

SRI	ISO 9001: 2015 Quality Management System Quality Procedure Manual	
Document No: SRI-QPM 07 (2) Date Issued : 03/04/2017 Revision Date: 03/02/2025	DSI Tyres®	Revision No :03 Page No : 1 of 7

Title : Procedure for Operational Planning & Control

7.2. PROCEDURE FOR PLANING

7.2.1. SCOPE

The Objective is:

- To plan the production to ensure the delivery promising date
- To keep finished goods stocks at minimum level
- To minimize the work –in-progress
- To Minimize the idle time due to non-availability of materials
- To ensure optimum utilization of machines

7.2.2. RESPONSIBILITY

Overall responsibility of production planning lies with the Senior Planning Manger further it is assisted by Senior Assistant Planning Manager

7.2.3. Production Planning & monitoring

Compiling Data

Activity	Responsibility	Ref
Master Information Gathering		
• 3 Month sales Forecast (local)	SALES/M	CR-REP-03
• Monthly Local Sales Forecast	MIM	CR-REP-07
• Export Forecast- Monthly		
• Export customer sales order	SALES/M	IFS/Customer Order
• Local customer wise order/purchase order	"	"
• BOM		IFS Manufacturing Std

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Executing

Activity

Customer orders conformation (Export Orders/Local Orders)

- Receive order conformation sheet IM Dept
- Release customer order & Create shop Orders PLO IFS Customer Order
- On receiving order check master plan at the finished good level „
- Consider customer required date „
- Find most suitable and immediate molding resource availability PLM / APLM / PLEXE IFS Preactor
- Determined the order completion date.
- Check material availability (if is not provided on master planning level) PLEXE / PLO
- Create purchase requisitions for Valves & Stickers PLO IFS
- Check labor availability (Every month review by HR) PLM / APLM / PLEXE „
- Give order conformation HR Dept CR-REC-01
- For local order, planning dept issue production capability report

Master Planning

Activity

- Receive Order IM Dept IFS/Customer Order
- Receive Monthly Sales Forecast Sales Dept Local
- Place the Order in planning Board PLNNIG DEPT CR-REP-03
- Close the acceptance (Generally 25th on of every month) PLEXE / PLO Preactor
- Optimize the plan & generate operation wise plan PLM / APLM / PC-PLAN-01
- Prepare Master plan PLEXE / PLO
- Send copies to relevant depts. (SRI/UGB/Tube) PLEXE / PLO „

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Production Operation Planning

Activity	Responsibility	Ref
<ul style="list-style-type: none"> Transfer customer orders to Preactor system from IFS Prepare best, optimum plan For Tyre - Molding plan 	PLO	IFS
For Tube – Molding plan /Autoclave plan	PLM / APLM / PLEXE / PLO	PC-PLAN-02
<ul style="list-style-type: none"> Release plan to relevant sections (Shop Flow) through preactor for further comments Receiving comments to the plan (Considering practical issues) Finalize and send the production plan 	PLEXE / PLO	PC-PLAN-02A
<ul style="list-style-type: none"> According to the completion of the plan shop floor will update the IFS 	PRDUCTION	IFS
Main attributes of the plan		
<ul style="list-style-type: none"> Resource name Customer Order Number Item code Item description Target Start time End time Operation Name Order quantity 		

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Process wise planning – Supporting Operations

After finalizing, the molding plan production plan will be generated for supporting service

Activity	Responsibility	Ref
• Tyre		
• Calendering Plan	PLM / APLM / PLEXE / PLO	PC-PLAN-02F PC-PLAN-02G WI-047
• Profile or Extruder plan		
Activity	Responsibility	Ref
Tubes		
• Extrusion plan	PLM / APLM / PLEXE / PLO	PC-PLAN-02B WI-047
Profile or Extruder plan		
• Resource name • Customer • Order Number • Item code • Item description • Target • Start time • End time • Operation Name • Order quantity		

Supporting Operations planning

Activity	Responsibility	Ref
• Bead Wire		
Consider current stocks – any excess or short Prepare production plan accordingly	PLM / APLM / PLEXE / PLAO	C-PLAN-02D WI-047
Create shop orders in IFS Set Preactor Plan	PLEXE / PLAO	IFS/Shop Order PC-PLAN-02E
• Air Bag plan		
Consider current stocks – any excess or short Prepare production plan accordingly	PLEXE / PLAO "	IFS/Shop Order WI-047
Create shop orders in IFS Set Preactor Plan		

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Main attributes

- Resource name
- Order Number
- Item code
- Item description
- Start time
- End time
- Operation Name

Activity	Responsibility	Ref
• Mixing Plan		
Mixing is a first operation in the whole manufacturing chain. Mixing planning is done after finalizing the molding operations & prepared on daily basis	PLM / APLM / PLEXE / PLO	PC-PLAN-03
Considering daily targets of molding operations, considering the shop floor stocks taking the compounds which are on delivery Prepare best possible day plan using preactor	PLEXE / PLO	WI-047
Create shop order Release the plan		IFS/Shop Order

Main attributes

- Order Number
- Item code
- Item Name
- Target
- Start time
- End time

Mixing plan amendment – Send as different revision number

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Schedule Delivery

Activity	Responsibility	Ref
<p>It is necessary to plan delivery of compound and airbags to ensure the availability at right time in the shop floor</p> <ul style="list-style-type: none"> Compound delivery schedule –SRI/RPW/UGB Air Bag delivery schedule 	PLM / APLM / PLEXE / PLO	
	PLEXE / PLO	PC-SCHED-01
	”	PC-SCHED-02

Key Attribute

- Delivery date
- Delivery time
- Item delivery
- Qty delivery
- Send loading schedule to relevant dept

Activity	Responsibility	Ref
General Labor Requirement	PLM / APLM / PLEXE / PLO	
In order to determine the labor availability, planning dept prepare & issue labor requirement to selected manufacturing dept		
<ul style="list-style-type: none"> Molding and Building labor plan with shift/press arrangement Profile/ Calendaring/ bias cutting labor plan Tube extortions / splicer / Autoclave / labor plan with shift arrangement 	PC-LB-01 PC-LB-02 PC-LB-03	

Monitoring

Activity	Responsibility	Ref
<ul style="list-style-type: none"> Control WIP at the shop floor 	PLM / APLM / PLEXE / PLO	WI-047
Taking physical stocks in shop floor and adjust the mixing plan to ensure the less WIP		
<ul style="list-style-type: none"> See the variation of the daily target and actual and provide a report to the management Prepare weekly production report and submit to the management Check order progress & rectify the delays Obtain details of production plan accordingly Create tonnage plan and see verification 	„ „ „ „ „	PPI Tool PC-SCHED-03

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7.2.4 Material Requirement Planning

Scope – This section describes the planning of material requirement

Activity	Responsibility	Ref
Material Forecasting		
Objective:- Get the material requirement for sale forecast	IMM/SM	
• Receive sale forecast.	PLEXE / PLO	
• Use forecast demand function in IFS	PLM / APLM /	IFS
• Enter sales qty against part number	PLEXE	"
• Check the qtys and transfer compounds to SRI site		PC-MRP-01
• Generate forecast material requirement		PC-MRP-02
• Generate actual material requirement of coming month every month by 25 th	PLEXE / PLO	PC-MRP-03

Weekly Material Requirement

- Plan dept issue weekly/monthly material requirement to ensure the availability of material

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