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BACKGROUND:
• Warstopper material buffers are established to provide a readiness capability that would allow for an accelerated ramp up of production to support current, wartime, or other military contingency requirements.

• Prior to 2008, material buffers were only established at the point of manufacturing (tactical) but lessons learned from OEF/OIF identified the need for establishing material buffers at the sub-tier supply chain level (strategic) to provide for greater flexibility to support current, wartime, or other contingency military requirements.

DISCUSSION:
• The selection of the type buffer is dependent on how well the requirement (material specification, shape, form and size, associated risks and product forecast) is known.

<table>
<thead>
<tr>
<th>Type</th>
<th>Buffer Characteristics</th>
<th>Pros</th>
<th>Cons</th>
<th>Cons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tactical</td>
<td>• Located at a manufacturer’s site</td>
<td>• Staged and ready for specific product(s) production</td>
<td>• Less flexibility to move material</td>
<td>- Contracting actions required</td>
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<td></td>
<td>• Material is in form required for specific product(s) production</td>
<td>• Lowest possible lead-time</td>
<td>- Acceptance and liability issues</td>
<td>- Reduced product application options</td>
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<td></td>
<td>• Located in sub-tier supply chain</td>
<td>• Fastest production ramp up to meet surge demand</td>
<td>- Higher cost to establish over Strategic</td>
<td>- Higher cost to establish over Tactical</td>
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<tr>
<td></td>
<td>• Material is usually not shape, formed or sized for specific product(s)</td>
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<tr>
<td></td>
<td>• Typically, set up as a business-to-business sale and not GFM</td>
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<tr>
<td>Strategic</td>
<td>• Located in sub-tier supply chain</td>
<td>• Greater flexibility to allow for</td>
<td>• There is a longer product production ramp up because of the</td>
<td>- Use by any manufacturer</td>
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<tr>
<td></td>
<td>• Material is usually not shape, formed or sized for specific product(s)</td>
<td>- Application across a wider number of products</td>
<td>requirement to further process material into specific shapes, forms,</td>
<td>- Application across a wider number of products</td>
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<td></td>
<td>• Typically, set up as a business-to-business sale and not GFM</td>
<td>• Potentially lower cost to establish over tactical</td>
<td>size</td>
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<td>• There is a longer product production ramp up because of the requirement to further</td>
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<td></td>
<td>process material into specific shapes, forms and size</td>
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<td></td>
</tr>
</tbody>
</table>

• The two types of buffers, tactical and strategic,
  - use sales (products or material, respectively) to maintain buffer inventories
  - have the greatest Return on Investment (ROI) when the requirement materializes
  - have exit strategies to recoup some or all of the Warstopper investments

• For readiness, the best approach is the strategic buffer since wartime demand is predicated upon system employed, operating environment and operational tempo.

• The Warstopper strategic material buffer readiness measure business case has a cumulative ROI of approximately 7 to 1.

• Tactical buffers are used by the Supplier upon receipt of a surge designated delivery orders

• Strategic buffers are business-to-business, not Government Furnished Material (GFM). Access is granted based on either
  (1) When a supplier has been asked to expedite delivery on a defense contract by supplying that information and the DPAS rating; or
  (2) In rare cases where Government must approve access, the COR approves the access to the buffer