

## *PlantTalk:Sequence*



**PlantTalk:Sequence** is an integrated and comprehensive solution to the automotive sequencing requirements. The essence of automotive sequencing is for suppliers to deliver parts to the OEM just in time, and also in the proper build sequence. Depending on the manufacturer, the sequencing requirement is referred to by many different names and acronyms, such as in-line vehicle sequencing (ILVS), sequential parts delivery (SPD), just-in-sequence (JIS), etc.

### *Receipt of Data with Sequencing Requirements*

There are a variety of communication methods to inform suppliers of the build sequence. Examples include:

- Using traditional EDI, the sequenced requirement usually comes in a form of an 866 transaction (Production Sequence). PlantTalk:Sequence imports a flat file with relevant information, extracted from the 866.
- In some instances, the sequenced build information is made available to the suppliers on the Internet, and it can be FTP'd into PlantTalk :Sequence.
- Another common way for suppliers to receive sequencing data is via a broadcast pulse directly into PlantTalk:Sequence. Usually, the pulse is triggered when the vehicle passes a predefined point on the manufacturer's assembly line (such as when the vehicle exits the paint section).





## ***Sequence Production Options***

Once the suppliers know the requirements, there are several different options to manufacture and deliver the parts in sequence to the manufacturer. These mostly depend on the nature of the product, how the products get packaged, and other factors considered by the suppliers. PlantTalk:Sequence supports both commonly used options.

Sometimes, the parts are built in batch (bulk), and are only sequenced at the end of the manufacturing process by placing the parts in proper sequence in the shipping rack, and then loading the shipping containers onto trucks in the proper sequence. Another option is to build in sequence, maximizing the utilization of floor space.

## ***Sequence Labeling***

PlantTalk:Sequence supports common part and rack labeling requirements. Usually, each sequenced part will require a bar-coded label, along with some other basic part information, such as sequence number, customer part number, etc. It is important to finalize the label requirements for each program, as they may change. Part labels can vary in size from as small as .75" x 1.5", to a more common 2" x 4" label size, or larger.

Rack labels also vary in size and specification. A more common type is a standard 4" x 6" (or 4" x 6.5") AIAG-type shipping label containing several pieces of information. The rack number, high and low sequence number, Plant ID, Line ID, and more may be included on the label. In some instances, the rack label may actually be a simple 8.5" x 11 piece of paper (without the adhesive), with or without a barcode. The label may also need to contain a grid schematic of the rack with the part numbers listed in the appropriate rack positions.

## ***Sequence Packing, Validation and Loading Process***

In addition to generating the OEM required rack sequence labels, our software includes a scanning validation process, verifying the sequences in the rack. Once each rack has been verified to be filled correctly (there is the right part number for the requested sequence in each slot), our system can be tailored to generate a production data upload file to be made available for import into ERP system.

Our application also includes the trailer load program, which ensures that the shipping racks are loaded onto trailers in correct sequence, based on the order that the OEM assembly plant requires the racks on the trailer. The trailer load is configured from a PC and then scanned, in sequence, by the RF hand held.

Based on the completed trailer load process, the Datanational system will generate a shipping file to be uploaded into your ERP/EDI system. The contents of the shipping file are normally imported into EDI/ERP to record a shipment, including the necessary inventory transactions, along with passing the data to EDI to generate an outbound 856 ASN transaction to be transmitted to the OEM. Your standard shipping process may include the printing of shipping paperwork, such as Bill of Lading and/or Packing List. Alternatively, our software can print a summarized BOL report that could be used as a packing list.