

Oracle[®] Engineering User's Guide

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Oracle® Engineering User's Guide Release 11i

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Preface

Welcome to the *Oracle Engineering User's Guide, Release 11i*.

This user's guide includes the information you need to work with Oracle Engineering effectively. It contains detailed information about the following:

- Overview and reference information
- Specific tasks you can accomplish using Oracle Engineering
- Oracle Engineering setup
- Oracle Engineering functions and features
- Oracle Engineering windows
- Oracle Engineering reports and processes

This preface explains how this user's guide is organized and introduces other sources of information that can help you.

About This User's Guide

This guide contains overviews as well as task and reference information about Oracle Engineering. This guide includes the following chapters:

- Chapter 1 contains all setup information and procedures including Profile Options.
- Chapter 2 provides an overview and procedures for defining engineering change orders (ECOs).
- Chapter 3 describes how to utilize ECOs in an engineering prototype environment.
- Chapter 4 describes all Engineering reports.

Audience for This Guide

This guide assumes you have a working knowledge of your business area's processes and tools. It also assumes you are familiar with Oracle Engineering. If you have never used Oracle Engineering, we suggest you attend one or more of the Oracle Engineering training classes available through World Wide Education. For more information about Oracle Engineering and Oracle training, see: Other Information Sources.

Do Not Use Database Tools to Modify Oracle Applications Data

Because Oracle Applications tables are interrelated, any change you make using Oracle Applications can update many tables at once. But when you modify Oracle Applications data using anything other than Oracle Applications, you may change a row in one table without making corresponding changes in related tables. If your tables get out of synchronization with each other, you risk retrieving erroneous information and you risk unpredictable results throughout Oracle Applications.

When you use Oracle Applications to modify your data, Oracle Applications automatically checks that your changes are valid. Oracle Applications also keeps track of who changes information. If you enter information into database tables using database tools, you may store invalid information. You also lose the ability to track who has changed your information because SQL*Plus and other database tools do not keep a record of changes.

Consequently, we STRONGLY RECOMMEND that you never use SQL*Plus or any other tool to modify Oracle Applications data unless otherwise instructed.

Other Information Sources

Here are some other ways you can increase your knowledge and understanding of Oracle Engineering.

Online Documentation

All Oracle Applications documentation is available online on CD-ROM, except for technical reference manuals. There are two online

formats, HyperText Markup Language (HTML) and Adobe Acrobat (PDF).

All user's guides are available in HTML, PDF, and paper. Technical reference manuals are available in paper only. Other documentation is available in PDF and paper.

The *content* of the documentation does not differ from format to format. There may be slight differences due to publication standards, but such differences do not affect content. For example, page numbers and screen shots are not included in HTML.

The HTML documentation is available from all Oracle Applications windows. Each window is programmed to start your web browser and open a specific, context-sensitive section. Once any section of the HTML documentation is open, you can navigate freely throughout all Oracle Applications documentation. The HTML documentation also ships with Oracle Information Navigator (if your national language supports this tool), which enables you to search for words and phrases throughout the documentation set.

Related User's Guides

Oracle Engineering shares business and setup information with other Oracle Applications products. Therefore, you may want to refer to other user's guides when you set up and use Oracle Engineering.

If you do not have the hardcopy versions of these manuals, you can read them online using the Applications Library icon or Help menu command.

Country-Specific User's Guides

These manuals document functionality developed to meet specific legal and business requirements in more than 25 countries. You should use the appropriate user's guide, such as the Oracle Financials for Germany User's Guide, for more information about using Oracle Financials in a specific country. Consult your country-specific user's guide, Oracle Financials Regional User's Guide, and your financial product's manual to effectively use Oracle Financials in your country.

Global Accounting Engine

Use the Global Accounting Engine to replace the transfer to General Ledger and create subledger accounting entries that meet additional statutory standards within some countries. The Accounting Engine

provides subledger balances, legal reports, and bi-directional drilldown from General Ledger to the subledger transaction.

Oracle Applications User's Guide

This guide explains how to enter data, query, run reports, and navigate using the graphical user interface (GUI) available with this release of Oracle Engineering (and any other Oracle Applications products). This guide also includes information on setting user profiles, as well as running and reviewing reports and concurrent processes.

You can access this user's guide online by choosing "Getting Started with Oracle Applications" from any Oracle Applications help file.

Oracle Applications Demonstration User's Guide

This guide documents the functional storyline and product flows for Vision Enterprises, a fictional manufacturer of personal computers products and services. As well as including product overviews, the book contains detailed discussions and examples across each of the major product flows. Tables, illustrations, and charts summarize key flows and data elements.

Oracle Bills of Material User's Guide

This guide describes how to create various bills of materials to maximize efficiency, improve quality and lower cost for the most sophisticated manufacturing environments. By detailing integrated product structures and processes, flexible product and process definition, and configuration management, this guide enables you to manage product details within and across multiple manufacturing sites.

Oracle Financials Regional User's Guide

This manual describes functionality developed to meet specific legal and business requirements that are common to several countries in a given region. Consult this user's guide along with your country-specific user's guide and your financial product's manual to effectively use Oracle Financials in your country.

Oracle Flow Manufacturing User's Guide

This guide describes how to use Oracle's Flow manufacturing functionality to support the processes of flow manufacturing. It

describes design features of demand management, line design and balancing, and kanban planning. It also describes production features of line scheduling, productions and kanban execution.

Oracle Inventory User's Guide

This guide describes how to define items and item information, perform receiving and inventory transactions, maintain cost control, plan items, perform cycle counting and physical inventories, and set up Oracle Inventory.

Oracle Master Scheduling/MRP and Supply Chain Planning User's Guide

This guide describes how to anticipate and manage both supply and demand for your items. Using a variety of tools and techniques, you can create forecasts, load these forecasts into master production schedules, and plan your end-items and their component requirements. You can also execute the plan, releasing and rescheduling planning suggestions for discrete jobs and repetitive schedules.

Oracle Manufacturing Scheduling User's Guide

This guide describes how to use Oracle Manufacturing Scheduling to view and reschedule single discrete jobs or the entire shop floor. Specifically, this guide details how to easily use the drag and drop functionality to view and reschedule jobs, operations, and resources.

Oracle Order Management User's Guide

This guide describes how to enter sales orders and returns, copy existing sales orders, schedule orders, release orders, create price lists and discounts for orders, run processes and create reports.

Oracle Shop Floor Management User's Guide

This guide describes how to manage different stages of a product as it moves through the shop floor., including dynamic network routings, lot transactions, lot genealogy, co-product functionality, and costing information.

Oracle Work in Process User's Guide

This guide describes how Oracle Work in Process provides a complete production management system. Specifically this guide describes how discrete, repetitive, assemble-to-order, project, flow, and mixed manufacturing environments are supported.

Reference Manuals

Oracle Automotive Implementation Manual

This manual describes the setup and implementation of the Oracle Applications used for the Oracle Automotive solution.

Oracle Manufacturing and Distribution Open Interfaces Manual

This manual contains up-to-date information about integrating with other Oracle Manufacturing applications and with your other systems. This documentation includes open interfaces found in Oracle Manufacturing.

Oracle Applications Message Reference Manual

This manual describes all Oracle Applications messages. This manual is available in HTML format on the documentation CD-ROM for Release 11i.

Oracle Project Manufacturing Implementation Manual

This manual describes the setup steps and implementation for Oracle Project Manufacturing.

Oracle Self-Service Web Applications Implementation Manual

This manual describes the setup steps for Oracle Self-Service Web Applications and the Web Applications dictionary.

Installation and System Administration

Oracle Alert User's Guide

This guide explains how to define periodic and event alerts to monitor the status of your Oracle Applications data.

Multiple Reporting Currencies in Oracle Applications

If you use the Multiple Reporting Currencies feature to record transactions in more than one currency, use this manual before implementing Oracle Engineering. This manual details additional steps and setup considerations for implementing Oracle Engineering with this feature.

Multiple Organizations in Oracle Applications

If you use the Oracle Applications Multiple Organization Support feature to use multiple sets of books for one Oracle Engineering installation, this guide describes all you need to know about setting up and using Oracle Engineering with this feature.

Oracle Applications Implementation Wizard User's Guide

If you are implementing more than one Oracle product, you can use the Oracle Applications Implementation Wizard to coordinate your setup activities. This guide describes how to use the wizard.

Oracle Applications Developer's Guide

This guide contains the coding standards followed by the Oracle Applications development staff. It describes the Oracle Application Object Library constituents needed to implement the Oracle Applications user interface described in the *Oracle Applications User Interface Standards*. It also provides information to help you build your custom Developer/2000 forms so that they integrate with Oracle Applications.

Oracle Applications Flexfields Guide

This guide provides flexfields planning, setup and reference information for the Oracle Engineering implementation team, as well as for users responsible for the ongoing maintenance of Oracle Applications product data. This manual also provides information on creating custom reports on flexfields data.

Oracle Applications Installation Manual for Windows Clients

This guide provides information you need to successfully install Oracle Financials, Oracle Public Sector Financials, Oracle Manufacturing, or Oracle Human Resources in your specific hardware and operating system software environment.

Oracle Applications Product Update Notes

If you are upgrading your Oracle Applications, refer to the product update notes appropriate to your update and product(s) to see summaries of new features as well as changes to database objects, profile options and seed data added for each new release.

Oracle Applications Upgrade Preparation Manual

This guide explains how to prepare your Oracle Applications products for an upgrade. It also contains information on completing the upgrade procedure for each product. Refer to this manual and the *Oracle Applications Installation Manual* when you plan to upgrade your products.

Oracle Applications System Administrator's Guide

This manual provides planning and reference information for the Oracle Engineering System Administrator.

Other Sources

Training

We offer a complete set of formal training courses to help you and your staff master Oracle Engineering and reach full productivity quickly. We organize these courses into functional learning paths, so you take only those courses appropriate to your job or area of responsibility.

You have a choice of educational environments. You can attend courses offered by Oracle Education Services at any one of our many Education Centers, or you can arrange for our trainers to teach at your facility. In addition, Oracle training professionals can tailor standard courses or develop custom courses to meet your needs. For example, you may want to use your organization structure, terminology, and data as examples in a customized training session delivered at your own facility.

Support

From on-site support to central support, our team of experienced professionals provides the help and information you need to keep Oracle Engineering working for you. This team includes your Technical Representative, Account Manager, and Oracle's large staff of consultants and support specialists with expertise in your business

area, managing an Oracle8 server, and your hardware and software environment.

About Oracle

Oracle Corporation develops and markets an integrated line of software products for database management, applications development, decision support, and office automation, as well as Oracle Applications, an integrated suite of more than 45 software modules for financial management, supply chain management, manufacturing, project systems, human resources and sales and service management.

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Thank You

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Oracle Applications Documentation Manager
Oracle Corporation
500 Oracle Parkway
Redwood Shores, CA 94065
U.S.A.

Or, send electronic mail to appsdoc@us.oracle.com.

Setting Up

This chapter tells you everything you need to know about setting up Oracle Engineering.

- Defining ECO Types: page 1 – 9
- Defining ECO Autonumbering: page 1 – 11
- Defining ECO Priorities: page 1 – 14
- Defining ECO Reasons: page 1 – 16
- Defining ECO Approval Lists: page 1 – 17
- Defining Material Dispositions: page 1 – 19
- Starting the AutoImplement Manager: page 1 – 20
- Engineering Profile Options and Security Functions: page 1 – 21

Setup Overview

This section contains an overview of each task you need to complete to set up Oracle Engineering.

Before you set up Oracle Engineering, you should:

- Set up an Oracle Applications System Administrator responsibility. See: *Oracle Applications System Administrator's Guide*.

Oracle Applications Implementation Wizard

If you are implementing more than one Oracle Applications product, it is recommended that you use the Oracle Applications Implementation Wizard (AIW) to coordinate your setup activities. The Wizard guides you through the setup steps for the applications you have installed, suggesting a logical sequence that satisfies cross-product implementation dependencies and reduces redundant setup steps.

You can use the Wizard to see a graphical overview of setup steps, read online help for a setup activity, and open the appropriate setup window. You can also document your implementation, for further reference and review, by using the Wizard to record comments for each step.

See Also

Oracle Applications Implementation Wizard User's Guide

Related Product Setup Steps

The following steps may need to be performed to implement Engineering. These steps are discussed in detail in the Overview of Setting Up sections of other Oracle product user's guides.

Set up Underlying Oracle Applications Technology

The Wizard guides you through the entire Oracle Applications setup, including system administration. However, if you do not use the Implementation Wizard, you need to complete several other setup steps, including:

- Performing system-wide setup tasks such as configuring concurrent managers and printers
- Managing data security, which includes setting up responsibilities to allow access to a specific set of business data and complete a specific set of transactions, and assigning individual users to one or more of these responsibilities
- Setting up Oracle Workflow

See Also

Oracle Applications Implementation Wizard User's Guide

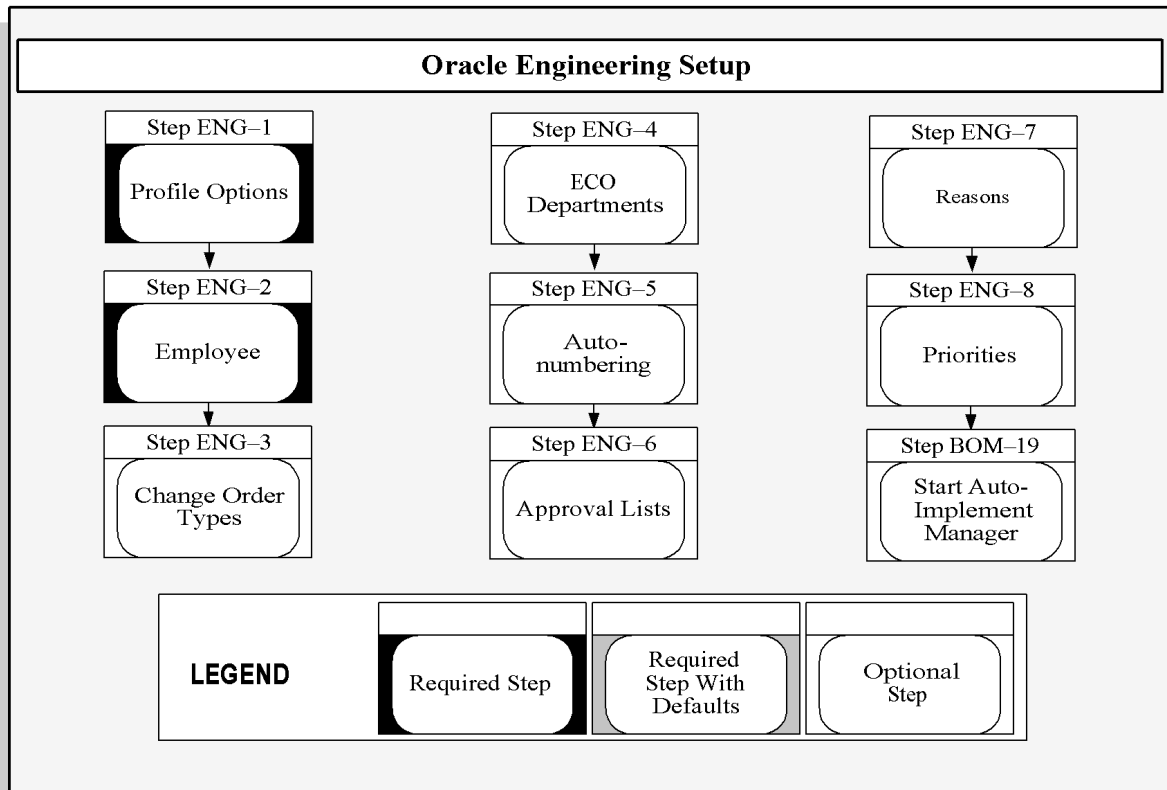
Oracle Applications System Administrator's Guide

Oracle Workflow Guide

Setup Flowchart and Checklist

Some of the steps outlined in this flowchart and setup checklist are Required and some are Optional. Required Step With Defaults refers to setup functionality that comes with pre-seeded, default values in the database; however, you should review those defaults and decide whether to change them to suit your business needs. If you want or need to change them, you should perform that setup step. You need to perform Optional steps only if you plan to use the related feature or complete certain business functions.

The diagram below is described in detail in the Setup Checklist table, and Setup Steps section that follow.



The following table lists setup steps and a reference to their location within the Wizard. For a detailed description of AIW reference levels, see the *Oracle Applications Implementation Wizard User's Guide*. After you log on to Oracle Applications, complete these steps to implement Oracle Engineering:

Step No.	Required	Step	AIW Reference
Step 1	Required	Set Profile Options	Oracle Engineering
Step 2	Required	Enter Employee	Oracle Engineering
Step 3	Optional	Define Change Order Types	Oracle Engineering
Step 4	Optional	Define ECO Departments	Oracle Engineering
Step 5	Optional	Define Autonumbering	Oracle Engineering
Step 6	Optional	Define Approval Lists	Oracle Engineering
Step 7	Optional	Define Material Dispositions	Oracle Engineering
Step 8	Optional	Define Reasons	Oracle Engineering
Step 9	Optional	Define Priorities	Oracle Engineering
Step 10	Optional	Start AutoImplement Manager	Oracle Engineering

Setup Prerequisites

Before you set up Oracle Engineering, you must complete the setup for the following:

In Oracle Inventory:

- Define items. See: *Defining Items, Oracle Inventory User's Guide*

In Oracle Bills of Material:

- See: *Setting Up, Oracle Bills of Material User's Guide*

Setup Steps

Step 1 Set Profile Options (Required)

Profile options specify how Oracle Engineering controls access to and processes data. In general, profile options can be set at one or more of the following levels: site, application, responsibility, and user.

Oracle Engineering users use the Update Personal Profile Options form to set profile options only at the user level. System administrators use the Update System Profile Options form to set profile options at the site, application, responsibility, and user levels.

Context: Perform this step once for each entity, that is, site, application, responsibility, or user..

See Also: Oracle Engineering Profile Options and Security Functions: page 1 – 21, *Applications User's Guide*

Step 2 Enter Employee (Required)

Define employees for your organization. ECO requestors and approvers must be defined as employees.

If you do not install Oracle Human Resource Management Systems with Oracle Engineering, you use the Enter Employee form to define and maintain employees in Oracle Engineering.

If you install Oracle Human Resource Management Systems, you use the forms in Oracle Human Resource Management Systems instead to enter and maintain employees.

Context: Perform this step once for each entity organization.

See Also: Defining ECO Approval Lists: page 1 – 17

Step 3 Define Change Order Types (Optional)

You can assign a change order type to your ECOs, either using the 'ECO' change order type that Oracle Engineering provides or choosing a change order type from any number of types you define using your own terminology, such as Design Revision, Manufacturing Change Order, or Substitution Waiver. You can create change order types for ECOs with manufacturing items, or manufacturing and engineering items.

Default: If you skip this step, Oracle shipped change order types will be used as the default value.

Context: Perform this step once per installation.

See Also: Defining ECO Types: page 1 – 9

Step 4 Define ECO Departments (Optional)

You can group users that use the engineering change order (ECO) system through ECO departments, creating multiple ECO departments within your Inventory organization. You can restrict access to ECOs by ECO department and require an ECO department on all ECOs—changing the responsible ECO department as the ECO moves through multiple departments.

Default: If you skip this step, *<enter value here>* will be used as the default value.

Context: Perform this step once per organization.

See Also: Defining ECO Approval Lists: page 1 – 17

Step 5 Define Autonumbering (Optional)

You can define customized autonumbering (for a user, organization, or site) for new ECOs or mass change orders. You can use the autonumber default value when you define an engineering or mass change order, or you can override the autonumber default and assign your own number.

Context: Perform this step once per organizational user.

See Also: Defining ECO Autonumbering: page 1 – 11

Step 6 Define Approval Lists (Optional)

You can define lists of approvers required to approve an ECO before it can be released. Oracle Engineering notifies the people on the list, using an alert, that the ECO requires their approval.

Context: Perform this step once per installation.

See Also: Defining ECO Approval Lists: page 1 – 17

Step 7 Define Material Dispositions (Optional)

You can define your own customized material dispositions, and then assign them to revised items when defining ECOs.

See Also: Defining Material Dispositions: page 1 – 19

Step 8 Define Reasons (Optional)

You can define reasons for engineering change orders using your own terminology, such as Model Year, Design, Safety, and Ergonomic. ECO reasons are for your reference use only.

Default: If you skip this step, Oracle shipped reasons will be used as the default value.

Context: Perform this step once per organization.

See Also: Defining ECO Reasons: page 1 – 16

Step 9 Define Priorities (Optional)

You can define scheduling priorities for engineering changes to describe the urgency of your ECO. Priorities are for your reference use only.

Default: If you skip this step Oracle shipped priorities will be used as the default value.

Context: Perform this step once per organization.

See Also: Defining ECO Priorities: page 1 – 14

Step 10 Start AutoImplement Manager (Optional)

If you automatically implement ECOs, you must specify the frequency that you want the AutoImplement manager to run. Once an ECO has been released to the autoimplement manager, you can automatically implement all scheduled ECO revised items whose effective date is less than or equal to the current date.

Context: Perform this step once per organization.

See Also: Starting the AutoImplement Manager: page 1 – 20

Defining ECO Types

Engineering change order (ECO) types help classify engineering and mass change orders to items and bills of material, and determine whether such orders apply to engineering in addition to manufacturing.

An ECO type can be associated with an Oracle Workflow process. If so, a priority can optionally be associated with the ECO type.

If you define an ECO using a type and priority combination (even if the priority is blank) that is associated with a workflow process, Workflow will control the ECO approval process. If the type and priority combination is *not* associated with a workflow process, the ECO approval status defaults to Approved.

► **To define an ECO type:**

1. Navigate to the Change Types window.

Type	Engineering Also	Description	Inactive On
Document	<input type="checkbox"/>	Documentation Only Change	
Eng Proto	<input checked="" type="checkbox"/>	Engineering prototype	
New Prod	<input checked="" type="checkbox"/>	New Product	
Prod Chg	<input type="checkbox"/>	Product Change	
	<input type="checkbox"/>		
	<input type="checkbox"/>		
	<input type="checkbox"/>		
	<input type="checkbox"/>		
	<input type="checkbox"/>		
	<input type="checkbox"/>		
	<input type="checkbox"/>		

Processes

2. Enter alphanumeric text for a unique change order type.

3. Indicate whether the change order type can revise both engineering and manufacturing items and bills.

ECOs with an engineering change type can include both engineering and manufacturing items; ECOs with a manufacturing change type *cannot* include engineering items.

If an ECO with a status of Open, Hold, Release, or Schedule is using this ECO type, this value cannot be updated.

4. Optionally, enter a description for the change order type.
5. Enter a date to inactivate the change order type. As of this date, you can no longer assign this change order type to a change order.
6. To associate this ECO type with a Workflow process, choose the Processes button.

If you do not associate this ECO type with a Workflow process, any ECO using this type will default to Approved.

► **To associate an ECO type with a Workflow process:**

1. Navigate to the Change Type Processes window. Do this by choosing the Processes button from the Change Types window.
2. Optionally, select an ECO priority.

Note: ECO types are not organization-specific. However, ECO priorities are organization-specific. This ECO type-priority combination will only be available in the current organization.

3. Select a workflow process to associate with this ECO type.

Whenever this type and priority combination (even if priority is blank) is used for an ECO, Workflow will control the ECO approval process.

See Also

Overview of Engineering Change Orders: page 2 – 2

Engineering Change Order Types Report: page 4 – 10

Workflow for ECO Approvals: page 2 – 12

Defining ECO Priorities: page 1 – 14

Defining ECO Autonumbering

You can define and update customized autonumbering to use as defaults when creating new engineering change orders (ECOs) and mass change orders.

Define autonumbering for a particular user in an organization, a user across all organizations, all users in one organization, or all users across all organizations.

When you first define an ECO, Engineering uses the following hierarchy to determine the prefix to use for autonumbering:

- specific prefix for you and your current organization
- specific prefix for you across all organizations
- specific prefix for all users for your current organization
- specific prefix for all users across all organizations

For example, if a prefix is set up for you and the current organization, it supersedes a prefix defined for you across all organizations.

When defining an ECO, you can either accept a default ECO number or manually enter one. Engineering displays the prefix along with the next available number. If Engineering does not find an autonumbering prefix, you must assign an ECO number manually.



Attention: When creating an ECO, once a default ECO autnumber displays, Engineering considers that number used—even if you do not save your changes and create the ECO using that number. For example, if you begin to define an ECO called ABC234, and then decide to abandon your changes, Engineering presents the next ECO number as ABC235. You can manually change this number.

Prerequisites

- Set the ENG: Change Order Autonumbering—System Administrator profile option to Yes to define ECO autonumbering for all users. Set this to No to define it only for yourself. See: Engineering Profile Options and Security Functions: page 1 – 21.

3. Enter a specific organization to define autonumbering for a particular organization, or select the All Other Organizations record to define autonumbering for all other organizations.



Attention: The information you provide in the Organizations region is associated with the specific user or the All Other Users record in the Users region.

4. Enter a prefix to use as the first characters for each defaulted ECO identifier for the specific user or All Other Users, whichever is currently selected.

You can define only one prefix per user per organization. You can define only one prefix per user across all other organizations.

5. Enter a Next Number to use as the of the base of the numeric portion of ECO autonumbering.

The combined prefix and next number—the autonumber—is incremented when each ECO is created. For example, if you enter 100 and your prefix is ABC, the first ECO number is ABC100. The next will then be ABC101.

Each new ECO number is defaulted to one integer plus the last used ECO number. When defining a new ECO, you can override this with a higher value. The next ECO number will then be one integer greater. For example, assuming ABC as the prefix and no ECOs defined using ABC, ABC1 is the default. If you have defined an ECO called ABC234, ABC235 is the default.

You cannot enter a prefix and next number that, when used together, exceeds ten alphanumeric characters.

See Also

Engineering Change Orders: page 2 – 2

Creating an ECO: page 2 – 24

Defining ECO Priorities

Engineering change priorities let you specify the urgency of the engineering change order. You can define a priority, enter a description, and enter a priority level between zero and nine.

Note: ECO priorities can be specified when associating ECO types with Oracle Workflow processes, which are used for ECO approvals.

- ▶ **To define an ECO priority:**
 1. Navigate to the ECO Priorities window.



The screenshot shows a window titled "ECO Priorities (M1)" with a table. The table has four columns: "Priority", "Priority Sequence", "Description", and "Inactive On". The "Priority" column has a small icon to its left. The "Description" column is the widest. The "Inactive On" column has a small icon to its right. The table is currently empty, with only the header row visible. The window has a standard Oracle interface with a title bar and navigation icons.

Priority	Priority Sequence	Description	Inactive On

2. Enter alphanumeric text to describe a unique priority for an ECO. For example, you could enter 1 to indicate an important priority.
3. Enter a priority sequence. This is a number between 0 and 9. For example, you can use 0 to denote the highest priority and 9 the lowest.
4. Enter a description for the priority.

5. Optionally, enter a date on which the priority becomes inactive. As of this date, you can no longer assign the priority to an ECO.

See Also

Defining ECO Types: page 1 – 9

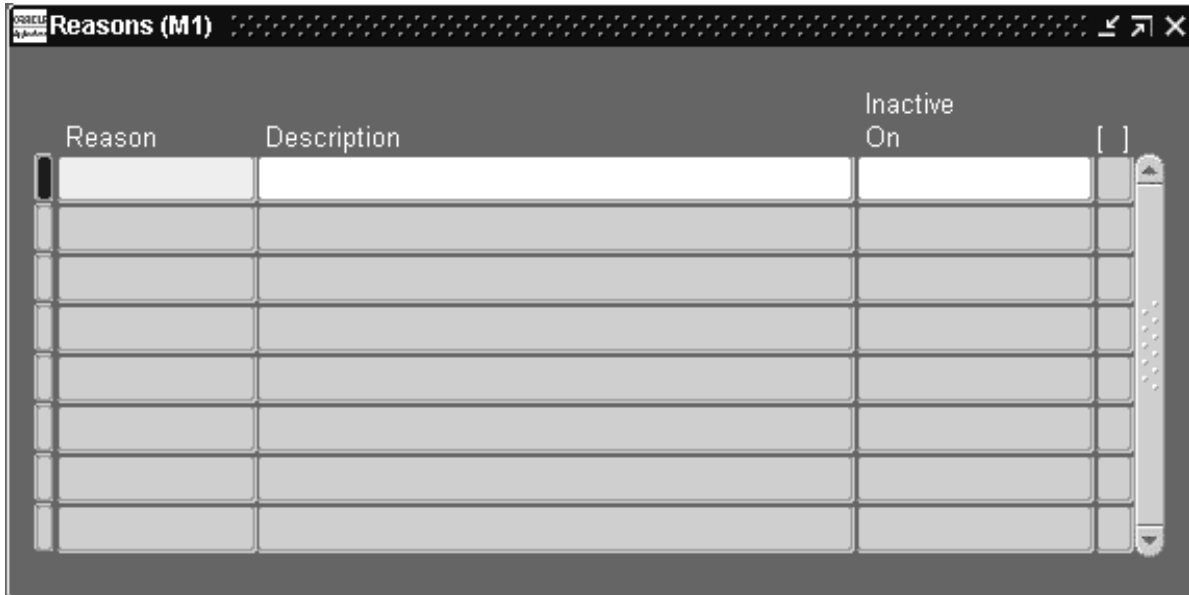
Engineering Change Order Priorities Report: page 4 – 5

Defining ECO Reasons

Use engineering change reasons to categorize and identify causes for ECOs. Engineering uses ECO reasons for reference only.

► **To define an ECO reason:**

1. Navigate to the ECO Reasons window.



The screenshot shows a window titled "Reasons (M1)" with a table. The table has three columns: "Reason", "Description", and "Inactive On". The first row is highlighted in white, while the other rows are grey. The "Inactive On" column has a date picker icon. The table is currently empty.

Reason	Description	Inactive On

2. Enter alphanumeric text to describe a unique reason for initiating an engineering change. For example, you could define a reason OBSOLETE to indicate an obsolete part, or WAIVER to indicate a component change on a bill of material.
3. Enter a description of the ECO reason.
4. Enter a date on which the reason becomes inactive. As of this date, you can no longer assign the reason to an ECO.

See Also

Engineering Change Order Reasons: page 4 – 6

Defining ECO Approval Lists

Engineering lets you define lists of approvers for ECOs. Each approval list can be used as a role by Oracle Workflow.

One workflow process, named “Standard Approval Process,” is installed with Engineering.

► **To define an ECO approval list:**

1. Navigate to the Approval Lists window.

The screenshot shows the 'Approval Lists' window. At the top, there are three input fields: 'List', 'Description', and 'Inactive On'. Below these is a section titled 'Approvers' which contains a table with four columns: 'Seq', 'Employee', 'Description', and 'Inactive On'. The table has several empty rows for data entry.

2. Enter the approval list name, a description, and, optionally, a date on which you can no longer assign the approval list to an ECO.
3. Enter a sequence for the approver. This number indicates the sequence of the approver for the ECO. Engineering uses this for information purposes only.
4. Enter an employee name for the approver.

5. Enter a date for this approver on this approval list. As of this date, the approver is no longer notified when an ECO requires their approval.

See Also

ECO Approval Statuses: page 2 – 72

Workflow for ECO Approvals: page 2 – 12

Roles Window, *Oracle Workflow Guide*

Viewing ECO Approval Status: page 2 – 27

Engineering Change Order Approval Lists Report: page 4 – 2

Defining Material Dispositions

Engineering enables you to define customized material dispositions. You can then assign them to revised items when defining an ECO.

► **To define a material disposition:**

1. Navigate to the Material Dispositions lookups form and define your material disposition.

Code	Meaning	Description	Tag	From	To	Enabled
1	No change required					<input checked="" type="checkbox"/>
10	Exhaust on serial nu					<input checked="" type="checkbox"/>
11	test disposition looku	test disposition lookup		01-FEB-2002		<input checked="" type="checkbox"/>
2	Scrap WIP and inven					<input checked="" type="checkbox"/>
3	Scrap only inventory					<input checked="" type="checkbox"/>
4	Scrap only WIP					<input checked="" type="checkbox"/>
5	Rework inventory an					<input checked="" type="checkbox"/>
6	Rework only invento					<input checked="" type="checkbox"/>
7	Rework only WIP					<input checked="" type="checkbox"/>
8	Exhaust WIP and inv					<input checked="" type="checkbox"/>

2. Enter a new code and description for your material disposition.
3. Save your work.
4. Navigate to the Revised Items window and assign your material disposition to revised items.

See Also

Defining ECO Revised Items: page 2 – 32

Starting the AutoImplement Manager

The AutoImplement Manager runs at the specified dates and times and automatically implements items whose schedule dates occur on or before the current date. Engineering change orders or revised items whose status is Scheduled are automatically implemented.

► **To start the AutoImplement Manager:**

1. Navigate to the Start AutoImplement Manager window. See: Submitting a Request, *Oracle Applications User's Guide*.
2. Enter or select the Automatic Engineering Change Order Implementation program.
3. Enter the dates and times when to run the ECO auto implement process.

See Also

Changing the ECO Status: page 2 – 30

Engineering Profile Options and Security Functions

During implementation, the system administrator sets up and maintains security functions and profile options.

Security Functions

Engineering Change Orders: Approvals (ENG_ENGFDECN_APPROVAL)

Determines whether an Engineering Change Order (ECO) approval Workflow process can be submitted or aborted.

Engineering Change Orders: Cancel (ENG_ENGFDECN_CANCEL)

Determines whether ECOs can be cancelled.

Engineering Change Orders: Implement (ENG_ENGFDECN_IMPLEMENT)

Determines whether ECOs can be implemented.

Engineering Change Orders: Release (ENG_ENGFDECN_RELEASE)

Determines whether ECOs can be released.

Engineering Change Orders: Reschedule (ENG_ENGFDECN_RESCHEDULE)

Determines whether ECOs can be rescheduled.

Engineering Change Orders: Schedule (ENG_ENGFDECN_SCHEDULE)

Determines whether ECOs can be scheduled.

Engineering Change Orders: Update (ENG_ENGFDECN_UPDATE)

Determines whether ECOs can be updated.

Engineering Items: Delete (ENG_INVIDITM_DELETE)

Determines whether engineering items can be deleted from the Bills of Material or Routings windows.

Engineering Items: Revisions (ENG_INVIDITM_REVISIONS)

Determines whether revisions for engineering items can be updated.

Engineering Items: Transfer (ENG_INVIDITM_TRANSFER)

Determines whether engineering items can be transferred to manufacturing.

Profile Option Settings

You can set or view the following profile options in Oracle Order Entry/Shipping. The following table includes some profile options from other applications that are used by Engineering.

Profile Option Settings

Profile Option	User	User	Resp	App	Site	Required?	Default Value
ENG: Change Order Autonumbering – System Administrator Access	–	✓	✓	✓	✓	Required	No
ENG: ECO Department	–	✓	✓	✓	✓	Optional	No
ENG: ECO Revision Warning	–	0	0	0	✓	Optional	No
ENG: Engineering Item Change Order Access	–	✓	✓	✓	✓	Optional	Yes
ENG: Mandatory ECO Departments	–	0	0	0	✓	Optional	No
ENG: Model Item Change Order Access	–	✓	✓	✓	✓	Optional	Yes
ENG: Planning Item Change Order Access	–	✓	✓	✓	✓	Optional	No
ENG: Require Revised Item New Revision	–	0	0	✓	✓	Optional	No
ENG: Standard Item Change Order Access	–	✓	✓	✓	✓	Optional	Yes
ENG: Allow Eng Comps for MFG Items in ECO	–	–	0	✓	✓	Optional	Yes
ENG: MRP Active Flag default for ECO	–	–	0	✓	✓	Optional	Yes
ENG: Update Unreleased WIP Jobs	✓	✓	✓	✓	✓	Optional	Yes

✓	You can update the profile option.
-	You can view the profile option value but you cannot change it.
0	You cannot view or change the profile option value.

Profile Options

ENG: Change Order Autonumbering – System Administrator Access

Indicate whether you can define ECO autonumbering for all users or for yourself only.

ENG: ECO Department

Indicate the default department Engineering uses when you define an ECO. An ECO department is the department currently responsible for an ECO. It restricts departments from updating ECOs for which they are not responsible.

ENG: ECO Revision Warning

Indicate whether to raise a warning but still implement ECO revisions with pending lower level revisions (Yes), or to raise an error and not perform the implementation (No or blank). A blank (or “null”) value is equivalent to No.

ENG: Engineering Item Change Order Access

Indicate whether you can revise engineering items on ECOs.

ENG: Mandatory ECO Departments

Indicate whether it is mandatory to assign a department to each ECO so you can enforce a security policy.

ENG: Model Item Change Order Access

Indicate whether you can revise model and option class items on ECOs.

ENG: Planning Item Change Order Access

Indicate whether you can revise planning items on ECOs.

ENG: Require Revised Item New Revision

Indicate whether it is mandatory to assign a new revision to revised items on ECOs. A blank (or “null”) value is equivalent to No.

ENG:Standard Item Change Order Access

Indicate whether you can revise standard items on ECOs.

ENG:Allow ENG COMPS for MFG Items in ECO

Indicate whether you can allow engineering components for MFG revised items in ECO.

ENG:MRP Active flag default for ECO

Indicate the default active flag for ECO revised items.

ENG:Update Unreleased WIP Jobs

Indicate if you can update unreleased WIP jobs.

See Also

Overview of Function Security, *Oracle Applications System Administrator's Guide*

Implementing Function Security, *Oracle Applications System Administrator's Guide*

Setting Your Personal User Profile, *Oracle Applications User's Guide*

Common User Profile Options, *Oracle Applications User's Guide*

Profile Options in Oracle Application Object Library, *Oracle Applications User's Guide*

Engineering Change Orders

This chapter tells you everything you need to know to use engineering change orders, including:

- Overview of Engineering Change Orders: page 2 – 2
- Defining Engineering Change Orders: page 2 – 23
- Transfer Engineering Items to Manufacturing page 2 – 50
- Copy Engineering Items to Manufacturing page 2 – 52
- Mass Changing ECOs: page 2 – 56
- Implementing ECOs: page 2 – 57
- Cancelling ECOs and Revised Items: page 2 – 60
- Viewing ECO Schedules: page 2 – 62
- Use-up ECOs: page 2 – 63
- Unreleased Item Revisions in Oracle Work in Process: page 2 – 65
- Purging ECOs: page 2 – 70
- Engineering Change Orders Field Reference: page 2 – 71

Overview of Engineering Change Orders

Engineering Change Orders (ECOs) enable you to control new item revisions and bill of material changes. With one ECO, you can group several bill of material changes that affect one or more bills.

You can define ECOs for all types of items and bills, including:

- manufacturing and engineering items
- bills and their components
- planning, model, option class, and standard items
- primary and alternate bills of material

An ECO specifies changes to one or more items that are logically related to each other, such as a new product introduction. Each ECO specifies changes for one or more revised items and each revised item can have one or more revised components.

Depending on the ECO type, an ECO can update manufacturing bills only or both manufacturing and engineering bills.

You can add either engineering or manufacturing items as components on engineering bills. However, you can only add manufacturing items as components on manufacturing bills.

You can create ECOs for routings. This is the process of revising engineering and manufacturing routings with change orders for both flow and non-flow environments.

You can transfer or copy engineering items, bills, and routing to manufacturing as part of an ECO.

Revised Items

Revised items can be either items or bills. If a revised item is a bill, you can change the item revision and component information (revised components). If a revised item defines a new bill, you can create revised components by copying an existing bill.

Engineering changes can be defined by date and or model/unit number effectivity. You should assign an effective date and model / unit number for each revised item on an ECO. Engineering uses this information to implement the ECO and to identify past due ECOs. Each time you change a revised item's effective date, Engineering adds an entry to list effective date changes. You can also specify an early effective date that determines the earliest date that you can manually implement a change. If you do not enter an early effective date, you

can manually implement the change at any time. You can reschedule an ECO by entering a new effective date. A date effective revised item can only have date effective revised components.

A unit effective revised item can have both unit and/or date effective components. All unit effective revised items must have a from end item unit number specified, if the effectivity profile is set to Unit effectivity. The from end item unit number will be null and non-updatable for date effective revised items. The to end item unit number field will also be null and non-updatable for revised components of date effective revised items. If you are implementing a ECO for a unit effective component, the from unit number needs to be specified in the revised item block and the to unit number needs to be specified in the revised components block.

Note: There are two conditions under which revised items are not implemented: if the early effective date is greater than the current date, and if the user does not have access to the item type of the revised item. For example, if the revised item is a model item and the user does not have access to model items, the revised item is not implemented. The same is true for option class, planning, and standard items.

You can control whether Oracle Master Scheduling/MRP plans your proposed changes before implementation. If you have engineering changes that are firm, but whose effective date is in the future, you may want planning to consider those changes. You can choose to plan changes on any pending ECO regardless of the ECO status. Changes to the ECO status or the revised item status will automatically update the MRP active attribute. However, you can always manually set the MRP active attribute as desired.

For each revised item, you can also specify whether Engineering should update work in process material requirements. When you implement such an ECO revised item, Engineering automatically re-explodes and updates the bill of material for all unreleased jobs and repetitive schedules for that item.

Engineering also updates repetitive schedules with statuses of Released, Complete, or On hold accordingly.

Revised Components

You can add, change, or delete bill of material components and their attributes. The components and their attributes have the same restrictions as when you define a bill using Oracle Bills of Material. For

example, you can only add components that are standard, model, or option class items for revised items that are model items.

Revised Operations

You can define an ECO for Operations. You can add, disable, and change Department information, Effective dates, Minimum Transfer quantities, and many other attributes.

Revised Resources

You can define an ECO for Resources. You can add, change, and disable resource information.

Revisions

When you enter a revised item on an ECO, Engineering displays the current and latest revision of the item. The latest revision could be higher than the current revision if the latest revision is on a pending ECO.

Engineering uses the ENG: Require Revised Item New Revision to control new item revisions for each engineering change. If engineering changes always correspond to new item revisions, set this profile option to Yes. Doing so will force a new item revision for all revised items on an ECO. When you require new item revisions, you can track all engineering changes to an item by revision. For example, you can group related design changes on an ECO and roll revisions for each item to reflect the latest design.

If you define related ECOs at different times, set this profile option to No so you increment the revision only once. You can then define one ECO to change the revised item revision and other ECOs that do not change the item revision. Minor changes that do not affect form, fit, or function of an item may not require new revisions.

Transfer and Copy to Manufacturing

You can transfer or copy entities to manufacturing. Transfer and copy transactions must proceed through the required approval cycles before they are implemented. The system captures all transfer and copy transactions for future reference.

See Also

Implementation of ECOs on Jobs and Schedules: page 2 – 65

Bill / Component Validation Rules, *Oracle Bills of Material User's Guide*

Item and Routing Revisions, *Oracle Bills of Material User's Guide*

ECO Revised Item Statuses: page 2 – 71

Copy Engineering Items to Manufacturing page 2 – 52

Transfer Engineering Items to Manufacturing page 2 – 50

ECO Access Control

Oracle Engineering controls the access to ECOs and the changes you can specify on them using profile options, security functions, item types, ECO types, and ECO departments.

ECO Types

For each ECO type, you specify if it can update engineering items. Only users whose profile option indicates they can update engineering items can choose ECO types that update engineering items.

Item Types

Oracle Bills of Material and Engineering use two item master attributes to control access to items and to determine the types of items that can be on a bill: BOM Item Type and Engineering Item.

The BOM Item Type item master field divides items into four major types: planning items, model items, option class items, and standard items.

User Profile Options

User profile options control the types of items you can revise on an ECO. You can specify whether a user or responsibility can revise model and option class items, planning items, standard items, or engineering items on ECOs.

Engineering uses the following four profile options to control the types of items you can change on an ECO:

- ENG: Engineering Item Change Order Access (engineering items)
- ENG: Model Item Change Order Access (model and option class items)
- ENG: Planning Item Change Order Access (planning items)
- ENG: Standard Item Change Order Access (standard items)

Engineering enforces security for engineering items by only letting users that are allowed to update engineering items choose ECO types that update engineering items. In addition, to update engineering bills of material for manufacturing items, you must choose ECO types that update engineering items.

Each time you try to add a revised item to an ECO, Engineering checks to see if you can update that item based on its BOM Item Type and your profile options.

For example, you might define several ECO types that can update manufacturing items, and only define one type that can update engineering items.

You might also specify profile options to control access to BOM item types by user, as shown in the following table:

User Profile Options

User	ECO Department	Standard Item Access	Planning Item Access	Model / Option Class Item Access	Engineering Item Access
Joe	Product Engineering	Yes	No	No	Yes
Mary	Mfg. Engineering	Yes	No	Yes	No
Fred	Customer Service	No	No	Yes	No
Sue	Material Planning	No	Yes	No	No
Dave	Production	Yes	No	Yes	No

In the example, Joe can create ECOs that update standard items. Mary can create ECOs that update manufacturing standard items and model / option class items. But Mary is not allowed to update engineering items.

Profile Settings for Changing Bills Only With ECOs

To limit user's access to bills of material only through ECOs, set the following Bills of Material profile options to No:

- BOM: Standard Item Access
- BOM: Planning Item Access
- BOM: Model Item Access

And the following Engineering profile options to Yes:

- ENG: Standard Item Change Order Access
- ENG: Planning Item Change Order Access
- ENG: Model Item Change Order Access
- ENG: Engineering Item Change Order Access.

Profile Settings for Changing Bills With or Without ECOs

With the same seven profile options listed above all set to Yes, bills can be changed with or without ECOs.

ECO Departments

You can assign users to departments and secure each ECO to a department so that only users in that department can access the ECO. If you do not specify a department for an ECO, any user can access it. If you do not assign a user to a department, they can access all ECOs. Setting the ENG: Mandatory ECO Departments to Yes requires you to specify a responsible department on every ECO.

You can update the responsible department as you release an ECO from the current ECO department. For example, if Product Engineering releases an ECO to Manufacturing Engineering, they can reassign the responsible department so it becomes visible and updatable to users assigned to the Manufacturing Engineering ECO department.

See Also

Engineering Profile Options and Security Functions: page 1 – 21

Oracle Bills of Material Profile Options, *Oracle Bills of Material User's Guide*

Defining ECO Types: page 1 – 9

Access Control by Item Type, *Oracle Bills of Material User's Guide*

Overview of Engineering Prototype Environment: page 3 – 2

ECO Life Cycle

Engineering uses two ECO status fields to control the ECO life cycle: ECO Status and ECO Approval Status. See: ECO Statuses: page 2 – 71.

You can change an ECO's status. You can open, hold, release, schedule, implement, or cancel a revised item or an ECO. Engineering does not let you set the ECO Status field to Implemented or Scheduled if the approval status has not been set to Approved.

The following table illustrates a typical ECO life cycle:

ECO Status Flow

Sequence	Action	Approval Status	ECO Department
Start creating new ECO	Hold	Not Submitted for Approval	Mfg. Engineering
Complete data entry	Open	Not Submitted for Approval	Mfg. Engineering
Submit approval process	n/a	Approval Requested	Mfg. Engineering
Oracle Workflow controls approval process	n/a	Approval Requested	Mfg. Engineering
Approve and release	Released	Approved	Production
Production updates date	Scheduled	n/a	Production
Effective date arrives	Implemented	n/a	Production

See Also

Creating an ECO: page 2 – 24

Viewing ECO Approval Status: page 2 – 27

Implementing ECOs: page 2 – 57

ECO Approvals

ECOs can be approved in three ways, two of which require an approval process. The third requires no approval process.

First, the ECO, based on the ECO type in combination with the ECO priority, can be associated with an Oracle Workflow process. Once approval is granted, Workflow automatically updates the approval status.

Second, a simple approval list can be used, which sends an Oracle Alert to all those listed requesting their approval. Once approved, you must manually update the approval status. This approval option does not require an Oracle Workflow process.

The third method is to use neither of the above; the ECO needs no formal approval process and is given the status of Approved.

If the ECO is associated with an Oracle Workflow process, only Workflow may set the status to Approved. If the ECO has an approval list, you must set the status to Approved manually after the ECO has been approved by the appropriate member(s) on the approval list.

If neither is used, the ECO is set to Approved but can be manually rejected.

The following table describes the conditions under which the different approval statuses can be used:

Approval Status Conditions

Condition	Valid Approval Statuses
No approval list / no workflow approval process	Approved (default), Rejected
Approval list	Not Submitted for Approval (default), Ready to Approve (Oracle Alert fires), Approval Requested, Rejected, Approved
Workflow approval process	Not Submitted for Approval, Approval Requested, Rejected, Approved, Processing Error

See Also

Workflow for ECO Approvals: page 2 – 12

ECO Approval Statuses: page 2 – 72

Transfer or Copy from within an ECO

You can transfer or copy engineering items, bills and routing to manufacturing from an ECO. When you transfer or copy an item, a bill or a routing to manufacturing, it passes through the necessary approval cycles and is implemented like other revised item changes. You can perform transfer or copy on only approved ECOs.

You can schedule transfer or copy transactions the same way you schedule revised items on an ECO. When the schedule date arrives, the times, bills and routings are automatically transferred or copied to manufacturing.

When transfer or copy of items is done through an ECO, the system captures the transaction history for future reference. It also give you the flexibility of creating all transactions when identified, and you may implement them at a later date.

See Also

Transfer Items to Manufacturing from an ECO: page 2 – 50

Copy Items to Manufacturing from an ECO: page2 – 52

Transferring or Copying Engineering Items, Bills, and Routings: page
3 – 8

Copying Bill and Routing Information, *Oracle Bills of Material User's
Guide*

Workflow for ECO Approvals

Most organizations have some form of approval process before engineering change orders (ECOs) are implemented. By using Oracle Workflow, the approval process can be customized to meet each organization's needs.

Business rules for the approval of ECOs are defined in a workflow process. For each ECO, Workflow manages adherence to these business rules, including:

- submission of the completed ECO for approval via Workflow
- enforced approval process for an ECO type
- communication of messages via Notification Viewer, electronic mail, or web browser
- review of ECO from Notification Viewer
- automatic processing of user responses and update of system
- workflow status indicator for ECOs
- usage of current approval lists (roles) in the workflow process.

Once the ECO is created, Workflow takes over processing.

When Workflow is in control of the approval process, the ECO approval status is set to Approval Requested. Before the approval status is changed, the workflow approval process can be aborted.

Workflow manages the approval process until the entire approval flow is complete. Only then is the ECO approval status updated to either Approved or Rejected. If an error occurs during the Workflow approval process, the approval status is set to Processing Error.

Standard Workflow Process

One workflow process, named "Standard Approval Process," is predefined when Engineering is installed, regardless whether the entire Oracle Workflow product is installed. If the entire Workflow product is installed, you can modify this process or create new processes.

If you use the Standard Workflow Process, you must assign a role to the "Standard Approval Notification" activity. Otherwise, the process will fail.

If the Workflow product is not fully installed, you can alter only the Standard Approval Process.

ECO Approval List Setup

Workflow can use roles whenever an activity involves several users. Approval lists defined in Engineering can be used to create roles. Roles are made up of either one approval list or one employee previously defined with the Enter Person window.

The ECO workflow approval process will notify all persons in the role, regardless if the role is defined using an approval list or an individual employee.

To approve (or reject) the ECO, approvers must respond to the notification. If the approver has an Oracle Applications Object Library account, they can respond to ECO approval requests using either a web browser or the Notification Viewer. If not, the approver can respond via electronic mail, provided their address is defined in the Enter Person window.

ECO Types and Priorities Setup

ECO types can be associated with a workflow process. If you do not associate an ECO type with a workflow process, there can be no workflow approval process for ECOs using that ECO type. If there is an approval list, the ECO cannot be associated with a process.

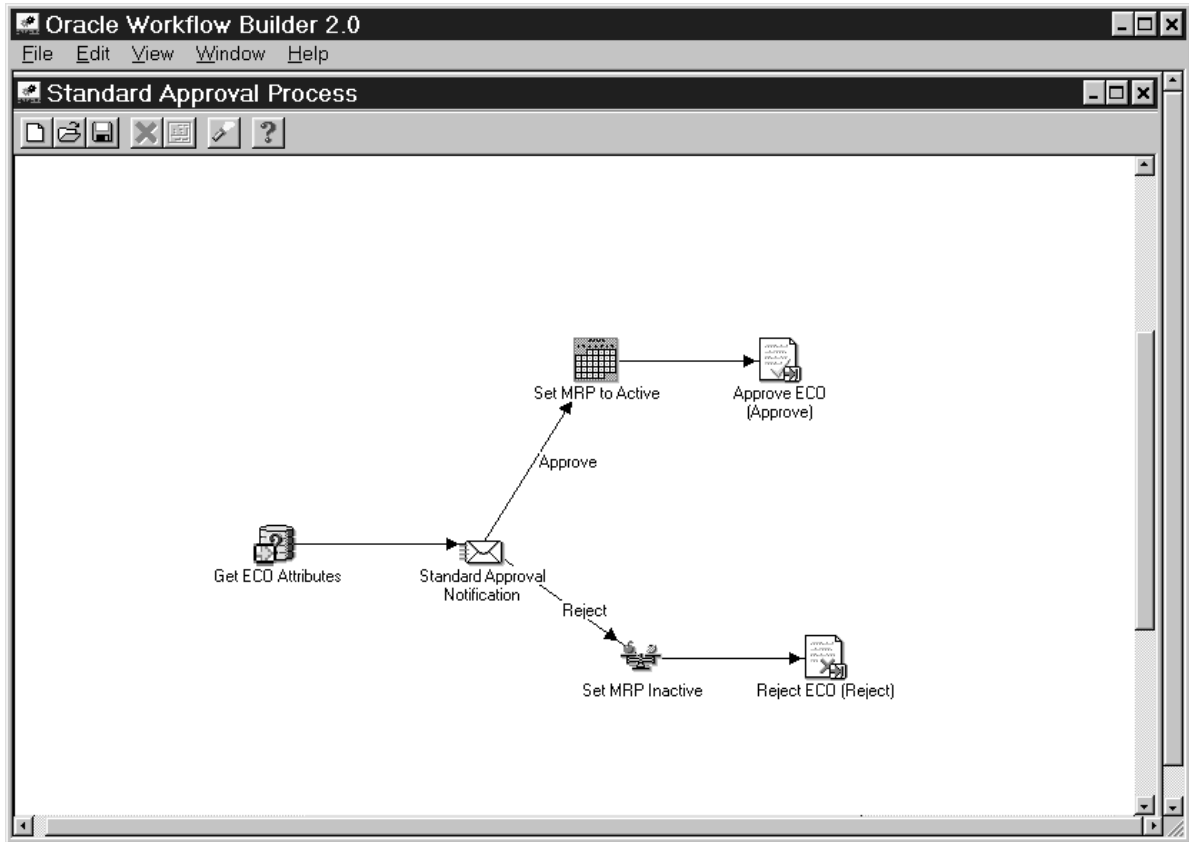
ECO types that are associated with a workflow process can optionally be associated with an ECO priority. If so, ECOs that use the type/priority combination are approved via Workflow. Doing so enables workflow approval processes to be ranked according to priority.

ECO Approval

The only user intervention required for a workflow approval process is for individual approvers to respond to an ECO approval notification. Once the process is complete, Workflow automatically updates the ECO approval status.

Customizing the Standard Approval Process

Once you install Oracle Engineering, you can view the Standard Approval Process in a Process window using Oracle Workflow Builder.



► **To Display the Standard Approval Process in Oracle Workflow Builder**

1. Choose Open from the File menu, and connect to the database where you installed Oracle Engineering.
2. Select the ECO Approval item type.
3. Expand the data source, then the ECO Approval item type branch within that data source.
4. Expand the Processes branch within ECO Approval then double-click on the Standard Approval Process activity to display the diagram of the process in a Process window.

Required Modifications

You must make the following modifications to the Standard Approval Process before you can use it to initiate a workflow:

1. Specify an Approval for the ECO Approval Process

- Choose Load Roles From the Database from the File menu. Select the role you wish to use for an approval.

Note: A role can represent a person or a group of persons. You must have already defined approvers and/or approval lists in Oracle Engineering.

- Select the Standard Approval Notification activity to view its properties.
- Enter Constant as the Performer Type. Select a Performer from the adjacent list of values.
- Select OK to save your changes.

Optional Modifications

Although you can use the Standard Approval Process as is, you may wish to customize the process further to accommodate your organization's specific needs.

Creating a New Custom Process

You can use the Standard Approval Process for your ECO approvals or create you own approval process using Oracle Workflow. You must have the Oracle Workflow product installed to create your own approval process.

See Also

Oracle Workflow, *Oracle Workflow Guide*

Introduction to Oracle Workflow, *Oracle Workflow Guide*

ECO Approval Process Activities: page 2 – 18

Defining ECO Types: page 1 – 9

Defining ECO Approval Lists: page 1 – 17

Creating an ECO: page 2 – 24

Viewing ECO Approval Status: page 2 – 27

The ECO Approval Item Type

The ECO Approval process is associated with an item type called ECO Approval. This item type represents the domain of all processes and activities used in the ECO Approval process and used by Oracle Engineering.

The following table presents ECO approval item type attributes:

ECO Approval Item Type Attributes

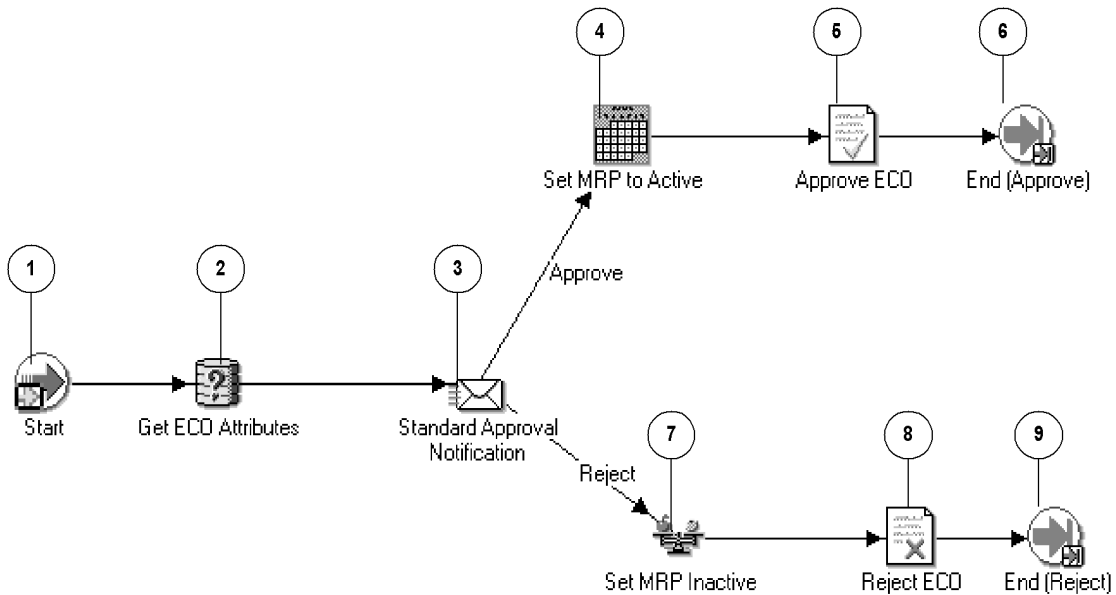
Display Name	Description	Type	Length
Approval Status	ECO Approval Status	Text	80
Attribute1	Attribute1	Text	150
Attribute2	Attribute2	Text	150
Attribute3	Attribute3	Text	150
Attribute4	Attribute4	Text	150
Attribute5	Attribute5	Text	150
Attribute6	Attribute6	Text	150
Attribute7	Attribute7	Text	150
Attribute8	Attribute8	Text	150
Attribute9	Attribute9	Text	150
Attribute10	Attribute10	Text	150
Attribute11	Attribute11	Text	150
Attribute12	Attribute12	Text	150
Attribute13	Attribute13	Text	150
Attribute14	Attribute14	Text	150
Attribute15	Attribute15	Text	150
Attribute Category	Attribute Category	Text	30
ECO	Engineering Change Order	Text	30
Change Type	Change Type	Text	10
ECO Dept Code	ECO Department Code	Text	3
ECO Dept Name	ECO Department Name	Text	60

Display Name	Description	Type	Length
ECO Description	ECO Description	Text	2000
ECO Status	ECO Status	Text	80
Estimated Eng Cost	Estimated Engineering Cost	Number	n/a
Estimated Mfg Cost	Estimated Manufacturing Cost	Number	n/a
Full Name	Change Requestor	Text	240
Initiation Date	ECO Initiation Date	Date	n/a
Organization Code	Organization Code	Text	3
Organization Name	Organization Name	Text	60
Org ID	Organization ID	Number	n/a
Priority Code	ECO Priority Code	Text	10
Reason Code	ECO Reason Code	Text	10
Rev ID	Revision ID	Number	n/a

Summary of the ECO Approval Process

The ECO Approval process consists of nine unique activities as displayed in the process diagram. The ECO Approval workflow begins when you submit an approval requisition from the ECO form in Oracle Engineering. The workflow begins at node 1 with the start activity. At node 2, the function gets all required ECO attributes and sets the item attributes. The ECO Approval status is changed to Approval Requested at node 3 and users on the approval list are notified of the ECO. If the user approves the ECO, the MRP Active ECO attribute is set to YES at node 4 and the approval status is set to Approved at node 5. If the user rejects the ECO, the MRP active attributes is set to NO at node 7 and the ECO approval status is set to Rejected at node 8. The workflow process ends either at node 6 or at node 9 depending on whether the user approves the ECO.

The following diagram illustrates what is described in the text above.



ECO Approval Process Activities

This section provides a description of each activity in the process, listed by the activity's display name. The legend for the information displayed is provided below, immediately followed by a list of activities.

Start (Node 1)

This is a standard function activity that simply marks the start of the process.

- Function – WF_STANDARD.NOOP
- Result Type – None
- Required – Yes
- Prerequisite Activities – None
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

Get ECO Attributes (Node 2)

This function gets all required ECO attributes and sets the item attributes.

- Function –
ENG_WORKFLOW_API_PKG.GET_ECO_ATTRIBUTES
- Result Type – None
- Required – Yes
- Prerequisite Activities – None
- Item Attributes Set by Function – CHANGE_NOTICE
 - ECO_DESCRIPTION
 - ECO_STATUS
 - INITIATION_DATE
 - PRIORITY_CODE
 - REASON_CODE
 - ESTIMATED_ENG_COST
 - ESTIMATED_MFG_COST
 - ATTRIBUTE_CATEGORY
 - ATTRIBUTE1
 - ATTRIBUTE2
 - ATTRIBUTE3
 - ATTRIBUTE4
 - ATTRIBUTE5
 - ATTRIBUTE6
 - ATTRIBUTE7
 - ATTRIBUTE8
 - ATTRIBUTE9
 - ATTRIBUTE10
 - ATTRIBUTE11
 - ATTRIBUTE12
 - ATTRIBUTE13
 - ATTRIBUTE14

- ATTRIBUTE15
- APPROVAL_STATUS
- ORGANIZATION_CODE
- ORGANIZATION_NAME
- FULL_NAME
- CHANGE_TYPE
- ECO_DEPT_NAME
- ECO_DEPT_CODE
- Item Attributes Retrieved by Function – None

Standard Approval Notification (Node 3)

This is a standard approval notification that requests approval from users on the approval list.

- Message – Standard Approval Message
- Result Type – ECO Approval
- Required – Yes
- Prerequisite Activities – Standard Approval Message
- Expand Roles – No
- Notification Function – None

Set MRP to Active (Node 4)

After the user has approved the ECO, this function sets the MRP Active attribute to on for revised items with status of Open and Scheduled. This can be used to create MRP demand when the ECO's approval status is updated to Approved.

- Function – ENG_WORKFLOW_API_PKG.SET_MRP_ACTIVE
- Result Type – None
- Required – Yes
- Prerequisite Activities – Standard Approval Notification
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

Approve ECO (Node 5)

This function sets the status of the ECO to Approved.

- Function – ENG_WORKFLOW_API_PKG.APPROVE_ECO
- Result Type – None
- Required – No
- Prerequisite Activities – Standard Approval Notification
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

End (Approve) (Node 6)

This function ends the ECO approval process with a status of Approved.

- Function – WF_STANDARD.NOOP
- Result Type – None
- Required – No
- Prerequisite Activities – None
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

Set MRP Inactive (Node 7)

After the user has rejected the ECO, this function sets the MRP Active attributes to off for revised items with status of Open and Scheduled.

- Function – ENG_WORKFLOW_API_PKG.SET_MRP_INACTIVE
- Result Type – None
- Required – Yes
- Prerequisite Activities – Standard Approval Notification
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

Reject ECO (Node 8)

This function sets the status of the ECO to Rejected.

- Function – ENG_WORKFLOW_API_PKG.REJECT_ECO

- Result Type – None
- Required – No
- Prerequisite Activities – Standard Approval Notification
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

End (Reject) (Node 9)

This function ends the ECO approval process with a status of Rejected.

- Function – WF_STANDARD.NOOP
- Result Type – None
- Required – No
- Prerequisite Activities – None
- Item Attributes Set by Function – None
- Item Attributes Retrieved by Function – None

See Also

Oracle Workflow, *Oracle Workflow Guide*

Defining Engineering Change Orders

An engineering change order (ECO) controls item revisions and bill of material changes. ECOs specify changes to one or more items and each of these items can have one or more revised components.

Prerequisites

- To update ECOs, the Engineering Change Orders: Update security function must be included as part of the responsibility.

► To define Engineering Change Orders:

1. Navigate to the Engineering Change Orders window.
2. Create the ECO. See: Creating an ECO: page 2 – 24.
3. Assign an ECO approval list and status. See: Viewing ECO Approval Status: page 2 – 27.
4. Define implementation costs. See: Defining Implementation Costs: page 2 – 31.
5. Define an ECO revision. See: Defining an ECO Revision: page 2 – 31.
6. Define revised items. See: Defining ECO Revised Items: page 2 – 32.
7. Review ECO scheduling. See: Viewing ECO Schedule History: page 2 – 37.
8. Review item revisions. See: Viewing Item Revisions: page 2 – 39.
9. Define revised components. See: Defining Revised Components: page 2 – 46.
10. Review substitute components and reference designators. See: Assigning or Deleting Substitute Components: page 2 – 48 and Assigning Reference Designators: page 2 – 49.
11. Optionally, attach files to ECOs. See: Attaching Files to ECOs: page 2 – 50.
12. Submit the ECO for approval or set approval status to Ready to Approve.
13. Transfer or Copy the ECO to manufacturing See: Transfer to Manufacturing from an ECO page 2 – 50 and Copy to Manufacturing from an ECO page 2 – 52.

See Also

Rescheduling an ECO or Revised Items: page 2 – 29

Changing the ECO Status: page 2 – 30

Implementing ECOs: page 2 – 57

Engineering Change Order Detail Report: page 4 – 3

Transferring or Copying Engineering Items, Bills, and Routings: page 3 – 8

Creating an ECO

An ECO's approval status must be Approved before the ECO can be implemented.

Note: If the approval status is Approval Requested, you cannot modify the ECO. If the approval status is Approved and the ECO is modified, the approval status will be set back to Not Submitted for Approval.

When ECO types are defined, they can optionally be associated with a priority as they are being associated with an Oracle Workflow process. When creating the ECO, if the selected ECO type / priority combination matches a defined ECO type/priority combination, the associated workflow process defaults. The approval status is set to Not Submitted for Approval until the Submit button is chosen. If there is no match between entered values and existing ECO type / priority combinations, the approval status is set to Approved and you can enter an approval list.

You can create, update and delete ECOs for the current organization, or for the current organization and all subordinate organizations in a given organization hierarchy.

Prerequisites

- Define at least one ECO type.

► **To create an ECO:**

1. Navigate to the Engineering Change Orders window.

The screenshot shows the 'Engineering Change Orders (M1)' window. The form contains the following fields and values:

ECO	JMH100			
Type	New Prod	New Product		
Creation Date	15-JUL-2002	<input type="checkbox"/> Hierarchy	Organization Hierarchy	
Status	Open			
Requestor	Green, Mr. Terry			
ECO Department	Eco Department1			
Reason	Perform	Performance		
Priority	Urgent	Urgent ECO		
Approval List				
Approval Process	Standard Approval Process			
Approval Status	Approval requested			
Project				
Task				

At the bottom, there are two tabs: 'Description' (selected) and 'Cancellation Comments'. The 'Description' tab contains the text: 'Change Component in Structure'. Below the tabs are five buttons: 'Submit', 'Transfer', 'Copy', 'ECO Revisions', and 'Revised Items'.

2. Enter an alphanumeric ECO identifier. If you use ECO autonumbering, the next identifier is defaulted.
3. Enter or select an ECO type.
You can only select ECO types that can revise engineering items and bills if the ENG: Engineering Item Change Order Access profile option is set to Yes. If the selected ECO type updates engineering and manufacturing items and bills, any new bills defined on the ECO are engineering bills.
4. Indicate whether to process the ECO across all organizations within the given organization hierarchy, or for the current organization.
Note: If the checkbox is not checked, then the ECO applies to the current organization. If the checkbox is checked and a value is

provided in the Organization Hierarchy field, then the ECO applies to the current organization and all subordinate organizations under the given organization hierarchy structure.



Attention: The Organization Hierarchy driver fields apply to the ECO Header, ECO Revisions, Revised Items, Revised Components, Reference Designators and Substitute Components.

5. Optionally, enter the requestor of the ECO.
6. Optionally, enter the ECO department responsible for the ECO.

This can be used to transition the ECO from one department to another, for example, from manufacturing engineering to operations. For new ECOs, the default is derived from the ENG: ECO Department profile option.

If you specify that each ECO must have an ECO department, that is, the ENG: Mandatory ECO Departments profile option is set to Yes, then you must specify a responsible department.

Access to ECOs by ECO department is as follows:

- You can only view and update ECOs with the same ECO department as your ENG: ECO Department profile option.
- If you do not have a value for the profile option ENG: ECO Department, you can query and update any ECO.
- Any user can query and update ECOs with no department reference.

7. Optionally, enter a reason for the engineering change.
8. Optionally, enter or select a priority for the ECO.

Note: If the ECO type and the priority combination are associated with an Oracle Workflow process, you cannot use an approval list.

9. If a workflow process is not associated with the ECO, you can enter an approval list. If you do not enter an approval list, the ECO approval status defaults to Approved without any kind of approval process.
10. Optionally, enter the approval status for the ECO.
11. Choose the ECO Revisions button to define ECO revisions. See: Defining an ECO Revision: page 2 – 31.
12. Choose the Revised Items button to define revised items. See: Defining ECO Revised Items: page 2 – 32.
13. Select the ECO status from the Tools menu. See ECO Statuses: page 2 – 71.

If the ECO status is Implement or Cancelled, the date of either status change is displayed.

14. If a workflow process is associated with the ECO, choose the Submit button to start the process.

See Also

Defining ECO Types: page 1 – 9

Viewing ECO Approval Status: page 2 – 27

Changing the ECO Status: page 2 – 30

Implementing ECOs: page 2 – 57

Defining ECO Autonumbering: page 1 – 11

MRP Planning for ECOs: page 2 – 64

Unreleased Item Revisions in Oracle Work in Process: page 2 – 65

Implementation of ECOs on Discrete Jobs and Repetitive Schedules:
page 2 – 65

Engineering Profile Options and Security Functions: page 1 – 21

Creating Organization Hierarchies, *Using Oracle HRMS–The Fundamentals*

Viewing ECO Approval Status

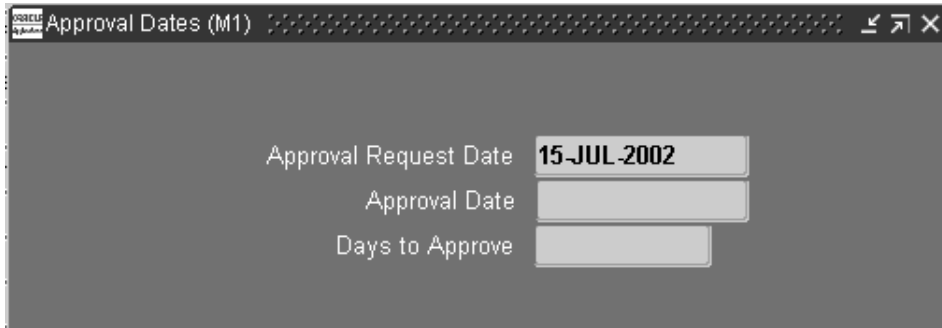
If an approval list is used, the approval status can only be changed manually, pending formal approval from a list member.

If a workflow process is associated with the ECO (based on the ECO type / priority combination), the approval status is changed automatically.

If neither a list nor a process is used, you must manually select either Approved or Rejected.

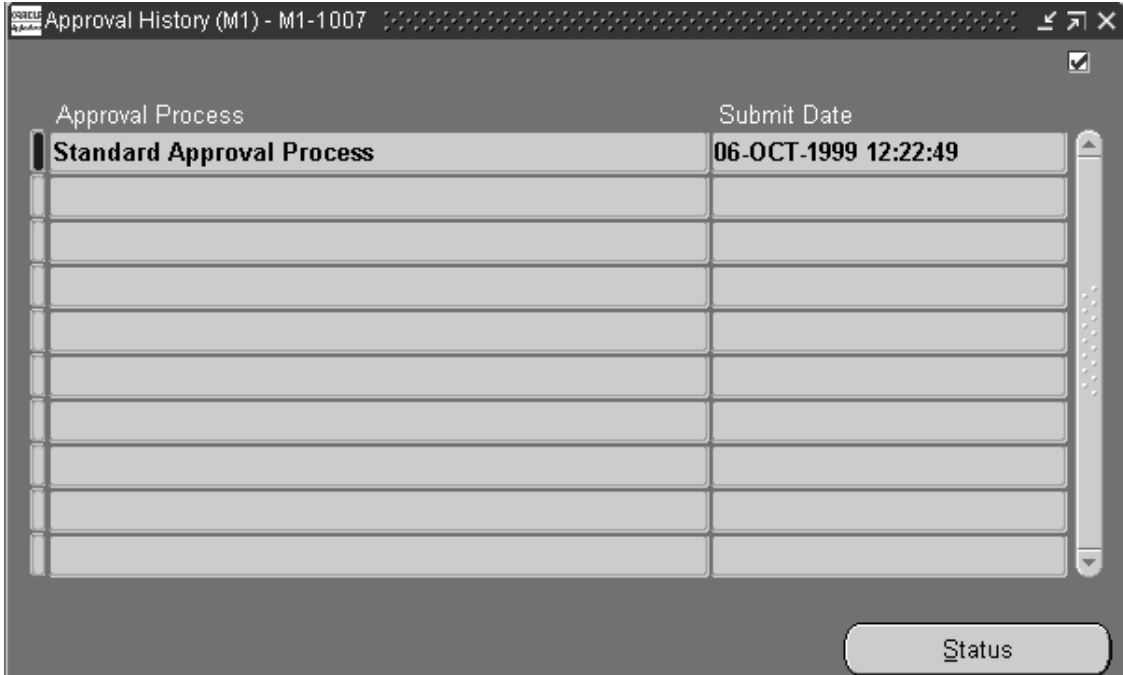
► **To view approval dates:**

1. Select View Dates from the Tools menu. The approval request date, the approved date (if applicable), and the days to approve are displayed for reference.



► **To view workflow approval status:**

1. If a workflow process is associated with an ECO, Select View Approvals from the Tools menu to view the approval status of the ECO.



2. Highlight the desired Approval Process, and select the Status button.

See Also

Creating an ECO: page 2 – 24

ECO Approval Statuses: page 2 – 72

Workflow for ECO Approvals: page 2 – 12

Rescheduling an ECO or Revised Items

You can reschedule ECOs or ECO revised items unless their status is Cancelled or Implemented.



Attention: Rescheduling does not change the ECO or revised item status, only the dates.

Prerequisites

- To reschedule an ECO, the Engineering Change Orders: Reschedule security function must be included as part of the responsibility.
- The approval status must be set to Approved before the ECO or any revised items can be scheduled or rescheduled.

► To reschedule an ECO or Revised Items:

1. Choose Reschedule from the Tools menu from either the Engineering Change Orders window or the Revised Items window.
2. Do one of the following:
 - If you are rescheduling an ECO, select an effective date from the calendar.
 - If you are rescheduling revised items, select a use-up date.
3. Enter the requestor of the rescheduled ECO.
4. Choose OK to save your work.

If you entered this window from the Engineering Change Orders window, choosing OK will reschedule all pending revised items (those with the status of Open, Hold, Schedule, or Release) for this ECO.

If you entered this window from the Revised Items window, this will reschedule only the selected revised item.

See Also

Overview of Function Security, *Oracle Applications System Administrator's Guide*

Implementing Function Security, *Oracle Applications System Administrator's Guide*

Changing the ECO Status

You can change the ECO status and the ECO revised item's status to Open, Hold, Release, Schedule, Implement, or Cancel.

An ECO's approval status must be Approved before the ECO can be implemented.

The following table describes the conditions regarding Workflow under which the status can be changed:

Status	Without Workflow	With Workflow: Before Approval	With Workflow: After Approval	With Workflow: Approval in Process
Open	Yes	Yes	Yes	No
Hold	Yes	Yes	Yes	No
Released	Yes	Yes	Yes	No
Scheduled	Yes	No	No	No
Rescheduled	Yes	Yes	Yes	No
Cancel	Yes	Yes	Yes	No
Implement	Yes	No	Yes	No

Prerequisites

To change the ECO status, the appropriate security function(s) must be included as part of the responsibility.

► **To change the ECO status:**

1. Navigate to the Engineering Change Orders window.
2. From the Tools menu, choose the status (Open, Hold, Release, Schedule, Implement, or Cancel). See: ECO Statuses: page 2 – 71.

3. If you are cancelling the ECO, select the Cancel Comments pop list to enter comments.
4. Save your work.

See Also

Implementing ECOs: page 2 – 57

Starting the AutoImplement Manager: page 1 – 20

Cancelling ECOs and Revised Items: page 2 – 60

Engineering Profile Options and Security Functions: page 1 – 21

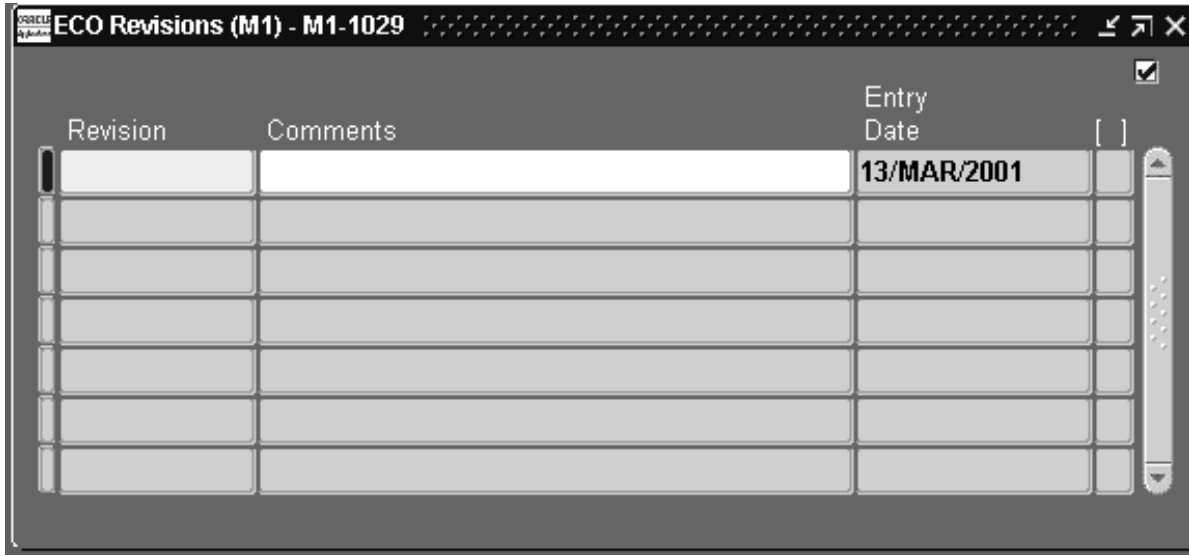
Defining Implementation Costs

Estimate the implementation costs to engineering and to manufacturing of the ECO. Oracle Engineering uses this information for reference purposes only.

- ▶ **To define manufacturing and engineering costs:**
 1. Choose Enter Costs from the Tools menu.
 2. Enter a cost for engineering
 3. Enter a cost for manufacturing.

Defining an ECO Revision

- ▶ **To define an ECO revision:**
 1. Navigate to the ECO Revisions window. Do this by choosing the ECO Revisions button from the Engineering Change Orders window.



2. Enter a revision for the ECO.
The date that you entered the ECO is displayed for reference.
3. Save your work.

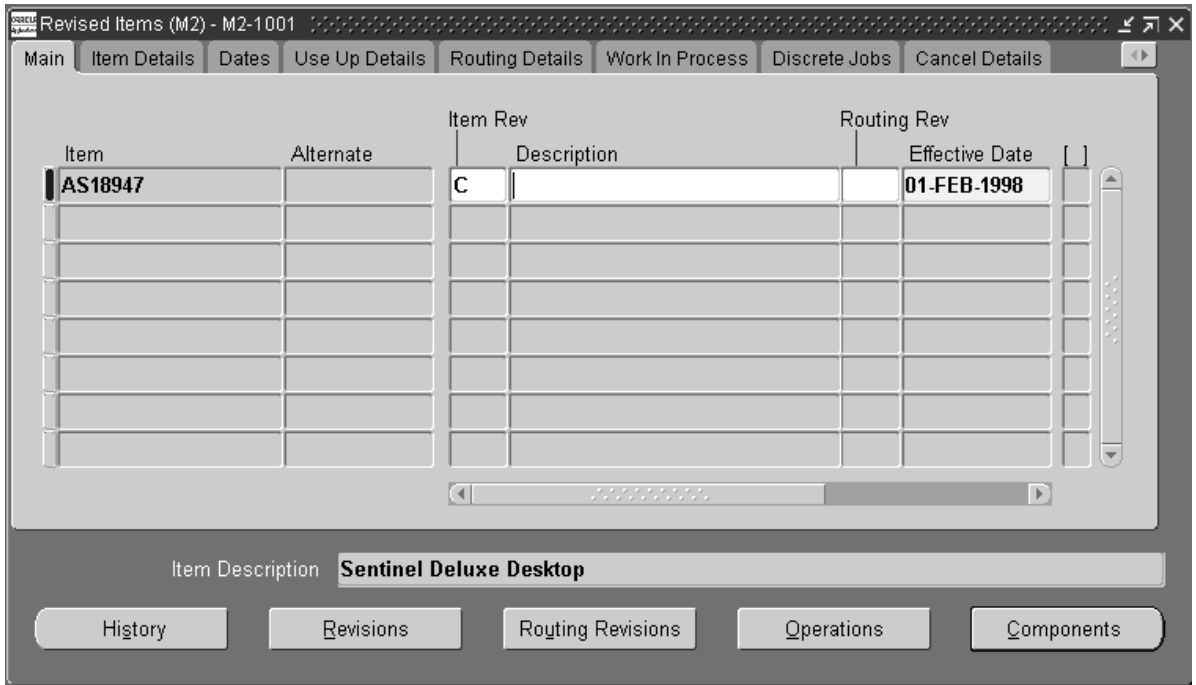
Defining ECO Revised Items

Each ECO can list one or more revised items whose form, fit, or function needs revision.

Any revised item can have an associated bill of material. You can create a bill for a revised item (if one does not exist) by copying it from another bill or by adding components to it.

► **To define revised items:**

1. Navigate to the Revised Items window. Do this by choosing the Revised Items button from the Engineering Change Orders window.



2. Enter or select an item to change with this ECO.

Note: You can create a bill for the item (if one does not exist) by choosing the Components button and adding components in the Revised Components window.

3. Optionally, enter an alternate for the item. You can create or update alternate bills using an ECO.
4. Optionally, enter a new revision for the revised item.

This must be greater than or equal to the current revision. If you create or update an alternate bill of material, you cannot assign a new item revision.

You must enter a new revision for the revised item if you set the ENG: Require Revised Item New Revision profile option to Yes.

5. Optionally, enter an item Description.

You do not have the ability to enter an item description if you enter an alternate for the item.

6. Optionally, enter a Routing Revision.

This must be greater than or equal to existing revisions. You cannot enter any revisions if you selected a Model/Unit effectivity

item in the Item field. If you entered a revised item that should not have routings, then the Routing Revision field will be disabled.

7. Enter an effective date for the item and component changes.

This date is used to implement the revised item and identify past due revised items.

If you select a use-up date for this item and its components, a record is created that indicates that this revised item is based on the use-up date of the item. If the MRP planning process computes a new use-up date before this revised item is implemented, Engineering automatically sends an alert to the planner.

8. Choose a status for the ECO revised item from the Tools menu. See: ECO Revised Item Statuses: page 2 – 71.

Note: You can set the revised item status to Hold, Released, Implemented, or Cancelled only if the ECO status is Open. Otherwise, the revised item status defaults from the ECO status.

If the ECO has a Workflow process and the item or its components are changed, the revised item's status is changed from Scheduled to Open and the approval status is changed to Not Submitted for Approval.

9. Indicate whether the revised item is MRP Active, that included in the planning process. The default is No if the Status is Hold; Yes if the Status is Open, Release, or Schedule.

If the ECO lists engineering changes and has an effective date in the future, you may want the planning process to consider those changes.

10. Open the Item Details tabbed region and view the description and the user-defined item type for that item.
11. Optionally, open the Dates tabbed region and enter the Early Effective date. This is the earliest date you can manually implement the revised item.

If applicable, the Cancelled date for the changes of the revised item and its components, or the Implemented date for the revised item is displayed.

The Implemented Immediately check box, if enabled, indicates the item was implemented manually from the Tools menu. If disabled, the item is scheduled for automatic implementation.

12. Open the Use Up Details tabbed region and do the following:

- If not already selected, enter the item whose use-up date is tied to the revised item effective date. The use-up item can be the revised item itself or a component of the revised item.
 - View the use-up item associated with the use-up date selected as the effective date.
 - View the name of the MRP plan to use for determining item use-up dates.
13. Open the Routing Details tabbed region and do the following:
 - Indicate whether CTP is enabled. This attribute is derived from the routing header information if the revised item has existing routing information. If routing information does not exist, routing header information is created automatically when you enable this attribute.
 - Enter a priority value for this item.
 - Choose a valid subinventory.
 - Enter Locator information. If the completion subinventory does not have a valid location, or the revised item's Locator Control attribute is set to No Control, then this field is disabled. If the revised item's Locator Control attribute is set to Dynamic Entry, then this field is enabled.
 14. Open the Work in Process tabbed region and indicate whether to update WIP requirements for unreleased jobs or schedules when the revised item is implemented.
 15. Select a disposition for inventory and work in process inventory affected by the ECO. See: Disposition: page 2 – 72.
 16. Open the Cancel Details tabbed region to view the cancellation date and cancel comments.
 17. Choose the History button to view revised item effective date history and track schedule changes to the revised item. Choose the Revisions button to view item revisions. Choose the Components button to add, change, or disable components.

See Also

Viewing ECO Schedule History: page 2 – 37

Defining Revised Components: page 2 – 46

Viewing Item Revisions: page 2 – 39

Use Up ECOs: page 2 – 63

Defining Material Dispositions: page 1 – 19

Viewing ECO Schedule History

View revised item effective date history and track schedule changes to revised items.

► **To view ECO schedule history:**

1. Navigate to the History window. Do this by choosing the History button from the Revised Items window.

The screenshot shows a software window titled "History (M1) - M1-1030". At the top, there are three input fields: "Revised Item" (with a long text box), "Alternate" (with a shorter text box), and "Effective Date" (with a date picker). Below these is a section titled "Reschedule History" with a checked checkbox. This section contains a table with three columns: "Effective Date", "Employee", and "Entry Date". The table has eight rows, all of which are currently empty. To the right of the table is a vertical scrollbar. Below the table is a "Comments" label followed by a large text area for entering notes.

A history of all previous effective dates and their entry date is listed for the revised item.

2. View the employee who initiated the change to the effective date and any comments describing the change to the effective date.

See Also

Engineering Change Order Detail Report: page 4 – 3

Viewing Item Revisions

- ▶ **To view item revisions:**
 1. Navigate to the Item Revisions window. Do this by choosing the Revisions button from the Revised Items window.
 2. Review the displayed information:

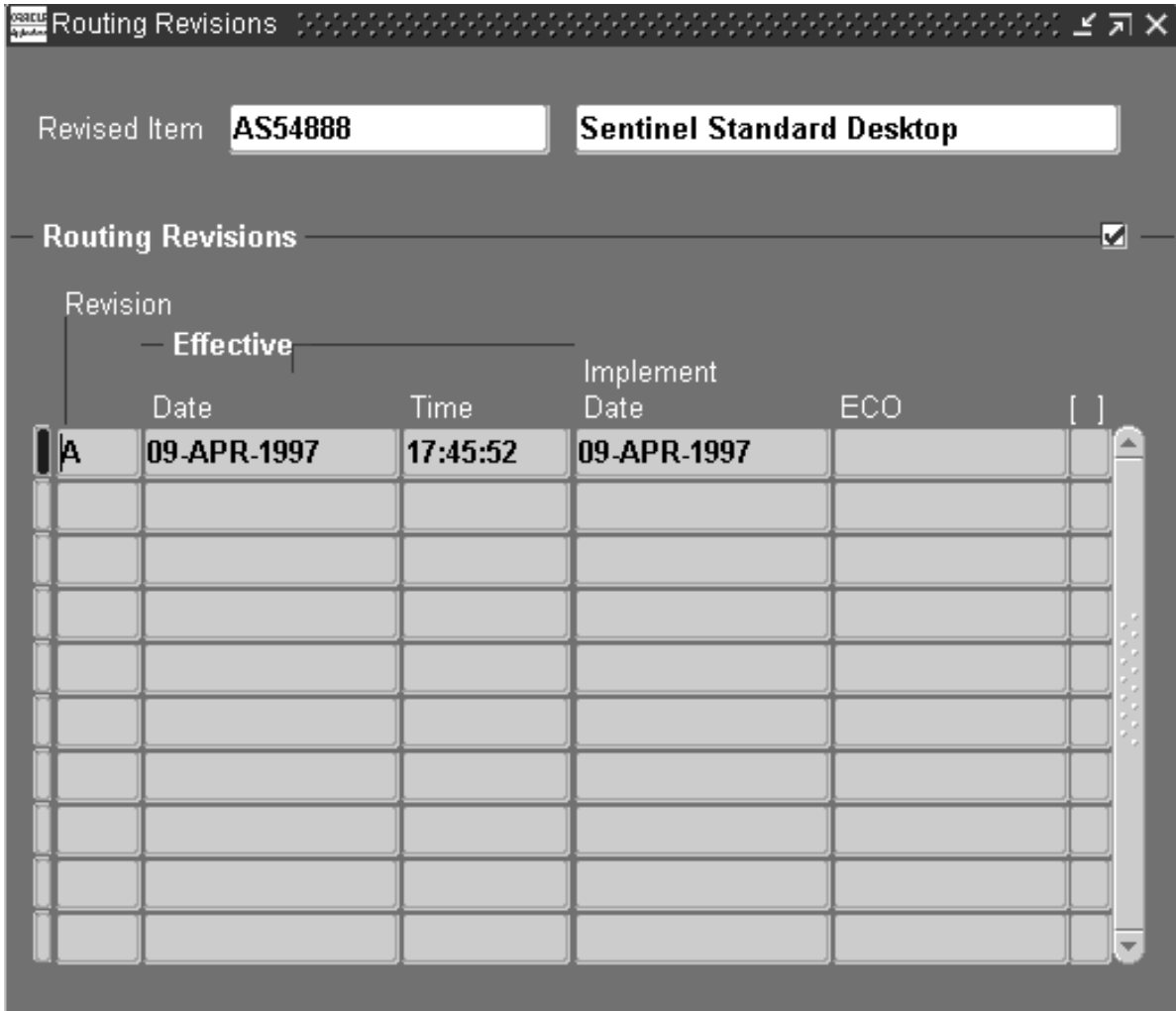
The revision, the effective date and time, the implementation date, the initiation date, and the ECO are displayed for information purposes.

See Also

Defining ECO Revised Items: page 2 – 32

Viewing Routing Revisions

- ▶ **To view routing revisions:**
 1. Navigate to the Routing Revisions window. Do this by choosing the Routing Revisions button from the Revised Items window.



2. Review the displayed information:

The revision, the effective date and time, the implementation date, and the related ECO are displayed for information purposes.

See Also

Defining Revised Components: page 2 – 46

Defining Revised Resources: page 2 – 43

Defining Revised Operations: page 2 – 41

Defining Revised Operations

Enter, disable, and update information for a revised item's operations.

► **To define revised operations:**

1. Navigate to the Revised Operations window. Do this by choosing the Operations button from the Revised Items window.

Revised Operations

Revised Item: **AA102** **AA-Serial Controlled Item**

Alternate:

Effective: **05-JUN-2002** Capable to Promise

Engineering Routing

Operations

Main WIP Operation Yield Description

Action	Op Seq	Reference Flag	Std Op	Dept Code	Disable Date	Option Dependent	Lead Time %
Change	10	...		D1-A706		<input type="checkbox"/>	
						<input type="checkbox"/>	
						<input type="checkbox"/>	
						<input type="checkbox"/>	
						<input type="checkbox"/>	
						<input type="checkbox"/>	
						<input type="checkbox"/>	
						<input type="checkbox"/>	

Revised Resources

2. Enter or select an action to take:

Add: Add an operation and the the operation's resources. If there is no existing operation, then a new routing header should be created.

Change: Change operation attribute and resource information.

Disable: Disable the operation from the revised item's bill. The resources which are associated with the operation should be disabled.

3. Enter the Operation Sequence Number of the target operation. If you selected the Add action, enter a new operation sequence number.. If you selected the Change or Disable actions, enter an existing operation sequence number.
4. Indicate whether this operation will be referenced if you selected the Add action. If you selected a standard operation, then this flag is turned on automatically. If you selected the Change action, then this flag is disabled.
5. Enter the Department Code. If you selected the Add action, or the Change action and a standard operation, enter an existing department code.
6. Enter the date the operation is to be disabled in the Disable Date field. If you selected the Disable action, the system date is entered automatically.
7. Indicate whether this operation is option dependent if you selected the Add action, or the Change action and did not select the reference flag.
8. Enter the Operation Lead Time if you selected the Add or Change actions. If an operation lead time is smaller than zero or greater than 100, then an error message will be shown.
9. Open the WIP tabbed region and enter the following attributes:
 - If you selected the Add action, or the Change action and did not select the reference flag, you can update the Count Point flag.
 - If you selected the Add action, you can update the Autocharge flag.
 - If you selected the Add action, or the Change action and did not select the reference flag, you can update the Backflush flag.
 - If you selected the Add action, or the Change action and did not select the reference flag, you can enter the Minimum Transfer Quantity.
10. Open the Operation Yield tabbed region and do the following:
 - Enter the Yield if you selected the Add or Change actions. Operation Yield is applicable to lot-based jobs, and is used to track variances between estimated and actual scrap absorption. See: Defining a Department, *Oracle Bills of Material User's Guide*

- Enter the Cumulative Yield if you selected the Add or Change actions. See: Yield, *Oracle Bills of Material User's Guide*.

Note: These fields can be updated for operations belonging to lot-based routings, and are applicable for Shop Floor Management enabled organizations.

See Also

Item and Operation Sequence, *Oracle Bills of Material User's Guide*

Effective Date Fields, *Oracle Bills of Material User's Guide*

Defining Revised Components: page 2 – 46

Defining Revised Resources: page 2 – 43

Defining Revised Resources

Enter or disable information for a revised operation's resources.

- If the Reference Flag in the Revised Operations window is selected, then you cannot add or disable resources.

► **To define revised resources:**

1. Navigate to the Operation Resources window. Do this by choosing the Revised Resources button from the Revised Operations window.

Operation Resources (M1)

Revised Item Alternate

Op Seq Effective Date

Resources

Main | Scheduling | Costing

Action	Res Seq	Resource Code	UOM	Basis Type	— Rate or Amount —	
					Usage	Inverse
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	Item	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

2. Enter or select an action to take:
 - Add:* Add a resource to the operation.
 - Change:* Change existing resource information.
 - Disable:* Disable the resource from the operation. Designate an existing resource sequence number.
3. Enter the Resource Sequence Number. If you selected the Add action, enter a new resource sequence number. If you selected the Disable action, enter an existing operation sequence number.
4. Enter the Resource Code. If you selected the Add action, select a resource belonging to the selected department in the Revised Operations window.

Note: The UOM field is derived from the Resource attribute and is read-only.
5. Enter the Basis Type. If you selected the Add or Change actions, select Item or Lot. See: Basis, *Oracle Bills of Material User's Guide*.
6. Enter the Usage Rate or Amount if you selected the Add or Change actions. Once you enter or change this value, the Inverse will be calculated automatically.

7. Enter the Inverse Rate or Amount if you selected the Add or Change actions. Once you enter or change this value, the Usage will be calculated automatically.
8. Open the Scheduling tabbed region and do the following:
 - Indicate whether this resource is available 24 hours. Once selected, you cannot update this value.
 - If you selected the Add or Change actions, enter a Schedule Sequence Number.
 - Enter the number of units assigned to this resource.
 - Select the Schedule option. Available options are Yes, No, Prior, and Next.
 - If you selected the Add or Change actions, enter the Offset percentage. This number should be greater than or equal to zero, and less than or equal to 100.
 - Indicate whether this is the principle resource in the operation, if you selected the Add or Change actions.
 - Enter the Setup Type Code for this resource.
9. Open the Costing tabbed region and do the following:
 - Select an Action. You can Add or Change costing information. Costing information must be defined for each resource.
 - Select whether to cost at the standard rate.
 - Select a Charge Type if you selected the Add action. If you selected the Change action, you can change the Charge Type but cannot enter an autocharge type of PO Move or PO Receipt for a resource without Outside Processing enabled. You can select Manual or WIP Move.

See Also

Item and Operation Sequence, *Oracle Bills of Material User's Guide*

Defining Revised Components: page 2 – 46

Defining Revised Operations: page 2 – 41

Defining Revised Components

Enter and update change information for a revised item's components.

► **To define revised components:**

1. Navigate to the Revised Components window. Do this by choosing the Components button from the Revised Items window.

Revised Item **AS18947** **Sentinel Deluxe Desktop**

Alternate

Effective Date **01-OCT-1997**

Components

Main | Item Details | Component Details | Material Control | Order Entry | Shipping | Comments | Cancel Details

Action	Component	Op Seq		Item Seq			Quantity		Effect
		Old	New	UOM	Old	New			
Disable	CM15138	60	60	20	Ea	1	0	01-OC	
Add	CM15140	60	60	21	Ea	1	1		

Component Description **Monitor - 17"**

Substitutes | Designators

2. Enter or select an action to take:

Add: Add a component to the revised item's bill of material. If a bill does not already exist, adding components creates one.

Change: Change usage information for the component of the revised item's bill.

Disable: Disable the component from the revised item's bill.

3. Enter a component on the bill.

4. Do the following:
 - If you are changing component information, enter the old operation sequence where the component is currently assigned.
 - If you are changing the component's operation sequence, enter a new operation sequence (from the routing) for the component of the revised item. The default is 1 for components being added where no routing exists.
 - Enter the item sequence of the item on the bill of material. The default is the next highest item sequence.
 - Enter the component quantity used by this particular revised item. For components you are changing, you can see the old component's quantity in the Old Quantity field when you change or disable a component. The default is the quantity used by the revised item, 0 for components you are deleting, and 1 for components you are adding.
 - For components you are adding or changing, enter an inactive date for the revised component.
5. Review the item's description, revision, and whether it is an engineering item in the Item Details tabbed region.
6. Open the Component Details tabbed region and do the following:
 - Enter the planning percent for optional components on model and option class bills, and all components on planning bills. Oracle Master Scheduling/MRP uses planning percentages for planning bill explosions. You can enter quantities over 100 percent to overplan. See: Planning Percent, *Oracle Bills of Material User's Guide*.
 - Enter a component yield factor. You cannot enter component yield for an option class item or for any components of a planning bill. The default is 1, indicating 100% yield. See: Yield, *Oracle Bills of Material User's Guide*.
 - Indicate whether to include the cost of this component in the cost of its parent item for the cost rollup.
 - View the component item type and status.
7. Open the Material Control tabbed region and select a supply type, a subinventory, and a locator. See: Supply Type, *Oracle Bills of Material User's Guide* and Subinventory and Locator, *Oracle Bills of Material User's Guide*.
8. Open the Order Entry tabbed region and do the following:

- Indicate whether to Check ATP. See: Check ATP, *Oracle Bills of Material User's Guide*.
 - Indicate whether the component is optional and mutually exclusive. See: Mutually Exclusive and Optional, *Oracle Bills of Material User's Guide*.
 - For optional components, enter the minimum and maximum sales order quantities. See: Minimum and Maximum Quantities, *Oracle Bills of Material User's Guide*.
 - Select a basis. See: Basis, *Oracle Bills of Material User's Guide*.
9. Open the Shipping tabbed region and indicate whether the component should be listed on shipping documents, required to ship, or required for revenue. See: Shipping Details, *Oracle Bills of Material User's Guide*.
 10. If the component is cancelled, open the Cancel Details tabbed region. Once the component is cancelled, you can no longer update any information about the revised component on this ECO.
Note: You can cancel revised components by choosing Cancel from the Tools menu.
 11. Choose the Substitutes button to open the Substitute Components window. Choose the Designators button to open the Reference Designators window.

See Also

Assigning Reference Designators: page 2 – 49

Assigning or Deleting Substitute Components: page 2 – 48

Item and Operation Sequence, *Oracle Bills of Material User's Guide*

Effective Date Fields, *Oracle Bills of Material User's Guide*

Assigning or Deleting Substitute Components

Assign or delete suggested substitute items for the revised component. You can assign any number of substitute items to each bill component and you can assign the same substitute item to more than one component.

► **To assign or delete substitute components:**

1. Navigate to the Substitute Components window. Do this by choosing the Substitutes button from the Revised Components window.
2. Enter an action: add a substitute item to, or delete a substitute item from the revised component.
3. Enter or select a substitute item for the revised component. This must be a manufacturing item.
4. Enter the quantity of the substitute item needed to replace the full component quantity.

This can differ from the bill usage quantity of the component. The default is the usage quantity of the component.

Assigning Reference Designators

► **To assign reference designators to the revised component:**

1. Navigate to the Reference Designators window. Do this by choosing the Designators button from the Revised Components window.
2. Indicate whether to relate component quantity to the number of reference designators.

Off: Assign any number of reference designators to each component (the default). The number of reference designators is independent of the component quantity. With Quantity Related unchecked, if the usage quantity of the component is four, you could, for example, define six or more reference designators.

On: Use one reference designator per usage of the component. The component usage quantity must be a positive integer in order for you to use this option. When the bill requires a quantity of four of a given component, you assign four reference designators to that component, one for each usage.

The number of reference designators implemented for the revised component is displayed. This value is 0 until the ECO is implemented.

Also, the total number of reference designators currently defined for the revised component is displayed.

3. Select an action: add to or delete a range of reference designators from the revised component.

Engineering enables you to view a prefix, suffix, and number range to assign to a sequence of reference designators.

See Also

Creating Reference Designators, *Oracle Bills of Material User's Guide*

Attaching Files to ECOs

You can attach text and files, such as spreadsheets, graphics, and OLE objects to engineering change orders.

For example, an attached file may include comments, such as a graphical representation of the bill structure or detailed instructions.

- ▶ **To attach files to ECOs:**
 - From the Engineering Change Orders window, choose the Attachments icon.

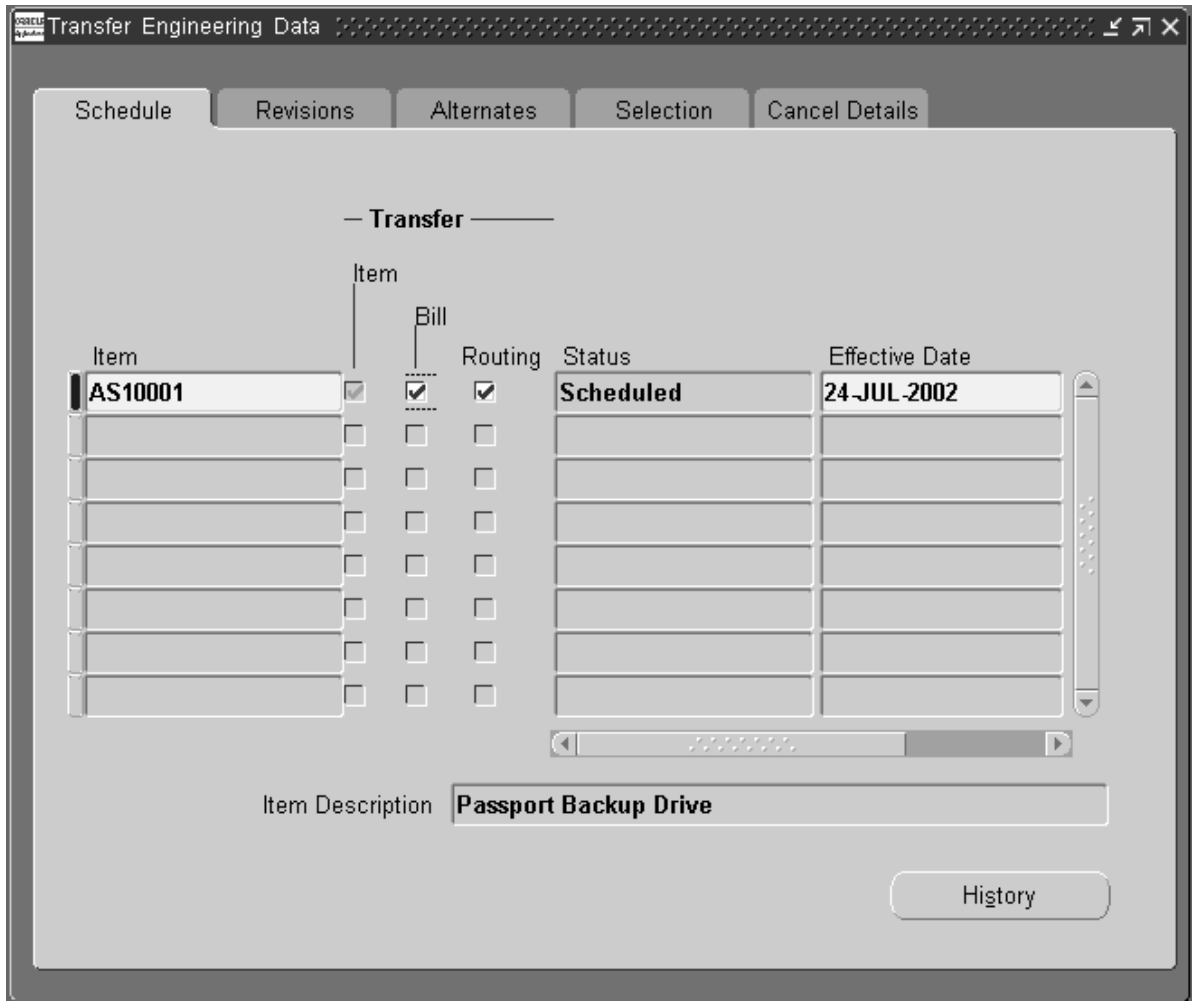
See Also

Working With Attachments, *Oracle Applications User's Guide*

Transfer to Manufacturing from an ECO

You can transfer engineering items, bills and routing to manufacturing from within an ECO.

- ▶ **To transfer entities to manufacturing from within an ECO**
 1. Navigate to the Engineering Change Orders window.
 2. Select the Transfer Button from the Engineering Change Orders window.



3. Enter an Item and select Bill and Routing if applicable.
4. Enter the Effective Date of the item.
5. Enter the Early Effective date if applicable.
6. Select the Revisions tabbed region. For information on the Revisions tabbed region and the Alternates tabbed, See: Transferring or Copying Engineering Items, Bills, and Routings: page 3 - 8
7. Select the Selections tabbed region.
8. Select the Selection Option from the list. The available selections are:

All: All past, current or future components and or operation steps associated with the assembly.

Current: All current components and or operation steps associated with the assembly that are effective on the Selection Date.

Future and Current: All current and future components and or operation steps associated with the assembly.

9. Enter the Selection Date.
10. Enter the Unit Number if applicable.
11. Save your work.
12. Select the History button to view the transaction history.

See Also

Transferring or Copying Engineering Items, Bills, and Routings: page 3 – 8

Transfer or Copy from an ECO: page 2 – 10

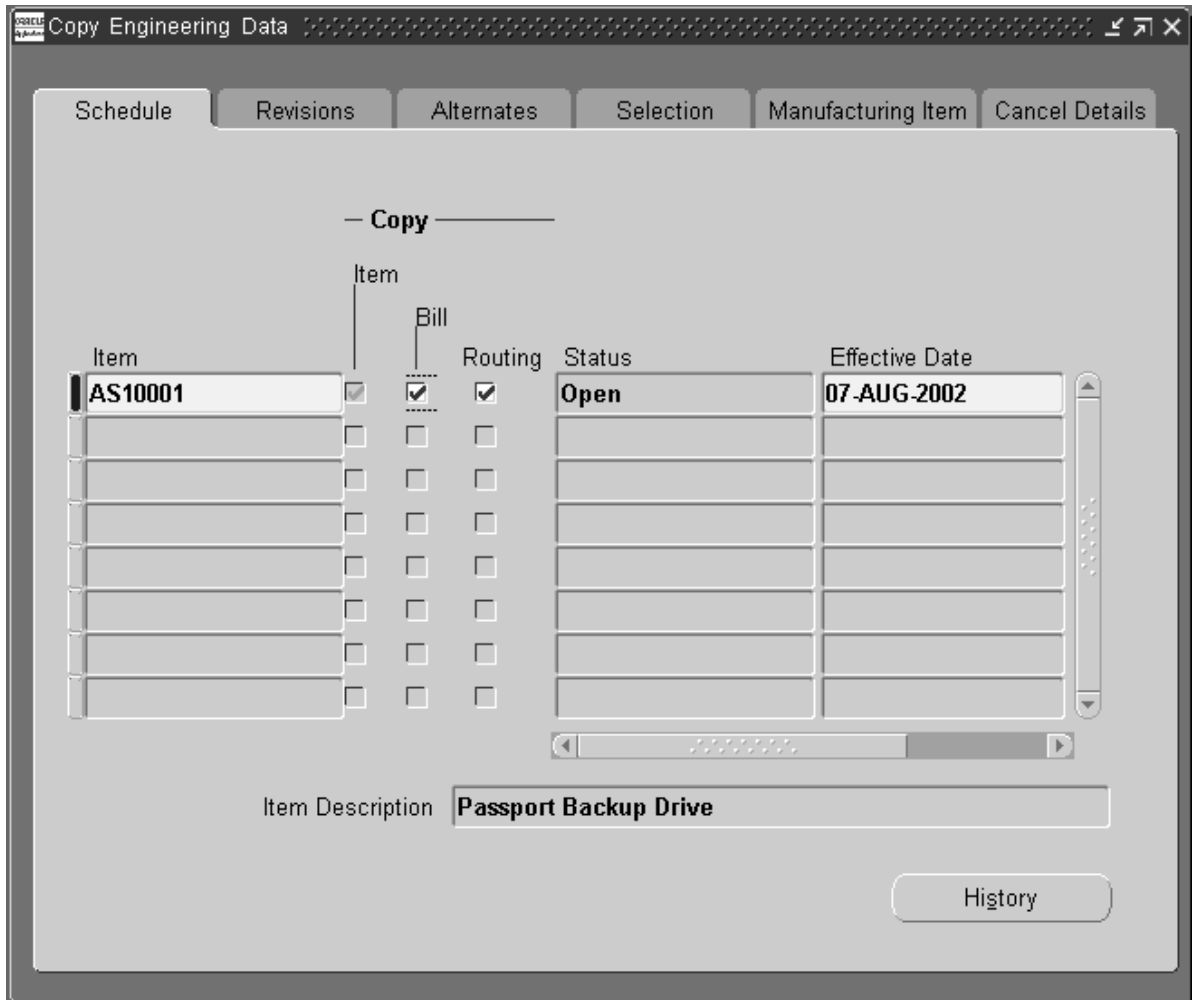
Copy to Manufacturing from an ECO: page 2 – 52

Copying Bill and Routing Information, *Oracle Bills of Material User's Guide*

Copy to Manufacturing from an ECO

You can copy engineering items, bills and routing to manufacturing from within an ECO.

- ▶ **To copy entities to manufacturing from within an ECO**
 1. Navigate to the Engineering Change Orders window.
 2. Select the Copy Button from the Engineering Change Orders window.



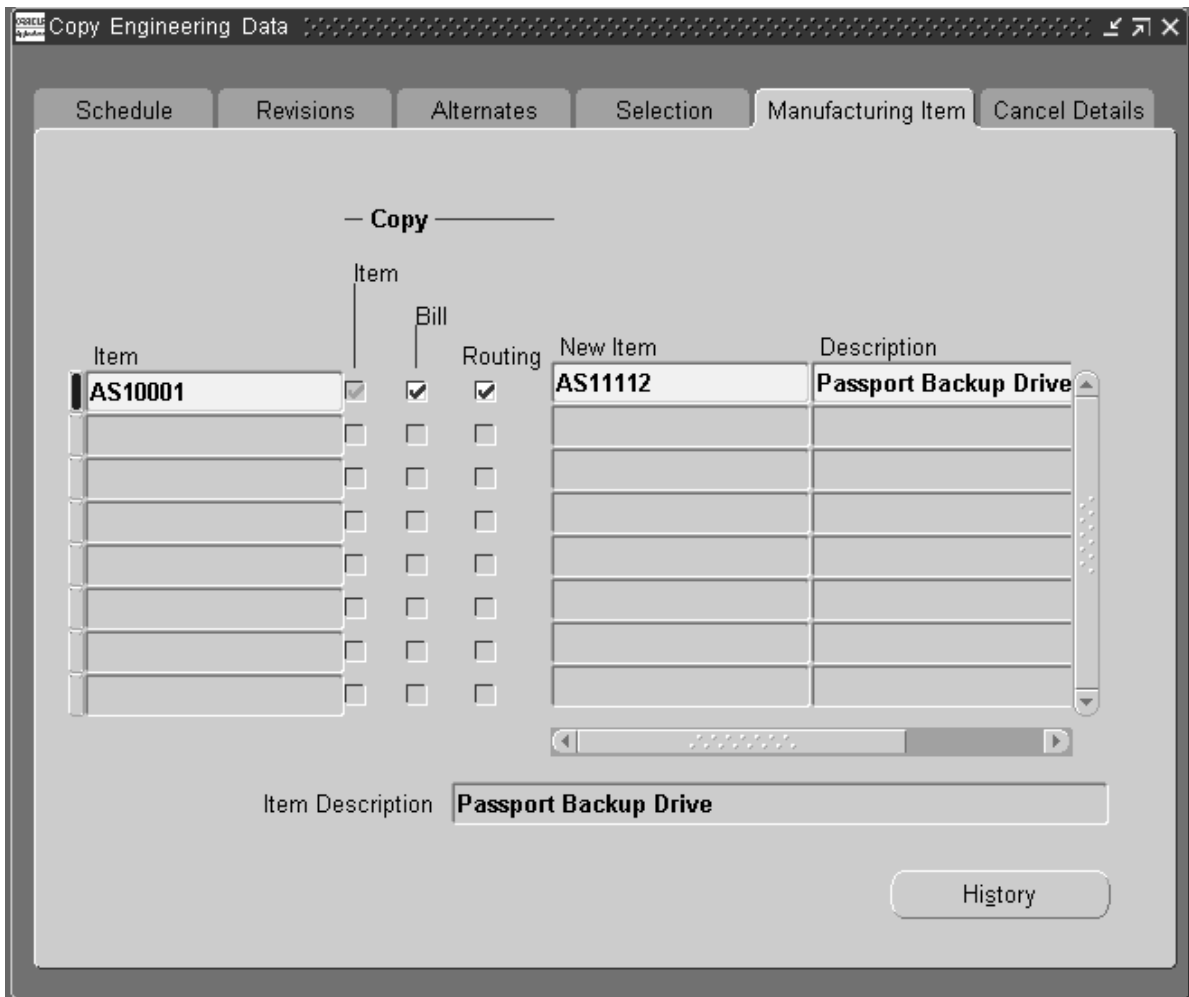
3. Enter an Item and select Bill and Routing if applicable.
4. Enter the Effective Date of the item.
5. Enter the Early Effective date if applicable.
6. Select the Revisions tabbed region. For information on the Revisions tabbed region and the Alternates tabbed, See: Transferring or Copying Engineering Items, Bills, and Routings: page 3 – 8
7. Select the Selections tabbed region.
8. Select the Selection Option from the list. The available selections are:

All: All past, current or future components and or operation steps associated with the assembly.

Current: All current components and or operation steps associated with the assembly that are effective on the Selection Date.

Future and Current: All current and future components and or operation steps associated with the assembly.

9. Enter the Selection Date.
10. Enter the Unit Number if applicable.
11. Select the Manufacturing Items tabbed region.



12. Enter a new item name and description.
13. Save your work.
14. Select the History button to view the transaction history.

See Also

Transferring or Copying Engineering Items, Bills, and Routings: page 3 – 8

Transfer or Copy from an ECO: page 2 – 10

Transfer to Manufacturing from an ECO: page 2 – 50

Copying Bill and Routing Information, *Oracle Bills of Material User's Guide*

Mass Changing ECOs

You can define a mass change to add, delete, or replace a component, alter a component quantity or yield, or change other component information. You can mass change all using bills of material or choose a subset of bills by item range, item category, or item type.

Engineering lets you create an ECO based on your parent item and component criteria. A mass change ECO lists all using assemblies that meet your search criteria as revised items, and assigns all component changes as revised components. You can manage and implement each revised item, or the entire ECO, the same way you maintain revised items you manually assign to an ECO.

Note: In Bills of Material, mass changes take place immediately. However, in Engineering, an ECO is created that must be implemented to take effect.

- ▶ **To mass change ECOs:**
 - Mass change the bills of material as needed. Be sure to set ECO options.

See Also

Mass Changing Bills of Material, *Oracle Bills of Material User's Guide*
Engineering Profile Options and Security Functions: page 1 – 21

Implementing ECOs

When you implement an ECO, each revised item's status is marked as "implemented"; you can no longer reschedule it. You can implement all revised items on an ECO, or implement each revised item on a different date. Engineering only lets you implement ECOs that do not have an approval status of Rejected, or do not have an ECO status of Hold or Cancelled. Once you implement an ECO or revised item, you can no longer make any revised item changes.

You can manually implement revised items on an ECO or you can automatically implement each revised item on its effective date. Engineering updates the actual implementation date for each revised item when it is implemented. When all of the revised items on an ECO have been implemented, the ECO is completely implemented and can be purged.

Engineering implements an ECO over time from the earliest revised item effective date to the latest revised item effective date. When you spread multiple changes across several ECOs, you should ensure that the effective date ranges for the ECOs do not overlap. For example, if you implement changes to a bill of material across many ECOs, you should make sure that the revised item effective dates do not overlap. If you implement one change using the current revision, you should implement all other changes to the current revision before you implement changes against future revisions.



Attention: You must implement new revisions in ascending order. If you implement a later revision for an item on one ECO, Engineering ensures that you implement any subsequent revisions for the item in ascending order.

Manual Implementation

For an ECO, you can specify whether to implement all or specific revised items. An ECO can be implemented today, but will not make the changes to the revised items effective until the date specified on the change order.

Automatic Implementation

To AutoImplement a revised item on an ECO, you mark the revised item status as 'scheduled' and specify an effective date. You can schedule all revised items on an ECO for auto-implementation, or

schedule each revised item individually. Engineering automatically implements scheduled changes on their effective dates.

You can automatically implement scheduled ECOs in the current organization, or the current organization including all subordinate organizations. You have the ability to specify the organization hierarchy name, since the current organization can be accessed from more than one organization hierarchy. You can also automatically implement scheduled ECOs in all organizations having the same item master organization as the current organization, and if they are accessible by the user responsibility.

Start the AutoImplement Manager process so Engineering implements scheduled changes daily.

Prerequisites

To implement an ECO, the Engineering Change Orders: Implement security function must be included as part of the responsibility.

▶ **To manually implement an ECO:**

1. Navigate to the Engineering Change Orders window.
2. Enter or select an ECO to implement.
3. Choose Implement from the Tools menu. Doing so automatically changes the status of all revised items.

▶ **To manually implement a revised item on an ECO:**

1. Navigate to the Revised Items window.
2. Select a revised item to implement.
3. Choose Implement from the Tools menu.

Note: A warning message appears if the ECO does not have a Workflow process and the revised item's effective date is in the future.

▶ **To automatically implement an ECO:**

1. Navigate to the Engineering Change Order window.
2. Enter or select an ECO to implement.
3. Set the ECOs status and/or the status of revised items to Scheduled.

4. Save your work.
5. Start the AutoImplement Manager.

The following parameter:s are provided:

- All Organizations
- Organization Hierarchy

Note: If the All Organizations parameter is set to Yes, then processing is done for all organizations having the same item master organization as the current organization. If All Organizations is set to No, and a value is provided in the Organization Hierarchy field, then processing is done for the current organization and all subordinate organizations. If the Organization Hierarchy field is left blank, then the ECO is implemented only for the current organization. For processing, an organization must be accessible by the user responsibility. You can specify a periodic schedule for the concurrent program. In this case, the user should set the processing interval, start date, and end date.

See Also

Engineering Profile Options and Security Functions: page 1 – 21

Starting the AutoImplement Manager: page 1 – 20

Implementation of ECOs on Discrete Jobs and Repetitive Schedules:
page 2 – 65

Creating Organization Hierarchies, *Using Oracle HRMS–The Fundamentals*

Canceling ECOs and Revised Items

You can cancel an entire ECO, a revised item on an ECO, or the individual revised components on an ECO before it is implemented. When you cancel an ECO, you can enter comments that explain the reason for cancellation.

Canceling an entire ECO cancels all the revised item changes and the changes to their associated revised components. Canceling a specific revised item cancels only the changes that affect that item and its revised components. Once you cancel an ECO you cannot update it, but you can view a cancelled ECO.

Canceling a revised component only affects that revised component for that revised item. The cancelled component can be viewed in the Cancellation tabbed region.

Prerequisites

- To cancel an ECO, the Engineering Change Orders: Cancel security function must be included as part of the responsibility.

► **To cancel the entire Engineering Change Order:**

1. Navigate to the Engineering Change Order window.
2. Find the ECO to cancel.
3. Choose Cancel from the Tools menu.
4. Save your work.
 - Cancel the ECO, its revised items, and the associated revised components by choosing Cancel from the Tools menu.
 - Cancel a revised item by choosing the Revised Items button on the Engineering Change Orders window, and choosing Cancel from the Tools menu.
 - Cancel a revised component by choosing the Components button from the Revised Items window and choosing Cancel from the Tools menu.
5. Save your work.

► **To cancel an ECO's revised items:**

1. Navigate to the Engineering Change Order window.
2. Find the ECO containing revised items to cancel.

3. Choose the Revised Items button.
4. Select the revised items to cancel.
5. Choose Cancel from the Tools menu.
6. Save your work.

► **To cancel components of a revised item:**

1. Navigate to the Engineering Change Order window.
2. Find the ECO containing components of revised items to cancel.
3. Choose the Revised Items button.
4. Select the revised item containing components to cancel.
5. Choose the Components button.
6. Select the components to cancel.
7. Choose Cancel from the Tools menu.
8. Save your work.

See Also

Creating an ECO: page 2 – 24

Material Requirements Planning, *Oracle Master Scheduling/MRP User's Guide*

Engineering Profile Options and Security Functions: page 1 – 21

Viewing ECO Schedules

View ECO information, including scheduling information, pending and implemented ECOs, approval status, revised item status, and so on.

► **To view ECO schedules:**

1. Navigate to the View ECOs folder window.
2. Enter search criteria in the Find ECOs window
3. Select how to sort ECOs—by ECO identifier then effective date, or by effective date then ECO identifier.
4. Optionally, enter revised item information:
 - an effective date range
 - a revised item
 - a revised component
 - whether to query for revised item status, and if so, any combination of revised item statuses.
5. Choose the Find button to find ECOs based on your search criteria.

This opens the View ECOs folder window which has three tabbed regions, each containing specific ECO information: Revised Items, ECO Details, and Use Up.
6. Choose the New and Open buttons to navigate to the Engineering Change Orders window. Using the New button enables you to create a new ECO; using the Open button enables you to view an existing ECO.

See Also

Using Query Find, *Oracle Applications User's Guide*

Using Query Operators, *Oracle Applications User's Guide*

Searching For Information, *Oracle Applications User's Guide*

Performing Query-by-Example and Query Count, *Oracle Applications User's Guide*

Defining Engineering Change Orders: page 2 – 23

Customizing the Presentation of Data in a Folder, *Oracle Applications User's Guide*

Engineering Change Order Schedule Report: page 4 – 7

Use Up ECOs

Oracle Master Scheduling/MRP automatically computes and stores the use-up date for each item it plans on each MRP plan. The use-up date is the date when on-hand quantity is exhausted based on projected gross requirements. It calculates the use-up date by applying any on-hand quantity in inventory (supply) against any gross requirements (demand). When calculating the date, it does not consider scheduled receipts or repetitive schedules as supply.

Revised Item Effective Dates Linked to Use-Up Dates

When you define a revised item on an ECO, you can base the revised item effective date on the use-up date of another item.

When you define a revised item on an ECO, you can select the use-up date for all components of the revised item and the use-up date of the revised item itself for all MRP plans that include those items. Doing so will default the plan name and use-up item. The revised item effective date is now linked to a use-up date.

Alternatively, for a revised item, you can select a use-up item, which can be any component of the revised item or the revised item itself. But since the plan name is not specified, the revised item effective date is *not* linked to a use-up date.

Use-Up Alerts

Engineering uses Oracle Alert to automatically notify planners whenever the MRP planning process computes a new use-up date for an item if it is a use-up item for an ECO revised item. For example, if revised item A specifies item B as its use-up item (so the revised item effective date for A equals B's use-up date), then if the MRP planning process computes a different use-up date for B, Oracle Alert notifies the planner for A that B's use-up date no longer equals the revised item effective date for A.

See Also

Material Planning Logic, *Oracle Master Scheduling/MRP User's Guide*
Reviewing the Horizontal Plan, *Oracle Master Scheduling/MRP User's Guide*

Creating an ECO: page 2 – 24

MRP Planning for ECOs

Oracle Master Scheduling/MRP lets you consider unimplemented ECOs when you plan material requirements and considers use-up date changes in some cases.

Unimplemented ECO Revised Items Planning

When you define an ECO, specify whether the MRP planning process should plan for an ECO revised item. This lets you order material and plan resources that you need to build a future revision in advance. When the MRP planning process explodes requirements for a planned order based on a planned order start date, it generates requirements considering component changes introduced on ECO revised items so specified.

Use-up ECOs Planning

The planning process automatically changes revised item effective dates and considers those new effective dates in the current MRP plan *only* when the use-up date changes and the revised item is the use-up item. The planning process then uses the updated effective date for component changes when it explodes requirements for planned orders.

See Also

Material Requirements Planning, *Oracle Master Scheduling/MRP User's Guide*

Unreleased Item Revisions in Oracle Work in Process

In Work in Process, you can open discrete jobs or schedules considering pending engineering changes. Each user can define a job with released, scheduled, and implemented engineering changes, but you can control whether a user or a responsibility can define a job considering unreleased engineering changes.

If you set the WIP: Exclude Open ECOs profile option to Yes, Work in Process sees the effects of *only* released, scheduled, and implemented ECO revised items when you choose a revision or revision date and when Work in Process explodes the bill of material. Work in Process also considers open (unreleased) ECOs if you set this profile option to No.

See Also

Overview of Discrete Manufacturing, *Oracle Work in Process User's Guide*

Overview of Repetitive Manufacturing, *Oracle Work in Process User's Guide*

Implementation of ECOs on Jobs and Schedules

You can indicate whether to update work in process requirements when you implement an ECO revised item. When you implement the revised item that is set to update work in process, the bill of material is automatically re-exploded and updated for all unreleased discrete jobs and repetitive schedules for the item.

If you have updated component material requirements for the unreleased job or schedule, you lose these updates after you implement the revised item.

Released, Complete, and On hold Repetitive Schedules

For repetitive schedules, if you have not moved assemblies beyond the Queue intraoperation step of the first operation, Work in Process automatically regenerates the bill and component requirements for the repetitive schedule to include the effects of the ECO.

If you have moved assemblies beyond the Queue intraoperation step of the first operation, when you implement the ECO, Work in Process splits the schedule into two schedules that take the place of the original

schedule. The first schedule uses the original bill and the second new schedule uses the revised bill that includes any revised item or component changes. Work in Process assigns the two new schedules a status of Released, Complete, or On hold, depending on the status of the original schedule.

The schedule splits based on the number of assemblies in process (moved past the Queue intraoperation step of the first operation if you are using routings) on the original routing. That number is rounded up to the nearest day so that you can finish your day's work using the original bill. The next day production starts using the revised bill and a new schedule.

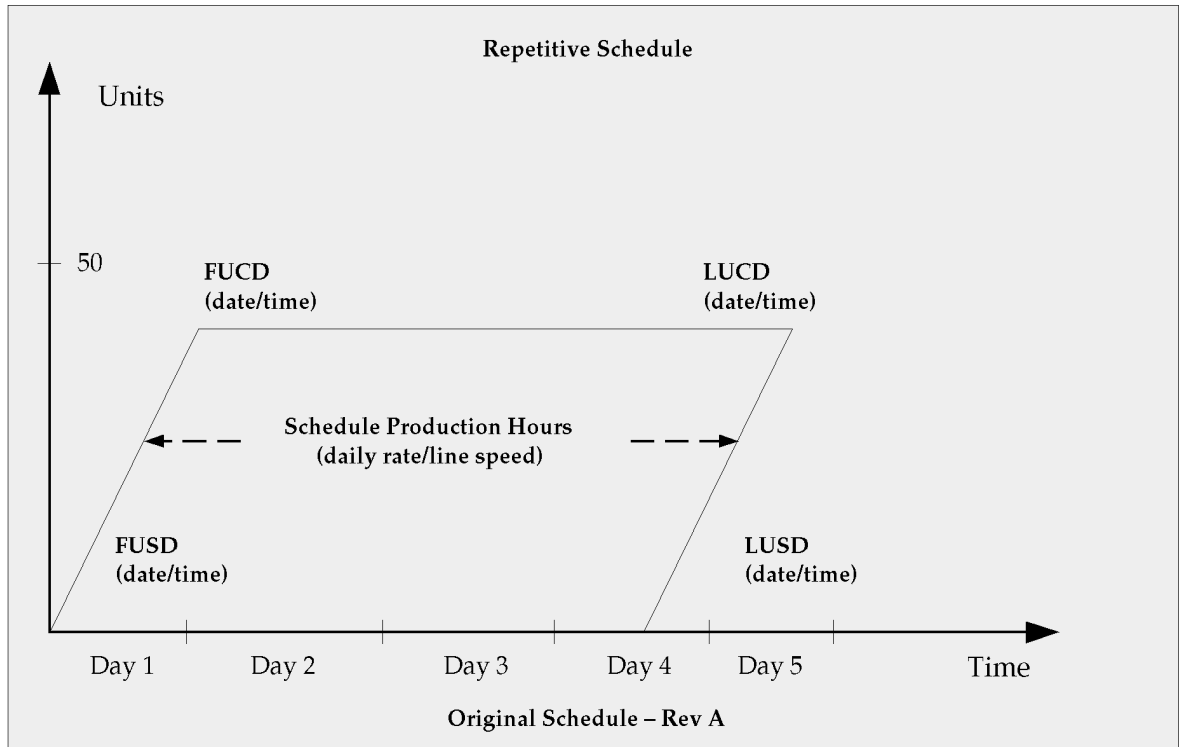
The following example best illustrates this procedure.

Example

Released Schedule:

- Production rate = 50 per day
- Process days = 4 days
- Total quantity of schedule = 200 units
- Throughput = 1 day

The following diagram illustrates the original schedule:



Shop floor distribution of assemblies before the implementation of the ECO for the original schedule:

- 80 units spread in the routing beyond queue of the first operation
- 120 units in queue of the first operation

Original schedule dates:

- First unit start date = Day 1
- First unit complete date = Day 2
- Last unit start date = Day 4
- Last unit complete date = Day 5

Since the daily quantity is 50, this means that production is in its second day. Therefore, if you implement the ECO now, the schedule splits after the second day's work is completed.

If you implement a change order for the item on Day 3 (Today), the shop floor distribution of assemblies following the implementation of the ECO are:

New Schedule 1 = 100 total units

- 20 units in queue of the first operation
- 80 units spread in the routing beyond queue of the first operation. These 80 units are located exactly where they were before the implementation of the ECO.

New Schedule 2 = 100 total units

- 100 units in queue of the first operation. The reason that there are only 100 assemblies and not 120 assemblies is that only two process days remain in the schedule; therefore, only two process days worth of assemblies can be put into new schedule 2.

Schedule dates following the implementation of the ECO:

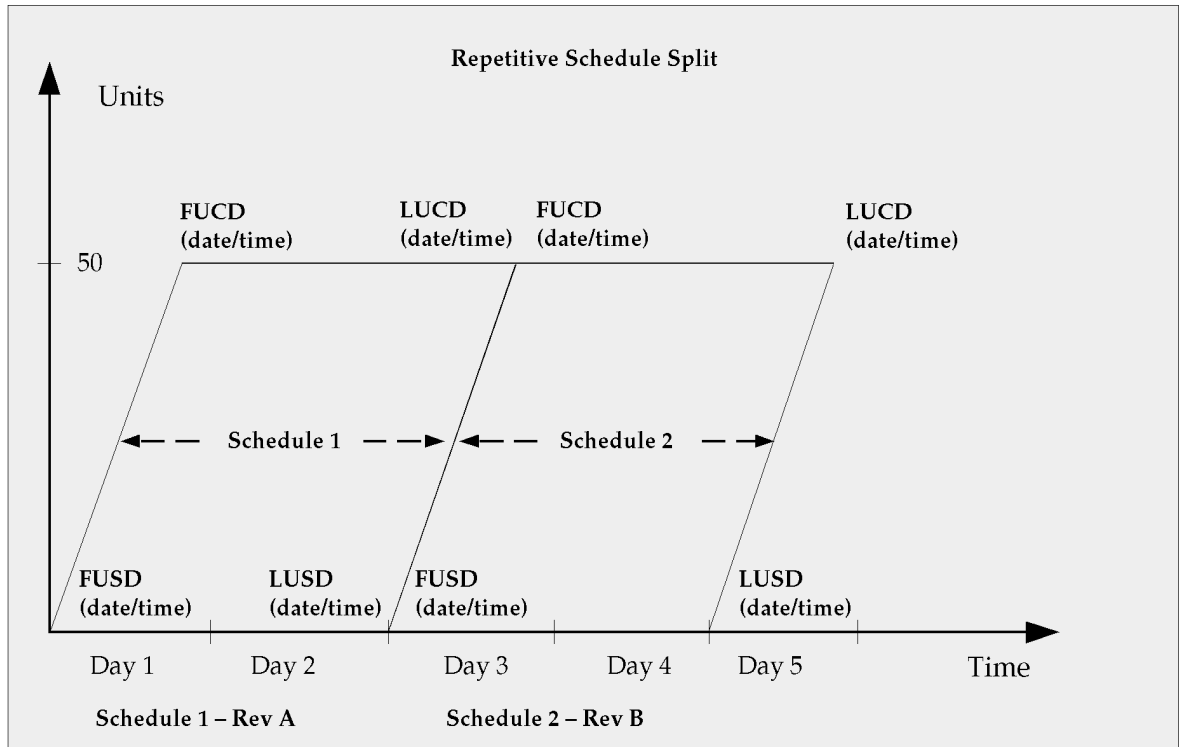
New Schedule 1:

- First unit start date = Day 1
- First unit complete date = Day 2
- Last unit start date = Day 2
- Last unit complete date = Day 3

New Schedule 2:

- First unit start date = Day 3
- First unit complete date = Day 4
- Last unit start date = Day 4
- Last unit complete date = Day 5

The following diagram illustrates the split schedule:



All material that you issued to the original schedule remains with new schedule 1. Material requirements for new schedule 1 are changed to match the new number of assemblies to complete. Material requirements for the altered assembly are exploded for new schedule 2 for the number of assemblies assigned to the new schedule 2.

See Also

Overview of Discrete Manufacturing, *Oracle Work in Process User's Guide*

Overview of Repetitive Manufacturing, *Oracle Work in Process User's Guide*

Purging ECOs

You can purge fully implemented engineering change information from the database. You can choose a range of ECOs and a date. Engineering purges all fully implemented or cancelled ECOs on or before that date.

When you purge ECOs, Engineering removes all implemented and cancelled ECOs as of that date from the database, along with all related information (except for the revision history of the bill itself). You cannot view or report ECO information once you purge it.

► **To purge an ECO:**

1. Navigate to the Purge Engineering Change Order window. See: *Submitting a Request, Oracle Applications User's Guide*.
2. Enter a range of ECOs to purge.
3. Indicate whether to purge implemented ECOs.
4. Indicate whether to purge cancelled ECOs.
5. Enter a date on or before which all implemented and/or cancelled ECOs are purged.

Engineering Change Orders Field Reference

This section describes the use of certain major fields.

ECO Statuses

Whenever this status is updated, the status of all revised items is also updated.

Open	The ECO is not complete; you can still make changes. MRP Active is defaulted to on.
Hold	The ECO cannot be implemented. The status of all pending revised items is set to Hold. MRP Active defaults to off.
Release	The entire ECO is released from the currently responsible ECO department. The status of all pending revised items is set to Released. MRP Active defaults to on.
Schedule	The ECO is scheduled for auto-implementation. An ECO can only have this status if the approval status is Approved. MRP Active defaults to on.
Implement	The ECO is implemented manually. You can no longer make changes to an implemented ECO.
Cancel	No more changes allowed. All unimplemented revised items are cancelled.

ECO Revised Item Statuses

These statuses are updated by changes to the ECO status.

Open	Changes to the revised item are still in process or not complete. The MRP active attribute will be updated to Yes. This is the default.
Hold	Changes to the revised item are on hold; you cannot implement them.

Release	Changes to the revised item have been released and can be implemented manually. The revised item has not been scheduled for auto-implementation.
Schedule	The revised item is scheduled for auto-implementation. You can only set the revised item to Schedule if the ECO status is Approved. The MRP active attribute is updated to on.
Implement	The revised item has been implemented manually or automatically. You cannot list additional changes for implemented revised items.
Cancel	The revised item has been cancelled.

ECO Approval Statuses

If you do not tie an Oracle Workflow process to the ECO, the only valid approval status is No Approval Needed.

Not Submitted for Approval	The ECO has not been submitted to the Workflow approval process.
Approval Requested	Engineering has started the Workflow process.
Rejected	Cannot schedule or implement the ECO or any revised items.
Approved	Approved for release, to schedule, or to implement.
Processing Error	Indicates that an error occurred while Workflow was processing the ECO approval.

Disposition Field

These values describe the disposition of inventory and work in process inventory affected by an engineering change order (ECO).

No change required	The ECO does not affect the revised item in WIP and inventory. This is the default.
Scrap WIP and inventory	Scrap the revised item in WIP and inventory when you implement the revised item.
Scrap only inventory	Scrap the revised item only in inventory when you implement the revised item.
Scrap only WIP	Scrap the revised item only in WIP when you implement the revised item.
Rework inventory and WIP	Rework the revised item in WIP and inventory when you implement the revised item.
Rework only inventory	Rework the revised item only in inventory when you implement the revised item.
Rework only WIP	Rework the revised item only in WIP when you implement the revised item.
Exhaust WIP and inventory	Use the revised item until you exhaust WIP and inventory for the item.
Exhaust only WIP	Use the revised item until you exhaust WIP for the item.
Exhaust on serial number	Use the revised item until it reaches a particular serial number.

CHAPTER

3

Engineering Prototypes

This chapter tells you everything you need to know about using engineering prototypes, including:

- Overview of Engineering Prototype Environment: page 3 – 2
- Engineering Bills of Material and Routings: page 3 – 5
- ECOs on Engineering Items and Bills: page 3 – 6
- Transferring or Copying Engineering Items, Bills, and Routings: page 3 – 8

Overview of Engineering Prototype Environment

Oracle Engineering enables you to move toward concurrent engineering by integrating engineering prototype data with manufacturing data. Each department that accesses engineering item information can perform the same functions on prototypes as all departments do for manufactured assemblies. With engineering item information, you can separate released product designs, controlled distribution products, and alternate manufacturing methods for existing products from your manufacturing data.

Engineering enables you to create engineering items, bills of material and routings the same way you define manufacturing item information.

Note: This does not apply to Product Families. See:

Each item defined in Engineering is assigned to engineering. You can define engineering items and assign item attribute details as you do for manufacturing items. You can perform any function with an engineering item that you do for a manufacturing item, including:

- revision control
- track inventory
- value inventory transactions
- rollup costs
- update frozen standard costs
- plan in MPS and MRP
- sell on customer orders
- purchase on purchase orders
- build in WIP and issue to a WIP job

Item Catalog for Group Technology

When you design new products, search for existing items that meet your requirements before you define a new engineering item. Doing so can help prevent duplicate items. When you define an engineering or manufacturing item, you can classify the item by any number of characteristics.

For example, you can catalog manufacturing items and engineering items by three descriptive elements—*form*, *fit*, and *function*. Before you create a new engineering item, search the item catalog for all items that

match any combination of these elements, such as "heated plastic" and "fastener". You can further restrict your search with other item details, including organization, item type, item category, and item status. If an item that meets your search criteria does not exist, you can create a new engineering item and assign the values of "heated plastic" to *form* and "fastener" to *function*. See: Overview of Item Catalogs, *Oracle Inventory User's Guide*.

Engineering Item Status

You can define item statuses for each phase of your product life cycle. Engineering enables you to control engineering item attribute information by item status, so you can manage the introduction of new products. For example, you may define an item status "Design Released" and assign this status to all engineering product designs released from Design Engineering to your organization. You can control a "Design Released" item so that it cannot be built, purchased, or sold. As your product design matures, you can assign an item status of "Alpha" to your item so you can build or purchase it, but not include it on customer orders. After the product design and process stabilize, you may assign a "Beta" item status to your item so you can build, purchase, and sell the item in small quantities. See: Defining Item Status Codes, *Oracle Inventory User's Guide*.

Engineering Item Costing

You can specify item costs, roll up costs, and update frozen standard costs for engineering items. When you assign item costs, you can specify cost elements, sub-elements, activities, basis and rates, the same way you assign costs for manufacturing items. Oracle Cost Management lets you roll up and update manufacturing and engineering item costs by item, category, or across all items. After you assign, roll up, and update item costs, you can review cost information for all cost types available to engineering. You can restrict access to item cost details in Engineering by cost type.

Engineering Item Purchasing

For each engineering item you define, you can enable the item for use in Oracle Purchasing. To include engineering items on your purchase orders and requisitions, you can assign default buyer, supplier, price tolerance, and account information the same way you assign purchasing details to manufacturing items. You can receive, return, or adjust engineering items the same way you receive manufacturing

items on purchase orders. For costed engineering items, you can track purchase price and compute purchase price variance the same way you cost other purchased items. With item status control, Engineering also enables you to control purchasing functions at any point in an engineering item's life cycle.

Engineering Item Planning

Engineering enables you to plan engineering items in Oracle Master Scheduling/MRP the same way you plan manufacturing items. When you define an engineering item, you can assign a MPS/MRP planning method, planning time fence, shrinkage rate, and other planning details. In Master Scheduling/MRP, you can forecast engineering items and manufacturing items, load forecast details, and consume forecasts with existing sales orders. Master Scheduling/MRP computes material requirements for engineering and manufacturing items using the master schedule, engineering or manufacturing bills of material, scheduled receipts, and inventory information. You can also control planning functions for engineering items by item status to track an engineering item's life cycle. See: *Overview of Forecasting, Oracle Master Scheduling/MRP User's Guide* and *Two-Level Master Scheduling, Oracle Master Scheduling/MRP User's Guide*.

Discrete Jobs for Engineering Items

When you define an engineering item, you can enable the item for use in Oracle Work in Process. To build an engineering assembly or prototype a new process, you define a discrete job using an engineering bill of material or routing. You can issue engineering and manufacturing items to jobs, as well as collect resource, material, and overhead costs based on an engineering routing. You can place finished engineering assemblies into inventory the same way you place manufacturing assemblies into inventory. To track an engineering item's life cycle, you can update item status and control when to build an engineering item or prototype a new process in Work in Process.

Item Types and Bill of Material Types

Each item can be identified as an engineering item and enabled for use in Engineering using two item master attributes, Engineering Item and BOM Item Type. The BOM Allowed item attribute must also be set to Yes.

The Engineering Item attribute indicates whether the item exists in engineering. If not, it is a manufacturing item. This attribute is not updatable when defining the engineering item. When an item is transferred to manufacturing, the Engineering Item attribute is disabled.

You can enable any item for use in Engineering when you assign one of the following four values for the BOM Item Type item attribute: standard, model, option class, or planning.

You can define an engineering item and an engineering bill of material for a manufacturing item enabled in Oracle Bills of Material, but you cannot define manufacturing bills of material for engineering items.

See Also

Overview of Bills of Material, *Oracle Bills of Material User's Guide*

Bill of Material Types, *Oracle Bills of Material User's Guide*

Creating a Bill of Material, *Oracle Bills of Material User's Guide*

Overview of Routings, *Oracle Bills of Material User's Guide*

Creating a Routing, *Oracle Bills of Material User's Guide*

Access Control by Item Type, *Oracle Bills of Material User's Guide*

Deleting Items, Bills, Routings, Components, and Operations, *Oracle Bills of Material User's Guide*

Creating Custom Deletion Constraints, *Oracle Bills of Material User's Guide*

Defining Items, *Oracle Inventory User's Guide*

Engineering Bills of Material and Routings

You can define an engineering bill of material or routing as alternates for a manufacturing bill or routing. This enables you to prototype variations from the primary bill of material that produce the same assembly.

You can specify a list of item catalog descriptive elements for model and option class engineering bills. After you release the engineering bill to manufacturing and take customer orders for specific configurations, Bills of Material creates the new configuration item and automatically assigns values to each catalog descriptive element.

Engineering lets you assign manufacturing and engineering items as components to the engineering bill of material.

Each routing you define can exist either in engineering or in manufacturing, and both engineering and manufacturing routings share the same resource, department, and standard operation information.

You can calculate manufacturing and cumulative lead times for engineering items.

See Also

Overview of Bills of Material, *Oracle Bills of Material User's Guide*

Creating a Bill of Material, *Oracle Bills of Material User's Guide*

Primary and Alternate Bills of Material, *Oracle Bills of Material User's Guide*

Overview of Routings, *Oracle Bills of Material User's Guide*

Creating a Routing, *Oracle Bills of Material User's Guide*

Assigning Descriptive Elements, *Oracle Bills of Material User's Guide*

Lead Time Management, *Oracle Bills of Material User's Guide*

ECOs on Engineering Items and Bills

Engineering enables you to define engineering change orders (ECOs) for manufacturing and engineering items. You can also mass change engineering bills of material the same way you manage mass changes to manufacturing bills of material.

ECO Types

Engineering controls the access to ECOs and the changes you can specify on an ECO. For each ECO type, you can specify if ECOs of this type can update engineering items. Only users whose profile option indicates they can update engineering items can choose ECO types that update engineering item information. If you define a new bill of material using an ECO with an ECO type that updates engineering items, Engineering creates the bill as an engineering bill when you implement the ECO.

Profile Options

Engineering uses the following four profile options to control the types of items you can change on an ECO:

- ENG: Engineering Item Change Order Access (engineering items)
- ENG: Model Item Change Order Access (model and option class items)
- ENG: Planning Item Change Order Access (planning items)
- ENG: Standard Item Change Order Access (standard items)

See Also

Creating an ECO: page 2 – 24

Defining ECO Types: page 1 – 9

Engineering Profile Options and Security Functions: page 1 – 21

Transferring or Copying Engineering Items, Bills, and Routings

You must transfer an engineering item prior to, or simultaneously with, its engineering bill of material and/or routing. When copying items, bills, and routings, all information must be copied simultaneously.

Note: Engineering does not transfer or copy an item, bill, or routing if it already exists in manufacturing. Also, information transferred to manufacturing is still available to engineering; it is not copied.

Transferring and copying engineering data is organization specific. That is, you can only transfer or copy an engineering item, bill, or routing to manufacturing within the same organization.

Engineering Items

All information associated with the engineering item is transferred or copied.

If you copy an engineering item, you must provide a new name and description. The original item information is retained in engineering.

When you transfer an engineering item assigned to a category set different from the inventory category set, Engineering automatically assigns the new manufacturing item to the inventory category set. Engineering also enables you to assign a new item revision and lets you reference an ECO when you transfer an engineering item.

Engineering Bills of Material

All bill information—including all engineering item components on a single level bill for an item is transferred (or copied). For multiple levels of engineering item components, you must transfer each engineering bill level by level, starting from the lowest level.

You can assign a new item revision and reference an ECO when you transfer an engineering bill of material. When you transfer an engineering bill of material, you can specify whether to transfer all components, current effective components, or current and future effective components. You can also specify whether to transfer pending component information from an ECO.

With this transfer criteria, Engineering transfers all engineering items that meet your criteria and that are components on the single level bill of material. For bills of material that reference a common engineering bill, you must transfer the common bill to manufacturing before you transfer any engineering bills that reference the common bill.

Engineering Routings

When you transfer a bill of material without transferring the engineering routing, all components on the manufacturing bill report to the operation sequence 1, regardless of the operations on the engineering routing. If components of the bill of material overlap (the same component item appears twice) at operation sequence one, Engineering does not transfer the engineering bill of material until you also transfer the engineering routing. If you transfer the engineering bill of material and routing simultaneously, components on the manufacturing bill report to the appropriate operation on the manufacturing routing.

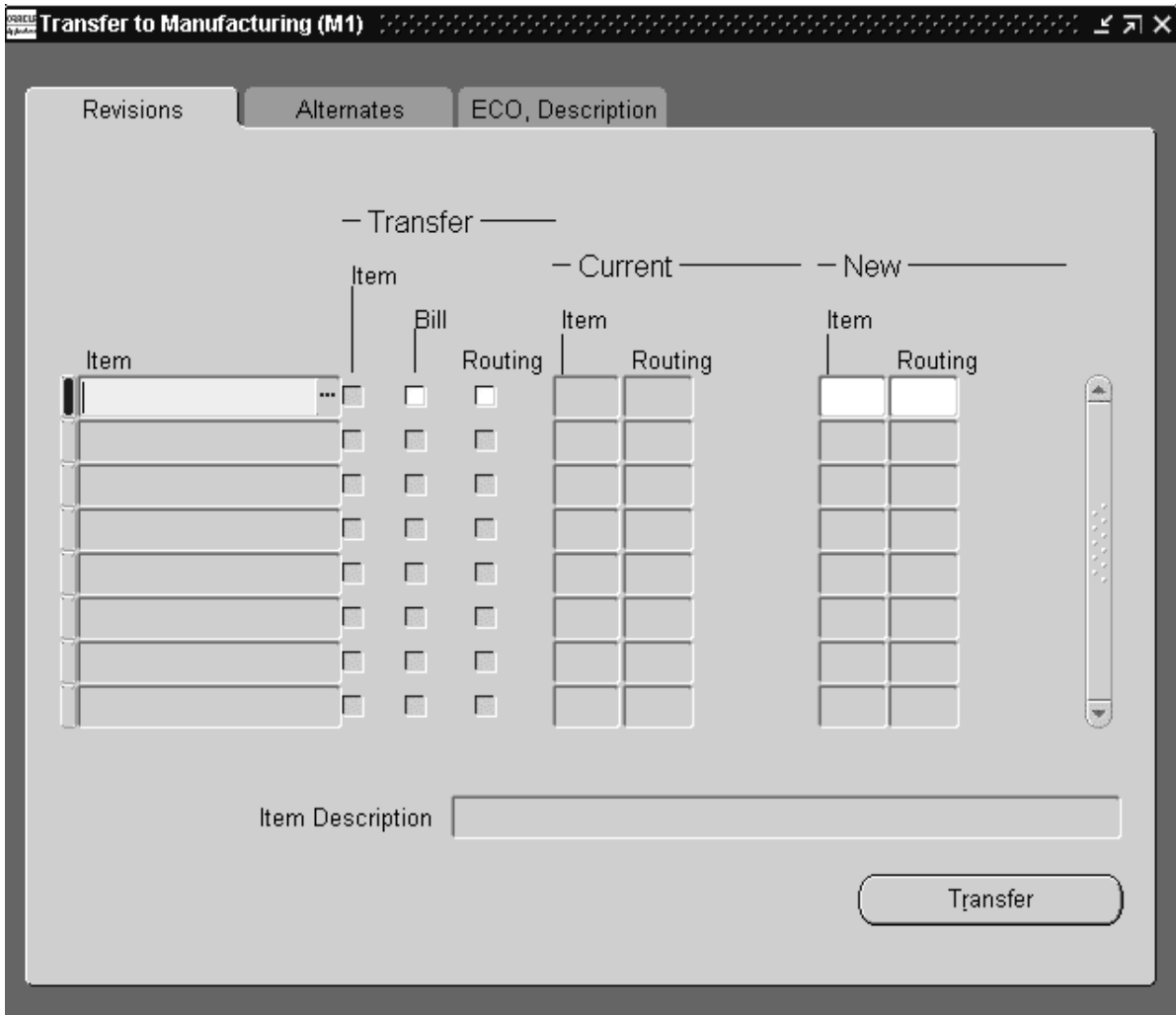
When you transfer a routing, you can also specify a new routing revision and reference an ECO. Engineering transfers all operations, current effective operations, or future effective operations depending on your transfer criteria. For routings that reference a common engineering routing, you must transfer the common routing to manufacturing before you transfer any engineering routings that reference the common routing.

Prerequisites

- You can only transfer, or copy, standard, model, option class, or planning items, bills, or routings if you have access to them. See: Engineering Profile Options and Security Functions: page 1 – 21.

► **To transfer or copy engineering items data to manufacturing:**

1. Navigate to the Transfer to Manufacturing window.



2. Enter an item and indicate whether to transfer (or copy) item, bill, and routing data (if applicable).

Note: When copying an engineering bill to manufacturing, you must copy the item simultaneously with its bill and/or routing.

3. Optionally, enter a new item or routing revision (if applicable).

The revision must be higher than the current revision (as shown) and can be alphanumeric.

4. Optionally, open the Alternates tabbed region and for Selection, select Specific to transfer (or copy) a specific alternate, select Primary to transfer the primary alternate, or select All to transfer all alternates.

Leaving this blank will transfer (or copy) the primary and all alternates (if any).

To transfer (or copy) a specific alternate, you must enter its name.

5. Open the ECO, Description tabbed region and enter an ECO. This is for informational purposes only.
6. If you are copying data, you must open the Manufacturing Items tabbed region and enter a new item name and description.
7. If you are transferring (or copying) bills, indicate if only implemented components should be transferred.
8. Select whether to transfer (or copy) All past, Current (effective on the specified revision date), or Future components and/or operation steps associated with the assembly. The default is Current.

If you select Current or Future and Current, enter an effective date.

9. Choose the Transfer (or Copy) button.

See Also

Copying Bill and Routing Information, *Oracle Bills of Material User's Guide*

Transfer or Copy from an ECO: page 2 – 10

Transfer items to manufacturing from an ECO: page 2 – 50

Copy items to manufacturing from an ECO: page 2 – 52

CHAPTER

4

Reports

This chapter describes Oracle Engineering reports. Each description includes a sample report, with a description of submission parameters.

Engineering Change Order Approval Lists Report

This report lists the approvers for engineering change orders (ECOs). When you change the approval status of an ECO to Ready to Approve, Oracle Alert automatically sends an alert to each approver on the list indicating that an ECO awaits their approval.

Report Submission

In the Submit Requests window, select Engineering Change Order Approval Lists Report in the Name field.

Report Parameters

Approval List Names From/To (Optional) [ZOOM PICK HELP](#)

To restrict the report to a range of approval list names, select beginning and ending approval list names.

See Also

Submitting a Request, *Oracle Applications User's Guide*

Engineering Change Order Detail Report

This report contains current or historical engineering change order (ECO) information. You can sort the report by engineering change notice or creation date. You can report all changes, current pending changes, or historical changes. You can run the report for all engineering change notices or for a range.

Report Submission

In the Submit Requests window, select Engineering Change Order Detail Report in the Name field.

Report Parameters

All Organizations (Optional) **HELP**

Choose one of the following options:

- | | |
|------------|---|
| <i>No</i> | Report ECO information for the current organization. |
| <i>Yes</i> | Report ECO information for all organizations having the same item master organization as the current organization, and for those organizations accessible by the user responsibility. |

Organization Hierarchy (Optional) **HELP**

Enter a valid organization hierarchy name from the list of values. If the value for the All Organizations parameter is set to No, and you have provided a value for the Organization Hierarchy parameter, then the report will provide ECO information for the current organization and all organizations below the current organization in the specified organization hierarchy. If this parameter is left blank, and the All Organizations parameter is set to No, then the report will provide ECO information for the current organization. You can enter a value in this field only if you have entered No in the All Organizations field.

Engineering Change Orders From/To

To restrict the report to a range of engineering change orders, select the beginning and ending engineering change orders.

Dates From/To

(Optional)

HELP

To restrict the report to a range of dates, select the beginning and ending dates.

Status

(Optional)

PICK HELP

Enter Open, Hold, Scheduled, Cancelled, Implemented, or Released to indicate the status of the ECO to print. See: ECO Statuses: page 2 – 71.

Additional Component Detail

Enter Yes or No to indicate whether to print ECO component detail.

Order Entry Component Detail

Enter Yes or No to indicate whether to print ECO order entry component detail.

See Also

Creating Organization Hierarchies, *Using Oracle HRMS–The Fundamentals*

Submitting a Request, *Oracle Applications User's Guide*

Engineering Change Order Priorities Report

This report lists engineering change order (ECO) priorities that you defined for Oracle Engineering. ECO priorities enable you to specify the urgency of your ECO. Engineering uses ECO priorities for reference only.

Report Submission

In the Submit Requests window, select Engineering Change Order Priorities Report in the Name field.

See Also

Submitting a Request, *Oracle Applications User's Guide*

Engineering Change Order Reasons Report

This report lists the engineering change order (ECO) reasons that you defined for Oracle Engineering. You can use engineering change reasons to categorize your ECOs. Engineering uses ECO reasons for reference only.

Report Submission

In the Submit Requests window, select Engineering Change Order Reasons Report in the Name field.

See Also

Submitting a Request, *Oracle Applications User's Guide*

Engineering Change Order Schedule Report

This report lists pending engineering change order (ECO) schedule information up to a specified date. You can run the report for all ECOs or for a range.

Report Submission

In the Submit Requests window, select Engineering Change Order Schedule Report in the Name field.

Report Parameters

Print Components (Required, Default) [ZOOM PICK HELP](#)

Enter either Yes or No to indicate whether you want to print revised components associated with the revised item.

Engineering Change Order Type

Enter an engineering change order type to print engineering change orders associated with it.

Engineering Change Orders From/To

To restrict the report to a range of Engineering Change Orders, select the beginning and ending Engineering Change Orders.

Effective Dates From/To (Optional) [ZOOM HELP](#)

To restrict the report to a range of dates, select the beginning and ending dates.

Revised Item Status (Optional) [ZOOM PICK HELP](#)

Enter Open, Hold, Scheduled, Cancelled, Implemented, or Released to indicate the status of the revised item to print.

Display Option (Required, Default) [ZOOM PICK HELP](#)

Choose one of the following options:

<i>All</i>	Report the pending and implemented engineering change orders.
<i>Historical changes</i>	Report the implemented engineering change orders.
<i>Pending changes</i>	Report the current engineering change orders. Oracle Engineering displays this option as the default.

Revised Item (Optional, Flexfield) **ZOOM HELP**

Enter a revised item to print.

Revised Component (Optional, Flexfield) **ZOOM HELP**

Enter a revised component to print.

Sort Criteria 1 (Required, Default) **ZOOM PICK HELP**

Choose one of the following options. The report sorts ECOs first in this order, then in the specified order for Sort Criteria 2 and Sort Criteria 3.

<i>ECO</i>	Sort ECOs first by ECO. Oracle Engineering displays this option as the default.
<i>Effective date</i>	Sort ECOs first by effective date.
<i>Item number</i>	Sort ECOs first by item number.

Sort Criteria 2 (Required, Default) **ZOOM PICK HELP**

Choose one of the following options. Engineering sorts the ECOs by the first sort type and then by this sort type within the first type.

<i>ECO</i>	Sort ECOs by ECO.
<i>Effective date</i>	Sort ECOs by effective date.
<i>Item number</i>	Sort ECOs by item number. Oracle Engineering displays this option as the default.

Choose one of the following options. Engineering sorts the ECOs by the first sort type, then by the second sort type within the first type, and finally by this sort type within the second type.

ECO

Sort ECOs by ECO.

Effective date

Sort ECOs by effective date. Oracle Engineering displays this option as the default.

Item number

Sort ECOs by item number.

See Also

Submitting a Request, *Oracle Applications User's Guide*

Engineering Change Order Types Report

This report lists the change orders types that determine the types of items and bills of material you can modify on engineering and mass change orders.

Report Submission

In the Submit Requests window, select Engineering Change Order Types Report in the Name field.

See Also

Submitting a Request, *Oracle Applications User's Guide*

APPENDIX

A

Windows and Navigator Paths

This appendix shows you the default navigator path for each Oracle Engineering window. Refer to this appendix when you do not already know the navigator path for a window you want to use.

Engineering Windows and Navigator Paths

For windows described in other manuals:

See...	Refer to this manual for a complete window description.
BOM	<i>Oracle Bills of Material User's Guide</i>
CAP	<i>Oracle Capacity User's Guide</i>
CST	<i>Oracle Cost Management User's Guide</i>
Flex	<i>Oracle Applications Flexfields Manual</i>
GL	<i>Oracle General Ledger User's Guide</i>
HR	<i>Oracle Human Resources User's Guide</i>
PO	<i>Oracle Purchasing User's Guide</i>
MRP	<i>Oracle Master Scheduling/MRP User's Guide</i>
SYS	<i>Oracle System Administrator's Guide</i>
User	<i>Oracle Applications User's Guide</i>

Text in brackets ([]) indicates a button.

The following table presents window names and navigation paths.

Engineering Responsibility

Window Name	Navigation Path
Approval History: page 2 – 27	ECOs > ECOs > [Approvals]
Approval Dates: page 2 – 27	ECOs > ECOs > [Special] > View Dates
Approval Lists: page 1 – 17	Setup > Approval Lists
Assign Cross Reference Types (See INV)	Prototypes > Items > Cross References > [Assign]
Bill Components Comparison (See BOM)	Prototypes > Bills > Comparison

Window Name	Navigation Path
Bill Details (See BOM)	Prototypes > Bills > Bills > [Bill Details]
Bill Documents (See BOM)	Prototypes > Bills > Documents
Bills of Material (See BOM)	Prototypes > Bills > Bills
Calculate Lead Times (See BOM)	Prototypes > Routings > Lead Times
Change Types: page 1 – 9	Setup > Change Types
Change Type Processes: page 1 – 9	Setup > Change Types > [Processes]
Component Changes: page 2 – 56	ECOs > Mass Changes > [Changes]
Component Changes (See BOM)	Prototypes > Bills > Mass Changes > [Changes]
Copy to Manufacturing: page 3 – 8	Copy to Manufacturing
Cross Reference Types (See INV)	Prototypes > Items > Cross References
Deletion Constraints (See BOM)	Setup > Delete Constraints
Departments (See BOM)	Prototypes > Routings > Departments
Descriptive Elements (See BOM)	Prototypes > Bills > Bills > [Elements]
ECO Autonumbering: page 1 – 11	Setup > AutoNumbering
ECO Department (See HR)	Setup > ECO Department
ECO Priorities: page 1 – 14	Setup > Priorities
Engineering Change Orders: page 2 – 23	ECOs > ECOs ECOs > Schedules
Engineering Master Item (See INV)	Prototypes > Items > Master Items

Window Name	Navigation Path
Engineering Organization Item (See INV)	Prototypes > Items > Organization Items
Enter Person (See HR)	Setup > Employees
History: page 2 – 37	ECOs > ECOs > [Revised Items] > [History]
Import Bills and Routings (See BOM)	Prototypes > Bills > Import
Indented Bill of Material (See BOM)	Prototypes > Bills > Indented Bills
Item Attributes (See INV)	Prototypes > Items > View Item Details > [Attributes]
Item Catalog Groups (See INV)	Prototypes > Items > Catalog Groups
Item Documents (See User)	Prototypes > Items > Documents
Item Relationships (See INV)	Prototypes > Items > Related Items > [Find]
Item Revisions: page 2 – 39	ECOs > ECOs > [Revised Items] > [Revisions]
Item Revisions (See BOM)	Prototypes > Bills > Bills > [Revision]
Item Search (See INV)	Prototypes > Items > Item Search > [Find]
Item Template (See INV)	Prototypes > Items > Item Template > [Find] > Item Templates Summary > [Open]
Item WhereUsed (See BOM)	Prototypes > Bills > Item WhereUsed
Mass Change Bills: page 2 – 56	ECOs > Mass Changes
Operation Resources (See BOM)	Prototypes > Routings > Routings > [Operation Resources]
Reasons: page 1 – 16	Setup > Reasons
Reference Designators: page 2 – 49	ECOs > ECOs > [Revised Items] > [Components] > [Designators]
Reference Designators (See BOM)	Prototypes > Bills > Bills > [Designators]

Window Name	Navigation Path
Resources (See BOM)	Prototypes > Routings > Resources
Resource WhereUsed (See BOM)	Prototypes > Routings > Resource WhereUsed
Revised Components: page 2 – 46	ECOs > ECOs > [Revised Items] > [Components]
Revised Items: page 2 – 32	ECOs > ECOs > [Revised Items]
Routing Details (See BOM)	Prototypes > Routings > Routings > [Routing De- tails]
Routing Documents (See BOM)	Prototypes > Routings > Documents
Routing Revisions (See BOM)	Prototypes > Routings > Routings > [Routing Revi- sions]
Routings (See BOM)	Prototypes > Routings > Routings
Standard Operations (See BOM)	Prototypes > Routings > Standard Operations
Start AutoImplement Manager: page 1 – 20	Setup >AutoImplement
Substitute Components: page 2 – 48	ECOs > ECOs > [Revised Items] > [Components] > [Substitutes]
Substitute Components (See BOM)	Prototypes > Bills > Bills > [Substitutes]
Transfer to Manufacturing: page 3 – 8	Transfer to Manufacturing
View ECOs: page 2 – 62	ECOs > Schedules

Oracle Engineering Character Mode Forms and Corresponding GUI Windows

The following table matches character mode forms with their corresponding GUI windows or processes. This information supplements *Windows and Navigator Paths* in the product online documentation. Text in brackets ([]) indicates a button.

The GUI Navigator paths are based on the Engineering responsibility.

The following table presents more information on any window, navigate to the window and choose the help icon.

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
Assign Key Flexfield Security Rules \Navigate Setup Flexfields Key Security Assign	Assign Security Rules Navigator: Setup > Flexfields > Key > Security > Assign
Assign Security Rules \Navigate Setup Flexfields Validation Security Assign	Assign Security Rules Navigator: Setup > Flexfields > Validation > Security > Assign
Bill of Material Comparison Report \Navigate Report Bill Compare	Bill Components Comparison Navigator: Prototypes > Bills > Comparison
Bill of Material Loop Report \Navigate Report Bill LoopCheck	Engineering Bill Reports Navigator: Reports > Bills
Bill of Material Structure Reports \Navigate Report Bill Structure	Engineering Bill Reports Navigator: Reports > Bills
Calculate Lead Times \Navigate Prototype Leadtimes	Calculate Lead Times Navigator: Prototypes > Routings > Lead Times
Change Organization \Navigate Other ChangeOrg	Organization Navigator: Other > Organization
Define Change Order Types \Navigate Setup ECO Types	Change Types Navigator: Setup > Change Types
Define Cross-Validation Rule \Navigate Setup Flexfields Key Rules	Cross-Validation Rules Navigator: Setup > Flexfields > Key > Rules

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
Define Descriptive Flexfield Segments \Navigate Setup Flexfields Descriptive Segments	Descriptive Flexfield Segments Navigator: Setup > Flexfields > Descriptive > Segments
Define Descriptive Security Rule \Navigate Setup Flexfields Descriptive Security Define	Define Security Rules Navigator: Setup > Flexfield > Descriptive > Security > Define
Define Descriptive Segment Values \Navigate Setup Flexfields Descriptive Values	Segment Values Navigator: Setup > Flexfields > Descriptive > Values
Define ECO Approval Lists \Navigate Setup ECO ApprovalLists	Approval Lists Navigator: Setup > Approval Lists
Define ECO Autonumbering \Navigate Setup ECO AutoNumbering	ECO Autonumbering Navigator: Setup > AutoNumbering
Define ECO Departments \Navigate Setup ECO Department	Define ECO Department Navigator: Setup > ECO Department
Define ECO Priorities \Navigate Setup ECO Priorities	ECO Priorities Navigator: Setup > Priorities
Define ECO Reasons \Navigate Setup ECO Reasons	Reasons Navigator: Setup > Reasons
Define Employees \Navigate Setup Employee	Enter Person Navigator: Setup > Employees
Define Engineering Bill of Material \Navigate Prototype Define Bill	EngineeringBills of Material Navigator: Prototypes > Bills > Bills

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
Define Engineering Change Order \Navigate ECO Define	Engineering Change Orders Navigator: ECOs > ECOs or Approval History Navigator: ECOs > ECOs > [Approvals] or Approval Dates Navigator: ECOs > ECOs. From the Tools menu choose View Dates or ECO Revisions Navigator: ECOs > ECOs > [ECO Revisions] or View Reference Designators Navigator: ECOs > ECOs > [Revised Items] > [Components] > [Designators] or View Substitute Components Navigator: ECOs > ECOs > [Revised Items] > [Components] > [Substitutes]
Define Engineering Item \Navigate Prototype Define Item Item	Engineering Master Item Navigator: Prototypes > Items > Master Items or Engineering Organization Item Navigator: Prototypes > Items > Organization Items
Define Engineering Item Revision \Navigate Prototype Define Item Revision	Item Revisions Navigator: Prototypes > Bills > Bills > [Revision]
Define Engineering Routing \Navigate Prototype Define Routing	Engineering Routings Navigator: Prototypes > Routings > Routings or Routing Details Navigator: Prototypes > Routings > Routings > [Routing Details]

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
Define Item Catalog Groups \Navigate Prototype Inventory Catalog Define	Item Catalog Groups Navigator: Prototypes > Items > Catalog Groups
Define Item Cross-References \Navigate Prototype Inventory Cross-Reference	Assign Cross Reference Navigator: Prototypes > Items > Cross References > [Assign]
Define Item Relationships \Navigate Prototype Inventory RelatedItems	Item Relationships Navigator: Prototypes > Items > Related Items > [Find]
Define Item Template \Navigate prototype Inventory Template	Item Template Navigator: Prototypes > Items > Templates > [Find] > Item Templates Summary > [Open]
Define Key Flexfield Security Rule \Navigate Setup Flexfields Key Security Define	Define Security Rules Navigator: Setup > Flexfields > Key > Security > Define
Define Key Flexfield Segments \Navigate Setup Flexfields Key Segments	Key Flexfield Segments Navigator: Setup > Flexfields > Key > Segments
Define Key Segment Values \Navigate Setup Flexfields Key Values	Segment Values Navigator: Setup > Flexfields > Key > Values
Define Rollup Groups \Navigate Setup Flexfields Key Groups	Rollup Groups Navigator: Setup > Flexfields > Key > Groups
Define Security Rule \Navigate Setup Flexfields Validation Security Define	Define Security Rules Navigator: Setup > Flexfields > Validation > Security > Define
Define Segment Values \Navigate Setup Flexfields Validation Values	Segment Values Navigator: Setup > Flexfields > Validation > Values
Define Shorthand Aliases \Navigate Setup Flexfields Key Aliases	Shorthand Aliases Navigator: Setup > Flexfields > Key > Aliases
Define Value Set \Navigate Setup Flexfields Validation Set	Value Sets Navigator: Setup > Flexfields > Validation > Sets
Delete Item Information \Navigate Prototype Delete	Engineering Deletion Groups Navigator: Delete Item Report

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
Delete Items Report \Navigate Report Delete	Delete History Report Navigator: Reports > Delete Groups
Engineering Change Order Reports \Navigate Report ECO	Engineering Change Order Reports Navigator: Reports > ECOs
Engineering Setup Reports \Navigate Reports Setup	Engineering Setup Reports Navigator: Reports > Setup
Implement Engineering Change Orders \Navigate ECO Implement	Engineering Change Orders Navigator: ECOs > ECOs
Item Cost Information Report \Navigate Report ItemCosts	Item Cost Information Report Use the Cost Management responsibility Navigator: Report > Cost > Item
Item Reports \Navigate Report Item	Engineering Item Reports Navigator: Reports > Items
Mass Change Bills of Material \Navigate ECO MassChange	Mass Change Bills Navigator: ECOs > Mass Changes
Purge Engineering Change Orders \Navigate ECO Purge	Purge Engineering Change Orders Navigator: ECOs > Delete
Routing Reports \Navigate Reports Routing	Engineering Routing Reports Navigator: Reports > Routings
Run Reports \ Navigate Report	Submit Request window See: Submit Requests (<i>Oracle Applications User's Guide</i>) Navigator: Reports > Run
Search Items \Navigate Prototype Inventory Catalog Search	Item Search Navigator: Prototypes > Items > Item Search > [Find]
Start AutoImplement Manager \Navigate Setup AutoImplement	Start AutoImplement Manager Navigator: Setup >AutoImplement
Transfer Engineering Data to Manufacturing \Navigate Prototype Transfer	Copy to Manufacturing Navigator: Prototypes > Copy to Manufacturing or Transfer to Manufacturing Navigator: Protoypes > Transfer to Manufacturing

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
Update Engineering Item/Org Attributes \Navigate Prototype Define Item Update	Item Attributes Navigator: Prototypes > Items > View Item Details > [Attributes]
Update Personal Profile Options \Navigate Other Profile	Personal Profile Values Navigator: Setup > Profiles
View Bill of Material Comparison \Navigate Inquiry Bill Compare	Bill Components Comparison Navigator: Prototypes > Bills > Comparison
View Bill of Material Details Navigate Inquiry Bill Detail	Bill Details Navigator: Prototypes > Bills > Bills > [Bill Details]
View Concurrent Requests \ Navigate Other Requests	Requests window See: Viewing Requests (<i>Oracle Applications User's Guide</i>) Navigator: Concurrent > Requests Choose: View Output button – to view Request Output View Log button – to view Request Log Use the Menu to choose: Tools > Managers – to view Manager Log
View Engineering Change Order Details \Navigate Inquiry ECO Details	Engineering Change Orders Navigator: ECOs > ECOs
View Engineering Change Order Schedule \Navigate Inquiry ECO Schedule	View ECOs Navigator: ECOs > Schedules
View Engineering Delete History \Navigate Inquiry DeleteHistory	Warning: Engineering Deletion Groups Navigator: Prototypes > Routings > Delete Groups
View Indented Bill of Material \Navigate Inquiry Bill Indented	Indented Bills of Material Navigator: Prototypes > Bills > Indented Bills
View Item Attributes \Navigate Inquiry Item Attributes	Item Attributes Navigator: Prototypes > Items > View Item Details > [Attributes]

Character Mode Form and Menu Path	GUI Window or Process, and Navigation Path
View Item Revision Navigate Inquiry Item Revision	Item Revisions Navigator: Prototypes > Bills > Bills > [Revision] or Revised Items Navigator: ECOs > ECOs > [Revised Items] > [Revisions]
View Item Usage \Navigate Inquiry WhereUsed Item	Item WhereUsed Navigator: Prototypes > Bills > Item WhereUsed
View Routing Details \Navigate Inquiry Routing	EngineeringRoutings Navigator: Prototypes > Routings > Routings

APPENDIX

B

Oracle Engineering Alerts

This appendix describes the pre-coded alerts included with Oracle Engineering.

Engineering Alerts

Engineering includes these pre-coded alerts that you can use with or without customizing.

ECO Approval Notification

This alert notifies all the approvers on an ECO's approval list that an ECO requires their approval

Alert Type	Periodic
Periodicity	Every <i>n</i> business days
Inputs	Organization
Distribution	Approvers for the ECO

```
To:      Henry Smith
From:    Oracle Alert
Subject: Approval Requested for ECO - ECO7
-----
```

The following Engineering Change Order needs your approval. Please take the appropriate action and inform the Requestor below.

```
Organization:  BM1      BOM Test Org 1

ECO:          ECO7          Reason: Cost
Priority:
Approver List:  appr1
Approver:      Mecker, Satyajit Singh
Requestor:

Revised Item:  E:EDEI_watch
Description:   Watch
Effective Date: 31-JUL-93      New Revision: 1
```

Oracle Alert

ECO Use Up Date

This alert notifies the ECO planner that a plan date for a use-up item has changed.

Alert Type	Periodic
Periodicity	Every <i>n</i> business days

APPENDIX

C

Oracle Engineering Special Menu

This appendix describes the options on the Oracle Engineering Tools menu.

Engineering Tools menu

Change the status of ECOs and ECO revised items by using the Tools menu and choosing a status. Other functions available from the Oracle Engineering Tools menu include:

Reschedule	Opens the Reschedule window to reschedule ECOs and ECO revised items. To reschedule ECOs, the Engineering Change Orders: Reschedule security function must be included as part of the responsibility.
Enter Costs	Opens the ECO Costs window so that you can enter engineering or manufacturing implementation costs.
Copy Bill from	Opens the Copy Bill window so that you can copy a bill into an ECO.
Check for Loops	Verifies that a bill does not contain items are not listed as components of the same item. Opens the Approval Dates window which shows the date the ECO approval list was requested, the date it was approved, or the days remaining for approval to take place.
Abort Approvals	Aborts the Workflow approval process. This is only available if the ECO approval status is Approval Requested. This is only available if the ECO: Approvals security function is included as part of the responsibility.

See Also

Changing the ECO Status: page 2 – 30

ECO Statuses: page 2 – 71

ECO Revised Item Statuses: page 2 – 71

Rescheduling an ECO or Revised Items: page 2 – 29

Defining Implementation Costs: page 2 – 31

Copying Bill and Routing Information, *Oracle Bills of Material User's Guide*

Checking for Bill Loops, *Oracle Bills of Material User's Guide*

Assigning an ECO Approval List and Status: page 2 – 27

GLOSSARY

acquisition cost The cost necessary to obtain inventory and prepare it for its intended use. It includes material costs and various costs associated with procurement and shipping of items, such as duty, freight, drayage, customs charges, storage charges, other supplier's charges, and so on.

activity A business action or task which uses a resource or incurs a cost.

alternate bill of material An alternate list of component items you can use to produce an assembly.

alternate routing An alternate manufacturing process you can use to produce an assembly.

ANSI American National Standards Institute which establishes national standards for the United States. The parent organization for X12 and also serves as the North American representative to ISO (International Standards Organization).

approval list A group of employees that review and control engineering change orders (ECOs). When you create an ECO, you can assign an approval list and an approval status. Oracle Alert automatically notifies each approver when an ECO requires their approval.

approval status A classification you can use to track an ECO's approval cycle. Approval statuses include: **Not ready to approve**, **Ready to approve**, **Approval requested**, **Approved**, and **Rejected**. Oracle Alert automatically notifies each approver when an ECO's approval status is set to **Ready to approve**.

assigned units The number of resource units assigned to work at an operation in a routing. For example, if you have 10 units of

machine resource available at a department, you can assign up to 10 of these units to an operation in a routing. The more units you assign, the less elapsed time Work in Process schedules for the operation.

autocharge A method of charging a discrete job or repetitive schedule for the resources consumed at an operation.

autoimplement To implement an ECO's revised item automatically on its effective date by setting the revised item status to **Scheduled** and running the autoimplement manager.

autoimplement manager An Engineering program that automatically implements all ECO revised items with a status of **Scheduled** and whose effective date is less than or equal to the current date.

autonumber A function to automatically default engineering change order (ECO) numbers when you create a new ECO. You can define an autonumber prefix and sequence for all users across all organizations, all users in one organization, one user across all organizations, and one user in one organization.

bill of material A list of component items associated with a parent item and information about how each item relates to the parent item. Oracle Manufacturing supports standard, model, option class, and planning bills. The item information on a bill depends on the item type and bill type. The most common type of bill is a standard bill of material. A standard bill of material lists the components associated with a product or subassembly. It specifies the required quantity for each component plus other information to control work in process,

material planning, and other Oracle Manufacturing functions. Also known as **product structures**.

bill revision A specific version of an item which specifies the components that are active for a date range.

BOM item type An item classification that determines the items you can use as components in a bill of material. BOM Item types include standard, model, option class, and planning items.

by-product Material produced as a residual of a production process. Represented by negative usage in the bill of material for an assembly.

capacity units The number of units of a resource available in a department. For example, the number of machines.

charge type See **autocharge**

common bill of material An assembly that uses the bill of material of another assembly as its bill. This enables you to reduce your maintenance effort by sharing the same bill structure among two or more assemblies. For example, if you have identical bills of material that produce the same product in two different organizations, you can define common bills of material for the identical structures.

common routing A routing that uses the routing of another assembly as its routing. This enables you to reduce your maintenance effort by sharing the same routing and operations for two or more assemblies.

component demand Demand passed down from a parent assembly to a component.

component item An item associated with a parent item on a bill of material.

component yield The percent of the amount of a component you want to issue to build an assembly that actually becomes part of that assembly. Or, the amount of a component you require to build plus the amount of the component you lose or waste while building an assembly. For example, a yield factor of 0.90 means that only 90% of the usage quantity of the component on a bill actually becomes part of the finished assembly.

configurator A form that allows you to choose options available for a particular model, thus defining a particular configuration for the model.

configure-to-order An environment where you enter customer orders by choosing a base model and then selecting options from a list of choices.

count point operation A default operation to move to and from where you record move and charge resource transactions. Also known as **pay point**.

cumulative manufacturing lead time The total time required to make an item if you had all raw materials in stock but had to make all subassemblies level by level. Bills of Material automatically calculates this value. Purchased items have no cumulative manufacturing lead time.

cumulative total lead time The total time required to make an item if no inventory existed and you had to order all the raw materials and make all subassemblies level by level. Bills of Material automatically calculates this value.

delete entity An item, bill of material or routing you choose to delete.

delete group A set of items, bills, and routings you choose to delete.

delete subentity A component or operation you choose to delete.

deletion constraint A business rule that restricts the entities you can delete. A deletion constraint is a test that must succeed before an item, bill, or routing can be deleted.

detailed scheduling A method of scheduling production that considers minute to minute resource availability information as well as exact resource requirements from routings.

disable date A date when an Oracle Manufacturing function is no longer available for use. For example, this could be the date on which a bill of material component or routing operation is no longer active, or the date a forecast or master schedule is no longer valid.

disposition Directions that describe how to dispose of inventory affected by an ECO. Engineering uses ECO disposition for informational purposes only.

dynamic lead time offsetting A scheduling method that quickly estimates the start date of an order, operation, or resource. Dynamic lead time offsetting schedules using the organization workday calendar.

effective date Date when an Oracle Manufacturing function is available for use. For example, this could be the date a bill of material component or routing operation becomes effective, or the date you anticipate revised item changes become part of a bill of material and can no longer be controlled by an ECO.

engineer-to-order An environment where customers order unique configurations for which engineering must define and release custom bills for material and routings. Oracle Manufacturing does not provide special support for this environment beyond

the support it provides for assemble-to-order manufacturing.

engineering change order (ECO) A record of revisions to one or more items usually released by engineering.

engineering change order department A group of users that use the engineering change order system. You assign users to an ECO department to control access to your ECOs.

engineering change order reason The purpose of an ECO.

engineering change order status A classification you can use to track and control an ECO's life cycle. ECO statuses include: **Open, Hold, Release, Schedule, Implement, and Cancelled.**

engineering change order type An ECO field that identifies the originating ECO department and the items you can include on an ECO (manufacturing or engineering).

engineering item A prototype part, material, subassembly, assembly, or product you have not yet released to production. You can order, stock, and build engineering items.

FIFO (first-in-first-out) costing method A cost flow method used for inventory valuation. Inventory balances and values are updated perpetually after each transaction is sequentially costed. It assumes that the earliest inventory units received or produced are the first units used or shipped. The ending inventory therefore consists of the most recently acquired goods. FIFO cost flow does not have to match the physical flow of inventory.

fixed lead time The portion of the time required to make an assembly independent

of order quantity, such as time for setup or teardown.

flow manufacturing Manufacturing philosophy utilizing production lines and schedules instead of work orders to drive production. Mixed models are grouped into families and produced on lines balanced to the TAKT time.

implement To make an ECO active so that no further changes can be made to that ECO. Usually, the day you implement an ECO is also the effective date for component changes. After that date, you must make further changes through a new ECO or directly to the bill.

implementation date The date a component becomes part of a bill of material and is no longer controlled through an ECO. Implementation date does not necessarily equal the effective date.

included item A standard mandatory component in a bill, indicating that it ships (if shippable) whenever its parent item is shipped. Included items are components of models, kits, and option classes.

item Anything you make, purchase, or sell, including components, subassemblies, finished products, or supplies. Oracle Manufacturing also uses items to represent planning items that you can forecast, standard lines that you can include on invoices, and option classes you can use to group options in model and option class bills.

item sequence The sequence of the component item on the bill of material used to sort components on reports.

LIFO (last-in-first-out) costing method A cost flow method used for inventory valuation. Inventory balances and values are updated perpetually after each transaction is

sequentially costed. It assumes that the most recent inventory units received or produced are the first units used or shipped. The ending inventory consists of old goods acquired in the earliest purchases or completions.

lead time lot size The item quantity used to compute the fixed and variable portions of manufacturing lead time. For manufactured items, the processing lead time represents the time required to build this quantity.

make-to-order An environment where customers order unique configurations that must be manufactured using multiple discrete jobs and/or final assembly orders where the product from one discrete job is required as a component on another discrete job. Oracle Manufacturing does not provide special support for this environment beyond the support it provides for assemble-to-order manufacturing.

mandatory component A component in a bill that is not optional. Bills of Material distinguishes required components from options in model and option class bills of material. Mandatory components in pick-to-order model bills are often referred to as included items, especially if they are shippable.

mass change order A record of a plan to replace, delete, or update one or more component items in many bills of material at the same time.

minimum transfer quantity The minimum number of assemblies to move from your current operation to the next. Work in Process warns you when you move less than the minimum transfer quantity.

model bill of material A bill of material for a model item. A model bill lists option classes

and options available when you place an order for the model item.

model item An item whose bill of material lists options and option classes available when you place an order for the model item.

occurrence An individual quality result. For example, a measurement that falls in or out of a specified tolerance. Occurrences can be charted using Oracle Quality.

offset percent An operation resource field that holds the percent of total manufacturing lead time required for previous operations. For example, if all operations require a total of ten hours to perform and the offset percent for a resource is 40%, then the resource is used four hours after the start of the first operation.

operation A step in a manufacturing process where you perform work on, add value to, and consume department resources for an assembly.

operation code A label that identifies a standard operation.

operation instructions Directions that describe how to perform an operation.

operation offset Elapsed days from the start of your first operation until the beginning of your current operation.

operation sequence A number that orders operations in a routing relative to each other.

option class item An item whose bill of material contains a list of related options.

option dependent operation An operation in a model or option class item's routing that appears in a configuration item routing only if the configuration contains an option that references that operation.

postprocessing lead time The time required to receive a purchased item into inventory from

the initial supplier receipt, such as the time required to deliver an order from the receiving dock to its final destination.

reference designator An optional identifier you can assign to a component on a bill. For example, when the bill requires four of a component, you can assign four reference designators to that component, one for each usage.

requestor The employee that creates an ECO or requests approval for an ECO.

resource Anything of value, except material and cash, required to manufacture, cost, and schedule products. Resources include people, tools, machines, labor purchased from a supplier, and physical space.

resource basis The basis for resource usage quantity that indicates whether that quantity is required per item or per lot.

resource sequence The number that indicates the order of a resource in an operation relative to other resources.

revised component Component changes to an assembly that is a revised item on an ECO.

revised item Any item you change on an engineering change order. Revised items may be purchased items, subassemblies, finished goods.

revised item status A classification you can use to track and control a revised item's life cycle. Revised item statuses include **Open**, **Released**, **Scheduled**, **Hold**, **Implemented**, and **Cancelled**.

revision A particular version of an item, bill of material, or routing.

revision control An inventory control option that tracks inventory by item revision and forces you to specify a revision for each material transaction.

routing A sequence of manufacturing operations that you perform to manufacture an assembly. A routing consists of an item, a series of operations, an operation sequence, and operation effective dates.

routing revision A specific version of a routing that specifies the operations that are active for a date range.

setup time The time required to for a machine or work center to convert from the production of one item to another.

shift A scheduled period of work for a department within an organization.

standard operation A commonly used operation you can define as a template for use in defining future routing operations.

standard rate The frozen standard unit cost for a resource.

subinventory Subdivision of an organization, representing either a physical area or a logical grouping of items, such as a storeroom or receiving dock.

substitute item An item that can be used in place of a component. Master Scheduling/MRP suggests substitutes items on some reports.

supply A quantity of materials available for use. Supply is replenished in response to demand or anticipated demand.

supply type A bill of material component field that controls issue transactions from inventory to work in process. Supply types supported by Work in Process include:

Push, Assembly pull, Operation pull, Bulk, Supplier, Phantom, and Based on bill.

teardown time The time required to clean up or restore a machine or work center after operation.

total lead time An item's fixed lead time plus the variable lead time multiplied by the order quantity. For lead time calculations, Bills of Material sets the order quantity to the item's standard or lead time lot size. The planning process uses the total lead time for an item in its scheduling logic to calculate order start dates from order due dates.

Update WIP When Engineering automatically implements a released revised item, the work in process requirements are automatically updated for the revised item.

usage rate The amount of a resource consumed at an operation.

use-up item A revised component whose MRP-planned order date and lead time offset determine the effective date of the revised item.

variable lead time The time required to produce one additional unit of an assembly. To compute an item's total lead time multiply variable lead time by order quantity, and add an item's fixed lead time.

workday calendar A calendar that identifies available workdays for one or more organizations. Master Scheduling/MRP, Inventory, Work in Process, and Capacity plan and schedule activities based on a calendar's available workdays.

workday exception set An entity that defines mutually exclusive sets of workday exceptions. For each organization, you can specify a workday calendar and exception set.

workday exceptions Dates that define plant or shift workday variations, including holidays, scheduled maintenance, or extended downtime.

yield See component yield.

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