Contents

1 Introduction **1**
- 1.1 Product recovery management 2
- 1.2 Product recovery options 5
- 1.3 Examples of remanufacturing in practice 6
- 1.4 Problem structure and complexity 7
  - 1.4.1 Relevant processes and goods-flows 8
  - 1.4.2 Complexity of planning and control in HMR systems 9
- 1.5 Research questions 11

2 Literature review **13**
- 2.1 Periodic review models 15
- 2.2 Continuous review models 20
- 2.3 Cash balancing models 25
- 2.4 Concluding remarks 27

3 PUSH and PULL control: Mathematical modeling **29**
- 3.1 System characteristics 30
- 3.2 Strategy definitions and analysis 33
  - 3.2.1 Analysis of the PUSH strategy 35
  - 3.2.2 Analysis of the PULL strategy 45
- 3.3 Optimization with respect to control parameters 49
- 3.4 Numerical aspects and validation 50
- 3.5 Relaxation of system assumptions 50

4 PUSH and PULL control without disposal **53**
- 4.1 Modeling uncertainty in the demand and return processes . 53
- 4.2 Modeling correlation between demands and returns 56
- 4.3 Numerical study 57
  - 4.3.1 HMR systems versus traditional systems 58

4.3.2 PUSH versus PULL control 60
4.3.3 Advises to management 61
4.4 Summary and conclusions 65

5 Lead time effects **67**
5.1 System characteristics and analysis 67
5.1.1 Analysis of the PUSH strategy 69
5.1.2 Analysis of the PULL strategy 72
5.1.3 Optimization with respect to control parameters . . 72
5.2 Numerical study 73
5.2.1 The effects of lead-time duration 75
5.2.2 The effects of lead-time *variability* 78
5.2.3 Sensitivity analysis 81
5.3 Summary and conclusions 83

6 PUSH and PULL control with disposal **87**
6.1 System characteristics 88
6.2 Strategy definitions and analysis 90
6.2.1 Analysis of the PUSH-disposal strategy 93
6.2.2 Analysis of the PULL-disposal strategy 95
6.2.3 PUSH- and PULL-disposal with Coxian-2 arrivals and correlation between returns and demands 98
6.3 Numerical study 99
6.3.1 Systems *with* versus systems *without* disposals 100
6.3.2 PUSH-disposal versus PULL-disposal 102
6.3.3 Robustness of control strategies during the product life-cycle 103
6.4 Summary and conclusions 109

7 Heuristics **111**
7.1 The Muckstadt & Isaac approach 112
7.2 An alternative procedure 115
7.3 Numerical comparison 121
7.4 Summary and discussion 122

8 Case study: Volkswagen **125**
8.1 Development of the simulation model 125
8.2 Data specification 129
8.3 Data analysis 131
8.4 System behaviour during a product life-cycle 135

8.5 A simple heuristical procedure 138
8.6 Summary and conclusions 139

9 Directions for future research **141**

References **145**

Samenvatting (summary in Dutch) **153**

Curriculum Vitae **157**