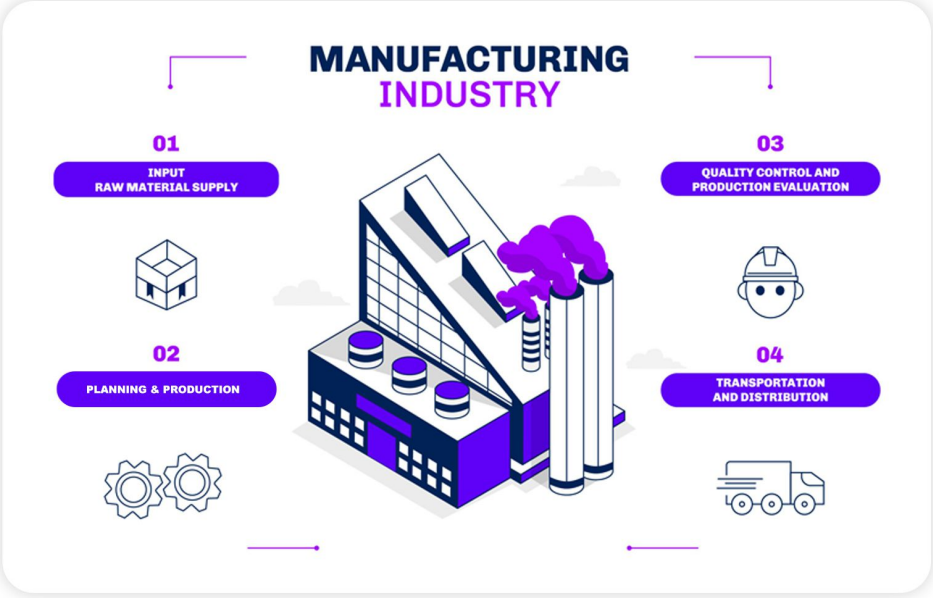
Case Study Document
April 2025



RDL MES 4.0 & INTEGRATED ERP

Connected Material | Connected Process | Connected Machine

Digital Transformation | Industry 4.0 | MES 4.0

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Key Challenges STORE & PROCUREMENT

Lack of Real-Time Inventory Visibility

- Manual stock updates lead to inaccurate stock levels.
- Risk of overstocking or stockouts.
- No centralized view across multiple warehouses or locations.

Inefficient Purchase Requisition & Order Processing

- Paper-based or email-based requisition is slow and error-prone.
- Delay in approvals due to lack of workflow automation.
- No standardized procurement process.

Vendor Management Issues

- No centralized vendor master; data scattered in spreadsheets.
- Difficulty tracking vendor performance (delivery delays, quality issues).
- Inconsistent pricing and lack of rate contract visibility.

Poor Material Tracking & Traceability

- Challenging to trace material batches, expiry, or warranty without proper tagging.
- Manual GRN (Goods Receipt Note) processes prone to duplication or omission.
- Lack of integration with quality checks or inspection processes.

Uncontrolled Consumption & Wastage

- No control over issuing materials to departments or machines.
- Manual registers can't track consumption patterns or unusual usage.

No Budgetary Controls

- Difficult to track procurement against departmental or project budgets.
- Tendency to exceed limits due to lack of real-time financial linkage.

Delayed Reporting & Poor Decision-Making

- Reports are manually compiled and often outdated.
- Lack of dashboards or alerts for low stock, PO delays, or excess consumption.

Audit & Compliance Risks

- Missing documents (POs, GRNs, invoices).
- Hard to track who approved what and when.
- Poor documentation affects internal and statutory audits.

No Integration Between Departments

- Procurement doesn’t sync with finance, stores, or production.
- Leads to duplication, delays, and miscommunication.

Human Dependency & Lack of Standardization

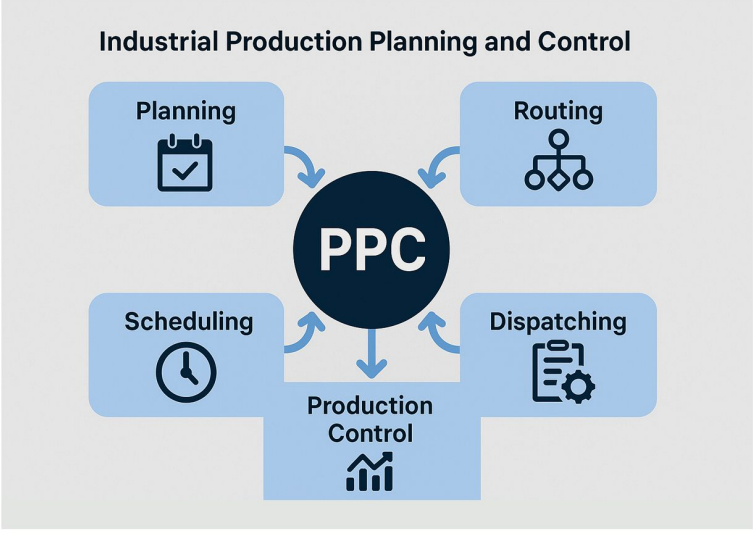
- Process knowledge resides with individuals, not systems.
- No SOP enforcement leads to inconsistencies.

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Key Challenges PLANNING & SCHEDULING

As Is Process

- The Planning Department has to manually enter the planning excel sheet based on his previous knowledge and experience.
- MRP will generated manually.
- Machine and shop floor planning for the shift / day / week will be done manually.
- No. of jobs are scheduled for the machine considering soon after the earlier job is completed.
- Scheduled job may be rescheduled / hold based on priority .
- Production data will be updated to the system after the shift / day.

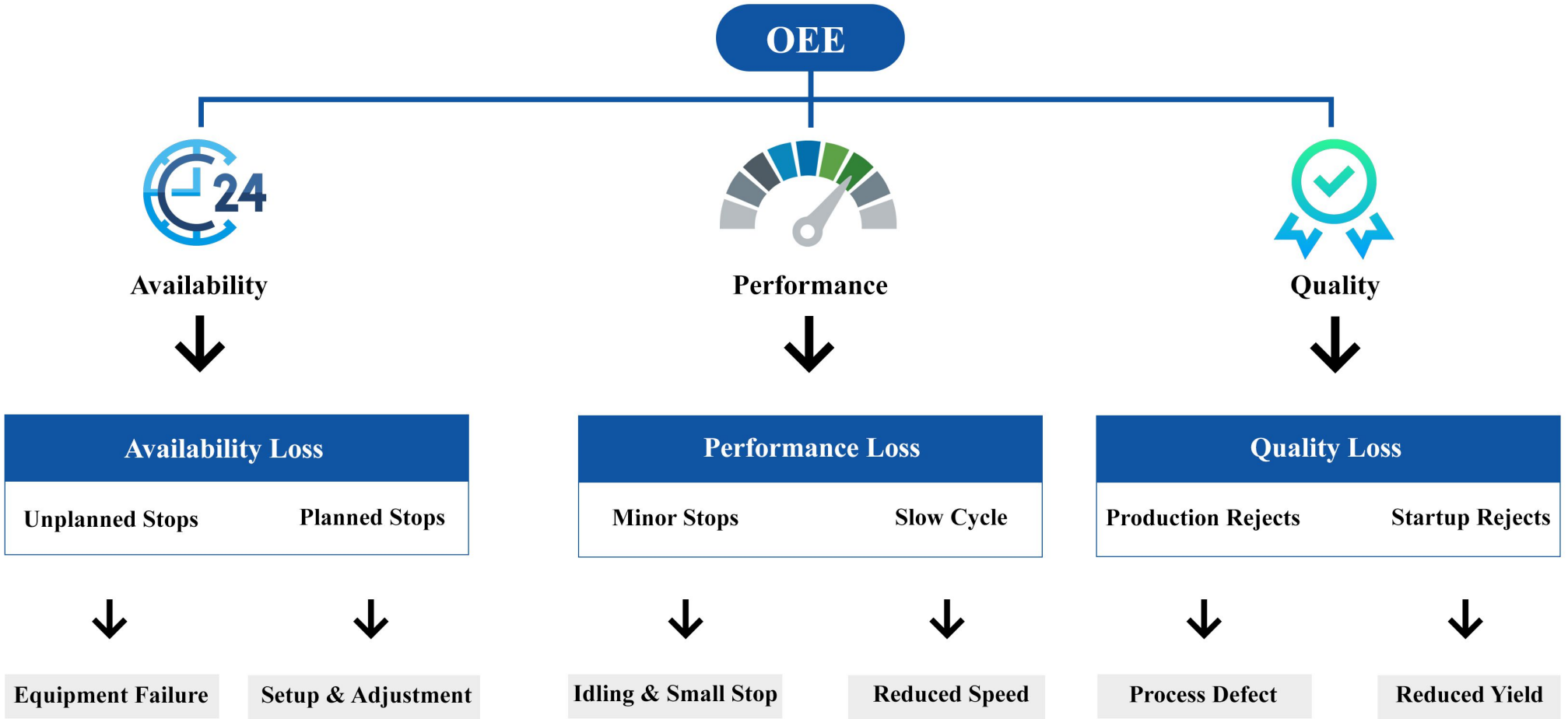


The Challenge

- Planning is manual centric.
- Planning require data from multiple department hence consumes excessive time.
- There is no real time update available about Planning vs current production status on a real time basis.
- Job production time estimation is purely on planner experience & knowledge.
- Managing the production schedule and transitioning to real-time dynamics, such as machine and raw material availability, SFG vendor process delays, production holds, production defects, operator availability, production quarter targets, and other priorities, can be challenging.

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Key Challenges OEE



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Key Challenges

MACHINE HEALTH & DOWNTIME

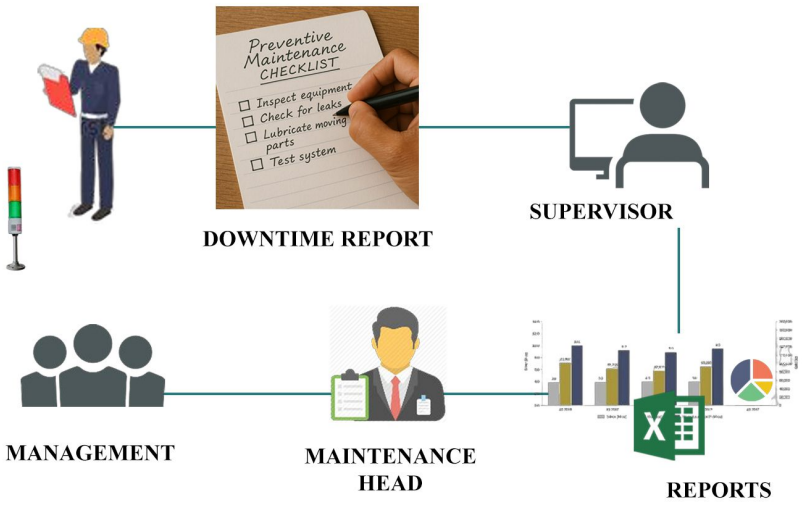
As Is Process

- Operator should reach the supervisor to escalate the issue.
- Supervisor should update downtime manually.
- Maintenance person fixes the issue based on his knowledge.
- Time and periodically based maintenance.



The Challenge

- No Accuracy in updating Downtime.
- There is no clear visibility and performance on the shop floor.
- Real-time tactical decision making is challenging.
- Predicting the root cause and anomaly is not possible.
- There are no proactive failure and disturbance alarms.
- Time and periodically based maintenance increases the cost of components, tools, and consumables as well as the duration of maintenance.



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Key Challenges UTILITIES MONITORING AND INSTRUMENTATION

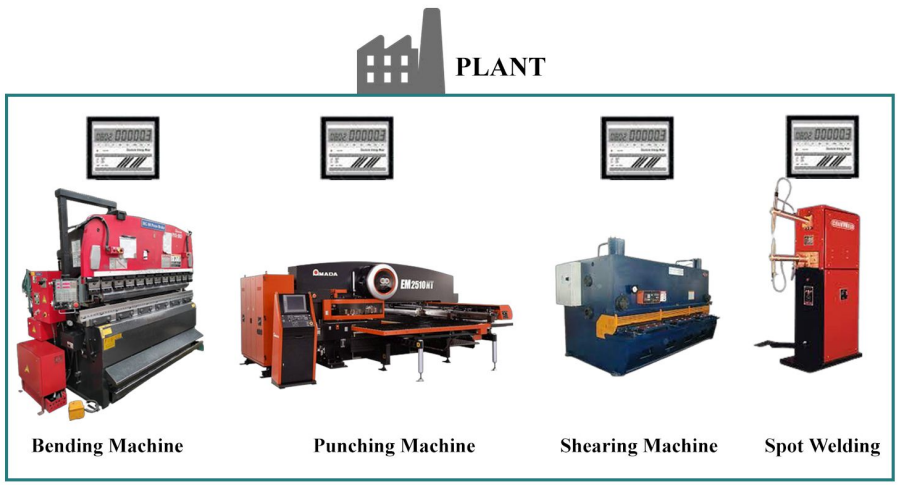
As Is Process

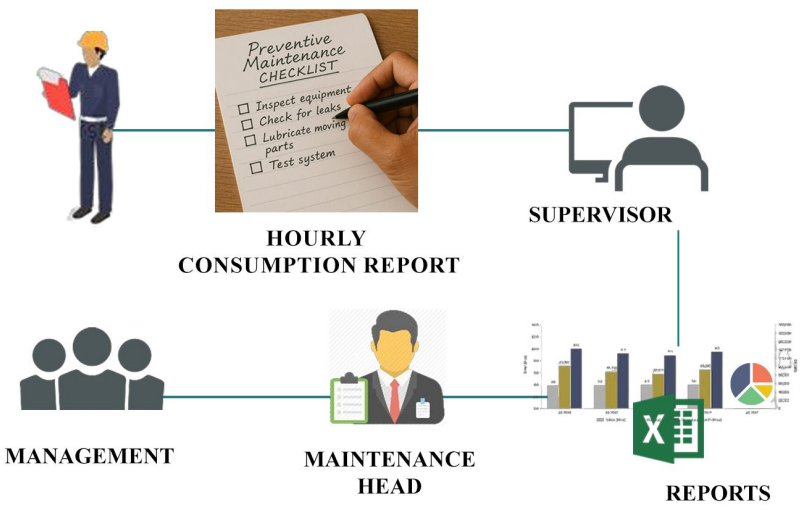
- Utility supervisor need to reach meter panel and take the reading periodically as scheduled.
- Calculation of power consumption against production & ideal conditions are totally manual.



The Challenge

- Human error, Not 100% Accurate readings noted & Only Specific Parameters are Captured.
- Limited visualization only provided localized view of the system.
- Invisibility of wastage, and any breakdown will lead long time to analyze.
- Predicting the root cause and anomaly is not possible.
- There are no proactive failure and disturbance alarms.
- Meter data used only for billing, cannot help in analysis like demand analysis, energy audit, pinpointing losses, etc.

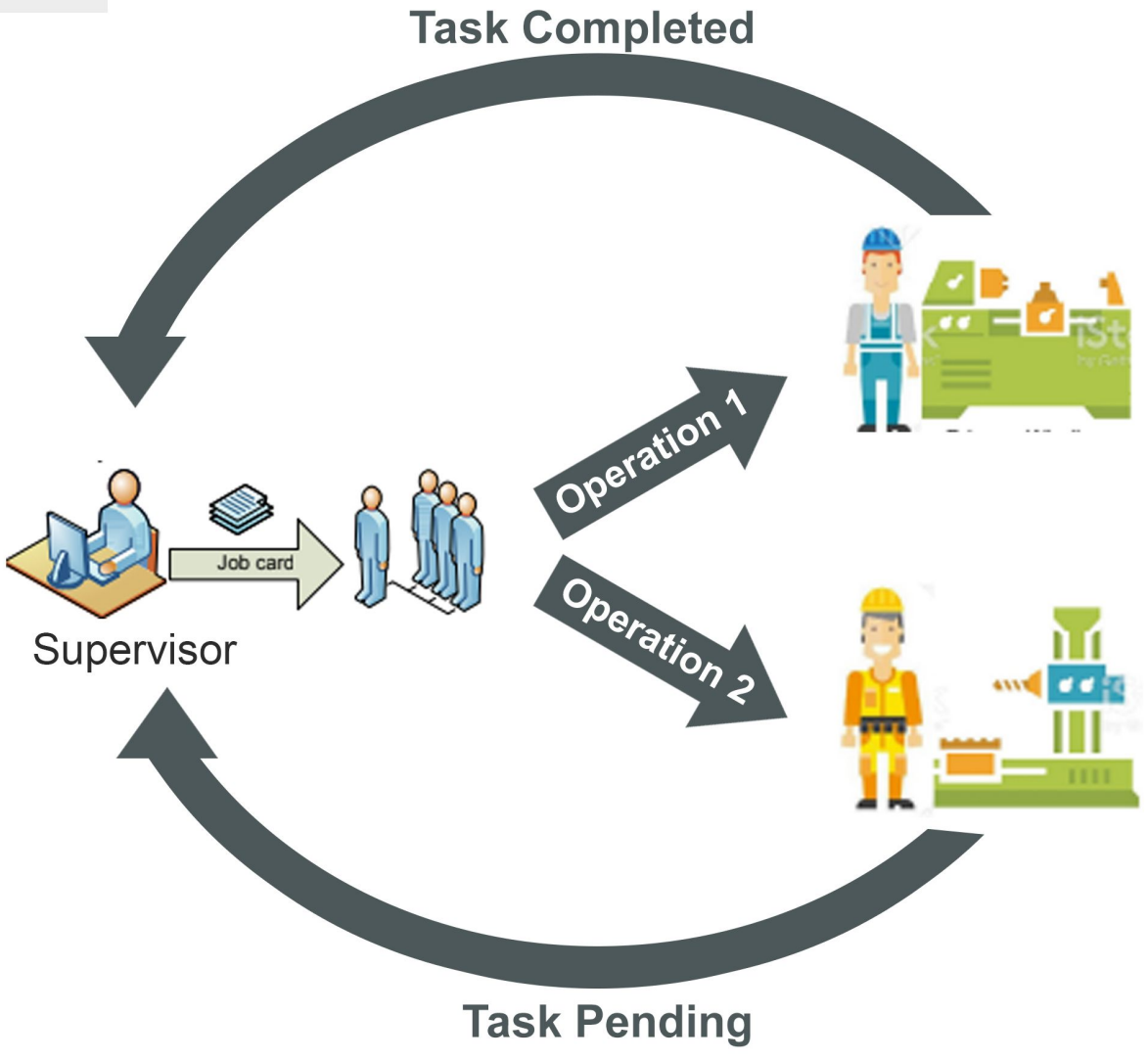




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Key Challenges OPERATORS & JOB CARDS

- Manual Job Card Allocation.
- No Real-Time Operator Tracking.
- Inefficient Shift & Attendance Management.
- Lack of Job Status Visibility.
- Poor Productivity Tracking.
- Material & Resource Mismatch.
- No Link to Quality or Rework.
- Paper-Based Documentation.
- Limited Analytics & Reporting.
- Difficulty in Planning & Forecasting.



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Key Challenges

4M (MAN, MATERIAL, METHOD, MACHINE) & SKILL MATRIX

- Difficulty in Track Operator Performance
- Defect & Production Vs Operator
- Training & Performance Enhancement
- Operator Timing
- Operator Attention towards work







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Key Challenges END TO END TRACEABILITY

As Is Process

- Raw material will be taken to store by generating unique GRN number.
- FG / SFG will be taken to the store by generating GRN number.

The Challenge

- GRN numbers are not mapped with Sales order no, Production order no and Part no.
- Sometimes new GRN numbers (Newly arrived stock) will be used in production by keeping old stock. Stock age is not considered.
- It's difficulty to backtrack if an issue occur due to raw material quality.
- Impact analysis of modifications is challenging.
- Hard to map material consumption vs production vs scrap.

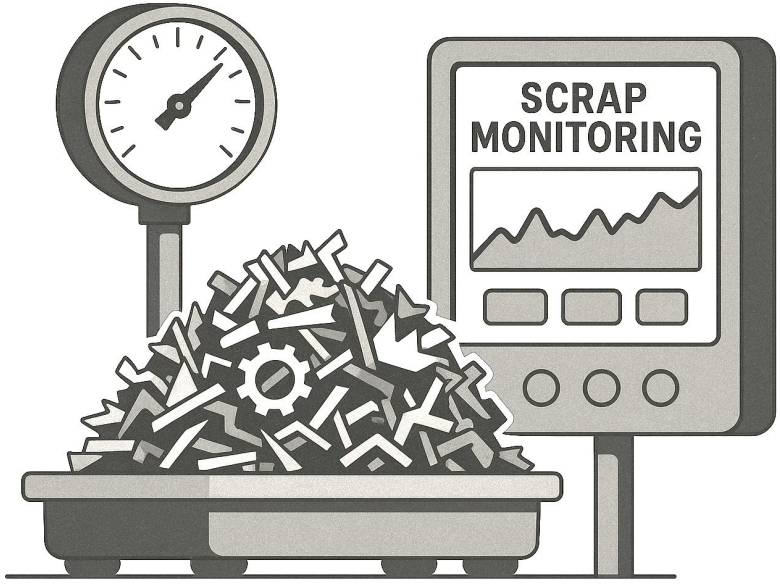


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Key Challenges REAL TIME SCRAP MONITOR

As Is Process

- Scrap weighing readings are taken manually and then entered to the sheet.
- Scrap Segregation based on machine type, material type, bins and shapes.



The Challenge

- No Alerts and notifications for scrap exceeding predefined thresholds.
- Difficulty to Identify key production areas with high scrap rates.
- No real time data to optimize machine settings for scrap reduction.

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Key Challenges DISPATCH MANAGEMENT SYSTEM

As Is Process

- Manually dispatch scheduled as per contracts / PO and based on vehicles available with respected to time.
- SFG & Vendor process dispatch scheduled manually.
- There is no visual proof of the pack item inside the box.

The Challenge

- It's quite difficult to ensure that the parts and assemblies & required Qty are present in the box with respect to the purchase order. It's a time consuming verification process for double verification.
- Manually need to coordinate with the production, assembly & quality assurance department to get information about the readiness of product to be dispatched.
- Manually need to be coordinated with the account department to get respective bills and E way, E Invoice DC/NRDC related documents.
- Timely dispatch is challenging.



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Key Challenges QUALITY & CHECK SHEET

- Human errors
- **Negligence** - Updating checklist randomly without checking
- **Time Authenticity** - No periodic / timely update
- **Go Green & Sustainability Initiative** - Lot of paper consumptions

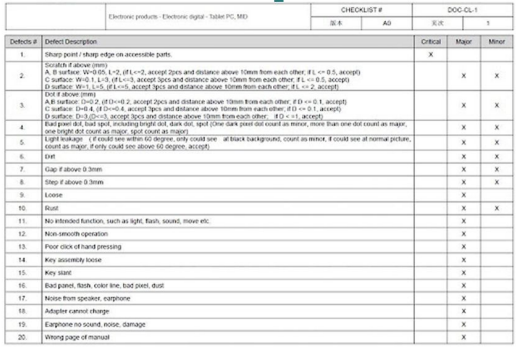
During Start Up



Production Output



Equipment Check Sheet

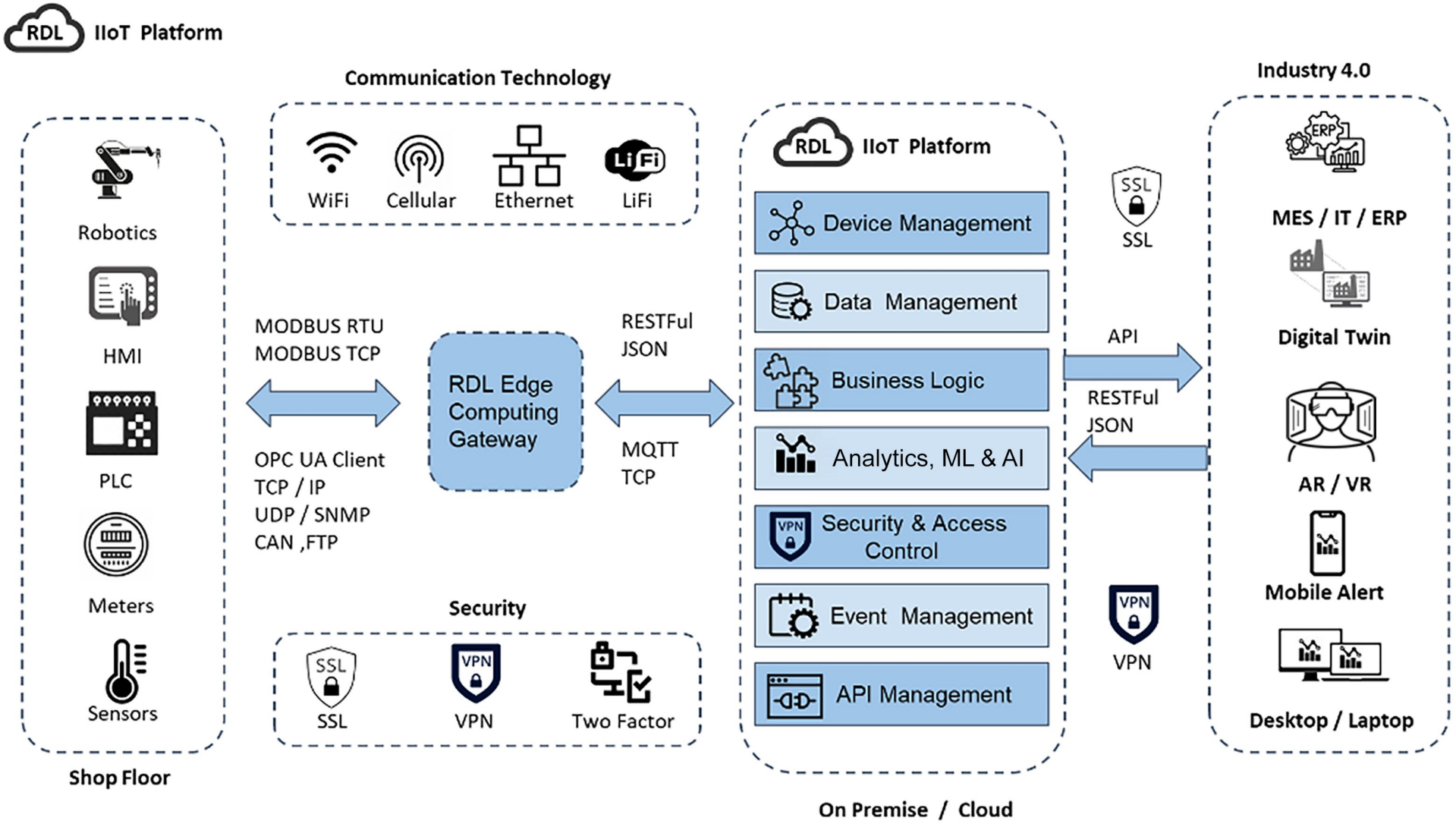


Defects #	Defect Description	Critical	Major	Minor
1.	Sharp point / sharp edge on accessible parts.	X		
2.	Scratch if above (mm) A, B surface: W=0.05, L=2, (if L=<2, accept 2pcs and distance above 10mm from each other, if L =< 0.5, accept) C surface: W=0.1, L=3, (if L=<3, accept 3pcs and distance above 10mm from each other, if L =< 0.5, accept) D surface: W=1, L=5, (if L=<5, accept 3pcs and distance above 10mm from each other, if L =< 2, accept)		X	X
3.	Dot if above (mm) A,B surface: D=0.2, (if D=<0.2, accept 2pcs and distance above 10mm from each other, if D =< 0.1, accept) C surface: D=0.4, (if D=<0.4, accept 3pcs and distance above 10mm from each other, if D =< 0.1, accept) D surface: D=3,(D=<3, accept 3pcs and distance above 10mm from each other, if D =< 1, accept)		X	X
4.	Bad pixel dot, bad spot, including bright dot, dark dot, spot (One dark pixel dot count as minor, more than one dot count as major, one bright dot count as major, spot count as major)		X	X
5.	Light leakage : (if could see within 60 degree, only could see at black background, count as minor, if could see at normal picture, count as major, if only could see above 60 degree, accept)		X	X
6.	Dirt		X	X
7.	Gap if above 0.3mm		X	X
8.	Step if above 0.3mm		X	X
9.	Loose		X	
10.	Rust		X	X
11.	No intended function, such as light, flash, sound, move etc.		X	
12.	Non-smooth operation		X	
13.	Poor click of hand pressing		X	
14.	Key assembly loose		X	
15.	Key slant		X	
16.	Bad panel, flash, color line, bad pixel, dust		X	
17.	Noise from speaker, earphone		X	
18.	Adapter cannot charge		X	
19.	Earphone no sound, noise, damage		X	
20.	Wrong page of manual		X	

Quality Check Sheet

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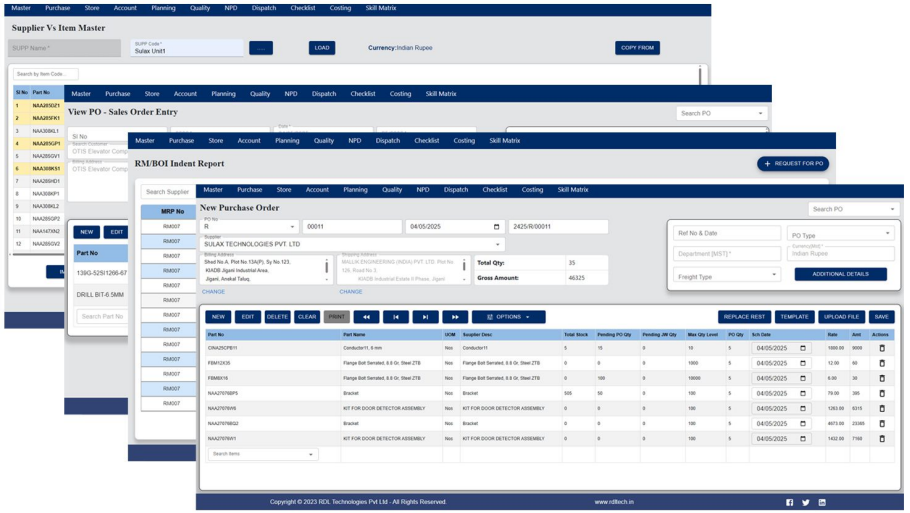
Architecture



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The Solution

STORE & PROCUREMENT



Objective

- Improve industry-focused inventory control and reduce material wastage.
- Streamline procurement procedures to ensure timely supply of raw materials and components.
- Enhance vendor management and negotiation capabilities tailored for industrial needs.
- Implement advanced technology for better tracking, reporting, and compliance.

Modules

- **Inventory Control:** Utilize automated systems to track raw materials, semi-finished goods, and finished products.
- **Storage Optimization:** Implement industrial-grade shelving, and proper labeling for efficient access.
- **Reporting & Auditing:** Maintain real-time records of stock transactions, generate compliance reports, and conduct periodic audits.
- **Needs Assessment:** Determine material and equipment requirements based on production schedules and operational demand.
- **Vendor Selection:** Establish criteria for evaluating suppliers based on quality, sustainability, and delivery timeliness.
- **Purchase Requisition & Approval:** Implement a multi-tiered approval process for bulk and critical procurements.
- **Order Management:** Automate purchase orders, track shipments, and ensure adherence to service level agreements (SLAs).
- **Invoice Processing:** Ensure efficient invoice verification and settlement to maintain supplier relationships and avoid delays.
- **End-to-End Traceability:** Implement a digital tracking system to monitor products from procurement to final delivery.
- **GRN Processing:** Implement automated Goods Receipt Notes (GRN) to validate received goods against purchase orders.
- **Quality Checks & Approvals:** Integrate GRN processing with quality control to flag discrepancies and ensure compliance.
- **Automated Documentation:** Digitize records for every transaction, ensuring transparency and accountability.
- **Price Change Notification & Approval:** Purchase order requires authorization when item price is hiked compared to previous purchase.
- **Forecasting and Cost Analysis**
- **Bulk Import and Export:** Hussle free bulk excel import and export.
- **Manual and Automated Material Issue Mode:** System will provide manual / auto option to issue the material based FIFO & item expiry date.

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The Solution ACCOUNTS

Sales Order Entry
- Capture sales requests.
- Map to Customer PO.
- Partial fulfillment + Short Close.

Short Close Sales Order
- Close pending/unfulfilled order lines.
- Logs reason and approval trail.

Proforma Invoice
- Non-tax invoice (quotation).
- Can convert to final Invoice.

Dispatch Module
- Dispatch Queue (from SO/DC).
- Pick List generation.
- Inventory / Warehouse Integration.

Transport Master
- Maintain master data for transport partners and vehicle info.

Customer DC Tracking
- Customer-issued DC mapping.
- Cross-verification at goods dispatch.

Customer PO to DC/Invoice Mapping
- Match Sales Docs to original POs.
- Prevent over-supply.

Invoice (Tax Invoice)
- GST-compliant with IRN.
- IRP & QR Code for eligible transactions.

Cancel GST Invoice
- Cancel within allowed GSTN time.
- Auto IRN and E-Way Bill revocation.

e-Invoice (IRN Generation)
- IRN, QR Code, Ack No.
- Real-time GSTN integration.

e-Way Bill
- Auto from DC or Invoice.
- NIC API-based with cancellation, extension.

Sales Return
- Full/partial returns from customer.
- Auto restocks inventory.

Credit Note
- Tax-compliant return/adjustment doc.
- Linked to GSTR-1.

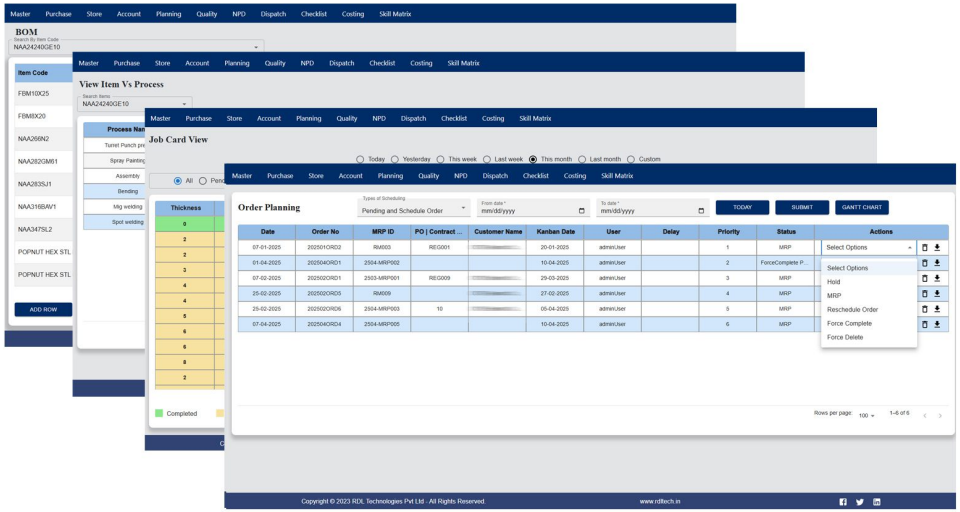
Customer vs Item Price Matrix
- Customer-specific pricing per item/UOM.
- Validity periods & tier pricing.

Reports & Logs
- Sales Register.
- Proforma Invoice Tracker.
- PO/DC Fulfillment Report.
- Customer DC Summary.
- IRN & EWB History.
- Credit Note Register.
- Price Matrix Overrides Log.

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The Solution PLANNING & SCHEDULING

- One common portal for factory head, project contract manager, planner, designer / programmer, shop floor in charge to monitor the production status like in-progress, delayed, on hold, shop floor schedule plan, machine schedule plan, assembly & testing schedule & upcoming pipelined projects.
- Option for viewing forward machine availability for jobs, current machine loading / capacity utilization and projected machine utilization & availability for a given time frame.
- Smarter production planning and traceability - Real-time production visibility like target vs produced across shifts, hours.
- Shop floor / machine schedule planning, heat treatment schedule planning assembly and testing schedule planning based on real time dynamics (Machine Availability, Manpower Availability, Production Defect, Monthly / Quarterly Production target and Project Hold by the customer).



- Connect production assets to provide a unified view of production status across stations and tracking real time manufacturing KPIs.
- Schedule / Reschedule / Machine downtime alert to respective stake holder.
- Asset utilization & availability for a given time frame.
- Descriptive analytics with historical data to analyze trends in production.
- Job card generation based on BOM and item vs process.
- Material requirement planning based on BOQ.
- Generation consolidated raw material requirement & BOI to purchase.
- Option for importing contract list / sale order to segregate regular production parts, R&D parts & MKD parts.

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The Solution

OEE & PRODUCTION MONITORING

Improve Productivity

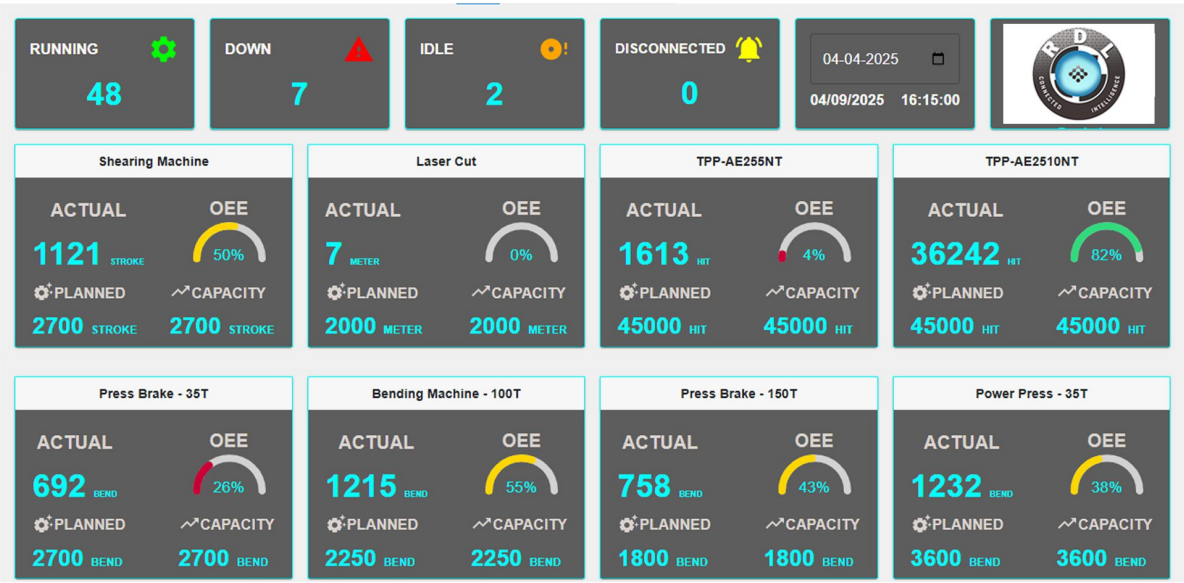
- Unlock the Hidden Production Capacity.
- Increase the Machine Availability.
- Maximize the Production Output.

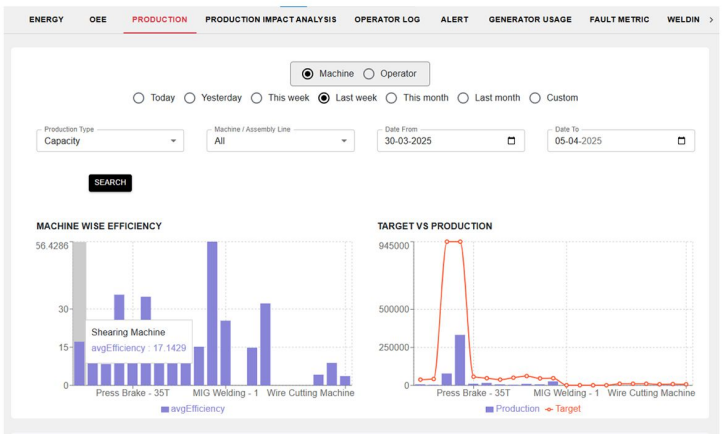
Reduce Loss

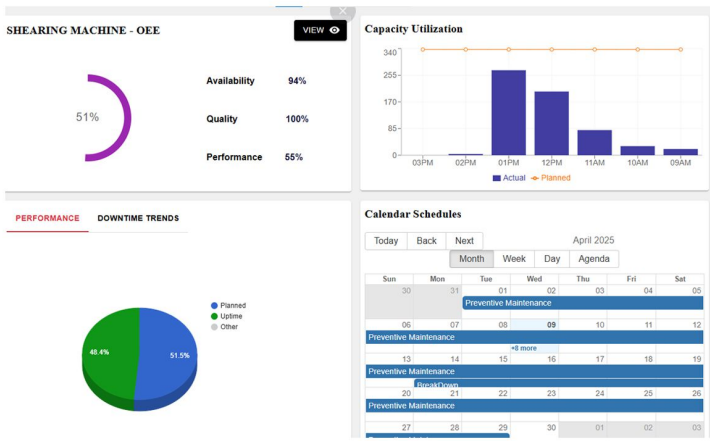
- Minimize the Unplanned Downtime.
- Reduce Product Defect.
- Prevent Unscheduled Maintenance.

Increase Profit

- Improve Asset Utilization.
- Shorten Production Lead Time.
- Optimize Product Quality.



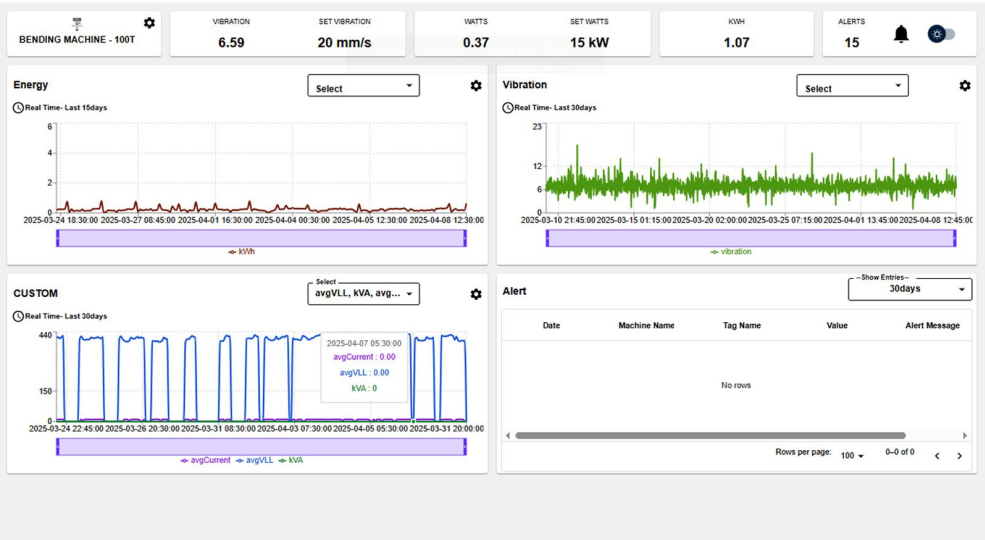


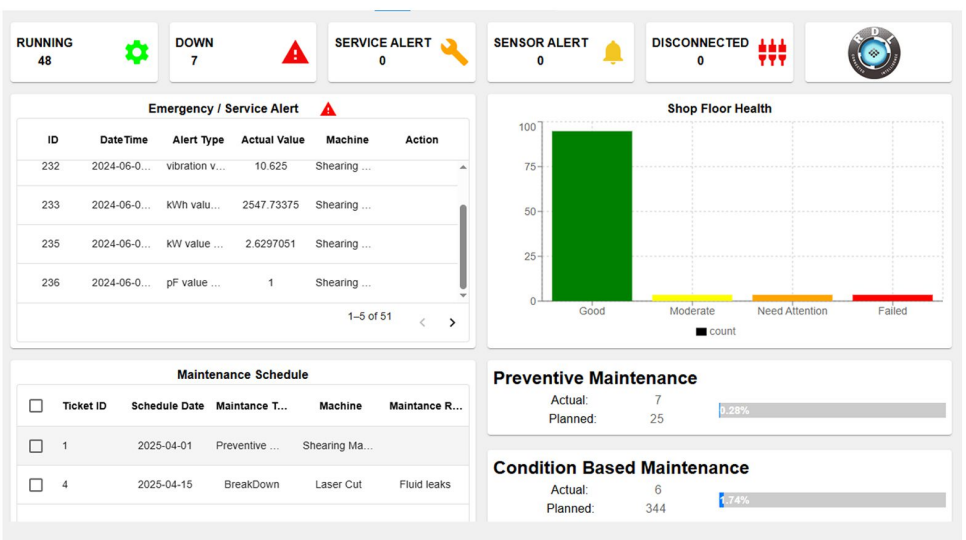


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The Solution MACHINE HEALTH | CRITICAL MACHINE DOWNTIME

- Solution for Capturing Machine data - Available time, Run time, Idle time, Down time, AUTO / MDI / JOG, Running Job, Alarm time, Operator Log etc.
- Solution for capturing Energy Parameter Voltage - P-P / P-N, Amps - R Y B, KW, KWH, PF, KVA - Real time basis.
- Solution for capturing Vibration - FFT & Magnitude.
- Closely monitor individual assets for critical indicators, Failure signatures, Machine status availability and performance.
- Insights to detect failures in advance through anomaly detection.
- Threshold based alerts to notify key stakeholders.
- Asset level downtime trend.
- Condition based maintenance to Avoid Time / Periodic based maintenance and reduce the parts / Tool / Consumables costs & maintenance time.



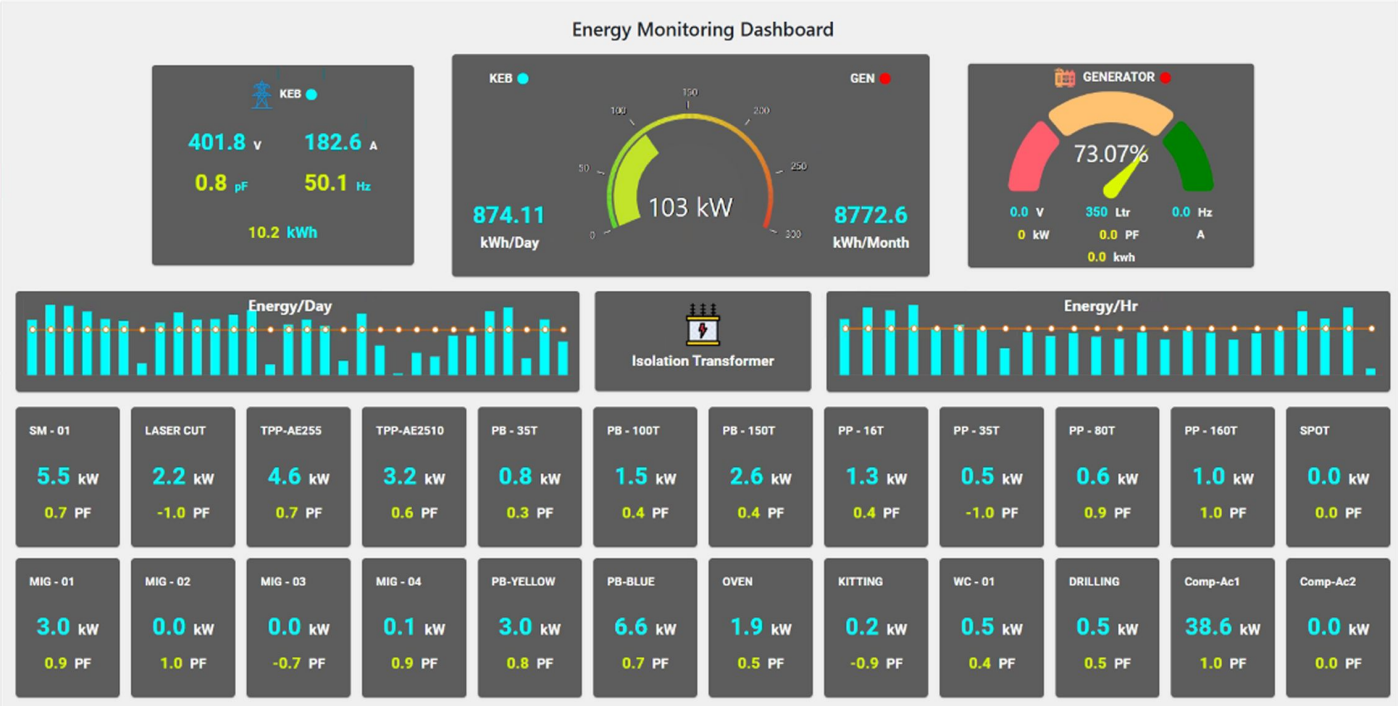


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The Solution

UTILITIES MONITORING AND INSTRUMENTATION

- Centralized monitoring with automatic pre-warning Alarm.
- Real-time end to end traceability of consumption.
- Early detection of potential problems leads to increased uptime maintenance activities, improved safety and longer machine lifespan.
- Visibility of usage of utilities and track them to set baseline values saving from penalties.
- Improve stand-by operation & energy cost per unit.
- Eliminate routine waste & reduce energy cost.
- Proactive alerts of failure and disturbances.
- Enable management with KPI views to set utility goals.
- Minimize unplanned downtime and reduce the maintenance costs & time.



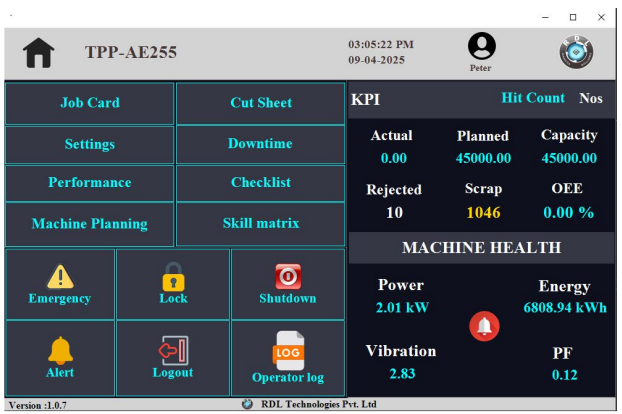
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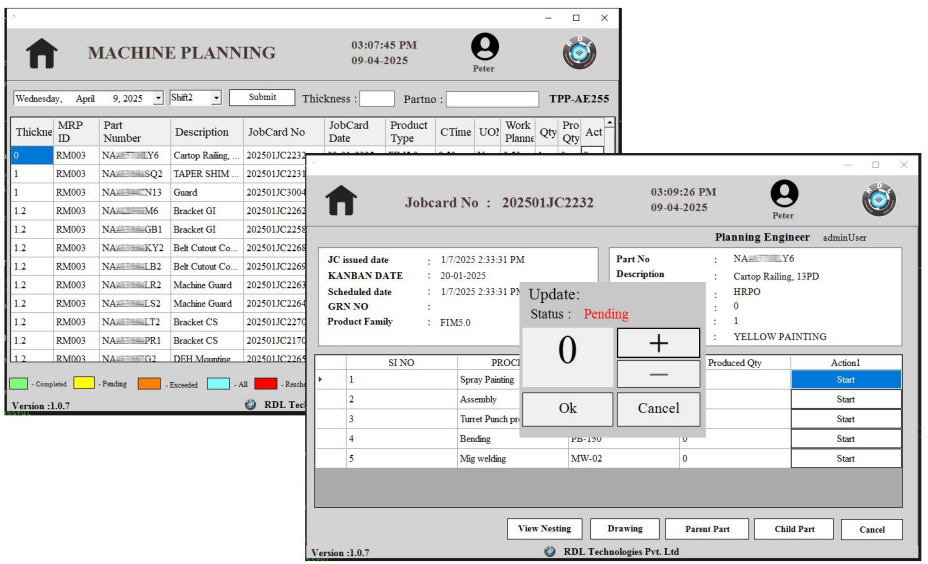
The Solution

OPERATORS & JOB CARDS

- Idle / breakdown reason selection from the machine screen and data capture in real time.
- Setup / Machining / Inspection and Rework data capture in real time.
- Application prompt to enter reason if actual hours are exceeding standard hours.
- Smart form to capture actual hours against standard hours for each operation.
- Application will have access to drawings, Job card & Machine schedule plan and CNC program.
- Operator assistance - Call supervisor / Maintenance person.
- Application will have option to take quality input and JH sheet input.
- Operator / Supervisor / Shop floor in charge can update the production / process status on a real time basis.





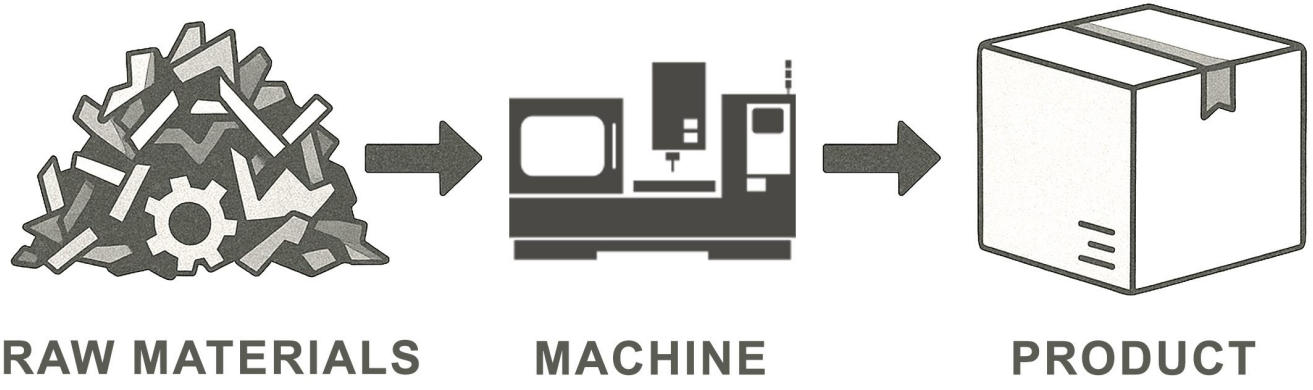


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The Solution

END TO END TRACEABILITY

- Assure that only adequate materials and components enter the final product.
- Provide accurate identification, e.g. to avoid mix-up of products which otherwise look alike.
- Use of materials on a first-in first-out basis reduces the risk of quality deterioration due to corruptible materials.
- To minimize the quality costs and impact of quality problems by identifying, locating and separating defective or potentially defective.
- Products from the total product population in internal material flow and from the customer base (e.g. retrofit or recall).
- To identify and help fixing the root causes which led to the quality problem.
- To enable data for development of supplier quality.
- To enable product quality and life cycle management.



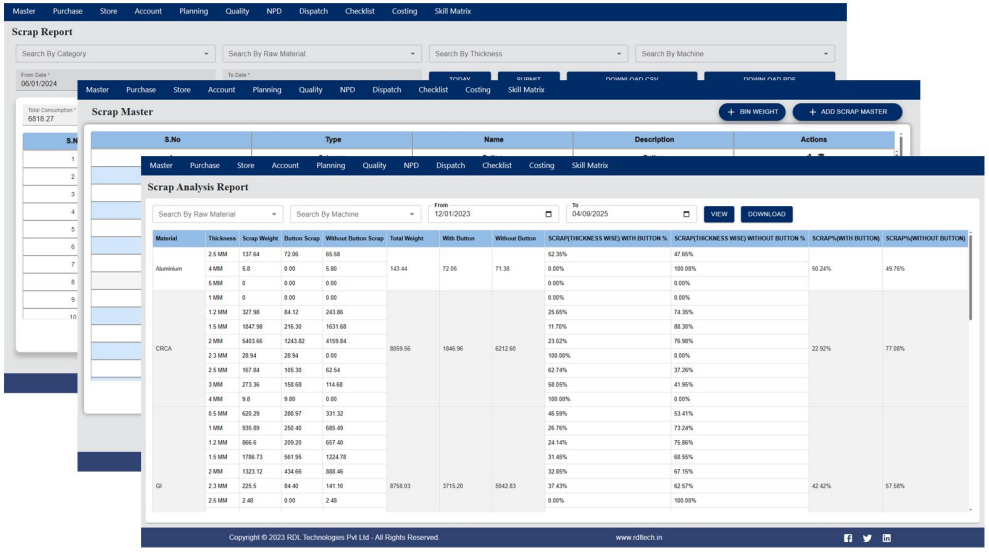


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The Solution

REAL TIME SCRAP MONITOR

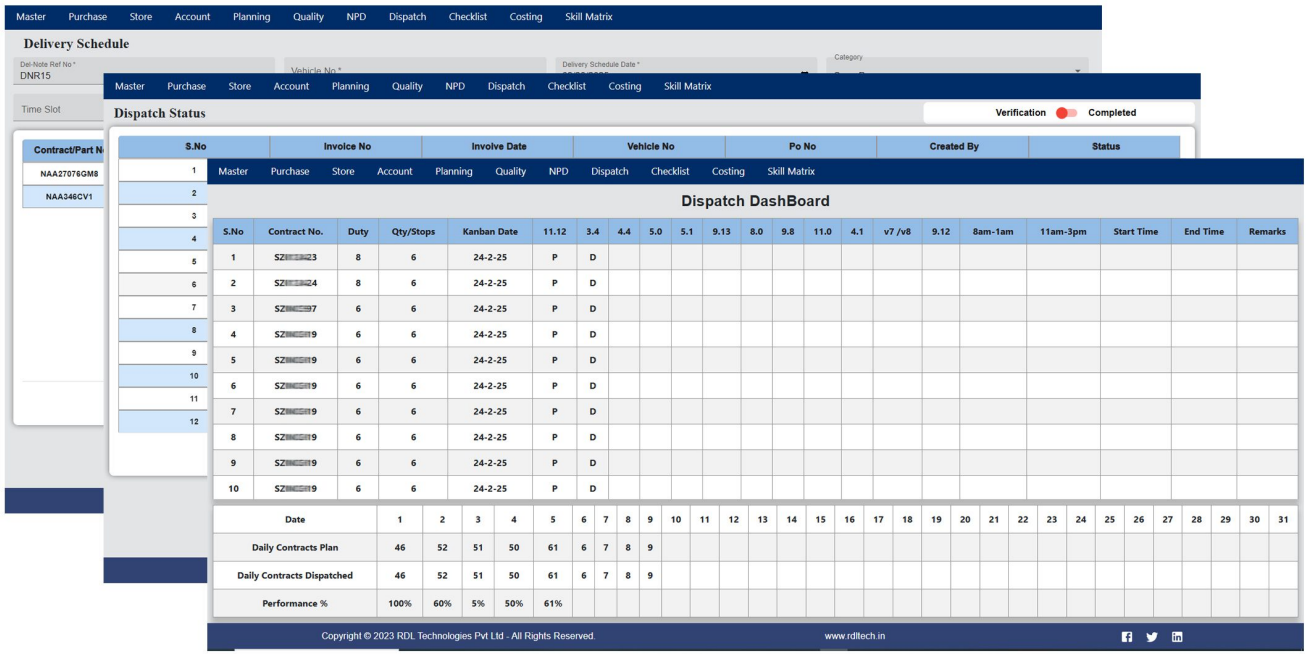
- IoT enabled Device for weighing scale to collect real time data.
- Identify key production areas with high scrap rates.
- Use feedback loops to continuously optimize scrap management processes.
- Train staff on using the dashboard and optimizing machine settings for scrap reduction.
- Set goals for scrap reduction and recycling targets.
- Visual displays of the total scrap generated, categorized by type and source.
- Alerts and notifications for scrap exceeding predefined thresholds.
- Reports on scrap reduction goals, trends, and recycling percentages.
- Predictive indicators of future scrap production based on production schedule and historical data.



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The Solution DISPATCH MANAGEMENT SYSTEM

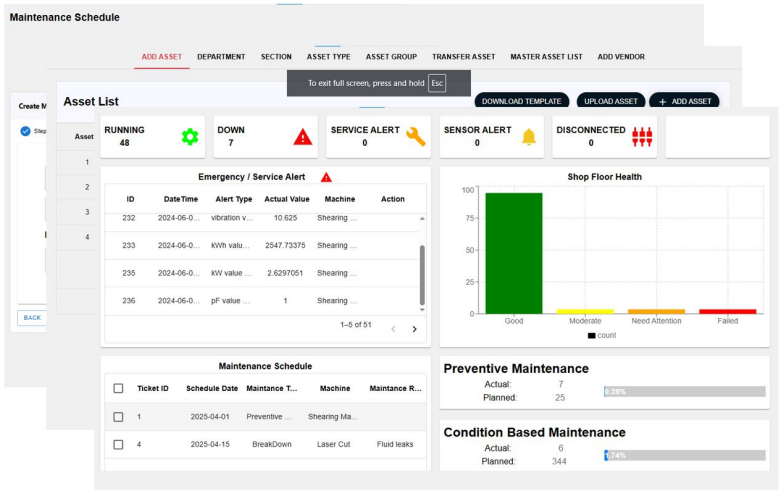
- Generating QR code / Barcode based on contract / PO part list.
- Grouping part number based on assembly and box.
- Barcode / QR code scanning while boxing to ensure that no parts are misplaced.
- Only after getting clearance from the assembly and quality department confirmation system will allow scheduling dispatch to the customer.
- System will take all the parts / assemblies photos in the box to maintain the records.
- System will connect the account department to raise the required bill to complete the process.
- System will note the SFG GRN & schedule dispatch for the SFG vendor process.
- System will complete the SFG vendor process upon receiving material from the vendor by inwarding stock with the same GRN number.
- Any delay in the dispatch process delayed notification will be displayed on the dashboard.



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The Solution

MAINTENANCE & ASSET MANAGEMENT



Objective

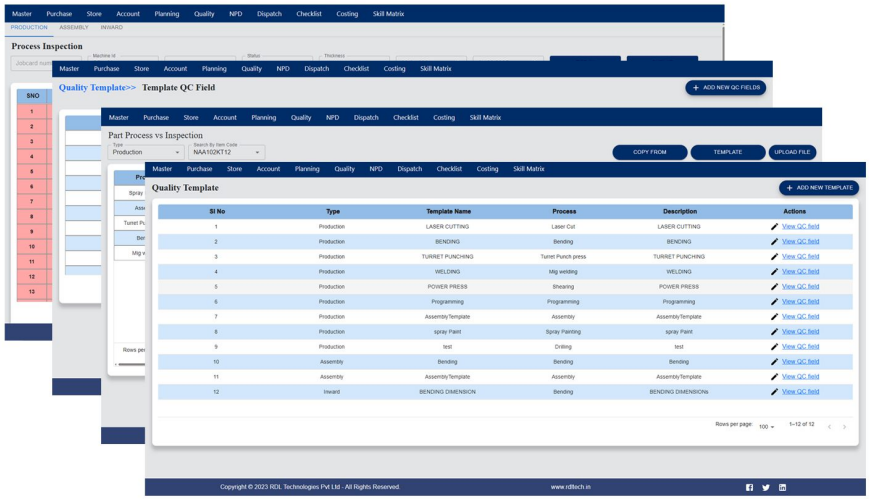
- Reduced Downtime: Predict and prevent failures before they occur.
- Cost Savings: Optimize maintenance schedules and reduce unnecessary maintenance.
- Improved Asset Lifespan: Prolong equipment life through timely interventions.
- Increased Productivity: Enhance operational efficiency with automated workflows.
- Regulatory Compliance: Ensure adherence to industry maintenance standards.

Module

- Preventive Maintenance: Scheduled maintenance tasks based on predefined intervals to reduce unexpected failures.
- Predictive Maintenance: AI-driven failure predictions using historical data and machine learning models.
- Condition - Based Maintenance: Real-time monitoring of equipment conditions using IoT sensors and alerts.
- Asset Registration: Maintain a centralized database of all equipment and machinery.
- Lifecycle Management: Track assets from acquisition to decommissioning.
- Maintenance History: Store and analyze past maintenance records for informed decision-making.
- Inventory Control: Manage spare parts and consumables to ensure timely availability.
- Downtime Tracking: Monitor and record equipment downtime for trend analysis and root cause identification.
- Automated Scheduling: AI-driven scheduling of preventive, predictive, and condition-based maintenance.
- Resource Allocation: Assign maintenance tasks to appropriate personnel and manage workforce availability.
- Calendar & Notifications: Integrated calendar with automated alerts and notifications for upcoming maintenance activities.
- Historical Analysis: Generate reports on past downtime events to improve future scheduling and resource planning.
- Integration with Production Systems: Sync with manufacturing and operations systems to align maintenance with production cycles.
- AMC & Certification Management: Automated tracking of Annual Maintenance Contracts (AMC) and certification compliance.
- Renewal Reminders: Automated alerts for upcoming contract renewals and expirations.
- Certification Compliance: Monitor and manage industry certifications and regulatory compliance.
- MTTF & MTBF Calculation: Automated calculation of Mean Time to Failure (MTTF) and Mean Time Between Failures (MTBF) for improved reliability analysis.

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The Solution QUALITY CONTROL



Objective

- Establish stringent quality control mechanisms in production and assembly.
- Minimize defects and improve product reliability.
- Ensure compliance with industry standards and regulatory requirements.
- Implement real-time monitoring and reporting tools for quality assurance.
- Enhance efficiency through automation and predictive analytics.

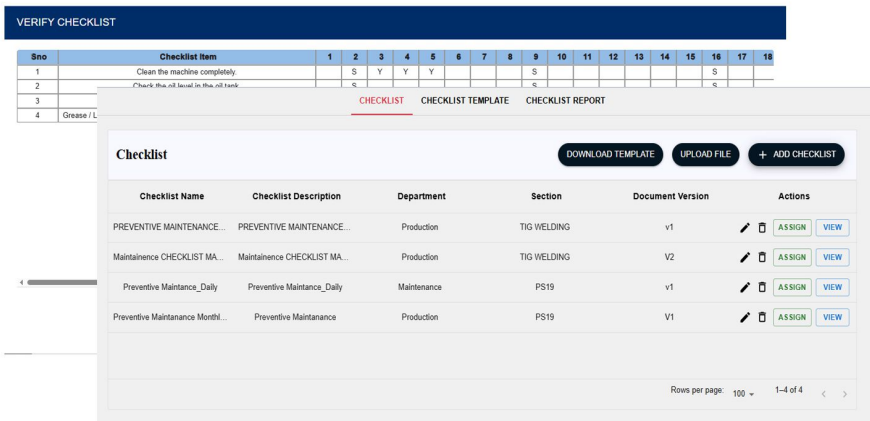
Modules

- Raw Material Inspection: Verify raw material quality before production to prevent defects at the source.
- In-Process Quality Checks: Conduct real-time quality inspections during manufacturing to detect and rectify defects.
- Defect Tracking & Analysis: Implement automated systems to track defects and identify root causes for corrective actions.
- Statistical Process Control (SPC): Utilize SPC techniques to monitor and control production quality.
- Compliance Testing: Ensure all products meet industry regulations and safety standards before dispatch.

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The Solution DIGITAL CHECKLIST

- Reduce Paperwork & Errors - Eliminate manual tracking with a digital, cloud-based platform.
- Improve Compliance & Safety - Stay on top of industry regulations with audit-ready logs.
- Enhance Productivity - Assign, monitor, and complete tasks in real-time.
- Data - Driven Decision Making - Gain valuable insights with reports and analytics.
- Work Anytime, Anywhere - Offline mode ensures uninterrupted operations.
- User - Friendly Interface - Simple, intuitive design for easy adoption.
- Role - Based Access Control - Secure access with different user permissions.
- Real - Time Progress Tracking - Monitor checklist completion instantly.
- Automated Notifications & Alerts - Never miss a deadline.
- Cloud & Mobile Integration - Access your checklists from any device.
- Audit Trail & Reports - Maintain records for compliance and transparency.
- Customizable Checklists - Adapt to any industry needs.



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Overall Impact of Digitization

- **Avoid human errors -** System driven process.
- **Commitments & SLA -** Real time delivery schedule impact notification / alerts due to various dynamics.
- **Less production lead time for order -** Maximum machine capacity utilization.
- **Right delivery commitment to the customer -** New order production delivery forecast considering shop floor current capacity.
- **Production flexibility -** Maximize the production capacity by splitting production order to smaller qty and different delivery date.
- **Connected Material -** End to End Material Traceability.
- **Connected process -** Individual part process traceability.
- **Minimize the downtime - Connected machine -** Predictive and condition based maintenance.
- **Customer satisfaction -** Timely delivery of goods and services.
- **Good quality control system -** Minimized rejection.

Performance Insights
Real - time performance monitoring

↑ Throughout	5 - 15%
↑ Yield	2 - 10%
↓ Cycle time	5 - 10%

Asset Insights
Asset monitoring & utilization

↑ OEE	5 - 10%
↓ Energy cost	2 - 8%

Workforce Insights
Connected work cell

↑ Productivity	2 - 10%
↓ Scrap	3 - 10%

Conclusion

Overall, our Shop Floor AI solution provides a powerful and effective way to optimize manufacturing operations by leveraging artificial intelligence technology. By providing real-time insights and predictive analytics, our solution enables businesses to improve their productivity, reduce costs and enhance quality control, ultimately leading to increased profitability and competitiveness.

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Sustainable Technology for Green Manufacturing

RDL

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The Summary

- Operator / Supervisor / Shopfloor In charge can update the production / process status on real time basis.
- One common portal for factory head, project contract manager, planner, designer / programmer, shopfloor in charge to monitor the status of project like in progress, delayed, on hold, assembly and testing schedule and upcoming pipelined projects.
- Production planning and control module having features to view forward machine availability for jobs. Current machine loading for projects, and projected machine utilization & availability for a given time frame. Real-time production visibility like target vs produced across shifts, hours, for smarter production planning and traceability
- Solution for project / contract / process / task scheduling and rescheduling integrated planning, heat treatment planning assembly & testing based on real-time dynamics (Machine availability, man power availability, production defect, monthly / quarterly production target, customer availability for testing and project hold by the customer).
- Connect production assets to provide unified view of production status across stations and tracking real time manufacturing KPIs.
- Schedule / Reschedule / Machine downtime alert to respective stake holder.
- Descriptive analytics with historical data to analyze trends in production.



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