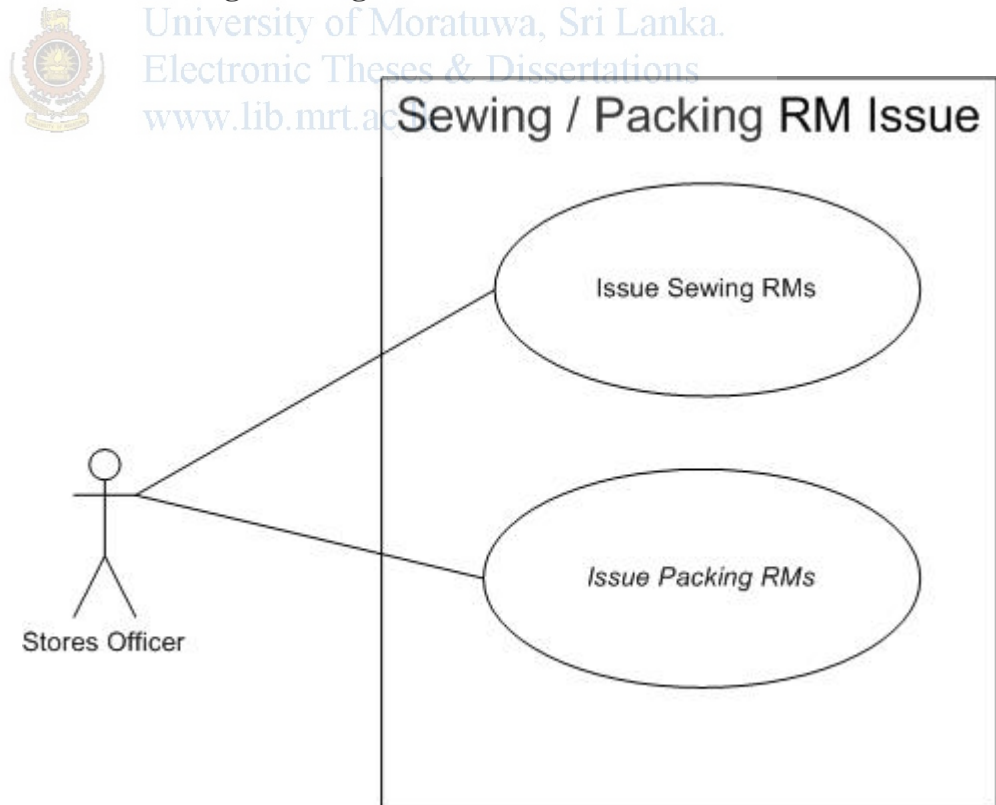


Figure B.3 Sewing / Packing RM issue current system

### B.1.4 Lien In confirmation

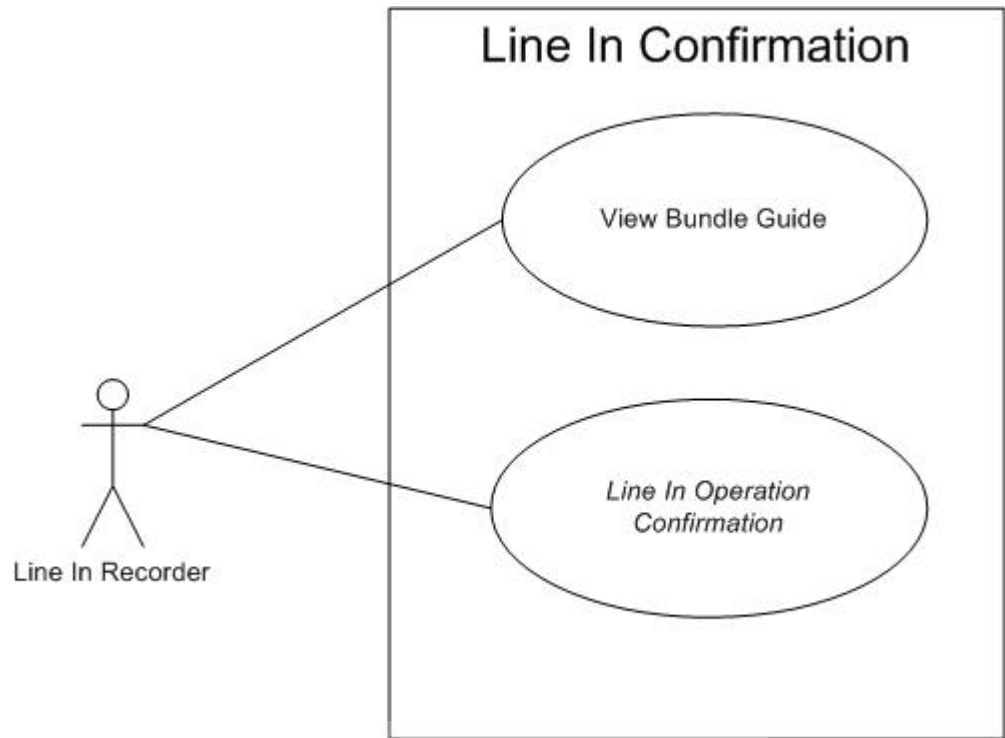


Figure B.4 Line in confirmation current system



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### B.1.5 Line out confirmation

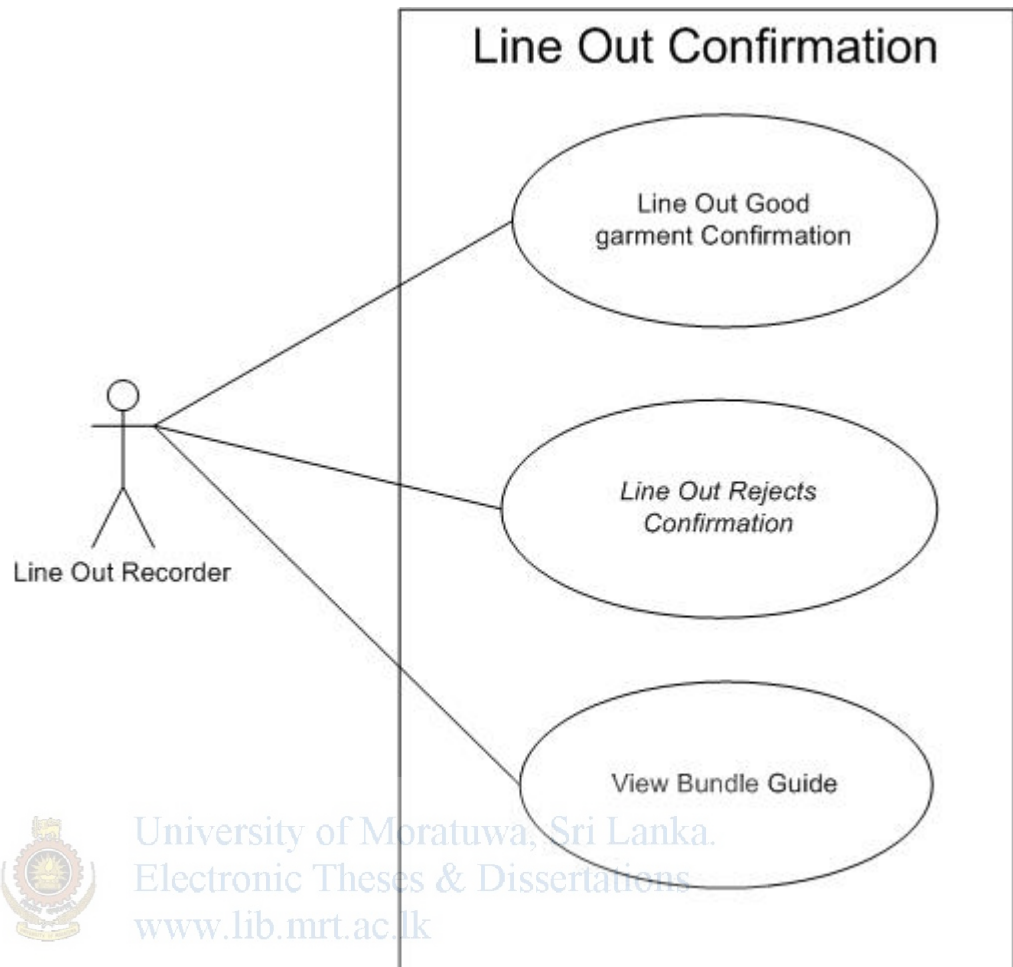


Figure B.5 Line out confirmation current system

## B-2 Use case descriptors

### B.2.1 Bundle guide creation use case descriptor

<b>Name</b>	1. Bundle Guide Creation(Sewing Production Order)
<b>Actor</b>	Plant Planner, Stores Officers
<b>Pre-Condition</b>	Cut Fabric + RM has been received to plant according to Cut docket/Requirement Line wise daily requirement should be pre identified
<b>Post-Condition</b>	Bundle Guide should be generated
<b>Flow</b>	Plant Planner Creates Bundle Guide Base on Cut Docket ,Production Capacity and daily requirement for the respective Sewing Modules
<b>Exception</b>	

Table B.1 Bundle guide creation use case descriptor

### B.2.2 Material Requisition /Picklist generation use case descriptor

<b>Name</b>	2. Material Requisition/Picklist Generation
<b>Actor</b>	Plant Planner/Merchant, Stores Officer
<b>Pre-Condition</b>	Valid Bundle Guide RM has to be in-house
<b>Post-Condition</b>	A material Requisition with all the sewing/packing materials and quantities required for the order
<b>Flow</b>	Against the bundle guide (production order) Merchant generates the bundle guide. During the generation period he disregards and removes all general items. And if there are alterations happens and which are not maintain in the BOM he alters those materials in MR Save the MR
<b>Exception</b>	

Table B.2 Material requisition/ Picklist generation use case descriptor

### B.2.3 Sewing / Packing RM issue case descriptor

<b>Name</b>	3. Sewing / Packing RM Issue
<b>Actor</b>	Stores officer
<b>Pre-Condition</b>	A valid Material Requisition No Sewing/Packing RM issues happens against the same Bundle Guide (Sewing Production Order)
<b>Post-Condition</b>	All the materials in Material Requisition should be issued against the Sewing Production Order (Bundle Guide)
<b>Flow</b>	Stores officer receiving the Material Requisition Stores officer then check the availability of all the materials in MR Then issues all the sewing and packing materials against the MR (Sewing Production Order)
<b>Exception</b>	If there is a any shortage of a any material he does not issue single material from the Material Requisitions.

Table B.3 Sewing / Packing RM Issue use case descriptor



### B.2.4 Line In confirmation use case descriptor

<b>Name</b>	4. Line In Confirmation
<b>Actor</b>	Line In Recorder
<b>Pre-Condition</b>	A valid Bundle Guide All the RM has to be issued against the Material Requisition This bundle guide (Sewing Production Order) has not been confirmed for Line In operation
<b>Post-Condition</b>	Full quantity of the bundle guide has to be confirmed as Operation Line In
<b>Flow</b>	Line In Recorder enters the bundle guide No (Sewing Production Order) to the system. Confirm the whole quantity for the Line In operation against the allocated sewing line.
<b>Exception</b>	

Table B.4 Sewing / Packing RM Issue use case descriptor

### B.2.5 Line out confirmation use case descriptor

<b>Name</b>	5. Line Out Confirmation
<b>Actor</b>	Line Out Recorder
<b>Pre-Condition</b>	Line In operation should have been done for the bundle guide (Sewing Production Order) Total quantity of Line Outs should be less than Line In quantity
<b>Post-Condition</b>	Line Out operation for the bundle guide (Sewing Production Order) has to be confirmed.
<b>Flow</b>	Line Out Confirmation for good garments against the bundle guide (Sewing Production Order)
<b>Exception</b>	When there are rejects it should also confirmed as rejects against the bundle guide (Sewing Production Order)

Table B.5 Line out confirmation use case descriptor

# Appendix C

## C- Proposed system use cases and descriptors

### C.1 Use case diagrams for the proposed system

#### C.1.1 Bundle guide maintenance use case

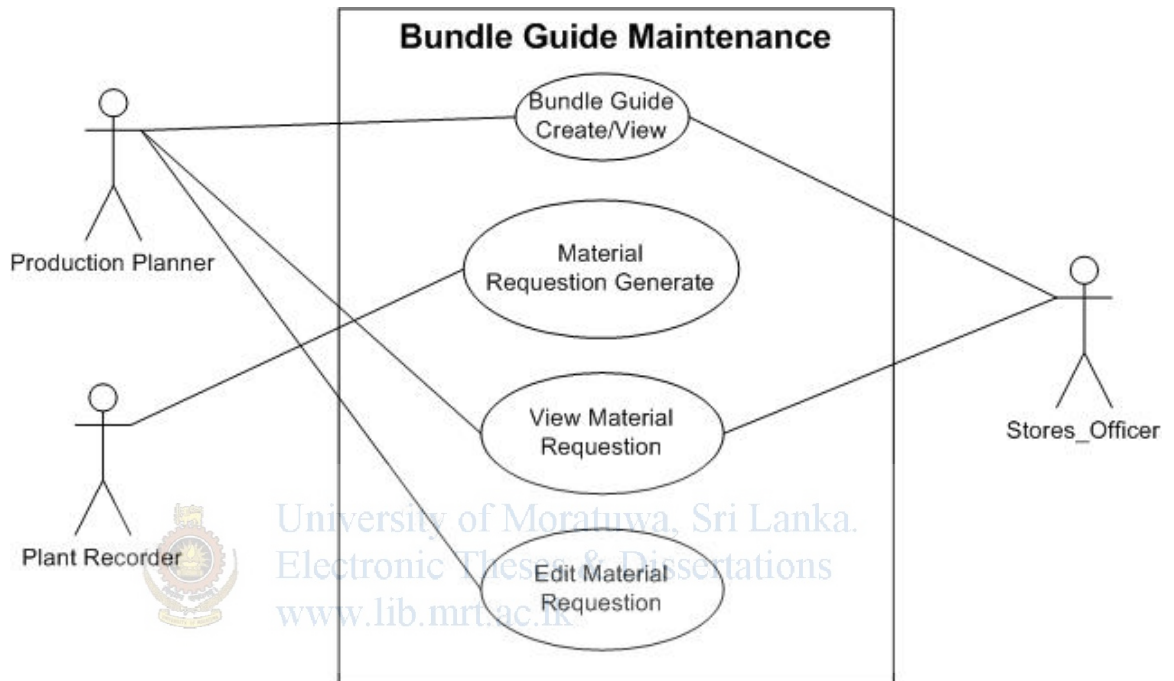


Figure C.1 Bundle guide maintenance use case

#### C.1.2 Bar code creation and UPC assignment use case

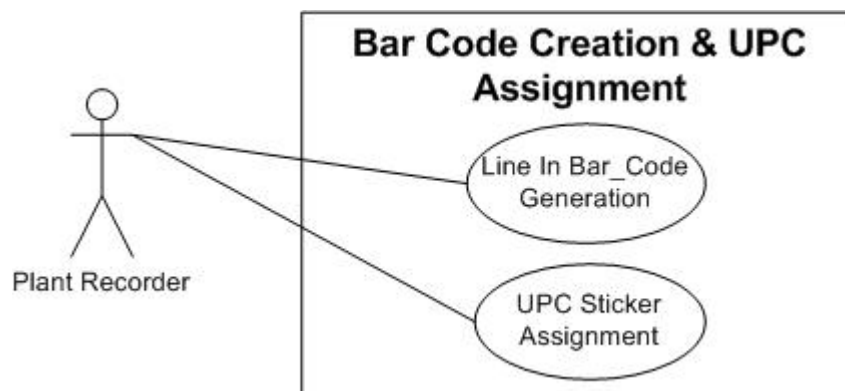


Figure C.2 Bar code creation and UPC assignment use case

### C.1.3 Line in confirmation use case

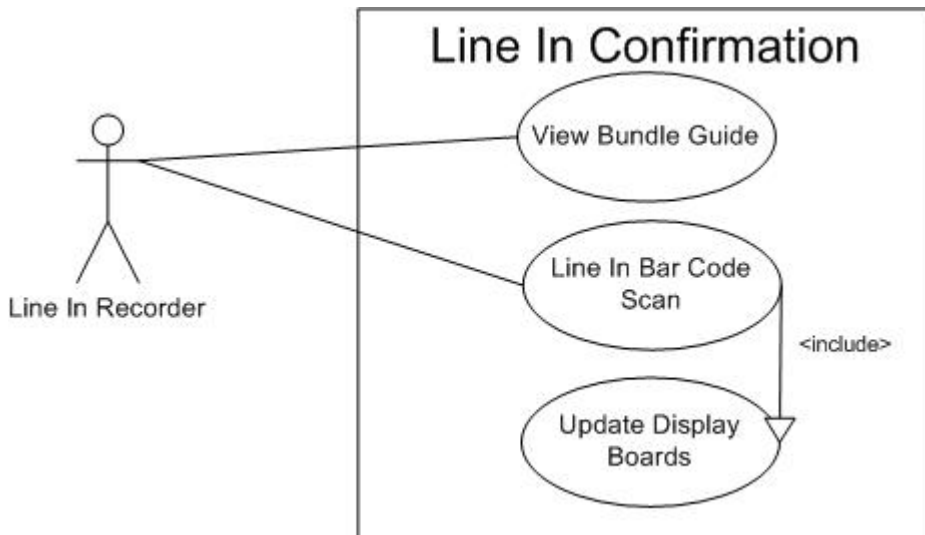


Figure C.3 Line in confirmation use case

### C.1.4 Line out confirmation use case

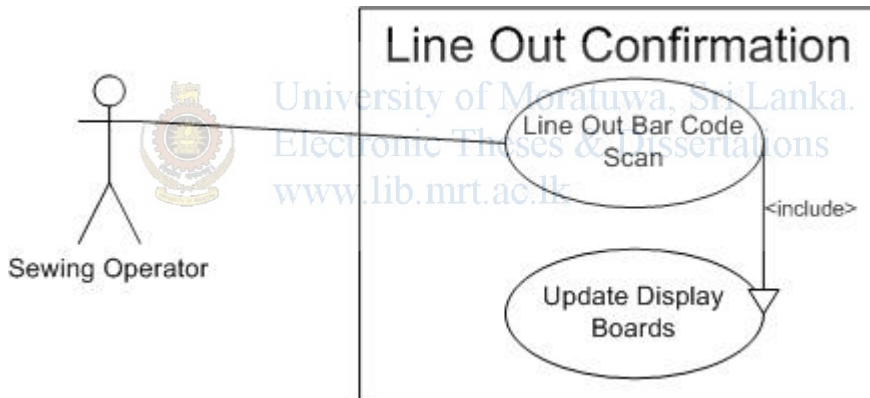


Figure C.4 Line out confirmation use case

### C.1.5 Reject update use case

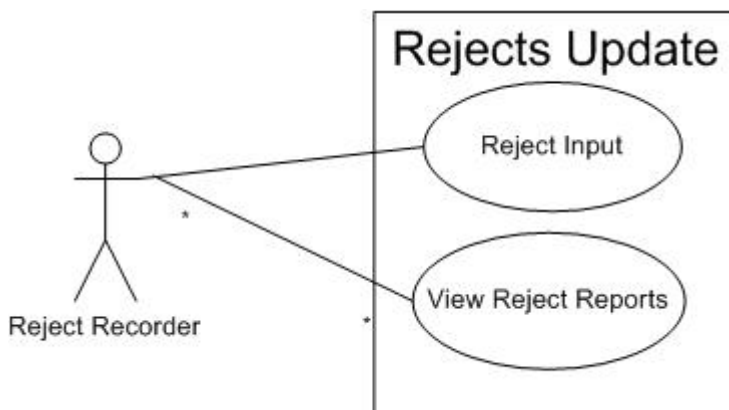


Figure C.5 Reject update use case

## C.2 Use case descriptors for the proposed system

### C.2.1. Bundle guide creation

<b>Name</b>	1. Bundle Guide Creation
<b>Actor</b>	Production Planner, Stores Officers, Plant Recorder, SAP System
<b>Pre-Condition</b>	<p>Cut Fabric + RM have been received to plant according to Requirement</p> <p>Line wise daily requirement should be pre identified.</p> <p>Sewing Module wise efficiency should be considered.</p> <p>Sewing Production Order and Packing Production Order has to be created</p> <p>Material Requisition can only be generated after the respective Bundle Guide is Created.</p> <p>Material Requisition can only edited before the bundle guide is confirmed for the Line In Operation</p>
<b>Post-Condition</b>	<p>Bundle Guide should be generated</p> <p>Material Requisition should be generated based on Bundle Guide.</p>
<b>Flow</b>	<ol style="list-style-type: none"> <li>1. Insert Sales order and Line Item by Production Planner.</li> <li>2. System will display created Sewing and Packing Production orders.</li> <li>3. Prod. Planner selects both Sewing and Packing Orders.</li> <li>4. Base on the Sewing Production Order System display size wise order break down.</li> <li>5. Size wise quantities are adjusted if required Cannot exceed the given quantities.</li> <li>6 Key in Sewing Module No</li> <li>7. Save</li> <li>8. System Generates and display the Bundle Guide No</li> <li>9. Bundle Guide No has to be insert to Create the Material Requisition</li> <li>10. Created Material Requisition can be edited if the relevant bundle is not confirmed for the Line In Operation.</li> </ol>
<b>Exception</b>	

Table C.1 Bundle guide creation

### C.2.2 Bar code creation & UPC assignment

<b>Name</b>	2. Bar Code creation and UPC sticker Assignment
<b>Actor</b>	Plant Recorder, SAP System
<b>Pre-Condition</b>	Valid Bundle Guide All the UPC stickers has to be in-house UPC stickers have not been introduced for the Sales Order by this time
<b>Post-Condition</b>	Valid Line In Bar Code Sticker System can identify relevant UPC Stickers for the Sales Order Line Item
<b>Flow</b>	For Bar Code Generation 1. Insert the Bundle guide No 2. System should display the content of Sticker 3. Print the Sticker For UPC stickers 1. Input the Sales Order and Line Item 2. Display all sizes and UPC (if already been Assigned) for the Sales Order Line Item 3. For the sizes that doesn't have UPC codes, UPC stickers has to be updated 4. Save.
<b>Exception</b>	

Table C.2 Bar code creation

### C.2.3 Line in confirmation

<b>Name</b>	3. Line In Confirmation
<b>Actor</b>	Line In Recorder, SAP System
<b>Pre-Condition</b>	A valid Bundle Guide All the RM's and semi finished goods has to be in-house. Line In Bar Code generated from Bundle Guide.
<b>Post-Condition</b>	All the materials in Material Requisition should be issued against the Sewing Production Order (Bundle Guide) Full quantity of the bundle guide has to be confirmed as Operation Line In. Display Boards should be updated with Line in quantities.
<b>Flow</b>	1. Scan the Bundle guide Bar Code Sticker. 2. It picks the Sales Order, Line Item, Sewing Order, Sewing Modules and size wise Line In Quantities. 3. Save and confirm the Line In. 4. Automatically issue all the sewing RM's 5. Update Display Boards with Cumulative qty for each Sewing module.
<b>Exception</b>	

Table C.3 Line in Confirmation

### C.2.4 Line out confirmation

<b>Name</b>	4. Line Out Confirmation
<b>Actor</b>	Line Out Recorder, SAP System, Schedule Uploader
<b>Pre-Condition</b>	Line In operation should have been done for the bundle guide (Sewing Production Order) Total quantity of Line Outs should be less than Line In quantity
<b>Post-Condition</b>	Line Out operation for the bundle guide (Sewing Production Order) has to be confirmed. All the Packing RM's has to be issued against Bundle Guide Display Boards should be updated with Line out quantities.
<b>Flow</b>	<ol style="list-style-type: none"> <li>1. IP Scanners Read the UPC stickers and write it to a Line Out Entry table with UPC code Scanner IP and system date/time.</li> <li>2. Read entries from Line Out Entry table according to schedule</li> <li>3. Schedule uploads to SAP after sort &amp; club records in Line Out entry table.</li> <li>4. SAP records upload data and save to the Upload table.</li> <li>5. Pick available Bundle Guides and Confirms the Line Out for the bundle guide Sewing Order</li> <li>6. Packing RM's are issued for the Packing Order in Bundle Guide.</li> <li>7. Display Boards should be update with Line Out quantities.</li> </ol>
<b>Exception</b>	If any error occurs in schedule upload then the data will be logged for post inspection

Table C.4 Line out confirmation

### C.2.5 Rejects confirmation

<b>Name</b>	5. Rejects Confirmation
<b>Actor</b>	Rejects Recorder, SAP System
<b>Pre-Condition</b>	A valid Bundle Guide Module wise Reject garments
<b>Post-Condition</b>	Rejects has to be uploaded against the Bundle guide
<b>Flow</b>	<ol style="list-style-type: none"> <li>1. Recorder has to insert the UPC code and module.</li> <li>2. System load the available bundle guide</li> <li>3. Check the bundle guide validity</li> <li>4. Then insert the size wise rejects with reject types</li> <li>5. Save.</li> </ol>
<b>Exception</b>	

Table C.5 Reject confirmation

# Appendix D

## D- Proposed system activity diagrams

### D.1 Activity diagrams for the proposed system.

#### D.1.1 Bundle guide creation activity diagram

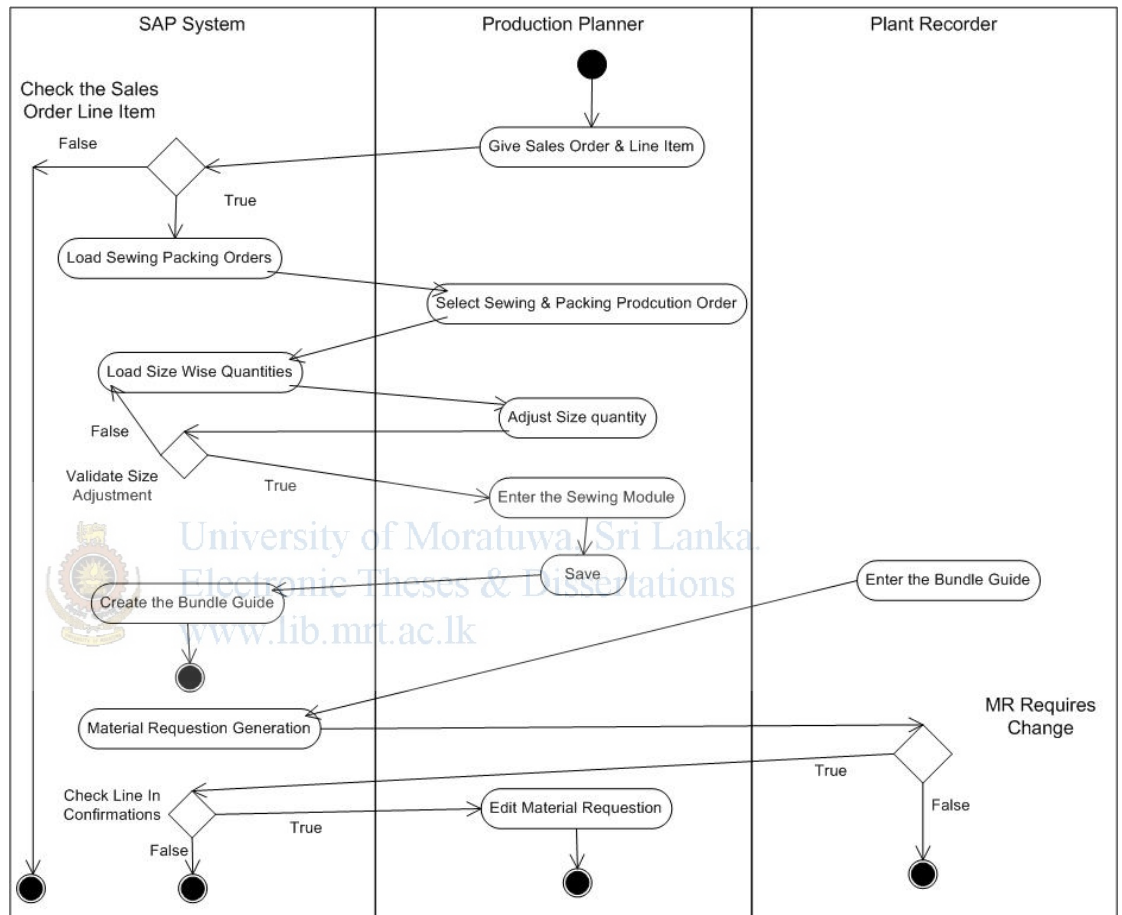


Figure D.1 Bundle guide creation activity diagram new system

### D.1.2 Bar code creation & UPC assignment activity diagram.

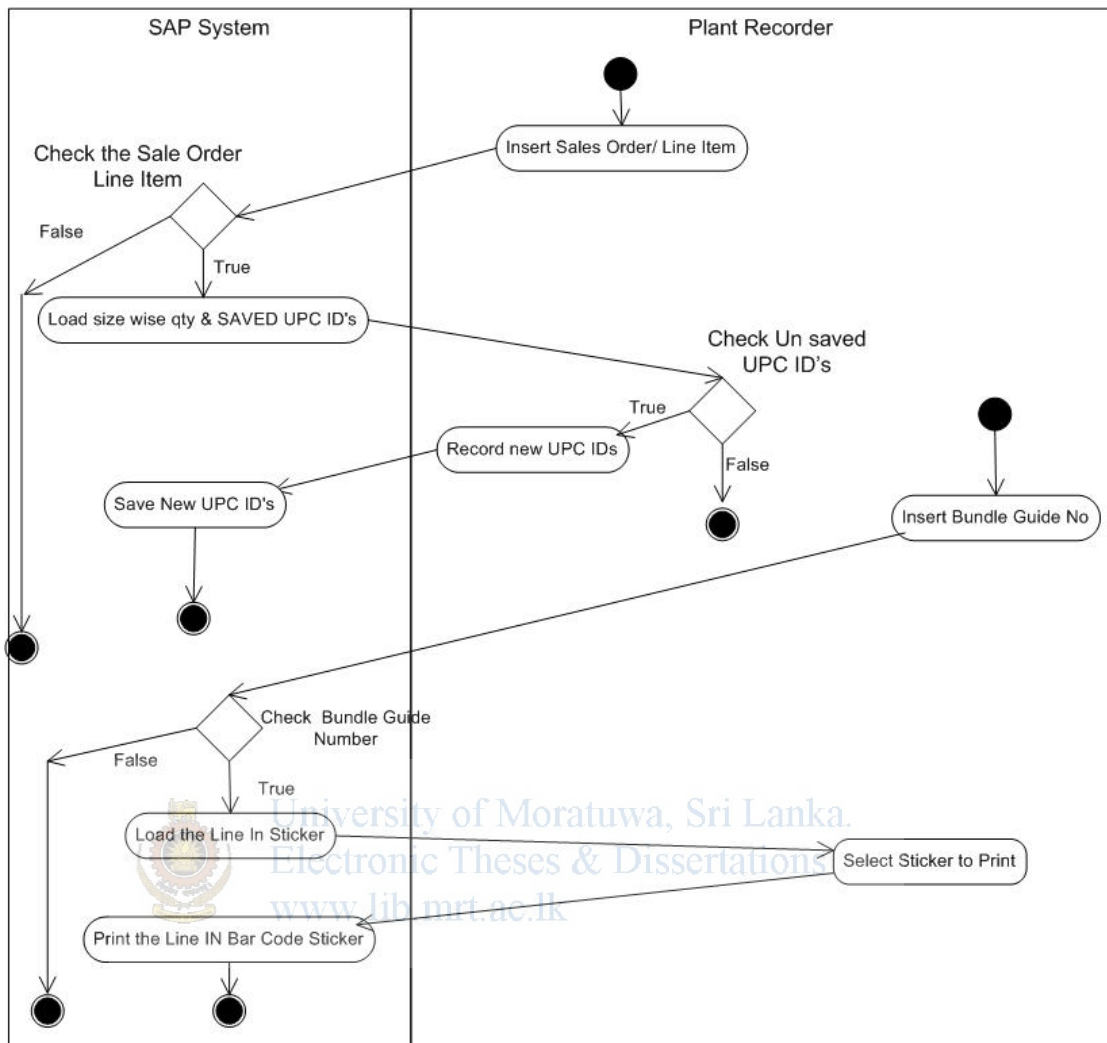


Figure D.2 Bar code creation and UPC assignment activity diagram



### D.1.3 Line In confirmation activity diagram.

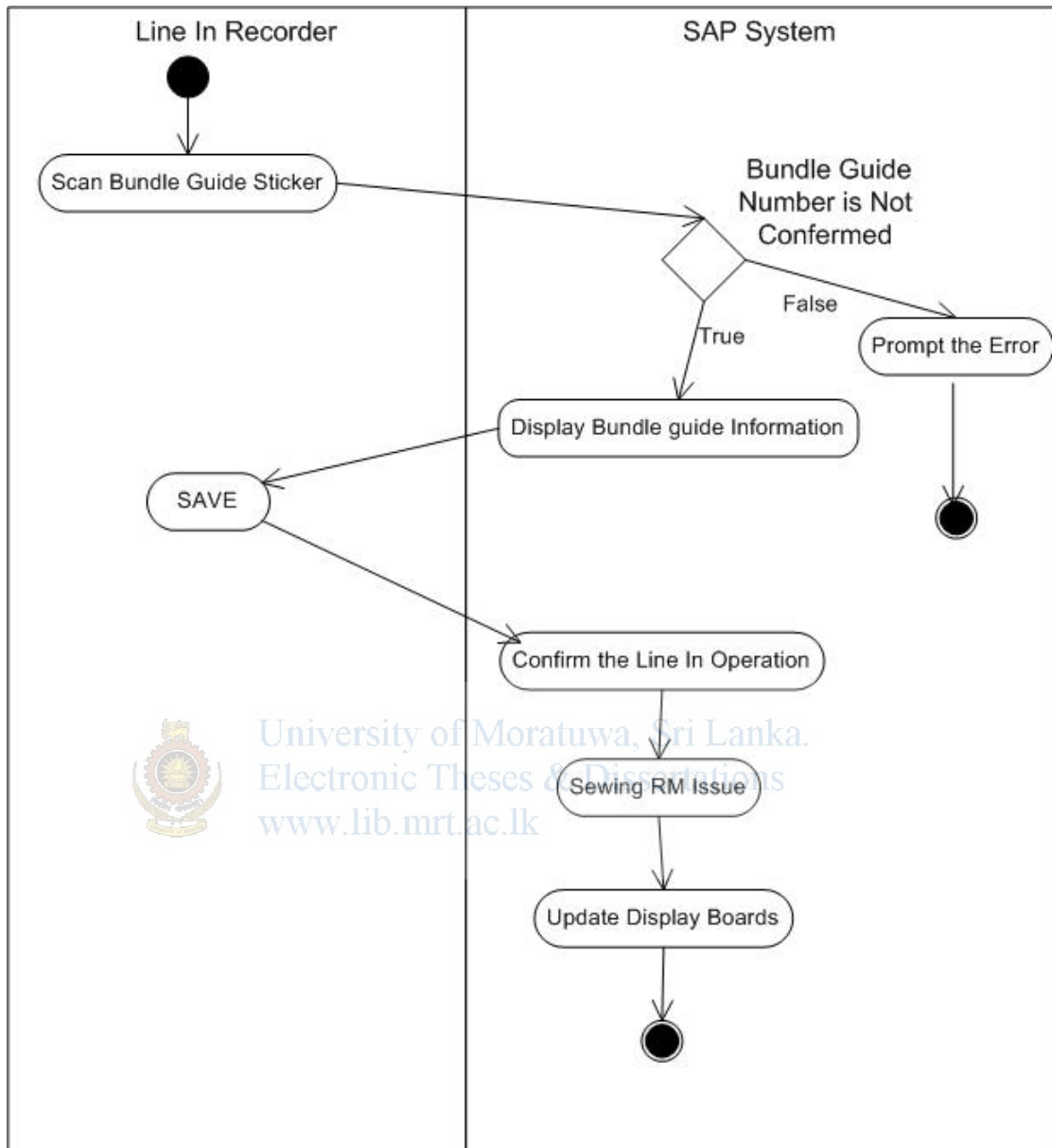


Figure D.3 Line In confirmation activity diagram

### D.1.4 Line Out confirmation activity diagram.

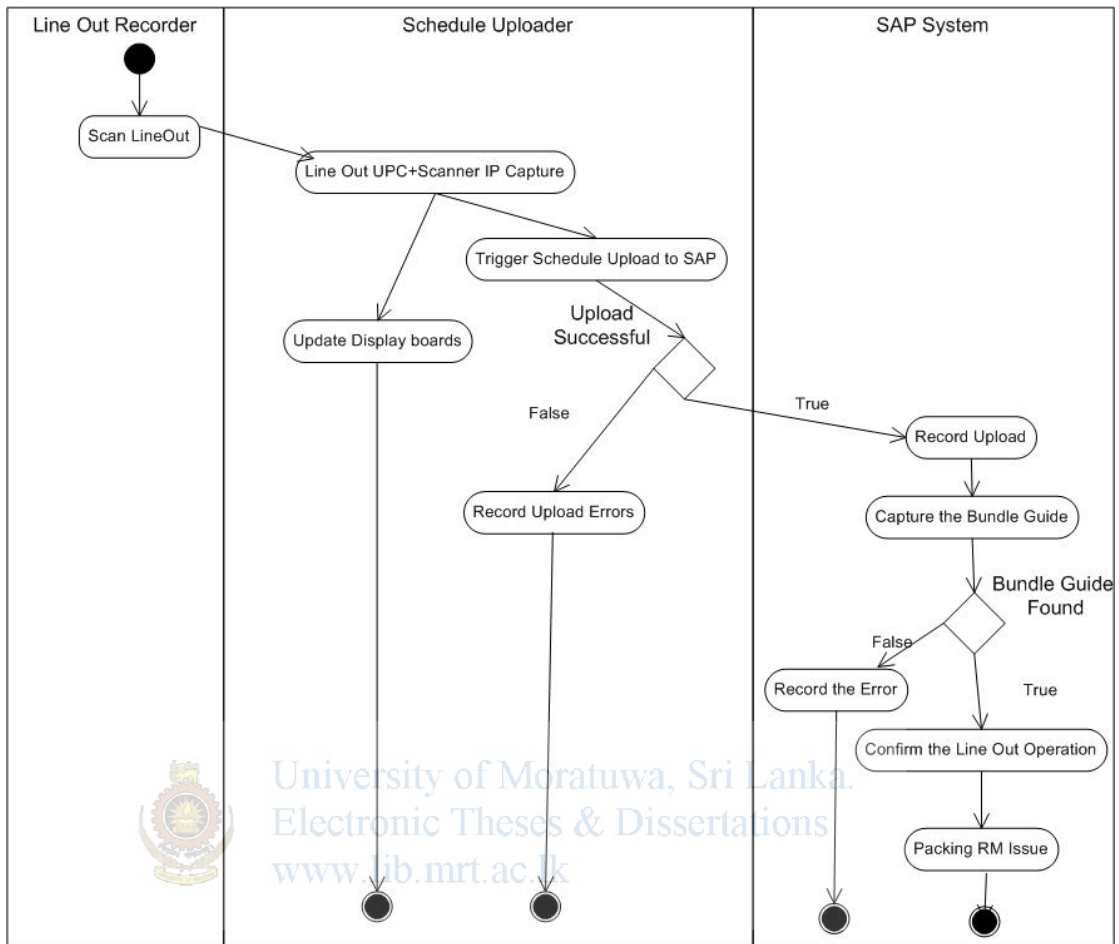


Figure D.4 Line Out confirmation activity diagram

**D.1.5 Reject confirmation activity diagram.**

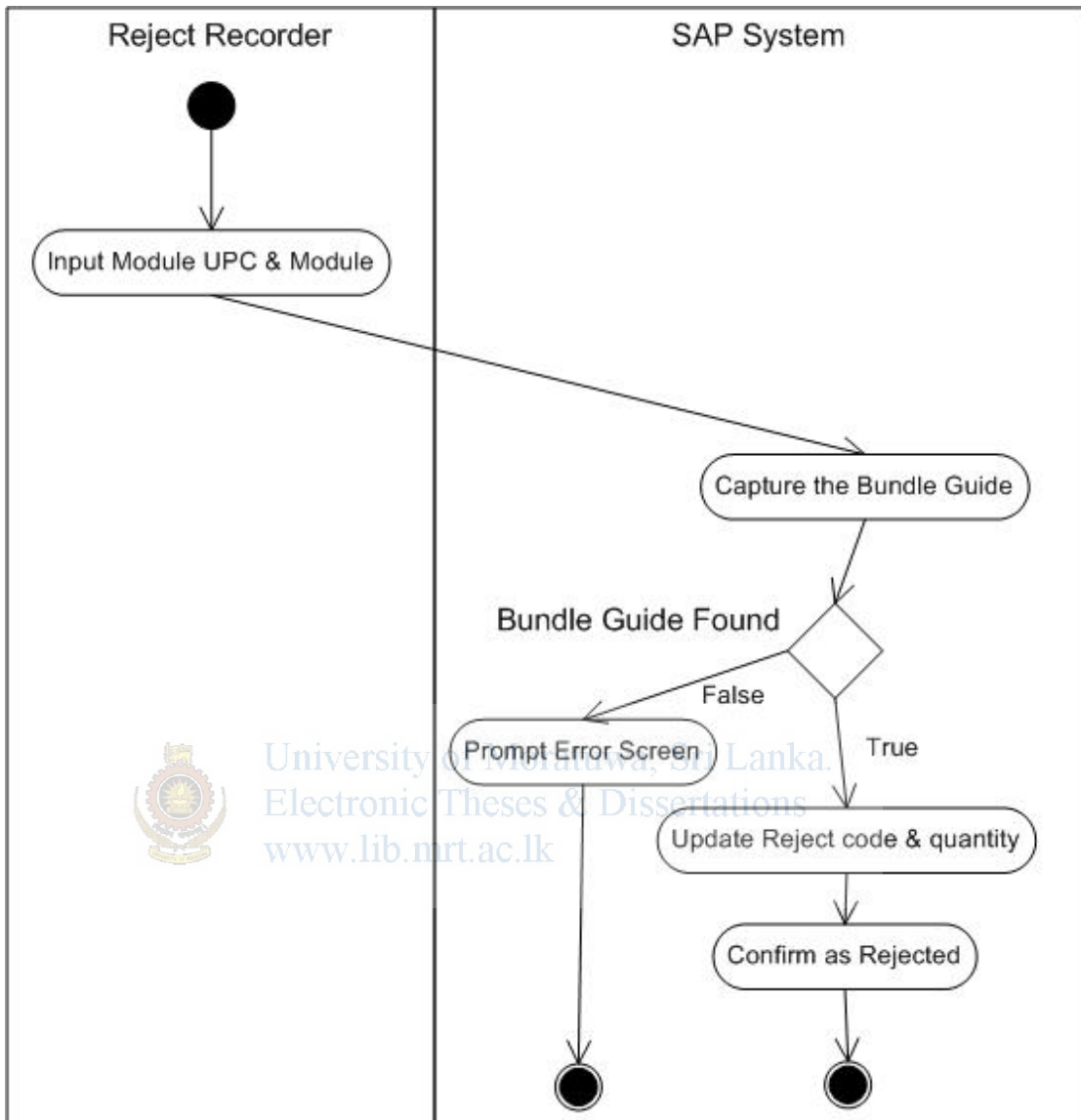


Figure D.5 Reject confirmation activity diagram

## Appendix E

### E- Test cases

#### E.1 Material Requisition and UPC assignment

Test Case ID		2		
Tested Component		Material Requisition & UPC assignment		
Tested Area		Functionality		
Purpose		Maintain the materials to be selected to Material Requisition (MR) and UPC stickers introduce to system for sizes.		
Prerequisites		Valid Bundle Guide All the UPC stickers has to be in-house UPC stickers have not been introduced for the Sales Order by this time		
Test Case Description				
No.	Test Case	Test data	Expected output	Result
1	Load RM's and sizes Insert sales order, line item Press enter	Sales order: 40677 Line item :10	All the RM's & description to be load to the left hand side list. All the sizes to be load to the right hand side list	Pass
2	Check Left hand side list for RM's to be picked for material requisition(MR) As default all the RM's are selected. If wants to omit particular RM have to unclick the check box against material		Then the check box will appear without mark sign	Pass
3	In right hand side table Update the UPC stickers Place the cursor in the text box in front of the size and scan or key the UPC sticker	Size M : 826218908279 Size XL: 826218910869 Size S: 826218907951 Size XXL: 826218910876	UPC sticker should match with the size in the screen. Then the UPC code should display against the size	Pass
4	Save		Press save button. Save message comes in the bottom of the screen.	Pass
	Test Results :		Pass	

Table E.1 Material requisition and UPC assignment test case.

## E-2 Line In test Case

Test Case ID		3		
Tested Component		Line In operation		
Tested Area		Functionality		
Purpose		Line In confirmation by recording the bar code		
Prerequisites		A valid Bundle Guide All the RM's and semi finished goods has to be in-house. Line In Bar Code generated from Bundle Guide.		
		Test Case Description		
No.	Test Case	Test data	Expected output	Result
1	Scan the Line In bar code	Barcode : 04067701000110	System will picked sales order, line item and sewing plant	Pass
2	Save		System gives the successfully save message in the bottom of the screen	Pass
	Test Results :		Pass	

Table E.2 Line in test case



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E-3 Reject update. Theses & Dissertations  
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Test Case ID		4		
Tested Component		Rejects confirmation		
Tested Area		Functionality		
Purpose		To update and confirmed the rejects found in the sewing process		
Prerequisites		A valid Bundle Guide Module wise Reject garments		
		Test Case Description		
No.	Test Case	Test data	Expected output	Result
1	Give the Module No which reject found Scan the UPC in reject garment Select the reject type form the list	UPC id : 826218908279 Module : SLK 07 and press Enter key	System will load the sales order, line item size, UPC code, material to the	Pass
2	Reject type	Reject type : 'SEW' from the drop down list in	Display the selected reject type in the same line where UPC code display	Pass

		the 6 <sup>th</sup> column in the table		
3	SAVE : Press save button		Display the successful save of the reject in message in the bottom of screen	Pass
	Test Results :		Pass	

Table E.3 Reject confirmation test case



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## Appendix F

### F- Data dictionary

Term	Abbreviations	Meaning
Sales Order	Sal. Ord	Sales Order is the word use in SAP in handling specific customer order
Line Item	LI,	In a one sales order there can be several combinations of colors and so on....
Production Order	Prd. ord	The unit which SAP use to pass the demand to a specific operation
Bundle	Bnd.	After fabric cut they are packed in to 10~15 packs contains all the components required to create garment
UPC sticker	UPC	All the NIKE garments contains UPC sticker. It is unique for a sal.ord /line item/size
MOS		Mass Operating system
Line In		Fabric cuts insert into sewing operation
Line Out		Stitched/ packed garments are falls out of production
Material Requisition	MR	List of Row materials and required quantities for particular operation
Raw Material	RM	

## Appendix G

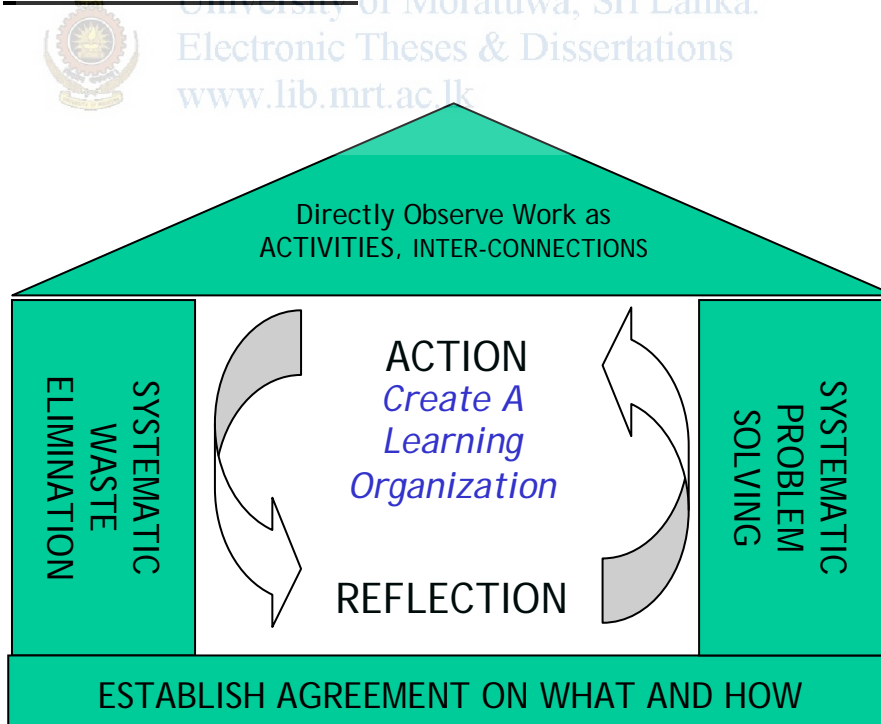
### G- MOS/TPS Concepts Overview

#### What is lean?

**“It is an embedded culture of understanding the customer’s needs, continually striving to reduce waste and optimising the performance of process, people and infrastructure.”**

- Improves business performance using simple, practical tools and techniques to enhance quality, cost, delivery and people contribution.
- Exposes the wastes in the system
- People have to change their long standing work practices and ideas
- Senior management will have to drive lean principles forward with total commitment to its success
- Not a “bolt on” technique, more a way of life leading to a total change in culture

#### FOUR RULES OF LEAN



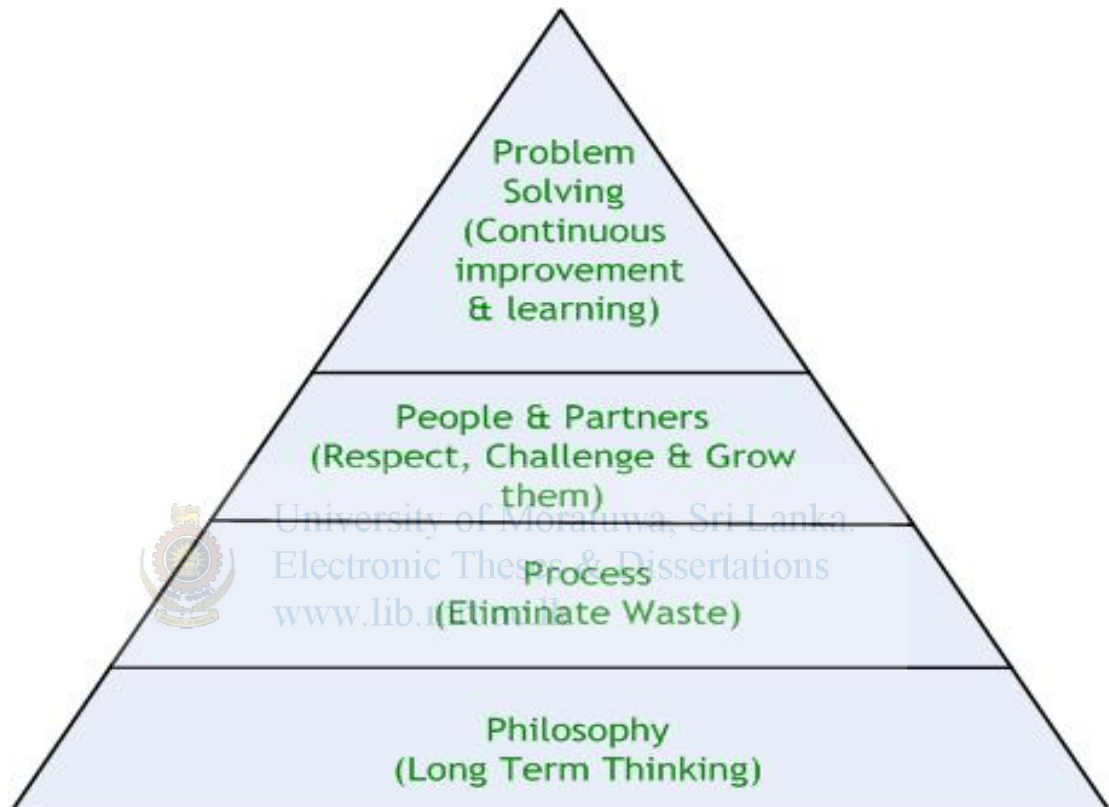


## Lean Definitions

### What is WASTE?

“Anything that takes time, resources or space but does not add to the value of the product or service delivered to the customer”

### Four Pillars of TPS Model.



### 14 Principals of Toyota Production System

- Principal 1: Base management decisions on a long term philosophy, even at the expense of short-term financial goals.
- Principal 2: Create a continuous process flow to bring problems to the surface.
- Principal 3: Use Pull systems to avoid overproduction.
- Principal 4: Level out the workload (*heijunka*). (Work like the tortoise, not the hare)

- Principal 5: Build a culture of stopping to fix problems, to get quality right the first time.
- Principal 6: Standardized tasks and processes are the foundation for continuous improvement and employee empowerment.
- Principal 7: Use visual control so no problems are hidden.
- Principal 8: Use only reliable, thoroughly tested technology that serves your people and processes.
- Principal 9: Grow leaders who thoroughly understand the work, live the philosophy, and teach it to others.
- Principal 10: Develop exceptional people and teams who follow your company's philosophy.
- Principal 11: Respect your extended network of partners and suppliers by challenging them and helping them improve.
- Principal 12: Go and see for yourself to thoroughly understand the situation (*genchi genbutsu*).
- Principal 13: Make decisions slowly by consensus, thoroughly considering all options; implement decisions rapidly (*nemawashi*).
- Principal 14: Become a learning organization through relentless reflection (*hansei*) and continuous improvement (*kaizen*).

## Appendix H

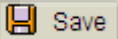
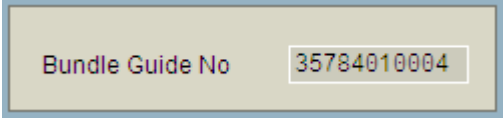
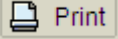
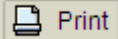
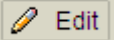
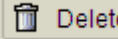
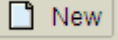
### H- User manuals

#### USER PROCEDURE

(1)

Activity	Bundle guide creation	
Scenario		
Details	Bundle guide details should enter to the system and then automatically it is generated by picking required details from sales order.	
Menu Path		ZBUN

#### Steps:








1.	Enter Sales order, line item and press 'Enter'.
2.	Enter the module number in the Module field and press 'Enter'.
3.	In the Sewing order field the relevant order/orders are displayed and select the correct order number from drop down list and press 'Enter'.
4.	Enter Size, cut no, set no and quantity.
5.	Enter all other details; I.D. number, care label, main label and other relevant information such as prepared by, issued by etc.
6.	
7.	Bundle guide number will display in the 'bundle guide' no field. 
8.	To get the print-out of the bundle guide, press enter and click on the  button. Or else copy the no (Ctrl+C) and click on edit button and paste (Ctrl+V) the bundle guide no and press enter. Then click on the  button.
9.	It can be edited by clicking on  or it can be deleted by clicking on  buttons.
10.	To create new bundle guide click on  button and enter details.

## USER PROCEDURE

(2)

Activity	Material requisition form creation (MRF)	
Scenario		
Details	This is automatically created based on the bundle guide details and the initial BOM in the system	
Menu Path		ZMRF

### Steps:

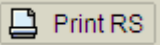
1.	Enter Bundle guide number and press 'Enter'.
2.	Select the correct sewing order and packing order from the drop down list.
3.	Enter other details; Requested by, authorized by etc.
4.	 Save
5.	It will give the MR number in the field. 
6.	To get the print-out of the MR click on the  Print button. Or else copy the no (Ctrl+C) and click on edit button and paste (Ctrl+V) both MR number and BG number and click on the  Print button.
7.	It can be edited by clicking on  Edit or it can be deleted by clicking on  Delete buttons.
8.	To create new MRF click on  New button and enter details.

## USER PROCEDURE

(3)

Activity	Print reference sticker (RS)	
Scenario		
Details	RS consists with a barcode which is used for the line-in operation and it is automatically created in the system based on the bundle guide details.	
Menu Path		ZMRF

### Steps:

1.	Raise the MRF by putting bundle guide number and save it.
2.	To get the barcode printout click on  button.



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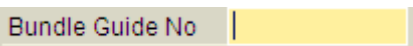
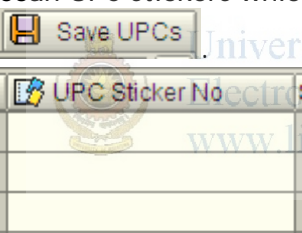



## USER PROCEDURE

(4)

Activity	Line-in Confirmation	
Scenario		
Details	Line-in is entered to the system by scanning the reference sticker. If the sales order is new to the scanning process, UPC stickers need to be introduced size-wise to the system.	
Menu Path		ZLIN

### Steps:

1.	Scan RS and the number will be picked in the relevant field. 
2.	Press enter. (Sales order, line item will be displayed. If the sales order has been utilized before the UPC details also will be displayed)
3.	Scan UPC stickers which are not initialized to the system and click on 
4.	Click on  button in the main menu to save the Line-in confirmation. (At the same time CKs will be issued to the production order and the sewing trims and packing materials with regard to the MRF will be issued automatically).

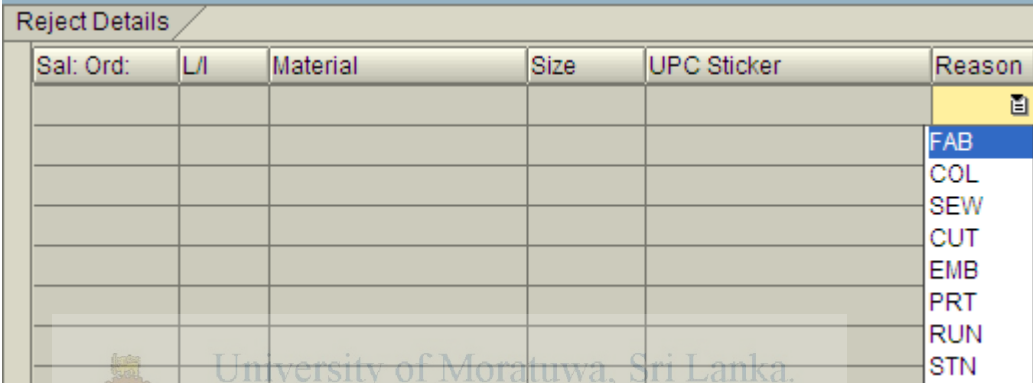

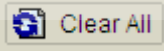
## USER PROCEDURE

(5)

Activity	Rejects records	
Scenario		
Details	Reject garments are entered to the system by scan the UPC against the module and facility is there to select the reject type. Once save the data, reject stocks will be converted to block stock stage at the same plant location.	

Menu Path		ZLORJ
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**Steps:**

1	Enter number of the module from which the garment was rejected.
2	Press enter
3	Scan the rejected UPC and press enter (it picks relevant information for the following screen)
4	Then, select the reason for the rejection from drop down list.(It shows the specific reject types which plant consider)
	 <p>The screenshot shows a software window titled "Reject Details". It contains a table with the following columns: "Sal: Ord:", "L/I", "Material", "Size", "UPC Sticker", and "Reason". The "Reason" column has a dropdown menu open, displaying a list of reasons: FAB, COL, SEW, CUT, EMB, PRT, RUN, and STN. The "FAB" option is currently selected and highlighted in blue. There is also a small trash icon in the top right corner of the Reason column.</p>
5	After scan and enter the reason for rejects for the particular module, click on  .
6	To clear all the details or enter new data, click on  button.