Founded in 1928, Haco Etiquetas is a leading manufacturer of labels, tags, and other clothing identifiers. It creates labeling products tailored for multiple market segments and exports to over 30 countries from its six factories in Portugal and Brazil.

Scheduling as a major challenge
Haco had been using Preactor’s advanced planning and scheduling (APS) software since 1999. When the system became outdated, the company decided to upgrade to the latest version of Preactor, which had recently been added to Siemens’ Manufacturing Operations Management (MOM) portfolio. The main focus was improving scheduling for the weaving and finishing operations and the graphical manufacturing unit. Scheduling was a major challenge for Haco, as Gustavo Figueiredo, Haco’s production scheduler, says: “Before this project, the optimization of resource usage was very dependent on the ability of the scheduler to balance customer requirements, set-ups, and delivery dates. It was almost impossible to do manually, considering our volume of orders and the number of resources.”

Faster delivery with Preactor
Over six months, Siemens implemented the upgrade in partnership with NEO, a Preactor reseller. NEO added new features and improvements to suit Haco’s requirements, further refining the quality of the company’s production scheduling. The solution runs completely integrated with Wintree, a specialist enterprise resource planning (ERP) system for the textile industry. Once implemented, the new version of Preactor had an immediate impact on Haco’s scheduling. It automated and accelerated many tasks, including the creation of a scheduling analysis, using different scenarios, and the calculation of a feasible scheduling plan. Haco’s scheduler was then able to make better decisions and needed to make only minor adjustments.

The Preactor solution was designed to generate several scenarios of production. This allows the company to make better decisions, considering
level of service and maximum utilization of capacity. “Our market is very competitive and dynamic, and Preactor is a key factor in our business,” Dulce Bruns, Haco’s production scheduling manager, says. “With Preactor, our production achieved greater than 95 percent adherence of our released schedule and what were performed by the shop floor.”

Additional benefits of the upgrade include reduced set-up time, improved production performance, and more accurate delivery estimates. “With the intelligent sequencing automatically generated based on the set-up time matrices, we save up to one hour per day on each machine, an increment of 5 percent on our productivity,” Figueiredo says. “Thanks to Preactor, we can predict deliveries much faster and more accurately. We have planned continuous improvement of the current solution and its expansion to other facilities.”

**Further applications planned**
Following the successful upgrade, Haco intends to roll out Siemens’ Preactor APS across all of operations. Commenting on the company’s future plans, Luciano Mondini, Haco operations manager, says, “The goal is to connect all factories in a whole consolidated view, improving logistics processes and reducing production bottlenecks. Preactor enables us to clearly see the dynamic bottlenecks of our process and work objectively for better use of resources.”

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