



Atlas AP Cycle Time Reduction

End-to-end DMAIC execution · 5 phases · 6 months · \$210K realized year-1

Get to the Core. Yield More.™



\$180K

annual COPQ at baseline

CHARTER + IPO

AP cycle time at 19-day median; \$180K/yr Cost of Poor Quality (late fees, missed discounts, manual rework).

CHARTER Y'S

Invoice cycle time	↓	≤ 10 d (aim 7)
First-pass 3-way match	↑	≥ 90%
Late fees avoided	↑	≥ \$6K / mo
SOX audit completeness	↑	≥ 99%

PROCESS SCOPE

Invoice Receipt > Validate & Match > Approval Routing > Payment Execution > Reconcile & Archive

\$180K / yr COPQ baseline

85%

of late invoices from top 3 causes

BASELINE + PARETO

MEDIAN	MEAN	STD DEV
19 d	22.8 d	10 d

90% of invoices above USL (> 10 days). Asymmetric defect side: virtually all on upper bound.

PARETO OF LATE-INVOICE CAUSES

Paper invoice manual processing	35%
Approval bottleneck (single approver)	28%
3-way match failure	22%
Missing PO reference	11%
Other (duplicate, currency, etc.)	4%

Top 3 causes = 85% of late invoices

5.8×

paper invoices fail 3-way match more often than EDI

ROOT CAUSES VERIFIED

THREE HYPOTHESES TESTED. ALL THREE VERIFIED.

- RC1 Paper invoice intake**
+2.8 d median vs electronic
Mann-Whitney U · p < 0.001 · n=9,612
- RC2 Single-approver bottleneck**
+3.1 d at quarter-end peak
One-way ANOVA · F=47.3 · p < 0.001
- RC3 Data-entry → match failures**
5.8× failure rate (paper vs EDI)
Pearson χ^2 · $\chi^2=312.5$ · p < 0.001

All 3 root causes statistically validated

19 → 7d

median cycle time after full rollout

SOLUTIONS + PILOT

THREE SOLUTIONS, MAPPED TO THE THREE ROOT CAUSES

- Vendor portal**
Top 75 strategic vendors → 60% of monthly volume electronic
- Tiered exception workflow**
L1 / L2 / L3 by \$ magnitude · SLA 24 / 48 / 72 hrs
- PO reference enforcement**
Required at goods receipt; auto-reject if missing

PILOT (8 WKS, 30% OF VOLUME)

	BASELINE	PILOT
Cycle time (median)	19 d	8 d
In-terms payment %	65%	86%
First-pass 3-way match	75%	94%

Full rollout: 7-day median — charter aim achieved

\$210K

year-1 realized savings (17% above baseline COPQ)

SUSTAIN + REALIZE

I-MR CHART, 25 WKS POST-ROLLOUT

YEAR-1 REALIZED SAVINGS

Late fees eliminated	\$72K
Discount capture	\$78K
Labor redeployment	\$60K
Year-1 realized	\$210K

\$210K realized · 17% above \$180K baseline COPQ

PROBLEM DEFINED

GAPS SIZED

ROOT CAUSES IDENTIFIED

PILOT PROVED

\$210K SUSTAINED

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