

# ASSISTANT SE Case Study

Helmut Simonis

email: helmut.simonis@insight-centre.org  
homepage: <http://insight-centre.org/>

ENTIRE EDIH  
Insight SFI Centre for Data Analytics  
School of Computer Science and Information Technology  
University College Cork  
Ireland

Constraint Based Production Scheduling

## Acknowledgments

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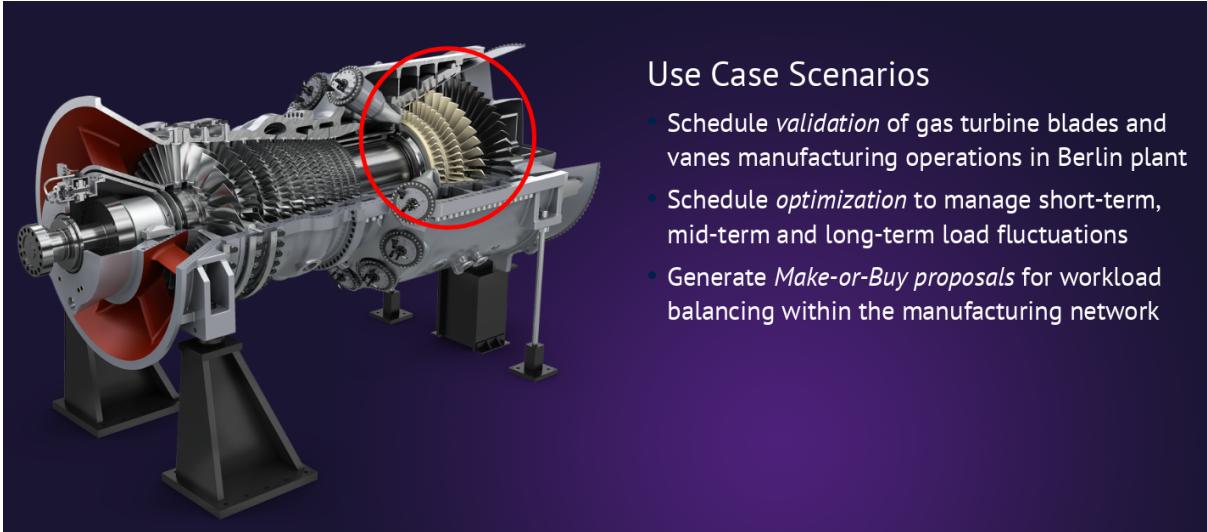
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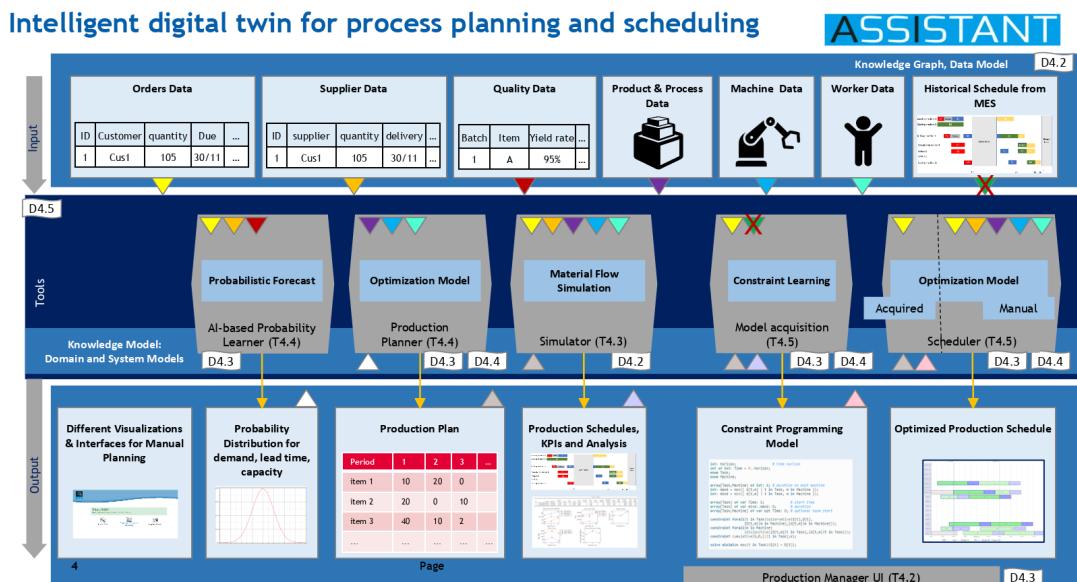
## Key Points

- Scheduling/Planning tool for manufacturing industry
- Developed as part of European ASSISTANT project
- Focused on key make-or-buy decisions
- Complex manufacturing process with alternative process paths
- Outperforms both current in-house tool and commercial simulator
- Key Technology: Optimization and Constraint Programming

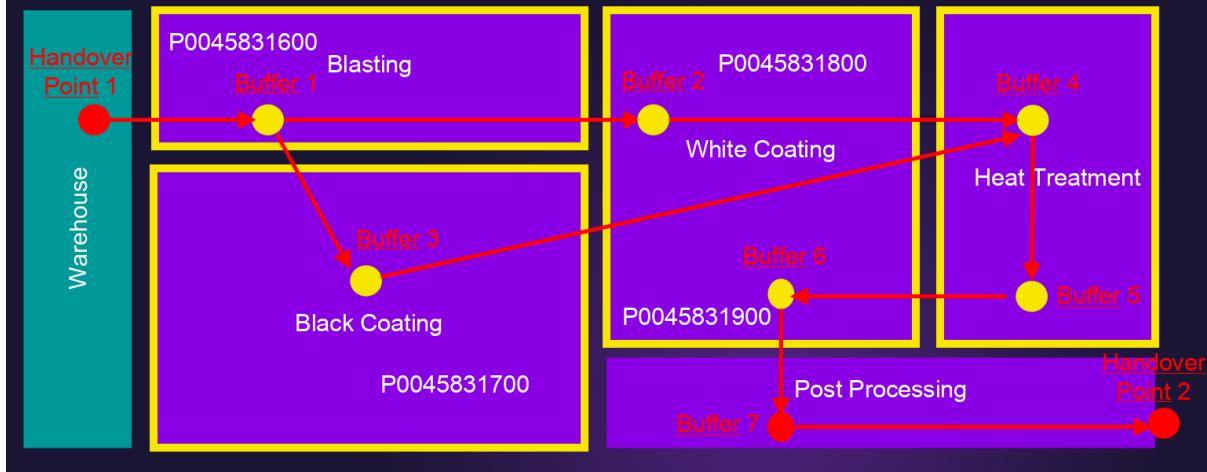
## Assistant Siemens Energy Use Case



## ASSISTANT Project Overview



## SE Product Routing



## Test Datasets

### Full Scale Datasets

Berlin06: 96 orders, 9 months horizon, previous review



Berlin07: 450 orders, 4 years horizon



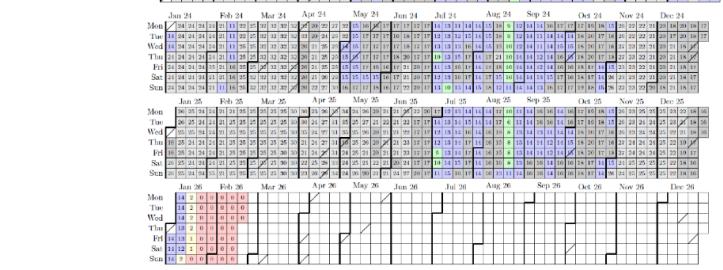
Berlin08: 559 orders, Christmas gap added



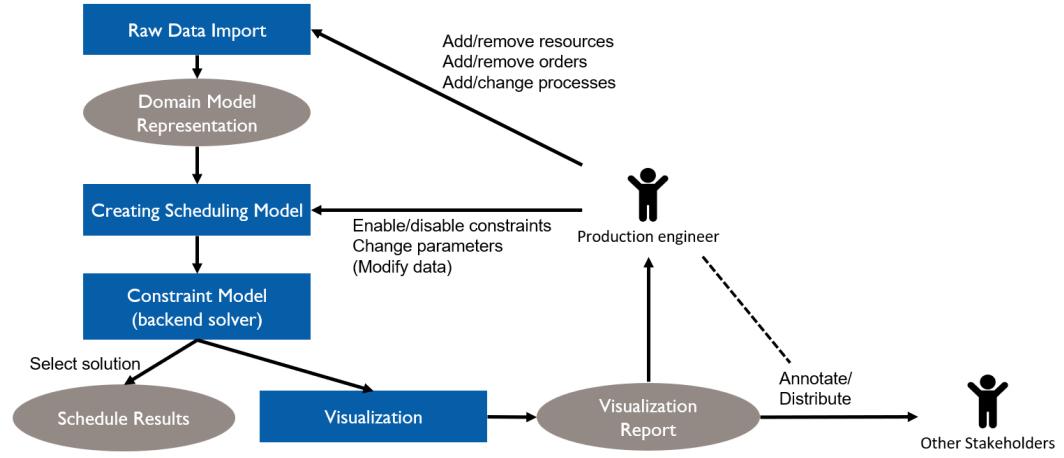
Berlin08a: 670 orders, filling gaps



Value in cell indicates active orders  
Yellow and red colors indicate low order volume



## Optimizer High Level Structure



### Raw Data - Manual Data Entry Causes Problems

- Raw data come from spreadsheet
  - 20 tabs
- Excel is a particularly bad input data format
- Realistic, not real data
- Created by hand/automatically from existing test scenarios
- Series of files Berlin01 - Berlin05 were too inconsistent to run
- Berlin06 still contains some errors
- Optimizer explains all issues that it finds

ASSISTANT Project Siemens Energy Use Case - Insight SFI Centre for Data Analytics

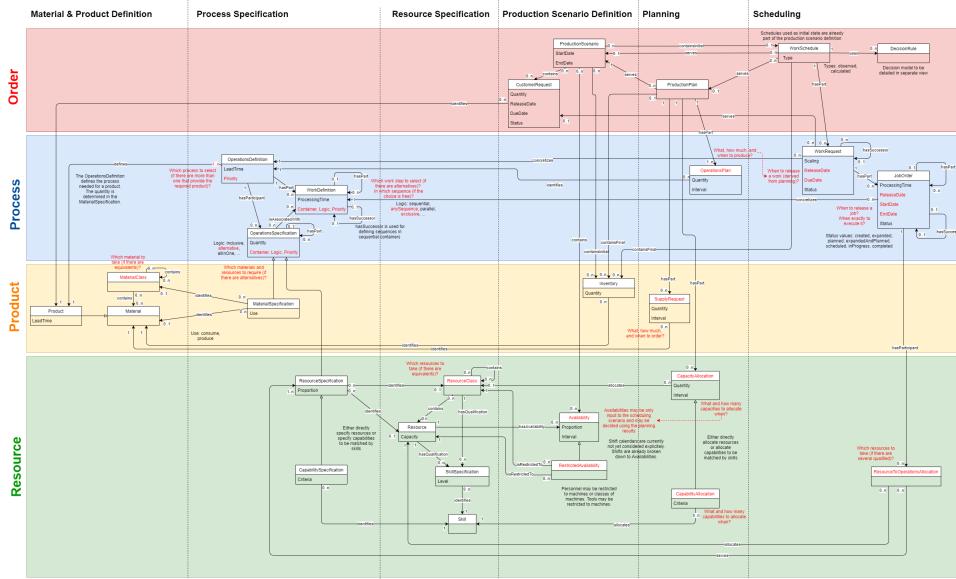
File Edit Scenario View Window Help

RawIssue X

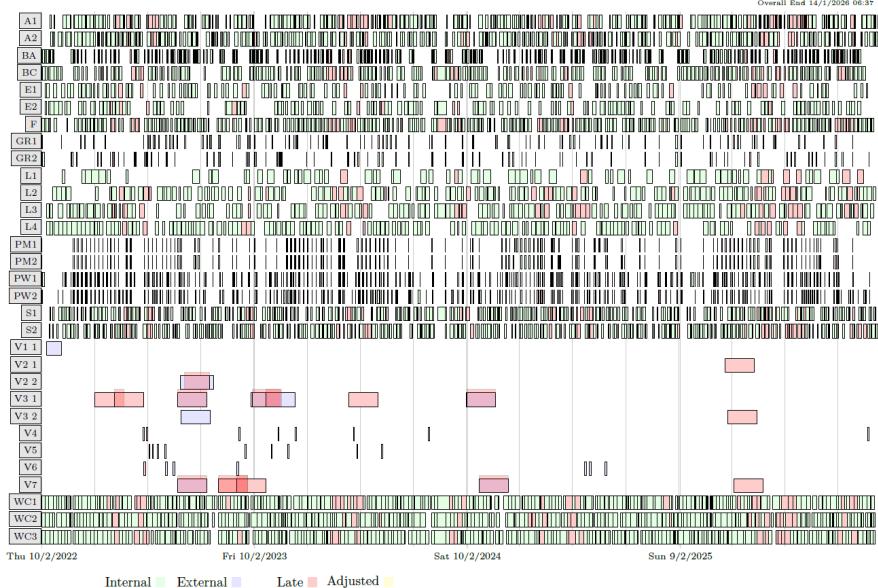
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Issue2	Minor	t_Products	1	15	Extra Empty Header
Issue3	Minor	t_Availabilities	1	8	Extra Empty Header
Issue4	Minor	t_Unavailabilities	1	8	Extra Empty Header
Issue5	Minor	t_Shift_Segments	1	6	Extra Empty Header
Issue6	Major	t_Shift_Segments	1	1	TimeOnly not formatted correctly, found 0.250000, format H:mm:ss
Issue7	Major	t_Shift_Segments	1	2	TimeOnly not formatted correctly, found 0.583333, format H:mm:ss
Issue8	Major	t_Shift_Segments	2	1	TimeOnly not formatted correctly, found 0.291667, format H:mm:ss
Issue9	Major	t_Shift_Segments	2	2	TimeOnly not formatted correctly, found 0.302083, format H:mm:ss
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Issue21	Major	t_Shift_Segments	8	2	TimeOnly not formatted correctly, found 0.010417, format H:mm:ss
Issue22	Major	t_Shift_Segments	9	1	TimeOnly not formatted correctly, found 0.083333, format H:mm:ss
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Issue25	Minor	t_Shift_Segments	11	0	First Column Empty
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Issue34	Minor	t_Shift_Patterns	7	0	First Column Empty
Issue35	Minor	t_Shift_Patterns	8	0	First Column Empty

▶ Filter

## Domain Model - Knowledge Graph



### Solution for Berlin 08a - Shows Only 20% of Tasks in Model



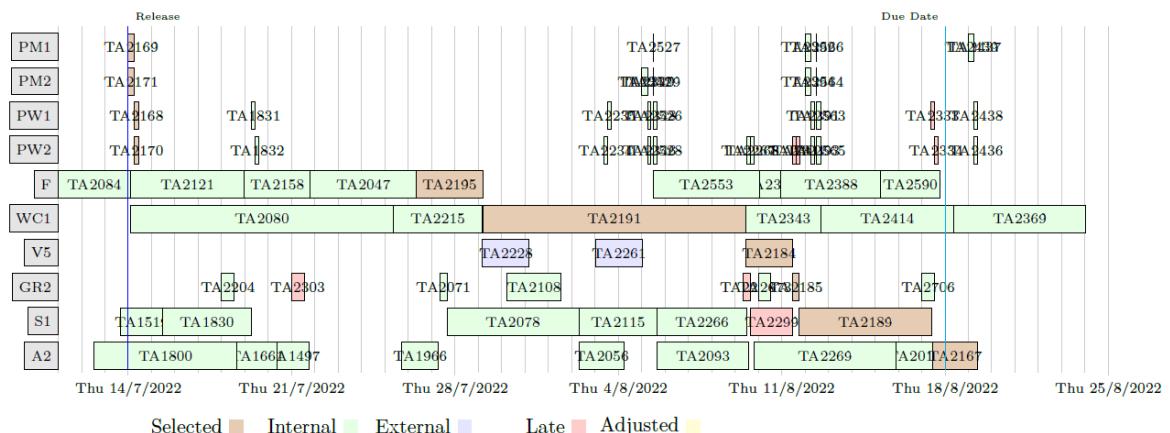
### Implementation

- Requirement capture done inside project
- Data checking/cleaning most time consuming aspect
- Some specified functionality was rejected by Betriebsrat
- Built in Java
- Uses IBM's CPOptimizer back-end
- 120k LoC, 110k generated, 3k solver
- Outperforms both
  - Current in-house tool

- Simulation based tool based on commercial simulator
- System installed at SE site, but not in daily use

### Explaining Late Delivery

- Explain why some orders are delivered late
- Find root-cause, show schedule in context



### Evaluation - KPIs

KPI	Baseline	Optimizer
OTD	> 80 %	92 %
Bottleneck machine utilization	99.5 %	100 %
Manufacturing defects	10-15 %	< 10 %
Scenarios in 8 hours	15-20	> 100,000

### Conclusion by Siemens Energy

*“Within less than eight hours the ASSISTANT tools provided us thousands of manufacturing scenarios including different make-or-buy recommendations for making deliberate decisions on the way to proceed for strategic planning.”*

from ASSISTANT final project review: Siemens Energy assessment

### Summary

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