PeopleSoft®

EnterpriseOne 8.10
Shop Floor Management
PeopleBook

May 2004

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Shop Floor Management PeopleBook
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About These EnterpriseOne PeopleBooks Preface

EnterpriseOne PeopleBooks provide you with the information that you need to implement and use PeopleSoft EnterpriseOne applications.

This preface discusses:

- EnterpriseOne application prerequisites
- Obtaining documentation updates
- Typographical elements and visual cues
- Comments and suggestions

Note

EnterpriseOne PeopleBooks document only fields that require additional explanation. If a field is not documented with the process or task in which it is used, then either it requires no additional explanation or it is documented with common elements for the section, chapter, PeopleBook, or product line.

EnterpriseOne Application Prerequisites

To benefit fully from the information that is covered in these books, you should have a basic understanding of how to use EnterpriseOne applications.

See the *Foundation Guide*.

You might also want to complete at least one EnterpriseOne introductory training course.

You should be familiar with navigating the system and adding, updating, and deleting information by using EnterpriseOne menus and forms. You should also be comfortable using the World Wide Web and the Microsoft Windows or Windows NT graphical user interface.

These books do not review navigation and other basics. They present the information that you need to use the system and implement your EnterpriseOne applications most effectively.

Obtaining Documentation Updates

You can find updates and additional documentation for this release, as well as previous releases, on the PeopleSoft Customer Connection Website. Through the Documentation section of PeopleSoft Customer Connection, you can download files to add to your PeopleBook Library. You can find a variety of useful and timely materials, including updates to the full PeopleSoft documentation that is delivered on your PeopleBooks CD-ROM.

Note

Before you upgrade, you must check PeopleSoft Customer Connection for updates to the upgrade instructions. PeopleSoft continually posts updates as the upgrade process is refined.

See Also

PeopleSoft Customer Connection Website, *http://www.peoplesoft.com/corp/en/login.jsp*

Typographical Conventions and Visual Cues

This section discusses:

- Typographical conventions
- Visual cues

Typographical Conventions

The following table contains the typographical conventions that are used in EnterpriseOne PeopleBooks:

Typographical Convention or Visual Cue	Description
Italics	Indicates emphasis, topic titles, and titles of PeopleSoft or other book-length publications. Also used in code to indicate variable values.
Key+Key	A plus sign (+) between keys means that you must hold down the first key while you press the second key. For example, Alt+W means hold down the Alt key while you press W.
Monospace font	Indicates a PeopleCode program or other code example.
" " (quotation marks)	Indicates an adjective that is used in a way that might not be readily understood without the quotation marks, for example "as of" date, "as if" currency, "from" date, and "thru" date.
Cross-references	EnterpriseOne PeopleBooks provide cross-references either below the heading "See Also" or preceded by the word See. Cross-references lead to other documentation that is pertinent to the immediately preceding documentation.

Visual Cues

EnterpriseOne PeopleBooks contain the following visual cues:

- Notes
- Cautions

Notes

Notes indicate information that you should pay particular attention to as you work with the PeopleSoft system.

Note

Example of a note.

Cautions

Text that is preceded by *Caution* is crucial and includes information that concerns what you must do for the system to function properly.

Caution

Example of a caution.

Comments and Suggestions

Your comments are important to us. We encourage you to tell us what you like, or what you would like to see changed about PeopleBooks and other PeopleSoft reference and training materials. Please send your suggestions to:

PeopleSoft Product Documentation Manager, PeopleSoft Inc., 4460 Hacienda Drive, Pleasanton CA 94588

Or you can send e-mail comments to *doc@peoplesoft.com*.

While we cannot guarantee an answer to every e-mail message, we will pay careful attention to your comments and suggestions.

Shop Floor Management Overview

A shop floor management system plays a key role in managing the flow of materials inside the plant. An effectively implemented shop floor management system serves as a mediator between production control and the shop floor. The PeopleSoft EnterpriseOne Shop Floor Management system provides an effective way to maintain and communicate information that the system requires to complete production requests.

An effectively-implemented Shop Floor Management system serves as a mediator between production control and the shop floor. It allows you to manage and track manufacturing work orders. It uses data from the shop floor to maintain and communicate status information regarding materials, work centers, routing instructions, and end operations that are required to complete the production requests. A traditional shop floor uses dispatch lists, capacity requirements, finite scheduling, capacity planning, capacity simulation, and optimization. Some companies might also use bar coding, kanban, and just-in-time manufacturing processes on the shop floor.

This section provides overview information about shop floor management in the manufacturing industry, as well as information about how the EnterpriseOne Shop Floor Management system integrates with other EnterpriseOne systems.

Shop Floor Process

The process of scheduling production begins with managing the release of orders to the shop floor. Scheduling production involves setting realistic priorities and adjusting schedules based on required dates and actual dates.

The next step is to manage production by controlling work that is in progress on the shop floor. This means that you must track production on the shop floor to update the system. Updating your system entails tracking the status of jobs and obtaining the most up-to-date information about production activity. After a company is set up to monitor the shop floor, the system reports information that is required by various departments.

Industry Challenges

Customers today want specialized products and shorter lead times from order to delivery of product. Manufacturers must respond faster to the changing needs of their customers. Currently, manufacturers struggle with manual paperwork, slow response times, and lack of system integration. Additionally, the need for higher product volume versus the complexity of the manufacturing steps requires a systematic management. To solve these problems, manufacturers require flexibility and agility to provide specialized products at a faster rate and a competitive price.

Manufacturers must control the shop floor. That is, they must initiate, maintain, and report on all activity that occurs on the shop floor. Manufacturers then need to communicate this information to the rest of the company. A company that has a well-run shop floor depends on a fast, accurate, and flexible system to produce a quality product.

Industry Improvements

Shop floor tracking includes monitoring machine status, absent employees, operations not finished on time, and parts rejected, all of which significantly impact the shop floor schedule. When the system monitors and reports this information, it provides redirection and recovery to meet the customer's due date.

The shop floor reports provide both estimated and actual costs. A company can compare the amount of time, material, and labor placed into the production of the end item to what they planned. A company can use the information from the system to drive improvements on the shop floor.

The system eliminates waste from unproductive activities, decreases work-in-progress, and shortens product life cycles. These improvements all result in increased product quality, flexibility, and speed. The EnterpriseOne Shop Floor Management system meets the customer's expectations of total lowest cost and highest quality, and it provides manufacturing lead-time that ensures on-time deliveries.

Competitive Advantage Through Shop Floor Management

The following table provides examples of typical problems in the manufacturing industry and possible solutions to these problems:

Multinational companies might have incompatible shop floor systems that force them to plan manually. This is both time-consuming and inaccurate.	You can use multisite planning to define bills of material and routings for each facility for the same item. The system displays material, bills of material, and routings for all defined business units. Accurate planning consists of current work in process (WIP), inventory, bills of material, and routings.
	Integration in multisite planning ensures accurate and efficient planning and reduces item numbers and WIP. This results in cost savings for materials, increased accuracy in inventory, and reduction in lead times.
A company might forget to account for actual inventory.	Through inventory management in the manufacturing industry, you can accurately and consistently make plans for the entire organization.
WIP does not always use up-to-date information.	The EnterpriseOne Shop Floor Management system includes planning features that consider WIP, inventory levels, bills of material and routings.
A company needs to know whether it operates at a profit or a loss.	You can use product costing and various accounting functions to review costing and accounting at each level in an organization.
	Costs are compiled in a single ledger record, regardless of where the system generates the cost record.
	The system provides the ability to sort and report cost information by summary or detail.
A company needs to know the source of its costs.	The system integrates product costing (by item, hours and quantities) and manufacturing accounting. The system shows all elements that influence the cost of an item.
	Product costing provides your system with improved cost visibility and supports better management decisions. The system information can increase a company's accuracy in determining costs to customers.

Many companies need to reduce leadtime.	You can use the Leadtime Rollup (R30822A) program to review the lead times for each item in each branch. You can identity potential production and delivery problems.
	When your company produces manufactured items at a rate that is defined in the routing, planners can determine whether the shop floor is on schedule. If it is not on schedule, planners can evaluate the causes and identify solutions early in the production stage.
Inadequate resources force companies to rely on costly overtime to meet manufacturing schedules.	You can use the Shop Floor Workbench program (P31225) to review work orders, work centers, and over-capacity situations in advance. You can also modify the schedule to ensure that production satisfies the demand.
	Customer demand is met through improved planning and scheduling in the Shop Floor Workbench program.
Inaccurate conversions and inventory counts occur when a company purchases and issues items in different units of measure.	The system converts different units of measure to a standard unit of measure, which allows the company to purchase, consume, and produce items in the appropriate units of measure. Inventory is accurate because the system performs conversions. Each item can have as many as eight different units of measure.
Most companies cannot interface with other companies' operating systems.	PeopleSoft EnterpriseOne software can operate interactively with third-party systems such as Manugistics and SynQuest. Users can use the full EnterpriseOne Shop Floor Management system or a compatible third-party system.
	Today, companies have more choices about how to run their businesses and the systems that they use to support their business processes.

Shop Floor System Integration

Shop Floor Management is one of many systems that is used for Supply Chain Management. Supply Chain Management enables you to coordinate your inventory, raw material, and labor resources to deliver products according to a managed schedule. The systems within Supply Chain Management are fully-integrated, which ensures that information is current and accurate throughout all of your business operations. It is a manufacturing system that formalizes the activities of company and operations planning, as well as the execution of those plans.

The Shop Floor Management system integrates with other PeopleSoft EnterpriseOne systems to take advantage of single entries, information sharing, and data consistency between systems.

These system integrations are described following the graphic:

Shop Floor Management System Integration
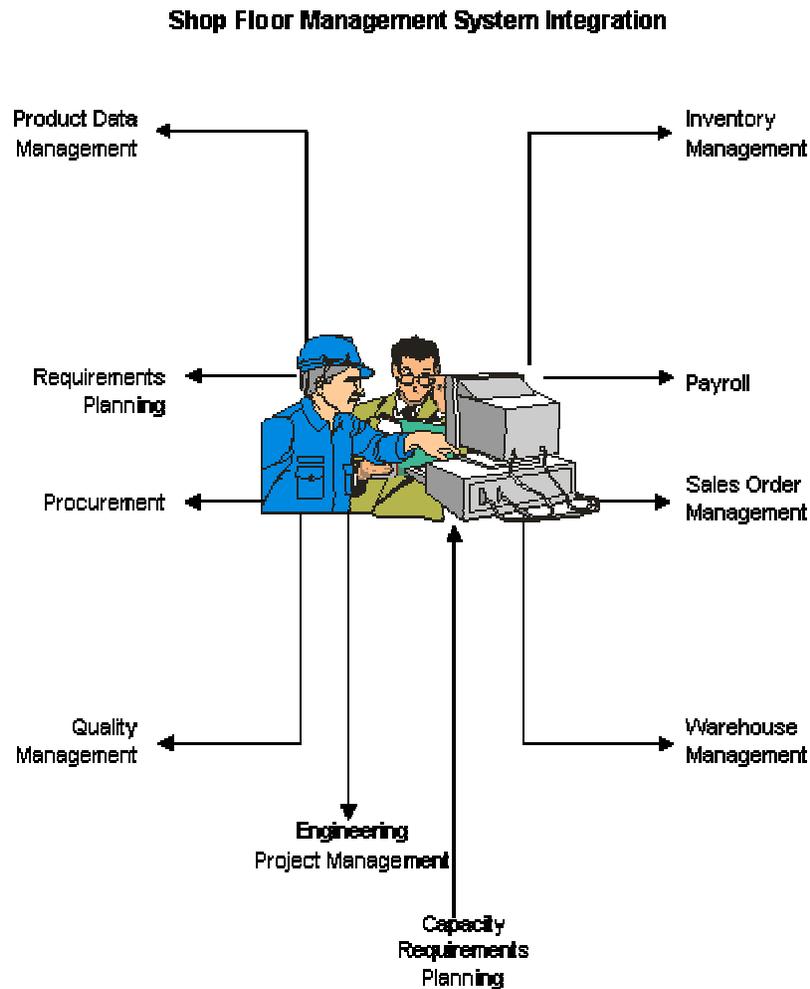
The Product Data Management system provides information about bills of material, work centers, routing instructions, and product costs.

The Distribution Requirements Planning, Master Production Schedule, and Material Requirements Planning systems provide suggested purchasing and manufacturing orders that are required to maintain a valid production schedule.

The Procurement system allows you to automatically generate purchase orders for subcontracted operations on the routing instructions.

The Quality Management system allows you to work with test results as you do the following:

- Create, process, manage, and complete work orders and rate schedules
- Record actual hours and quantities
- Backflush labor and parts

The Capacity Requirements Planning system reads the routing instructions for work orders and rate schedules and monitors the load on the work centers involved. This allows you to effectively manage the loads on your work centers to maximize production and meet scheduled demand.

The Engineer to Order system allows you to work with large engineer-to-order projects. You use a number of Shop Floor Management programs, such as Order Processing (R31410), Inventory Issues (P31113), and Work Order Completion (P31114), to process the work orders that you create for the project.

The Warehouse Management system allows you to originate picking requests through manufacturing systems, which further enhances the automated method of tracking inventory movement within a warehouse.

The Sales Order Management system allows you to generate work orders when you enter a sales order, and it updates sales information from within the Shop Floor Management system.

The Payroll system allows single entry of employees' hours. You can record hours and quantities per work request or per employee to accommodate both piece-rate and hourly-rate employees.

The Inventory Management system allows you to track materials between inventory or storage locations and the shop floor. You can manage inventory issues and commitments, complete orders, and track order quantities throughout the production process.

Shop Floor Management Features

The following graphic illustrates the features available to you in the Shop Floor Management system. These features are described in detail in the text that follows this graphic.

Shop Floor Management Features
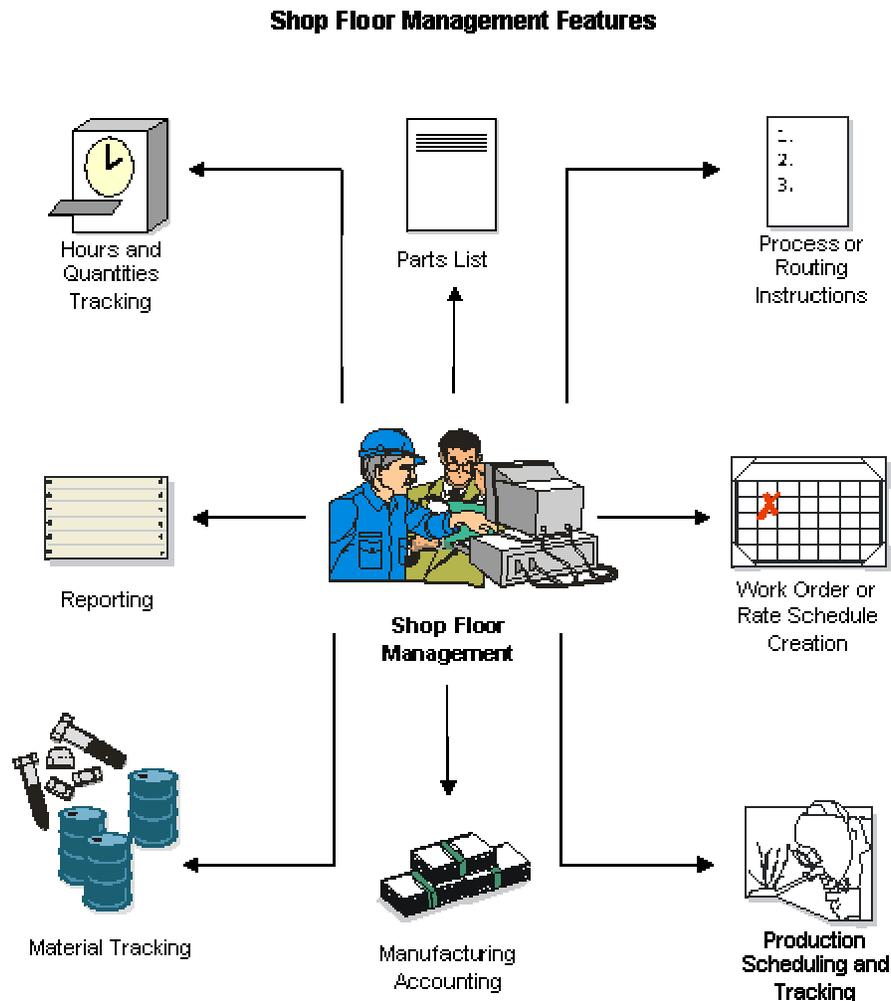
Hours and Quantities Tracking

You use the hours and quantities tracking features to do the following:

- Enter and track time and quantity completed and quantity scrapped by work order and by employee

- Allocate and track resource usage by work center per calendar month

- Review and analyze work order reports with detail information when you use standard versus actual values for the following:

  - Setup, labor, and machine time

  - Quantity completed and quantity scrapped

- Charge actual hours and quantities to a work order as each manufacturing step is completed

Reporting

You use the reporting features to do the following:

- Generate reports that compare actual values with planned values and indicate the variance between the two

- Generate shortage reports by item or work order to identify potential manufacturing constraints due to a lack of required components

- Print shop floor paperwork, such as work orders, parts lists, and routing instructions for items

- Review daily work lists to monitor job status, identify queue problems at work centers, and flag other areas, such as engineering changes or lost material

Material Tracking

You use the material tracking features to do the following:

- Create a parts list automatically when you run the Order Processing program (R31410).

- Attach the parts list and routing instructions to the work order and print shop floor paperwork.

- Check the availability of the components required to manufacture a parent item and generate a shortage list.

- Issue the parts to a work order using a manual, preflush, or backflush method.

- Backflush quantities of components issued to a work order and the labor expended with pay point operations.

- Signal material movement with kanban processing from inventory, work orders, or purchase orders.

- Enter and track completions to inventory when parent items are completed.

- Track where lots are used, and split and trace where lots originate with advanced lot control.

- Maintain and monitor work orders created from the Base Configurator system for configured items.

- Process work orders that produce co-products or by-products.

- Enter issue transactions for inventory items associated with a work order.

- Generate a picking request in the Warehouse Management system to select a location and move the inventory. This task occurs after the system creates a parts list without a work center attached, and checks availability. You must have Warehouse Management installed to take this step.

Manufacturing Accounting

You use the manufacturing accounting features to do the following:

- Plan and track costs for setup, labor, material, and overhead

- Compare planned costs to actual costs and calculate a variance amount

- Create journal entries in the general ledger to charge actual costs and variance costs to a work order or rate schedule

- Use feature cost percent for coproduct and by-product costing

Production Scheduling and Tracking

You use the production scheduling and tracking features to do the following:

- Schedule work center production for work orders, rate schedules, or both

- Track and compare planned production schedules with actual schedules

- Use the online scheduling workbench to review, dispatch, and update production scheduling information in real time

- Calculate start and completion dates for each work order by operation

- Maintain the rate schedule after using rate-based MRP or MPS

Work Order and Rate Schedule Creation

You use the work order and rate schedule creation features to do the following:

- Enter work orders or rate schedules manually

- Create work orders and rate schedules automatically from the Master Production Schedule or Material Requirements Planning systems by answering action messages, or from the Sales Order Entry system, in which you can select kits for assemble-to-order products.

- Automatically generate shop floor paperwork for rate schedules, including standard parts lists and routing instructions.

- Differentiate work orders and rate schedules by type, priority, and status.

- Group work orders by a parent number. For example, you can create job numbers that contain many work order numbers.

- Automatically generate purchase orders for subcontracted operations on the routing instructions for work orders and rate schedules. The system generates these purchase orders when you run the Order Processing program (R31410).

Process or Routing Instructions

You use the process or routing instructions features to do the following:

- Generate routing instructions automatically when you run the Order Processing program (R31410)

- Use master routings or nonstandard routing instructions for items and indicate when to use each item

- Change the work centers and procedures for each operation on the routing instructions

- Modify the sequence and status of each operation on the routing instructions
- Make real-time modifications to routings instructions
- Review quantity ordered, completed, and scrapped for each operation in the Production Status program (P31226) or the Production History program (P31227)

Parts List

You use the parts list features to do the following:

- Generate a parts list automatically when you run the Order Processing program (R31410)
- Copy an existing bill of material for the items required by a new work order and attach the parts list to the new work order
- Copy a parts list from an existing work order and attach it to a new work order
- Specify or change a substitute item or quantities from different locations
- Choose defined substitute items and their quantities on-hand when a component shortage exists

Shop Floor Management Process Flow

The following graphic illustrates all of the processes involved in the Shop Floor Management system. The arrows show the flow from process to process, beginning with a work order or rate schedule and ending with an inventory completion.

Process Flow for Shop Floor Management

Create Work Orders

or

Rate Schedules

Attach Routing Instructions

Attach Parts List

Perform Commitments

Check Availability

Issue Inventory

Schedule Work

Integrate with Payroll (optional)

Record Hours and Quantities

Complete Super Back Flushing

Post Completion to Inventory
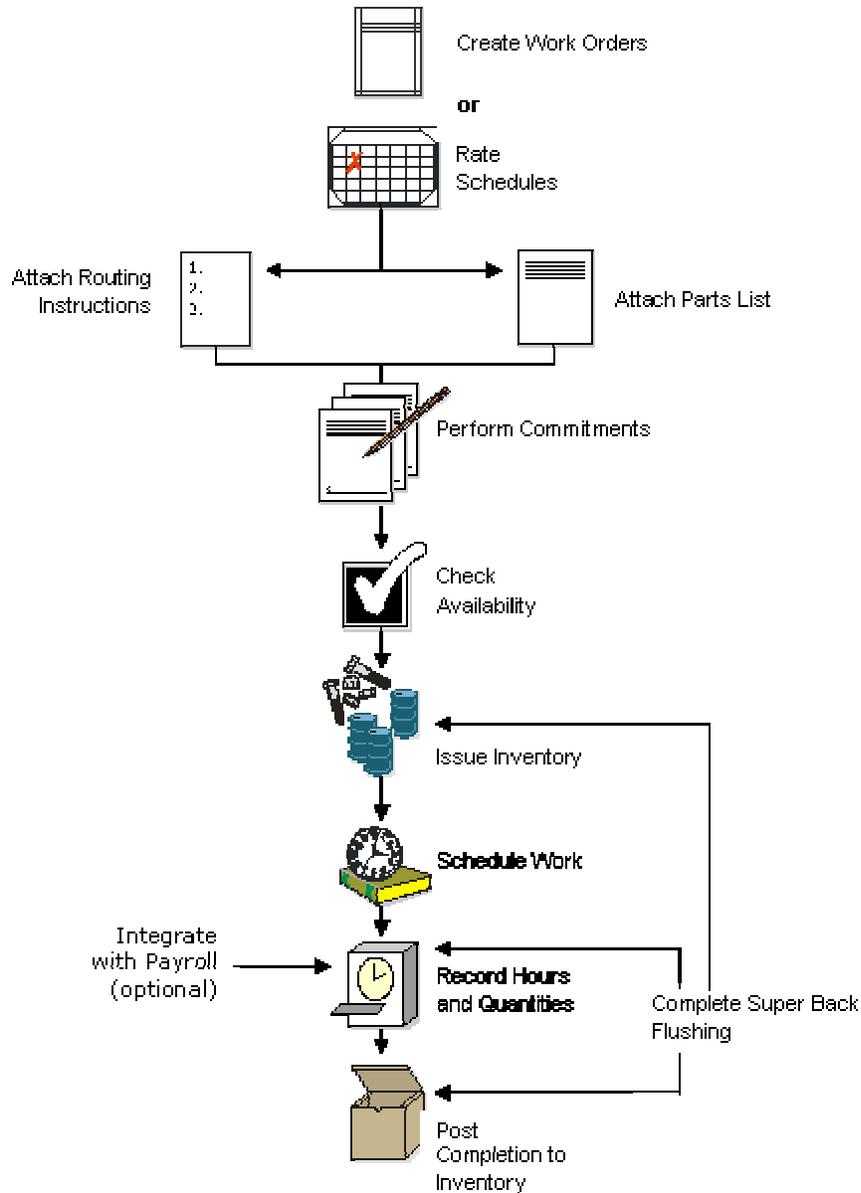
Tables for Shop Floor Management

The following is a list of the tables that are used throughout the Shop Floor Management system:

Business Unit Master (F0006) Stores branch, plant, warehouse, and business unit information, such as company, description, and category codes that are assigned to that entity.

Generic Message/Rates (F00191) Stores codes that correspond to a text message and the employee labor rate. In the Shop Floor Management system, these codes are used for the routing instructions text on a work order.

Account Master (F0901) Stores account definitions including numbers and descriptions.

Account Ledger (F0911) Stores detailed transactions in the general ledger.

Work Center Master File (F30006) Stores detailed information, such as efficiency, about all defined work centers.

Bill of Material Master File (F3002) Stores information at the business unit level about bills of materials, such as quantities of components, features, options, and levels of detail for each bill.

Item Cost Component Add-Ons (F30026) Stores frozen standard costs for the creation of journal entries that are related to work orders.

Routing Master File (F3003) Stores information about routing instructions, including operation sequences; work centers; and run, setup, and machine time. The system uses this information to calculate labor, machine, and overhead costs.

Work Center Resource Units (F3007) Stores the capacity information for work centers, such as business unit, month, shift, and efficiency.

Job Shop Manufacturing Constants (F3009) Stores general branch/plant information, such as bill of material and routing instructions validation, commitment control, work hours per day, and costs.

Kanban Master (F3016) Stores the set of kanban cards that are associated with an item. Each kanban defines the supplying location, consuming location, quantity, and unit of measure. The system uses next numbers to control the kanban identification number. If the system obtains the item from an external source, the supplier's number is included.

Kanban Card Detail (F30161) Stores information related to the kanban, such as status, transaction quantity, and date updated.

Production Cost (F3102) Stores the work order variance. Variance is the difference between actual costs and the standard costs that were defined at the beginning of the accounting period.

Work Order LSN (F3105)	Stores the data that identifies work order assemblies with lot serial numbers.
Summarized WO Cross-Reference (F3108)	Stores the cross-reference information for work orders, such as batch number and date, user, program ID, and workstation.
Line/Item Relationship Master (F3109)	Stores the relationships between items and production lines. The system uses one of the records as the default rate generation rule.
Schedule Quantity Detail (F31091)	Stores the daily quantities that make up a work order or a rate schedule. The system uses this table for scheduling and sequencing production lines and work centers.
Work Order Parts List (F3111)	Stores the components required by a work order.
Work Order Routing (F3112)	Stores the routing steps that are attached to a work order or tae schedule. It contains one record for each operation sequence number and work center.
Work Order Time Transactions (F31122)	Stores the labor transactions reported on work orders and rate schedules.
Shortage Maintenance Master File (F3118)	Stores component shortages for work orders.
Distribution/Manufacturing − AAI Values (F4095)	Stores the automatic accounting instructions for the Manufacturing systems.
Assembly Inclusion Rules (F3293)	Stores the inclusion parameters for item numbers and business units.
MPS/MRP/DRP Message File (F3411)	Stores the supply and demand relationship among the branches.
Forecast File (F3460)	Stores the forecast data that Resource Requirements Planning (RRP) validates. The data is then used as input to MPS/MRP/DRP.
Inventory Constants (F41001)	Stores the constants for the day-to-day transactions that occur within the Inventory Management system. Inventory constants direct the nature of certain integrated operations between Inventory Management and other systems, such as Sales Order Management, Procurement, and General Accounting.
Item Master (F4101)	Stores basic information about each defined inventory item, such as item number, description, category codes and units of measure.
Item Branch File (F4102)	Stores the warehouse or plant-level information for an item, such as costs, quantities, category codes, and physical locations.
Item Location File (F41021)	Stores all inventory locations for an item.

Item Cross Reference File (F4104)	Stores information that enables you to relate item numbers for a specific purpose.
Lot Master (F4108)	Stores the potency of a lot.
Item Ledger File (F4111)	Stores transaction history for all items.
Item History (F4115)	Stores usage data for items that are optional in some transaction programs in the Shop Floor Management system.
Warehouse Requests (F4600)	Stores putaway, picking, and replenishment requests.
Location Detail Information (F4602)	Stores the information for locations, such as item, business unit, and lot.
Warehouse Suggestions (F4611)	Stores putaway, pick, and replenishment suggestions for inventory movement
Work Order Master File (F4801)	Stores the work order and rate schedule information, such as item numbers, quantities, dates, lots, locations, and shift codes.
Work Order Instructions File (F4802)	Stores text and instructions for specific work orders that are identified by different record types.

Types of Manufacturing

Discrete, process, and repetitive manufacturing all use bills of material and routing instructions. The bills of material contain individual parts or components, such as nuts, bolts, wire, plastic, or metal parts of a fixed or variable quantity. Products can be broken down into subassemblies that go into various larger assemblies. The routing instructions include the operations to be performed, their sequence, the various work centers involved, and the standards for setting up and running the operations.

All types of manufacturing use the term *item* for both the raw materials and finished goods. Not all items are planned, scheduled, or produced in their primary unit of measure. To accommodate this fact, full unit of measure capabilities are allowed throughout the Shop Floor Management system. Most entry programs have a Unit of Measure field next to the quantity fields. The unit of measure is stored in the database tables with the quantities. Throughout the Shop Floor Management system, the system uses the values in the following three fields in the Item Master table (F4101) as default values in entry forms:

- Component Unit of Measure

- Production Unit of Measure

- Primary Unit of Measure

The value in the Primary Unit of Measure field must be the smallest of the three units of measure.

See Also

❑ *Defining Default Units of Measure for Bulk Items* in the *Bulk Stock Management Guide*, if your company uses or manufactures bulk product

Discrete Manufacturing

Discrete manufacturing is typically characterized by the following:

- Work orders produce a specific quantity of a single item for a specific completion date.

- Routing instructions are a series of independent operations.

- Components can be manually issued with the release of the work order, backflushed at the completion of the work order, or both.

Discrete manufacturing is most often used in the following manufacturing environments:

- Make-to-stock, using either a highly repetitive or process order-based system

- Any of the "to-order" strategies, such as make-to-order, assemble-to-order, or engineer-to-order

- The one-off or job shop environment

Discrete manufacturing is used to produce items such as the following:

- Cars

- Furniture

- Electronics

- Airplanes

Process Manufacturing

Process manufacturing is typically characterized by the following:

- Work orders produce multiple items, both coproducts and by-products, for a specific completion date.

- Routing instructions are a series of dependent operations that work together continuously.

- Products are often produced in batches or with a continuous process.

- Components or ingredients are often stated in terms of a recipe or formula.

- The quantities of components or ingredients can vary according to their grade or potency.

- Components or ingredients can be issued by preflushing with the release of the work order or backflushed at the completion of the work order.

Process manufacturing is most often used to produce the following:

- Pharmaceuticals

- Foods and beverages

- Raw materials such as lumber, metals, and fluids

The different types of processing in process manufacturing consist of the following:

Batch processing	In batch processing, a product is usually made in a standard run or lot-size that is determined by vessel size, line rates, or a length of standard run. Items are typically scheduled in short production runs due to the life cycle of the product after its completion. Typical items might be pharmaceuticals, foods, inks, glues, oil or chemical products, and paints. A coproducts and by-products list might be generated during batch processing.
Continuous processing	In continuous (or flow) processing, the production period is typically extended, using dedicated equipment that produces one product or product line with slight variations. This method of manufacturing is characterized by the difficulty of planning and controlling variances in quantity and quality yield. Typical items might be petroleum-based products or distilled seawater. Coproducts and by-products are generally more prevalent in continuous processing than in batch processing.

Strategies that are similar to discrete manufacturing, including repetitive or any of the to-orders strategies (such as, make-to-order, assemble-to-order, or engineer-to-order) might be used to control the process. Usually, both batch and continuous processing methods require extensive record-keeping. You must track quality and tolerance values during the process, as well as strictly adhere to *lot tracing* and *lot tracking*. You use lot tracing to display the items that are assigned to a lot. You use lot tracking to display the items that are removed from a lot.

Repetitive Manufacturing

Repetitive manufacturing is typically characterized by the following:

- Entire production lines are dedicated to a family of products.

- Product families share similar components and routing instructions.

- Products are often manufactured in a continuous process that requires less inventory movement to and from the production line.

- Work center setup and changeover times between related products are minimized.

- Production is defined in units per hour. The time spent at the operational level might or might not be important. Therefore, you must be able to set up line capacity and define routing instructions in units per hour at the line level. The fundamental basis for backscheduling and capacity planning is hours. To view information in units, the system uses a conversion factor defined at the work center level.

- Visual cues, called kanbans, control material movement. Kanbans represent predetermined quantities of components at specified locations on the production line. They are designed to minimize work-in-process inventories.

Fast Path Commands

The following table lists the fast path commands that you can use to move among the Shop Floor Management menus. From any menu, enter the fast path command in the Fast Path box.

Fast Path	Menu	Menu Title
SFC	G31	Shop Floor Management
DOPD	G3111	Daily Order Preparation - Discrete
DORD	G3112	Daily Order Reporting - Discrete
DOPP	G3113	Daily Order Preparation - Process
DORP	G3114	Daily Order Reporting - Process
DRB	G3115	Daily Processing - Repetitive
MA	G3116	Manufacturing Accounting
PSFD	G3121	Periodic Functions - Discrete
PSFP	G3122	Periodic Functions - Process
PMA	G3123	Manufacturing Acctg Reports
ASF	G3131	Shop Floor Management Advanced
SSFC	G3141	Shop Floor Management Setup

You can use the Work With User Defined Codes form to locate fast path commands (UDC 00/FP).

Shop Floor System Setup

Shop Floor Management requires some setup before you can use the system. Setup for Shop Floor Management includes identifying the codes needed for work orders, such as priority, status, and category codes, and defining the information needed for discrete, process, and repetitive manufacturing, such as shop floor calendars, work centers, and so on.

You must also set up information that is necessary for manufacturing, such as generic messages, shop floor calendars, manufacturing constants, work centers, resource units, and item-to-line relationships.

Prerequisites

❑ Set up records in the following tables in the Inventory Management system:

- Item Master (F4101)

- Item Branch File (F4102)

See *System Setup* and *Lot Processing* in the *Inventory Management Guide* for information about setting up the item master, item branch, and lot master records

❑ Verify that all of the items that you want to control by kanbans have been set up and that the kanbans have been generated and printed. See the *Kanban Management Setup* section in the *Kanban Management Guide* for information about defining kanban-controlled items.

User Defined Codes for Work Orders

Many fields throughout Shop Floor Management accept only user defined codes for work orders. You need to define these user defined codes for your manufacturing work orders.

User defined codes are stored in tables by system and code type. For example, system 31, type OS represents Shop Floor Management and a user defined code called operation status. To set up operation status codes for your work orders, use the User Defined Codes program (P0004A) to identify all of the codes that you want to use to identify the different operation statuses. If you enter an operation status code on another form that you did not identify as an operation status code in the User Defined Codes program, the system displays an error message. For example, in the operation status code field, you can enter only those codes that exist in the user defined code table 31/OS.

You can access all codes through a single user defined code form. After you choose a user defined code form from a menu, you can change the values in the System Code and User Defined Code fields to access another user defined code table. The system stores user defined codes in the User Defined Codes table (F0005).

The following table lists user defined codes for work orders:

Work Order/ECO Type (00/TY)

Work order/ECO type codes indicate the classification of a work order. For example, rework orders might be type R, and design orders might be type D.

Work Order Priority Code (00/PR)

Work order priority codes indicate the priority of a work order in relation to other work orders. These codes are for reference only and do not affect the scheduling or planning of work. Do not use these codes as your formal priority system.

Work Order Status Code (00/SS)

Work order status codes describe the status of an order or the current step in the process of implementing a work order. You can prevent certain transactions from occurring, based on the status of a work order. For instance, the system can hold work orders for which the status indicates that they are pending approval or quality inspection, and release work orders that have status codes indicating that they have been approved or have passed quality inspection. You can also set up the system to automatically update the work order status code when you enter issue and completion transactions.

Phase and Matter Codes (00/W1)

Phase and matter codes indicate the implementation phase of the work order. You can use phase and matter codes to group families of orders for project management, cost accounting, and inquiry purposes. For example, if inspection on the internal parts of a product is not possible beyond a certain point in its production, you can divide the routing into phases. You can then use the phase code to indicate the availability of the product for the next level of inspection.

Work Order Category Codes (00/W2 and 00/W3)

Work order category codes can represent any category or description by which you want to group work orders for project management, cost accounting, or reviews. For example, you can set up one category code to represent types of problems that you might encounter during the work order implementation, such as improper startup or inadequate maintenance, and another code to represent locations in which the work is taking place.

Operation Status (31/OS)

Work order operation status codes indicate the progress or status of an order during the steps that you follow in a particular operation. For example, you can set up codes to indicate whether materials have been received or work has begun at a particular operation. This code allows management to monitor the progress of operations that have longer run times, or shop floor personnel to indicate when items are ready to move to the next operation.

Document Type (00/DT)

Document type codes categorize information throughout your EnterpriseOne systems. You can specify up to 12 document types to use for work orders and rates in supply and demand calculations by entering them in the processing options for the Supply/Demand Inclusion Rules program (P34004) in the Manufacturing Planning system. The Manufacturing Accounting system uses the document type to match your orders to the document types that are defined in your automatic accounting instructions (AAIs) when you post journal entries to the general ledger. You can use the document type codes to categorize your work orders by document type. For example, you can define document type codes to indicate rework orders, prototype orders, or repair orders. If you do not specify a document type on a new work order, the system enters a document type of WO (Firm Work Order).

In the Codes field, enter the two-character document type code for which you want the system to track lot quantities. For example, enter OP to allow the system to track lot quantities for all purchase orders.

Order Type (48/OT)

Order type codes allow you to distinguish each work order record in the Work Order Master File table (F4801) from other records with different work order types. For example, you do not use the same document type and work order type to represent both an equipment work order and a manufacturing work order. The relationship between the document type and its related order type is defined in the Document Type Maintenance program (P40040).

Unit of Measure (00/UM)

Unit of measure codes must be assigned to each item that you purchase, issue, manufacture, or sell. Each item can have as many as eight units of measure, but one must be identified as the primary unit of measure. You must also set up the conversion tables after you have set up all unit of measure and potent unit of measure codes.

Potent units are units of measure for items with potency. The potent units always have a comparable code in UDC 00/UM. For example, if your company uses potency and measures product in gallons, you set up a code such as GA for gallon and a potent unit code such as GP for the potent gallon. When you set up potent units, you must enter P in the Special Handling Code field.

When the system creates commitments for an item that is set up with a potent unit of measure, it converts the quantity to the primary unit of measure. For example, if you issue product in GP (potent gallons), the system converts it to the primary unit of measure of GA (gallons).

Defining Document Type Constants for Work Orders

Document types are used in the software to specify particular types of transactions. You define the characteristics of document types in the Document Type Maintenance program (P40040). The document type constants defined in this program affect all software transactions. The order type for each of the document types must be defined so that the system knows how to process the activity for it. For example, the document type for a manufacturing work order can be set to WO for the correct transactions that relate to the processing of a manufacturing work order.

To differentiate the various work order document types from each other, you assign a specific order type to each work order document type. For example, a manufacturing work order is associated with order type 02.

The following order type values for work order processing are stored in the UDC table 48/OT (Order Type) and are hard-coded:

Document Type	Order Type
Manufacturing Work Order	02
Manufacturing Rework Work Order	03
Equipment Work Order	04
Service Order	05
Warranty Claim Order	06
Supplier Recovery Order	07
Engineering Change Order	08
Engineering Change Request Order	09
Real Estate Management	10
ETO Summary Order	11
Rate Schedule	12

See Also

❑ *Setting Up Document Type Information* in the *Inventory Management Guide*

Converting Existing Document Types

From the Upgrade Conversions menu (GH9619A), choose Convert F40039 to ERP 9.0.

In PeopleSoft EnterpriseOne 8.9 software, each type of work order is designated by a specific work order type (A201). If you have existing records in the Document Type Master table (F40039), these records now require a specific value in the Work Order Type field (A201). You run the Convert F40039 to ERP 9.0 program (R31P40039) only once to enter the desired values in this field. You determine the values entered in the processing options. Depending on which systems you use, you complete the fields on the appropriate tabs. For example, you complete the fields on the Manufacturing tab for manufacturing work orders. You can run this program in either proof mode or final mode.

Processing Options for Document Type Master (F40039) Conversion (R31P40039)

Process Tab

This processing option controls whether you run the conversion program in proof or in final mode.

1. Mode

Blank = Proof
1 = Final

Use this processing option to specify whether the system runs the report in proof or final mode. Valid values are:

1

Proof (default)

2

Final

Manufacturing Tab

These processing options specify which order type is assigned to manufacturing orders during conversion.

1. Order Type value 01 for Manufacturing Orders

Use this processing option to specify the order type for manufacturing work orders.

2. Order Type value 02 for Manufacturing Orders

Use this processing option to specify the order type for manufacturing work orders.

3. Order Type value 03 for Manufacturing Orders

Use this processing option to specify the order type for manufacturing work orders.

4. Order Type value 04 for Manufacturing Orders

Use this processing option to specify the order type for manufacturing work orders.

5. Order Type value 05 for Manufacturing Orders

Use this processing option to specify the order type for manufacturing work orders.

Manufacturing Rework Tab

These processing options specify which order type is assigned to manufacturing rework orders during conversion.

1. Order Type value 01 for Engineering Change Request Orders

Use this processing option to specify the order type for manufacturing rework work orders.

2. Order Type value 02 for Engineering Change Request Orders

Use this processing option to specify the order type for manufacturing rework work orders.

3. Order Type value 03 for Engineering Change Request Orders

Use this processing option to specify the order type for manufacturing rework work orders.

4. Order Type value 04 for Engineering Change Request Orders

Use this processing option to specify the order type for manufacturing rework work orders.

5. Order Type value 05 for Engineering Change Request Orders

Use this processing option to specify the order type for manufacturing rework work orders.

Equipment Tab

These processing options specify which order type is assigned to equipment orders during conversion.

1. Order Type value 01 for Equipment Orders

Use this processing option to specify the order type for service work orders.

2. Order Type value 02 for Equipment Orders

Use this processing option to specify the order type for service work orders.

3. Order Type value 03 for Equipment Orders

Use this processing option to specify the order type for service work orders.

4. Order Type value 04 for Equipment Orders

Use this processing option to specify the order type for service work orders.

5. Order Type value 05 for Equipment Orders

Use this processing option to specify the order type for service work orders.

S/WM Tab

These processing options specify which order type is assigned to service during conversion.

1. Order Type value 01 for Service Orders

Use this processing option to specify the order type for service work orders.

2. Order Type value 02 for Service Orders

Use this processing option to specify the order type for service work orders.

3. Order Type value 03 for Service Orders

Use this processing option to specify the order type for service work orders.

4. Order Type value 04 for Service Orders

Use this processing option to specify the order type for service work orders.

5. Order Type value 05 for Service Orders

Use this processing option to specify the order type for service work orders.

Warranty Claim Tab

These processing options specify which order type is assigned to warranty claim orders during conversion.

1. Order Type value 01 for Warranty Claim Orders

Use this processing option to specify the order type for warranty claim orders.

2. Order Type value 02 for Warranty Claim Orders

Use this processing option to specify the order type for warranty claim orders.

3. Order Type value 03 for Warranty Claim Orders

Use this processing option to specify the order type for warranty claim orders.

4.Order Type value 04 for Warranty Claim Orders

Use this processing option to specify the order type for warranty claim orders.

5. Order Type value 05 for Warranty Claim Orders

Use this processing option to specify the order type for warranty claim orders.

Supplier Recovery Tab

These processing options specify which order type is assigned to supplier recovery orders during conversion.

1. Order Type value 01 for Supplier Recovery Orders

Use this processing option to specify the order type for supplier recovery orders.

2. Order Type value 02 for Supplier Recovery Orders

Use this processing option to specify the order type for supplier recovery orders.

3. Order Type value 03 for Supplier Recovery Orders

Use this processing option to specify the order type for supplier recovery orders.

4. Order Type value 04 for Supplier Recovery Orders

Use this processing option to specify the order type for supplier recovery orders.

5. Order Type value 05 for Supplier Recovery orders

Use this processing option to specify the order type for supplier recovery orders.

ECO Tab

These processing options specify which order type is assigned to engineering change orders during conversion.

1. Order Type value 01 for Engineering Change Orders

Use this processing option to specify the order type for engineering change orders.

2. Order Type value 02 for Engineering Change Orders

Use this processing option to specify the order type for engineering change orders.

3. Order Type value 03 for Engineering Change Orders

Use this processing option to specify the order type for engineering change orders.

4. Order Type value 04 for Engineering Change Orders

Use this processing option to specify the order type for engineering change orders.

5. Order Type value 05 for Engineering Change Orders

Use this processing option to specify the order type for engineering change orders.

ECO Request Tab

These processing options specify which order type is assigned to engineering change request orders during conversion.

1. Order Type value 01 for Engineering Change Request Orders

Use this processing option to specify the order type for engineering change request orders.

2. Order Type value 02 for Engineering Change Request Orders

Use this processing option to specify the order type for engineering change request orders.

3. Order Type value 03 for Engineering Change Request Orders

Use this processing option to specify the order type for engineering change request orders.

4. Order Type value 04 for Engineering Change Request Orders

Use this processing option to specify the order type for engineering change request orders.

5. Order Type value 05 for Engineering Change Request Orders

Use this processing option to specify the order type for engineering change request orders.

Real Estate Management Tab

These processing options specify which order type is assigned to Real Estate Management orders during conversion.

1. Order Type value 01 for Real Estate Management Orders

Use this processing option to specify the order type for property management orders.

2. Order Type value 02 for Real Estate Management Orders

Use this processing option to specify the order type for property management orders.

3. Order Type value 03 for Real Estate Management Orders

Use this processing option to specify the order type for property management orders.

4. Order Type value 04 for Real Estate Management Orders

Use this processing option to specify the order type for property management orders.

5. Order Type value 05 for Real Estate Management Orders

Use this processing option to specify the order type for property management orders.

Rate Schedule Tab

These processing options specify which order type is assigned to rate schedules during conversion.

1. Order Type value 01 for Rate Schedule Orders

Use this processing option to specify the order type for rate schedules.

2. Order Type value 02 for Rate Schedule Orders

Use this processing option to specify the order type for rate schedules.

3. Order Type value 03 for Rate Schedule Orders

Use this processing option to specify the order type for rate schedules.

4. Order Type value 04 for Rate Schedule Orders

Use this processing option to specify the order type for rate schedules.

5. Order Type value 05 for Rate Schedule Orders

Use this processing option to specify the order type for rate schedules.

ETO Summary Order Tab

These processing options specify which order type is assigned to ETO summary orders during conversion.

1. Order Type value 01 for ETO Summary Orders

Use this processing option to specify the order type for engineer to order summary orders.

2. Order Type value 02 for ETO Summary Orders

Use this processing option to specify the order type for engineer to order summary orders.

3. Order Type value 03 for ETO Summary Orders

Use this processing option to specify the order type for engineer to order summary orders.

4. Order Type value 04 for ETO Summary Orders

Use this processing option to specify the order type for engineer to order summary orders.

5. Order Type value 05 for ETO Summary Orders

Use this processing option to specify the order type for engineer to order summary orders.

Converting Order Types

In the EnterpriseOne Windows environment, choose Batch Versions from the System Administration Tools menu (GH9011).

In PeopleSoft EnterpriseOne 8.9 software, different work orders have to be designated by different document types. For example, if manufacturing work orders have document type WO, equipment orders have to be assigned a different document type. To ensure that the different types of work orders have unique document types, you run the Order Type Conversion program (R31P802). You use the data selection to define which orders in the Work Order Master File table (F4801) need to be converted. The program assigns new document types to work orders based on the definition in the processing options.

Processing Options for Order Type Conversion (R31P802)

Default Tab

This processing option defines the new order type to which the selected work orders should be converted.

1. Order Type (to be converted to)

Use this processing option to specify the new order type to which orders are converted. The order type that you specify here will be the default order type for the selected records.

Process Tab

This processing option controls whether the conversion program runs in proof or final mode.

1. Mode

1   = Final
Blank = Proof

Use this processing option to specify whether the program runs in proof mode or final mode. When you run the program in proof mode, the system generates a report but does not update data. When you run the program in final mode, the system updates the order type in the Work Order Master File table (F4801). Valid values are:

Blank

Proof mode

1

Final mode

Setting Up Standard Procedures

You can set up codes and text to describe standard procedures for your work orders. For example, you can do the following:

- Designate a specific procedure for a work order or group of work orders.

- Provide a list of instructions to complete a work order.

- Include messages for work orders.

For example, you might set up a code called 1000 for a 1000-hour maintenance inspection. For the 1000 code, you can enter text to describe procedures, such as checking coolant levels and adjusting belt tension.

To avoid retyping similar procedures for every work order, you can also copy the appropriate message text from another procedure.

After you set up standard procedures, you can assign them to the appropriate work orders.

► **To set up standard procedures**

Use one of the following navigations:

For the Work Orders system, choose Standard Procedures from the Work Order Setup menu (G4841).

For the Product Data Management system, choose Standard Procedure Descriptions from the Product Data Management Setup menu (G3041).

For the Shop Floor Management system, choose Standard Procedures from the Shop Floor Management Setup menu (G3141).

1. On Work With Generic Message/Rate Types, click Select or Add.

PeopleSoft.

Standard Procedures - Enter Generic Message/Rates

OK Find Delete Cancel Form Row Tools

Product Code   48   Work Order Processing

User Defined Codes   SN

Records 1 - 10   Customize Grid

		Code	Description	Rate
⦿	🖉	01-405	Overhaul Motor	
○		1000	1000 hour maintenance steps	
○		1001	General Assembly Procedure	
○		1002	Quality Control General Proc	
○		250	250 hour maintenance steps	
○		500	500 hour maintenance steps	
○		CHECKLIST	Maintenance Checklist	
○		LOCKOUT	Lockout / Tagout Procedure	
○		VEHICLE	General Work On Vehicle	
○				

2. On Enter Generic Message/Rates, in a blank record, complete the following fields:

   - Code
   - Description

3. Choose the record that you entered and then choose General Message from the Row menu.

4. On General Message, to enter new message text, complete the following field:

   - Description

     Enter a description of the standard procedure.

5. Click OK and go to Step 10.

6. On General Message, to copy message text from another procedure, choose Search from the Row menu.

7. On Standard Text Search, complete any of the following fields and click Find:

   - Product Code
   - User Defined Codes
   - Message Number

8. Choose the rows of text to copy and click Select.

   The text that you selected to copy appears on the General Message form.

9. On General Message, click OK.

   The system adds the message text to the standard procedure code.

10. On Enter Generic Message/Rates, click OK.

    If you need to change message text for a standard procedure code, you can type over the existing text.

Processing Options for Standard Procedures (P00191)

Defaults
1. System Code
2. Record Type
Display
1. Text Type

1 = Display Rate Text
2 = Display Message Text
2. Text Column Display

1 = 60 Column Display
2 = 80 Column Display

Setting Up Employee Labor Rates

You can set up codes that represent the hourly labor rates for your employees. Table 31/ER contains employee labor rates that the system uses to calculate actual labor costs. For each code, you can define the name or type of employee that the code represents and the hourly labor rate for the employee or job category.

When you use actual costing, the rate that you define for each employee appears in the Employee Rate field on the Time Entry Revisions form (W311221C) when the employee enters time transactions.

See Also

❑ *Setting Up Manufacturing Constants for Product Costing and Manufacturing Accounting* in the *Product Costing and Manufacturing Accounting Guide* for information about the fields to use for actual costing

► **To set up employee labor rates**

From the Shop Floor Management Setup menu (G3141), choose Employee Labor Rates.

1. On Work With Generic Message/Rate Types, choose Message/Rates from the Row menu.

2. On Enter Generic Message/Rates, access a blank row in the detail area, complete the following fields, and then click OK:

   - Code
   - Description
   - Rate

   The code should represent an address book record of an employee who completes work on a work order.

Setting Up the Shop Floor Calendar

You can use the Shop Floor Calendar program (P00071) to define the work days by month and year for each branch or all branches in your system. The system uses this calendar to determine manufacturing schedules.

You can also define calendars by shift. The system uses these calendars for line scheduling and sequencing by shift in repetitive manufacturing. Shift calendars are not used for DRP/MPS/MRP.

To increase plant capacity, manufacturers run production lines for more than one shift, as well as run different lines of production on different days of the week. You specify these shifts and lines in the Shop Floor Calendar program.

When you have not yet defined the shop floor calendar for the branch, month, and year, the system preloads default work days (Monday through Friday) and weekends (Saturday and Sunday). Holidays are always user defined.

▶ To add a work day calendar

Use one of the following navigations:

For the Accounts Payable and Accounts Receivable systems, choose Work Day Calendar from the Payment Terms Revisions menu (G00141).

For the Capital Asset Management system, choose Work Day Calendar from the Planning Setup menu (G1346).

For the Transportation Management system, choose Work Day Calendar from the Transportation Setup menu (G4941).

For the Shop Floor Management system, choose Shop Floor Calendar from the Shop Floor Management Setup menu (G3141).

For the Product Data Management system, choose Shop Floor Calendar from the Product Data Management Setup menu (G3041).

The Work With Workday Calendar form appears, displaying all of the calendars that have been set up.

PeopleSoft.

Work Day Calendar - Work With Workday Calendar

Select Find Add Delete Close Tools

Branch/Plant   [ ]

Calendar Type   [*]

Calendar Name   [*]

Calendar Month [*]   Calendar Year [*]   Shift Code [*]

Records 1 - 10   Customize Grid

	Branch/Plant	Description	Month	Year	Century	Shift Code	Calendar Type	Calendar Name
☐	10	Western Distribution Center	6	5	20			
☐	27	Eastern Area DC	1	98	19			
☐	27	Eastern Area DC	2	98	19			
☐	27	Eastern Area DC	3	98	19			
☐	27	Eastern Area DC	4	98	19			
☐	27	Eastern Area DC	5	98	19			
☐	27	Eastern Area DC	6	98	19			
☐	27	Eastern Area DC	7	98	19			
☐	27	Eastern Area DC	8	98	19			
☐	27	Eastern Area DC	9	98	19			

1. To add a new calendar, on Work With Workday Calendar, complete the following required fields:

   - Branch/Plant

     With the exception of ALL, which is a hard-coded value for this program, the branch/plant that you assign must exist in the Business Unit Master table (F0006).

   - Calendar Year
   - Calendar Month

2. Complete the following optional fields to specify unique calendars for the same branch/plant:

   - Calendar Type
   - Calendar Name
   - Shift Code

     If you enter a value in the Calendar Name field, you must enter a shift code.

3. Click Add.

   The Workday Calendar Revisions form appears, displaying two calendars for the month and year. The calendar on the left shows the numerical days, and the one on the right shows the work days and nonworking days.

4. On Workday Calendar Revisions, change the default values as necessary for each day of the week and click OK.

The types of days that you can specify are in UDC 00/TD. With the exception of W, which is hard-coded as a work day, all other values specified are nonworking days. Examples of the type of day that you can specify on the calendar are:

- W (workday)
- E (weekend)
- H (holiday)
- S (shut-down)

Processing Options for Workday Calendar (P00071)

Interop
1. Enter the transaction type for the interoperability transaction. If left blank, outbound interoperability processing will not be performed.
Type - Transaction
2. Enter a '1' to write before images for outbound change transactions. If left blank, only after images will be written.
Before Image Processing

Setting Up Manufacturing Constants

You set up manufacturing constants to define branch-specific information that affects processing throughout the EnterpriseOne Manufacturing systems. You can use the Manufacturing Constants program (P3009) to specify the values for constants. The following table describes the information that appears on each tab of the Manufacturing Constants program:

Manufacturing constants	These constants specify the following: • Whether the system validates bills of material online as you enter them • Whether an audit trail tracks all changes made to bills of material • Whether the system uses the master routing for an item or the routing instructions that are defined for the parent item
Shifts	These constants specify the number of work hours that the plant typically operates in a day.
Commitment Control	These constants specify when inventory is committed and backflushed.
Costing options	These constants specify which overhead cost calculations are used and whether the system considers work center efficiency when it calculates direct labor and overhead costs. You can specify whether costs are maintained by cost components and work center or by cost component only. Costing options also include the source for machine and labor rates.

► **To set up manufacturing constants for Shop Floor Management**

From the Shop Floor Management Setup menu (G3141), choose Manufacturing Constants.

1. On Work with Manufacturing Constants, complete the following field and click Find:

   • Skip to Branch/Plant

2. Choose the appropriate branch/plant and click Select.

3. On Manufacturing Constants Revision, click the following required BOM/Routing option to turn it on:

- On-Line BOM Validation

4. Click the Manufacturing Constants tab and complete the following optional fields:

- Backflush Options
- Status for Changes

5. Click any of the following BOM/Routing options to turn them on:

- Log Bill of Material
- Master Routings

6. Click the Shifts tab and then complete the following fields:

- Work Hours
- Shift Code

You can enter hours for up to six different shifts. However, the Work Hours Per Day field displays the total of only the first three shift hours.

7. Click the Commitment Control tab, and then click one of the following Commitment Control options:

- Primary Location
- Split-Cross Branch boundaries
- Split-Don't cross Branch boundaries

8. Click one of the following Hard/Soft Commit options:

- Hard at creation of Parts List
- Soft, Hard when printing
- Soft at creation of Parts List

9. Click OK.

See Also

❑ *Setting Up Manufacturing Constants for Product Costing and Manufacturing Accounting* in the *Product Costing and Manufacturing Accounting Guide* for information about defining costing options

Setting Up Work Centers

You can maintain general information about a work center, such as pay points, prime load codes, number of machines and workers, crew size, and backflush locations. You set up work centers by branch/plant, which means that you can associate the same work center with multiple branch/plants. You can also define a unique shop floor calendar for a particular combination of work center and branch/plant.

From the Enter/Change Work Centers program (P3006), you can access business unit information to maintain business units and track costs.

Note

If you use the Warehouse Management system and do not set up valid work center locations, the system interfaces with Warehouse Management when you attach a parts list to a work order. If you set up valid work center locations before you attach a parts list, but the work order quantity exceeds the quantity that you have in the work center, the system uses Warehouse Management to create a pick request for the remaining quantity to fill the work order request. This process follows the rules that you define in the Warehouse Management system.

Use the Enter/Change Work Centers program to set up production lines for repetitive manufacturing. This setup consists of linking work centers together to establish a specific repetitive line on which a product family will be manufactured.

Prerequisite

❑ Set up your work centers and dispatch groups as valid business units in the Revise Single Business Unit program (P0006). See *Setting Up Business Units* in the *General Accounting Guide*.

► **To set up work centers**

From the Shop Floor Management Setup menu (G3141), choose Enter/Change Work Centers.

1. On Work With Work Centers, click Add.

2. On Work Center Master Revisions, complete the following fields:

   - Work Center
   - Branch/Plant

3. On the Work Center Master tab, complete the following fields:

   - Prime Load
   - Crew Size
   - Number of Employees

4. If you want to associate a particular shop floor calendar with the work center, complete the following field:

   - Calendar Name

- Dispatch Group
- Location - Issue
- Location Branch
- Work Center Type
- Pay Point
- Critical W/C
- Number of Machines

5. Click the Capacity & Shifts tab and complete the following fields:

- Work Hours
- Shift

- Standard Capacity
- Capacity UOM
- Minimum Capacity
- Maximum Capacity

6. Click the Hours & Efficiency tab and complete the following optional fields:

- Queue Hours
- Move Hours

7. Click OK.

See Also

❑ *Working with Work Centers* in the *Product Data Management Guide* for more information about defining costing and accounting information for work centers

❑ *Setting Up Simulated Rates for Work Centers* in the *Product Costing and Manufacturing Accounting Guide* for information about maintaining simulated work center rates

Processing Options for Work Center Revision (P3006)

Interop
1. Enter the transaction type for the interoperability transaction. If left blank, outbound interoperability processing will not be performed.
Type - Transaction
2. Enter a '1' to write before images for Outbound change transactions. If left blank, only after images will be written.
Before Image Processing
Versions
Manufacturing Constants (P3009)
Business Units (P0006)

Setting Up Resource Units

Resource unit information indicates the capacity of a work center on a given day. The system uses this information to back-schedule work orders in Shop Floor Management and to calculate available hours for capacity planning.

You can manually change the values to account for scheduled or unscheduled downtime, additional shifts, or vacation time. However, each time that you run the Work Center Resource Units Generation program (R3007G), the system recalculates the form values based on information in the Work Center Revisions program (P3006), the Shop Floor Calendar program (P00071), and the Job Shop Manufacturing Constants table (F3009), and then overwrites the changes that you entered manually, based on the effectivity dates that you specified in the processing options.

The Work Center Resource Units Generation program recalculates the work center hours and updates them on the Work Center Resource Units program (P3007). The system recalculates the resource units for a work center based on information in the Work Center Revisions program, the Shop Floor Calendar program, and the Job Shop Manufacturing Constants table (F3009). You can create versions to recalculate the labor, setup, or machine hours, and set the processing options to update different dates and branches.

The system multiplies the number of machines or employees by the work hours per day from the Work Center Revisions program. If the work hours per day are not available from the Work Center Revisions program, then the system uses the work hours per day from the F3009 table that the system defines for each work day on the Shop Floor Calendar.

Resource unit calculations for machine- and labor-related hours are:

- Machine-related hours (prime load code = C or M)

    Number of machines multiplied by work hours per day

- Labor-related hours (prime load code = L or B)

    Number of employees multiplied by work hours per day

Prerequisite

❑   Define work days for the branch or plant in the shop floor calendar.

► **To set up resource units**

Use one of the following navigations:

For Shop Floor Management, choose Enter/Change Resource Units from the Shop Floor Management Setup menu (G3141).

For Capital Asset Management, choose Craft Resource Units from the Labor Planning menu (G1324).

1. On Work with Resource Units, complete the following fields:

   - Branch/Plant
   - Work Center
   - Month
   - Year

2. To specify a specific shift, complete the following field:

   - Shift

3. Click Find.

4. Choose a record and click Select.

5. On Work Center Resource Unit Revision, complete the following field for each day:

   - Total Resource Units

6. Complete the following optional fields:

   - Efficiency
   - Utilization

7. Click OK.

8. Review the following field:

   - Shift

Note

You cannot manually change the values if the value in the Shift field is blank. A blank value in the Shift field represents the sum of all shifts for a work center for a specific period of time.

9. Click OK.

See Also

❑ *Setting Up the Shop Floor Calendar*

❑ *Generating Resource Units Automatically* in the *Requirements Planning Guide* for information about refreshing resource units for work centers

Processing Options for Work Center Resource Units (P3007)

Defaults
1. Enter the Default Unit of Measure for Work Center Resource Units. If left blank, HR will be used as the default Unit of Measure.
Unit of Measure as Input
Work Day Calender (P00071)

Setting Up Item-to-Line Relationships

For repetitive manufacturing, the item-to-line relationships define the lines on which an item is produced and the amount of resources consumed by an item on each line. The Line/Item Relationships program (P31093) allows you to add, change, and delete data that is stored in the Line/Item Relationship Master table (F3109). You can define work center operations within a production line.

► **To set up item-to-line relationships**

From the Shop Floor Management Setup menu (G3141), choose Line/Item Relationships.

1. On Work With Line/Item Relationships, complete the following fields and click Add:

   - Branch/Plant
   - Item Number

2. On Line/Item Relationships Revisions, complete the following fields and click OK:

   - Line/Cell Identifier
   - Capacity consumed
   - Use As Default (0/1)
   - Default Shift
   - Default Period

Note

The Requirements Planning system uses the record that you identify as the default line when the system creates rates. The specifications for shift and period are valid only for the default line.

Work Orders and Rate Schedules

Work orders and rate schedules are requests to complete a given quantity of a specific item. A rate schedule is a request to complete a given quantity of an item over a period of time on a specific production line. Rate schedules are used in repetitive manufacturing, in which you produce items in a continuous process on a dedicated production line. Work orders and rate schedules consist of a header, parts list, and routing instructions.

The work order header specifies the quantity of the item requested and the date on which the quantity is required. The parts list and routing instructions specify the components, operations, and resources that are required to complete the work order. However, the rate schedule header specifies not only the quantity of the item requested and the required date, but also the production line. For process manufacturing, the work order also includes a coproducts and by-products list. This list identifies the products produced during the manufacturing process.

Creating Work Orders or Rate Schedules

You can create work orders or rate schedules in several different ways. You can enter a work order header manually. You can also create a work order as a result of master production scheduling or material requirements planning. Finally, when you create a sales order line with line type W, the system automatically creates a work order.

After creating a work order header, you attach the parts list and routing instructions, as well as the coproducts and by-products list, if applicable. You can perform these steps manually, interactively, or by using the Order Processing program (R31410). This batch program allows you to process multiple work orders or rate schedules. It performs the following actions:

- Updates the status of each work order or rate schedule

- Supplies the date to use for effectivity checking

- Issues inventory

- Prints shop paperwork

- Calculates standard costs for configured items

- Allows substitute items to be used

- Generates a purchase order for an outside operation

Usually, you enter all of the work order or rate schedule headers and then attach the parts lists, routing instructions, and list of coproducts and by-products to create the work order or rate schedule, using the Order Processing program. However, you can either attach this information to the work order or rate schedule interactively or revise it manually after you run the batch program. For example, to change a part on the parts list or specify substitutes, you can do so manually after you run the batch program. When you attach routing instructions to your work order or rate schedule interactively or revise them manually, you can identify the percent of run time that a sequence can overlap the previous operation.

Regardless of the method that you use to attach the parts list, routing instructions, and list of coproducts and by-products, you use the processing options for the Work Order Entry (P17714) and Order Processing programs to define information, such as the unit of measure to use for backscheduling the work order or rate schedule.

After you determine the resources that are required to produce the items requested, you can schedule the work order or rate schedule and begin the work. As you complete items on the work order or rate schedule, you report the following:

- Items completed

- Materials used

- Quantities scrapped

- Hours of machine and personnel time expended

You can report completions by operation to track work order or rate schedule activity as it is in process. Using the feature cost percent for configured items and the resource percent for process items, you can also calculate costs by operation and track inventory throughout the production process.

Note

If you use the Quality Management system, you can test and record test results for manufactured items in the following ways.

- Use the Quality Preference Revisions program (P40318) to maintain tests for the parent item

- Maintain generic text to indicate when to test materials, and the test with which to do so

- Enter test results for the tests that you defined for the parent item

See Also

❑ *Work Orders in Accounting* in the *Product Costing and Manufacturing Accounting Guide*

Attaching a Parts List

You attach the parts list after you enter a work order or rate schedule header. A parts list is a table of the components and their quantities required to complete the work order. You can attach the parts list using any of the following methods:

- Manually, by entering the required parts on the Work Order Parts List form (W3111A)

- Interactively, by copying a a bill of material or an existing parts list

- Automatically, using the Order Processing program (R31410)

- Automatically, by setting a processing option for the Work Order Routing Instructions program (P3112) after you attach routing instructions using the work order entry program

For batch bills and batch routings, the system determines which parts list to use by matching the quantity for the bill type that is specified on the work order header. (Use a batch bill to accommodate physical constraints, such as ovens or vats, in industries in which products are produced in fixed quantities. Use batch routings in industries such as pharmaceuticals, foods, or petroleum, in which products are manufactured in fixed quantities or batches.) If the system does not find a batch size that matches the parts list, it uses the following search sequence to locate a matching batch:

- Searches for the specified bill type with a zero batch quantity
- Searches for a type M bill with the specified quantity
- Searches for a type M bill with a zero batch quantity

If the system does not find a match, it does not attach a parts list, and you must attach the parts list manually.

Based on their effective dates, components are included in or excluded from the parts list for a work order. The system increases the quantity of each component by its scrap factor and operation scrap, if applicable.

The following table defines the terms that are used throughout the examples of the work orders that follow:

Shrink The planned loss of a parent item caused by factors such as breakage, theft, deterioration, and evaporation.

Scrap Unusable material that results from the production process. Scrap is material outside of specifications and of such characteristics that rework is impractical.

Yield The ratio of usable output from a process to its input.

The following examples illustrate several scenarios pertaining to shrink, scrap, and operational yield for the following components of parent item A. Each example is based on a quantity of 10 for Parent Item A.

	Parent Item A					
Component	B	C	D	E	F	G
Quantity Per	(2)	(4)	(1)	(12)	(2)	(1)
Operation	10	10	10	10	25	30

The following example illustrates a work order with no shrink, scrap, or yield:

Example 1	Parent Item A					
Component	B	C	D	E	F	G
Quantity Per	20	40	10	120	20	10
Operation	10	10	10	10	25	30

The following example illustrates a work order with 10 percent shrink on parent item A:

Example 2	Parent Item A					
Component	B	C	D	E	F	G
Quantity Per	22	44	11	132	22	11
Operation	10	10	10	10	25	30

The following example illustrates a work order with 10 percent scrap on component G:

Example 3	Parent Item A					
Component	B	C	D	E	F	G
Quantity Per	20	40	10	120	20	11
Operation	10	10	10	10	25	30

The following example illustrates a work order with 95 percent yield at both operations 10 and 25:

Example 4	Parent Item A					
Component	B	C	D	E	F	G
Quantity Per	22	44	11	133	21	10
Operation	10	10	10	10	25	30

The following example illustrates a work order with 10 percent shrink on parent item A, 10 percent scrap on component G, and 95 percent yield on both operations 10 and 25:

Example 5	Parent Item A					
Component	B	C	D	E	F	G
Quantity Per	24	49	12	146	23	12
Operation	10	10	10	10	25	30

Phantom Items

The Shop Floor Management system includes lower-level components of phantom items when you attach a parts list. Phantom items are characterized by the following:

- They are not planned by MRP.

- They can be any lower-level component in the bill for a parent item.

- They can be used to define a subassembly within a parent item when the subassembly is not stocked in inventory or planned by MRP, but is consumed by the parent.

For process manufacturing, these items are intermediates, and can be any lower-level part or intermediate within the process for a coproduct (parent item).

Parts List Requirements

In the following example, the parts list includes items B, E, F, and G.

Requirements

Parent A

Component B

Component C
(phantom)

Component E

Component D
(phantom)

Component F
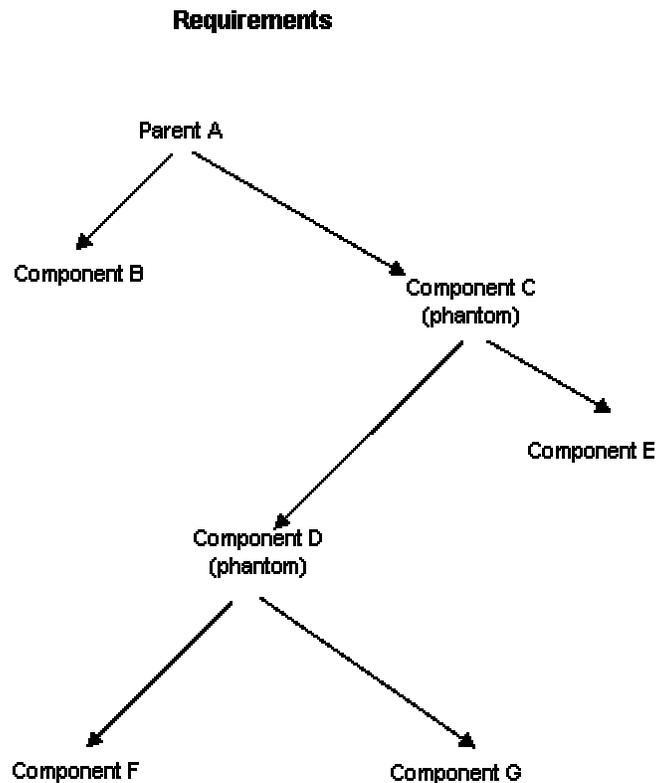
Component G

For variable quantity items, the system calculates component quantities according to the order quantity on the work order.

Note

When you activate the rounding feature in the Item Master table (F4101), the system rounds up the extended quantity value to a whole number if it has a decimal value greater than or equal to .01.

When the inventory available is insufficient to cover the parts list requirements for the work order, the system highlights the Order Quantity field on the parts list for the item that is in short supply.

The lead time offset indicates the number of days that a part is needed before or after the start date of a manufacturing work order. The system adds the lead time offset days for the part to the start date of the work order to determine the actual date on which the part is required. To indicate how many days after the work order start date that the part is required, enter a positive number on the Enter Bill of Material Information form (W3002A). To indicate that a part is needed prior to the work order start date, enter the days as a negative number. Examples of items that require negative lead time offset days are items that need processing or inspection before they can be used in an assembly. If the requested date for a component is later than the order completion date, the system enters the order completion date for the item.

When you define a shrink factor for the item on the Additional System Info form of the Item Branch program (P41026), the system compensates for the loss by increasing the component requirements for parent items by the percentage or quantity. The system displays the increased order quantity in the Order + Shrink field on the work order header. You use scrap or yield to inflate the component quantity. The system includes shrink adjustments, if applicable, when it calculates parts list quantities and routing instructions for the order.

Attaching Routing Instructions

You attach the routing instructions after you enter a work order header. Routing instructions provide details about the operations and resources that are required to complete the quantity of items requested from the shop floor. You can attach the routing instructions using any of the following methods:

- Manually, by entering each work center on the Work Order Routing form (W3112E)

- Interactively, by using the Work Order Entry program (P48013)

- Automatically, by setting a processing option for the Work Order Parts List program (P3111) after you attach a parts list using the work order entry program

- Automatically, using Order Processing (R31410)

Regardless of the method that you use to attach routing instructions to work orders, you should attach the instructions at the same time that you attach the parts list. The system uses the routing instructions to verify information about each item on the parts list.

Outside Operations

You might have steps on the routing instructions that are completed by outside operations. In this case, you need to identify those steps and run order processing in batch mode to create purchase orders for the steps. You can also create purchase orders interactively as you add the routing step that includes the outside operation. When you record the receipt through the Purchase Order Receipts program (P4312), the Routing Quantities and Status form automatically appears and allows you to update the routing quantities and status as necessary.

You can also track costs for the outside operations. To do so, set up the outside operation as an item in the Item Master table (F4101), by using the following item number structure as the item number before you process the order.

Item Number Structure

XXXXXXXX *OP YYY

Operation Number

Constant

Work Order Item Number
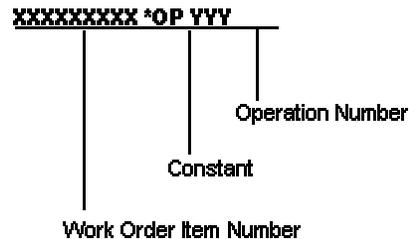
You can then assign a unit cost to the item on the Cost Revisions form (W4105A). The unit cost will be added to the item cost of the total parent when you run a cost rollup.

If you do not set up the outside operation as an item in the F4101 table, the system uses the structure mentioned previously to generate an item number for the operation, and enters the item number on the purchase order. System-generated item numbers for outside operations do not have unit costs defined. Therefore, if you do not define outside operations as items, they will carry a zero unit cost when you perform a cost rollup for the parent item and cause errors in the Purchase Order Receipts program.

The quantity of the new item on the purchase order and the supplier instructions are updated with the current information.

If the system cannot create a purchase order, it enters *NO PO in the Related Order field on the routing instructions. The system might be unable to create a purchase order for the following reasons:

- The routing instructions for the parent item do not include an item master or item branch record that has an outside operation

- The purchasing order activity rules were not set up for combination of line type, document type, and status

Attaching Co-products and By-Products

For process manufacturing, you attach coproducts and by-products after you enter a work order header. Co-products are usually manufactured together or sequentially because of product or process similarities. By-products are materials for which production is incidental to the process, but that may have value.

You can use the following methods to attach coproducts and by-products:

- Manually, by making changes after running the Order Processing program (R31410)

- Interactively, by using the Work Order Entry program (P48013)

- Automatically, by attaching them after the header is entered by setting a processing option in the Work Order Entry program (P48013)

- Automatically, by setting a processing option to attach them from the MRP system

Attaching Intermediates

Intermediates allow you to track the quantity of output of any operation in a work center at a specific time. You can define intermediates in different units of measure, by item, or by quantity. You can set up one intermediate per operation, but you cannot define an intermediate for the last operation. You can manually attach intermediates.

Fermented liquid is an example of an intermediate. The liquid ferments for an extended period of time before being distilled. The resulting liquid is not a finished product, but it proceeds to the next operation. You can use intermediates to verify quality as the process is running to ensure that the end product is produced according to specifications.

Calculating a Start Date

After you enter all required work order information on the Work Order Details form (W48013A), the system calculates the start date for the work order. To calculate the start date of a work order based on the order's due date, the system uses level lead time or lead time per unit for an item that is defined on the Plant Manufacturing tab on the Additional System Info form (W41026D). The system calculates the start date using either the item's fixed lead time or its variable lead time. For process work orders, you use the effective dates to schedule the rate.

See Also

❑ *Lead Times* in the *Shop Floor Management Guide* for detailed information about lead time calculations

Fixed Lead Time

When an item on a work order has a fixed lead time, the system determines the start date by using the level lead time to backschedule.

For example, assume the following:

- Work order due date = 10/15/99

- Level lead time = three days

The system has a start date of 10/12/99. The system then calculates the start date for the work order by subtracting the level lead time or lead time per unit, depending on the fixed or variable lead time option, from the required date. The system displays an error message if either of the following conditions occurs:

- The start date differs from the date of the first operation sequence on the routing instructions for the item

- The operation sequence dates could not be calculated using backscheduling

Variable Lead Time

If an item on the work order has a variable lead time, the system determines the start date by using the lead time per unit to backschedule. The system uses the following calculation:

$$\frac{\text{(Lead time per unit x order quantity / Time Basis Code (Item Branch)) + setup + queue}}{\text{Work hours per day}}$$

For example, assume the following:

- Work order due date = 10/15/99

- Lead time per unit = 32 hours

- Work order quantity = 1000

- Setup = 1 hour

- Queue = 9 hours

- Time basis code = 4 (units/1000)

  This information is from the Item Branch File table (F4102)

- Work hours per day = 8

The system calculates the start date by counting back two working days on the shop floor calendar from the due date. The work order start date is 10/13/99.

Backscheduling a Work Order

To meet the MRP-required date for an order, the Shop Floor Management system assigns a completion date for the routing instructions that is one day prior to the MPS/MRP-required date. Then, the system assigns the start and requested dates to each operation in the routing instructions for the work order or rate schedule. Assigning the start and requested dates for each operation is called backscheduling.

Backscheduling ensures that the material is out of production and available on the required date. For example, a work order completion date of February 15 for routing instructions ensures that the items produced will be out of production and available for shipping or sale on the MRP required date of February 16.

After you have defined your work order routing instructions, the system performs the following actions:

- Retrieves the resource units for the work center of each operation.

- Consumes the hours (queue, run, then move hours) using the calculations for either fixed or variable lead time.

- Scales the work center's remaining units proportionate to the previous operation's remaining units. For example, if 25 percent of the previous work center's units remain available, the current work center's units available to schedule for the same day will equal 25 percent of its daily total. This calculation assumes that all work centers have consumed 50 percent of available units by the middle of the calendar workday.

Generating Shop Paperwork

Shop paperwork consists of the following printouts:

- Work orders or rate schedules with or without the parts list or routing instruction information

- Shop packet summary

- Parts list shortages

To generate shop paperwork, you must run the Order Processing program (R31410) with the Shop Packet Summary processing option activated.

Entering Work Order Headers

To enter a work order header, you identify the item, its branch/plant and quantity, and the requested date for the work order. You can also enter other optional information, such as the revision level for the bill of material, or associated sales information. If you have set up the order item with a secondary unit of measure in the Item Master (P4101) and Item Branch/Plant (P41026) programs, you can enter the order information in both the primary and the secondary unit of measure, but this entry is not required.

The system calculates the start date based on the requested date that you enter. If the requested date is before the current date or is not defined as a work day, an error message appears. The system cannot calculate the start date for the work order when the requested date is in error.

If the order is created for a lot-controlled item, you can define a planned effective date, on which the item will be available for sales or commitments. You can enter this date manually or you can let the system calculate the date based on the Manufacturing Effective Days field in the Item Branch File table (F4102). If the Manufacturing Effective Days field is blank, the work order's requested date provides the default value for the Planned Effective Date field.

If a scheduling problem exists for your work order, the system displays an error message. This message indicates that a difference exists between the work order start date and one or both of the following dates:

- The start date of the first routing operation

- The calculated start date for the work order, which indicates difficulty in backscheduling

You need to differentiate each type of work order, such as manufacturing work orders, rework orders, repair orders, engineering change orders, orders for prototypes, and so on, by assigning each of them a unique document type and work order type. You use the Document Type Maintenance program (P40040) to set up these document constants.

Use the Enter/Change ECO program (P48020) to create a work order for a prior revision level by doing the following:

- Selecting a revision level to attach to the work order

- Manually entering a different revision level

You might want to determine the availability of the parts that are needed to complete a work order before you create the work order.

While entering a work order header, you can access the following additional forms:

Order Address Information (W4006B)	Use this form to locate the address of the customer on the sales order related to your work order. Blank fields appear when no sales order is associated with your work order.
Work Order Details (W48013A)	Use this form to add detailed information to the work order description.

Media Objects	Use this form to create a separate generic text entry for each work order. Notes provide more information and specific instructions for an order. Any modifications that you make to the text do not affect the text that was originally attached to the bill of material.
	You can also review update dates and information about the user by choosing Properties from the File menu on the Media Objects form. By choosing Templates from the File menu, you can access the Work with Media Object Templates form to retrieve templates that you can use to create notes.

If you use other EnterpriseOne systems, the following integration features apply:

Requirements Planning integration	The Distribution Requirements Planning, Master Production Schedule, and Material Requirements Planning systems suggest purchase and manufacturing orders that are required to maintain a valid production schedule.
Sales Order Management integration	You can generate work orders when you enter a sales order. The integration allows you to update sales information from within the Shop Floor Management system.

Prerequisites

❑ In the processing options, enter the unit of measure that you want the system to use for backscheduling the routing operations for the process.

❑ Set up the shop floor calendar for the work days and months that the order activity requires, including lead times.

❑ Set up the document types that you use to identify different work order types in the Order Type user defined code table 48/OT.

❑ If the new document types are to be used in other EnterpriseOne Manufacturing systems, specify which work order types to use in the processing options for the Supply/Demand Inclusion Rules program (P34004).

❑ Set up valid work center locations.

► **To enter work order headers**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, click Add.

2. On Work Order Details, complete the following fields:

   - Branch/Plant
   - Item No.

3. Click the Dates and Qtys tab and complete the following fields:

   - Requested
   - Order/UOM

4. Complete the following optional fields:

   - Secondary/UOM
   - Planned Effective
   - Start

5. Click the Status & Type tab, and then complete the following optional fields:

- Sts Comm.
- Bill Type
- Rtg. Type
- Status
- Type
- Freeze Code

6. Click the Addl Details 1 tab, and then complete the following optional fields:

- Charge to CC
- Parent WO
- Lot/Serial

Note

If the system created a work order from a sales order line with line type W, the fields on the Addl Details 2 tab are updated with information from the work order.

7. To add specific notes to your work order, click the Attachment tab.

8. Enter the information that you want to attach to the work order in the space provided.

9. Click OK.

See Also

❑ *Reviewing Part Availability* in the *Shop Floor Management Guide* to determine the availability of a part

Processing Options for Enter/Change Order (P48013)

Defaults Tab

Use these processing options to specify the default values for backscheduling a work order.

1. Document Type

Use this processing option to specify the default document type associated with a work order. The Document type is a user defined code (00/DT) that identifies the origin and purpose of a document. Enter the document type to use as the default value or choose it from the Select User Defined Codes form.

2. Back Scheduling Unit of Measure

Use this processing option to specify the default unit of measure to use for back scheduling the work order. Unit of measure is a user defined code (00/UM) that identifies the unit of measure to use in the document. Enter the unit of measure to use as the default value or choose it from the Select User Define Codes form.

3. Back Scheduling Queue and Move Hours

Use this processing option to specify the method that the system uses to backschedule queue hours in the work order routing. Valid values are:

   Blank The system backschedules queue hours as a percentage of the resource units per day.

   1   The system backschedules queue hours as a percentage of the work hours per day.

Optional Defaults Tab

Use these processing options to specify the default values for the type, priority, beginning status, and the cross-reference codes for the work order, and where the system retrieves the default value for the Charge to Business Unit field.

1. Work Order Type

Use this processing option to specify the default work order type associated with the work order. Work order type is a user defined code (00/TY) that identifies the type of work order. Enter the work order type to use as the default value or choose it from the Select User Define Codes form.

2. Work Order Priority

Use this processing option to specify the default priority associated with the work order. Work order priority is a user defined code (00/PR) that identifies the priority of the document. Enter the work order priority to use as the default value or choose it from the Select User Define Codes form.

3. Beginning status

Use this processing option to specify the default beginning status code on the work order header. The beginning status code is a user defined code (00/SS) that identifies the status of the work order to use when a work order is created. Enter the status code to use as the default value or choose it from the Select User Define Codes form.

4. Charge to Business Unit
1=The program uses the project number.
Blank=The program uses the branch/plant.

Use this processing option to specify whether the system uses the Project Number in the Business Unit Master table (F0006) or the branch/plant on the work order as the Charge to Business Unit. Valid values are:

1   The system uses the project number.

  Blank The system uses the branch/plant.

5. Cross Reference Code

Use this processing option to specify the default cross reference code. The cross reference code is a user defined code (41/DT) that determines how the system retrieves item replacements for obsolete items. Enter the code to use as the default value or choose it from the Select User Define Codes form.

When you enter an order containing an item that will be obsolete for your work order time frame, the system allows you to specify a replacement item if you set this processing option to R.

Sales / Configured Tab

Use these processing options to specify the default values for the work orders that are generated through sales orders.

1. Held Status Code

Use this processing option to specify a status code that the system assigns to a sales order generated work order when the related sales order is placed on hold.

The system assigns this status to the work order if the current status of the work order is less than the Cutoff Status. Status code is a user defined code (00/SS) that identifies the status of the work order. Enter the status code to use as the default value or choose it from the Select User Define Codes form.

2. Changed Status Code (Before Cutoff)

Use this processing option to specify the status code that the system assigns to:

 o A sales order generated work order when the related sales order is changed.

 o A configured work order when it is modified as a result of a change in its Configuration.

The system assigns this status to the work order if the current status of the work order is less than the Cutoff status. If you leave this processing option blank, the system will not update the status of the work order. Status codes are user-defined codes (00/SS). Enter a default status code or choose it from the Select User Define Codes form.

3. Changed Status Code (After Cutoff)

Use this processing option to specify the status code that the system assigns to:

o A sales order generated work order when the related sales order is changed.

o A configured work order when it is modified as a result of a change in its Configuration.

The system assigns this status to the work order if the current status of the work order is greater than or equal to the Cutoff status. If you leave this processing option blank, the system will not update the status of the work order. Status codes are user-defined codes (00/SS). Enter a default status code or choose it from the Select User Define Codes form.

4. Canceled Status Code

Use this processing option to specify a status code that the system assigns to:

o A sales order generated work order when the related sales order is cancelled.

o A configured work order that has been removed from its Configuration.

The system assigns this status to the work order if the current status of the work order is less than the Cutoff Status. Status code is a user defined code (00/SS) that identifies the status of the work order. Enter the status code to use as the default value or choose it from the Select User Define Codes form.

5. Cutoff Status Code

Use this processing option to specify the Cutoff status for the following types of work

orders:

    o A sales order generated work order.

    o A configured work order.

The system uses this status to determine if the work order can be automatically changed. Status code is a user defined code (00/SS) that identifies the status of the work order. Enter the status code to use as the default value or choose it from the Select User Define Codes form.

Category Codes Tab

Use these processing options to specify the default category codes for the work order and the item/branch classification codes.

Work order category codes are user defined codes (00/W1, W2, W3) that identifies the category for the work order. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

Item/branch category code is a user defined code (32/CC) that identifies the item/branch classification code on the work order header. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

1. Category Code 1

Use this processing option to specify the default category code for the work order. Work order category code is a user defined code (00/W1) that identifies the category for the work order. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

2. Category Code 2

Use this processing option to specify the default category code for the work order. Work order category code is a user defined code (00/W2) that identifies the category for the work order. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

3. Category Code 3

Use this processing option to specify the default category code for the work order. Work order category code is a user defined code (00/W3) that identifies the category for the work order. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

4. Category Code 1 on the work order header

Use this processing option to specify the default item/branch category code for the work order header. Item/branch category code is a user defined code (32/CC) that identifies the item/branch classification code on the work order header. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

5. Category Code 2 on the work order header

Use this processing option to specify the default item/branch category code for the work order header. Item/branch category code is a user defined code (32/CC) that identifies the item/branch classification code on the work order header. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

6. Category Code 3 on the work order header

Use this processing option to specify the default item/branch category code for the work order header. Item/branch category code is a user defined code (32/CC) that identifies the item/branch classification code on the work order header. Enter the category code to use as the default value or choose it from the Select User Define Codes form.

Validating Tab

Use these processing options to specify whether the system recalculates the parts list and routing instructions when quantities change, and whether to validate that the parts list text matches the item/branch record.

1. Quantities and Dates
1=The program recalculates the Parts List and Routing information.
Blank=The program does not recalculate the information.

Use this processing option to specify whether the system automatically recalculates the parts list and routing instructions when the quantities or the dates on the work order change. Valid values are:

1

The system recalculates parts list, routing instructions, and the production costs.

Blank

The system does not recalculate the information.

2. Item Branch/Plant Validation

1=Validates for existing Item/Branch record.

Blank=Does not validate for existing Item/Branch record.

Use this processing option to specify whether the system validates an existing item/branch record when you add or update a work order. Valid values are:

Blank

Do not validate an existing item/branch record.

1

Validate an existing item/branch record.

Hold Codes Tab

Use these processing options to specify the related sales order and purchase order hold codes that the system uses when the work order quantity or date changes.

1. Sales Order

Use this processing option to specify the default sales order to use. Hold code is a user defined code (42/HC) that identifies whether the sales order is being held. Enter the hold code to use as the default value or choose it from the Select User Define Codes form.

2. Purchase Order

Use this processing option to specify the default purchase order to use. Hold code is a user defined code (42/HC) that identifies whether the purchase order is being held. Enter the hold code to use as the default value or choose it from the Select User Define Codes form.

Display Options Tab

Use these processing options to specify whether the system displays the Bill of Material Type and Routing Type fields for work orders that are not manufacturing work orders. Work orders are manufacturing work orders when M is the value in the Bill of Material Type and Routing Type fields.

1. Bill of Material Field
1=The program displays the field.
Blank=The program does not display the field.

Use this processing option to specify whether the system displays the Bill of Material Type field on the Work Order Details form. Valid values are:

1   The system displays the Bill of Material Type field.

   Blank The system does not display the Bill of Material Type field.

2. Routing Type Field
1=The program displays the field.
Blank=The program does not display the field.

Use this processing option to specify whether the system displays the Routing Type field on the Work Order Details form. Valid values are:

1   The system displays the Routing Type field.

   Blank The system does not display the Routing Type field.

Versions Tab

Use these processing options to specify the versions of the following programs that the system uses in the work order creation process:

1. Bill Availability (P30200)

Use this processing option to specify the version that the system uses when you choose the row exit to the Bill Availability program (P30205) from the Work With Manufacturing Work Orders form or the Work Order Details form. If you leave this processing option blank, the system uses the ZJDE0001 version of the Bill Availability program.

Versions control how the Bill Availability program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

2. ECO Work Order Entry (P48020)

Use this processing option to specify the version that the system uses when you choose the row exit to the ECO Work Order Entry program (P48020) from the Work With Manufacturing Work Orders form or the Work Order Details form. If you leave this processing option blank, the system uses the ZJDE0001 version of the ECO Work Order Entry program.

Versions control how the ECO Work Order Entry program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

3. Assign Serial Numbers (P3105)

Use this processing option to specify the version that the system uses when you choose the row exit to the Assign Serial Numbers program (P3105) from the Work With Manufacturing Work Orders form or the Work Order Details form. If you leave this processing option blank, the system uses the ZJDE0001 version of the Assign Serial Numbers program.

Versions control how the Assign Serial Numbers program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

4. Routings (P3112)

Use this processing option to specify the version that the system uses when you choose the row exit to the Routings program (P3112) from the Work With Manufacturing Work Orders form or the Work Order Details form. If you leave this processing option blank, the system uses the ZJDE0001 version of the Routing program.

Versions control how the Routings program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

5. Parts List (P3111)

Use this processing option to specify the version that the system uses when you choose the row exit to the Parts List program (P3111) from the Work With Manufacturing Work Orders form or the Work Order Details form. If you leave this processing option blank, the system uses the ZJDE0001 version of the Parts List program.

Versions control how the Parts List program displays information. Therefore,you might need to specify the processing options to specific versions to meet your needs.

6. Material Issues (P31113)

Use this processing option to specify the version that the system uses when you take a row exit to the Work Order Inventory Issues (P31113) from the Work With Manufacturing Work Orders form. If you leave this processing option blank, the system uses the

ZJDE0001 version of the Work Order Inventory Issues program.

7. Configured Item Specification (P32942)

Use this processing option to specify the version of the Configured Item Specifications program (P32942) that the system uses when you create a work order for a configured item. If you leave this processing option blank, the system uses version ZJDE0001.

8. Related Configured Orders

Use this processing option to specify the version of the Related Configured Orders program (P3201) that the system uses when you call this program from the Work With Manufacturing Work Orders form. If you leave this processing option blank, the system uses version ZJDE0001.

Processing Manufacturing Tab

Use this processing option to specify whether the system automatically creates co-products and by-products.

1. Co- and By-Products
1=The program creates co- and by-products.
Blank=The program does not create co- and by-products.

Use this processing option to specify whether the system automatically copies and attaches co-products and by-products from the Bill of Materials. Valid values are:

   1   The system copies and attaches co-products and by-products from the Bill of Material.

   Blank The system does not copy and attach co-products and by-products from the Bill of Material.

Interoperability Tab

Use this processing option to specify the transaction type that the system uses for export processing.

1. Transaction Type

Use this processing option to specify the transaction type that the system uses for export processing. Transaction type is a user defined code (00/TT) that identifies the type of transaction for the work order. Enter the transaction type to use as the default value or choose it from the Select User Define Codes form. If you leave this field blank, the system does not use export processing.

Entering Rate Schedules

Repetitive manufacturing is designed for items that you produce in a continuous process on a dedicated production line. A rate schedule is a request to complete a given quantity of an item over a period of time on a specific production line.

Rate schedules consist of a header, a parts list, and routing instructions. The rate schedule header specifies the quantity of the item requested, the required date, and the production line. The parts list and routing instructions specify the parts, operations, and resources required to complete the rate.

Use the Enter/Change Rate Schedule program (P3109) to add a rate schedule. When you add a rate, the system verifies the following:

- The line exists in the Line/Item Relationship Master table (F3109)
- The dates appear in the appropriate shop floor calendar
- The effective date ranges are within the defined period

To increase plant capacity, manufacturers run production lines for more than one shift, as well as run different lines or production on different days of the week. You specify these shifts and lines on the shop floor calendar.

You can identify up to six shifts for the production line using the Manufacturing Constants program (P3009). You can then identify all shifts for the production line by work center, if necessary. After you set up the shifts, use the Line Scheduling Workbench program (P3153) and the Line Sequencing Workbench program (P3156) to schedule production.

Prerequisites

❑ Use the Line/Item Relationships program (P31093) to create a relationship between a line and an item.

❑ Set the processing options to automatically attach the parts list and routing instructions when you enter a rate schedule.

► **To enter rate schedules**

From the Daily Processing - Repetitive menu (G3115), choose Enter/Change Rate Schedule.

1. On Work With Rate Schedules, complete the following fields:

- Branch/Plant
- Item Number
- Effective From Date
- Thru Date

2. Click Add.

Enter/Change Rate Schedule - Rate Schedule Revisions

3. On Rate Schedule Revisions, click the Rate Schedule tab and complete the following fields:

    *   Quantity Ordered
    *   UM
    *   Line/Cell
    *   Item Number

4. Complete the following optional fields:

    *   Secondary Qty Ordered
    *   Sec UM
    *   P
    *   S
    *   Rate Status
    *   Category 1
    *   Category 2
    *   Category 3
    *   Bill Type
    *   Routing Type
    *   Freeze Code

5. Click OK.

    Depending on how you set the Attach Parts List and Routing processing option, the system can attach the parts list and routing instructions to rate schedules automatically by calling the Order Processing program (R31410) when you click OK.

See Also

The following topics in the *Shop Floor Management Guide*:

❑ *Attaching Supplementary Information* for information about interactively attaching the parts list and routing instructions

❑ *Setting Up the Shop Floor Calendar* for information about setting up shifts

❑ *Setting Up Work Centers* for information about setting up production lines

❑ *Setting Up Item-to-Line Relationships* for information about creating relationships between lines and items

Processing Options for Enter/Change Rate Schedule (P3109)

Defaults Tab

Use these processing options to specify default values to be used in the Enter/Change Rate Schedule program.

1. Rate Type

Use this processing option to specify the default rate type (UDC 00/DT) for a work order. If you leave this processing option blank, the system uses rate type SC.

2. Scheduling Unit of Measure

Use this processing option to specify the default unit of measure (00/UM) to use for scheduling.

3. Number of Days to Add to Today's Date for the Thru Date (Optional)

Use this processing option to specify the effective thru date for a rate. Specify the number of days that the system adds to the current date to calculate the effective thru date. The effective thru date specifies when a rate is no longer active. This date acts as a filter for reviewing rates.

4. From Status

Use this processing option to specify the From Status (UDC 00/SS) for a work order rate. From Status acts as a filter when you review rates.

5. Thru Status

Use this processing option to specify the default Thru Status (UDC 00/SS) for a rate. Thru Status is used as a filter for reviewing rates.

6. Beginning Status

Use this processing option to specify the default Beginning Status code (UDC 00/SS) on

the rate header. The Beginning Status code specifies the status that you use to create new rates.

Note: This processing option is not used if the parts list and routing are created in batch mode. The system uses the beginning status from the Order Processing program (R31410) for batch mode.

7. Closed Rate Status Code

Use this processing option to specify the Closed Rate Status code (UDC 00/SS) that the system uses to indicate a closed rate. If you leave this processing option blank, the system uses 99.

8. Charge to Business Unit

Use this processing option to specify whether the system uses the job number from the Business Unit Master table (F0006) or the branch/plant number from the work order as the Charge to Business Unit number. Valid values are:

Blank

Use the branch/plant number.

1

Charge the business unit that is associated with the job number in the Business Unit Master table..

Display Tab

Use this processing option to control whether the system displays all rate schedules or only open rate schedules.

1. Open Schedules

Use this processing option to specify whether the system displays all schedules or open schedules only. Open schedules include schedules that have a status code that is less than the Closed Rate Status code. Valid values are:

Blank

Display all schedules.

1

Display open schedules only.

Categories Tab

Use these processing options to specify default values for the category code fields either by entering them manually or by retrieving them from the corresponding Item Branch class codes.

1. Category Code 1 (optional)

Use this processing option to specify the default category code (00/W1) for the rate schedule.

2. Category Code 2 (optional)

Use this processing option to specify the default category code (00/W2) for the rate schedule.

3. Category Code 3 (optional)

Use this processing option to specify the default category code (00/W3) for the rate schedule.

4. Category Code 1 (optional)

Use this processing option to specify the default item/branch category code UDC value (32/CC) to use for new rate schedule headers. The Line Sequencing Workbench program (P3156) sequences rate schedules either by rate sequence number or by this category code.

5. Category Code 2 (optional)

Use this processing option to specify the default item/branch category code UDC value (32/CC) to use for new rate schedule headers. The Line Sequencing Workbench program (P3156) sequences rate schedules either by rate sequence number or by this category code.

6. Category Code 3 (optional)

Use this processing option to specify the default item/branch category code UDC value (32/CC) to use for new rate schedule headers. The Line Sequencing Workbench program (P3156) sequences rate schedules either by rate sequence number or by this category code.

Process Tab

Use this processing option to specify whether the system automatically attaches the parts list and routing to the rate schedule.

1. Attach Parts List and Routing

blank = Parts list and routing will not be attached
1 = Attach parts list and routing interactively
2 = Attach parts list and routing through batch processing

Use this processing option to specify the method the system uses to attach parts lists and routings to the rate schedules. Valid values are:

Blank

Do not attach parts lists and routings.

1

Attach parts lists and routings interactively.

2

Attach parts lists and routings through batch processing.

Edits Tab

Use these processing options to specify whether the system automatically updates the parts list and routing when rate quantities and dates change, and validates existing item branch records when you add rate schedules.

1. Update Parts List and Routing

blank = No recalculation will be performed when quantities or dates change
1 = Update parts list and routing when rate quantities or dates change

Use this processing option to specify whether the system automatically recalculates parts list quantities, routing quantities, and dates when you change rate schedule quantities or rate schedule dates from the Enter/Change Rate Schedule program (P3109). Valid values are:

Blank

Do not recalculate parts list quantities, routing quantities, or dates.

1

Update parts list, routing quantities, and dates.

2. Validate Existing Branch/Item Records

blank = Do not validate
1 = Validate for existing branch/item records

Use this processing option to specify whether the system validates an existing item/branch record when you add or update a rate schedule. Valid values are:

Blank

Do not validate an existing item/branch record.

1

Validate an existing item/branch record.

Versions Tab

Use these processing options to specify which versions the system uses when it calls the following programs from the Enter/Change Rate Schedule program.

1. Completions Workbench (P3119).

Use this processing option to specify the version that the system uses when you choose the Completions Workbench program (P3119) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Completions Workbench program. The version controls how the Completions Workbench program displays information.

2. MPS/MRP/DRP Time Series (P3413).

Use this processing option to specify the version that the system uses when you choose the MPS Time Series program (P3413) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the MPS Time Series program. The version controls how the MPS Time Series program displays information.

3. Bill Availability (P30200).

Use this processing option to specify the version of the Bill of Material Inquiry program (P30200) that you want to use when you choose Availability from the row menu of the Work With Rate Schedules form. If you leave this processing option blank, the system uses version ZJDE0001.

4. Assign Serial Numbers (P3105).

Use this processing option to specify the version that the system uses when you choose the Assign Serial Numbers program (P3105) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Assign Serial Numbers program. The version controls how the Assign Serial Numbers program displays information.

5. Lot Master Revisions (P4108).

Use this processing option to specify the version that the system uses when you choose the Lot Master program (P4108) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Lot Master program. The version controls how the Lot Master program displays information.

6. Bill of Materials Revisions (P3002).

Use this processing option to specify the version that the system uses when you choose the Bill of Material Revisions program (P3002) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Bill of Material Revisions program. The version controls how the Bill of Material Revisions program displays information.

7. Bill of Materials Inquiry (P30200).

Use this processing option to specify the version that the system uses when you choose the Bill of Material Inquiry program (P30200) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Bill of Material Inquiry program. The version controls how the Bill of Material Inquiry program displays information.

8. Line Scheduling Workbench (P3153).

Use this processing option to specify the version that the system uses when you choose the Line Scheduling Workbench program (P3153) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Line Scheduling Workbench program. The version controls how the Line Scheduling Workbench program displays information.

9. Supply/Demand Inquiry (P4021).

Use this processing option to specify the version that the system uses when you choose the

Supply and Demand Inquiry program (P4021) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Supply and Demand Inquiry program. The version controls how the Supply and Demand Inquiry program displays information.

10. Order Processing (R31410). If left blank, XJDE0008 will be used.

Use this processing option to specify the version that the system uses when you choose the Order Processing program (R31410) from row exit of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0008 of the Order Processing program. The version controls how the Order Processing program updates information.

11. Parts List (P3111).

Use this processing option to specify the version that the system uses when you choose the Work Order Parts List program (P3111) from the row menu of the Work with Rate Schedule form. If you leave this processing option blank, the system uses version ZJDE0001 of the Work Order Parts List program. The version controls how the Work Order Parts List program displays information.

12. Routing (P3112).

Use this processing option to specify the version of the Work Order Routing program (P3112) that the system uses when you choose it from the row menu of the Enter/Change Rate Schedule program (P3109). If you leave this processing option blank, the system uses version ZJDE0001. The version controls how the Work Order Routing program displays information.

Interop Tab

Use this processing option to specify the export transaction type when using interoperability.

1. Export Transaction Type

Use this processing option to specify the transaction type that the system uses for export processing or for supply chain scheduling and planning. Transaction type is a user defined code (00/TT).

Note: Blank is a valid value if you do not choose to use export processing.

Hold Codes Tab

Use this processing option to specify the default hold code for related purchase orders.

1. Related Purchase Order

Use this processing option to specify the default hold code for a purchase order. Hold code is a user defined code (42/HC) that identifies whether the purchase order is being held.

Processing Work Orders and Rate Schedules

After you enter a work order header, you can use the Order Processing batch program (R31410) to attach the parts list and routing instructions for each work order or rate schedule header. If you attach the parts list and routing instructions interactively, you can use the Order Processing batch program to generate and print the shop paperwork.

The processing options for the Order Processing program allow you to perform a wide range of functions, such as the following:

- Generate a parts list and routing instructions

- Indicate the date to use for effectivity verification

- Change the status code of the work orders or rate schedules that are being processed

- Print information about the work order or rate schedule, such as the routing, parts list, sales order text, and so on

- Print a shop packet summary that lists processed work orders and rate schedules

- Enter the unit of measure for backscheduling

- Issue inventory automatically

- Generate a shortage report for the work orders and rate schedules

- Indicate the versions of the associated programs that you want to access

- Create parts lists based on prior revision levels

You can organize and separate these functions to accomplish different tasks by setting up several reporting versions, each with different data selections and processing option values. For example, you can set up one version to generate the parts lists and routings for work orders, another version to print shop paperwork, and another version to perform batch inventory issues.

If you use other EnterpriseOne systems, the following integration features apply:

Configured items integration	You use the Order Processing program to process assembly inclusion rules in order to generate a parts list and routing instructions, if the parts list and routing instructions do not already exist.
	The assembly inclusion rules are defined in the Base Configurator system. The P assembly inclusion rule is used to put component parts on the sales order and work order, while the Q assembly inclusion rule is used to put component parts on the work order only. The R assembly inclusion rule is used to create the routing instructions for the work order.
	When a sales order is entered for a configured item, then the P assembly inclusion rules perform the following functions:

- Prints components as separate line items on the sales order
- Displays different levels for configured components in the Sales Order Entry program (P4210)

Running the Order Processing program generates a parts list for a configured item by performing the following:

- Uses data from the Sales Order Detail File table (F4211) that is generated from the P assembly inclusion rule in the Sales Order Entry program to create records in the Work Order Parts List table (F3111)
- Processes Q assembly inclusion rules to write additional components to the Work Order Parts List table

In the process, the system generates a routing by processing the R assembly inclusion rule.

The system uses the Issue Type Code and Operations Sequence Number fields from the Assembly Inclusions Rules table (F3293).

Quality Management integration	When you process work orders, you can use processing options to set values for the status of the work order and operation lot if the components fail tests.
Sales Order Management integration	When you create a work order for a kit during sales order entry, the system can build the parent item and stock it in inventory after you process and complete the work order. When you create the work order, the system subtracts the components from the on-hand quantity in inventory. After you complete the work order, the system adds the parent item to the on-hand quantity in inventory.
	You must specify line type T (Text) for sales orders in the Order Processing program to avoid writing journal entries for cost of goods sold and inventory for the components when you update the sales order. This line type also ensures that the system does not again subtract components from on-hand quantity in inventory during shipment confirmation or sales update.

Warehouse Management integration   If you use Warehouse Management, when you process a work order, the system does not search for inventory. Instead, the system generates a pick request. The pick request notifies you of the need for materials from the warehouse.

After the system creates the pick request, the Warehouse Management system processes instructions and creates suggestions for you to confirm. Then, the system updates the parts list and increases the on-hand quantity for the To location and decreases the quantity on-hand for the From location.

You can specify in the processing options whether you want to print a consolidated pick list for multiple work orders, or individual pick lists for each work order.

Prerequisites

❑   Create a version of the Order Processing program (R31410) with the appropriate processing option settings.

❑   Set up valid work center locations. See *Setting up Work Centers* in the *Shop Floor Management Guide*.

❑   Set up a valid routing with appropriate line and item relationship information.

❑   Use the processing options to initiate Warehouse Management system integration, if applicable.

Running Order Processing

From the Daily Order Preparation - Discrete menu (G3111), choose Order Processing.

When you run the Order Processing program (R31410), the system creates the planned variance in the Work Order Variance Tag - Needed for upgrade table (F3102T). The variance shows the difference in costs from when the standards were set at the beginning of the accounting period.

When you run the Order Processing program, the system deletes any previously-generated or manually-entered parts list that is attached to the work order or rate schedule. You can manually revise the system-generated parts list. If you add parts to the list, the system commits them from the primary location that is defined in the Item Branch program (P41026).

You should not regenerate the parts list if any part on the list has been issued to the work order or rate schedule. If you regenerate the parts list after parts have been issued, you must manually adjust the list to prevent duplication of component quantities.

When you generate a parts list that includes lot-controlled components, the system hard-commits the components from the work center location where lots with quantities exist. If the lot quantity is not sufficient, the parts list line is split.

When you run the Order Processing program, the system deletes any previously-generated or manually-entered routing instructions. You should not regenerate the routing instructions for the work order or rate schedule if hours and quantities are recorded for any of its operations.

Use a processing option to update the routing instructions if you change the work order or rate schedule. The system recalculates the run labor and run machine hours based on the quantity ordered on the work order or rate schedule.

If the system finds an error in calculating the date for an operation sequence, it enters the work order or rate schedule start and requested dates for that operation.

To automatically issue material to a work order when you run the Order Processing program, you set the Preflush Items processing option to issue only items identified as preflushed items or to preflush all items.

Use a processing option to print a consolidated parts list that provides you with a means to pick inventory needed for a number of work orders or rate schedules. The items are consolidated based on item name, location, lot, unit of measure, and branch/plant. The system prints information for each branch/plant on a separate page and prints on a separate line each occurrence of an item that is in a different location, lot, or unit of measure.

When you run the Order Processing program, the system generates an exception report for the following conditions:

- The system previously created pick requests but did not regenerate a parts list.

- The system did not create a pick request because the Warehouse Control option for the branch/plant was not set to Y.

Processing Options for Order Processing (R31410)

Process Tab

Use these processing options to specify whether the system does the following:

- Generate a parts list and routing instructions

- Update the parts list and routing instructions when quantities and dates change

---

1. Generate Parts List and Routing Instructions
1 = Parts list only
2 = Routing instructions only
3 = Both parts list and routing instructions
Blank = Do not generate a parts list or routing instructions

Use this processing option to specify whether the system generates a parts list, routing instructions, or both when you process a work order. Valid values are:

1   The system generates a parts list only.

2   The system generates routing instructions only.

3   The system generates both a parts list and routing instructions.

Blank The system does not generate a parts list or routing instructions.

Please refer to the Work Orders tab help for detailed information about the parts list and routing instructions generation.

2. Update Parts List and Routing Instructions
1 = Update the existing parts list and routing instructions.
Blank = Do not update the existing parts list or routing.

Use this processing option to specify whether the system updates an existing parts list and routing instructions if the work order quantity or dates have changed. Valid values are:

1   The system updates the existing parts list and routing instructions.

Blank The system does not update the existing parts list or routing.

Defaults Tab

Use these processing options to specify how the system verifies effectivity and to specify the default header status code to use.

1. Work Order Effectivity Date
1 = Work Order Date
Blank = Work Order Start Date

Use this processing option to specify the default work order date for effectivity checking. If you leave this field blank, the system uses the work order start date.

2. Header Status Code

Use this processing option to specify the default status code for the work order header. Document type is a user defined code (00/SS) that identifies the status of the work order. Enter the document type to use as the default value or choose it from the Select User Define Codes form. If you leave this field blank, the system does not change the status on the work order header.

Parts List Tab

Use these processing options to specify whether the system does the following:

- Uses substitute items when a shortage exists
- Uses prior revision levels to build the parts list
- Preflushes issues only or issues all items
- Uses commitment processing as specified in the Manufacturing Constants program (P3009)

1. Substitutions
1 = Substitution processing performed
Blank = Substitution processing not performed.

Use this processing option to specify whether the system uses bill of material substitutes when there is a shortage. Valid values are:

1   The system uses substitutions.

Blank The system does not use substitutions.

2. Prior Revision Level
1 = Prior revision level used
Blank = Prior revision level not used

Use this processing option to specify whether the system builds the parts list against a prior revision level. Valid values are:

1   The system uses prior revision levels.

Blank The system does not use prior revision levels.

3. Preflush Items
1 = Material issued for all items
Blank = Material issued only for preflushed items

Use this processing option to specify whether the system issues all items on the work order. Valid values are:

1   The system issues all items.

Blank The system issues only preflushed items.

If you choose to issue all items, the system only issues material if you specify the version of the Inventory Issues program (P31113) in the Inventory Issues processing option under the Versions tab.

4. Commitment Processing Bypass
1 = Commitment processing not performed

Blank = Commitment processing performed per commitment control

Use this processing option to specify whether the system bypasses commitment processing when it creates the parts list. Valid values are:

1   The system does not use commitment processing.

Blank The system uses commitment control.

You specify commitment processing in the Commitment Control field in the Manufacturing Constants program (P3009).

5. Batch Bill of Material Processing
1 = Bypass batch bill processing
Blank = Perform batch bill processing

Use this processing option to determine whether the system uses batch bill processing. In batch bill processing, the system searches for a bill of material that matches the work order quantity. If a matching bill of material is not found, the system uses the zero bill of material to extend the required components. Valid values are:

Blank The system uses batch bill processing.

1   The system does not use batch bill processing.

6. Parts List Text
1 = Copy the component's generic text
Blank = Do not copy the component's generic text

Use this processing option to determine whether or not the system copies a component's generic text to a parts list.

1   The system copies a component's generic text to a the parts list.

Blank The system does not copy a component's generic text to a parts list.

7. Phantom Operation Sequence Number
1 = Use the phantom's (parent) operation sequence number.
Blank = Use components' operation sequence number

Use this processing option to specify how the system displays operation sequence numbers for components of a phantom item. Valid values are:

Blank

The system displays the operation sequence number of the component.

1

The system displays the operation sequence number of the phantom item.

Routing Tab

Use these processing options to specify the default values that the system uses for the unit of measure, document type, line type beginning status, and so on.

1. Unit of Measure

Use this processing option to specify the default unit of measure to use for back scheduling on the routing instructions. Unit of measure is a user defined code (00/UM) that identifies the unit of measure to use in the document. Enter the unit of measure to use as the default value or choose it from the Select User Define Codes form.

2. Document Type

Use this processing option to specify the default document type associated with the purchase order for a subcontract routing. Document type is a user defined code (00/DT) that identifies the origin and purpose of the document. Enter the document type to use as the default value or choose it from the Select User Define Codes form.

3. Line Type

Use this processing option to specify the default line type associated with the purchase order for a subcontract routing. Enter the line type to use as the default value or choose it from the Line Type Search form.

4. Beginning Status

Use this processing option to specify the default beginning status associated with the purchase order for a subcontract routing. Beginning status is a user defined code (40/AT) that identifies the beginning status of the document. Enter the beginning status to use as the default value or choose it from the Select User Define Codes form.

5. Subledger Field
1 = Work order number entered into the subledger field of the purchasing journal

entries

Blank = Work order number not used.

Use this processing option to specify whether the system enters the work order number into the Subledger field of the purchase order. Valid values are:

1   The system enters the work order number.

  Blank The system does not enter the work order number.

6. Batch Routing Processing
1 = Bypass batch routing processing
Blank = Perform batch routing processing

Use this processing option to determine whether to use batch routing processing. In batch routing processing, the logic searches for a routing that matches the work order quantity. If no match is found, the system uses the zero routing to extend the required hours. Valid values are:

1   The system does not look for a batch routing.

  Blank The system will look for a batch routing.

7. Routing Text
1 = Copy the operation's generic text
Blank = Do not copy the operation's generic text

Use this processing option to determine whether the system copies an operation's generic text to a routing.

  Blank The system does not copy the operation's generic text to a routing.

1   The system copies the operation's generic text to a routing.

8. Back Scheduling Queue and Move Hours

Use this processing option to specify the method that the system uses to backschedule queue hours in the work order routing. Valid values are:

Blank

The system backschedules queue hours as a percentage of the resource units per day.

1

The system backschedules queue hours as a percentage of the work hours per day.

9. Queue and Move Hours
1 = Default Queue and Move Hours from Work Center.
Blank = Does not default Queue and Move Hours from Work Center.

Use this processing option to specify whether the system enters queue hours and move hours in the Work Order Routing program (P3112) from the work center when the queue hours and move hours are blank or zero in the standard routing from the Work With Routing Master program (P3003). Valid values are:

Blank

If queue hours and move hours are blank or zero in the standard routing, do not enter queue hours and move hours from the work center into the work order routing.

1

If queue hours and move hours are blank or zero in the standard routing enter the queue hours and move hours from the work center into the work order routing.

2

Enter queue hours and move hours from the the work center into the work order routing only if a routing step or instuction has been manually added to the detail area of the work order routing.

10. Override Number of Employees/Machines to '1'
1 = Override No. of Employees/Machines to '1'
Blank = Use existing No. of Employees/Machines

Sales/Configurator Tab

Use these processing options to specify the default values that the system uses for the line type and next status for kit components on sales orders, and whether to calculate the cost in the variance table of the sales order.

1. Line Type

Use this processing option to specify the default line type associated with the sales order for kit components. This processing option applies only to kit items. Enter the line type to use as the default value or choose it from the Line Type Search form.

2. Next Status

Use this processing option to specify the default next status associated with the sales order. Next status is a user defined code (40/AT) that identifies the next status for the kit component lines on the sales order. Enter the next status to use as the default value or choose it from the Select User Define Codes form.

3. Standard Cost Calculation

1 = Calculate standard cost

2 = Calculate standard cost only if it has not already been calculated

Blank = Do not calculate standard cost

Use this processing option to specify how the system calculates the cost from the configured routings in the variance table. Valid values are:

1	The system calculates the standard cost.
2	The system calculates the standard cost if it has not already been calculated.
Blank	The system does not calculate the cost.

Printing 1 Tab

Use these processing options to specify whether the system prints the work orders, and, if so, whether it prints associated information.

When you turn on the Warehouse Management picking interface, the report displays the value In Warehouse in the Location field for all parts with the proper material status code.

1. Work Orders

1 = Print work orders

Blank = Do not print work orders or any associated information

Use this processing option to specify whether the system prints the work orders. You cannot print associated information described in the remaining processing options on the

Printing tab if you do not choose to print the work orders using this processing option. Valid values are:

1   The system prints the work orders.

Blank The system does not print the work orders or any associated information.

You must choose to print work orders if you want to print information on parts lists and routing instructions, the shop packet summary, or sales order text lines.

2. Parts Lists
1 = Print parts list
Blank = Do not perform any parts list print processing

If you choose the Work Orders processing option to print work orders (Printing

1 tab), use this processing option to specify whether the system prints the associated parts lists. Valid values are:

1   The system prints the parts lists.

Blank The system does not print the parts lists.

3. Parts List Detail
1 = Print detail information
Blank = Do not print detail information

If you choose the Work Orders processing option to print work orders (Printing 1 tab) and the Parts List processing option to print the parts list (Printing 1 tab), use this processing option to specify whether the system prints the second line of information on the parts lists. Valid values are:

1   The system prints the parts list detail.

Blank The system does not print the parts list detail.

4. Parts List on Separate Pages
1 = Print each parts list on a new page

Blank = Print parts list on work order header page

If you choose the Work Orders processing option to print work orders (Printing 1 tab) and the Parts List processing option to print the parts list (Printing 1 tab), use this processing option to specify whether the system prints each parts list on a new page. Valid values are:

1   The system prints each parts list on a new page.

   Blank The system does not print each parts list on a new page.

5. Consolidated Parts List
1 = Consolidate the parts list
Blank = Do not consolidate the parts list

If you choose the Work Orders processing option to print work orders (Printing 1 tab) and the Parts List processing option to print the parts list (Printing 1 tab), use this processing option to specify whether the system prints a consolidated parts list. The items are consolidated based on item name,location, lot, unit of measure, and branch/plant. The system prints each branch/plant encountered on a separate page and prints each occurrence of an item that is in a different location, lot, or unit of measure on a separate line. Valid values are:

1   The system consolidates the parts list.

   Blank The system does not consolidate the parts list.

6. Parts List Component Text
1 = Print component (generic) text
Blank = Do not print component text

If you choose the Work Orders processing option to print work orders (Printing 1 tab) and the Parts List processing option to print the parts list (Printing 1 tab), use this processing option to specify whether the system prints the component text on the parts lists. Valid values are:

1   The system prints component text.

   Blank The system does not print component text.

Printing 2 Tab

Use these processing options to specify whether the system prints the work orders, and if so, what associated information is also printed.

When you turn on the Warehouse Management picking interface, the report displays the value In Warehouse in the Location field for all parts with the proper material status code.

---

1. Routing Instructions
1 = Print routing instructions
Blank = Do not perform any routing instructions print processing

If you choose the Work Orders processing option to print work orders (Printing 1 tab), use this processing option to specify whether the system prints the associated routing instructions. Valid values are:

   1   The system prints the routing instructions.

  Blank The system does not print the routing instructions.

2. Routing Instructions on Separate Pages
1 = Print routing instructions on a new page
Blank = Do not print routing instruction on new page

If you choose the Work Orders processing option to print work orders (Printing 1 tab) and the Routing Instructions processing option to print routing instructions (Printing 2 tab), use this processing option to specify whether the system prints each routing instruction on a new page. Valid values are:

   1   The system prints each routing instruction on a new page.

  Blank The system does not print each routing instruction on a new page.

3. Routing Instructions Text
1 = Print routing instructions (generic) text
Blank = Do not print routing instructions text

If you choose the Work Orders processing option to print work orders (Printing 1 tab) and the Routing Instructions processing option to print routing instructions (Printing 2 tab), use this processing option to specify whether the system prints the text on the routing instructions. Valid values are:

1 The system prints the text.

 Blank The system does not print the text.

4. Shop Packet Summary
1 = Print shop packet summary
Blank = Do not print summary

If you choose the Work Orders processing option to print work orders (Printing 1 tab), use this processing option to specify whether the system prints the shop packet summary. Valid values are:

1 The system prints the summary.

 Blank The system does not print the summary.

5. Sales Order Text Lines
1 = Print sales order text lines
Blank = Do not print sales order text

If you choose the Work Orders processing option to print work orders (Printing 1 tab), use this processing option to specify whether the system prints the sales order text lines. Valid values are:

1 The system prints the text.

 Blank The system does not print the text.

6. Configurator Generic Text
1 = Print Configurator Generic Text
Blank = Do not print Configurator Generic Text

Warehouse Management Tab

Use these processing options to specify how the system processes putaway requests for Warehouse Management integration, and to specify the default staging location and whether the system verifies availability.

1. Pick Requests

1 = Generate request only

2 = Generate request and process using subsystem

Blank = No request processed

Use this processing option to specify the directed putaway mode for the system to use. Valid values are:

1   The system processes putaway requests only.

2   The system processes putaway requests by using the subsystem.

Blank The system does not process putaway requests.

If you specify mode 2, enter the version of the subsystem for the system to use in the Location Driver Processing processing option (below).

2. Location Driver Processing Version (R46171)

If you choose directed putaway mode 2 for the Putaway Requests processing option (above), use this processing option to specify the version of the Location Driver Processing program (R46171) for the system to use when processing putaway requests. If you leave this field blank, the system uses the XJDE0007 version of the Location Driver Processing program.

Versions control how the Location Driver Processing program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

3. Staging Location

Use this processing option to specify the default staging location for moving goods out of the warehouse. The parts picked from the warehouse are staged at this location prior to use within manufacturing. Enter the staging location to use as the default value or choose it from the Item/Branch Locations form.

4. Staging Location Availability

1 = Check staging location for availability

Blank = Does not check for availability

Use this processing option to specify whether the system checks the staging location for availability. If a part is not available at the staging location,the system does not generate a request. This option only applies to parts without work center locations. Valid values are:

1   The system checks the staging location for available parts.

Blank The system does not check for availability.

Versions Tab

Use these processing options to specify the versions of the following reports and programs that the system uses when processing work orders:

1. Work Order Print (R31415)

Use this processing option to specify the version of the Work Order Print report (R31415) that the system uses. The default sequencing for the parts list is by component item number. The default sequencing for the routing instructions is by operation sequence number. If you leave this field blank,the program uses the ZJDE0001 version of the Work Order Print report.

Versions control how the Work Order Print report displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

2. Shortage Report (R31418)

Use this processing option to specify the version of the Shortage report (R31418) that the system uses. If you leave this field blank, the system does not generate this report.

Versions control how the Shortage report displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

3. Bar Coding Report (R31413)

Use this processing option to specify the version of the Bar Coding report (R31413) that the system uses. If you leave this field blank, the system uses the ZJDE0001 version of the Bar Coding report.

Versions control how the Bar Coding report displays information. Therefore,you might

need to set the processing options to specific versions to meet your needs.

4. Inventory Issues (P31113)

Use this processing option to specify the version of the Inventory Issues program (P31113) that the system uses. If you leave this field blank, the system does not issue any material.

Versions control how the Inventory Issues program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

5. Purchase Order Entry (P4310)

Use this processing option to specify the version of the Purchase Order Entry program (P4310) that the system uses when generating purchase orders. The default tax area and automatic blanket order release options are controlled by the Purchase Order Entry version that you specify.

Versions control how the Purchase Order Entry program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

6. Test Results Worksheet (R37470)

Use this processing option to specify which version of the Test Results Worksheet program (R37470) that the system uses. If you leave this processing option blank, the system uses version ZJDE0001. The version specifies how the program displays information.

Interoperability Tab

Use these processing options to specify the default transaction type that the system uses for processing export transactions, and to specify whether the system writes the before images to the Work Order Master File table (F4801) and Work Order Parts List table (F3111).

1. Work Order Transaction Type

Use this processing option to specify the default transaction type for the work order header that the system uses when processing export transactions. If you leave this field blank, the system does not perform export processing.

2. Parts List Transaction Type

Use this processing option to specify the default transaction type for the parts list that the system uses when processing export transactions. If you leave this field blank, the system does not perform export processing.

3. Routing Instructions Transaction Type

Use this processing option to specify the default transaction type for the routing instructions that the system uses when processing export transactions.

If you leave this field blank, the system does not perform export processing.

4. Work Order Header Before Image
1 = Include before image
Blank = Do not include before image

Use this processing option to specify whether the system writes the before image for the work order header. Valid values are:

  1   The system includes the image.

  Blank The system does not include the image.

5. Parts List Before Image
1 = Include before image
Blank = Do not include before image

Use this processing option to specify whether the system writes the before image for the parts list. Valid values are:

  1   The system includes the image.

  Blank The system does not include the image.

6. Routing Instructions Before Image
1 = Include before image
Blank = Do not include before image

Use this processing option to specify whether the system writes the before image for the routing instructions. Valid values are:

  1   The system includes the image.

  Blank The system does not include the image.

Printing a Summary

From the Periodic Functions - Discrete menu (G3121), choose Work Order Summary.

The Work Order Summary report retrieves the work orders that you specify from the Work Order Master File table (F4801). You can use this report to review work orders in your system. The report shows the planner ID, item number, order quantity, completed quantity, and start and due dates.

Attaching Supplementary Information

Instead of using the Order Processing program (R31410) to attach parts lists and routing instructions to work orders and rate schedules, you can also accomplish this task interactively. You can also attach co-products and by-products, as well as intermediate items, to process work orders. Finally, you can also assign serial numbers.

Note

The Product Data Management system provides information to the Shop Floor Management system about bills of material, work centers, and routings.

Attaching a Parts List Interactively

After you enter a work order header, you attach a parts list to it. You can either manually enter a custom parts list or copy a parts list from a bill of material or existing work order. You use the manual method to create the parts list, components, quantities, and the bill of material. You use the copy method when existing information exists that you want to copy.

After you attach the parts list to a work order header, you can do the following:

- Specify or change a substitute item or quantities from different locations

- Add or delete components

- Change quantities or other information on the parts list or choose substitute items and their quantities on-hand when a component shortage is encountered

To use substitute items or integrate with other EnterpriseOne systems, you should be familiar with the information in the following table:

Substitute items	To use substitute items, you must use a processing option for the Work Order Parts List program (P3111) to specify the substitute processing that you want to use. You can select one of the following commitments: • Commit using the commitment control set in the Manufacturing Constants program (P3009) • Commit using the commitment control set in the Manufacturing Constants program, but use substitutes for shortages • Commit using the commitment control set in the Manufacturing Constants program, but use substitutes when the quantity available can compensate for the shortage The Hard/Soft Commit option on the Manufacturing Constant Revisions form must indicate a Hard at Creation of Parts List setting for you to use substitutions. When the system encounters a component shortage, you can choose the available substitutes and quantity. After you enter the information, the system adds the selected items and quantities to the parts list and deducts the equivalent quantity from the component.
Warehouse Management integration	If you use Warehouse Management and generate a parts list, the system searches for inventory in the staging or work center location. If you did not define a staging or work center location, or if you did not locate inventory, the system generates a pick request. The pick request notifies you of the need for materials from the warehouse. After the system creates the pick request, the Warehouse Management system processes instructions and creates suggestions for you to confirm. Then the system updates the parts list and increases the on-hand quantity for the To location and decreases the quantity on-hand for the From location. When you recreate the parts list, and the items are in the warehouse, the following two actions can occur: • The Work Order Print program (R31415) prints In Warehouse for all items with the correct material status code. • The Order Processing program (R31410) prints a message indicating that a warehouse pick request already exists. The system does not generate a parts list.

► **To enter a custom parts list**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate a specific work order:

   • Skip to Order Number

2. Choose the record, and then choose Parts List from the Row menu.

3. On Work Order Parts List, complete the following fields, as needed:

- Component Item Number
- Description
- Order Quantity
- UM
- Ln Ty
- Component Branch
- Location
- Lot Serial Number
- Lot Grd
- Lot Potency
- Oper Seq#
- From Potency
- Thru Potency
- Frm Grd
- Thr Grd
- Oper Scrap
- Is Cd
- Cmp Rev
- F V
- Component Item Number

4. To add the parts list to the work order header, click OK.

5. On Work With Manufacturing Work Orders, choose Parts List from the Row menu to review the parts list.

► **To copy a parts list from a bill of material**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

You can also copy a parts list from a bill of material that you established in the work order header.

1. On Work With Manufacturing Work Orders, complete the following field and click Find:

   • Skip to Order Number

2. Choose a record, and then choose Parts List from the Row menu.

3. On Work Order Parts List, choose Copy BOM from the Form menu.

PeopleSoft®

Enter/Change Order - Copy Screen

OK   Cancel   Tools

Item Number   2001
Branch   D30
Bill Revision Level
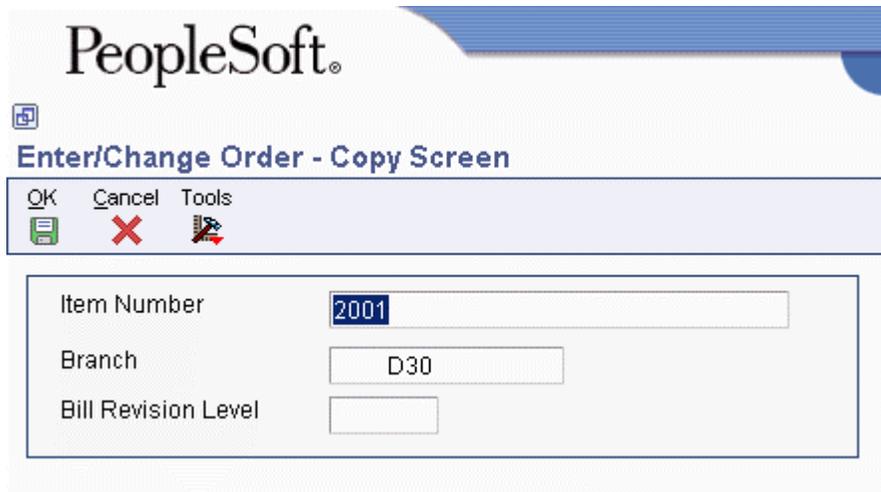
4. On Copy Screen, complete the following fields and click OK:

- Branch/Plant
- Item Number

5. On Work Order Parts List, review the components copied from the bill of material.

6. Click OK.

► **To copy a parts list from an existing work order**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate the work order to which you want to attach a parts list:

- Skip to Order Number

2. Choose a record, and then choose Parts List from the Row menu.

3. On Work Order Parts List, choose Copy from WO on the Form menu.

4. On Copy Screen, complete the following fields to enter the work order from which you want to copy the parts list and click OK.

- Order Number

5. Make any final corrections to the imported parts list and click OK.

► **To choose substitute items**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

When the system encounters a component shortage, you can choose the available substitutes and quantity. After you enter the information, the system adds the selected items and quantities to the parts list and deducts the equivalent quantity from the component. You cannot access this form unless at least one quantity is available.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate a work order:

- Skip to Order Number

2. Choose the record, and then choose Parts List from the Row menu.

3. On Work Order Parts List, choose an item, and then choose Substitute Avail (Availability) from the Row menu.

Note

You cannot access the Substitute Availability program (P3111S), unless a quantity exists for the substitute item.

4. On Substitute Availability Revisions, review the following information:

   - Quantity Ordered
   - Component 2nd Number
   - Quantity Available
   - Quantity On Hand

5. Change the value in the following field as needed:

   - Quantity Ordered

6. To place the equivalent quantity for the component in the parts list, click OK.

   The quantity is calculated using the values that you set up for substitute items (fixed or variable, partial, and so on).

► **To enter multiple locations**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

You can specify more than one commitment location for the item. However, if you select a location that is not the primary location specified on the parts list, the system hard-commits the item.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate a work order:

   - Skip to Order Number

2. Choose the record, and then choose Parts List from the Row menu.

3. On Work Order Parts List, choose an item, and then choose Multi-Location from the Row menu.

4. On Select Multiple Locations, complete the following fields:

- Quantity
- Location
- Lot / Serial
- Branch/Plant

5. Click OK.

Note

You can specify more than one commitment location for the item. However, if you select a location other than the primary location that is specified on the parts list, the system hard-commits the item.

See Also

❑ *Parts List and Routing* in the *Product Costing and Manufacturing Accounting Guide* for information about work order costs

❑ *Defining the Commitment Rules* in the *Shop Floor Management Guide* for information about commitment control and substituting items

Processing Options for Work Order Parts List (P3111)

Edits Tab

These processing options control whether you are able to attach a parts list to a prior revision level of the bill of material and whether you can select components for the parts list.

---

1. Parts List at Prior Revision Levels

Use this processing option to specify whether the program allows you to attach a parts list to prior revision levels of the bill of material for the parent item. Valid values are:

Blank

Do not allow the attachment of a parts list at prior revision levels.

1

Allow the attachment of a parts list at prior revision levels.

2. Select Components for Parts List

Use this processing option to specify whether the system allows you to choose components to be included on the parts list when you copy a work order. If you leave this processing option blank, the system disables the Row menu and includes all components on the parts list. Valid values are:

Blank

Include all components on the parts list.

1

Allow the ability to choose specific components to be included on the parts list.

Process Tab

These processing options control whether the system generates a routing when you create a parts list and whether the system copies component text. They also control substitute and commitment processing.

1. Routings

Use this processing option to specify whether the system generates routings when a parts list is created for a work order. The system adds routing information to the Work Order Parts List table (F3111). Valid values are:

Blank

Do not generate routings when a parts list is created for a work order.

1

Generate routings when a parts list is created for a work order.

2. Substitute Processing Method

blank = Substitute processing will not be done.
1 = Use substitutes for shortages.
2 = Display the Substitute Availability Window when substitute quantity can cover the shortage.

Use this processing option to specify the substitute processing method that the system uses when attaching a parts list to a work order. Valid values are:

Blank

Do not use substitutes for shortages.

1

Use substitutes for shortages.

2

Display the Substitute Availability form when substitute quantity can cover the shortage.

3. Commitment Processing

blank = Commitments will be processed per Commitment Control in Manufacturing Constants (F3009).
1 = Bypass commitment processing.

Use this processing option to specify whether the system generates component

commitments (based on commitment control settings stored in the Job Shop Manufacturing Constants table (F3009)), when the parts list is attached to the work order, or whether the the system bypasses commitment processing. Valid values are:

Blank

Use commitment control settings in the Job Shop Manufacturing Constants table (F3009).

1

Bypass commitment processing.

4. Component Generic Text

blank = Do not copy the component's generic text
1 = Copy the component's generic text

Use this processing option to copy the text attachment for a component line item to a work order parts list. Valid values are:

Blank

Do not copy the component's text attachment to a work order parts list.

1

Copy the component's text attachment to a work order parts list.

5. Phantom Operation Sequence Number

blank = Use components' operation sequence number.
1 = Use the phantom's (parent) operation sequence number.

Use this processing option to specify how the system displays operation sequence numbers for components of a phantom item. Valid values are:

Blank

The system displays the operation sequence number of the component.

1

The system displays the operation sequence number of the phantom item.

Warehousing Tab

These processing options control the integration with Warehouse Management, if you use this system.

1. Request Process Mode

blank = Do not generate a pick request
1 = Generate request only
2 = Generate request and process using subsystem

Use this processing option to specify whether the system generates a warehouse pick request for the items on the parts list.

Note: To use this processing option, all warehouse setup must be complete and warehouse control must be turned on in the Branch/Plant Constants program (P41001).

Valid values are:

Blank

Do not generate a pick request.

1

Generate a pick request only.

2

Generate a pick request and process using subsystem.

2. Location Selection Version

Use this processing option to specify the version of the Location Selection Driver program (R46171) that the system uses. If the Request Process Mode processing option is set to 2, you should enter a version here. If you leave this processing option blank, the system uses version ZJDE0007 of the Location Selection Driver program. The version controls how the Location Selection Driver program displays information.

3. Default Staging Location

Use this processing option to enter the default staging location for releasing warehouse goods. When the Request Process Mode processing option is set to generate pick requests, the pick requests are staged at the location you enter here.

4. Check Default Staging Location for Availability

blank = Do not check staging location for availability.
1 = Check staging location for availabilty.

Use this processing option to specify whether the system verifies part availability in the default staging location. If the part is available at the staging location, the system does not generate a request for the part.

Note: This processing option applies to parts with no work center location assigned.

Valid values are:

Blank

Do not verify part availability in the default staging location.

1

Verify part availability in the default staging location.

Versions Tab

These processing options control the version that the system uses when you call the following programs from the Work Order Parts List program (P3111):

1. Work Order Routings - P3112 (ZJDE0001)

Use this processing option to specify the version of the Work Order Routing program (P3112) to use when a routing list is automatically attached to a parts list. The version controls how the Work Order Routing program displays information. If you leave this processing option blank, the system uses version ZJDE0001 of the Work Order Routing program.

2. Work Order Inventory Issues - P31113 (ZJDE0001)

Use this processing option to specify the version that the system uses when you choose the Work Order Inventory Issues program (P31113) from the row menu of the Work Order Parts List form. If you leave this processing option blank, the system uses version ZJDE0001 of the Work Order Inventory Issues program. The version controls how the Work Order Inventory Issues program displays information.

3. Purchase Order Entry - P4310 (ZJDE0001)

Use this processing option to specify the version that the system uses when you choose the Purchase Orders program (P4310) from the row menu of the Work Order Parts List form. If you leave this processing option blank, the system uses version ZJDE0001 of the Purchase Orders program (P4310). The version controls how the Purchase Orders program displays information.

4. Configured Item Specifications - P32942 (ZJDE0001)

Use this processing option to specify the version of the Configured Item Specifications program (P32942) that the system uses when generating a purchase order. If you leave this processing option blank, the system uses version ZJDE0001.

5. Supply and Demand Inquiry - P4021 (ZJDE0003)

Use this processing option to specify the version that the system uses when you choose the Supply and Demand Inquiry program (P4021) from the row menu of the Work Order Parts List form. If you leave this processing option blank, the system uses version ZJDE0003 of the Supply and Demand Inquiry program. The version controls how the Supply and Demand Inquiry program displays information.

Export Tab

These processing option control the transaction type that the system uses for export processing and for the Supply Chain Planning and Scheduling integration.

1. Export Transaction Type

Use this processing option to specify the transaction type that the system uses for export processing or for supply chain scheduling and planning. Transaction type is a user defined code (00/TT). Enter the transaction type to use as the default value. Blank is a valid value if you do not want to use export processing.

What You Should Know About Processing Options for P3111

To access these processing options, use the Interactive Versions program (P983051). Choose Interactive Versions from the System Administration Tools menu (GH9011). Enter P3111 in the Interactive Application field, click Find, choose the program version, and then choose Processing Options from the Row menu.

Attaching Routing Instructions Interactively

In addition to attaching routing instructions to work order headers in batch, you can also enter routing instructions interactively or manually, that is, you can create a custom set of routing instructions or revise them manually after they have already been attached to the work order header. For example, you might have a special routing for a certain engineering release phase in which you want to test a new process step. As with the parts list, you have the option of copying information from an existing routing for an item or from another work order.

When you locate the routing instructions, the system displays the operations that are effective at the start date of the work order and those that are standard instructions or text lines. When no routing instructions are attached to the work order, no values appear in the associated fields.

You must create a purchase order for any step in the routing instructions that involves a subcontractor. You use the Enter/Change Routing program (P3003) to add an outside operations step. To define a routing step as an outside operation, you must enter a supplier and cost type and enter Y in the PO (Y/N) field. When you run the Order Processing batch program (R31410), the system generates a purchase order. You can also enter the purchase order interactively by calling the Outside Operation Revisions program (P3161) from the Work Order Routing form (W3112E).

Caution

When you create purchase orders for outside operations, consider the following:

- When you change the status of a routing instruction, the system can create duplicate purchase orders for that operation when you run the Order Processing program for that work order again.

- When you enter a purchase order interactively and then run the Order Processing program, the system creates duplicate purchase orders as well.

- When you delete an outside operation with an associated purchase order, the system deletes the purchase order when the original status of the operation remains unchanged. When the system deletes the purchase order, it updates the supplier instructions with the quantity of the value of the purchase order for the primary location and the open amount.

Note

If you set up a work center as a valid location, the system verifies that the work center is available before you use Warehouse Management.

Prerequisites

- ❑ Verify that a record for the parent item exists in the Item Master (F4101) and Item Branch (P41026) tables.

- ❑ Enter the document type, line type, and status code for the purchase order in the processing options for the Order Processing program (R31410).

► **To copy a routing instruction from a routing**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate a work order:

    - Skip to Order Number

2. Choose a record, and then choose Routing from the Row menu.

3. On Work Order Routing, choose Copy by Item from the Form menu.

4. On Copy by Item, click OK to copy the routing instructions for the displayed item and branch/plant to the work order.

5. On Work Order Routing, review the following fields:

    - Work Center
    - Operation Sequence
    - Operation Description
    - Machine Run Hours
    - Labor Run Hours
    - Cons Prod
    - Setup Hours
    - Move Hours
    - Queue Hours
    - Crew Size
    - Start Date
    - Request Date
    - Pay Point
    - Operation Type
    - Instruction Number

6. To add the routing instructions to the work order header, click OK.

7. On Work With Manufacturing Work Orders, choose the record and then choose Routing from the Row menu to review information about the routing instructions.

8. On Work Order Routing, to change routing instruction information for a specific operation sequence, choose the appropriate sequence, and then choose Details from the Row menu.

9. On Routing Details, make the appropriate changes and click OK.

► **To copy routing instructions from an existing work order**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate a work order:

   - Skip to Order Number

2. Choose the record and then choose Routing from the Row menu.

3. On Work Order Routing, choose Copy By WO from the Form menu.

4. On Copy by Order Number, complete the following field to enter the work order from which you want to copy the routing and click OK:

   - Work Order Number

5. On Work Order Routing, make any final corrections to the routing instructions and click OK.

See Also

❑ *Parts List and Routing* in the *Product Costing and Manufacturing Accounting Guide* for information about the work order costs

▶ **To add a purchase order for an outside operation**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate a work order:

   • Skip to Order Number

2. Choose a work order, and then choose Routing from the Row menu.

3. On Work Order Routing, choose the outside operation routing step for which you want to create a purchase order, and then choose Outside Operations from the Row menu.

4. On Outside Operation Detail, the system completes the following fields with routing information:

   • Order Number/Type
   • WO Description
   • Branch/Plant
   • Item Number
   • Operations Sequence Number

5. Complete the following fields:

   • Vendor
   • Cost Type

6. Choose Generate PO from the Form menu.

   The system generates a purchase order number that appears in the Related PO Number field.

7. Click OK.

8. On Work Order Routing, click OK.

Note

You can also cancel purchase orders in this program by choosing Cancel PO from the Form menu.

Processing Options for Work Order Routing (P3112)

Process Tab

These processing options control whether the system creates a parts list and copies generic text during the processing.

---

1. Create Parts List

Blank = No Parts List.
1 = Parts List.

Use this processing option to specify whether the system creates a parts list when it creates routings for a work order. The system adds the parts list information to the Work Order Parts List table (F3111). Valid values are:

  Blank The system does not create a parts list when it creates routings for a work order.

  1   The system creates a parts list when it creates routings for a work order.

2. Operation's Generic Text

Blank = Does not copy to the work order routing.
1 = Copies to the work order routing.

Use this processing option to copy the operation's generic text to a work order routing. Valid values are:

  Blank The system does not copy the operation's generic text to a work order routing.

  1   The system copies the operation's generic text to a work order routing.

3. Queue and Move Hours

Blank = Do not default Queue and Move Hours from Work Center.
1 = Always Default Queue and Move Hours from Work Center.
2 = Default Queue and Move Hours from Work Center only for manual entry.

Use this processing option to specify whether the queue and move hours in the Work Order Routing program (P3112) enter the work center when the system leaves the values blank in the Standard Routing program (P3003). Valid values are:

Blank The system does not enter the queue and move hours from the work center in the Work Order Routings program when the system leaves the values blank in the Standard Routing program.

1   The system enters the queue and move hours from the work center in the Work Order Routings program only when the system leaves the values blank in the Standard Routings program.

2   The system enters the queue and move hours from the work center in the Work Order Routings program only when you manually add a routing step or instruction in the detail area for work order routings.

4. Override Number of Employees/Machines to '1'

Blank = Use Existing No. of Employes/Machines
1 = Override No. of Employees/Machines to '1'

Export Tab

These processing option control the transaction type the system uses for export processing and for the Supply Chain Planning and Scheduling integration.

1. Transaction Type

Enter the Transaction Type for the export transaction.

Blank = Export processing will not be performed.

Use this processing option to specify a transaction type that the system uses for export processing or for the Supply Chain Scheduling and Planning. Transaction type is a user defined code (00/TT) that identifies the type of transaction for the work order. Enter the transaction type to use as the default value. Blank is a valid value if you do not want to use export processing.

Versions Tab

These processing options control the version the system uses when you call the following programs from the Work Order Routing List program:

1. Capacity Load program (P3313)

Blank = ZJDE0003

Use this processing option to specify the version of the Capacity Load program (P3313). The system uses this program to identify the capacity load in a work center for a specific operation in the work order routing. If you leave this option blank, the system uses the default version ZJDE0003.

2. Work With Activity Based Costing Workbench (P1640)

Blank = ZJDE0001

3. Resource Assignment (P48331)

Blank = ZJDE0001

Use this processing option to specify which version of the Resource Assignment program(P48331) the system uses. If you leave this processing option blank, the system uses version ZJDE0001.

4. Outside Operation Revisions (P3161)

Blank = ZJDE0001

Use this processing option to specify which version of the Outside Operation Revisions program (P3161) the Work Order Routing program (P3112) calls. The system uses this program to generate and maintain purchase orders for outside operations. If you leave this processing option blank, the system uses version ZJDE0001.

What You Should Know About Processing Options for P3112

To access these processing options, use the Interactive Versions program (P983051). Choose Interactive Versions from the System Administration Tools menu (GH9011). Enter P3112 in the Interactive Application field, click Find, choose the program version, and then choose Processing Options from the Row menu.

Attaching Co-Products and By-Products

For process manufacturing, after you enter a work order header, you attach a co-products and by-products list to the work order. Co-products and by-products identify the items that result from the process, whether they are planned or unplanned.

► **To attach co-products and by-products**

From the Daily Order Preparation - Process menu (G3113), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find:

    - Skip to Order Number

2. Choose a record, and then choose Co/By Products from the Row menu.

3. On Work Order Process Resource Revisions, review the following fields and click OK:

    - Item Number
    - Co By
    - Description
    - Qty Ordered/ Output Qty
    - UM

Attaching Intermediate Items

For process manufacturing, use intermediates to track the quantity of output of any operation in a work center at a specific time. You can define intermediates in different units of measure and quantities. You set up one intermediate per operation. However, you cannot define an intermediate for the last operation.

► **To attach intermediates**

From the Daily Order Preparation - Process menu (G3113), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find:

   - Skip to Order Number

2. Choose a record, and then choose Routing from the Row menu.

3. On Work Order Routing, choose an item and choose Intermediates from the Row menu.

4. On Intermediate Product Revisions, complete the following fields and click OK:

   - Item Number
   - UM
   - Quantity Ordered

Assigning Serial Numbers

You assign serial numbers to work orders to track serialized items within lots. You can assign serial numbers to work orders at any time. When you enter serial numbers, the system creates serial number master records, as well as work order lot or serial numbers (LSNs). The system does not validate any serial number that you enter until you complete the work order. If you do not assign a serial number to a serialized assembly, the system requires a number before you can complete the work order. After you complete a work order, you cannot modify any serial numbers that are assigned to the assemblies.

You can assign serial numbers to specific assemblies at any time prior to completing the work order. You can also assign serial numbers to specific assemblies at the time of work order completions by choosing Lot SN Generation from the Form menu on the Serial Number Revisions form (W3105B). You can associate serialized components to a specific assembly either at inventory issues or at work order completions. You must issue serialized components in their respective primary unit of measure to associate them to a specific assembly.

The Assign Serial Numbers program (P3105) assumes a quantity of one in the unit of measure on the work order. For serialized assemblies, this is the primary unit of measure. You cannot enter more serial numbers than the quantity on the work order.

Note

You can delete a serial number only when the system detects no activity for the number.

Prerequisite

❑ Set the Lot Process Type and Serial Number Required fields on the Item Master Information form for serial number processing. See *Entering Item Master Information* in the *Inventory Management Guide* for details about the Item Master Information form.

▶ **To assign serial numbers**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find to locate the work order to which you want to assign serial numbers:

   - Skip to Order Number

2. Choose the work order, and then choose Serial Numbers from the Row menu.

3. On Work With Work Order Serial Numbers, choose Revisions from the Form menu.

PeopleSoft®

Enter/Change Order - Work With Work Order Serial Numbers

Select Find Close Form Row Tools

Order Number	451080 WO			Branch Plant	M30
Item Number	2600			*Bike Trailer*	
Qty Ordered	5	EA		Requested	06/10/05
Qty Completed	5			Qty Scrapped	

Records 1 - 5   Customize Grid

	Lot/SN	Memo Lot 1	Memo Lot 2	Date Complete
☑	20592	1-1		11/24/97
☐	20593	1-1		11/24/97
☐	20594	1-1		11/24/97
☐	20595	1-1		11/24/97
☐	20596	1-1		11/24/97

4. On Serial Number Revisions, choose Lot/SN Generation from the Form menu to assign serial numbers.

5. Review the following fields and click OK:

    - Lot / SN
    - Memo Lot 1
    - Memo Lot 2

Note

You can also access the Assembly Serial Numbers program (P3105) from the menu (G3111). In this case, however, you can use it only to locate existing serial numbers, but not to update or add serial numbers.

Lot Processing

Lot processing allows you to manage information about groups of items. For example, for groups of perishable items, you can have the system assign lot numbers based on receipt dates that identify the items that you must sell first. You can view current information about each lot, such as the quantity of available items and the transactions that have affected the lot.

Lot control is beneficial for identifying groups of items that are components of a final product. For example, if you assign lot numbers to both bicycle tires and bicycles assembled from the tires, you can do the following:

- Identify the lot number for the tires that were used in the manufacture of a specific bicycle

- Identify all bicycles that used tires from a specific lot

If you later find that a particular lot of tires is defective, you can immediately identify and recall all bicycles that drew from the lot of defective tires.

A lot usually contains one type of item, but you can set up system constants in the Branch/Plants Constants program (P41001) to allow different types of items in the same lot. When a lot contains different items, the system maintains lot information for each lot number and item. You can also set up system constants to restrict a lot to one type of item and still allow that lot to exist in multiple warehouses.

In manufacturing, you can complete items in multiple lots in inventory from a single work order. When you report multiple lot completions, the system links materials issued to the work order to the completed items by lot number. If you do not have a lot number for the end item by the time that you issue component materials, the system uses only the work order number to link the components to the end item.

The system allows you to define multiple dates that are relevant for lot processing. These dates can be used to determine when lot-controlled items become available. For each lot containing a lot-controlled item, you can define the following availability dates based on the information that is set up for the item in the Item Master (P4101) and the Item Branch/Plant (P41026) programs:

- ❑ Lot expiration date
- ❑ On-hand date
- ❑ Best-before date
- ❑ Sell-by date
- ❑ Lot effectivity date
- ❑ Based-on date
- ❑ User lot dates 1 through 5

You can use the lot expiration date, the sell-by date, and the best-before date, as well as the user-defined lot dates, to define the commitment date method.

Expiration planning considers the expiration dates of lots while calculating the on-hand quantity and consumes the lot quantities in the order of expiration dates. That is, lots with the most current expiration dates are consumed first. This is the first-in, first-out (FIFO) method. Expiration planning is important because whoever in the chain has possession of the product when it expires incurs the loss. Accurate planning, forecasting, and adherence to schedules are important to expiration planning because products must make it through the entire chain from the supplier and, finally, to the customer before the expiration date. If any party in the chain does not adhere to the schedule, at least one party incurs a loss.

By using the lot effectivity date, you can define a lot to become available for use at a future date. You can calculate the effective date for the lot manually or automatically when the lot is created and becomes on-hand. You can use the Manufacturing Effective Days field on the Item Master Revisions or the Item Branch/Plant Info form to define the number of days before which a lot will be effective.

When you set the appropriate processing options, EnterpriseOne manufacturing planning systems perform the following actions:

- Deduct expired quantities of items from the on-hand values
- Send a warning message that is recorded in the MPS/MRP/DRP Message File table (F3411)
- Adjust the time series to reflect the expired product's effect

You can use several methods to assign lot numbers to items. For example, you can use one of the following methods:

- Have the system assign lot numbers
- Assign your own lot numbers
- Assign supplier lot numbers

See Also

❑ The following chapters in the *Inventory Management Guide* for further information about lot processing:

- *Defining System Constants* for information about allowing different types of items in the same lot
- *Setting Up Dates for Lots* for information about defining lot availability dates
- *Choosing the Calculation Method for Lot Expiration Dates* for information about different methods to calculate lot expiration dates
- *Defining Effective Dates for Future Availability* for information about marking lots for future availability

Creating Lots

You can create lots automatically or manually. Lots are generated automatically when you perform any of the following tasks:

- Create purchase order receipts
- Complete work orders
- Adjust inventory)

You can create lots manually, by accessing the Lot Master Revisions program (P4108) either directly from the menu or during work order entry from the Work Order Details form (W48013A). Each time that you create a lot, the system adds a record to the Lot Master table (F4108).

The actual grade and potency of a lot is defined in the Lot Master table. You also use the Lot Master Revisions program to specify a reason code for a grade or potency change. In addition, you can use processing options to protect a grade or potency from being updated.

Lot master information includes the status and availability dates for the lot. You can also define grade and potency for a lot and specify a reason code for a grade or potency change. In addition, you can use processing options to protect a grade or potency from being updated.

See Also

- ❑ *Entering Lot Information* in the *Inventory Management Guide* for the steps required to enter lot information for items and to enter information for lots

Lot Status

The status of a lot determines whether it is available for the system to process. When a lot is on hold for any reason, the system does not process it unless you activate a processing option that allows processing of held lots.

You set up lot status codes to identify reasons that a lot can be put on hold. After you set up the codes, you can assign them to items and lots.

You set up lot status codes in the user defined code table 41/L by using the Lot Status Code Revisions program (P0004A). You assign status codes to different lot locations in the Lot Master Revisions program (P4108). You can assign different status codes to a single lot based on the different locations in which the lot resides. When assigning a lot status, you can use the status code from the lot's record in the Lot Master table (F4108) or the default status from the Item Branch File table (F4102) if no lot status exists.

You can run the Lot Status Update program (R41082) to place expired lots on hold. You can run the program in proof or final mode. If you run the program in proof mode, you can produce a report showing all lots that will be put on hold. If you run the program in final mode, you can produce a report showing all lots that have been put on hold. You assign lot statuses when you do the following:

- Enter a new lot using the Lot Master Revisions form. If you do not enter a status at this time, the system uses the lot status from the item's branch information in the Item Branch File table.

- Set up a new location for an item using the Item Branch/Plant program P41026).

You can assign lot statuses to different lot locations using the Location Lot Status Update form from the Lot Master Revisions program. When you create a lot through transfer from another location, the system assigns statuses, using the status code of the From location. You can assign status codes to locations without using lots. Whether the system processes items that reside in locations that are on hold depends on how you set the processing options.

Use the following tables to determine the lot status for newly created records in the Lot Master table and the Item Location File table (F4108).

Lot Master (F4108)	If you enter a lot status on the Lot Master Revisions form, the system uses that lot status.
	If you do not enter a lot status, the system uses the default lot status from the Item Branch File table.
Item Location File (F41021)	If you enter a lot status on the Lot Master Revisions form, the system uses that lot status.
	If you are moving a lot from another location, the system uses the following sequence to assign a lot status:

- The default lot status from the From location
- If a lot number exists, the lot status from the Lot Master record
- If no lot number exists, the default lot status from the Item Branch File table

See Also

- ❑ *Assigning Lot Status Codes* in the *Inventory Management Guide* for the steps to set up lot status codes and assign them to different lot locations

Grade and Potency

Manufacturers in the process industry need full control over the quality of products that they make or buy. Examples of process industries include the food, chemical, and pharmaceutical industries. Grade and potency qualifications allow you to categorize your products more specifically and trace their movement through the manufacturing and distribution processes.

Grade identifies the particular specification makeup of an item and allows the system to separate one lot from other production lots without changing the item number. Examples of items that have grades are diamonds, lumber, and raw turquoise. Potency refers to the percentage of active ingredient within a solution, such as a 40% solution of hydrochloric acid, 3.2 beer versus beer with standard percentages of alcohol, and coffee with varying amounts of caffeine.

In the EnterpriseOne systems, grade and potency are mutually exclusive. You can use only one or the other to categorize an item. All items that are grade- or potency-controlled must also be tracked by lot number. Grades and potencies divide items by their specific makeup or characteristics without changing item numbers. Programs that calculate on-hand and available quantities use the grade or potency for each lot.

For grade- and potency-controlled items, you can enter a standard (preferred) value for each item. You can also enter a range of acceptable values that allow you to continue operations with grades or potencies that are outside of the standard value, but are still acceptable for your use. A range helps to establish and maintain quality levels in your products, but is flexible enough to keep your operations running when the standard level of product is unavailable. The system records grade or potency and lot transfer transactions in the item ledger and the general ledger, so that accounting is incorporated into the tracking.

Only items that meet the grade or potency range requirements stated in the bill of material are issued to the shop floor for production. Components that are outside of the range do not appear as available or on-hand in material inquiries for Shop Floor Management. You can order only a certain grade or potency of an item. Sales order and purchase order systems accommodate grade and potency standards and ranges.

Grade and Potency Control

You set up the following grade- or potency-control fields on the Grade and Potency tab on the Additional System Information form in the Item Master program (P4101). The system uses these control field values when you create a branch/plant record for the item.

Grade/Potency Pricing	Determines how to price grade- or potency-controlled items in Sales Order Management.
Potency Control	Identifies whether the item is potency-controlled.
Grade Control	Identifies whether the item is grade-controlled.
Standard Potency	Identifies the standard percentage of active ingredients that are normally found in an item. The value that you enter provides the default value for several forms in the EnterpriseOne manufacturing systems. In certain cases, the potency standard is used for the potent unit of measure conversion.
Standard Grade	Identifies the standard grade of the item, such as premium or average. The value that you enter provides the default for several forms in EnterpriseOne manufacturing systems.
From and Through Potency	Defines the allowable potency ranges for an item.
From and Through Grade	Defines the allowable grade ranges for an item.

You define the values for grade, potent units of measure, and conversions for potent units of measure as follows:

- Define the user defined codes in the user defined code table 40/LG for the grades that you will use.

- Define the user defined codes for the potent units of measure in the user defined code table 00/UM. For each potent unit of measure that you define, you must type P in the second space of the Special Handling Code field on the User Defined Codes form.

- Define a conversion for each potent unit of measure to a physical unit of measure in the Standard Units of Measure program (P41003). For example, 100 gallons of a solution at 80 percent potency equals 80 potent gallons, and 80 potent gallons of a solution at 80 percent equals 100 gallons.

See Also

❑ *Entering Item Grade and Potency Information* in the *Inventory Management Guide* for more information about grade and potency

Lot and Serial Control Items

Grade- and potency-controlled items must be lot-controlled. Use the Item Branch/Plant program (P41026) to identify an item as a lot- or serial-controlled item by entering one of the following values in the Lot Process Type field:

Blank Lot assignment is optional. Numbers must be manually assigned. Quantity can be greater than one.

1 Lot assignment is used. Numbers are assigned by the system using the system date in YYMMDD format. Quantity can be greater than one.

2 Lot assignment is used. Numbers are assigned in ascending sequence using next numbers. Quantity can be greater than one.

3 Lot assignment is required. Numbers must be manually assigned. Quantity can be greater than one.

4 Serial number assignment is optional except during shipment confirmation. Quantity must not exceed 1.

5 Serial number assignment is required. The system assigns numbers using the system date in YYMMDD format. Quantity must not exceed 1.

6 Serial number assignment is required. The system assigns numbers in ascending order using next numbers. Quantity must not exceed 1.

7 Serial number assignment is required. You must manually assign numbers. Quantity must not exceed 1.

When you attach a parts list to a work order header, the system creates commitments for the components. How these commitments are created depends on the parameters of commitment method, commitment control, and hard- or soft-commit. After you set up these parameters, commitments can be created in the same manner using both the Enter/Change Order (P48013) and Order Processing (R31410) programs.

When an item is defined as lot-controlled, the system moves the grade or potency range to the parts list and allows only those lots within the range to be eligible for commitments. Any remaining quantities are committed to the primary location.

Commitments

A commitment is a reservation for the parts that are needed on a work order. You can define commitments by branch or work center. You can change commitments manually or through a batch program.

When you attach a parts list to a work order header, the system creates commitments for the required quantity of each component. The commitment reserves the material for a particular work order. The type of commitment that the program creates (hard or soft) depends on which commitment option that you specified in the Manufacturing Constants program (P3009).

A hard commitment reserves designated inventory in a specific location for a particular work order. A soft commitment allows you to commit the inventory at the primary location to a work order without designated inventory from a specific location. This inventory can be used for another work order. Soft commitments also enable you to compare the material that is needed for current work orders to available inventory.

The system allows you to use hard commitments or soft commitments in a work order, or you can let the system change the commitment from soft to hard when you process the work order. You can also set up the system to place a soft commitment at the creation of the work order and change it to a hard commitment when you run the Order Processing program (R31410).

If, at any time, the location that appears on the parts list is not the primary location, the system hard-commits that line item. Inventory remains committed until the system records the issues. Then, the system reduces the on-hand quantity and the committed quantities.

The Inventory Issues program (P31113) relieves commitments. When you issue or reverse material that you committed to a secondary location when you entered the parts list line, the system performs a hard commitment for this material. When you partially issue or reverse inventory to a different location, the system relieves the commitment from the old location and commits the remaining material to the new location.

If you use lot processing, the system creates commitments based on the commitment date method, the lot expiration date method, and the lot effectivity date, if applicable, as well as grade or potency ranges for the lot numbers. The parts list for the work order might specify a range of grade or potency values that can be used on the order. The system commits the lot of the grade or potency within the range that you defined for the item. The system can also search for inventory that you need for the order in a certain sequence. For example, you might want to search for inventory with a specific lot number, grade, or potency.

When you commit lot-controlled component quantities at the work center location, the system searches for available quantities in the lots that are available at the work center location and commits quantities from those lots based on the commitment method. When you use more than one lot, the parts list line is split. If more components are needed than are available, the system commits the remaining quantity from the primary location. This process applies only when you do not use the Warehouse Management system.

Use the following table to identify the processing options available for both the Enter/Change Order (P48013) and Order Processing programs.

Enter/Change Order	Using the Enter/Change Order program, you can automatically generate the following:

- Routing instructions, when you create the parts list online
- Parts list, when you create the routing instructions online

Order Processing	Using the Order Processing program, you can specify either the work order effective date or the start date for effectivity checking. You can set up the system to perform the following tasks automatically:

- Use substitutes for items that are out of stock and for blanket order release processing
- Generate the parts list, routing instructions, or both

Defining the Commitment Rules

When a parts list is attached to a work order header, either manually or by using the batch program, the system automatically creates commitments for the components unless you set the processing option to bypass inventory commitments.

When you define commitments, you set up the parameters that determine how the commitment is created. If you are using lot control, you can also manage commitments by commitment date method, as well as grade or potency. You repost commitments when you need to clear commitments and reassign quantities to other work orders.

When creating commitments, you can activate a processing option to verify whether substitutes exist for an item. To use substitutes, you must use a hard commitment at the creation of a work order or at pick time.

You define the method that the system uses when creating a commitment. Using the Item Branch/Plant program (P41026), you can define the commitment method by location, lot number, or date. If you define commitments by date, you specify the commitment date method, as well as the lot expiration date method, if applicable, on the Lot Processing tab. The system calculates these dates based on the default days information that you define in the Item Master (P4101) and Item Branch/Plant programs and stores them in the Lot Master table (F4108).

You use the Manufacturing Constants program (P3009) to define the commitment control method and type of commitment for the work order. Commitment control determines how the system commits inventory to a work order. For example, commitment control determines whether the system can cross branch boundaries to fill requirements. In addition, you can specify whether the commitment is soft or hard. Soft commitments can become hard commitments in certain circumstances, such as when inventory is relieved.

► **To define the commitment method for the item**

From the Inventory Master/Transactions menu (G4111), choose Item Branch/Plant.

1. On Work With Item Branch, complete the following field and click Find:

   • Item Number

2. Choose a record in the detail area and click Select.

3. On Item/Branch Plant Info., complete the following field:

   • Commitment Method

4. If you define the commitment method by date, choose the Lot Processing tab and complete the following field:

   • Commitment Date Method

5. If you specify the lot expiration date as the commitment date method, complete the following field:

   • Lot Expiration Date Method

6. Click OK.

Processing Options for Item Branch (P41026)

Process Tab

These processing options allow you to specify whether the system displays additional Item Branch forms when you perform an add or change on the Item Branch/Plant Info. form.

1. Category Codes

Blank = Do not display screen
1 = Display screen

Use this processing option to specify whether the Category Codes form appears when you are adding or changing information. Valid values are:

Blank

Do not display the form.

1

Display the form.

2. Quantities

Blank = Do not display screen
1 = Display screen

Use this processing option to specify whether the system displays the Quantities form when you add or change information. Valid values are:

Blank

Do not display the form.

1

Display the form.

3. Additional System Information

Blank = Do not display screen
1 = Display screen

Use this processing option to specify whether the system displays the Additional System Information form when you add or change information. Valid values are:

Blank

Do not display the form.

1

Display the form.

4. Item Profile Revisions

Blank = Do not display screen
1 = Display screen

Use this processing option to specify whether the system displays the Item Profile Revisions form when you add or change information. Valid values are:

Blank

Do not display the form.

1

Display the form.

5. Cost Revisions

Blank = Do not display screen
1 = Display screen

Use this processing option to indicate whether the system displays the Cost Revisions form when you add or change information. Valid values are:

Blank

Do not display the form.

1

Display the form.

6. Price Revisions

Blank = Do not display screen
1 = Display screen

Use this processing option to specify whether the system displays the Price Revisions form
when you add or change information. Valid values are:

Blank

Do not display the form.

1

Display the form.

7. Unit of Measure

Blank = Do not display screen
1 = Display Unit of Measure screen

Use this processing option to specify whether the system displays the Unit of Measure
form when the Unit of Measure conversions are at the branch level and you are adding or
changing information. Valid values are:

Blank

Do not display the form.

1

Display the form.

Versions Tab

These processing options allow you to specify the versions for various programs that you access from
the Item Branch program. Versions control how the system processes and displays information.
Therefore, you might need to set the processing options to meet your specific needs.

1. Summary Availability (P41202)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you access the Item Availability program (P41202). If you leave this processing option blank, the system uses version ZJDE0001.

2. Item/Location Information (P41024)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you access the Location Revisions program (P41024). If you leave this processing option blank, the system uses version ZJDE0001.

Interop Tab

These processing options control whether the system performs outbound interoperability processing and whether the system creates a record of a transaction prior to changes to the transaction.

1. Transaction Type

Blank = No outbound interoperability processing

Use this processing option to define the type of document for which you want the system to search.

The transaction type is a user defined code (00/TT) that identifies the type of transaction, such as an invoice or a sales order. You can enter a transaction type or choose one from the Select User Define Code form. The system uses the transaction type as the default.

Note that if you leave this processing option blank, the system does not perform export processing.

2. Before/After Image Processing

Blank = Write only the after image
1 = Write the before and after image

Use this processing option to specify the point at which the system creates a record of a transaction. Valid values are:

Blank

Create a record of a transaction after changes.

1

Create two records: one record before changes and one record after changes.

▶ **To define the commitment control and type of commitment**

From the Shop Floor Management Setup menu (G3141), choose Manufacturing Constants.

After you define the commitment method for the item, define the commitment control and type of commitment for the work order.

1. On Work With Manufacturing Constants, complete the following field and click Find:

   • Skip to Branch/Plant

2. Choose a record in the detail area and click Select.

3. On Manufacturing Constants Revision, choose the Commitment Control tab and then choose one of the following options:

   • Primary Location
   • Split-Cross Branch boundaries
   • Split-Don't cross Branch boundaries

   If you choose primary location, the program does not select lots.

   If you want to split locations, you have two options. You can either specify commitments throughout different locations within one branch/plant, or specify commitments throughout different locations from different branch/plants.

4. Choose one of the following options, and then click OK:

   • Hard at creation of Parts List
   • Soft, Hard when printing
   • Soft at creation of Parts List

   If you use substitutes, you must specify a hard commitment.

Defining Commitments at a Work Center Location

In order to commit inventory to be issued to a particular work order, you need to define the values that allow you to make the material available where and when it is needed. For this purpose, you need to specify the work center for the routing instructions, as well as the issue location for the work center. You also specify the operation sequence at which each component is needed. If you work in a process manufacturing environment, you do not have a bill of material. Finally, you need to specify in the Manufacturing Constants program (P3009) which backflush option to use for the branch/plant.

► **To define the work center in the routing instructions for an item**

From the Daily PDM Discrete menu (G3011), choose Enter/Change Routing.

1. On Work With Routing Operations, complete the following fields and click Find:

   - Item Number
   - Branch/Plant

2. Choose a record and click Select.

3. On Enter Routing Information, complete the following field:

- Work Center

4. Complete the following optional field, if necessary:

- Consuming Location

5. Click OK.

After you complete these steps, define the location at the work center.

▶ **To define the location at the work center**

From the Daily PDM Discrete menu (G3011), choose Enter/Change Work Center.

1. On Work With Work Centers, click Find to locate all work centers or use the Query by Example row to narrow your search to specific work centers.

2. Choose a record in the detail area and click Select.

3. On Work Center Master Revisions, complete the following fields and click OK:

- Location - Issue
- Location Branch

► **To assign a component to a routing operation**

From the Daily PDM Discrete menu (G3011), choose Enter/Change Bill.

1. On Work with Bill of Material, complete the following fields and click Find:

- Branch/Plant
- Item Number

2. Choose a record in the detail area and click Select.

3. On Enter Bill of Material Information, complete the following field in the detail area and click OK:

- Oper Seq#

Managing Commitments for Grade and Potency

When the system creates commitments for grade- and potency-controlled items, it moves the grade and potency range to the parts list. Only lots that are within the range are eligible for commitments. The system creates the commitments in date sequence.

In the following example, the work order quantity required is 800, and the grade range is A01 through A03:

	Location	Expiration Date	Grade	On Hand	Commit
Primary					50
Secondary	9406220000	08/31	A01	50	50
Secondary	9406230000	08/15	A02	300	300
Secondary	9406240000	12/12	A03	400	400
Secondary	9406250000	09/01	A04	5	
Secondary	9406260000	09/01	A05	5000	

The system commits the quantities using the primary unit of measure. When the specified lots in the range have insufficient quantity to meet all of the commitments, the system commits the remainder to the primary location at standard grade or potency.

Converting Units of Measure for Potent Units

When you define a unit of measure as a potent unit of measure, and the system creates commitments, the system converts the quantity to the primary unit of measure. For example, assume that the component unit of measure is GP (potent gallons), and the standard potency is 70 percent. Also assume that the parts list requires 500 GP. However, only the equivalent of 470 potent gallons is available. The demand for the remaining 30 potent gallons is committed from the primary location in the primary unit of measure (30 GP/.7 = 43 GA).

	Location	Potency	On Hand	Potent Units	Commit at 70 percent potency
Primary					43
Secondary	9406220000	80%	50	40	50
Secondary	9406230000	90%	300	270	300
Secondary	9406240000	40%	400	160	400

The potency associated with the item in the Lot Master table (F4108) is for conversion purposes only.

A lot that consists of 100 potent units with a potency of 75 percent is the equivalent of 133.3333... physical gallons (100/.75). Companies that store inventory in potent units must know the physical size of the inventory.

Caution

The system displays a warning message when it changes the standard value for grade or potency on the branch/plant record. Commitments can be brought out of balance if the primary unit of measure for an item is not potent and commitments in a potent unit of measure exist from a sales order or work order. Conversion errors work in both directions. That is, commitments can be out-of-balance by either the potent or the primary unit of measure. You can correct this imbalance by running a repost for the sales order and work order. You should run sales order reports and repost the sales order after you repost the work order.

To create commitments for potent units, you must set up the correct unit of measure conversions. You set up a unit of measure conversion for potent units so that the system can do the following:

- Convert potent units of measure to physical units of measure

- Convert physical units of measure to potent units of measure

Prerequisite

❑ Set up potent units in UDC table 00/UM (Units of Measure).

► **To convert units of measure for potent units**

From the Inventory Setup menu (G4141), choose Standard Units of Measure.

1. On the Work With Standard Units of Measure form, click Add.

2. On Standard Units of Measure Revisions, complete the following fields and click OK:

   - To Unit of Measure
   - Conversion Factor
   - From Unit of Measure

The conversion for potent units is always 1 potent unit = 1 physical unit. For example, 1 LP = 1 LT and 1 GP = 1 GA.

Managing Commitments for Grade- and Potency-Controlled Items

Use the Work Order Parts List form (W3111A) to specify the location and grade or potency for each applicable component on a work order.

► **To manage commitments for grade- and potency-controlled items**

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find:

   - Skip to Order Number

2. Choose a record, and then choose Parts List from the Row menu.

3. On Work Order Parts List, complete the following fields:

   - Issued Quantity
   - Location
   - Lot Serial Number
   - Lot Grd
   - Lot Potency
   - From Potency
   - Frm Grd
   - Thr Grd

4. Click OK.

Reposting Commitments

From the Shop Floor Management Advanced menu (G3131), choose Repost Open Quantities.

After you set up commitments, run the Repost Open Quantities program (R3190) to perform the following tasks:

- Clear all values for the quantity and quantity committed in the Item Location File table (F41021).

- Repost the quantity value in the Item Branch File table (F4102) for the parent item. The system uses the information from the Work Order Master File table (F4801) and the following calculation:

  quantity ordered - (quantity completed + quantity scrapped)

- Repost the quantity-committed value for components in the Item Branch File table for the location specified on the work order parts list for the item. The system uses the information from the Work Order Parts List table (F3111) and the following calculation:

  quantity required - quantity issued

Processing options allow you to repost only those work orders that are below a certain status.

The system does not repost bulk items and lines that do not have an inventory interface.

Prerequisites

- ❑ Verify that the Item Location File table (F41021) is not in use.
- ❑ Indicate whether you want inventory hard- or soft-committed at each branch.

Processing Options for Repost Open Work Orders (R3190)

Process
1. Enter the work order status for update. Any order with a status less than the status input will be reposted. If left blank, the status will default to '99'.
Work Order Status Code

Availability and Shortages

To ensure that jobs are completed in the most cost-effective manner, Shop Floor Management coordinates material handling, material availability, setup and tooling availability, and operator skills. You can use availability and shortage tracking programs to determine what inventory you have and what inventory you need.

You verify the availability of the parts that you need to complete a work order, either before you create the work order or when the work order has been processed and is ready for release to the shop floor. You can use the bill of material, as well as the parts list, to review the materials that are available for completing the work order or rate schedule. You can choose to print shortages for specified components or print all shortages.

Note

If you use the EnterpriseOne Procurement system, you can automatically generate purchase orders for subcontracted operations on the routing instructions. You can also enter purchase orders interactively by accessing the Outside Operation Revisions program (P3161) from the Work Order Routing form.

When material shortages exist, you can enter and review them using the Shortage Workbench program (P3118). You can also create shortage reports.

Defining Availability Calculations for a Branch

The system uses the quantities that are defined for each branch to calculate availability. Therefore, you indicate the quantities that you want the system to add or subtract from the on-hand balance when the system calculates availability at your branch. If you leave any field blank, the system excludes the quantity in that field from the calculation.

► **To define availability calculations for a branch**

From the Inventory Setup menu (G4141), choose Branch/Plant Constants.

1. On Work With Branch/Plant Constants, complete the following field in the Query by Example row and click Find:

   - Branch/Plant

2. Choose the branch, and then choose Availability from the Row menu.

3. On Item Availability Definition, click any of the following options to subtract the appropriate quantities:

- Quantity Soft Committed to SO & WO
- Quantity Hard Committed to SO
- Quantity Future Committed to SO
- Quantity Hard Committed to WO
- Other Quantity 1 SO
- Other Quantity 2 SO
- Quantity on Hold
- Safety Stock

4. To add a quantity, click any of the following options, and then click OK:

- Quantity on Purchase Order Receipts
- Quantity on PO - Other 1
- Quantity on Work Order Receipts
- Quantity in Transit
- Quantity in Inspection
- Quantity in Operation 1
- Quantity in Operation 2

Reviewing Part Availability Information

You can determine the availability of the parts that are required to make a certain quantity of a parent item before you create a work order or rate schedule. Use the Part Availability program (P30200) to determine the availability of the parts.

Before you release a work order or rate schedule to the shop floor, you can review the parts list for the work order to determine the availability of the parts that are required to make a certain quantity of a parent item. Use the Parts List Inquiry program (P3121) to determine the availability of a part.

When you specify a soft commitment for the part, the quantities that appear indicate the item's availability at all locations. When you specify a hard-commitment for the part, only quantities from the hard-committed locations appear. You can also display the quantities of each part that have hard and soft commitments to work orders and sales orders.

► **To review part availability**

From the Daily Order Preparation - Discrete menu (G3111), choose Part Availability.

1. On Parts Availability - Multi Level Indented, complete the following fields and click Find:

   - Parent Item
   - Branch

2. Review the following fields and click Close:

   - 2nd Item Number
   - Quantity Available

After you complete these steps, you can review parts list availability.

Processing Options for Part Availability (P30200)

Defaults Tab

These processing options control default settings for running this program. For example, you can use a processing option to specify the processing mode that the system uses and the bill of material type that appears.

---

1. Processing Mode

Use this processing option to specify how the system displays the information on which you inquiry. Choose from the following processing modes: simple inquiry, parts availability, or leadtime inquiry.

The simple inquiry mode displays the components of a bill of material.

The parts availability mode displays the components of a bill of material and the available quantities for those components. If you use this mode, specify whether you want the system to subtract safety stock from the quantity on hand and whether to display negative quantities using the Safety Stock and Negative Items processing options under the Select tab.

The leadtime inquiry mode displays actual and calculated leadtimes for an item. Actual leadtimes are derived from the leadtimes as updated in the Item Branch table by the Leadtime Rollup program. Calculated leadtimes are the number of days that you must start to manufacture a part prior to the date that the parent needs it. You can use this mode of processing to define leadtimes for an item at each routing instruction step or to compare the actual and calculated leadtimes. If you use this mode, specify whether you want the system to display the actual or calculated leadtimes in the Leadtime Values processing option under the Select tab.

Valid values are:

1   The system displays the simple inquiry mode.

2   The system displays the parts availability mode.

3   The system displays the leadtime inquiry mode.

If you leave this processing option blank, the system displays the simple inquiry mode.

2. Inquiry Mode

Use this processing option to specify the level of detail that you want the system to display. The single level mode displays the parent item and its components. The multilevel mode displays the parent item, its components, and the subassemblies of the components. The multilevel indented mode displays the parent item, its components, and the subassemblies of the components. In addition, it indents the subassemblies. Valid values are:

   1   The system displays the single level mode.

   2   The system displays the multilevel mode.

   3   The system displays the multilevel indented mode.

If you leave this processing option blank, the system displays the multilevel indented mode.

3. Bill of Material Type

Use this processing option to specify the type of bill of material that the system uses as the default value in the Type of Bill field on the Work With Bill of Material form. Bill of material type is a user defined code (40/TB)

that designates the type of bill of material. Enter the bill of material type to use or choose it from the Select User Define Code form. If you leave this processing option blank, the system uses M for manufacturing bill of material.

4. Display Sequence

Use this processing option to specify how you want the system to sort information on the Work With Bill of Material form. You can choose to sequence the data by component line number or by operation sequence number. The component line number indicates the sequence of the components on a bill of material. The operation sequence number indicates the sequence of the fabrication or assembly steps in the manufacture of an item. Valid values are:

   1   The system sorts by component line number.

2   The system sorts by operation sequence number.

If you leave this processing option blank, the system sorts the data by component line number.

Versions Tab

These processing options control which version the system uses when the following programs are called from the Part Availability program.

1. Bill Of Material Print (R30460)

Use this processing option to specify the version of the Bill of Material Print report that the system uses. If you leave this processing option blank,the system uses the ZJDE0001 version.

Versions control how the Bill of Material Print report displays information.

Therefore, you might need to set the processing option to a specific version to meet your needs.

2. ECO Workbench (P30225)

Use this processing option to specify the version that the system uses when you choose the Row exit to the ECO Workbench program from the Work With Bill of Material form. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the ECO Workbench program displays information.

Therefore, you might need to set the processing option to a specific version to meet your needs.

3. ECO Header (P48020)

Use this processing option to specify the version of the ECO Header program that the system uses when you choose the Form exit to the Bill of Material Revisions program from the Work With Bill of Material. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the ECO Header program displays information. Therefore,you might

need to set the processing option to a specific version to meet your needs.

4. Bill of Material Revisions (P3002)

Use this processing option to specify the version that the system uses when you choose the Form exit to the Bill of Material Revisions program from the Work With Bill of Material form. If you leave this processing option blank,the system uses the ZJDE0001 version.

Versions control how the Bill of Material Revisions program displays information. Therefore, you might need to set the processing option to a specific version to meet your needs.

5. Item Master (P4101B)

Use this processing option to specify the version that the system uses when you choose the Form exit to the Item Master program from the Work With Bill of material form. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the Item Master program displays information. Therefore,you might need to set the processing option to a specific version to meet your needs.

6. Process Inquiry (P30240)

Use this processing option to specify the version that the system uses when you choose the Form exit to the Process Inquiry program from the Work With Bill of Material form. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the Process Inquiry program displays information.

Therefore, you might need to set the processing option to a specific version to meet your needs.

7. Work With Routing Master (P3003)

Use this processing option to specify the version of the Work With Routing Master program that the system uses. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the Work With Routing Master program displays information. Therefore, you might need to set the processing option to a specific version to meet your needs.

8. Item Availability (P41202)

Use this processing option to specify the version of the Item Availability program that the system uses. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the Item Availability program displays information.

Therefore, you might need to set the processing option to a specific version to meet your needs.

9. Item Cross Reference (P4104)

Use this processing option to specify the version of the Item Cross Reference program that the system uses. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the Item Cross Reference program displays information.

Therefore, you might need to set the processing option to a specific version to meet your needs.

10. Item Search (P41200)

Use this processing option to specify the version of the Item Search program that the system uses. If you leave this processing option blank, the system uses the ZJDE0001 version.

Versions control how the Item Search program displays information. Therefore,you might need to set the processing option to a specific version to meet your needs.

Select Tab

These processing options control how certain values appear, based on the default selection for the Processing Mode processing option.

1. Safety Stock

Use this processing option to specify whether the system subtracts the safety stock from the quantity on hand. Use this processing option in conjunction with the Parts Availability mode in the Processing Mode processing option under the Defaults tab. Valid values are:

Blank The system does not subtract safety stock from the quantity on hand.

1   The system subtracts safety stock from the quantity on hand.

2. Negative Quantities

Use this processing option to specify whether the system displays negative amounts for the component quantities. Use this processing option in conjunction with the Parts Availability mode in the Processing Mode processing option under the Defaults tab. Valid values are:

Blank The system displays all amounts.

1   The system displays only negative amounts.

3. Leadtime Values

Use this processing option to specify whether the system displays the actual or calculated leadtime values. Use this processing option in conjunction with the Leadtime Inquiry mode in the Processing Mode processing option under the Defaults tab. Valid values are:

Blank The system displays the actual leadtime values from the Item Branch table (F4102).

1   The system displays the calculated leadtime values.

Process Tab

These processing options control how the system uses certain data in the program. For example, you can use a processing option to specify whether phantom or process item are included in the inquiry.

1. Phantom Items

Use this processing option to specify whether the system explodes the phantoms to the next level and omits the display of the phantom. A phantom is normally defined for engineering or manufacturing purposes. Phantoms allow common parts, that may or may not be assembled, to be grouped in a bill of material structure. When viewing the bill of material, you may want to display only the subassemblies and raw material. Valid values are:

Blank The system omits the phantom items from the inquiry and displays only the subassemblies and raw material.

1   The system includes phantom items in the inquiry.

2. Process Items

Use this processing option to specify whether the system displays the process items. Process items include the process, co-products, by-products, and ingredients. A discrete bill may contain a component that is produced from a process. You use this processing option when you combine discrete and process manufacturing to display a complete structure of the requirements. Valid values are:

Blank The system excludes process items from the inquiry.

1   The system includes process items in the inquiry.

3. Text Lines

Use this processing option to specify whether the system displays the text lines. Valid values are:

Blank The system excludes text lines from the inquiry.

1   The system includes text lines in the inquiry.

4. Consolidate Component Items

Use this processing option to specify whether the system consolidates duplicate components. The same component may be listed in the bill of material several times, either on different subassemblies or on the same subassembly at different operations. When you use this processing option with the Subassemblies processing option, the system consolidates components at the subassembly level or for all levels of the bill of material. When viewing the consolidated components, the quantity required is accumulated for duplicate components. Valid values are:

Blank The system displays individual occurrences of duplicate components in the inquiry.

1   The system consolidates duplicate components in the inquiry.

5. Subassemblies

Use this processing option to specify whether the system displays the subassemblies. A subassembly is an assembly that is used at a higher level to make up another assembly. Valid values are:

Blank The system excludes subassemblies from the inquiry.

1   The system includes subassemblies in the inquiry.

6. Shrink

Use this processing option to specify whether the system adjusts the requested quantity for shrinkage. Shrinkage is the planned loss of a parent item caused by factors such as breakage, theft, deterioration, and evaporation. Valid values are:

Blank The system does not adjust the requested quantity.

1   The system adjusts the requested quantity for shrinkage.

7. Scrap

Use this processing option to specify whether the system adjusts the extended quantity for scrap. Scrap is unusable material that results from the production process. It is material outside of specifications and of such characteristics that rework is impractical. Valid values are:

Blank The system does not adjust the extended quantity.

1   The system adjusts the extended quantity for scrap.

8. Yield

Use this processing option to specify whether the system adjusts the extended quantity for yield. Yield is the ratio of usable output from a process to its input. Valid values are:

Blank The system does not adjust the extended quantity.

| 1 | The system adjusts the extended quantity for yield. |

9. Purchased Items

Use this processing option to specify whether the system explodes to the next level of purchased items in the bill of material report. Valid values are:

Blank The system excludes lower-level purchased items from the report.

| 1 | The system includes lower-level purchased items in the report. |

10. Phantom Operation Sequence Number

Use this processing option to specify how the system displays operation sequence numbers for components of a phantom item. Valid values are:

Blank

The system displays the operation sequence number of the component.

1

The system displays the operation sequence number of the phantom item.

► **To review parts list availability**

From the Daily Order Preparation - Discrete menu (G3111), choose Parts List Inquiry.

After you review part availability, you can review parts list availability.

1. On Work With Work Order Parts List, complete the following field and click Find:

   • WO Number

2. Choose the appropriate item and click Select.

3. On Parts List Detail Inquiry, review the following fields:

    - Item Number
    - Qty Required
    - Qty on Hand
    - Qty Available
    - Ordered
    - Issued
    - WO Hard Commit
    - SO Hard Commit
    - WO/SO Soft Commit
    - Qty on Order

Processing Options for Parts List Inquiry (P3121)

Versions Tab

These processing options control which version the system uses when the following programs are called from the Parts List Inquiry program.

---

1. Purchase Order Inquiry Version (P4310)
Blank = ZJDE0001

Use this processing option to specify the version of the Purchase Orders program (P4310). If you leave this processing option blank, the system uses the ZJDE0001 version.

2. Supply/Demand Version (P4021)
Blank = ZJDE0001

Use this processing option to specify the version for the Supply and Demand Inquiry program (P4021). If you leave this processing option blank, the system uses the ZJDE0003 version.

3. Manufacturing WO Parts List (P3111)
Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you choose the row exit to the Parts List program (P3111) from the Work With Manufacturing Work Orders form or the Work Order Details form. If you leave this processing option blank, the system uses the ZJDE0001 version of the Parts List program.

Versions control how the Parts List program displays information. Therefore,you might need to specify the processing options to specific versions to meet your needs.

4. Equipment/Service Order Parts List (P17730)
Blank = ZJDE0001

Use this processing option to specify the version of the Work Order Parts Detail program (P17730) that the system uses. If you leave this processing option blank, the system uses the ZJDE0001 version.

Managing Shortage Information

Shortages occur when you do not have enough of the required materials to complete the quantity of the parent item requested on a work order. When you review the availability of items and compare it to a bill of material or a work order, the system indicates items that are short by displaying a negative available quantity.

You track shortage information for parts with the following characteristics:

- Purchased parts that you obtain from a single source

- Purchased parts that are difficult to obtain

- Parts that have a long lead time

- Parts that, if absent, stop the production line

- Parts that are expensive to purchase or manufacture

- Parts that must be closely monitored

- Parts that are produced at critical work centers

You can change component shortage information by item, work order, branch/plant, work order type, or any combination of these by using the Shortage Workbench program (P3118). You can also review and revise information that indicates how the system fills shortages.

You can locate and review shortage information for an item that is associated with one or more work orders. Use this program to determine the amount of a shortage and how the shortage will be filled. You can locate item shortages by using the following criteria:

- Branch/plant and item number

- Branch/plant, item number, order number, and order type

- Order number and order type

- Order type

You can print a report that lists all shortages or only the component shortages for a specific work order. The system retrieves the shortage information for these reports from the Shortage Maintenance Master File table (F3118).

► **To revise shortage information**

From the Daily Order Preparation - Discrete menu (G3111), choose Shortage Workbench.

1. On Work With Shortage Workbench, complete the following fields and click Find:

   - Branch/Plant
   - Order Number

2. Choose a record and click Select.

3. Revise the following information, if necessary:

- Due Date
- Short Quantity
- Deliver To W/C
- Rel Ord Type
- Requested Date

4. Click OK.

Processing Options for Shortage Revisions (P3118)

Versions
Enter the reporting feature version. If left blank, default version ZJDE0001 will be used.
1. For Order Inventory Issues :
2. For Open Work Orders:
3. For Open Purchase Orders:
Defaults
1. Enter the default work order type. If left blank, 'WO' will be used.

Printing Shortage Information

From the Periodic Functions - Discrete menu (G3121), choose Component Shortages.

The Component Shortages report (R31418) lists the component parts required to complete a work order and indicates their current availability. It includes the following information:

- Quantities available
- Quantities on order
- Quantities required
- Quantities short

Use the processing option to specify whether the system prints only parts with shortages. A part with a shortage is included on more than one order only when the sum of the on-hand quantity and the on-order quantity, minus the required quantity, is negative. You can also generate this report as part of the shop paperwork when you run the Order Processing program (R31410).

Note

If you use Warehouse Management, the Component Shortages report does not include parts that have a status of In Warehouse.

In addition, you can print the All Shortages report (R3118P) that lists shortage details for items in the Shortage Maintenance Master File table (F3118). You can set the processing option to print either one or two lines of detail information about each short item.

Processing Options for Component Shortages (R31418)

Print
1. Enter a '1' to print only parts with a shortage.
Print shortages only.

Processing Options for All Shortages (R3118P)

Print
1.Enter a '1' to print one line of detail or a '2' for a second line of detail.
Enter your selection

Issues, Material Movement, and Kanbans

Regardless of whether you use work orders or rate schedules for an item that you produce, you must send the required materials to the shop floor for production. You must also deduct the quantities that are issued to the shop floor from inventory through an issue transaction. Along with issue transactions, you can use a visual system called kanban processing to alleviate paperwork.

The Shop Floor Management and Manufacturing Accounting systems use issue transactions to determine the actual quantities of materials that are used in the production process according to the parts list for the work order or rate schedule.

The following table identifies integration features with other EnterpriseOne systems:

Inventory Management	The Inventory Management system allows you to track materials between inventory or storage locations and the shop floor. You can manage inventory issues and commitments, complete orders, and track order quantities throughout the production process. The system allows you to issue material in two different units of measure, if dual units of measure are defined for the item in the Item Master program (P4101). When the item that you are issuing is a lot-controlled item, and the effective date of the lot is greater than the current date, the system issues a warning.
Warehouse Management	The Warehouse Management system allows you to originate picking requests through manufacturing systems, which further enhances the automated method of tracking inventory movement within a warehouse.

See Also

❑ *Processing Kanban Transactions by Item* in the *Kanban Management Guide*

Issuing Inventory

You do not have to generate an issue transaction at the same time that inventory is physically moved. The Shop Floor Management system allows you to choose the point in the production process during which you generate issue transactions. In other words, you can choose when you want your inventory records to reflect the issue of materials to the work order or rate schedule.

For example, for a short production cycle, you might want to simultaneously deduct the issued inventory and receive the completed product into inventory when you report full completions for the work order or rate schedule. For longer production cycles, you might need to generate issue transactions at various operations within the routing instructions to minimize the discrepancies between materials that are actually on the shop floor and materials that the inventory system lists as being on the shop floor.

You can choose any of the following methods to issue inventory:

Manual issues	The system deducts materials from inventory when you enter the issue transactions on the Inventory Issue Revisions form.
Preflush	The system automatically deducts materials from inventory when you run the Order Processing program (R31410).
Backflush	The system deducts materials from inventory when you report items on the work order or rate schedule as complete. Backflush can occur when you report partial completions throughout the production process or when you report full completions at the last operation of the routing instructions.
	When the parts list includes lot-controlled items, the system first issues the parts list lines with lot numbers because those quantities are already hard-committed. When these quantities are not sufficient, the system searches for additional lots at the work center location and issues material from those lots based on the commitment method.
Super Backflush	The system automatically deducts materials from inventory during operations that are defined as pay points throughout the routing instructions. Super backflush allows you to simultaneously backflush materials and labor hours and to report items as complete.

Some issue methods allow you to issue materials without displaying the Inventory Issue Revisions form. Other methods display the issue transaction for your review before the system records it.

You can perform partial issues by setting up the work order or rate schedule and issuing a backflush daily. For example, if your rate for the week is 10,000, and your daily backflush is 2,000, you can perform a partial issue of 2,000 for five days. On the fifth day, your rate schedule is completed.

The default transaction date for issue transactions is the current system date. You can enter a different date. If you issue too much of one item, the system displays a warning message. You can either adjust the issue quantity or accept the issue.

Inventory is issued from the location at which it is committed. You can change the commitment location for an item. The Inventory Issues program (P31113) correctly relieves these commitments. If you are issuing a grade- or potency-controlled item from a lot, and the lot grade or potency rating is not within the desired range, the system displays a warning message.

When you issue inventory, the system performs the following updates:

- Relieves inventory
- Updates the Item Location File table (F41021)
- Writes records to the Item Ledger File table (F4111)
- Updates the Production Cost table (F3102)
- Updates unaccounted units in the Work Order Parts List table (F3111)
- Writes G/L transaction in the Account Ledger table (F0911)

You can issue materials without recording a completion to a work order. You can also record component quantities that are scrapped and the reason for the scrap.

Note

If you have repeated items in the bill of material, verify that the operation sequence numbers for those lines are unique for the bill of material.

If you are using the Warehouse Management system and issuing materials to a work order, the system does not issue any part that has a status of In Warehouse. Before the system can issue the part, you need to update its status to Out of Warehouse by pick confirmation through a pick list. A pick list is a document that specifies to warehouse personnel what inventory to pick up per work order and where the inventory is located. The system generates the pick list when you run the Order Processing program.

See Also

❑ *Issuing Material* in the *Product Costing and Manufacturing Accounting Guide* for information about the impact on costs when issuing material

❑ *Confirming Pick Suggestions* in the *Warehouse Management Guide* for information about how to confirm a pick request

Issuing Material by Preflushing

From the Daily Order Preparation - Discrete menu (G3111), choose Order Processing.

Preflushing is the act of using the Order Processing program (R31410) to enter issue transactions for all material that is required for a work order when you process the work order. Materials include those that are not required until the last operation in the routing instructions, which could occur weeks or months in the future. These items are issued at the start date of the work order when you use the Order Processing program.

Caution

You should not use the preflushing method unless your manufacturing cycle time is short enough to ensure that materials are physically moved to the shop floor within the same day that the issue transaction is recorded. If your cycle time is longer than a day, a discrepancy appears in your inventory records because the materials have been deducted from inventory records, but not physically removed from inventory stock.

You can set a processing option to issue only preflush items. If you leave this processing option blank, the system preflushes any item that is associated with the work order, regardless of the issue code of the item.

Prerequisite

❑ Set the issue type code on the parts list.

Issuing Material Manually

You can use the Inventory Issues program (P31113) to manually issue material that is associated with a work order. When you issue material, you can choose to have the system automatically adjust the issue quantity by the parent item's shrink or yield factor. You can also use this program to change the commitments that the system recorded. When you change commitments, the system displays an error message if the quantities do not add up to the total quantity that is required. It also adjusts the available balance for any location in which you changed the quantity committed.

If you are working with a large parts list and do not need to issue all component quantities at the same time, the system provides you with filter fields to display only those component records for which you want to perform issues. You can filter the parts list by operation sequence, requested dates, component item numbers, and component line numbers. If you issue items that have a secondary unit of measure, the issue line must state the issue quantity in both the primary and secondary unit of measure.

If you did not assign serial numbers to any of the assemblies on your work order at order entry, you can assign them during the inventory issue process.

You can access the Select Multiple Locations program (P42053) from the Inventory Issue Revision form if you need to issue material from locations that are different from the locations that appear on the Inventory Issue Revisions form.

► **To issue material from a single location**

From the Daily Order Preparation - Discrete menu (G3111), choose Inventory Issues.

1. On Work With Work Order Inventory Issue, complete the following field and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order and click Select.

Note

Complete step 3 only if you do not want to issue material for all component quantities at once.

3. On Inventory Issue Revisions, choose the Filters tab, complete any of the following fields and options, and click Find:

   - Requested Date - From
   - Requested Date - Through
   - From Op Seq
   - Through Op Seq
   - Component Item No
   - Skip To Component Line Number
   - Display All Lines
   - Display Only Open Lines

4. Review the following fields:

- Mt St
- Quantity Ordered
- Component Branch
- Secondary Qty Ordered
- Location
- Lot Serial Number
- Expired Date
- Lot Effective Date

5. Choose the Basic Information tab and complete the following field:

- Issue Material For/UOM

Use this field to enter the quantity of the parent item that indicates how many sets of parts are needed. If you are issuing a partial parent item quantity, enter this quantity and click Find. The detail area displays the partial quantity to be issued. The Qty (Quantity) Ordered field in the detail area indicates the quantity of each component that the system deducts from inventory.

6. To override the processing option settings for applying the shrink or yield factor of the parent quantity, choose the Additional Details tab and turn on one or both of the following options:

- Inflate Shrink
- Inflate Yield

7. To complete the issue process, click OK.

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Note

To reverse an issue transaction, change the item quantity that you want to reverse to a negative number. The system decreases the amount in the Quantity Ordered field for the item by the amount of the reversal.

To close items that you no longer need, choose the items and then choose Close Line from the Row menu. The system closes the item and changes the information in the Description field to **Line Item is Closed**.

You can associate components with a specific serialized assembly during inventory issues. If you do not know the assembly number, use the Assembly Serial Numbers program (P3105) to review numbers that the system previously assigned to work order assemblies.

► **To issue material from multiple locations**

From the Daily Order Preparation - Discrete menu (G3111), choose Inventory Issues.

1. On Work With Work Order Inventory Issue, complete the following field and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order and click Select.

3. On Inventory Issue Revisions, click Find:

4. Choose an item in the detail area, and then choose Multi-Location from the Row menu.

5. On Select Multiple Locations, review the default information in the following fields:

   - Quantity
   - Location
   - Lot / Serial
   - Branch/Plant
   - Expiration Date
   - Lot Effective Date

6. To issue material from different locations, position the cursor in the first blank record in the detail are and complete the following fields:

   - Quantity
   - Location
   - Lot / Serial
   - Branch/Plant

7. Click OK.

8. On Inventory Issue Revisions, click OK.

Processing Options for Work Order Inventory Issues (P31113)

Edits Tab

These processing options control default values for the Inventory Issues program-- for example, the default document type for inventory issues-- as well as the status beyond which the system cannot issue inventory and the lot hold codes that still allow you to issue inventory to a lot. You can also determine whether an error message is displayed when an issue causes the on-hand quantity to become negative.

1. Document Type

Use this processing option to specify the default document type that the system enters when issuing inventory. Document type is a user defined code (00/DT) that identifies the origin and purpose of the document. Enter the document type to use as the default value or choose it from the Select User Defined Codes form.

2. Work Order Status Code

Use this processing option to specify the default status code for the issued material on the

work order header. Work order status code is a user defined code (00/SS) that identifies the status of the work order that the system uses when a material issue has been performed. Enter the status code to use as the default value or choose it from the Select User Defined Codes form. If you leave this field blank, the system does not update the work order header status code.

3. Material Status Code

Use this processing option to specify the default material status code that the system uses on the work order header. Material status code is a user defined code (31/MS) that identifies the status of the material to use when the system issues material. Enter the status code to use as the default value or choose it from the Select User Defined Codes form. If you leave this field blank, the system does not enter a material status code.

4. Work Order Status Code Limit

Use this processing option to specify the default status code that the system assigns to the work order header, at or beyond which the system cannot issue material.

5. Negative Quantity on Hand

Use this processing option to specify whether the system displays an error message when the material issued sets the on-hand quantity to a negative amount. Valid values are:

1   The system displays an error message for negative on-hand quantities.

Blank The system does not display an error message for negative on-hand quantities.

6. Item Sales History

Use this processing option to specify whether the system updates the Item Sales History table (F4115) when you issue material. Valid values are:

1   The system updates the Sales Item History table.

Blank The system does not update the Sales Item History table.

7. Lot Hold Codes
a. Lot Hold Code #1

Use this processing option to specify one of five lot hold codes to which the system issues inventory. Enter a hold code, an asterisk, or leave this field blank. If you enter an asterisk in this field, the system issues inventory to all held lots. If you leave this field blank, the system does not issue inventory to held lots.

b. Lot Hold Code #2

Use this processing option to specify one of five lot hold codes to which the system issues inventory. Enter a hold code, an asterisk, or leave this field blank. If you enter an asterisk in this field, the system issues inventory to all held lots. If you leave this field blank, the system does not issue inventory to held lots.

c. Lot Hold Code #3

Use this processing option to specify one of five lot hold codes to which the system issues inventory. Enter a hold code, an asterisk, or leave this field blank. If you enter an asterisk in this field, the system issues inventory to all held lots. If you leave this field blank, the system does not issue inventory to held lots.

d. Lot Hold Code #4

Use this processing option to specify one of five lot hold codes to which the system issues inventory. Enter a hold code, an asterisk, or leave this field blank. If you enter an asterisk in this field, the system issues inventory to all held lots. If you leave this field blank, the system does not issue inventory to held lots.

e. Lot Hold Code #5

Use this processing option to specify one of five lot hold codes to which the system issues inventory. Enter a hold code, an asterisk, or leave this field blank. If you enter an asterisk in this field, the system issues inventory to all held lots. If you leave this field blank, the system does not issue inventory to held lots.

8. Unplanned Issues

Use this processing option to specify whether the system processes unplanned issues. Valid values are:

1   The system processes unplanned issues.

Blank The system does not process unplanned issues.

9. Purchase Order Document Type

Use this processing option to specify the default document type of the purchase order associated with the simultaneous issue and receipt of material.

Purchase order document type is a user defined code (00/DT) that identifies the document type that the system uses when searching for an open purchase order. Enter the document type to use as default value or choose it from the Select User Define Codes form. If you leave this field blank, the system uses OP as the document type.

Display Tab

These processing options control the display of values in the Inventory Issue program. For example, you can specify that the system only display components with valid issue type codes, and that the issue quantity is displayed with shrink or yield already applied.

1. Issue Type Code

Use this processing option to specify whether the system displays all components or only components with a valid issue type code. Valid values are:

1   The system displays only components with valid issue type codes.

Blank The system displays components of all issue type codes.

2. Lot Number

Use this processing option to specify whether the system protects the Lot Number field from entry. Valid values are:

1   The system does not allow you to enter a value in the Lot Number field.

Blank The system allows you to enter a value in the Lot Number field.

3. Issue Material For

Use this processing option to specify whether the system enters the recommended issued quantity for all components with a valid issue type code.

The system uses the value from the Issue Material For field on the Work With Work Order

Inventory Issue form. The system issues only items with an issue quantity. Valid values are:

1   The system automatically enters the quantity.

Blank The system does not enter the quantity.

4. Apply Shrink to Issue Quantity

1 = Apply

Blank = Do not apply

A code that controls whether the system applies a parent item's shrink factor to the recommended issue quantity of a component item. Valid values are:

1   The system applies the shrink factor to the issue quantity.

Blank The system does not apply the shrink factor to the issue quantity.

5. Apply Yield to Issue Quantity

1 = Apply

Blank = Do not apply

A code that specifies whether the system applies operation scrap percentage to the recommended issue quantity of a component item. Valid values are:

1   The system applies the operation scrap percent to the issue quantity.

Blank The system does not apply the operation scrap percent to the issue quantity.

6. Select All Lines for Issue on Entry

Use this processing option to specify whether the system processes unviewed records after you click OK. The detail area displays components one page at a time. Click OK before scrolling down to view and process all records. Valid values are:

Blank

Process unviewed records after clicking OK.

1

Do not process unviewed records after clicking OK.

7. Display Only Open Lines

Use this processing option to specify whether the system displays only open lines or all lines in the detail area. A line is considered open if it has not been closed by choosing "Close Line" from the row menu. A line is also considered open if the order quantity is greater than the issued quantity. Valid values are:

Blank

Display all lines in the detail area.

1

Display only open lines in the detail area.

Versions Tab

These processing options control which version the system uses when you call the following programs from the Inventory Issues program:

1. Shortage Maintenance (P3118)

Use this processing option to specify the version that the system uses when you choose the row exit to the Shortage Maintenance program (P3118) from the Inventory Issue Revisions form. If you leave this field blank, the system uses the ZJDE0001 version of the Shortage Maintenance program. Versions control how the Shortage Maintenance program displays information. Therefore, you might need to set the processing option to a specific version to meet your needs.

2. Open Purchase Orders (P3160W)

Use this processing option to specify the version that the system uses when you choose the row exit to the Purchase Order Inquiry program (P4310) from the Inventory Issue Revisions form. If you leave this field blank, the system uses the ZJDE0001 version of the Purchase Order Inquiry program. Versions control how the Purchase Order Inquiry program displays information.

Therefore, you might need to set the processing option to a specific version to meet your

needs.

3. PO Receipts (P4312)

Use this processing option to specify the version that the system uses when you choose the row exit to the Purchase Order Receipts program (P4312) from the Inventory Issue Revisions form. If you leave this field blank, the program uses the ZJDE0008 version of the Purchase Order Receipts program. Versions control how the Purchase Order Receipts program displays information. Therefore, you might need to set the processing option to a specific version to meet your needs.

4. Movement and Disposition (P43250)

Use this processing option to specify the version that the system uses when you choose the row exit to the Receipt Routing Movement and Disposition program (P43250) from the Inventory Issue Revisions form. If you leave this field blank, the program uses the ZJDE0002 version of the Receipt Routing Movement and Disposition program. Versions control how the Receipt Routing Movement and Disposition program displays information. Therefore, you might need to set the processing option to a specific version to meet your needs.

Equipment Management Tab

This processing option controls whether the system automatically enters the work order number into the subledger field of the journal entry when processing maintenance orders.

1. Work Order Number

Use this processing option to specify whether the system enters the work order number in the subledger field of the journal entry when the system processes a maintenance work order. Valid values are:

1

The system automatically enters the work order number in the subledger field.

Blank

The system does not enter the work order number in the subledger field.

Interop Tab

These processing options control the default transaction type for inventory issue and work order transactions, as well as whether the system writes a before image for the work order header.

1. Inventory Issue Transaction Type

Use this processing option to specify the transaction type that the system uses for export processing. Transaction type is a user defined code (00/TT) that identifies the type of transaction for the work order. Enter the transaction type to use as the default value or choose it from the Select User Define Code form. If you leave this field blank, the system does not use export processing.

2. Work Order Transaction Type

Use this processing option to specify the default transaction type for the work order header that the system uses when processing export transactions. If you leave this field blank, the system does not perform export processing.

3. Work Order Header Before Image
1 = Include the image
2 = Do not include the image

Use this processing option to specify whether the system writes the before image for the work order header. Valid values are:

1   The system includes the image.

Blank The system does not include the image.

Recording Component Scrap

You can use the Component Scrap program (P31116) to add scrapped quantities of component items to the Item Ledger File table (F4111) and the Work Order Parts List table (F3111). The Item Ledger File table provides an audit trail of the quantity scrapped and the reason for the scrap transaction.

When you use the Component Scrap program, note the following important information:

- You cannot scrap components unless they have been issued to a work order.

- The total quantity that is scrapped for a component cannot exceed the total quantity that is issued to the work order.

- Negative transactions are allowed unless the transaction quantity causes a negative issue.

- You can enter scrap transactions in any unit of measure. The scrapped quantity is converted to the unit of measure of the parts list and rounded to one whole unit of measure when the system updates the F3111 table.

The system uses the order number information from the Work Order Master File table (F4801) and the component information from the F3111 table.

▶ **To record component scrap**

From the Daily Order Preparation - Discrete menu (G3111), choose Component Scrap.

1. On Work With Component Scrap, complete the following field and click Find:

    - Item Number

2. Choose the appropriate order and click Select.

3. On Component Scrap Revisions, complete the following optional fields and click OK:

    - Quantity To Scrap
    - Reason Code
    - Explanation
    - Date

See Also

❑ *Recording Component Scrap* in the *Product Costing and Manufacturing Accounting Guide*

Processing Options for Component Scrap (P31116)

Process
1. Enter a '1' for Item Number entry. Blanks will default to Work Order Number entry.
Processing Mode
2. Enter the Status Code beyond which Component Scrap cannot be made. Blank means no restriction
for Component Scrap.
Defaults
2. Item Ledger Transaction Date. (Blanks will default to the current date).
Transaction Date
3. Default Reason Code.
Reason Code
4. Enter the document type associated with the Component Scrap Transaction.
Document Type
SN Processing
1. Enter the Document Type used for Serial Number Issues. If left blank 'IM' will default.
Document Type

Work Order Scheduling and Rate Schedules

As part of your scheduling activities, you can monitor work order progress, manage work order releases, and update the status of any order to ensure the validity of your Material requirements planning and master production scheduling schedules. When you work with schedules, you can display manufacturing work orders by item, planner, customer, parent work order, status, type, priority, or a combination of these. You can display work orders by start date or requested date. You can also access related information, such as associated work orders, sales orders, purchase orders, parts lists, and routing instructions.

Note

If you use the Capacity Requirements Planning system, it reads the routing instructions for work orders and rate schedules and monitors the load on the involved work centers. This allows you to manage the loads on your work centers to maximize production and meet scheduled demand.

After you have established the production schedule, you print scheduling information and run the production in a work center.

Repetitive manufacturing involves consistent demand for a family of products that can be built on dedicated production lines. To use the capacity of the production lines efficiently, you schedule and sequence items using the Line Scheduling Workbench (P3153) and the Line Sequencing Workbench (P3156) programs.

Revising Work Order Status Information

After a work order is on the shop floor, you can review the order and the capacity of each work center through which the order is scheduled. When you review a work order, you can change the status, type, priority rating, freeze code designation, and type of flash message.

► **To revise work order information**

From the Daily Order Preparation - Discrete menu (G3111), choose Shop Floor Workbench.

1. On Work With Order Scheduling, complete the following field and click Find:

   - Branch/Plant

2. In order to filter the work order displayed, choose the Work Order Info tab and complete any of the following fields:

   - Item No.
   - Planner
   - Customer Number

3. Choose the Additional Selection Criteria tab and complete any of the following fields:

   - Order Type
   - Type Work Order
   - Priority
   - Phase
   - Category 02
   - Category 03

4. Choose a work order number and click Select.

5. On Work Order Status Update, complete the following optional fields and click OK:

   - Status
   - Type
   - Priority
   - Flash Msg
   - Freeze Y/N
   - Sequence

Processing Options for Shop Floor Workbench (P31225)

Default 1
1. Select Status Range or Item
   From W.O. Status
   Thru W.O. Status
   Item Number
   Item Cross Reference
2. Select Planner and/or Customer
   Address Number-Planner
   Address Number-Customer
Default 2
3. Select WO Categories
   W.O. Type
   W.O. Priority
   Phase (Category 1)
   Category 2
   Category 3
4. Select WO Document Type
   W.O. Document Type
Versions 1
Note: Versions will default to ZJDE0001
  1. Work Order Completions Version
  2. Super Backflush Version
  3. Inventory Issues Version
  4. Work Order Entry Version
  5. Work Order Parts List Version
  6. Work Order Routing Version
  7. Rate Schedule Version
  8. Production Status Version
Versions 2
Note: Versions will default to ZJDE0001
  9. Sales Order Inquiry Version
 10. Sales Order Entry Version
 11. Purchase Order Inquiry Version
 12. Purchase Order Entry Version
Interop
1. Work Order Transaction Type
2. Work Order Header Before Image
1 = Include before image
Blank = Do not include before image

Printing Scheduling Information for Work Centers

From the Periodic Functions - Discrete menu (G3121), choose Dispatch List.

Use the Dispatch List batch program (R31435) to plan and run the production in a work center. The Dispatch List program displays scheduling information for a work center. You can review and change this information in Dispatch List program (P31220).

The system retrieves the scheduling information for the work centers from the Work Order Master File table (F4801) and the Work Order Routing table (F3112).

Scheduling Items on a Production Line

Use the Line Scheduling Workbench (P3153) to schedule rates and work orders for the family of items produced on a production line. This program shows information in daily areas about both firmed and planned rates and work orders. After you manually revise the scheduled quantities, you can firm the schedule. Use start and through dates to show the workdays for the production line within the date range. When you create a rate or work order, or the system creates a rate through planning, the system spreads the quantities evenly throughout the workdays within the date range specified in the line and item relationship for the item. From the workbench, you can access the following forms:

- Alternate Line Selection (W3155WC)
- Split Lines Window (W3154WA)
- Parts Availability Multi Level Indented (W30200C)
- Work with Detail Messages (W3411D)

You use the Split Lines form to move scheduled quantities from one line or shift to another. You can use any of the following methods:

- Splitting production among two lines, which might create a schedule on the new line
- Consolidating production from two lines to one line
- Transferring production from one line to another
- Splitting production among shifts on the same or different lines

Use Alternate Line Selection to review all lines for which line and item relationships exist with the item.

Note

The system highlights over-capacity values.

► **To schedule items on a production line**

From the Daily Processing - Repetitive menu (G3115), choose Line Scheduling Workbench.

1. On Line Scheduling Workbench, complete the following fields:
   - Branch/Plant
   - Line/Cell

2. Complete the following optional fields:
   - From Date
   - Thru Date

3. Click Find:

4. Change any scheduled quantity as needed.

   If you change the total quantity and update the schedule, the system displays a warning before it spreads the new quantity evenly across the date range. You must update the schedule before the system changes the record.

5. To specify an alternate line, choose a record, and then choose Alternate Line from the Row menu.

6. On Alternate Line Selection, choose the alternate line, choose Select/Split from the Row menu and click OK:

7. On Split Lines Window, complete the following field to move scheduled quantities from one line to another:

- Quantity

Note

If you access the Split Lines Window directly from the Line Scheduling Workbench form, you also need to complete the Line field.

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8. To specify shift and date information, complete the following fields:

- Start Date
- Request Date
- S h

9. To complete the split, click OK.

Processing Options for Line Scheduling Workbench (P3153)

Defaults
1. Enter the Status Code to use when Firming rates and/or work orders.
2. Enter the Order Type to use for data selection. (Optional)
3. Enter the Shift Code to use for data selection. (Optional)
4. Enter the number of days to add to today's date when defaulting the Thru Date. (Optional)
Display
1. Status Code used to exclude closed rates from the workbench. (Default '99')
2. Enter a '1' to display PLANNED rates and work orders.
Versions
Enter the version to be used for each program. If left blank, ZJDE0001 will be used.
1. Production Status (P31226)
2. Line Sequencing Workbench (P3156)
3. Split Lines Window (P3156W)
4. Enter/Change Rate Schedule (P3109)
5. Supply/Demand Inquiry (P4021)
6. Message File Revisions (P3411)
7. Sales Order Entry (P4210)
8. Rates/Manufacturing Work Orders (P48013)
Enter the version to be used. If left blank, ZJDE0004 will be used.
9. Part Availability (P30200)

Sequencing Rates by Classification Scheme

Use the Line Sequencing Workbench program (P3156) to sequence the rates after you schedule production. This workbench shows information about actual rates only, and it displays the information in daily amounts. You must update the schedule before the system changes the record. You can use the following criteria to sequence the rates:

- Category code
- Sequence number

The category code values are determined by the processing options for the Enter/Change Rate Schedule program (P3109). Beginning with the first shift and day, the program forward-schedules the quantities, thus consuming the available capacity. You use the processing options to control whether these quantities are pulled forward or pushed back in time across shifts only, or both shifts and days. This process places the scheduled quantities that exceed the capacity available, within the date range selected, in the last shift of the last day.

If you sequence by sequence number, beginning with the first shift and day, the program forward-schedules the quantities, thus consuming the available capacity. When created, a new rate has an initial sequence number of 999999, which causes the rate to be sequenced last for the shift, placing it after any previously-sequenced rates. To manually override the default sequence, change the sequence number value of either the new rate, an existing rate, or both. Keep in mind that the status of the new rate cannot be greater than the rate status value on the Manufacturing Constants Revision form (W3009B). After revising the sequence, you can update the schedule as it is, or forward-schedule it again.

► **To schedule rates by classification scheme**

From the Daily Processing - Repetitive menu (G3115), choose Line Sequencing Workbench.

1. On Sequencing Workbench, complete the following fields:

    - Branch/Plant
    - Line/Cell

2. Complete the following optional fields:

    - Effective From
    - Thru

3. Click Find.

4. To change the sequence of the rate, complete the following fields, as needed, and click OK:

    - S h
    - Seq#

Processing Options for Line Sequencing Workbench (P3156)

Process
1. Enter a '1' to allow scheduling across shifts.
2. Enter a '1' to allow scheduling across days. If left blank and scheduling across shifts is allowed, remaining hours for a day will be applied to the last shift of the day.
NOTE: In order to schedule across days, scheduling across shifts must be allowed.
Defaults
1. Enter the number of days to add to today's date for the Effective Thru Date. (Optional)
2. Enter the Status Code used to exclude closed rates from the Workbench. (Default is '99').

Hours and Quantities

As you produce the items on a work request, you need to record the hours spent on production and the number of items (or co-products and by-products, for process manufacturing) that are completed in that time. This allows you to monitor progress and actual costs and compare them to the standard hours and quantities that you estimated for the job.

If your estimates are reasonably accurate, you can use the Super Backflush program (P31123) to have the system automatically enter the standard values at the paypoint operations in the routing instructions. Otherwise, you can have all employees individually enter their time and the quantities that they completed.

The Shop Floor Management system interfaces with the time entry feature of the EnterpriseOne Time Accounting system so that employee hours and quantities produced have to be entered only once. The single entry saves time, reduces the risk of data entry error, and ensures that data throughout your enterprise is consistent.

The system can record hours and quantities in the work order record and in the Time and Labor system. Hours and quantities can be applied to a specific work order so that you can maintain accurate manufacturing accounting and costing data. To accommodate both piecework and hourly-rate employees, you can record hours and quantities either per work order or per employee.

The Shop Floor Management system manages hour and quantity information in the same manner whether you enter it in the Hours and Quantities program (P311221) or in the Speed Time Entry program (P051121) in the Time and Labor system. If you use the Time and Labor system in conjunction with the Shop Floor Management system, you should use the Speed Time Entry program to enter hours and quantities information.

After you enter hours and quantities on either time entry form, you can review and revise them before you post them to the Manufacturing system for further tracking and cost accounting. You can review the hours and quantities either online or by printing a report.

Note

When you change the status of a routing operation, the change does not take effect until you run the Hours and Quantities Update program (R31422) to update the Work Order Routing table (F3112).

The system stores header information from the Work With Work Order Time Entry form (W311221B) in the Work Order Master File table (F4801). Detail information is stored in the Work Order Time Transactions table (F31122).

If you use the Quality Management System, as you record actual hours and quantities for a work order, you can access the Enter Test Results program (P3711) for completed items that require testing.

Entering Hours and Quantities

Use the Hours and Quantities program (P311221) to charge actual hours and quantities to a work order. You can use the processing options to specify either of the following formats for work order time entry:

Order number format	This format records time and quantities for employees by work order
Employee number format	This format records time and quantities for the routing instruction steps on a work order by employee.

Note the following important information about entering hours and quantities:

- Enter the quantity completed only once per operation sequence number. Entering it for each type of hours causes a variance amount.

- Enter hours using beginning and ending times for each entry or the actual hours, up to two decimal places.

- To reverse completed or scrapped quantities that you have entered, enter the quantity as a negative quantity.

- If you activate the Apply Yield to Completed Quantity processing option, the system applies the operation yield percentage to the completed quantity. When you enter the completed quantity, the system automatically adds a scrap quantity line that is calculated based on the yield percentage.

- The system verifies that the completed and scrapped quantities that you enter do not exceed the quantity at operation.

Note

If you use the Speed Time Entry program (P051121), you can set the Manufacturing Time Entry processing option to update the information in the Hours and Quantities program.

See Also

- ❑ *Recording Hours and Quantities* in the *Product Costing and Manufacturing Accounting Guide* for information about the impact of time entry data on manufacturing accounting

- ❑ *Working with Test Results* in the *Quality Management Guide* for information about entering test results

- ❑ *Working with Employee Timecards* in the *Time and Labor Guide* for information about time entry methods

► To enter hours and quantities

From the Daily Order Reporting - Discrete menu (G3112), choose Hours and Quantities.

1. On the Work With Work Order Time Entry, complete the following fields and click Find:

   - Work Date
   - Order Number

   Note

   If you use the employee number format for time entry, the system displays the Employee Number field instead of the Order Number filter field.

2. To enter hours and quantities, click Add.

3. On Time Entry Revisions, complete the following fields:

   - Employee Number
   - Oper #
   - Ty Hrs
   - Shift Code
   - Hours
   - Quantity

4. Complete the following fields:

   - Equipment Number
   - UM
   - St
   - Employee Rate
   - Equipment Rate
   - Reason Code

5. Enter as many lines as needed to record work hours and completed quantities.

6. Click OK.

7. On Work With Work Order Time Entry, review your entries.

    If you entered a quantity that you want to be posted as complete, the system adds a separate detail line for the completed quantity (Type of Hours 4). If scrap exists, the system adds a scrap quantity line (Type of Hours 5).

Processing Options for Hours and Quantities (P311221)

Display Tab

This processing option controls whether the system displays the Time Entry Revisions form (W051131A) in order number or employee number format.

---

1. Display

Blank = Employee Format Display
1= Order Number Format Display

Use this processing option to specify whether the system displays forms by employee number or order number. Valid values are:

Blank

Employee number

1

Order number

Defaults Tab

These processing options control the default values for the document type and work order status code that are used in the Hours and Quantities program.

---

1. Enter the Document Type associated with Shop Floor Activity.

Use this processing option to specify the document type (UDC 00/DT) associated with shop floor activity. You define document type codes in the Document Type Maintenance program (P40040).

2. Work Order Status Code

Use this processing option to specify the default work order status code (UDC 00/SS) that the system assigns to the work order when hours and quantities are posted to the work

order routing. If you leave this processing option blank, the system does not update the work order status code.

Edits Tab

These processing options control processing in the Hours and Quantities program, such as whether the system performs quantity verification or applies a yield percentage to the completed quantity.

1. Enter the Status Code beyond which Shop Floor Activity cannot be entered.

Use this processing option to specify the status (UDC 00/SS) of a work order beyond which shop floor activity cannot be entered.

2. Quantity Verification

Blank = Disable Quantity Verification
1 = Enable Quantity Verification

Use this processing option to specify whether the system verifies if the quantity complete and the quantity scrapped exceeds the quantity at operation.

Blank

Disable quantity verification.

1

Enable quantity verification.

3. Employee Rate

Blank = Show Rates
1 = Hide Rates

Use this processing option to specify whether the system displays the employee rate. Valid values are:

Blank

Display the employee rate.

1

Do not display the employee rate.

4. Apply Yield to Completed Quantity

Blank = Do not apply
1 = Apply

Use this processing option to specify whether the system applies the operation yield percentage to the quantity that the user completes at an operation. The yield percentage determines the scrap quantity. Valid values are:

Blank

The system does not apply the operation yield percentage to the quantity completed.

1

The system applies the operation yield percentage to the quantity completed.

Versions Tab

These processing options control which version the system uses when the following programs are called from the Hours and Quantities program.

1. Test Results Revisions (P3711)

Blank = ZJDE0001

2. Manufacturing Scheduling Workbench (P31225)

Blank = ZJDE0001

3. Production Status (P31226)

Blank = ZJDE0001

4. Hours and Quantities Update (R31422)

Blank = XJDE0001

Interop Tab

These processing options control which transaction type the system uses for outbound hours and quantities transactions and whether the system writes a before image for the work order header.

1. Work Order Transaction Type

Use this processing option to specify the default transaction type for the work order header that the system uses when processing export transactions. If you leave this processing option blank, the system does not perform export processing.

2. Work Order Header Before Image

Blank = Do not include the image
1 = Include the image

Use this processing option to specify whether the system writes the before image for the work order header. Valid values are:

1

The system writes the before image.

Blank

The system does not write the before image.

Updating Hours and Quantities

From the Daily Order Reporting - Discrete menu (G3112), choose Hours and Quantities Update.

To post hours and quantities to the Manufacturing system, you must run the Hours and Quantities Update program (R31422). This program updates the Work Order Routing table (F3112) with unaccounted labor units and amounts for each work order operation. This table then supplies the manufacturing accounting programs with the current data. Before the data is updated, you can locate and change it as necessary. After you run this program, you cannot locate the data on the Time Entry Revisions form (W051131A).

If you use the Super Backflush program (P31123) to enter hours and quantities, the quantity transactions are posted in real time. The program enters the transactions at the points in the routing instructions that you specify. To post hours, you still have to run the Hours and Quantities Update program. The system posts only the records that are in the current entry session. Therefore, if you exit the Super Backflush form after you enter the transaction data, you must locate the data on the Time Entry Revisions form and change the records to make them current with the system.

When you run this batch program from the menu, you use data selection to update those records that have not yet been posted. The system retrieves the hours and quantities information from the Work Order Time Transactions table (F31122). The system enters a P in the Processed Code field for each entry that it updates so that the record cannot be updated again. If you access the update program from Time Entry Revisions form, the system updates the time entry lines that appear on the form for the selected work order or employee. After the update, the system clears the form, and the records that were processed no longer appear.

Processing Options for Hours and Quantities Update (R31422)

Interop Tab

These processing options control the transaction type for outbound hours and quantities transactions and the call to the batch program for the outbound subsystem.

1. Transaction Type

 A specific transaction type
 Blank = No outbound transaction processing

Use this processing option to specify the transaction type for the hours and quantities the system uses when processing outbound transactions. If you leave this field blank, the system does not perform outbound processing.

2. Outbound Subsystem UBE

 1 = The UBE will be called
 Blank = The UBE will not be called

Use this processing option to specify whether the system calls the subsystem after the Hours and Quantities Update program (P31422) successfully processes the outbound transactions. Valid values are:

1 The system calls the subsystem.

Blank The system does not call the subsystem.

S/WM Tab

These processing options control processing for Service Management. For example, the processing options control whether the system creates journal entries, whether flex accounting is used, and whether the order number should be used as a default value for the subledger field.

1. S/WM Journal Entries

1 = Create S/WM journal entries
Blank = Do not create S/WM journal entries

Use this processing option to specify whether the system creates journal entries for SWM Work Orders. Valid values are:

1

The system creates SWM journal entries.

Blank

The system does not create SWM journal entries.

2. Flex Accounting

1= Use flex accounting
Blank = Do not use flex accounting

Use this processing option to indicate whether this program searches for flex accounting rules to populate cost objects in the Account Ledger table (F0911).

The system requires flex accounting to attach cost objects to the journal entries. Valid values are:

1   The system uses flex accounting.

Blank The system does not use flex accounting.

3. General Ledger Date

A specific date
Blank = Use today's date

Use this processing option to specify the date that appears on journal entries. If you leave this field blank, the program uses the system date.

4. Subledger

1 = Default order number

Blank = Do not default order number

Use this processing option to specify whether the system uses the work order number as the default in the Subledger field. Valid values are:

1   The system uses the work order number as the default.

Blank The system does not supply a default value.

5. Document Type

A specific document type

Blank = Default 'IH'

Use this processing option to specify the default document type that the system enters for journal entries on extra cost components if you do not use routings. Document type is a user defined code (00/DT) that identities the origin and purpose of the document. Enter the document type to use as the default value or choose it from the Select User Define Code form. If you use routings, the system automatically assigns a document type of IH. If you leave this field blank, the system uses document type IH.

Defaults Tab

This processing option controls the status that the system assigns to the work order when hours and quantities are posted to the work order routing.

1. Work Order Status Code

Use this processing option to specify the work order status code (UDC 00/SS) that the system uses to update the work order when hours and quantities are posted to the work order routing. If you leave this processing option blank, the system does not update the work order status code.

Reviewing Statuses and Transactions

After you enter hours and quantities, you can review the information either online or by printing a report. To review hours and quantity entries before you post them, you can use the Hours and Quantities Proof program (R31322). Then, you run the Hours and Quantities Update program (R31422) to post the entries.

You can use the Order Hours Status program (P31121) to display the actual hours for machine, labor, and setup hours entered for each operation that is associated with a work order. You can also access the Work Order Status - Hours Revisions form, on which you can review the actual, standard, and variance values for the hours.

You can use the Order Quantities Status program (P31122) to display the quantities entered for the operations that are scheduled for a work order, including the actual quantity ordered, completed, and scrapped for each operation. You can also access the Quantities Revision form, on which you can review the actual, standard, and variance values for the quantities.

You can use the Operation Quantity Inquiry program (P31124) to display the routing instructions, operation quantity, quantity completed, and quantity scrapped for a work order, including the projected quantity complete and projected yield, for each operation and for the entire order. Processing options allow you to define the default from and through statuses.

To review hours and quantities entries before you post them, you can use the Hours and Quantities Proof program (R31322)

Reviewing Hours and Quantities Transactions

From the Daily Order Reporting - Discrete menu (G3112), choose Hours and Quantities Proof.

The Hours and Quantities Proof program (R31322) allows you to print a report that lists all labor hours and completed quantities that are recorded for a work order. You can print the hours and quantities transactions that have been entered and review them before you post them to the general ledger system. Before you post the transactions, you can change or update them. After you post them, you cannot change them. The system retrieves the hours and quantities information from the Work Order Time Transactions table (F31122).

► **To review the status of hours**

From the Daily Order Reporting - Discrete menu (G3112), choose Order Hours Status.

1. On Work With Work Order Status - Hours, complete the following field and click Find:

   • Order Number/Type

2. Choose an operation and click Select.

3. On Work Order Status - Hours Revisions, review the Actual, Standard, Variance, and Variance % fields under the Machine, Labor, and Setup headings, and click OK.

► **To review the status of quantities**

From the Daily Order Reporting - Discrete menu (G3112), choose Order Quantities Status.

1. On Work with Work Order Status - Quantities, complete the following field and click Find:

   - Order Number/Type

2. Choose an operation sequence number and click Select.

3. On Work Order Status - Quantities Revisions, review the following fields and click OK:

   - Completed
   - Standard
   - Variance
   - At Operation
   - Scrapped
   - Variance Scrap

► **To review the status of operation quantities**

From the Daily Order Reporting - Discrete menu (G3112), choose Operation Quantity Inquiry.

1. On Work With Operation Quantities, complete the following fields and click Find:

   - Branch/Plant
   - Order Number/Type

2. Choose an order number and click Select.

3. On Operation Quantities Inquiry, review the following fields and click Cancel:

   - Completed Date
   - Projected Comp./UOM
   - Yield

Processing Options for Operation Quantity Inquiry (P31124)

Defaults
Status Info
1. From Status
2. Thru Status

Completions

When you finish producing items on the shop floor, you need to record the completions to inventory. The completion transactions that you enter in the Shop Floor Management system update the item quantity records in the Inventory Management system. The system provides you with programs and processes that allow you to record completions for discrete and process work orders, as well as rate schedules.

You use the Super Backflush (P31123) and Work Order Completions (P31114) programs to enter completions for work orders, and the Completions Workbench program (P3119) to enter completions to rate schedules.

If you use lot control, you can complete the item to an existing lot or you can create a new lot for the completed item and set its expiration date. The system can calculate different lot dates, such as expiration date and effectivity date, based on the lot date calculation information that you defined in the Item Master (P4101) or the Item Branch/Plant (P41026) program.

When you use Shop Floor Management with other EnterpriseOne systems, the following integration features apply:

Inventory Management

The Inventory Management system allows you to track materials between inventory or storage locations and the shop floor. You can manage inventory issues and commitments, complete orders, and track order quantities throughout the production process. If you set dual unit of measure information in the item master record for an item, you need to enter completed quantities both in the primary and in the secondary unit of measure.

Warehouse Management

If you process transactions for a branch/plant that uses warehouse control, the Location Detail Maintenance program (P4602) appears when you enter backflush transactions, and the system creates a second record with the location detail information. In this case, you select location detail information records for processing. To ensure that the quantities in the Location Detail Information table (F4602) are consistent, you should make a selection from the form. The original quantity being processed through this transaction program, using the Location Detail Maintenance program, appears in the header section of the Super Backflush form.

If the item being processed has a unit of measure structure or storage containers, the system enters them in the detail area of the Location Detail Maintenance form. Although you can override these values, the system verifies that the following information is true:

- The primary unit of measure in the structure and the last level specified are valid, based upon unit of measure conversions in the Item Master program (P4101).
- The units of measure appear in order from the largest to the smallest.
- The structure must result in whole number conversions between units of measure.

The system allows unit of measure values in the following conditions:

- Each unit of measure can contain only one partial quantity for that unit of measure.

- You can overfill pallet-type units of measure only as defined on the Unit of Measure Group Revisions form (W46096B).

The system always displays the Location Detail Maintenance form when you add inventory to the branch/plant, except when inventory is removed and only one location detail record is in the location. In this case, the quantity is automatically removed from the single location detail.

For completed items for which cross-docking is activated in the record in the Item Branch File table (F4102), you can determine whether the system performs cross-docking to fill back orders. You can also specify whether the system creates pick requests for cross-docked items.

As you enter work order completions, including quantity completed and quantity scrapped, you can do the following:

- Access the Enter Test Results program (P3711) for any items that require testing upon completion
- Review generic text for the work order
- Set processing options for default lot, work order, and operation statuses

As you backflush labor and material for a work order, you can do the following:

- Access the Enter Test Results program for any items that require testing
- Review generic text for the parent item and its operation

Sales Order Management

If you partially complete a work order that was generated from a sales order, the system can split the sales order into multiple sales order lines to reflect the partial commitment. If the sales order contains no hard commitment, you can set the Sales Order Lot and Location processing options to update the sales order with location information following a partial completion. You can also set a processing option to update the sales order status, regardless of whether the completed quantity is hard-committed. You can also reverse a partial completion. In this case, the system splits the sales order again and creates a negative line.

When you complete work orders or rate schedules, the system performs the following actions:

- Updates the Item Location File table (F41021)
- Writes a record in the Item Ledger File table (F4111)
- Updates the Production Cost table (F3102)
- Updates unaccounted units in the Work Order Master File table (F4801)
- Writes a general ledger transaction in the Account Ledger table (F0911)

See Also

❑ *Recording Completions* in the *Product Costing and Manufacturing Accounting Guide*

Completing Discrete Work Orders

When you finish producing discrete items on the shop floor, you need to record the completions to inventory. The completion transactions that you enter in the Shop Floor Management system update the item quantity records in the Inventory Management system. For items that are defined in a primary and a secondary unit if measure, you must enter the completed quantity in both units of measure.

You use the Work Order Completion (P31114) program to record completions. If you have already manually issued material for a work order, you perform a completion without backflush. You can either report all items as complete when the entire work order is finished, or report partial completions as they occur throughout the production process. The point at which you choose to report completions depends on factors related to your production cycle time. Depending on the nature of the manufactured item, you can report partial completions or report total completions in one transaction.

When you report partial completions, you can also indicate the stage or progress that is being made on an order in production and identify any delays in the production process. The Work With Work Order Completions form displays completed and scrapped quantities and percent complete information for a work order.

When you use the Work Order Completion program to complete more than the quantity ordered, the system highlights the Completed Quantity field and warns you that completing the quantity that you designated will generate an over-completion. You can complete a work order to multiple locations. In this case, you enter the total quantity to be completed and then divide it among multiple locations.

When a previous completion exists for a work order, the system displays information in the lot, grade or potency, and status fields. Also, when you enter a quantity, the system adds inventory to the lot at the grade or potency and the current status.

You can perform full or partial order completions either with or without backflushing the parts. If you use backflushing, you report the issue transactions at completion or at operations that are defined as pay point operations for super backflush. For backflush to occur, the ingredient must be set up with an issue code that allows the item to be backflushed.

When you set a completions threshold in the processing option, the system updates the Update Status field on the Work Order Completion Detail form according to the threshold rules. If you use lot control, you can also specify a default value for the completion lot number, such as the work order number or the associated sales order number. You can override the default value on the form.

Prerequisite

❑ If you want to perform a completion with backflush, set the appropriate processing options to access the Inventory Issues program (P31113) and to identify the version of the program to use.

► **To complete work orders without backflushing**

From the Daily Order Reporting - Discrete menu (G3112), choose Partial Completion or Full Completion.

1. On Work With Work Order Completions, complete the following fields and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields:

   - Quantity Completed
   - Secondary Qty Completed

   Note

   You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional fields:

   - Quantity Scrapped
   - Date Completed

Note

You can enter scrap manually for a parent item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

5. To complete a work order at a location other than the primary location, choose the Lot/Location tab, complete the following field and click OK:

    -   Location

Caution

If you have activated the Location Control option in the Branch/Plant Constants program (P41001), you can only complete work orders to locations you have defined in the Location Master program (P4100).

6. If you are creating a new lot for a lot-controlled item, complete the following field:

    -   Lot/Serial

Note

You can also set the appropriate processing option to use the sales order or work order number as the default value for the lot number on this form.

If you complete an item to an existing lot, the lot expiration and effectivity dates are populated from the lot master record. You can also use the Lot Date Override form exit on Work Order Completion Detail to enter the appropriate lot dates.

7. Click OK.

Processing Options for Work Order Completions (P31114)

Defaults Tab

These processing options control the default document types that the system uses when you complete inventory.

1. Inventory Completion Document Type

Use this processing option to specify the default document type for inventory completions. Select the document type from UDC 00/DT (Document Type - All Documents).

2. Inventory Scrap Document Type

Use this processing option to specify the default document type for inventory scrap

transactions. Select the document type from UDC 00/DT (Document Type - All Documents).

Edits Tab

These processing options control how the system invokes processes, such as issues and receipt routing, during the completions process.

1. Backflush
Blank = Do not call WO issues
1 = Perform an interactive execution of WO issues
2 = Perform a blind execution of WO issues

Use this processing option to specify whether the system issues material to the Parts List based on the quantity that is completed. You can also specify whether the system issues material in interactive mode or blind mode. If the processing option is set to 1 or 2, you need to specify the version of the Work Order Inventory Issues program (P31113) on the Versions tab. Valid values are:

Blank

The system does not issue material to the Parts List.

1

The system displays the Work Order Issues form.

2

The system performs a blind execution of Work Order Issues.

2. Receipt Routing
Blank = Do not initiate receipts routing
1= Initiate receipt routing

Use this processing option to specify whether the system initiates the receipt routing process. This action allows the inventory completion to enter an inspection mode before the quantity is moved to stock.

To activate receipt routing for an item, the item must have a route assigned to it through the Supplier/Item Relationships program (P43090). The supplier for the manufactured end-item must be listed as -99999999. Valid values are:

Blank

The system does not initiate receipt routing.

1

The system initiates receipt routing.

3. Override Lot Numbers
Blank = The user cannot override lot number
1 = The user can override lot number

Use this processing option to specify whether the system allows you to override the lot number. If you leave this processing option blank and you have performed no other completions for the work order, the lot number field is unprotected. If you have performed any completions for the work order, the system protects the lot number field. It uses the lot number for the first completion of that work order and for all other partial completions. However, if you set this processing option to 1, you can override the lot number even if you have already performed a partial completion for the work order. Valid values are:

Blank

The system does not allow you to override the lot number.

1

The system allows you to override the lot number.

4. Negative Quantity on Hand

Use this processing option to specify whether the system displays an error message when the completed material sets the on-hand quantity to a negative amount. Valid values are:

Blank

The system does not display an error message for negative on-hand quantities.

1

The system displays an error message for negative on-hand quantities.

5. Enter a '1' to initiate WIP Revaluation (R30837)

Use this processing option to specify whether the system calls the WIP Revaluation program (R30837) to adjust work-in-progress amounts to reflect cost changes. Valid values are:

Blank

Do not initiate WIP Revaluation.

1

Initiate WIP Revaluation.

WO Status Tab

These processing options controls the status that you can assign to partially and fully completed work orders. You can also define a status as a threshold beyond which the system does not perform completion processing.

1. Partial Work Order Status Code

Use this processing option to specify the status code that you want the system to assign to a partially completed order. The system considers an order partially complete as long as the completed quantity is less than the percentage that is specified in the completion threshold processing option. If you leave this processing option blank, the system does not automatically update the status.

2. Completed Status Code

Use this processing option to specify the status code that the system assigns to a completed order. If you leave this processing option blank, the system does not automatically change the status. The system considers an order complete if the completed quantity is greater than or equal to the percentage that is specified in the Completion Threshold processing option.

3. Completion Threshold

Use this processing option to specify the threshold percentage at which the system considers the order to be complete. For example, if you enter 95, the system sets the work order status to complete when 95 precent of the order quantity is complete. If you specify a threshold value of zero, the system sets the work order status to complete when 100 percent of the order quantity is complete. If the completed quantity does not reach the threshold, the system sets the work order status to partially complete. If a related sales order is attached or the work order is cross-docked, any threshold less than 100 percent is ignored.

4. Work Order Status Limit

Use this processing option to specify the work order status code (00/SS) at or beyond which the system cannot run the Work Order Completions program (P3114). For example, if this processing option is set to status 95 and a work order has reached this status, the system generates an error message if you attempt to run Completions for that work order. If you leave this processing option blank, the system processes work orders at any status.

Lot Hold Codes Tab

These processing options control the lot hold codes to which the system processes a completion. You can enter up to five lot hold codes.

If you enter an asterisk in any of these fields, the system processes completions to all held lots. Additionally, if you leave these fields blank, the system does not process completions to any held lots.

1. Backflush
Blank = Do not call WO issues
1 = Perform an interactive execution of WO issues
2 = Perform a blind execution of WO issues

Use this processing option to specify one of five lot hold codes to which the system processes completions. Enter a hold code, an asterisk, or leave this field blank. If you enter a hold code, the system processes completions to that hold code. If you enter an asterisk, the system processes completions to all held lots. If you leave this field blank, the system does not process completions to any held lots.

2. Receipt Routing
Blank = Do not initiate receipts routing
1= Initiate receipt routing

Use this processing option to specify one of five lot hold codes to which the system processes completions. Enter a hold code, an asterisk, or leave this field blank. If you enter a hold code, the system processes completions to that hold code. If you enter an asterisk, the system processes completions to all held lots. If you leave this field blank, the system does not process completions to any held lots.

3. Override Lot Numbers
Blank = The user cannot override lot number
1 = The user can override lot number

Use this processing option to specify one of five lot hold codes to which the system processes completions. Enter a hold code, an asterisk, or leave this field blank. If you enter a hold code, the system processes completions to that hold code. If you enter an asterisk, the system processes completions to all held lots. If you leave this field blank, the system does not process completions to any held lots.

4. Negative Quantity on Hand

Use this processing option to specify one of five lot hold codes to which the system processes completions. Enter a hold code, an asterisk, or leave this field blank. If you enter a hold code, the system processes completions to that hold code. If you enter an asterisk, the system processes completions to all held lots. If you leave this field blank, the system does not process completions to any held lots.

5. Enter a '1' to initiate WIP Revaluation (R30837)

Use this processing option to specify one of five lot hold codes to which the system processes completions. Enter a hold code, an asterisk, or leave this field blank. If you enter a hold code, the system processes completions to that hold code. If you enter an asterisk, the system processes completions to all held lots. If you leave this field blank, the system does not process completions to any held lots.

Sales Orders Tab

These processing options control the information that the system needs to process completions that are associated with sales orders.

1. Partial Work Order Status Code

Use this processing option to specify which number the system uses for the completion lot number and the completion location. Valid values are:

1

The system uses the sales order number as the completion lot number.

2

The system uses the sales order number as the completion location and the sales order line number as the completion lot number.

3

The system uses the work order number as the completion lot number.

2. Completed Status Code

Use this processing option to specify whether the system updates the related sales order by committing the inventory to the related sales order, splitting the sales order detail line when a partial completion occurs, and updating the lot number and location number fields from the work order. Valid values are:

Blank

Do not update the sales order.

1

Update the sales order.

3. Completion Threshold

Use this processing option to specify the default next status code for the sales order. The system uses this processing option only if the Update Sales Order Next Status processing option is set to update.

Enter a status code from UDC 40/AT (Activity/Status Codes). If you leave this processing option blank, the system uses the sales order next status from the order activity rules.

4. Work Order Status Limit

Use this processing option to specify whether the system updates the Next Status for the sales order. Valid values are:

Blank

The system does not update the Next Status.

1

The system updates the Next Status.

5. Display Back Order Release Form
Blank = Do not display form
1 = Display form

Use this processing option to specify whether the system calls the Backorder Release
program (P42117) for completed backordered items. By using this program, you can view
the items that are on backorder and choose to ship them immmediately. You can also
prioritize existing backorders. If you enter 1 for this processing option, use the Back
Order Release Version processing option on the Versions tab to specify which version of
the Backorder Release program to use. Valid values are:

Blank

Do not call the Backorder Release program.

1

Call the Backorder Release program.

Process Manufacturing Tab

These processing options control whether the system allows unplanned co-products and by-products
and whether the system issues them separately or together.

1. Lot Hold Code # 1

Use this processing option to specify whether the system processes completions of
unplanned co-products and by-products. Valid values are:

  Blank The system does not process completions of unplanned co-products and by-
products.

    1   The system processes completions of unplanned co-products and by-products.

2. Lot Hold Code # 2

Use this processing option to determine if ingredients are issued to the process item or to each co- or by-product that the system completes. This processing option is used only if the Backflush option is set to call the Work Order Inventory Issues program (P31113). Valid values are:

Blank

The system issues ingredients to the process item.

1

The system issues ingredients to co- and by-products.

Note: If you choose 1, you can track lots to the final end product.

Serial Number Processing Tab

These processing options control how the system processes inventory completions when you have serial numbers attached to the work orders.

1. Putaway Requests
Blank = Do not process putaway requests
1 = Process putaway requests only
2 = Process putaway requests using the subsystem

Use this processing option to specify whether the system duplicates lot numbers, serial numbers, or both, that exist in the system. Valid values are:

Blank

The system does not duplicate lot numbers or serial numbers.

1

The system duplicates lot numbers and serial numbers.

2. Entry of license plate numbers

Blank = Automatically assigned by system

1 = Input allowed

Use this processing option to specify the default document type that the system uses for serial number issues. Document types are listed in UDC 00/DT (Document Type - All Documents). If you leave this processing option blank, the system uses IM (Material Charged to W.O.'s) as the default value.

Warehouse Management Tab

These processing options control information that is relevant to integration with the Warehouse Management system.

1. Work Order Lot and Location Defaults

1 = Use SO number as lot number

2 = Use SO number as location, and SO line number as lot number

3 = Use WO number as the lot number.

Use this processing option to specify whether putaway requests will be processed. For mode 2, you need to specify the version of the subsystem program that the system uses in the Location Selection Driver processing option (R46171) on the Versions tab. Valid values are:

Blank

The system does not process putaway requests.

1

The system processes putaway requests only.

2

The system processes putaway requests when it accesses the subsystem.

2. Entry of license plate numbers

Blank = Automatically assigned by system

1 = Input allowed

Use this processing option to specify whether the system assigns license plate numbers automatically or allows you to specify the value. You use this processing option only if you enable license plate functionality at the Item/Branch level by using the Item Unit of Measure Definition program (P46011). Valid values are:

Blank

License plate numbers are assigned automatically.

1

License plate numbers are assigned manually.

Cross-Docking

These processing options control processing for cross-docking.

1. Cross Docking
Blank = No cross docking
1 = Opportunistic cross docking
2 = Planned cross docking
3 = Planned and opportunistic cross docking

Use this processing option to specify whether the system performs opportunistic cross-docking, planned cross-docking, or both. The system performs planned cross-docking only for items for which the cross-docking code is activated in the item branch/plant record. Valid values are:

Blank

Do not use cross-docking.

1

Use opportunistic cross-docking (only for warehouse items).

2

Use planned cross-docking.

3

Use both opportunistic and planned cross-docking.

2. Pick Request for Planned Cross Docking

Blank = Do not create pick request

1 = Create pick request

2 = Create pick request and process through subsystem

Use this processing option to specify whether the system creates a pick request when it performs planned cross-docking. Valid values are:

Blank

Do not create a pick request.

1

Create a pick request.

2

Create a pick request and process it through the subsystem.

3. Override Next Status for Sales Orders

Use this processing option to specify the default next status code for the sales order. The system uses this processing option only if planned cross-docking is performed.

Enter a status code from UDC 40/AT (Activity/Status Codes). If you leave this processing option blank, the system uses the sales order next status from the order activity rules.

4. From Sales Order Status

Use this processing option to specify the from status code of the sales order for cross-docking during work order completions. The system uses this processing option only if planned cross-docking is performed.

5. Thru Sales Order Status

Use this processing option to specify the thru status code of the sales order for cross-docking during work order completions. The system uses this processing option only if planned cross-docking is performed.

Versions Tab

These processing options control which versions of the following programs the system uses in the completion process:

1. Work Order Entry (P48013)

Use this processing option to specify the version you want to use when calling the Work Order Entry program (P48012) from the Work Order Completion Detail form. The version controls how the program displays information. If you leave this processing option blank, the system uses version ZJDE0001.

2. Work Order Issues Version (P31113)

Use this processing option to specify the version of the Work Order Issues program that the system uses. The system only requires this processing option when Work Order Issues is set to execute.

If you leave this field blank, the system uses the ZJDE0001 version of the program. This version controls how the Work Order Issues program displays information.

3. Test Results Revisions (P3711)

Use this processing option to specify the version that you want to use when calling the Test Results Revisions program (P3711) from the Work Order Completion Detail form. The version controls how the program displays information. If you leave this processing option blank, the system uses version ZJDE0001.

4. WIP Revaluation (R30837)

Use this processing option to specify which version of the WIP Revaluation program (R30837) the system uses. If you leave this processing option blank, the system uses version ZJDE0001.

5. Pick Request Version (R46171)

Use this processing option to specify the version of the Location Selection Driver program (R46171) that the system uses to create pick requests during planned cross-docking. If you leave this processing option blank, the system uses version ZJDE0001.

6. Location Selection Driver Version (R46171)

Use this processing option to specify the version of the Location Selection Driver program (P46171) to use. If you leave this processing option blank, the system uses version ZJDE0001. The version controls how the program displays information.

7. Back Order Release Version (P42117)

Use this processing option to specify the version of the Backorder Release program (P42117) that the system uses to complete inventory with backordered items. The version controls how the Back Order Release program displays information. Enter a version if the Display Back Order Release Form processing option on the Sales Orders tab is set to 1. If you leave this processing option blank, the system uses version ZJDE0001.

8. Shortage Workbench (P3118)

Use this processing option to specify the version that you want to use when calling the Shortage Revisions program (P3118) from the Work Order Completion Detail form. The version controls how the program displays information. If you leave this processing option blank, the system uses version ZJDE0001.

Interoperability Tab

These processing options control the default transaction type that the system uses to process export transactions and to identify the outbound subsystem.

1. Cross Docking
Blank = No cross docking
1 = Opportunistic cross docking
2 = Planned cross docking
3 = Planned and opportunistic cross docking

Use this processing option to specify the transaction type that the system uses for outbound interoperability processing. Transaction types are listed in UDC 00/TT (Transaction Type). The system assigns a transaction type to a transaction when it completes a work order. If you leave this processing option blank, the system does not

perform outbound interoperability processing.

2. Pick Request for Planned Cross Docking

Blank = Do not create pick request

1 = Create pick request

2 = Create pick request and process through subsystem

Use this processing option to specify whether the system activates the subsystem after the Work Order Completions program (P31114) has successfully processed an outbound transaction. Valid values are:

Blank

The system does not activate the subsystem.

1

The system activates the subsystem.

3. Work Order Header Before Image

Blank = Do not include the image

1 = Include the image

Use this processing option to specify whether the system writes the before image for the work order header. Valid values are:

1   The system includes the image.

Blank The system does not include the image.

► **To complete work orders through backflush**

From the Daily Order Reporting - Discrete menu (G3112), choose Completion with Backflush.

1. On Work With Work Order Completions, complete the following fields and click Find:

- Skip to Order Number
- Branch/Plant

2. Choose an order and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields:

- Quantity Completed
- Secondary Qty Completed

Note

You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional fields:

- Quantity Scrapped
- Date Completed

Note

You can enter scrap manually for a parent item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

5. To complete a work order at a location other than the primary location, choose the Lot/Location tab, complete the following field and click OK:

- Location

6. If you are creating a new lot for a lot-controlled item, complete the following field:

- Lot/Serial

7. Click OK.

8. On Inventory Issue Revisions, review the issue quantities and click OK to issue the material.

► **To complete a work order for multiple locations**

From the Daily Order Reporting - Discrete menu (G3112), choose Partial Completion.

1. On Work With Work Order Completions, complete the following fields and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order number and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields:

   - Quantity Completed
   - Secondary Qty Completed

Note

You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

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4. Complete the following optional fields:

   - Quantity Scrapped
   - Date Completed

Note

You can enter scrap manually for a process item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

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5. To complete the quantity for multiple locations, choose Multi-location from the Form menu.

6. On Select Multiple Locations, complete the following fields for all locations for which you want to complete parent items:

   - Quantity
   - Location

7. Complete the following optional field:

   - Lot / Serial

Partial Completion - Select Multiple Locations

8. Click OK.

9. On Work Order Completion Detail, click OK.

Releasing Sales Backorders During Completions

You can create a sales order in the Sales Order Management system that automatically generates a work order to supply the ordered item (a sales order with line type W). If the requested date of this sales order does not allow sufficient time for the item to be manufactured, given the item's level lead time, the order quantity can be identified as backordered. In this case, you can launch the Release Backorders - Online program (P42117) during work order completion to release the backorder for the item.

Prerequisite

❑ Before you release sales backorders during completion, set processing options to call the Backorder Release program (P42117) and identify the version of the program to use.

► **To release sales backorders during completions**

From the Daily Order Reporting - Discrete menu (G3112), choose Full Completion.

1. On Work With Work Order Completions, complete the following fields and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order number and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields:

    - Quantity Completed
    - Secondary Qty Completed

    Note

    You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional field:

    - Quantity Scrapped

    Note

    You can enter scrap manually for a parent item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

5. To complete a work order at a location other than the primary location, choose the Lot/Location tab, complete the following field and click OK:

    - Location

6. On Work With Backorders, review the following information:

    - Order Number
    - Or Ty
    - Item Number
    - Quantity on Backorder
    - Ship To

    If the available quantity plus the amount being received is enough to fill any or all of the backorders, the system enters the amount for that order in the Quantity to Ship field on Release Backorders.

Managing Completions that Use Receipts Routing

You set up a receipt routing in the Procurement system by specifying a unique code name for routing receipts in the UDC table 43/RC (Route Codes) and an operation name in UDC 43/OC (Operation Codes). You enter a Y in any of the update fields in the Receipt Routing Definition program (P43091) to cause the system to update the appropriate field in the Item Location File table (F41021) when an item arrives at the specified operation.

The system considers items to be on-hand only at the end of a receipt routing. You must enter a Y (Yes) in the Update O/H field for the system to assign the last operation to a routing. The system assigns a Y in the Pay field on the operation to which a Y is assigned in the On-Hand field.

To specify whether the system directs items through a receipt routing, you must assign a routing to each item. You assign receipt routings to items based on item or supplier relationships or both.

For manufactured items, the supplier must be -99999999. However, the system generates the supplier when you set the processing options for Work Order Completion in the Supplier/Item Relationships program (P43090). The processing options automatically sets the manufactured items to supplier -99999999 and prevents the system from displaying a supplier field in the program.

Prerequisite

❑   Set the processing option to initiate the receipt routing process.

► **To manage completions using receipts routing**

From the Receipt Routing menu (G43A14), choose Routing/Analysis Revisions.

1. On Work With Supplier/Item Relationships, complete the following field and click Find:

- Branch/Plant

2. Choose a record and click Select.

3. On Supplier/Item Relationships, complete the following fields and click OK:

- Effective Date
- Expiration Date
- Normal Route Code

To locate the status of the receipts routing, use the Status Inquiry program (P43250). To view the details of a step, access the Receipt Routing Movement form.

See Also

❑ *Reviewing Manufacturing AAIs* in the *Product Costing and Manufacturing Accounting Guide* for more information about automatic accounting instructions for manufacturing

❑ *Entering Receipts* in the *Procurement Guide* for detailed information about entering receipts

Processing Options for Routing/Analysis Revisions (P43090)

Process
Cross Ref. Type for Supplier Item (Default VN)
Enter a '1' to automatically display the applications listed below when adding a new item.
Standard Item Master
Non-Stock Item Master
Supplier Prices
Enter a '1' for Work Order Completion Mode
Versions
Enter the version for each program that is called. If left blank, ZJDE0001 will be used.
Item Master Maintenance (P4101)

Processing Work Orders through Super Backflush

You can use the Super Backflush program (P31123) to enter completed and scrapped quantities by operation and employee. If the quantities you enter exceed the quantity at operation, the system issues an error message. The pay point code that you define for each operation in the routing instructions determines what information is backflushed at each pay point. Pay point code B, for example, means that you issue materials and report labor at the operation. You can also choose to backflush material or labor only at a given pay point. The last operation in the routing instructions must be set up with pay point code B to ensure that all remaining materials and labor are reported before the work order is completed. The backflush procedure can perform the following transactions by operation:

- Issue parts to the work order

- Enter hours and quantities for the work order

- Enter inventory completions

In the processing options, you can set up the super backflush process to be performed either automatically or interactively. If the process is set up to run interactively, the system displays the following programs after you enter the completion information on the Super Backflush form:

- Inventory Issues (P31113)

- Hours and Quantities (P311221)

- Work Order Inventory Completions (P31114)

You can accept the information that appears in these programs, or you can revise it. For example, when the Time Entry Revisions form appears after you enter information on the Super Backflush form, you can view the labor recorded for the operation, as well as the quantity completed. The records created through Super Backflush are stored in the Work Order Time Transactions table (F31122) with a Processed Code of S. The system automatically updates the Work Order Routing table (F3112). If you add information on the Time Entry Revisions form, you must run the Hours and Quantities Update program (R31422) to update the Work Order Routing table. These records will have a Processed Code of P in the Work Order Time Transactions table.

► **To process work orders through super backflush**

From the Daily Order Reporting - Discrete menu (G3112), choose Super Backflush.

1. On Work With Order Numbers, complete the following fields and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose the order that you want to process and click Select.

   On the Super Backflush form, operations defined as pay points appear in reverse image.

3. On Super Backflush, complete the following fields:

   - Transaction Date
   - Shift Code

4. Complete the following grid fields for a paypoint operation:

   - Employee Number
   - Quantity Completed
   - Op St

   If you have defined default values for the shift code, employee number and operation status in the processing options, you do not have to enter values into these fields.

5. Complete the following optional field and click OK:

- Pay Point Status

If the pay point code for the operation indicates that material should be backflushed, the Inventory Issue Revisions form appears.

6. On Inventory Issue Revisions, accept or revise the issue quantities and click OK.

If the pay point code for the operation indicates that labor should be backflushed, the Time Entry Revisions form appears.

7. On Time Entry Revisions, review any of the following fields and click OK:

- Employee Number
- Oper #
- Ty Hrs
- Hours
- Quantity
- UM
- St

The Time Entry Revision form displays the records created in the Super Backflush program. The system updates the Work Order Routing table (F3112) with this information. On Time Entry Revision, you can add hours and quantity information.

8. On the last pay point, complete steps 3 through 7.

The Work Order Completion Detail form appears.

9. Review the completion information and click OK.

Processing Options for Super Backflush (P31123)

Defaults Tab

These processing options allow you to identify the operation status for partial and full completions, as well as default values for the work order status, employee number, and shift code.

1. Operation Status for Partial Completions.

Use this processing option to specify the default operation status for a line when the quantity is partially completed at this operation step in the routing.

2. Operation Status Code for Full Completions.

Use this processing option to specify the default operation status at the point when the quantity is fully complete.

3. Work Order Status Code

Use this processing option to specify the default status code for the work order header that the system updates after a super backflush transaction. This value always supersedes any status set by Work Order Inventory Issues (P31113), Work Order Time Entry (P311221), or Work Order Completions (P31114) programs.

4. Employee Number

Use this processing option to specify an employee number (AN8) that the system uses as the default value for the detail area on the Super Backflush form. If you leave this processing option blank, The Employee Number field in the detail area remains blank.

5. Shift Code

Use this processing option to specify a shift code that the system uses as the default value in the header area on the Super Backflush form. If you leave this processing option blank, the Shift Code field in the header area remains blank.

Process Tab

These processing options control whether the system displays the following forms for interactive processing when you run the Super Backflush program. You can also specify whether the system applies the operation yield percentage to the completed quantity.

1. Work Order Completions

Blank = Interactive Mode
1 = Blind Mode

Use this processing option to specify how the Super Backflush program (P31123) processes work order completions. If completions are processed blindly, the Super Backflush program completes the quantity that is specified on the Super Backflush grid. If you plan to complete quantities to different locations, lot or serial numbers, then process the Work Order Completions program (P31114) in interactive mode. Valid values are:

Blank

The program calls the Work Order Completions program for interactive processing.

1

The program blindly processes work order completions.

2. Work Order Issues

Blank = Interactive Mode
1 = Blind Mode

Use this processing option to specify how Super Backflush (P31123) processes inventory issues for work orders. If the Work Order Inventory Issues program (P31113) is executed blindly, the Super Backflush program issues the quantity that is specified on the Super Backflush grid, according to the issue type code. If you plan to issue quantities other than the standard calculated quantity, then process the Work Order Inventory Issues program (P31113) in interactive mode. Valid values are:

Blank

The program calls the Work Order Inventory Issues program for interactive processing.

1

The program blindly processes inventory issues to work orders.

3. Hours and Quantities Form

Blank = Interactive Mode
1 = Blind Mode

Use this processing option to specify how the Super Backflush program (P31123) processes hours and quantities transactions. If the hours and quantities transactions are processed blindly, the Super Backflush program creates standard transactions in the Work Order Time Transactions table (F31122). If you plan to enter additional hours and quantities other than the standard amount, then process the Work Order Time Entry program (P311221) in interactive mode. Valid values are:

Blank

The program calls the Hours and Quantities program for interactive processing.

1

The program blindly processes hours and quantities transactions.

4. Apply Yield to Completed Quantity

Blank = Do not apply
1 = Apply

Use this option to specify whether the system applies the operation yield percentage to the quantity that the user completes at an operation. The yield percentage determines the scrap quantity. Valid values are:

Blank The system does not apply the operation yield percent to the quantity completed.

1   The system applies the operation yield percent to the quantity completed.

Edits Tab

These processing options control whether the system compares the quantity at operation with the completed and scrapped quantity, and they define the work order status beyond which the Super Backflush program cannot be run for a work order.

1. Validate Quantity at Operation

Blank = Do not validate
1 = Validate

Use this processing option to validate that the quantity completed plus the quantity scrapped does not exceed the quantity at operation.

Valid values are:

Blank The system does not validate quantities at operation.

1   The system validates quantities at operation.

2. Work Order Status Limit

Use this processing option to specify the work order status code (00/SS) at or beyond which the system cannot run the Super Backflush program. For example, if this processing option is set to 95 and a work order has reached a status of 95, then the system generates an error message if you attempt to run Super Backflush on that work order.

Versions Tab

These processing options control which version the system uses when the following programs are called from the Super Backflush program:

---

1. Hours and Quantities (P311221)

Use this processing option to specify the version of the Work Order Time Entry program (P311221) that the system uses to report labor hours, machine hours, and quantities for a routing step of a particular work order. If you leave this processing option blank, the system uses version ZJDE0001.

2. Work Order Issues (P31113)

Use this processing option to specify which version of the Work Order Inventory Issues program (P31113) that the system uses to report material which is issued from inventory to a work order. If you leave this processing option blank, the system uses version ZJDE0001.

3. Work Order Completions (P31114)

Use this processing option to specify which version of the Work Order Completions program (P31114) that the system uses to complete manufacturing items from a work order to inventory. If you leave this processing option blank, the system uses version ZJDE0001.

4. Test Results Revisions (P3711)

Use this processing option to specify which version of the Test Results Revisions program (P3711) that the system uses when you call this program from the Super Backflush form. If you leave this processing option blank, the system uses version ZJDE0001.

5. Scheduling Workbench (P31225)

Use this processing option to specify which version of the Manufacturing Scheduling Workbench program (P31225) that the system uses when you call the program from the Super Backflush form. If you leave this processing option blank, the system uses version ZJDE0001.

6. Work Order Entry (P48013)

Use this processing option to specify which version of the Work Order Entry program (P48012) that the system uses when you call this program from the Super Backflush form.

If you leave this processing option blank, the system uses version ZJDE0001.

Interop Tab

These processing options control the work order transaction type that the system uses for outbound processing and whether it includes a before image of the work order header.

1. Work Order Transaction Type

Use this processing option to specify the default transaction type for the work order header that the system uses when processing export transactions. If you leave this processing option blank, the system does not perform export processing.

2. Work Order Header Before Image

Blank = Do not include the image
1 = Include the before image

Use this processing option to specify whether the system writes the before image for the work order header. Valid values are:

1

The system writes the before image.

Blank

The system does not write the before image.

Completing Work Orders with Serialized Components

When you enter a completion for serialized components, you can generate a serial number for each completed item by accessing the Assembly Serial Numbers program (P3105). Another program, Serial Number Associations (P3107), is accessible only when you are associating serial number-controlled components to serial number assemblies. The system displays the preassigned serial numbers and any memo lot information on the Serial Number Associations form.

After you generate serial numbers for a work order, you associate the serialized components with a serialized assembly. To associate a serialized component with a serialized assembly, you enter the associating quantity.

In addition, the completion program allows you to enter a memo lot number to use when both lot and serial numbers are required for tracking assemblies. You can set the Serial No. Required field on the Item Branch/Plant Info. form (W41026A) to specify that the system verify the memo lot number and serial number.

When you complete work orders with components that are not serialized, you cannot assign serial numbers to the assemblies at completion.

When you set the appropriate processing options in the completion program, the system allows you to complete multiple items using the same serial number.

▶ **To complete work orders with serialized components**

From the Daily Order Reporting - Discrete menu (G3112), choose Partial Completion.

1. On Work With Work Order Completions, complete the following fields and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order number and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields:

   - Quantity Completed
   - Secondary Qty Completed

   Note

   You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional fields:

   - Quantity Scrapped
   - Date Completed

   Note

   For serialized items you can complete only one item at a time.

5. If you know the serial number, choose the Lot/Location tab and complete the following field:

   - Lot/Serial

6. If you do not know the serial number, choose Serial Numbers from the Form menu.

7. On Work With Order Serial Number, choose a number, click Select, and then go to step 11.

   If a list of serial numbers does not appear, you must generate them by choosing Revisions from the Form menu.

8. On Serial Number Revisions, choose Lot/SN Generation from the Form menu.

   The system generates enough serial numbers for all the items on the work order.

9. Click OK to return the list to Work With Order Serial Numbers.

10. On Work With Order Serial Numbers, choose the serial number that you want and click Select.

11. To complete a work order at a known location other than the primary location, complete the following field and click OK:

   • Location

12. Choose Lot/SN Association from the Form menu.

13. On Serial Number Associations, choose Issued Items from the Form menu.

14. On Work With Serialized Issued Items, choose the components that you want to associate with the serialized assembly and click Select.

15. On Serial Number Associations, click OK.

16. On Work With Work Order Completion Detail, click OK.

Completing Process Work Orders

When you finish producing a process item on the shop floor, you need to record the completions to inventory. The completion transactions that you enter in the Shop Floor Management system update the ingredient quantity records in the Inventory Management system.

You use the Super Backflush (P31123) or Work Order Completions (P31114) programs to report completions. Use these programs to perform one of the following two functions:

   • Report all co-products and by-products as complete after the entire work order is complete

   • Report partial completions as they occur throughout the production process

The point at which you choose to report completions depends on the process, the co-products and by-products that it produces, and your production cycle time. Depending on the nature of the manufactured item, you can report partial completions or report total completions in one transaction. When you report partial completions, you can also indicate the stage or progress that is being made on an order in production and identify any delays in the production process.

When you use the Work Order Completions program to complete more than the quantity ordered, the system highlights the Completed Quantity field and warns you that completing the quantity that you designated will generate an overcompletion.

When a previous completion exists for a work order, the system displays information in the lot, grade or potency, and status fields. Also, when you enter a quantity, the system adds inventory to the lot at the grade or potency and the current status. The Work With Work Order Completions form displays completed and scrapped quantities and percent complete information for a work order.

You can perform full or partial process order completions without or without backflushing the ingredients. When you use backflushing, you report the issue transactions for ingredients that you use in a process after the co-products and by-products of the process are produced. For backflush to occur, the ingredient must be set up with an issue code that allows backflushing.

When you set a completions threshold in the processing option, the system updates the Update Status field on the Work Order Completion Detail form according to the threshold rules. When you use lot control, you can also specify a default value for the completion lot number, such as the work order number or the associated sales order number. You can override the default value on the form.

Prerequisites

❑ Set the appropriate processing options to access the Inventory Issues program (P4112) and to identify the version of the program to use.

❑ Set the appropriate processing options to issue ingredients for each co-product and by-product separately, and to allow completion of unplanned co-products and by-products.

► **To complete process orders without backflushing**

From the Daily Order Reporting - Process menu (G3114), choose Partial Completion or Full Completion.

1. On Work With Work Order Completions, complete the following fields and click Find:

    • Skip to Order Number
    • Branch/Plant

2. Choose a record and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields for the process item:

    • Quantity Completed
    • Secondary Qty Completed

Note

You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional fields:

- Quantity Scrapped
- Date Completed

Note

You can enter scrap manually for a process item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

5. Click OK.

6. On the Co/By Completion Revisions form, complete the following fields:

- Quantity Completed
- Quantity Canceled
- Date Completed
- Secondary Qty Completed
- Location
- Lot Serial Number

7. Click OK.

► **To complete process orders through backflush**

From the Daily Order Reporting - Process menu (G3114), choose Completion with Backflush.

1. On Work With Work Order Completions, complete the following fields and click Find:

    *   Skip to Order Number
    *   Branch/Plant

2. Choose a record and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields for the process item:

    *   Quantity Completed
    *   Secondary Qty Completed

    Note

    You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional fields:

    *   Quantity Scrapped
    *   Date Completed

    Note

    You can enter scrap manually for a process item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

5. Click OK.

6. On the Co/By Completion Revisions form, complete the following fields:

    *   Quantity Completed
    *   Quantity Canceled
    *   Date Completed
    *   Secondary Qty Completed
    *   Location
    *   Lot Serial Number

7. Click OK.

    After you click OK, the system updates the on-hand inventory for the co-products and by-products. The Inventory Issues form appears for each co-product and by-product, allowing you to issue the ingredients separately for each co-product and by-product.

8. On Inventory Issue Revisions, review the issue quantities.

9. To issue the material, click OK.

Setting the Resource Percent for the Co-Products and By-Products

Use the Co/By Product Revision form to indicate what percent of the ingredients should be issued separately to co-products and by-products.

▶ **To set the resource percent for the co-products and by-products**

From the Daily PDM Process menu (G3012), choose Enter/Change Process.

1. On Work with Routing Operations, complete the following fields and click Find:

   • Item Number
   • Branch/Plant

2. Choose an operation and click Select.

3. On Enter Process Information, choose Co/By Revision from the Form menu.

4. On Co/By Product Revision, complete the following optional field and click OK:

   • Resource %

Releasing Sales Backorders During Completions

You can create a sales order in the Sales Order Management system that automatically generates a work order to supply the ordered item (sales order with line type W). If the requested date of this sales order does not allow sufficient time for the item to be manufactured, given the item's lead time, the order quantity can be identified as backordered. In this case, you can choose to run the Release Backorders - Online program (P42117) during work order completion to release the backorder for the item.

Prerequisite

❑ Set processing options to call the Backorder Release program (P42117) and identify the version to use.

► **To release sales backorders during completions**

From the Daily Order Reporting - Process menu (G3114), choose Completion with Backflush.

1. On Work With Work Order Completions, complete the following fields and click Find:

   - Skip to Order Number
   - Branch/Plant

2. Choose an order number and click Select.

3. On Work Order Completion Detail, choose the Quantity tab and complete the following fields for the process item:

   - Quantity Completed
   - Secondary Qty Completed

   Note

   You must complete the Secondary Quantity Completed field if the item you are completing is set up with dual units of measure in the item master record.

4. Complete the following optional fields:

   - Quantity Scrapped
   - Date Completed

   Note

   You can enter scrap manually for a process item. You can also set up the system to calculate scrap automatically by using the scrap or yield percentage values defined in the bill of material and routing.

5. Click OK.

6. On the Co/By Completion Revisions form, complete the following fields:

   - Quantity Completed
   - Quantity Canceled
   - Date Completed
   - Secondary Qty Completed
   - Location
   - Lot Serial Number

7. Click OK.

8. On Work With Backorders, review the following default information:

- Quantity on Backorder
- Order Number
- Or Ty
- Item Number
- Ship To

If the available quantity plus the amount being received is enough to fill any or all of the backorders, the system enters the amount for that order in the Quantity to Ship field on Work with Backorders.

9. Click OK.

Processing Process Orders through Super Backflush

You can use the Super Backflush program (P31123) to enter completed and scrapped quantities by operation and employee. If the quantities that you enter exceed the quantity at operation, the system issues an error message. The pay point code that you define for each operation in the routing instructions determines what information is backflushed at each pay point. Pay point code B, for example, means that you issue material and report labor at the operation. You can also choose to backflush material or labor only at a given pay point. The last operation in the routing instructions must be set up with pay point code B to ensure that all remaining materials and labor are reported before the process order is completed. The backflush procedure can perform the following transactions by operation:

- Issue parts to the process order
- Record hours and quantities against the process order
- Record inventory completions

In the processing options, you can set up the super backflush process to be performed either automatically or interactively. When you set up the process to run interactively, the system displays the following programs after you enter the completion information on the Super Backflush form:

- Inventory Issues (P31113)
- Hours and Quantities (P311221)
- Work Order Completions (P31114)

You can accept the information that appears on the forms, or you can revise it. For example, when the Time Entry Revisions form appears after you enter information on the Super Backflush form, you can review the labor recorded for the operation, as well as the quantity completed. The records created through Super Backflush are stored in the Work Order Time Transactions table (F31122) with a Processed Code of S. The system automatically updates the Work Order Routing table (F3112). If you add information on the Time Entry Revisions form, you must run the Hours and Quantities Update program (R31422) to update the Work Order Routing table. These records will have a Processed Code of P in the Work Order Time Transactions table.

When the system has an intermediate for the operation, all form quantities appear in the unit of measure for the intermediate. When the system completes the quantity, it deducts the quantity from the operation and adds it to the next operation.

► **To process process orders through super backflush**

From the Daily Order Reporting - Process menu (G3114), choose Super Backflush.

1. On Work With Order Numbers, complete the following fields and click Find:

    * Skip to Order Number
    * Branch/Plant

2. Choose the order that you want to process and click Select.

    On the Super Backflush form, operations defined as pay points appear in reverse image.

3. On Super Backflush, complete the following fields:

    * Transaction Date
    * Shift Code

4. Complete the following grid fields for a paypoint operation:

    * Employee Number
    * Quantity Completed
    * Op St

    If you have defined default values for the shift code, employee number and operation status in the processing options, you do not have to enter values into these fields.

5. Complete the following optional field and click OK:

    * Pay Point Status

    If the pay point code for the operation indicates that material should be backflushed, the Inventory Issue Revisions form appears

6. On Inventory Issue Revisions, accept or revise the issue quantities and click OK.

    If the pay point code for the operation indicates that labor should be backflushed, the Time Entry Revisions form appears.

7. On Time Entry Revisions, review any of the following fields and click OK:

    * Employee Number
    * Oper #
    * Ty Hrs
    * Hours
    * Quantity
    * UM
    * St

The Time Entry Revision form displays the records created in the Super Backflush program. The system has already updated the Work Order Routing table with this information. You can add hours and quantity information here.

8. On the last pay point, complete steps 3 through 7.

   The Work Order Completion Detail form appears.

9. Review the completion information and click OK.

10. On the Co/By Completion Revisions form, review the following fields:

   - Quantity Completed
   - Quantity Canceled
   - Date Completed
   - Secondary Qty Completed
   - Location
   - Lot Serial Number

11. Click OK.

Completing Rate Schedules

Use the Completions Workbench program (P3119) to enter rate schedule completions, issue parts, and enter hours and quantities for the rate. Depending on how you set the processing options, the Inventory Issue Revisions and Time Entry Revisions forms appear as you complete rate schedules.

When you perform a completion, the system enters the inventory records as they are received and updates all of the required tables for the Inventory Management system. The system adds the quantity that is completed to the quantity on hand for the location that you indicate.

Note

If you use the Quality Management system when you manage rate-based information and complete quantities to inventory, you can access the Test Results Revisions form for items that require testing.

Prerequisite

❑ Set the processing options to access the Inventory Issues (P31113) and Hours and Quantities programs (P311221).

► **To complete rate schedules**

From the Daily Processing - Repetitive menu (G3115), choose Completions Workbench.

1. On Completions Workbench, complete the following fields and click Find:

   - Branch/Plant
   - Order Type
   - Item Number
   - Line/Cell
   - Effective Date From
   - Effective Date Thru

2. Complete the following fields:

   - Quantity Completed
   - Secondary Qty Completed
   - Date Complete
   - Shift

3. Complete the following optional fields and click OK:

   - Quantity Scrapped
   - Effective From Date
   - Location
   - Lot/Serial Number
   - Employee

4. On Super Backflush, click OK.

5. On Inventory Issue Revisions, click OK.

6. On Time Entry Revisions, review the following fields and click OK:

- Employee Number
- Quantity
- St

7. On Work Order Completion Detail, click OK.

Processing Options for Completions Workbench (P3119)

Defaults
1. Enter the Schedule Type. Default value is 'SC'
2. Enter the Employee Number (Optional)
3. Enter the Production Line (Optional)
4. Enter the Number of Days to Add to the From Date for the Thru Date (Optional)
5. Enter the Status From (Optional)
6. Enter the Status Thru (Optional)
7. Enter the status code to use when
   closing rates. Default value is '99'
Versions
Enter the version for each program. If left blank, 'ZJDE0001' will be used.
1. Super Backflush (P31123)
2. Hours and Quantities (P311221)
3. Material Issues (P31113)
4. Enter/Change Rate Schedule (P3109)
5. Item Ledger Inquiry (P4111)
6. Line Schedule Review (P3152)
7. Schedule History Inquiry (P31226)
8. Work Order Completions (P31114)
9. Lot Master Revisions (P4108)
10. Hours and Quantities Update (R31422)
11. Name Search (P01012)
12. Test Results Revisions (P3711)
Process
1. Enter a '1' to automatically process hours and quantities using the version for R31422. If left blank,
R31422 should be submitted manually.

Work Order and Rate Schedule Information

After you have processed work orders or rate schedules, you can close, delete, or purge work orders and rate schedules from the system, review component information, such as usability, availability, supply, and demand, and print reports that you need to effectively manage work order or rate schedule information. You can also compare bills of material or parts lists by using the Bill of Material Comparison program (P30204).

Deactivating Work Orders and Rate Schedules

You might want to deactivate any work orders or rate schedules that are no longer active or that have been completed. To maintain a record of the work order or rate schedule and its progress, you should close the work order or schedule before you deactivate it. This ensures that quantity information in the Inventory Management system and manufacturing accounting information is traceable after you deactivate the work order or rate schedule.

You can use one of the following methods to deactivate work orders or rate schedules that you no longer use:

Change its status to closed	When you change the status of a work order or rate schedule to closed, the system identifies the work order or schedule as inactive, but does not delete it. This is the recommended way to deactivate a work order or rate schedule. This method enables you to keep complete historical records of the work order or rate schedule and its associated costing and accounting transactions.
Delete it	When you delete a work order or rate schedule, it is removed from the system entirely. You should complete the work order or rate schedule before deleting it to ensure that manufacturing accounting and inventory information is updated. If you delete a work order or rate schedule before completing it, these records might not be in place. If the quantity completed on the work order or rate schedule is less than the quantity ordered, the system removes the remaining quantity from the Quantity on Work Order field in the Item Location File table (F41021) when you delete the order or schedule.

Before you delete or purge a work order or rate schedule from the system, you must first complete the work order and then delete the parts list and routing instructions that are attached to the order.

Additionally, you cannot delete a work order or rate schedule if any of the following is true:

- The order number is used as a subledger number in the Account Ledger table (F0911)
- The work order is a parent order to other work orders
- Parts have been issued to the work order or rate schedule
- Labor has been entered for the work order or rate schedule

When a work order is in process, PeopleSoft recommends that you report completed and scrapped quantities for it before you delete it.

Purge it   When you purge work orders and rate schedules, the system deletes them based on their status code. You can save the purged records in a separate purge table.

Reviewing Work Order and Rate Schedule Status

Use the Production Status program (P31226) to review the status of all rate schedules and work orders by work center or line, work order number, rate schedule number, or item number, as qualified by the status and date ranges. You might want to review all of your work orders or rate schedules that are at a particular status or for a particular date range to determine which ones you want to deactivate. The program shows historical information, as well as open rates and work orders.

From the Production Status program, you can access the Production History program (P31227) where you can review the transactions for each entry of completions and scrap at an operation. The history program shows all transactions that make up the scrapped quantities and the details of these transactions.

►   **To review work order and rate schedule status**

From the Daily Processing - Repetitive menu (G3115), choose Production Status.

1. On Production Status, complete the following field:

    - Branch/Plant

2. Complete one, or a combination of any two, of the following fields:

- Work Center/Line
- Item Number
- Order Number/Type

3. To narrow your search to orders or schedules by date, complete the following fields:

- Effective Date From
- Effective Date Thru

4. To limit your search to orders or schedules at a specific status, such as complete, complete the following fields and click Find:

- Operation Status From
- Operation Status Thru

5. Review the information and click Cancel.

Processing Options for Production Status (P31226)

Defaults
1. Enter the From Status. (Optional)
2. Enter the Thru Status. (Optional)
3. Enter the number of days to add to today's date to calculate the default Thru Date. (Optional)
Process
1. Remaining Quantity

Blank = Include Cancelled/Scrapped quantity
1 = Exclude Cancelled/Scrapped quantity

Changing the Status of Work Orders to Closed

When you change the status of a work order to closed, the system identifies the order as inactive, but does not delete it. This is the recommended way to deactivate a work order. This method enables you to keep complete historical records of the work order and its associated costing and accounting transactions.

► **To change the status of work orders to closed**

To close a work order without deleting it from the system, you change the status of the order.

From the Daily Order Preparation - Discrete menu (G3111), choose Enter/Change Order.

1. On Work With Manufacturing Work Orders, complete the following field and click Find:

- Skip to Order Number

2. Choose an order number and click Select.

3. On Work Order Details, choose the Status & Type tab, type 99 in the following field, and then click OK:

- Status

Changing the Status of Rate Schedules to Closed

From the Shop Floor Management Advanced menu (G3131), choose Batch Rate Close.

For repetitive manufacturing, use the Batch Rate Close program (R3191) to close rate schedules when either of the following conditions applies:

- The status is less than or equal to the value specified in the processing options
- The effective through date is less than or equal to the date specified in the processing options

When you close rates, the system performs the following steps:

- Purges the rate schedule data from the Line/Item Relationship Master table (F3109)
- Release the commitment of any quantities for the applicable rates

Processing Options for Batch Rate Close (R3191)

Process
Enter in the following:
1. Enter the date to compare to the Rate Effective Thru Date. All rates for which the Thru Date is less than this date will be closed. If left blank, no rates will be closed.
2. Enter the status for closed rates. If left blank, '99' will be used.

Purging Work Orders

From the Shop Floor Management Advanced menu (G3131), choose Purge Orders.

The Purge Orders program (R4801P) deletes selected work orders or rate schedules from your system. The system purges the work orders and rate schedules and their associated information from the following tables:

- Work Order Master File (F4801)

- Work Order Instructions File (F4802)

- Work Order Parts List (F3111)

- Work Order Routing (F3112)

- Work Order Time Transactions (F31122)

When you purge work orders or rate schedules, the system deletes them based on their status codes. When you need to purge work orders or rates schedules that contain information that you might want to retain, you can save the purged records in a separate table.

You use the processing option for the Purge Orders program to specify whether you want to save the records that you purge in a special purge library. The system names this library JDE, followed by the current system date (without separators). For example, if you purge the records on January 1, 2005, the purge library is named JDE010105. The system creates a physical table with the same name within that library. If you purge the same table multiple times on the same day, the system adds the purged records to the records that are already in the purge table for that day.

Prerequisite

❑ Complete the accounting for the work orders or rate schedules before you purge them from the system. See *Work Orders in Accounting* in the *Product Costing and Manufacturing Accounting Guide* for information about how to complete the accounting.

Processing Options for Purge Orders (R4801P)

Process Tab

This processing option controls whether the records that you choose to purge are saved to the appropriate purge tables.

Blank   Do not Save Purged Records

1   Save Purged Records

Use this processing option to specify whether the records you want to purge will be saved in the following purge-related tables: F1307P, F3102S, F3105S, F3111S, F3112S, F31122S, F31171S, F31172S, F4801S, F4801ST, F4802S, and F48311S. Valid values are:

1

Save the records.

Blank

Do not save the records.

Reviewing Work Order and Rate Schedule Information

Throughout the manufacturing process, many different positions and business areas need access to product and manufacturing information. You might need information to solve problems, make decisions, or answer questions. You can review information for components, such as usability, availability, supply, and demand. You can review all item transactions in the system. Additionally, you can review all work orders that make up the load at a particular work center.

Reviewing Part Usability

Use the Part Usability program (P30212) to display the quantity of a parent item that can be produced based on the component quantity. The system adjusts the production quantity in relation to the component quantity. You can use this program to determine how much of a parent item can be produced, based on component material on-hand. You can limit the information that appears to a specific lot, grade, or potency of the item.

► **To review part usability**

From the Daily Order Preparation - Discrete menu (G3111), choose Part Usability.

1. On Work With Usability, complete the following fields and click Find:

   - Branch/Plant
   - Component
   - Quantity

2. To filter the display by lot number, potency or grade, complete one of the following optional fields:

   - Lot/Serial
   - Grade
   - Potency

3. Review the following fields and click Close:

   - Item Number
   - Prod. QTY
   - Batch Quantity
   - Type

Processing Options for Part Useability (P30212)

Default
Enter default Type of Bill
Type Bill of Material
Versions
Enter the version to be used for each program. If left blank, version 'ZJDE0001' is used.
Item Search (P41200)
Work Order Entry (P48013)
Item Master (P4101)
Item Availability (P41202)
Enter the version to be used for this program. If left blank, version 'ZJDE0002' is used.
BOM Inquiry (P30200)
Enter the version to be used for this program. If left blank, version 'ZJDE0004' is used.
Parts Availability (P30200)

Reviewing Summary Availability

Use the Summary Availability program (P41202) to verify the availability of an item in your branches or plants. You can display the data in detail or summary mode, and for one branch or for all of your branches.

► **To review summary availability**

From the Daily Order Preparation - Discrete menu (G3111), choose Summary Availability.

1. On Work With Item Availability, complete the following field and click Find:

   - Item Number

2. If you want to view availability for a particular branch, complete the following field:

   - Branch/Plant

3. Review the following fields:

   - P S
   - Location
   - On Hand
   - Committed
   - Available
   - On Receipt

4. To review detailed information about item availability at a particular branch, choose a record, and then choose Detail Avail from the Row menu.

Summary Availability - Detail Availability

Work With Item Availability | **Detail Availability**

Cancel Form Previous Next Tools

Item Number	220	Touring Bike, Red
Branch/Plant	M30	
Location	. .	Lot/Serial

Primary

U/M EA

Quantity to Subtract		Quantity to Add	
☑ Soft Committed - SO, WO	464	On Hand	13
☑ Hard Committed - SO		☐ On Purchase Order	7
☐ Future Committed		☐ On PO - Other 1	499
☑ Hard Committed - WO		☐ On WO Receipts	7442882
☐ On Sales Order - Other 1		☐ In Transit	
☐ On Sales Order - Other 2		☐ In Inspection	
☑ On Hold		☐ In Operation 1	
☐ Safety Stock		☐ In Operation 2	
Hard Committed - Project			

Total Quantity

| On Receipt | 7442889 | Available | 451- |

5. On Detail Availability, review the fields that provide detail information about committed and other quantity types, and then click Cancel to return to Work With Item Availability.

6. Click Close.

Processing Options for Summary Availability (P41202)

Versions
Enter the version for each program. If left blank, ZJDE0001 will be used.
1. Item Master

2. Item Notes
3. Item Search
4. Purchase Order Inquiry
5. Customer Service Inquiry
6. Open Work Orders
7. Supply and Demand
8. Bill of Material
9. Lot Availability
10. Item Ledger
11. Branch/Plant Item Information
12. Location Master
13. Item Location Information
Display
1. Grade Information

Blank = No information is displayed
1 = Display grade information
2. Potency Information

Blank = No information is displayed
1 = Display potency information
3. Quality Management

Blank = No information is displayed
1 = Use Quality Management.
4. Quantity - Primary Units of Measure

Blank = No information is displayed
1 = Also display primary units
5. Truncate/Round

Blank = Default to round
1 = Truncate information in the grid
2 = Round up
6. Customer Self-Service

Blank = Bypass Customer Self-Service functionality
1 = Activate Shopping Cart mode
Lot Options
1. Display Percent of Life Remaining
2. Display Number of Days Remaining
3. Calculation Date

Reviewing Item Ledger Information

Use the Item Ledger (The CARDEX) program (P4111) to display a detailed history of the transactions that have occurred for an item. The transactions include the following information:

- Inventory issues, adjustments, and transfers

- Sales posted after sales update

- Purchase receipts

- Manufacturing issues and completions

- Physical inventory updates

► **To review item ledger information**

From the Periodic Functions - Discrete menu (G3121), choose Item Ledger (The CARDEX).

1. On Work With Item Ledger, complete the following fields and click Find:

   - Item Number
   - Branch/Plant

2. Choose a document number and click Select.

3. On Item Ledger Detail, review the information that appears and click Cancel.

Processing Options for Item Ledger Inquiry (CARDEX) (P4111)

Default
Enter a Document Type. If left blank, '*' will be the default value and all document types will be
shown.
1. Document Type
Versions
Enter the version to be used for each program. If left blank, ZJDE0001 will be used.
1. Load and Delivery Ledger Inquiry (FUTURE)
Display
1. Enter a '1' to display Quantity in Primary Units of Measure along with Quantity in Transaction Units
of Measure.

Reviewing Dispatch List Information

A dispatch list is a sequential listing of manufacturing work orders or rate schedules that contains
detailed information about location, quantity, and capacity requirements. You should generate
dispatch lists daily by work center or line.

Use the Dispatch List program (P31220) to list the work orders that have remaining operations for a
given work center. The work order might not be physically present at the work center. You can
display sequenced orders by start date or requested date. You can also schedule and release work
orders to the work center. Additionally, you can access associated information, such as routing
instructions, parts lists, status hours, and quantities for work orders.

Processing options allow you to define default from and through status and date values for the review.
You can also specify the versions that the system uses when you access other programs, such as the
Parts List Inquiry program (P3121).

The system calculates the remaining machine, labor, and setup run hours and the remaining quantities
of the item to be produced, as follows:

Remaining run machine hours	Standard run machine hours x (quantity remaining / standard quantity)
Remaining run labor hours	Standard run labor hours x (quantity remaining / standard quantity)
Remaining setup time	Standard setup time - hours recorded
Remaining quantity	Total quantity ordered - completed quantity

Prerequisite

❑ Display the actual quantities by entering actual quantities on the Time Entry Revisions form
   (W311221C) and running the Hours and Quantities Update program (R31422).

► **To review dispatch list information**

From the Daily Order Preparation - Discrete menu (G3111), choose Dispatch List.

1. On Work With Operation Dispatch, complete the following field and click Find:

   •   Work Center

2. Choose an order number and click Select.

3. On Operation Dispatch Detail Revisions, review the information that appears and click
    Cancel.

Processing Options for Dispatch List (P31220)

Defaults Tab

These processing options control the default settings for status and days for the inquiry.

From Status

Use this processing option to specify the from status (UDC 31/OS) on the Work with
Operation Dispatch form. The from status specifies the beginning date for the selection of
work order information.

Thru Status

Use this processing option to specify the thru status (UDC 31/OS) on the Work with
Operation Dispatch form. The thru status specifies the end date for the selection of work
order information.

Prior to todays date for the From Date

Use this processing option to specify the from date on the Work with Operation Dispatch

form. You can specify a from date prior to the current date by entering the number of days that the system must subtract from the current date. For example, if the current date is 6/15 and you want the system to use 6/10 as the from date, you enter 5. The system subtracts five days and sets the from date to 6/10. If you leave this processing option blank, the system uses the current date as the from date.

Note: The From Date/Period specifies that the system displays transactions beginning with this date or period. Totals are calculated for the transactions that are displayed.

After todays date for the Thru Date

Use this processing option to specify the thru date on the Work with Operation Dispatch form. You can specify a thru date later than the current date by entering the number of days that the system adds to the current date. For example, if the current date is 6/15 and you want the system to use 6/20 as the thru date, you enter 5. The system adds five days and sets the thru date to 6/20. If you leave this processing option blank, the system uses the current date as the thru date.

Note: The Thru Date/Period specifies that the system displays transactions ending with this date or period. Totals are calculated for the transactions that are displayed.

Versions Tab

These processing options control the versions that the system uses when the following programs are called from the Dispatch List program.

1. Work Order Processing (P48013)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you choose the Work Order Entry program (P48013) from the Row menu on the Work With Operation Dispatch form. If you leave this processing option blank, the system uses version ZJDE0001.

2. Work Order Routing (P3112)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you choose the Work Order Routing program (P3112) from the Row menu on the Work With Operation Dispatch form. If you leave this processing option blank, the system uses version

ZDJE0001.

3. Work Order Parts List (P3111)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you choose the Work Order Parts List program (P3111) from the Row menu of the Work With Operation Dispatch form. If you leave this processing option blank, the system uses version ZDJE0001.

4. Work Order Parts Inquiry (P3121)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you choose the Work Order Parts List Inquiry program (P3121) from the Row menu on the Work With Operation Dispatch form. If you leave this processing option blank, the system uses version ZJDE0001.

5. Operation Dispatch Inquiry (P31220)

Blank = ZJDE0001

Use this processing option to specify the version that the system uses when you choose the Operation Dispatch Inquiry program (P31220) from the Row menu on the Work With Operation Dispatch form. If you leave this processing option blank, the system uses version ZJDE0001.

6. Work Order Quantity (P31121)

Blank = ZJDE0001

7. Work Order Hours (P31122)

Blank = ZJDE0001

Process Tab

This processing option controls whether the remaining quantity includes the scrapped or cancelled quantity.

1. Quantity Calculation

Blank = Remaining Quantity includes quantity scrapped/cancelled

1= Remaining Quantity does not include quantity scrapped/cancelled

Use this processing option to specify whether the system subtracts the quantity scrapped or canceled from the remaining quantity. Valid values are:

Blank

Include the quantity scrapped or canceled in the remaining quantity.

1

Subtract the quantity scrapped or canceled from the remaining quantity.

Reviewing Production History

To solve problems, make decisions, and answer questions, you might need to review the historical information about your work orders or rate schedules. When you review the production history in the Production History program (P31227), you can review information such as date updated and the quantities ordered, shipped, and cancelled for a particular work center.

Caution

For repetitive manufacturing, to have correct data appear on the Production History form, you must not simultaneously process records with the same hour type and operation sequence number.

► **To review production history**

From the Daily Processing - Repetitive menu (G3115), choose Production History.

1. On Work With Production History, complete one, or a combination of any two, of the following fields:

   - Work Center/Line
   - Item Number
   - Order Number/Type

2. Complete the following field and click Find:

- Branch/Plant

3. Review the information.

Processing Options for Production History (P31227)

Defaults
Enter values:
1. Sequence Number - Operations
2. Enter the default # of days to be added to today's date to arrive at Thru date
3. Shift Code

Reviewing Production Line Quantities

For repetitive manufacturing, use the Line Dispatch List program (P3159) to view the planned and remaining quantities for all items that are scheduled for a particular production line.

► **To review production line quantities**

From the Daily Processing - Repetitive menu (G3115), choose Line Dispatch List.

1. On Work With Line Dispatch List, complete the following fields and click Find:

   - Branch/Plant
   - Line/Cell

2. Review the information.

Processing Options for Line Dispatch List (P3159)

Defaults
1. Enter the number of days to add to today's date for the Thru date.
2. Enter the Shift Code. (Optional)
3. Enter the From Status. (Optional)
4. Enter the Thru Status. (Optional)
Process
1. Enter '1' to subtract Quantity Cancelled/Scrapped from the Remaining Quantity. If left blank, the remaining quantity value will include cancelled/scrapped quantity.

Reviewing Production Across Lines

Use the Line Schedule Review program (P3152) to review the schedule of the production lines for the family of items produced. If items are produced on multiple production lines, use this program to review production across lines while staying within the capacity of each line. You can also review the information graphically.

► **To review production across lines**

From the Daily Processing - Repetitive menu (G3115), choose Line Schedule Review.

1. On Line Schedule Review, complete the following fields and click Find:

   - Line/Cell
   - Branch/Plant
   - Date From
   - Thru

2. Review the information.

Processing Options for Line Schedule Review (P3152)

Defaults Tab

These processing options specify default values for the Document Type and Shift fields.

---

1. Document Type (Default is 'SC')

Use this processing option to specify the default document type associated with the schedule quantity detail. Document type is a user defined code (00/DT) that identifies the origin and purpose of the document. Enter the document type to use as the default value or choose it from the Select User Define Code form. If you leave this field blank, the system uses SC.

2. Shift (Optional)

Use this processing option to specify the default shift code associated with the schedule quantity detail. Shift code is a user defined code (00/SH) that identifies daily work shifts. Enter the shift code to use as the default value or choose it from the Select User Define Code form.

Versions Tab

This processing option specifies the version of the Rate Revisions program (P3109) that the Line Schedule Review program uses.

---

1. Rate Revisions (P3109)

Use this processing option to specify which version the system uses when you choose the row exit to the Enter/Change Rate Schedule program (P3109) from the Line Schedule Review form. If you leave this processing option blank, the system uses the ZJDE0001 version of the Enter/Change Rate Schedule program.

Versions control how the Enter/Change Rate Schedule program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

Reviewing Work Center Loads

Use the Work Center Schedule Review program (P31224) to review the rate schedule load and the work order load for a work center. You can review a work center load for a day, a week, or a month. You can also enter a specific date range to review the load for the work center. If you need to adjust the scheduled load at the work center, you can access several different forms to make adjustments. Use a processing option to specify whether to include loads that are generated by a work order before or after loads that are generated by a rate schedule.

► **To review work center loads**

From the Daily Order Preparation - Discrete menu (G3111), choose Work Center Schedule Review.

1. On Work Center Schedule Review, complete the following fields and click Find:

   - Branch/Plant
   - Work Center
   - Order Type
   - Effective From
   - Thru

2. Review the information in the detail area.

Processing Options for Work Center Schedule Review (P31224)

Defaults Tab

This processing option controls the default document type for the records that appear on the form.

---

1. Document Type

   A specific document type
   Blank = No default

Use this processing option to specify the default document type associated with the work order or rate schedule. Document type is a user defined code (00\DT) that identifies the origin and purpose of the document. Enter the document type to use as a default value or choose it from the Select User Define Code form.

Disp Options Tab

This processing option controls the time frames for which work center load information appears on the form.

---

1. Subfile Dates

   1 = Monthly
   2 = Weekly
   3 = Daily

Use this processing option to specify how the system calculates and displays the loads. Valid values are:

1	The system calculates and displays monthly loads.
2	The system calculates and displays weekly loads.
3	The system calculates and displays daily loads.

Blank The system calculates and displays daily loads.

WO Processing Tab

These processing options control the work center information that appears on the form.

1. Include Work Order Generated Loads

  1 = Before Rate loads
  2 = After Rate loads
  Blank = No Work Order loads

Use this processing option to specify whether the system includes work order loads before rate schedules, after rate schedules, or not at all. Valid values are:

1	The system generates work order loads before rate schedules.
2	The system generates work order loads after rate schedules.

Blank The system does not recognize work order loads.

2. From Operation Status

  Include as an active operation
  Blank = No specific status to include

Use this processing option to specify the status the system uses for the work orders or rate schedules as the routing steps are completed. Operation status is a user defined code (31/OS) that describes the status of a work order or rate schedule. Enter the operation status to use as the default value or choose it from the Select User Define Code form.

3. To Operation Status

Include as an active operation
Blank = No specific status to include

Use this processing option to specify the operation status the system uses for the work orders or rate schedules as the routing steps are completed. Operation status is a user defined code (31/OS) that describes the status of a work order or rate schedule. Enter the operation status to use as the default value or choose it from the Select User Define Code form.

Versions Tab

This processing option controls the version that the system uses when you call the following program:

1. Rate Revisions (P3109)

Use this processing option to specify the version the system uses when you choose the row exit to the Enter/Change Rate Schedule program (P3109) from the Work Center Schedule Review program (P31224). If you leave this field blank,the system uses the ZJDE0001 version of the Enter/Change Rate Schedule program.

Versions control how the Enter/Change Rate Schedule program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

Reviewing Process Orders

For process manufacturing, use the Process Order Inquiry program (P31240) to display the following information for a process work order:

- Each operation of the process
- The ingredients lists
- A list of the coproducts and by-products
- The existing intermediates of a work order, by operation

From this program, you can perform the following tasks:

- Access the Enter/Change Order program (P48013) and make changes, as necessary
- Display the intermediate for a specific operation, using the unit of measure defined for the intermediate instead of the primary unit of measure
- Display intermediates for all operations

► **To review process orders**

From the Daily Order Preparation - Process menu (G3113), choose Process Order Inquiry.

1. On Work with Process Orders, complete the following field and click Find:

   - Order Number/Type

2. Choose a record and then choose Ingreds/Co/By-Prod from the Row menu.

3. On Work with Ingredients and Co/By-Products, review the following fields:
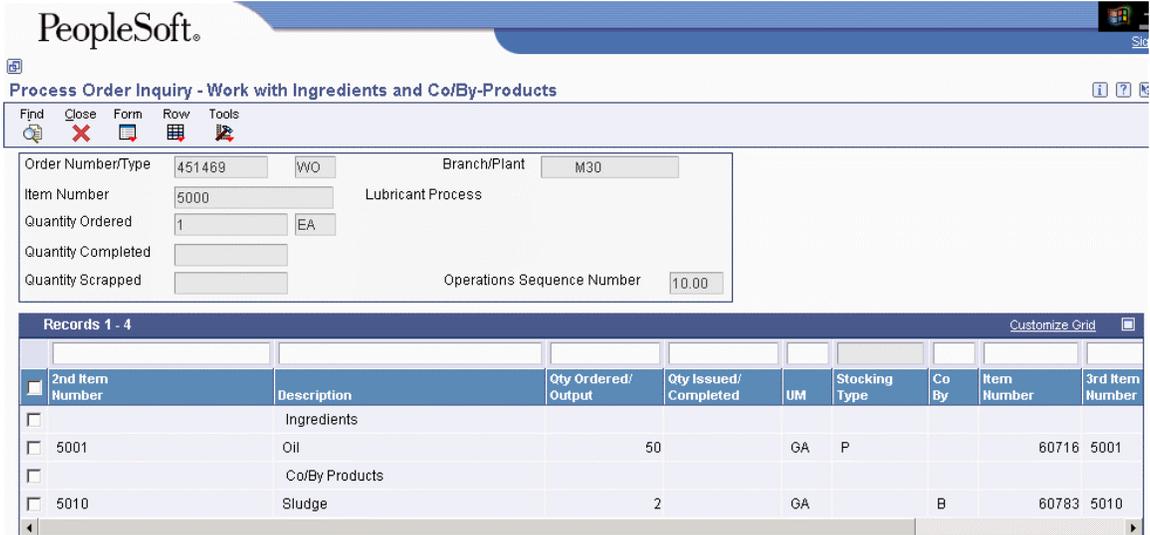
   - Qty Ordered/ Output
   - Qty Issued/ Completed
   - Co By

Working with Supply and Demand Information

Information about the supply and demand for an item helps you accurately plan for future needs. You can monitor information about how many items are on demand, available in supply, and available to promise (ATP). For example, members of your organization can do the following:

- Personnel in sales order entry can provide customers with an expected order ship date.

- Purchase agents can evaluate future orders and stocking needs.

- Warehouse personnel can plan warehouse resource around receipts and order picking.

You can access supply and demand information from the Shop Floor Management, Inventory Management, and Sales Order Management systems. If you are using Supply Chain Management in conjunction with the Inventory Management system, you should set up the supply and demand inclusion rules.

Reviewing Supply and Demand Information

Use the Supply/Demand Inquiry program (P4021) to review demand, supply, and available quantities for a specific item. You can also access the following programs to confirm detail information:

- Manufacturing Scheduling Workbench (P31225)

- Parts Availability (P30200)

- MRP/MPS Detail Message Revisions (P3411)

- Time Series (P3413)

- Pegging Inquiry (P3412)

- Item Availability (P41202)

- Customer Service Inquiry (P4210)

- Item Branch/Plant (P41026)

The demand quantities are shown by date and can include safety stock, quantities on sales orders, work order parts lists, planned order demand for lower levels, and interplant and forecasted demand.

The supply quantities are shown by date and can include on-hand inventory and quantities on purchase orders, manufacturing work orders, planned orders, and rate schedules. Supply quantities shown without dates or order information represent current availability by branch/plant location or lot.

► **To review supply and demand information**

From the Daily Order Preparation - Discrete menu (G3111), choose Supply/Demand Inquiry.

1. On Work With Supply and Demand, complete the following fields and click Find:

- Branch/Plant
- Item Number

2. Review the information that appears and click Close.

Processing Options for Supply/Demand Inquiry (P4021)

Process Tab

These processing options control processing for the Supply/Demand Inquiry program, such as which quantities and document types, as well as forecast and planning data, are included in the inquiry.

---

1. Deduct Safety Stock From Available Quantity

Blank = Do Not Deduct

1   = Deduct Safety Stock

Use this processing option to specify whether the system displays the safety stock line and decreases the safety stock from the available quantity. Valid values are:

Blank The system does not deduct safety stock.

1   The system deducts safety stock.

2. Receipt Routing Quantities Considered As On Hand

Blank = Do Not Consider

1   = Consider As On Hand

3. Supply/Demand Inclusion Rules

Use this processing option to specify the supply and demand inclusion rules version for the system to use. These rules define the order type, line type and line status. Inclusion rule version is a user defined code (40/RV) that identifies the version to use for processing. Enter an inclusion rule to use as the default value or choose it from the Select User Define Code form.

4. Subtract Expired Lot Quantities

Blank = Do Not Subtract
1   = Subtract Expired Lots

Use this processing option to specify whether the system deducts the expired lot quantities from the available quantity. Valid values are:

  Blank The system does not reduce the available quantity.

1   The system reduces the available quantity.

This processing option does not work with available to promise lines. If you choose value 1 in this processing option, you must set the Available to Promise Line Flag processing option, under the Process 1 Tab, to either blank or 2.

5. Enable Engineer to Order (ETO)

Blank = Do Not Enable ETO
1   = Enable ETO Functionality

Use this processing option to specify whether the system enables Engineer-to-Order (ETO)

functionality. Valid values are:

Blank

Do not enable ETO functionality.

1

Enable ETO functionality.

6. Include Past Due Supply In Quantity Available

Blank = Do Not Include
1   = Include Past Due Supply

Use this processing option to specify if past due quantities are considered while calculating available quantity. Valid values are:

Blank

Do not include past due quantities.

1

Include past due quantities.

7. Rate Based Schedule Type

Blank = Do Not Include Rate Based Items

Use this processing option to specify the rate-based schedule type for the system to display. Rate-based schedule type is a user defined code (31/ST)

that identifies the schedule type. Enter the type to use as the default value or choose it from the Select User Define Code form. If you leave this field blank, the system does not display any rate-based schedules.

8. Include MPS/MRP/DRP Planned Orders

Blank = Do Not Include
1   = Include Planned Orders

Use this processing option to specify whether the system displays planned orders from MPS/MRP/DRP generations. Valid values are:

Blank The system does not display planned orders.

1   The system displays planned orders.

9. Forecast Types (5 Types Maximum)

Use this processing option to specify which forecast types, up to five, that the system includes in the inquiry. If you leave this field blank, the system does not include any forecast records. Enter multiple forecasts as follows: To enter 01, 02, and BF, type 0102BF.

10. Days From Today To Include Forecast

Blank = Include From Today

Use this processing option to specify the number of days (+ or -) from the system date that you want the system to include forecast records. If you leave this field blank, the system uses the system date.

11. Exclude Bulk Items

Blank = Do Not Exclude
1   = Exclude Bulk Items

Use this processing option to specify whether the system displays bulk stocking type records. Valid values are:

Blank The system displays bulk stocking type records.

1   The system does not display bulk stocking type records.

12. Include Past Due Rates as a supply

Blank = do not include
1   = include

Use this processing option to specify whether the system considers open quantities from past due rate schedules as supply. When you enter 1, the system includes past due rate orders in the display. Valid values are:

Blank

Do not use open quantities from past due rate orders as supply.

1

Use open quantities from past due rate orders as a supply.

13. Forecast Start Date

Blank = System Date
1   = Start Date Of Current Forecast Period

Use this processing option to determine the Start Date. Valid values are:

Blank

Use the System Date.

1

Use the Start Date of the current forecast period.

Note: If you enter a 1, the Enable Engineer to Order processing option must be blank.

14. Lot Hold Codes (up to 5)

Blank = include no held lots in calculation of on-hand inventory
*   = include all held lots in calculation of on-hand inventory

Use this processing option to specify the lots to be included in the calculation of on-hand inventory. You can enter a maximum of 5 lot hold codes (41/L).

blank   include no held lots in calculation of on-hand inventory

*   include all held lots in calculation of on-hand inventory

Display Tab

These processing options control how certain information appears on the Work With Supply and Demand form. For example, a processing option controls whether quantities appear after they are converted to standard potency.

1. Convert Quantities To Standard Potency

Blank = Do Not Convert
1   = Convert To Standard Potency

Use this processing option to specify whether the system converts quantities to the standard potency. Valid values are:

  Blank The system does not convert the quantities.

  1   The system converts the quantities.

2. Display ATP Line

Blank = Do Not Display
1   = Display ATP Line
2   = Display CATP Line

Use this processing option to specify whether the system displays an available to promise line, a cumulative available to promise line, or neither. Valid values are:

  Blank The system does not display either line.

  1   The system displays the available to promise line.

  2   The system displays the cumulative available to promise line.

If you choose to display the available to promise line (value 1) in this processing option,

you cannot use the Display 3 Tab, Reduce Expired Lot Quantities processing option (above).

3. Summarize All In Receipt Routing Steps

Blank = Do Not Summarize
1   = Summarize

Use this processing option to specify whether the system summarizes all quantities for the In Receipt routing steps into one line. Valid values are:

  Blank The system does not summarize.

  1   The system summarizes the In Receipt routing steps.

4. Summarize Item Balance Quantity Records

Blank = Do Not Summarize
1   = Summarize

Use this processing option to specify whether the system summarizes all the quantities in the item location records into one line. Valid values are:

  Blank The system does not summarize.

  1   The system summarizes all the quantities in the item location records.

5. Display Data In Window Mode

Blank = Do Not Display
1   = Display In Window Mode

Use this processing option to specify whether the system displays the Supply &Demand Inquiry program (P4021) in the window format if called from another program. Valid values are:

  Blank The system displays the program in the full form format.

  1   The system displays the program in the window format.

Versions Tab

These processing options control the versions that the system uses when you call the following programs:

1. Purchase Order Entry (P4310)

Use this processing option to specify the version of the Purchase Order Entry program (P4311) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Purchase Order Entry program.

Versions control how the Purchase Order Entry program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

2. Purchase Order Inquiry (P4310)

Use this processing option to specify the version of the Purchase Order Inquiry program (P430301) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Purchase Order Inquiry program.

Versions control how the Purchase Order Inquiry program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

3. Sales Order Entry (P4210)

Use this processing option to specify the version of the Sales Order Entry program (P4211) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Sales Order Entry program.

Versions control how the Sales Order Entry program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

4. Sales Order Inquiry (P4210)

Use this processing option to specify the version of the Sales Order Inquiry program (P42045) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Sales Order Inquiry program.

Versions control how the Sales Order Inquiry program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

5. Scheduling Work Bench (P31225)

Use this processing option to specify the version of the Scheduling Workbench program (P31225) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Scheduling Workbench program.

Versions control how the Scheduling Workbench program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

6. MPS/MRP/DRP Pegging Inquiry (P3412)

Use this processing option to specify the version of the MPS/MRP/DRP Pegging Inquiry program (P3412) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Pegging Inquiry program.

Versions control how the Pegging Inquiry program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

7. MPS/MRP/DRP Time Series (P3413)

Use this processing option to specify the version of the MPS Time Series program (P3413) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the MPS Time Series program.

Versions control how the MPS Time Series program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

8. MPS/MRP/DRP Msg Detail (P3411)

Use this processing option to specify the version of the MPS/MRP Detail Message Revisions program (P3411) that the system uses when call from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the MPS/MRP Detail Message Revisions program.

Versions control how the MPS/MRP Detail Message Revisions program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

9. Bill of Material Inquiry (P30200)

Use this processing option to specify the version of the Bill of Material Inquiry program (P30200) program that the system uses when called from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Bill of Material Inquiry program.

Versions control how the Bill of Material Inquiry program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

10. Item Branch (P41026)

Use this processing option to specify the version of the Item Branch program (P41026) that the system uses when you access the program from row and form exits on the Work With Supply and Demand form. If you leave this option blank, the system uses the ZJDE0001 version of the Item Branch program. Versions control how the Item Branch program displays information.

11. Mfg WO Processing (P48013)

Use this processing option to specify the version of the Manufacturing Work Order Processing program (P48013) program that the system uses when called from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Manufacturing Work Order Processing program.

Versions control how the Manufacturing Work Order Processing program displays

information. Therefore, you might need to set the processing options to specific versions to meet your needs.

12. Enter/Change Rate Schedule (P3109)

Use this processing option to specify the version of the Enter/Change Rate Schedule program (P3109) program that the system uses when called from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Enter/Change Rate Schedule program.

Versions control how the Enter/Change Rate Schedule program displays information. Therefore, you might need to set the processing options to specific versions to meet your needs.

13. Item Availability (P41202)

Use this processing option to specify the version of the Item Availability program (P41202) that the system uses when called from row and form exits from the Work With Supply and Demand form. If you leave this field blank, the system uses the ZJDE0001 version of the Item Availability program.

Versions control how the Item Availability program displays information.

Therefore, you might need to set the processing options to specific versions to meet your needs.

Printing Supply and Demand Information

From the Periodic Functions - Discrete menu (G3121), choose Supply/Demand.

The Supply and Demand report (R4051) shows the supply, demand, and available quantities for an item. This report can include quantities of materials in the following categories:

- On-hand inventory
- Safety stock
- Sales orders
- Purchase orders
- Work orders
- MPS/MRP planned orders
- Forecasts
- Rate schedules

You can set the processing options to customize your report in various ways; for example, you can decide which quantities to include and what date range to consider for the report.

Working with Bills of Material

After you process work orders or rate schedules, you can compare bills of material or parts lists either online by using different versions of the Bill of Material Comparison program (P30204), or by reviewing reports that provide different views of the components that are listed on the bill of material. Use the comparisons to show the differences that exist between the parts lists or bill of material for two different orders or items.

Comparing Bills of Material and Parts Lists

Use the Bill of Material Comparison program (P30204) to compare bills of material or parts lists. The system displays all the components of both items or only those components that are different between the two, depending on your processing option selections. You can change the display from the View menu on the Work With Comparisons form. You use the processing options to define whether the program allows you to compare bills of material or parts lists. You can access different versions of this program that are defined by these processing option settings.

► **To compare two parts lists**

From the Daily Order Preparation - Discrete menu (G3111), choose Parts List Comparison.

1. On the Work With Comparisons form, choose the PL to PL tab, and then complete the following field for the first parts list:

   - Order Number

2. Complete the following optional fields for the first parts list:

- Work Center
- Dispatch Group

3. Complete the following field for the second parts list and click Find:

- Order Number

4. On Display Comparisons, review the information and click Close.

► **To compare a bill of material to a parts list**

From the Daily Order Preparation - Discrete menu (G3111), choose Parts List BOM Comparison.

1. On Work With Comparisons, choose the PL to BOM tab and complete the following field for the parts list:

- Order Number

2. Complete the following fields for the bill of material click Find:

- Item Number
- Branch/Plant
- Bill Type
- As of Date

3. On Display Comparisons, review the information and click Close.

Processing Options for Bill of Material Comparison (P30204)

Defaults Tab

This processing option controls the default value for the Bill Type fields.

1. Bill of Material Type

Use this processing option to specify the type of bill of material that the system uses as the default value in the Bill Type fields. Bill of material type is a user defined code (40/TB) that designates the type of bill of material. Enter the bill of material type to use or choose it from the Select User Define Code form. If you leave this processing option blank, the system uses M (manufacturing bill of material).

Display Tab

These processing options control the comparison level and the view mode for the review.

1. Single Level or Multilevel Comparison

Use this processing option to specify whether the system displays the information in a single level or multilevel comparison. The single level comparison shows the item's first-level components; the multilevel comparison shows the subassemblies and components for an item. Valid values are:

1   The system displays a single level comparison.

2   The system displays a multilevel comparison.

If you leave this processing option blank, the system displays a single level comparison.

2. View Mode

Use this processing option to specify the mode in which the system displays the information. The bill of material mode compares two bills of material, the parts list mode compares two parts lists, and the parts list to bill of material mode compares a parts list to a bill of material. Valid values are:

1 The system uses the bill of material mode.

2 The system uses the parts list mode.

3 The system uses the parts list to bill of material mode.

If you leave this processing option blank, the system uses the bill of material mode.

Process Tab

These processing options control the information that is included in the comparison.

1. Include Different Records

Use this processing option to specify whether the system displays all components or only those components that are different between the two bills of material or parts lists. Valid values are:

D The system displays the component that are different between the two bills of material or parts lists.

A The system displays all the components of the two bills of material or parts lists.

If you leave this processing option blank, the system displays the components that are different between the two bills of material or parts lists.

2. Work Center or Item Summary

Use this processing option to specify whether the system sorts the information by work center or by item number. Valid values are:

1 The system sorts the information by work center.

2 The system sorts the information by item number.

If you leave this processing option blank, the system sorts the information by item number.

3. Subassemblies

Use this processing option to specify whether the system displays the subassemblies. A subassembly is an assembly that is used at a higher level to make up another assembly. Valid values are:

Blank The system excludes subassemblies from the inquiry.

1 The system includes subassemblies in the inquiry.

4. Phantom Items

Use this processing option to specify whether the system explodes the phantom to the next level and omits the display of the phantom. A phantom is normally defined for engineering or manufacturing purposes. Phantoms allow common parts, that may or may not be assembled, to be grouped in a bill of material structure. When viewing the bill of material, you may want to display only the subassemblies and raw material. Valid values are:

Blank The system omits the phantom items from the inquiry and displays only the subassemblies and raw material.

1 The system includes phantom items in the inquiry.

Printing Bill of Material Information

You can generate several reports to review bill of material information. These reports retrieve data from the Bill of Material Master File table (F3002). You access these report from the Periodic PDM Discrete menu (G3021). They allow you to display different views of the bill of material. The following reports are available:

Single Level Bill of Material Report (R30460)   Displays the first-level components for an item.

Multi Level Bill of Material Report (R30460)   Displays all the levels of an item's components and allows you to review all of the subassemblies.

Where Used Item Report (R30420)   Lists the parent assemblies that contain a specific component and shows all the subassemblies of the components for an item, as well as the indented level of these subassemblies.

You can use processing options to define the scope for each report.

Caution

PeopleSoft recommends that you do not change the first two data sequences from the settings in the demonstration version of these reports. If you change the data sequencing, you might obtain unexpected or inaccurate results.

Processing Options for Bill of Material Print (R30460)

Display Tab

These processing options control the display format, display sequence, and other parameters for the report.

1. Inquiry Mode

Use this processing option to specify whether the system displays the information in single level or multilevel format. The single level format shows the item's first-level components, the multilevel format shows the subassemblies and components for an item, and the multilevel indented format shows the subassemblies indented. Valid values are:

1   The system displays the single level format.

2   The system displays the multilevel format.

3   The system displays the multilevel indented format.

If you leave this processing option blank, the system displays the multilevel indented format.

2. As of Date

Use this processing option to specify the "as of" date that the system uses for the bill of material. The "as of" date is the date that the system uses for effectivity checking. Enter a specific date to display bills of material that are effective on or after that date. You can enter any future or past date as the default value or choose it from the Calendar. If you leave this processing option blank, the system uses the current date.

3. Type Bill of Material

Use this processing option to specify the type of bill of material that the system uses as the default value. Bill of material type is a user defined code (40/TB) that designates the type of bill of material. Enter the bill of material type to use or choose it from the Select User Define Code form. If you leave this processing option blank, the system uses M (manufacturing bill of material).

4. Display Sequence

Use this processing option to specify whether the system sequences the information by component line number or by operation sequence number. The component line number indicates the sequence of components on a bill of material. The operation sequence number indicates the number that designates the routing step in the fabrication or assembly process that requires a specified component part. Valid values are:

1   The system sequences by component line number.

2   The system sequences by operation sequence number.

If you leave this processing option blank, the system sequences by component line number.

Print Tab

These processing options control the types of information that are included on the report.

1. Detail Line

Use this processing option to specify whether the system prints a second line of detail for each item. This second line of detail includes data such as leadtime level and bill revision

level. Valid values are:

   Blank The system prints only one line of detail for each item.

   1   The system prints a second line of detail for each item.

2. Component Locators

Use this processing option to specify whether the system prints the component locations. The component location is the specific location of a component in the assembly of an item, for example, the location of a part on a circuit board. Valid values are:

   Blank The system does not print component locations.

   1   The system prints component locations.

3. Parent Item Detail Line

Use this processing option to specify whether the system prints a line of detail for the parent item. This detail line includes data such as the drawing number. Valid values are:

   Blank The system does not print a line of detail for the parent item.

   1   The system prints a line of detail for the parent item.

Process Tab

These processing options control the types of item quantities that are included on the report.

1. Phantom Items

Use this processing option to specify whether the system explodes the phantoms to the next level and omits the display of the phantom. A phantom is normally defined for engineering or manufacturing purposes. Phantoms allow common parts, that may or may not be assembled, to be grouped in a bill of material structure. When viewing the bill of material, you may want to display only the subassemblies and raw material. Valid values are:

Blank The system omits the phantom items from the inquiry and displays only the subassemblies and raw material.

1   The system includes phantom items in the inquiry.

2. Process Items

Use this processing option to specify whether the system displays process items. Process items include the process, co-products, by-products, and ingredients. A discrete bill may contain a component that is produced from a process. You use this processing option when you combine discrete and process manufacturing to display a complete structure of the requirements. Valid values are:

Blank The system excludes process items.

1   The system includes process items.

3. Subassemblies

Use this processing option to specify whether the system displays subassemblies. A subassembly is an assembly that is used at a higher level to make up another assembly. Valid values are:

Blank The system excludes subassemblies.

1   The system includes subassemblies.

4. Text Lines

Use this processing option to specify whether the system displays text lines.

Valid values are:

Blank The system excludes text lines.

1   The system includes text lines.

5. Consolidate Component Items

Use this processing option to specify whether the system consolidates duplicate components. The same component may be listed in the bill of material several times, either on different subassemblies or on the same subassembly at different operations. When you use this processing option with the Subassemblies processing option, the system consolidates components at the subassembly level or for all levels of the bill of material. When viewing the consolidated components, the quantity required is accumulated for duplicate components. Valid values are:

   Blank The system displays individual occurrences of duplicate components.

   1   The system consolidates duplicate components.

6. Purchased Item

Use this processing option to specify whether the system explodes to the next level of purchased items in the bill of material report. Valid values are:

   Blank The system excludes lower-level purchased items.

   1   The system includes lower-level purchased items.

7. Shrinkage

Use this processing option to specify whether the system adjusts the requested quantity for shrinkage. Shrinkage is the planned loss of a parent item caused by factors such as breakage, theft, deterioration, and evaporation. Valid values are:

   Blank The system does not adjust the requested quantity for shrinkage.

   1   The system adjusts the requested quantity for shrinkage.

8. Scrap

Use this processing option to specify whether the system adjusts the extended quantity for scrap. Scrap is unusable material that results from the production process. It is material outside of specifications and of such characteristics that rework is impractical. Valid values are:

   Blank The system does not adjust the extended quantity for scrap.

1   The system adjusts the extended quantity for scrap.

9. Yield

Use this processing option to specify whether the system adjusts the extended quantity for yield. Yield is the ratio of usable output from a process to its input. Valid values are:

Blank The system does not adjust the extended quantity for yield.

1   The system adjusts the extended quantity for yield.

10. Requested Quantity

Use this processing option to specify the required quantity of the parent item in the bill of material inquiry.

11. Unit of Measure as Input

Use this processing option to specify the unit of measure of the parent item in which the requested quantity is entered.

Processing Options for Material Where Used (R30420)

Format Option
1. Select the Mode or Style of report to be created: 1 = Single Level; 2 = Multi- Level; 3=Multi-Level Indented
Mode of Report
2. Enter a '1' to print a second line of detail on the report. If left blank, only one line of detail will be printed.
Print Line of Detail

Interoperability

To fully cover the information requirements of an enterprise, companies sometimes use products from different software and hardware providers. Interoperability between different products is important to successfully implementing the enterprise solution. Full interoperability between different systems results in a flow of data between the systems that is seamless to the user. The interoperability function provides an interface that facilitates exchanging transactions, both inbound and outbound, with external systems.

External systems send data to the interface tables, either using an external program or using flat files and the Inbound Flat File Conversion program (R47002C). The sending party is responsible for conforming to format and other requirements for the interface tables. You run a transaction process (a batch program) that validates the data, updates valid data to the EnterpriseOne application tables, and sends action messages to the Employee Work Center about any invalid data.

You use an inquiry function to interactively review the invalid data for correctness, and then run the transaction process again. You repeat this process as often as necessary.

You set a processing option to specify the transaction type for the outbound transaction. The system uses the master business function for the type of transaction, creates a copy of the transaction, and places it in the interface table from which external systems can access it.

You use the purge function to remove obsolete and unnecessary data from interface tables. Your system is more efficient when you keep these tables as small as possible.

Interoperability Programs

Shop Floor Management provides the following interoperability programs:

Inbound Conversion Programs (R47002C)

- Inbound Backflush Flat File Conversion

- Inbound Completion Flat File Conversion

- Inbound Issues Flat File Conversion

- Inbound Work Order Flat File Conversion

Inbound Transaction Programs

- Inbound Hours and Quantities Processor (R31122Z1I)

- Inbound Inventory Issues Processor (R31113Z1I)

- Inbound Completion Processor (R31114Z1I)

- Inbound Super Backflush Processor (R31123Z1I)

Inbound Inquiry Programs

- Inbound Hours and Quantity Inquiry (P31122Z1)

- Inbound Inventory Issues Inquiry (P3111Z1)

- Inbound Work Order Inquiry (P4801Z1)

- Inbound Super Backflush Inquiry (P3112Z1)

Purge Programs

- Inbound Hours and Quantity Purge (R31122Z1)

- Inbound Inventory Issues Purge (R3111Z1P)

- Inbound Completion Purge (R4801Z1)

- Inbound Super Backflush Purge (R3112Z1P)

- Outbound Work Order Purge (R4801Z1P)

Outbound Extraction Programs

- Outbound Work Order Extraction (R4801Z1X)

- Outbound Operation Status Extraction (R4801Z2X)

- Item Balance Extraction (R31SYN02)

Converting Flat Files to Interface Tables

You can use a variety of methods to send data from external systems to the interoperability interface tables. One method is to enter the data in a flat file. If you use this method, the system converts the flat file to the interface table.

You can set a processing option to start the transaction process when the conversion completes successfully.

Prerequisites

❑ Ensure that the flat file is a comma-delimited ASCII text file that is stored on the hard drive of your personal computer.

❑ Ensure that the data conforms to the specified format. See *Converting Data from Flat Files into EDI Interface Tables* in the *Data Interface for Electronic Data Interchange Guide* for information about formatting requirements.

Setting Up the Flat File Cross-Reference

Before you can convert a flat file, you must provide a cross-reference from the flat file fields to the interface table fields. When you exchange data between this system and an external system, you use flat file cross-reference information for the following conditions:

- For inbound transactions for which the external system cannot write data to the interface tables in the required format for this system. In this case, the external system can write the data to a specific flat file for each transaction and record type.

- For outbound transactions for which this system cannot write data to the interface tables in the format that is required by the external system. In this case, this system can write the data to a specific flat file for each transaction and record type.

See Also

❑ *Converting Data from Flat Files into EDI Interface Tables* in the *Data Interface for Electronic Data Interchange Guide* for more information about this process. The process for setting up flat file cross-references for Interoperability is identical to that for EDI interface tables.

Prerequisite

❑ On the appropriate drives on your computer or network, set up the folders for the flat files.

► To set up the flat file cross-reference

Use one of the following navigations:

From the Forecast Interoperability menu (G36301), choose Flat File Cross-Reference.

From the Sales Interoperability menu (G42A313), choose Flat File Cross Reference.

From the Inventory Interoperability menu (G41313), choose Flat File Cross-Reference.

From the Product Data Interoperability menu (G30311), choose Flat File Cross-Reference.

From the Purchasing Interoperability menu (G43A313), choose Flat File Cross-Reference.

From the Shop Floor Management Interoperability menu (G31311), choose Flat File Cross-Reference.

1. On Work With Flat File Cross-Reference, click Add.

2. On Flat File Cross-Reference, to specify the transaction type, such as receipts, complete the following field:

   - Transaction

3. To indicate whether this transaction type is Inbound (1), or Outbound (2), complete the following field:

   - Direction Indicator

4. To indicate the information source, complete the following field:

   - Record Type

5. Enter the specific file name in the following field:

- File Name

The file name refers to the application table from which the system exchanges information, as defined by the record type.

6. Click OK.

Running the Conversion Program

Use one of the following navigations:

From the Forecast Interoperability menu (G36301), choose Inbound Flat File Conversions

From the Inventory Interoperability menu (G41313), choose Inbound Flat File Conversion.

From the Product Data Interoperability menu (G30311), choose the applicable Inbound Flat File Conversion.

From the Purchasing Interoperability menu (G43A313), choose Inbound Flat File Conversion.

From the Shop Floor Management Interoperability menu (G31311), choose the applicable Inbound XX Flat File Conversion, where XX is the process that the conversion completes, such as Inbound Completion Flat File Conversion.

You use the Inbound Flat File Conversion program (R47002C) to import flat files into PeopleSoft interface tables. You can create a separate version of the Inbound Flat File Conversion program for each interface table. This program recognizes both the flat file from which it reads and the record types (UDC 00/RD) within the flat file. Each flat file contains records of differing lengths, based on the interface table record to which they correspond. The Inbound Flat File Conversion program uses the Flat File Cross-Reference Table (F47002) to convert the flat file into the interface tables. Table F47002 indicates to the conversion program which flat file to read from, based on the transaction type that you are receiving.

The conversion program reads each record in the flat file and maps the record data into each field of the interface tables, based on the text qualifiers and field delimiters that are specified in the flat file.

The conversion program inserts the field data as one complete record in the interface table. If the conversion program encounters an error while converting data, it withholds the data in error and continues processing the conversion. If the data is successfully converted, the system automatically starts the transaction process for that interface table, provided that you set the processing options in the conversion program to do so.

See Also

❑ *Receiving Transactions from External Systems* in the *Inventory Management Guide* for information about the transaction process programs

Processing Options for Inbound Flat File Conversion (R47002C)

Transaction
1. Enter the transaction to process.
Separators
1. Enter the field delimiter.
2. Enter the text qualifier.
Process
1. Enter the inbound processor to run after successful completion of the conversion.
2. Enter the version for the inbound processor. If left blank, XJDE0001 will be used.

Receiving Transactions from External Systems

From the Shop Floor Management Interoperability menu (G31311), choose one of the following:

Inbound Hours and Quantity Processor

Inbound Inventory Issues Processor

Inbound Completion Processor

Inbound Super Backflush Processor

When an external system sends inbound transactions, the system stores the data in interface tables. These tables contain unedited transactions. You must then run the appropriate transaction process to edit the transactions and update the application tables. For example, if you receive transactions in the Work Order Time Transactions Unedited Transaction table (F31122Z1), you run the Inbound Hours and Quantities Inquiry program (P31122Z1) to update the Work Order Time Transactions table (F31122).

Note

When you run the Inbound Flat File Conversion program (R47002C) and it completes successfully, the system automatically starts the transaction process, if specified in the processing option for the conversion.

To be received in the interface tables, data from an external system must conform to the minimum field requirements that are specified for the interface table.

The transaction process performs the following steps:

- Validates the data in the interface table (for example, F31122Z1) to ensure that the data is correct and conforms to the format that is defined for the Shop Floor Management system

- Updates the associated application table (for example, F31122) with validated data

- Produces a report that lists invalid transactions and sends an action message for each invalid transaction to the Employee Work Center program (P012501)

- Marks in the interface tables those transactions that are successfully updated to the application tables

If the report indicates errors, access the Employee Work Center program from the Workflow Management menu (G02) and review the messages in the message center. Use the associated inquiry function to review and revise the transactions and rerun the transaction process.

Before you run any of the inbound transaction programs, specify the appropriate values for processing in the processing options.

Processing Options for Inbound Completion Processor (R31114Z1I)

Versions
1. Enter the version of Inventory Completions (P31114). If left blank ZJDE0001 wil be used.
Process
1. Enter '1' to print only the records with errors

Processing Options for Inbound Super Backflush Processor (R31123Z1I)

Data Edits
Enter the Version of Work Order Super Backflush (P31123). If left blank ZJDE0001 will be used.
Printing
1. Enter '1' to print unsuccessfully processed records only. If left blank, all records will be printed.

Processing Options for Inbound Hours and Quantity Processor (R31122Z1I)

Versions
1. Enter the version for P311221 Hours and Quantities to be called. If left blank ZJDE0001 will be used
Printing
1. Enter '1' to print unsuccessfully processed records only. If left blank, all records will be printed.

Processing Options for Inbound Inventory Issues Processor (R31113Z1I)

Versions
1. Enter the Version of Work Order Inventory Issues (P31113) to be called. If left blank "ZJDE0001' will be used.

Reviewing and Revising Inbound Transactions

Running one of the transaction processes, such as the Inbound Work Order Inquiry (P4801Z1), often identifies one or more inbound transactions that contain invalid transactions. For example, a work order might have an invalid item number. In that case, the program cannot add that work order to the Work Order Master table (F4801). Instead, the program sends an error message to the Employee Work Center program (P012501), which indicates the transaction number for the transaction in error.

Use the inbound inquiry programs to review and revise inbound transactions, as well as to add, change, or delete transactions that contain errors. Then run the transaction process again. Continue to make corrections and rerun the transaction process until the program runs without errors.

► **To review and revise inbound transactions**

From the Shop Floor Management Interoperability menu (G31311), choose Inbound Hours and Quantity Inquiry.

Note

This task provides an example of typical steps you might perform to review or revise inbound transactions.

1. On Work With Inbound Transaction Records for F31122Z1, complete the following fields and click Find:

   - User ID
   - Batch Number
   - Transaction Number

2. Choose the transaction record you want to review or revise, and click Select.

3. On Transaction Record Revisions for F31122Z1, review and revise as needed, and then click OK.

4. After you correct the errors identified by the Inbound Work Order Inquiry (P4801Z1), run the transaction process again.

5. If the system identifies other errors, repeat steps 1 - 4 until no more transaction errors appear.

See Also

❑ *EDI Document Inquiry and Revision* in the *Data Interface for Electronic Data Interchange Guide* for information about reviewing and revising inbound transactions

Processing Options for Inbound Work Order Inquiry (P4801Z1)

Display
1. Default View Mode. If left blank, default is '1'.
'1' - View Unprocessed Records
'2' - View Records Processed Successfully
'3' - View Records Processed Unsuccessfully
2. Enter the Direction Indicator value. ('1' for Inbound Records, '2' for Outbound Records). If left blank '2' will be used.
3. Enter the value for the screen to be displayed. ('1' for Work Order Revisions, '2' for Completion Revisions). If left blank, '1' will be used.
Defaults
1. Enter the Transaction Type for new Work Order Header Transactions. If left blank, "JDEWO" will be used.
2. Enter the Transaction Type for new Work Order Parts List Transactions. If left blank, "JDEPL" will be used
3. Enter the Transaction Type for new Work Order Routings Transactions. If left blank, "JDERTG" will be used
Process 1
1. Name of Inbound Subsystem UBE to process Inbound transactions.
If left blank, default is 'R31114Z1I'.
2. Version of Inbound UBE. Default is 'XJDE0002'.

Processing Options for Inbound Hours and Quantity Inquiry (P31122Z1)

Display
1. Default View Mode. If left blank, default is '1'.
'1' - View Unprocessed Records. '2' - View Records Processed Successfully. '3' - View Records Processed Unsuccessfully.
2. Enter the Direction Indicator value. ('1' for Inbound Records, '2' for Outbound Records). If left blank, '1' will be used.
Defaults
1. Enter the Transaction Type for new Work Order Header Transactions. If left blank, "JDEHQ" will be used.
Process
1. Name of Inbound Subsystem UBE to call to process Inbound transactions.
If left blank, default is 'R31122Z1I'
2. Version of Inbound UBE to call. Default is 'XJDE0002'.

Processing Options for Inbound Inventory Issues Inquiry (P3111Z1)

Display
1. Default View Mode. If left blank, default is '1'.
'1' - View Unprocessed Records.   '2' - View Records Processed Successfully.   '3' - View Records Processed Unsuccessfully
2. Enter the Direction Indicator value. ('1' for Inbound Records, '2' for Outbound Records). If left blank, '1' will be used.
Defaults
1. Enter the Transaction Type for new Work Order Header Transactions. If left blank, "JDEII" will be used.
Process
1. Name of Inbound Subsystem UBE to call to process Inbound transactions. If left blank, default is 'R31113Z1I'.
2. Version of Inbound UBE to call. Default is 'XJDE0002'.

Processing Options for Inbound Super Backflush Inquiry (P3112Z1)

Display
1. Default View Mode. If left blank, default is '1'.
'1' - View Unprocessed Record. '2' - View Records Processed Successfully. '3' - View Records Processed Unsuccessfully.
Enter the Direction Indicator value. ('1' for Inbound Records, '2' for Outbound Records). If left blank '1' will be used.
Defaults
1. Enter the Transaction Type for new Work Order Header Transactions. If left blank, "JDESBF" will be used.
Process
1. Name of Inbound Subsystem UBE to call to process Inbound transactions. If left blank, default is 'R31123Z1I'.
2. Version of Inbound UBE to call. Default is 'ZJDE0001'.

Sending Transactions to External Systems

You might need to send to another system transactions that you create or change in the Shop Floor Management system. For example, if your organization uses hand-held scanning devices, you can use interoperability transactions to update the database used by the scanning devices.

The default outbound transaction is a copy of a data transaction after you created or changed it (an *after image*). With interoperability, you can also send a copy of each transaction as it was before you changed it (a *before image*). Creating and sending before images requires additional processing time. To control the type of image, you set a processing option in the application programs that create transactions.

You can send transactions to an external system from the following programs in the Shop Floor Management system:

- Enter/Change Order (P48013)
- Enter/Change Rate Schedule (P3109)
- Order Processing (R31410)
- Inventory Issues (P31113)
- Hours and Quantities Update (R31422)
- Work Order Completions (P31114)

To create outbound transactions, specify the appropriate transaction type in the related processing option. The system places a copy of the transaction in the interface table for that type of transaction. For example, when you run the Enter/Change Order program with the interoperability processing option turned on, the system places a copy of updated work order data in the Outbound Work Order Header interface table (F4801Z1). The data is then available for an external system to use.

The system creates the outbound transaction in EDI format. External systems can process the transactions using standard EDI processing, including extraction.

Prerequisite

❑ Define the data export controls for the type of outbound transaction. The system uses data export controls to determine the batch programs or business processes that third parties supply for use in processing transactions. See *Setting Up Data Export Controls* in the *Interoperability Guide*.

Lead Times

Determining lead time is an essential part of any manufacturing or scheduling process. For any product that you purchase or manufacture, you encounter a time lag between when you order or start it, and when you receive or finish it. To account for the lag, you must estimate the extra time (lead time) and allow for it in your planning.

Cumulative lead time is the total amount of time that is required to produce a product. The Shop Floor Management system uses the requested date of the order and calculates the appropriate order start date, based on the methods used to define the level lead time or lead time per unit for the product. Many factors can influence your company's lead time policy, including the following:

- Manufacturing environment (assemble-to-order, make-to-order)
- Fixed or variable quantities
- Serial or overlap operations
- Fixed or variable time
- Number of shifts and operators
- Factoring by efficiency
- Protection

Whether your company uses fixed or variable lead time depends on whether you have consistent work order quantities for a manufactured item. If your work order quantities vary significantly, you use variable lead time. A significant variation is any amount that requires more or less lead time. Items with short lead times can have larger fluctuations than items with long lead times. You specify fixed or variable lead time on the Additional System Information forms in the Item Master program (P4101) and the Item Branch/Plant program (P41026). The system calculates lead times for parent and component items based on this information combined with the work center information and routing instructions that are set up in the Product Data Management system. At any point in your planning and scheduling process, you can change lead time values manually.

The system subtracts fixed lead times directly from the requested date on the work request to calculate the start date of production. Fixed lead time remains the same, regardless of the quantity produced. However, variable lead time adjusts according to the quantity produced.

For any manufactured product, the system calculates the following four types of lead time:

Level lead time	The number of workdays required to complete the product after all items are available.
Manufacturing lead time	The total number of workdays required to complete a product, from its lowest-level components to the final item, assuming that all purchased items are in-house.
Cumulative lead time	The number of workdays required to acquire items and complete a product, from its lowest-level components to the final item. Cumulative lead time is the level lead time for a product plus the longest cumulative lead time of any of its components.

| Per unit lead time | The sum of the run times, as defined by the prime load codes for the work centers, factored by the routing time basis and converted to the lead time per unit. You use this lead time calculation when the Fixed/Variable option in the Item Master and the Item Branch/Plant programs is set to variable lead time. |

The Shop Floor Management system uses the following information to calculate lead times:

- Serial or overlap operations
- Fixed or variable lead time indicator
- Routing labor, setup, queue, move, and machine run hours
- Work center prime load code
- Number of employees or machines per work center
- Hours per work day

Lead Time Concepts

The following table explains important lead time terms and concepts that you need to understand:

Machine hours	The number of machine hours that is required to produce the amount from the time basis code.
Labor hours	The number of labor hours that is required to produce the amount from the time basis code.
Setup hours	The number of hours that is required to prepare machinery to produce a specific item, regardless of quantity.
Move hours	The number of hours that a manufacturing work order is in transit from the completion of one operation to the beginning of the next.
Queue hours	The number of hours that a job waits at a work center before setup or work is performed on it.
Total queue and move hours	The sum of the move hours and the queue hours.
Time basis code	A user defined code (30/TB) that indicates how machine or labor hours are expressed for a product. Time basis codes identify the time basis or rate to be used for machine or labor hours entered for every step in the routing instructions, such as 25 hours per 1000 pieces.
Resource units	The available amount of capacity in a work center for the months in the calendar. As the system calculates the operation start and due dates, it uses the available hours to calculate the operation start dates. You maintain the resource units in the Enter/Change Resource Units program (P3007).

Prime load code   A code that indicates whether a work center is labor-intensive or machine-intensive. The prime load code also indicates whether the system uses the number of employees or the number of machines to determine the daily resource units in the Work Center Resource Units table (F3007). You maintain the prime load codes in the Enter/Change Work Centers program (P3006). For calculating lead times, the following prime load code values are valid:

- L = run labor hours
- M = machine labor hours
- B = run and setup hours
- C = machine and setup hours
- O = Other

Purchased parts   A part bought from a supplier. For any purchased part, you specify the level lead time, which is equal to the cumulative lead time. By default, the manufacturing lead time, lead time per unit, total queue and move hours, and setup times for purchased parts are zero.

Work Order Start Dates

When an item has a fixed lead time, the system uses the item's level lead time value to backschedule the work order start date. For backscheduling, the start of a work order is based on the due date of the order.

For example, suppose that the system generates a planned order with a requested due date of 10/15. The level lead time is three days for this product, so the system calculates the start date by counting back three working days on the shop floor calendar from (but not including) the requested date. The system assigns the order a start date of 10/12.

Fixed Leadtime
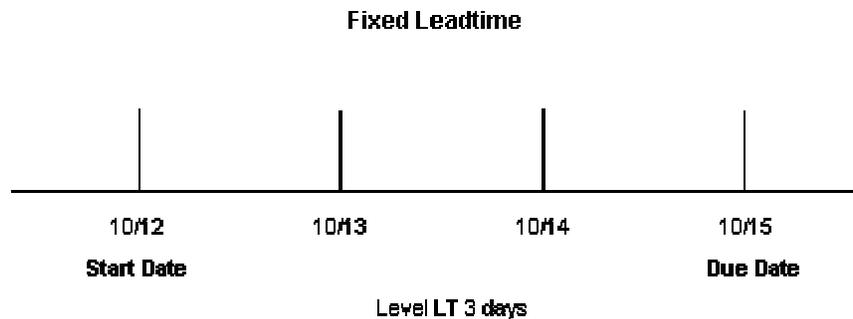
When an item has a variable lead time, the system uses the following calculation to determine the lead time days:

(Lead time per unit x order quantity / TIMB*) + setup + total queue/move = Variable lead time

The system reads the time basis code (TIMB) from the Item Branch File table (F4102).

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The calculation uses the following values:

Due date   10/15

Lead time per unit   32 hours

Order quantity   1000

Setup   1 hour

Total queue/move   9 hours

Work hours per day   8 hours

$$((32 \times 1000 / 10,000) + 1 + 9) / 8 = 2 \text{ days}$$

To determine the start date, the system counts back the lead time days from the due date of planned orders. The system backschedules the due date, 10/15, two days to determine the start date of 10/13.

Note

Lead time per unit does not use crew size to calculate lead time for an item with a labor-based work center. However, lead time per unit does use the number of employees in the work center to calculate lead time.

Operation Start Dates

The system calculates the operation start dates with the average number of hours per operation.

For a fixed lead time, the system calculates the operation hours using the following information:

- Level lead time
- Hours per work day
- Number of employees per machine
- Number of operations

You must schedule the hours per operation according to the resource units within the entire level lead time to ensure that the start date of the first operation is the same as the start date of the work order. When the job moves to a different work center in the same day, the system decreases the resource units available by the percentage of the work day remaining. The system does not use resource units on the due date of the work order. Instead, it assumes that the order was completed at the end of the previous day.

For each operation, the system then schedules this average time into the appropriate work center, based on the available hours from the Work Center Resource Units table (F3007). The system schedules the last operation due date on the day before the work order due date.

The system uses the following formula to calculate average time per operation:

Level lead days x work hours per day* x employees or machine = Average time per operation
number of operation sequences (blank operation sequence codes only)

The work hours per day are retrieved from the Job Shop Manufacturing Constants table (F3009)

The following table shows the values used in this calculation.

Work order due date	05/01/05		
Average time per operation	25 hours		
Operations in the routing instructions	OP40	WC 200-204	due 4/30 start 4/27
	OP30	WC 200-101	due 4/27 start 4/24
	OP20	WC 200-204	due 4/24 start 4/21
	OP10	WC 200-101	due 4/21 start 4/17
WC Resource Units 200-204	8		
WC Resource Units 200-101	8		

To determine variable lead times, the system schedules the actual hours from the work order routing instructions according to the same resource unit rules used for fixed lead time.

The system uses the prime load code to determine the hours to use. The hours are then applied to the Work Center Resource Units table, similar to fixed lead time. The system applies the queue time from the work order routing instructions at the beginning of an operation and the move time at the end of an operation.

Overlapping Operations

To compress lead times, operations can be scheduled to overlap. Overlapping operations occur when two or more operations in a routing instruction run at the same time. The percentage of overlap is the amount of time that these operations can run concurrently. You can define the point at which the second operation can begin before the first operation is complete. Because of setup, move, and queue times, the actual overlap in run time might be less than the percent of overlap that you defined.

In the following example, Operation B has an 80 percent overlap, so Operation B can begin when 80 percent of Operation A remains to be finished, or when Operation A is 20 percent complete. Operations A and B are both active as they overlap.

Overlapping Operations

Operation A is 20% (run) complete

Run time for Operation A

80% of overlap (run)

Run time for Operation B

Actual start date for Operation B

Move

Queue

Setup

Run
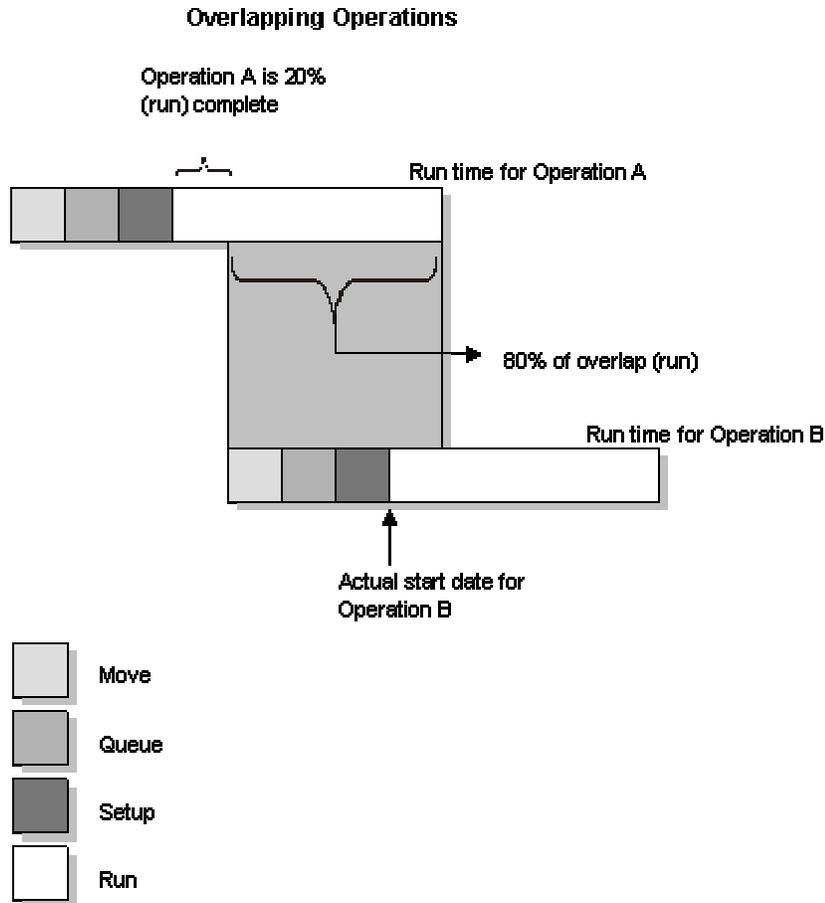
When the percent of overlap causes an operation to end later than the last operation in the routing instructions, the system issues an error message and enters the work order start and requested dates into each operation.

Overlapping and Concurrent Operations

If a percent of overlap is specified in the routing instructions, the work order routing instruction includes specified operations that overlap. For example, an overlap percentage of 80 percent for an operation means that the next operation can start when 20 percent of the previous operation is complete.

Work order complete date	05/01
Last operation 20	24 hours
First operation 10	24 hours
Resource hours per day, per work center	8 hours
Operation overlap on 20	75%

	Without Overlap	With Overlap
Operation 10		
start	04/27	04/27
complete	04/29	04/29
Operation 20		
start	04/30	04/27
complete	05/02	04/30

Using data from the previous tables, the system advances the complete date of the previous operation by 75 percent of 24 hours, or 18 hours. The system then recalculates the start date using normal backscheduling rules. As a result, operations 10 and 20 overlap and will take 24 hours to complete.

The following diagram illustrates this concept.

Date	4/27	4/28	4/29	4/30	5/1	5/2
Resource hours	8	8	8	8	8	8
OP 10 (24 hrs) (w/o overlap)	<----	-----	---->			
OP 20 (24 hrs) (w/o overlap)				<----	-----	---->
OP 10 (w/ overlap)	<----	-----	---->			
OP 20 (w/ overlap)	<-	-----	-----	-->		

Calculating Lead Times

From the Advanced Product Data Management menu (G3031), choose Leadtime Rollup.

When you run the Leadtime Rollup program (R30822A), the system updates the following values in the Item Branch File table (F4102):

- Level lead time (if using manufacturing lead time quantity)
- Manufacturing lead time
- Cumulative lead time
- Lead time per unit
- Total queue and move hours
- Setup hours

Level Lead Time

For a manufactured product, level lead time is the number of workdays that is required to complete the product after all of the items are available. Level lead time for a purchased item is the number of calendar days that are required for you to receive the item after the supplier receives your purchase order. The following example shows you where the level lead times occur for a manufactured item and a purchased item:

The system uses the following formula to calculate level lead time.

$$\sum \{[[\{(M\ or\ L)/(E\ or\ M)\} / \{(EF\ or\ UT)*(CUM\ Yield)\}] *MLQ] / TIMB\} + \ Setup + Total\ Queue\ \&\ Move$$

Work Hours per Day

The work hours per day are retrieved from Job Shop Manufacturing Constants table (F3009). The system reads the time basis code from the Routing Master File table (F3003).

The following table defines the values used in the formula.

M or L	Machine or labor hours based on the prime load code
SUM	Sum of all operations
TIMB	Time basis code
MLQ	Manufacturing lead time quantity
E or M	Number of employees or machines in the work center
Setup	Information from the routing
Queue	Queue plus move time from the routing or work center
EF or UT	Efficiency or utilization from the work center
CUM Yield %	Yield from the routing

Manufacturing Lead Time

Manufacturing lead time is the total number of workdays required to complete a product, from its lowest-level components to the final item, assuming that all purchased items are in-house. Manufacturing lead time includes the following:

- Order preparation time
- Queue time
- Setup time
- Run time

- Move time

- Inspection time

- Putaway time

Manufacturing lead time is the total of the level lead time for an item plus the longest manufacturing lead time for any of its components. Lead time for purchased items is not included in manufacturing lead time calculations.

The following example, which depicts the calculation for manufacturing lead time, shows you where the manufacturing lead time occurs in the process for a manufactured item:

Manufacturing Leadtime Calculation
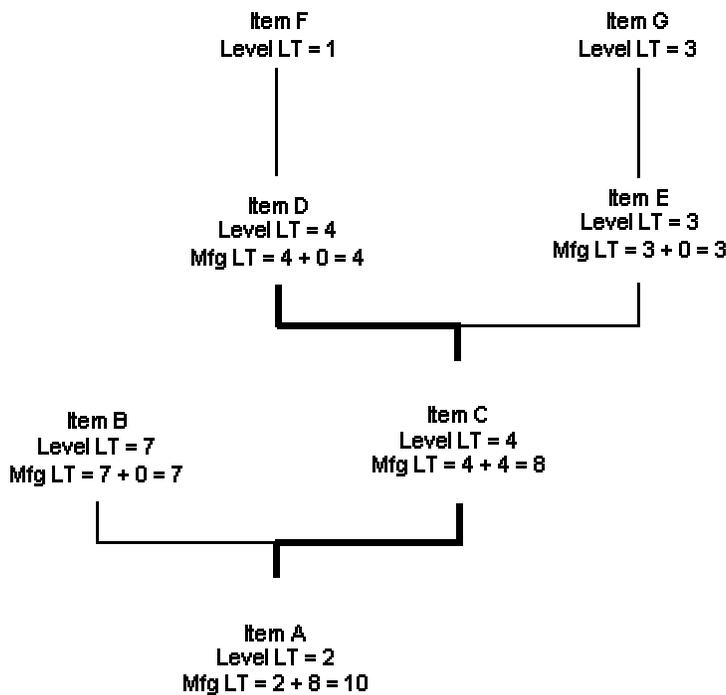
Item F
Level LT = 1

Item G
Level LT = 3

Item D
Level LT = 4
Mfg LT = 4 + 0 = 4

Item E
Level LT = 3
Mfg LT = 3 + 0 = 3

Item B
Level LT = 7
Mfg LT = 7 + 0 = 7

Item C
Level LT = 4
Mfg LT = 4 + 4 = 8

Item A
Level LT = 2
Mfg LT = 2 + 8 = 10

Bold line = Longest manufacturing leadtime for any of the product's items
Items A, B, C, D, and E are manufactured items
Items F and G are purchased items

Cumulative Lead Time

Unlike manufacturing lead time, cumulative lead time includes the lead times for purchased items. It includes both the time to acquire purchased items and the time to complete the product.

Cumulative lead time is the number of workdays that are required to acquire items and complete a product, from its lowest-level components to the final item. Cumulative lead time is the level lead time for a product plus the longest cumulative lead time of any of its components. The cumulative lead time for a purchased item is its level lead time.

The following flow chart depicts the calculation for cumulative lead time.
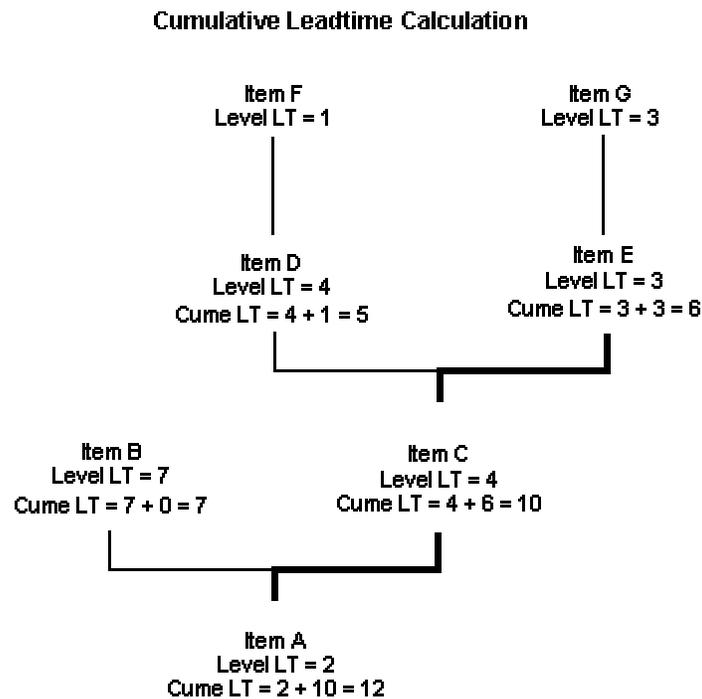
Cumulative Leadtime Calculation

Item F
Level LT = 1

Item G
Level LT = 3

Item D
Level LT = 4
Cume LT = 4 + 1 = 5

Item E
Level LT = 3
Cume LT = 3 + 3 = 6

Item B
Level LT = 7
Cume LT = 7 + 0 = 7

Item C
Level LT = 4
Cume LT = 4 + 6 = 10

Item A
Level LT = 2
Cume LT = 2 + 10 = 12

Bold line = Longest manufacturing leadtime for any of the product's items
Items A, B, C, D, and E are manufactured items
Items F and G are purchased items

Total Queue and Move Hours

Queue hours indicate the time that a manufacturing work order is idle at a work center before setup or work begins. Move hours indicate the time that a manufacturing work order is moving from the completion of one operation to the start of the next operation. To calculate the total queue and move hours, add together the move hours per routing and the queue hours per routing.

In the following example, the total queue and move hours are nine hours.

OP 30   OP 60   OP 80

(1+2)   (2+4)   (0+0)   = 9

Lead Time Per Unit

The lead time per unit is the sum of the run times, as defined by the prime load codes for the work centers, factored by the routing time basis and converted to the lead time per unit. The lead time per unit sets valid start dates for orders planned in other-than-normal planned order quantity. When you run the lead time rollup program, the system measures the lead time per unit in hours.

The system uses the following formula to calculate the lead time per unit:

$$\sum \frac{\{ ((M \text{ or } L)/(E \text{ or } M)) / ((EF \text{ or } UT)*(CUM \text{ Yield})) \} / TIMB1}{TIMB2}$$

The system reads the time basis code 1 (TIMB1) from the Item Branch File table (F4102) and the time basis code 2 (TIMB2) from the Routing Master File table (F3003).

If the processing option to override the number of employees or machines in the work center is set to one, the system uses the following formula:

$$\sum \frac{\{ ((M \text{ or } L)/(1)) / ((EF \text{ or } UT)*(CUM \text{ Yield})) \} / TIMB1}{TIMB2}$$

The following table defines the values used in the formula.

M or L	Machine or labor hours based on the prime load code
SUM	Sum of all operations
TIMB1	Time basis code from the Item Branch File table
TIMB2	Time basis code from the routing
E or M	Number of employees or machines in the work center
EF or UT	Efficiency or utilization from the work center
CUM Yield %	Yield from the routing

Setup Hours

Setup hours indicate the time that is required to prepare the machinery to run a specific item. To calculate setup hours, divide the setup by the number of employees or machines for each routing, and then add the values together. This formula ensures consistency during the backscheduling routing because the resource units for the work center are created based on those numbers.

In the following example, the setup hours equal six hours:

Setup Hours

$$\frac{\text{Setup}}{\text{Employees or machines}} = \frac{1}{1} + \frac{2}{1} + \frac{6}{2} = 6 \text{ setup hours}$$

OP 30   OP 60   OP 80

EnterpriseOne PeopleBooks Glossary

"as of" processing	A process that is run at a specific point in time to summarize item transactions.
52 period accounting	A method of accounting that uses each week as a separate accounting period.
account site	In the invoice process, the address to which invoices are mailed. Invoices can go to a different location or account site from the statement.
active window	The window that contains the document or display that will be affected by current cursor movements, commands, and data entry in environments that are capable of displaying multiple on-screen windows.
ActiveX	A technology and set of programming tools developed by Microsoft Corporation that enable software components written in different languages to interact with each another in a network environment or on a web page. The technology, based on object linking and embedding, enables Java applet-style functionality for Web browsers as well as other applications (Java is limited to Web browsers at this time). The ActiveX equivalent of a Java applet is an ActiveX control. These controls bring computational, communications, and data manipulation power to programs that can "contain" them—for example, certain Web browsers, Microsoft Office programs, and anything developed with Visual Basic or Visual C++.
activity	In Advanced Cost Accounting, an aggregation of actions performed within an organization that is used in activity-based costing.
activity driver	A measure of the frequency and intensity of the demands that are placed on activities by cost objects. An activity driver is used to assign costs to cost objects. It represents a line item on the bill of activities for a product or customer. An example is the number of part numbers, which is used to measure the consumption of material-related activities by each product, material type, or component. The number of customer orders measures the consumption of order-entry activities by each customer. Sometimes an activity driver is used as an indicator of the output of an activity, such as the number of purchase orders that are prepared by the purchasing activity. See also cost object.
activity rule	The criteria by which an object progresses from a given point to the next in a flow.
actual cost	Actual costing uses predetermined cost components, but the costs are accumulated at the time that they occur throughout the production process.
adapter	A component that connects two devices or systems, physically or electronically, and enables them to work together.
add mode	The condition of a form where a user can enter data into it.
advanced interactive executive	An open IBM operating system that is based on UNIX.
agent	A program that searches through archives or other repositories of information on a topic that is specified by the user.

aging	A classification of accounts by the time elapsed since the billing date or due date. Aging is divided into schedules or accounting periods, such as 0-30 days, 31-60 days, and so on.
aging schedule	A schedule that is used to determine whether a payment is delinquent and the number of days which the payment is delinquent.
allegato IVA clienti	In Italy, the term for the A/R Annual VAT report.
allegato IVA fornitori	In Italy, the term for the A/P Annual VAT report.
application layer	The seventh layer of the Open Systems Interconnection Reference Model, which defines standards for interaction at the user or application program level.
application programming interface (API)	A set of routines that is used by an application program to direct the performance of procedures by the computer's operating system.
AS/400 Common	A data source that resides on an AS/400 and holds data that is common to the co-existent library, allowing PeopleSoft EnterpriseOne to share information with PeopleSoft World.
assembly inclusion rule	A logic statement that specifies the conditions for using a part, adjusting the price or cost, performing a calculation, or using a routing operation for configured items.
audit trail	The detailed, verifiable history of a processed transaction. The history consists of the original documents, transaction entries, and posting of records and usually concludes with a report.
automatic return	A feature that allows a user to move to the next entry line in a detail area or to the first cell in the next row in several applications.
availability	The expression of the inventory amount that can be used for sales orders or manufacturing orders.
available inventory	The quantity of product that can be promised for sale or transfer at a particular time, considering current on-hand quantities, replenishments in process, and anticipated demand.
back office	The set of enterprise software applications that supports the internal business functions of a company.
backhaul	The return trip of a vehicle after delivering a load to a specified destination. The vehicle can be empty or the backhaul can produce less revenue than the original trip. For example, the state of Florida is considered a backhaul for many other states—that is, many trucking companies ship products into the state of Florida, but most of them cannot fill a load coming out of Florida or they charge less. Hence, trucks coming out of Florida are either empty or produce less revenue than the original trip.
balance forward	The cumulative total of inventory transactions that is used in the Running Balance program. The system does not store this total. You must run this program each time that you want to review the cumulative inventory transactions total.

balance forward receipt application method	A receipt application method in which the receipt is applied to the oldest or newest invoices in chronological order according to the net due date.
bank tape (lock box) processing	The receipt of payments directly from a customer's bank via customer tapes for automatic receipt application.
base location	[In package management] The topmost location that is displayed when a user launches the Machine Identification application.
basket discount	A reduction in price that applies to a group or "basket" of products within a sales order.
basket repricing	A rule that specifies how to calculate and display discounts for a group of products on a sales order. The system can calculate and display the discount as a separate sales order detail line, or it can discount the price of each item on a line-by-line basis within the sales order.
batch job	A job submitted to a system and processed as a single unit with no user interaction.
batch override	An instruction that causes a batch process to produce output other than what it normally would produce for the current execution only.
batch process	A type of process that runs to completion without user intervention after it has been started.
batch program	A program that executes without interacting with the user.
batch version	A version of a report or application that includes a set of user-defined specifications, which control how a batch process runs.
batch/lot tracking	The act of identifying where a component from a specific lot is used in the production of goods.
batch/mix	A manufacturing process that primarily schedules short production runs of products.
batch-of-one processing	A transaction method that allows a client application to perform work on a client workstation, and then submit the work all at once to a server application for further processing. As a batch process is running on the server, the client application can continue performing other tasks. See also direct connect, store-and-forward.
binary large object (BLOB)	A collection of binary data stored as a single entity in a [file].
binder clip	See paper clip.
black products	Products that are derived from the low or heavy end of the distillation process—for example, diesel oils and fuel oils. See also white products.
blend note	Document that authorizes a blending activity, and describes both the ingredients for the blend and the blending steps that occur.

blend off	Reworking off-specification material by introducing a small percentage back into another run of the same product.
blind execution	The mode of execution of a program that does not require the user to review or change the processing options set for the program, and does not require user intervention after the program has been launched.
boleto	In Brazil, the document requesting payment by a supplier or a bank on behalf of a supplier.
bolla doganale	VAT-Only Vouchers for Customs. In Italy, a document issued by the customs authority to charge VAT and duties on extra-EU purchasing.
bookmark	A shortcut to a location in a document or a specific place in an application or application suite.
bordero & cheque	In Brazil, bank payment reports.
broker	A program that acts as an intermediary between clients and servers to coordinate and manage requests.
BTL91	In the Netherlands, the ABN/AMRO electronic banking file format that enables batches with foreign automatic payment instructions to be delivered.
budgeted volume	A statement of planned volumes (capacity utilization) upon which budgets for the period have been set.
bunkering	A rate per ton or a sum of money that is charged for placing fuel on board; can also mean the operation itself.
business function	An encapsulated set of business rules and logic that can normally be re-used by multiple applications. Business functions can execute a transaction or a subset of a transaction (check inventory, issue work orders, and so on). Business functions also contain the APIs that allow them to be called from a form, a database trigger, or a non-EnterpriseOne application. Business functions can be combined with other business functions, forms, event rules, and other components to make up an application. Business functions can be created through event rules or third-generation languages, such as C. Examples of business functions include Credit Check and Item Availability.
business function event rule	Encapsulated, reusable business logic that is created by using through event rules rather than C programming. Contrast with embedded event rule. See also event rule.
business object library	[In interoperability] The repository that stores EnterpriseOne business objects, which consist of Java or CORBA objects.
business unit	A financial entity that is used to track the costs, revenue, or both, of an organization. A business unit can also be defined as a branch/plant in which distribution and manufacturing activities occur. Additionally, in manufacturing setup, work centers and production lines must be defined as business units; but these business unit types do not have profit/loss capability.

business view	Used by EnterpriseOne applications to access data from database tables. A business view is a means for selecting specific columns from one or more tables with data that will be used in an application or report. It does not select specific rows and does not contain any physical data. It is strictly a view through which data can be handled.
business view design aid (BDA)	An EnterpriseOne GUI tool for creating, modifying, copying, and printing business views. The tool uses a graphical user interface.
buy-back crude	In foreign producing oil countries, that portion of the host government's share of "participation crude" which it permits the company holding a concession to "buy back."
CAB	In Italy, the bank branch code or branch ID. A five-digit number that identifies any agency of a specific bank company in Italy.
cadastro de pessoas físicas	Cadastro de pessoas físicas. In Brazil, the federal tax ID for a person.
category code	A code that identifies a collection of objects sharing at least one common attribute.
central object	A software component that resides on a central server.
central objects merge	A process that blends a customer's modifications with the objects in a current release with objects in a new release.
central server	A computer that has been designated to contain the originally installed version of the software (central objects) for deployment to client computers.
certificate input	See direct input.
certificate of analysis (COA)	A document that is a record of all of the testing which has been performed against an item, lot, or both, plus the test results for that item and lot.
change management	[In software development] A process that aids in controlling and tracking the evolution of software components.
change order	In PeopleSoft, an addendum to the original purchase order that reflects changes in quantities, dates, or specifications in subcontract-based purchasing. A change order is typically accompanied by a formal notification.
chargeback	A receipt application method that generates an invoice for a disputed amount or for the difference of an unpaid receipt.
chart	EnterpriseOne term for tables of information that appear on forms in the software. See forms.
check-in location	The directory structure location for the package and its set of replicated objects. This location is usually \\deploymentserver\release\path_code\ package\packagename. The subdirectories under this path are where the central C components (source, include, object, library, and DLL file) for business functions are stored.

checksum value	A computed value that depends on the contents of a block of data, and that is transmitted or stored with the data to detect whether errors have occurred in the transmission or storage.
class	[In object-oriented programming] A category of objects that share the same characteristics.
clean cargo	Term that refers to cargoes of gasoline and other refined products. See also dirty cargo.
client access	The ability to access data on a server from a client machine.
client machine	Any machine that is connected to a network and that exchanges data with a server.
client workstation	A network computer that runs user application software and is able to request data from a server.
ClieOp03	In the Netherlands, the euro-compliant uniform electronic banking file format that enables batches with domestic automatic direct debit instructions and batches with domestic payment instructions to be delivered.
ClieOp2	In the Netherlands, the uniform electronic banking file format that enables batches with domestic automatic direct debit instructions and batches with domestic payment instructions to be delivered.
cluster	Two or more computers that are grouped together in such a way that they behave like a single computer.
co-existence	A condition where two or more applications or application suites access one or more of the same database tables within the same enterprise.
cold test	The temperature at which oil becomes solid. Generally considered to be 5 degrees F lower than the pour point.
commitment	The number of items that are reserved to fill demand.
common object request broker architecture	An object request broker standard that is endorsed by the Object Management Group.
compa-ratio	An employee's salary divided by the midpoint amount for the employee's pay grade.
component changeout	See component swap.
component object model (COM)	A specification developed by Microsoft for building software components that can be assembled into programs or add functionality to existing programs running on Microsoft Windows platforms. COM components can be written in a variety of languages, although most are written in C++, and can be unplugged from a program at runtime without having to recompile the program.

component swap	In Equipment/Plant Management, the substitution of an operable component for one that requires maintenance. Typically, you swap components to minimize equipment downtime while servicing one of the components. A component swap can also mean the substitution of one parent or component item for another in its associated bill of material.
conference room pilot environment	An EnterpriseOne environment that is used as a staging environment for production data, which includes constants and masters tables such as company constants, fiscal date patterns, and item master. Use this environment along with the test environment to verify that your configuration works before you release changes to end-users.
configurable network computing (CNC)	An application architecture that allows interactive and batch applications that are composed of a single code base to run across a TCP/IP network of multiple server platforms and SQL databases. The applications consist of re-usable business functions and associated data that can be configured across the network dynamically. The overall objective for businesses is to provide a future-proof environment that enables them to change organizational structures, business processes, and technologies independently of each other.
configurable processing engine	Handles all "batch" processes, including reporting, Electronic Data Exchange (EDIt) transactions, and data duplication and transformation (for data warehousing). This ability does not mean that it exists only on the server; it can be configured to run on desktop machines (Windows 95 and NT Workstation) as well.
configuration management	A rules-based method of ordering assemble-to-order or make-to-order products in which characteristics of the product are defined as part of the Sales Order Entry process. Characteristics are edited by using Boolean logic, and then translated into the components and routing steps that are required to produce the product. The resulting configuration is also priced and costed, based on the defined characteristics.
configured item segment	A characteristic of a configured item that is defined during sales order entry. For example, a customer might specify a type of computer hard drive by stating the number of megabytes of the hard drive, rather than a part number.
consuming location	The point in the manufacturing routing where a component or subassembly is used in the production process. In kanban processing, the location where the kanban container materials are used in the manufacturing process and the kanban is checked out for replenishment.
contra/clearing account	A G/L account used by the system to offset (balance) journal entries. For example, you can use a contra/clearing account to balance the entries created by allocations.
contribution to profit	Selling price of an item minus its variable costs.
control table	A table that controls the program flow or plays a major part in program control.
control table workbench	During the Installation Workbench process, Control Table Workbench runs the batch applications for the planned merges that update the data dictionary, user defined codes, menus, and user overrides tables.

control tables merge	A process that blends a customer's modifications to the control tables with the data that accompanies a new release.
corrective work order	A work order that is used to formally request unscheduled maintenance and communicate all of the details pertaining to the requested maintenance task.
corrective work order	A work order that is used to formally request unscheduled maintenance and communicate all of the details pertaining to the requested maintenance task.
cost assignment	Allocating resources to activities or cost objects.
cost component	An element of an item's cost—for example, material, labor, or overhead.
cost object	Any customer, product, service, contract, project, or other work unit for which you need a separate cost measurement.
cost rollup	A simulated scenario in which work center rates, material costs, and labor costs are used to determine the total cost of an item.
costing elements	The individual classes of added value or conversion costs. These elements are typically materials, such as raw and packaging; labor and machine costs; and overhead, such as fixed and variable. Each corporation defines the necessary detail of product costs by defining and tracking cost categories and subcategories.
credit memo	A negative amount that is used to correct a customer's statement when he or she is overcharged.
credit notice	The physical document that is used to communicate the circumstances and value of a credit order.
credit order	A credit order is used to reflect products or equipment that is received or returned so that it can be viewed as a sales order with negative amounts. Credit orders usually add the product back into inventory. This process is linked with delivery confirmation.
cross segment edit	A logic statement that establishes the relationship between configured item segments. Cross segment edits are used to prevent ordering of configurations that cannot be produced.
crude oil assay	A procedure for determining the distillation curve and quality characteristics of a crude oil.
cumulative update	A version of software that includes fixes and enhancements that have been made since the last release or update.
currency relationships	When converting amounts from one currency to another, the currency relationship defines the from currency and the to currency in PeopleSoft software. For example, to convert amounts from German marks to the euro, you first define a currency relationship between those two currencies.
currency restatement	The process of converting amounts from one currency into another currency, generally for reporting purposes. It can be used, for example, when many currencies must be restated into a single currency for consolidated reporting.

current cost	The cost that is associated with an item at the time a parts list and routing are attached to a work order or rate schedule. Current cost is based on the latest bill of material and routing for the item.
customer pricing rules	In Procurement, the inventory pricing rules that are assigned to a supplier. In Sales, inventory pricing rules that are assigned to a customer.
D.A.S. 2 Reporting (DAS 2 or DADS 1)	In France, the name of the official form on which a business must declare fees and other forms of remuneration that were paid during the fiscal year.
data dictionary	A dynamic repository that is used for storing and managing a specific set of data item definitions and specifications.
data source workbench	During the Installation Workbench process, Data Source Workbench copies all of the data sources that are defined in the installation plan from the Data Source Master and Table and Data Source Sizing tables in the Planner data source to the System - release number data source. It also updates the Data Source Plan detail record to reflect completion.
data structure	A description of the format of records in a database such as the number of fields, valid data types, and so on.
data types	Supplemental information that is attached to a company or business unit. Narrative type contains free-form text. Code type contains dates, amounts, and so on.
datagram	A self-contained packet of information that is forwarded by routers, based on their address and the routing table information.
date pattern	A period of time that is set for each period in standard and 52-period accounting and forecasting.
DCE	See distributed computing environment.
DEB	See déclaration d'echange de biens.
debit memo	In Accounts Payable, a voucher that is entered with a negative amount. Enter this type of voucher when a supplier sends you a credit so that you can apply the amount to open vouchers when you issue payment to the supplier.
debit memo	A form that is issued by a customer, requesting an adjustment of the amount, which is owed to the supplier.
debit statement	A list of debit balances.
de-blend	When blend off does not result in a product that is acceptable to customers. The further processing of product to adjust specific physical and chemical properties to within specification ranges. See also blend off.
déclaration d'echange de biens (DEB)	The French term that is used for the Intrastat report.
delayed billing	The invoicing process is delayed until the end of a designated period.

delta load	A batch process that is used to compare and update records between specified environments.
denominated-in currency	The company currency in which financial reports are based.
deployment server	A server that is used to install, maintain, and distribute software to one or more enterprise servers and client workstations.
detail	The specific information that makes up a record or transaction. Contrast with summary.
detail information	Information that primarily relates to individual lines in a sales or purchase order.
direct connect	A transaction method in which a client application communicates interactively and directly with a server application. See also batch-of-one immediate, store-and-forward.
direct input	The system calculates the net units when you enter gross volume, temperature, and gravity or density. This data is generally entered during product receiving from the certificate that is prepared by an independent inspector.
direct ship orders	A purchase order that is issued to a third-party supplier who designates the destination as the customer. A direct ship sales order is also created for the customer. Direct ship orders occur when a product is not available from a company-owned or company-operated source, so the system creates an order to ship the product from a third-party source directly to the customer. Sometimes referred to as a drop ship or third-party supply.
direct usage	Consumption of resources that are attributable to specific production runs because the resources were directly issued to the schedule/order.
director	An EnterpriseOne user interface that guides a user interactively through an EnterpriseOne process.
dirty cargo	Term that refers to crude oil cargoes or other non-refined petroleum cargoes. See also clean cargo.
dispatch planning	Efficient planning and scheduling of product deliveries. Considerations include: Dispatch groups Scheduled delivery date Scheduled delivery time Preferred delivery date Preferred delivery time Average delivery time for that geographical location Available resources Special equipment requirements at the product's source or destination.

displacement days	The number of days that are calculated from today's date by which you group vouchers for payment. For example, if today's date is March 10 and you specify three displacement days, the system includes vouchers with a due date through March 13 in the payment group. Contrast with pay-through date.
display sequence	A number that the system uses to re-order a group of records on the form.
distributed computing environment (DCE)	A set of integrated software services that allows software which is running on multiple computers to perform seamless and transparently to the end-users. DCE provides security, directory, time, remote procedure calls, and files across computers running on a network.
distributed data processing	Processing in which some of the functions are performed across two or more linked facilities or systems.
distributed database management system (DDBMS)	A system for distributing a database and its control system across many geographically dispersed machines.
do not translate (DNT)	A type of data source that must exist on the AS/400 because of BLOB restrictions.
double-byte character set (DBCS)	A method of representing some characters by using one byte and other characters by using two bytes. Double-byte character sets are necessary to represent some characters in the Japanese, Korean, and Chinese languages.
downgrade profile	A statement of the hierarchy of allowable downgrades. Includes substitutions of items, and meeting tighter specifications for those products with wider or overlapping specification ranges.
DTA	Datenträgeraustausch. A Swiss payment format that is required by Telekurs (Payserv).
dual pricing	To provide prices for goods and services in two currencies. During the euro transition period, dual pricing between the euro and Economic and Monetary Union (EMU) member currencies is encouraged.
dynamic link library (DLL)	A set of program modules that are designed to be invoked from executable files when the executable files are run, without having to be linked to the executable files. They typically contain commonly used functions.
dynamic partitioning	The ability to dynamically distribute logic or data to multiple tiers in a client/server architecture.
economy of scale	A phenomenon whereby larger volumes of production reduce unit cost by distributing fixed costs over a larger quantity. Variable costs are constant; but fixed costs per unit are reduced, thereby reducing total unit cost.
edit mode	A processing mode or condition where the user can alter the information in a form.
edit rule	A method that is used for formatting user entries, validating user entries, or both, against a predefined rule or set of rules.

embedded event rule	An event rule that is specific to a particular table or application. Examples include form-to-form calls, hiding a field that is based on a processing option value, or calling a business function. Contrast with business function event rule. See also event rule.
employee work center	A central location for sending and receiving all EnterpriseOne messages (system and user-generated), regardless of the originating application or user. Each user has a mailbox that contains workflow and other messages, including Active Messages. With respect to workflow, the Message Center is MAPI compliant and supports drag-and-drop work reassignment, escalation, forward and reply, and workflow monitoring. All messages from the message center can be viewed through EnterpriseOne messages or Microsoft Exchange.
Emulator	An item of software or firmware that allows one device to imitate the functioning of another.
encapsulation	The ability to confine access to and manipulation of data within an object to the procedures that contribute to the definition of that object.
engineering change order (ECO)	A work order document that is used to implement and track changes to items and resulting assemblies. The document can include changes in design, quantity of items required, and the assembly or production process.
enhanced analysis database	A database containing a subset of operational data. The data on the enhanced analysis database performs calculations and provides summary data to speed generation of reports and query response times. This solution is appropriate when external data must be added to source data, or when historical data is necessary for trend analysis or regulatory reporting. See also duplicated database, enterprise data warehouse.
enterprise server	A computer containing programs that collectively serve the needs of an enterprise rather than a single user, department, or specialized application.
EnterpriseOne object	A re-usable piece of code that is used to build applications. Object types include tables, forms, business functions, data dictionary items, batch processes, business views, event rules, versions, data structures, and media objects. See also object.
EnterpriseOne process	Allows EnterpriseOne clients and servers to handle processing requests and execute transactions. A client runs one process, and servers can have multiple instances of a process. EnterpriseOne processes can also be dedicated to specific tasks (for example, workflow messages and data replication) to ensure that critical processes do not have to wait if the server is particularly busy.
EnterpriseOne web development computer	A standard EnterpriseOne Windows developer computer with the additional components installed: Sun's JDK 1.1. JFC (0.5.1). Generator Package with Generator.Java and JDECOM.dll. R2 with interpretive and application controls/form.

environment workbench	During the Installation Workbench process, Environment Workbench copies the environment information and Object Configuration Manager tables for each environment from the Planner data source to the System release number data source. It also updates the Environment Plan detail record to reflect completion.
equivalent fuel	A barrel of equivalent fuel supplies six million BTUs of heat. Fuel gas quantities are usually calculated as equivalent fuel barrels in economic calculations for refinery operations.
escalation monitor	A batch process that monitors pending requests or activities, and restarts or forwards them to the next step or user after they have been inactive for a specified amount of time.
ESR	Einzahlungsschein mit Referenznummer. A pay slip with a reference number.
event rule	[In EnterpriseOne] A logic statement that instructs the system to perform one or more operations that are based on an activity that can occur in a specific application, such as entering a form or exiting a field.
exit bar	[In EnterpriseOne] The tall pane with icons in the left portion of many EnterpriseOne program windows.
facility	An entity within a business for which you want to track costs. For example, a facility might be a warehouse location, job, project, work center, or branch/plant. Sometimes referred to as a business unit.
fast path	[In EnterpriseOne] A command prompt that allows the user to move quickly among menus and applications by using specific commands.
file handle	A temporary reference (typically a number) that is assigned to a file which has been opened by the operating system and is used throughout the session to access the file.
file server	A computer that stores files to be accessed by other computers on the network.
find/browse	A type of form used to: Search, view, and select multiple records in a detail area. Delete records. Exit to another form. Serve as an entry point for most applications.
firm planned order (FPO)	A work order that has reached a user defined status. When this status is entered in the processing options for the various manufacturing programs, messages for those orders are not exploded to the components.
fiscal date pattern	A representation of the beginning date for the fiscal year and the ending date for each period in that year.
fix/inspect	A type of form used to view, add, or modify existing records. A fix/inspect form has no detail area.

fixed quantity	A term that indicates the bill of material relationship between a parent item and its components or ingredients. When a bill of material component has a fixed quantity relationship to its parent, the amount of the component does not change when the software calculates parts list requirements for different work order quantities. Contrast with variable quantity.
flexible account numbers	The format of account numbers for journal entries. The format that you set up must be the three segments: Business unit. Object. Subsidiary.
form design aid (FDA)	The EnterpriseOne GUI development tool for building interactive applications and forms.
form exit	[In EnterpriseOne] An option that is available as a button on the Form Exit bar or as a selection in the Form menu. It allows users to open an interconnected form.
form interconnection	Allows one form to access and pass data to another form. Form interconnections can be attached to any event; however, they are normally used when a button is clicked.
form type	The following form types are available in EnterpriseOne: Find/browse. Fix/inspect. Header detail. Headerless detail. Message. Parent/child. Search/select.
form-to-form call	A request by a form for data or functionality from one of the connected forms.
framework	[In object-oriented systems] A set of object classes that provide a collection of related functions for a user or piece of software.
frozen cost	The cost of an item, operation, or process after the frozen update program is run; used by the Manufacturing Accounting system.
frozen update program	A program that freezes the current simulated costs, thereby finalizing them for use by the Manufacturing Accounting system.
globally unique identifier (GUI)	A 16-byte code in the Component Object Model that identifies an interface to an object across all computers and networks.
handle	[In programming] A pointer that contains the address of another pointer, which, in turn, contains the address of the desired object.

hard commitment	The number of items that are reserved for a sales order, work order, or both, from a specific location, lot, or both.
hard error	An error that cannot be corrected by a given error detection and correction system.
header	Information at the beginning of a table or form. Header information is used to identify or provide control information for the group of records that follows.
header information	Information that pertains to the entire order.
hover help	A help function that provides contextual information or instructions when a cursor moves over a particular part of the interface element for a predefined amount of time.
ICMS	Imposto sobre circulação de mercadoria e servicos. In Brazil, a state tax that is applied to the movement of merchandise and some services.
ICMS Substituto	Imposto sobre circulacao de mercadoria e servicos substituto. In Brazil, the ICMS tax that is charged on interstate transactions, or on special products and clients.
ICMS Substituto-Markup	See imposto sobre circulação de mercadoria e servicos substituto-markup.
imposto de renda (IR)	Brazilian income tax.
imposto sobre produtos industrializados	In Brazil, a federal tax that applies to manufactured goods (domestic and imported).
imposto sobre services (ISS)	In Brazil, tax on services.
inbound document	A document that is received from a trading partner using Electronic Data Interface (EDI). This document is also referred to as an inbound transaction.
indented tracing	Tracking all lot numbers of intermediates and ingredients that are consumed in the manufacture of a given lot of product, down through all levels of the bill of material, recipe, or formula.
indexed allocations	A procedure that allocates or distributes expenses, budgets, adjustments, and so on, among business units, based on a fixed percentage.
indirect measurement	Determining the quantity on-hand by: Measuring the storage vessels and calculating the content's balance quantity. or Theoretically calculating consumption of ingredients and deducting them from the on-hand balance.
indirect usage	Determining what should have been used by multiplying receipt quantity of the parent times the quantity per statement in the formula, recipe, or bill of material. This transaction typically affects both consumption on schedule as well as issue from on-hand balances.

in-process rework	Recycling a semi processed product that does not meet acceptable standards. Further processing takes the product out of a given operation and sends it back to the beginning of that operation or a previous operation (for example, unreacted materials). Rework that is detected prior to receipt of finished goods and corrected during the same schedule run.
INPS withholding tax	Instituto Nazionale di Previdenza Sociale withholding tax. In Italy, a 12% social security withholding tax that is imposed on payments to certain types of contractors. This tax is paid directly to the Italian social security office.
inscrição estadual	ICMS tax ID. In Brazil, the state tax ID.
inscrição municipal	ISS tax ID. In Brazil, the municipal tax ID.
integrated toolset	Unique to EnterpriseOne is an industrial-strength toolset that is embedded in the already comprehensive business applications. This toolset is the same toolset that is used by PeopleSoft to build EnterpriseOne interactive and batch applications. Much more than a development environment, however, the EnterpriseOne integrated toolset handles reporting and other batch processes, change management, and basic data warehousing facilities.
integrity test	A process that is used to supplement a company's internal balancing procedures by locating and reporting balancing problems and data inconsistencies.
interbranch sales order	A sales order that is used for transactions between branch/plants other than the selling branch/plant.
Interoperability	The ability of different computer systems, networks, operating systems, and applications to work together and share information.
inventory pricing rule	A discount method that is used for purchases from suppliers and sales to customers. The method is based on effectivity dates, up-to quantities, and a factor by which you can mark up or discount the price or cost.
inventory turn	The number of times that the inventory cycles, or turns over, during the year. A frequently used method to compute inventory turnover is to divide the annual costs of sales by the average inventory level.
invoice	An itemized list of goods that are shipped or services that are rendered, stating quantities, prices, fees, shipping charges, and so on. Companies often have their invoices mailed to a different address than where they ship products. In such cases, the bill-to address differs from the ship-to address.
IP	See imposto sobre produtos industrializados.
IR	See imposto de renda.
IServer Service	Developed by PeopleSoft, this Internet server service resides on the Web server and is used to speed up delivery of the Java class files from the database to the client.
ISS	See imposto sobre servicos.

jargon	An alternate data dictionary item description that EnterpriseOne or PeopleSoft World displays, based on the product code of the current object.
java application server	A component-based server that resides in the middle-tier of a server-centric architecture and provides middleware services for security and state maintenance, along with data access and persistence.
JDBNET	A database driver that allows heterogeneous servers to access each other's data.
jde.ini	A PeopleSoft file (or member for AS/400) that provides the runtime settings that are required for EnterpriseOne initialization. Specific versions of the file or member must reside on every machine that is running EnterpriseOne, including workstations and servers.
JDE.LOG	The main diagnostic log file of EnterpriseOne. Always located in the root directory on the primary drive. Contains status and error messages from the startup and operation of EnterpriseOne.
JDEBASE Database Middleware	PeopleSoft proprietary database middleware package that provides two primary benefits: 1. Platform-independent APIs for multidatabase access. These APIs are used in two ways: a. By the interactive and batch engines to dynamically generate platform-specific SQL, depending on the data source request. b. As open APIs for advanced C business function writing. These APIs are then used by the engines to dynamically generate platform-specific SQL. 2. Client-to-server and server-to-server database access. To accomplish this access, EnterpriseOne is integrated with a variety of third-party database drivers, such as Client Access 400 and open database connectivity (ODBC).
JDECallObject	An application programming interface that is used by business functions to invoke other business functions.
JDEIPC	Communications programming tools that are used by server code to regulate access to the same data in multiprocess environments, communicate and coordinate between processes, and create new processes.
JDENET	PeopleSoft proprietary middleware software. JDENET is a messaging software package.
JDENET communications middleware	PeopleSoft proprietary communications middleware package for EnterpriseOne. It is a peer-to-peer, message-based, socket-based, multiprocess communications middleware solution. It handles client-to-server and server-to-server communications for all EnterpriseOne supported platforms.
just in time installation (JITI)	EnterpriseOne's method of dynamically replicating objects from the central object location to a workstation.
just in time replication (JITR)	EnterpriseOne's method of replicating data to individual workstations. EnterpriseOne replicates new records (inserts) only at the time that the user needs the data. Changes, deletes, and updates must be replicated using Pull Replication.

Kagami	In Japan, summarized invoices that are created monthly (in most cases) to reduce the number of payment transactions.
latitude	The X coordinate of the location of an item in the warehouse. The system can use latitude, longitude, and height when suggesting locations for putaway, replenishment, and picking.
laytime (or layhours)	The amount of time that is allotted to a tanker at berth to complete loading or discharging cargo. This time is usually expressed in running hours, and is fixed by prior agreement between the vessel owner and the company that is chartering the vessel. Laytime is stipulated in the charter, which states exactly the total of number of hours that are granted at both loading and unloading ports, and indicates whether such time is reversible. A statement of "Seventy-Two Hours, Reversible" means that a total of 72 hours is granted overall at both ports, and any time saved at one port can be applied as a credit at the other port. For example, if the vessel uses only 32 hours instead of 36 hours to load cargo, it can apply an additional four hours to the 36 hours allotted at the discharge port. Such considerations are important for purposes of computing demurrage.
leading zeros	A series of zeros that certain facilities in PeopleSoft systems place in front of a value that is entered. This situation normally occurs when you enter a value that is smaller than the specified length of the field. For example, if you enter 4567 in a field that accommodates eight numbers, the facility places four zeros in front of the four numbers that you enter. The result appears as 00004567.
ledger type	A code that designates a ledger which is used by the system for a particular purpose. For example, all transactions are recorded in the AA (actual amounts) ledger type in their domestic currency. The same transactions can also be stored in the CA (foreign currency) ledger type.
level break	The position in a report or text where a group of similar types of information ends and another one begins.
libro IVA	Monthly VAT report. In Italy, the term for the report that contains the detail of invoices and vouchers that were registered during each month.
line of business	A description of the nature of a company's work; also a tool to control the relationship with that customer, including product pricing.
linked service type	A service type that is associated with a primary service type. Linked service types can be cancelled, and the maintenance tasks are performed when the primary service type to which they are linked comes due. You can specify whether the system generates work orders for linked service types, as well as the status that the system assigns to work orders that have already been generated. Sometimes referred to as associated service types. See also primary service type and service type.
livro razao	In Brazil, a general ledger report.
load balancing	The act of distributing the number of processes proportionally to all servers in a group to maximize overall performance.

location workbench	During the Installation Workbench process, Location Workbench copies all locations that are defined in the installation plan from the Location Master table in the Planner data source to the System data source.
log files	Files that track operations for a process or application. Reviewing log files is helpful for troubleshooting problems. The file extension for log files is .LOG.
logic data source	Any code that provides data during runtime.
logical compartment	One of two ways that is identified in the transportation constants to display compartments on vehicles. Logical display numbers the compartments sequentially. For example, if two vehicles are on a trip and each vehicle has three compartments, the logical display is 1,2,3,4,5,6.
logical file	A set of keys or indices that is used for direct access or ordered access to the records in a physical file. Several logical files can have different accesses to a physical.
logical shelf	A logical, not physical, location for inventory that is used to track inventory transactions in loan/borrow, or exchange agreements with other companies. See also logical warehouse.
logical warehouse	Not a physical warehouse containing actual inventory, but a means for storing and tracking information for inventory transactions in loan/borrow, or exchange agreements with other companies.
longitude	The Y coordinate of the location of an item in the warehouse. The system can use latitude, longitude, and height when suggesting locations for putaway, replenishment, and picking.
LSV	Lastschriftverfahren. A Swiss auto debit format that is required by Telekurs (Payserv).
mail merge	A mass-mail facility that takes names, addresses, and (sometimes) pertinent facts about recipients and merges the information into a form letter or a similarly basic document.
mailmerge workbench	[In EnterpriseOne] An application that merges Microsoft Word 6.0 (or higher) word-processing documents with EnterpriseOne records to automatically print business documents.
main fuels	Usually refers to bulk fuel products, but sometimes includes packaged products.
maintenance loop	See maintenance route.
maintenance route	A method of performing PMs for multiple pieces of equipment from a single preventive maintenance work order. A maintenance route includes pieces of equipment that share one or more identical maintenance tasks which can be performed at the same time for each piece of equipment. Sometimes referred to as maintenance loop.

maintenance work order	In PeopleSoft EnterpriseOne systems, a term that is used to distinguish work orders created for the performance of equipment and plant maintenance from other work orders, such as manufacturing work orders, utility work orders, and engineering change orders.
manufacturing and distribution planning	Planning that includes resource and capacity planning, and material planning operations. Resource and capacity planning allows you to prepare a feasible production schedule that reflects your demand forecasts and production capability. Material Planning Operations provides a short-range plan to cover material requirements that are needed to make a product.
mapping	A set of instructions that describes how one data structure passes data to another.
master business function	An interactive master file that serves as a central location for adding, changing, and updating information in a database.
master business function	A central system location for standard business rules about entering documents, such as vouchers, invoices, and journal entries. Master business functions ensure uniform processing according to guidelines that you establish.
master table	A database table that is used to store data and information that is permanent and necessary to the system's operation. Master tables might contain data such as paid tax amounts, supplier names, addresses, employee information, and job information.
matching document	A document that is associated with an original document to complete or change a transaction. For example, a receipt is the matching document of an invoice.
media object	An electronic or digital representation of an object.
media storage objects	Files that use one of the following naming conventions that are not organized into table format: Gxxx, xxxGT, or GTxxx.
memory violation	An error that occurs as the result of a memory leak.
menu selection	An option on a menu that initiates a software function directly.
message center	A central location for sending and receiving all EnterpriseOne messages (system- and user-generated), regardless of the originating application or user.
messaging application programming interface (MAPI)	An architecture that defines the components of a messaging system and how they behave. It also defines the interface between the messaging system and the components.
metal content	A series of properties of a blended product that help to determine its suitability for a prescribed purpose.
metals management	The process of maintaining information about the location and status of durable product containers such as liquid petroleum gas (LPG) cylinders.
mobile inventory	Inventory that is transferred from a depot to a barge or truck for milk-run deliveries.

modal	A restrictive or limiting interaction that is created by a given condition of operation. Modal often describes a secondary window that restricts a user's interaction with other windows. A secondary window can be modal with respect to its primary window or to the entire system. A modal dialog box must be closed by the user before the application continues.
model work order	For scheduled preventive maintenance or for a condition-based alert, a model work order functions as a template for the creation of other work orders. You can assign model work orders to service types and condition-based alerts. When the service type comes due or the alert is generated, the system automatically generates a work order that is based on information from the model work order.
modeless	Not restricting or limiting interaction. Modeless often describes a secondary window that does not restrict a user's interaction with other windows. A modeless dialog box stays on the screen and is available for use at any time, but also permits other user activities.
multiple stocking locations	Authorized storage locations for the same item number at locations, in addition to the primary stocking location.
multitier architecture	A client/server architecture that allows multiple levels of processing. A tier defines the number of computers that can be used to complete some defined task.
named event rules (NER)	Also called business function event rules. Encapsulated, re-usable business logic that is created by using event rules, rather than C programming.
national language support (NLS)	Mechanisms that are provided to facilitate internationalization of both system and application user interfaces.
natureza da operação	Transaction nature. In Brazil, a code that classifies the type of commercial transaction to conform to the fiscal legislation.
negative pay item	An entry in an account that indicates a prepayment. For example, you might prepay a supplier before goods are sent or prepay an employee's forecasted expenses for a business trip. The system stores these pending entries, assigning them a minus quantity as debit amounts in a designated expense account. After the prepaid goods are received or the employee submits an expense report, entering the actual voucher clears all of the negative pay items by processing them as regular pay items. Note that a negative pay item can also result from entering a debit memo (A/P) or a credit memo (A/R).
net added cost	The cost to manufacture an item at the current level in the bill of material. Thus, for manufactured parts, the net added cost includes labor, outside operations, and cost extras applicable to this level in the bill of material, but not materials (lower-level items). For purchased parts, the net added cost also includes the cost of materials.
next status	The next step in the payment process for payment control groups. The next status can be either WRT (write) or UPD (update).
node	A termination point for two or more communications links. A node can serve as the control location for forwarding data among the elements of a network or multiple networks, as well as performing other networking and, in some cases, local processing.

non-inventory items	See non-stock items.
non-list price	A price for bulk products that is determined by its own algorithms, such as a rolling average or commodity price plus.
non-prime product	A manufactured product with revenue potential that is less than the product planned for, or scheduled to be produced.
non-stock items	Items that the system does not account for as part of the inventory. For example, office supplies, or packaging materials can be non-stock items.
nota fiscal	In Brazil, a legal document that must accompany all commercial transactions.
nota fiscal fatura	In Brazil, a nota fiscal and invoice information.
notula	In Italy, the process whereby a business does not recognize value added tax until the payment of a voucher.
object configuration manager (OCM)	EnterpriseOne's object request broker and the control center for the runtime environment. It keeps track of the runtime locations for business functions, data, and batch applications. When one of these objects is called, the Object Configuration Manager directs access to it by using defaults and overrides for a given environment and user.
object embedding	When an object is embedded in another document, an association is maintained between the object and the application that created it; however, any changes made to the object are also only kept in the compound document. See also object linking.
object librarian	A repository of all versions, applications, and business functions that are re-usable in building applications.
object linking	When an object is linked to another document, a reference is created with the file in which the object is stored, as well as with the application that created it. When the object is modified, either from the compound document or directly through the file in which it is saved, the change is reflected in that application as well as anywhere it has been linked. See also object embedding.
object linking and embedding (OLE)	A technology for transferring and sharing information among applications by allowing the integration of objects from diverse applications, such as graphics, charts, spreadsheets, text, or an audio clip from a sound program. OLE is a compound document standard that was developed by Microsoft Corporation. It enables you to create objects with one application, and then link or embed them in a second application. Embedded objects retain their original format and links to the application that created them. See also object embedding, object linking.
object management workbench (OMW)	The change management system that is used for EnterpriseOne development.

object-based technology (OBT)	A technology that supports some of the main principles of object-oriented technology: Classes. Polymorphism.I Inheritance. Encapsulation.
object-oriented technology (OOT)	Brings software development past procedural programming into a world of re-usable programming that simplifies development of applications. Object orientation is based on the following principles: Classes. Polymorphism.I Inheritance. Encapsulation.
offsetting account	An account that reduces the amount of another account to provide a net balance. For example, a credit of 200 to a cash account might have an offsetting entry of 200 to an A/P Trade (liability) account.
open database connectivity (ODBC)	Defines a standard interface for different technologies to process data between applications and different data sources. The ODBC interface comprises set of function calls, methods of connectivity, and representation of data types that define access to data sources.
open systems interconnection (OSI)	The OSI model was developed by the International Standards Organization (ISO) in the early 1980s. It defines protocols and standards for the interconnection of computers and network equipment.
order detail line	A part of an order that contains transaction information about a service or item being purchased or sold, such as quantity, cost, price, and so on.
order hold	A flag that stops the processing of an order because it has exceeded the credit or budget limit, or has another problem.
order-based pricing	Pricing strategy that grants reductions in price to a customer. It is based upon the contents and relative size (volume or value) of the order as a whole.
outbound document	A document that is sent to a trading partner using EDI. This term is also referred to as an outbound transaction.

outturn	The quantity of oil that is actually received into a buyer's storage tanks when a vessel is unloaded. For various reasons (vaporization, clingage to vessel tank walls, and so on), the amount of a product pumped into shore tankage at unloading is often less than the quantity originally loaded onto the vessel, as certified by the Bill of Lading. Under a delivered or CIF outturn transaction, the buyer pays only for the barrels actually "turned out" by the vessel into storage. When a buyer is paying CIF Bill of Lading figures, a loss of 0.5% of total cargo volume is considered normal. Losses in excess of 0.5%, however, are either chargeable to the seller or are covered by specialized insurance that covers partial, as well as total, loss of the cargo.
overhead	In the distillation process, that portion of the charge that leaves the top of the distillation column as vapor. This definition is strictly as it relates to ECS.
override conversion method	A method of calculating exchange rates that is set up between two specific currencies. For those specific currencies, this method overrides the conversion method in General Accounting Constants and does not allow inverse rates to be used when calculating currency amounts.
package / package build	A collection of software that is grouped into a single entity for modular installation. EnterpriseOne objects are installed to workstations in packages from the deployment server. A package can be compared to a bill of material or kit that indicates the necessary objects for that workstation and where the installation program can find them on the deployment server. It is a point-in-time "snapshot" of the central objects on the deployment server.
package location	The directory structure location for the package and its set of replicated objects. This location is usually \\deployment server\release\path_code\package\ package name. The replicated objects for the package are placed in the subdirectories under this path. This location is also where the package is built or stored.
package workbench	During the Installation Workbench process, Package Workbench transfers the package information tables from the Planner data source to the System - release number data source. It also updates the Package Plan detail record to reflect completion.
packaged products	Products that, by their nature, must be delivered to the customer in containers which are suitable for discrete consumption or resale.
pane/panel	A resizable subarea of a window that contains options, components, or other related information.
paper clip	An icon that is used to indicate that a media object is attached to a form or record.
parent/child form	A type of form that presents parent/child relationships in an application on one form: The left portion of the form presents a tree view that displays a visual representation of a parent/child relationship. The right portion of the form displays a detail area in browse mode. The detail area displays the records for the child item in the tree. The parent/child form supports drag and drop functionality.

parent/child relationship	See parent/component relationship.
parent/component relationship	1. In Capital Asset Management, the hierarchical relationship of a parent piece of equipment to its components. For example, a manufacturing line could be a parent and the machinery on the line could be components of the line. In addition, each piece of machinery could be a parent of still more components.

2. In Product Data Management, a hierarchical relationship of the components and subassemblies of a parent item to that parent item. For example, an automobile is a parent item; its components and subassemblies include: engine, frame, seats, and windows.

Sometimes referred to as parent/child relationship. |
partita IVA	In Italy, a company fiscal identification number.
pass-through	A process where data is accepted from a source and forwarded directly to a target without the system or application performing any data conversion, validation, and so on.
pay on consumption	The method of postponing financial liability for component materials until you issue that material to its consuming work order or rate schedule.
payment group	A system-generated group of payments with similar information, such as a bank account. The system processes all of the payments in a payment group at the same time.
PeopleSoft database	See JDEBASE Database Middleware.
performance tuning	The adjustments that are made for a more efficient, reliable, and fast program.
persistent object	An object that continues to exist and retains its data beyond the duration of the process that creates it.
pervasive device	A type of intelligent and portable device that provides a user with the ability to receive and gather information anytime, from anywhere.
planning family	A means of grouping end items that have similarity of design or manufacture.
plug-in	A small program that plugs into a larger application to provide added functionality or enhance the main application.
polymorphism	A principle of object-oriented technology in which a single mnemonic name can be used to perform similar operations on software objects of different types.
portal	A Web site or service that is a starting point and frequent gateway to a broad array of on-line resources and services.
Postfinance	A subsidiary of the Swiss postal service. Postfinance provides some banking services.

potency	Identifies the percent of an item in a given solution. For example, you can use an 80% potent solution in a work order that calls for 100% potent solution, but you would use 25% more, in terms of quantity, to meet the requirement (100 / 80 = 1.25).
preference profile	The ability to define default values for specified fields for a user defined hierarchy of items, item groups, customers, and customer groups. In Quality Management setup, this method links test and specification testing criteria to specific items, item groups, customers, or customer groups.
preflush	A work order inventory technique in which you deduct (relieve) materials from inventory when the parts list is attached to the work order or rate schedule.
preventive maintenance cycle	The sequence of events that make up a preventive maintenance task, from its definition to its completion. Because most preventive maintenance tasks are commonly performed at scheduled intervals, parts of the preventive maintenance cycle repeat, based on those intervals.
preventive maintenance schedule	The combination of service types that apply to a specific piece of equipment, as well as the intervals at which each service type is scheduled to be performed.
primary service type	A service type to which you can link related service types. For example, for a particular piece of equipment, you might set up a primary service type for a 1000-hour inspection and a linked service type for a 500-hour inspection. The 1000-hour inspection includes all of the tasks performed at 500 hours. When a primary service type is scheduled to be performed, the system schedules the linked service type. See also linked service type.
pristine environment	An EnterpriseOne environment that is used to test unaltered objects with PeopleSoft demonstration data or for training classes. You must have this environment so you can compare pristine objects that you modify.
processing option	A data structure that allows users to supply parameters that regulate the execution of a batch program or report.
product data management (PDM)	In PeopleSoft EnterpriseOne software, the system that enables a business to organize and maintain information about each item which it manufactures. Features of this system, such as bills of material, work centers, and routings, define the relationships among parents and components, and how they can be combined to manufacture an item. PDM also provides data for other manufacturing systems including Manufacturing Accounting, Shop Floor Management, and Manufacturing and Distribution Planning.
product line	A group of products with similarity in manufacturing procedures, marketing characteristics, or specifications that allow them to be aggregated for planning; marketing; and, occasionally, costing.
product/process definition	A combination of bill of material (recipe, formula, or both) and routing (process list). Organized into tasks with a statement of required consumed resources and produced resources.
production environment	An EnterpriseOne environment in which users operate EnterpriseOne software.

program temporary fix (PTF)	A representation of changes to PeopleSoft software that your organization receives on magnetic tapes or diskettes.
project	[In EnterpriseOne] A virtual container for objects being developed in Object Management Workbench.
projected cost	The target expenditure in added value for material, labor, and so on, during manufacture. See also standard cost.
promotion path	The designated path for advancing objects or projects in a workflow.
protocollo	See registration number.
PST	Provincial sales tax. A tax that is assessed by individual provinces in Canada.
published table	Also called a "Master" table, this is the central copy to be replicated to other machines and resides on the "publisher" machine. The Data Replication Publisher Table (F98DRPUB) identifies all of the published tables and their associated publishers in the enterprise.
publisher	The server that is responsible for the published table. The Data Replication Publisher Table (F98DRPUB) identifies all of the published tables and their associated publishers in the enterprise.
pull replication	One of the EnterpriseOne methods for replicating data to individual workstations. Such machines are set up as pull subscribers that use EnterpriseOne's data replication tools. The only time that pull subscribers are notified of changes, updates, and deletions is when they request such information. The request is in the form of a message that is sent, usually at startup, from the pull subscriber to the server machine that stores the Data Replication Pending Change Notification table (F98DRPCN).
query by example (QBE)	Located at the top of a detail area, this area is used to search for data to display in the detail area.
rate scheduling	A method of scheduling product or manufacturing families, or both. Also a technique to determine run times and quantities of each item within the family to produce enough of each individual product to satisfy demand until the family can be scheduled again.
rate type	For currency exchange transactions, the rate type distinguishes different types of exchange rates. For example, you can use both period average and period-end rates, distinguishing them by rate type.
real-time	Pertaining to information processing that returns a result so rapidly that the interaction appears to be instantaneous.
receipt routing	A series of steps that is used to track and move items within the receipt process. The steps might include in-transit, dock, staging area, inspection, and stock.
referential integrity	Ensures that a parent record cannot be deleted from the database when a child record for exists.

regenerable	Source code for EnterpriseOne business functions can be regenerated from specifications (business function names). Regeneration occurs whenever an application is recompiled, either for a new platform or when new functionality is added.
register types and classes	In Italian VAT Summary Reporting, the classification of VAT transactions.
relationship	Links tables together and facilitates joining business views for use in an application or report. Relationships that are created are based on indexes.
rélevé d'identité bancaire (RIB)	In France, the term that indicates the bank transit code, account number, and check digit that are used to validate the bank transit code and account number. The bank transit code consists of the bank code and agency code. The account number is alphanumeric and can be as many as 11 characters. PeopleSoft supplies a validation routine to ensure RIB key correctness.
remessa	In Brazil, the remit process for A/R.
render	To include external data in displayed content through a linking mechanism.
repasse	In Brazil, a discount of the ICMS tax for interstate transactions. It is the adjustment between the interstate and the intrastate ICMS tax rates.
replenishment point	The location on or near the production line where additional components or subassemblies are to be delivered.
replication server	A server that is responsible for replicating central objects to client machines.
report design aid (RDA)	The EnterpriseOne GUI tool for operating, modifying, and copying report batch applications.
repost	In Sales, the process of clearing all commitments from locations and restoring commitments, based on quantities from the Sales Order Detail table (F4211).
resident	Pertaining to computer programs or data while they remain on a particular storage device.
retorno	In Brazil, the receipt process for A/R.
RIB	See rélevé d'identité bancaire.
ricevute bancarie (RiBa)	In Italy, the term for accounts receivable drafts.
riepilogo IVA	Summary VAT monthly report. In Italy, the term for the report that shows the total amount of VAT credit and debit.
ritenuta d'acconto	In Italy, the term for standard withholding tax.
rollback	[In database management] A feature or command that undoes changes in database transactions of one or more records.
rollup	See cost rollup.

row exit	[In EnterpriseOne] An application shortcut, available as a button on the Row Exit bar or as a menu selection, that allows users to open a form that is related to the highlighted grid record.
runtime	The period of time when a program or process is running.
SAD	The German name for a Swiss payment format that is accepted by Postfinance.
SAR	See software action request.
scalability	The ability of software, architecture, hardware, or a network to support software as it grows in size or resource requirements.
scripts	A collection of SQL statements that perform a specific task.
scrub	To remove unnecessary or unwanted characters from a string.
search/select	A type of form that is used to search for a value and return it to the calling field.
selection	Found on PeopleSoft menus, selections represent functions that you can access from a menu. To make a selection, type the associated number in the Selection field and press Enter.
serialize	To convert a software object into a stream of bytes to store on a disk or transfer across a network.
server map	The server view of the object configuration mapping.
server workbench	During the Installation Workbench process, Server Workbench copies the server configuration files from the Planner data source to the System release number data source. It also updates the Server Plan detail record to reflect completion.
service interval	The frequency at which a service type is to be performed. Service intervals can be based on dates, periods, or statistical units that are user defined. Examples of statistical units are hours, miles, and fuel consumption.
service type	An individual preventive maintenance task or procedure, such as an inspection, lubrication, or overhaul. Service types can apply to a specific piece of equipment or to a class of equipment. You can specify that service types come due based on a predetermined service interval, or whenever the task that is represented by the service type becomes necessary.
servlet	A [small] program that extends the functionality of a Web server by generating dynamic content and interacting with Web clients by using a request-response paradigm.
share path	The network node under which one or more servers or objects reside.
shop floor management	A system that uses data from multiple system codes to help develop, execute, and manage work orders and rate schedules in the enterprise.
silent mode	A method for installing or running a program that does not require any user intervention.

silent post	A type of post that occurs in the background without the knowledge of the user.
simulated cost	After a cost rollup, the cost of an item, operation, or process according to the current cost scenario. This cost can be finalized by running the frozen update program. You can create simulated costs for a number of cost methods—for example, standard, future, and simulated current costs. See also cost rollup.
single-byte character set (SBCS)	An encoding scheme in which each alphabetic character is represented by one byte. Most Western languages, such as English, can be represented by using a single-byte character set.
single-level tracking	Finding all immediate parents where a specific lot has been used (consumed).
single-voyage (spot) charter	An agreement for a single voyage between two ports. The payment is made on the basis of tons of product delivered. The owner of the vessel is responsible for all expenses.
slimer	A script that changes data in a table directly without going through a regular database interface.
smart field	A data dictionary item with an attached business function for use in the Report Design Aid application.
SOC	The Italian term for a Swiss payment format that is accepted by Postfinance.
soft commitment	The number of items that is reserved for sales orders or work orders in the primary units of measure.
soft error	An error from which an operating system or program is able to recover.
software action request (SAR)	An entry in the AS/400 database that is used for requesting modifications to PeopleSoft software.
SOG	The French term for a Swiss payment format that is accepted by Postfinance.
source directory	The path code to the business function source files belonging to the shared library that is created on the enterprise server.
special period/year	The date that determines the source balances for an allocation.
specification merge	The Specification merge is comprised of three merges: Object Librarian merge (via the Object Management Workbench). Versions List merge. Central Objects merge. The merges blend customer modifications with data that accompanies a new release.
specification table merge workbench	During the Installation Workbench process, Specification Table Merge Workbench runs the batch applications that update the specification tables.

specifications	A complete description of an EnterpriseOne object. Each object has its own specification, or name, which is used to build applications.
spot charter	See single-voyage charter.
spot rates	An exchange rate that is entered at the transaction level. Spot rates are not used on transactions between two EMU member currencies because exchange rates are irrevocably fixed to the euro.
stamp tax	In Japan, a tax that is imposed on drafts payable, receipts over 30000 Japanese yen, and all contracts. The party that issues any of the above documents is responsible for this tax.
standalone	Operating or capable of operating independently of certain other components of a computer system.
standard cost	The expected, or target cost of an item, operation, or process. Standard costs represent only one cost method in the Product Costing system. You can also calculate, for example, future costs or current costs. However, the Manufacturing Accounting system uses only standard frozen costs.
standard costing	A costing method that uses cost units that are determined before production. For management control purposes, the system compares standard costs to actual costs and computes variances.
subprocess	A process that is triggered by and is part of a larger process, and that generally consists of activities.
subscriber table	The Subscriber table (F98DRSUB), which is stored on the Publisher Server with the Data Replication Publisher table (F98DRPUB), that identifies all of the subscriber machines for each published table.
summary	The presentation of data or information in a cumulative or totaled manner in which most of the details have been removed. Many systems offer forms and reports that summarize information which is stored in certain tables. Contrast with detail.
super backflush	To create backflush transactions for material, labor, or both, against a work order at predefined pay points in the routing. By doing so, you can relieve inventory and account for labor amounts at strategic points throughout the manufacturing process.
supersession	Specification that a new product is replacing an active product on a specified effective date.
supplemental data	Additional types of data for customers and suppliers. You can enter supplemental data for information such as notes, comments, plans, or other information that you want in a customer or supplier record. The system maintains this data in generic databases, separate from the standard master tables (Customer Master, Supplier Master, and Address Book Master).

supplying location	The location from which inventory is transferred once quantities of the item on the production line have been depleted. In kanban processing, the supplying location is the inventory location from which materials are transferred to the consuming location when the containers are replenished.
system code	A numeric or alphanumeric designation that identifies a specific system in EnterpriseOne software.
system function	[In EnterpriseOne] A named set of pre-packaged, re-usable instructions that can be called from event rules.
table access management (TAM)	The EnterpriseOne component that handles the storage and retrieval of user defined data. TAM stores information such as data dictionary definitions; application and report specifications; event rules; table definitions; business function input parameters and library information; and data structure definitions for running applications, reports, and business functions.
table conversion workbench	During the Installation Workbench process, Table Conversion Workbench runs the table conversions that change the technical and application tables to the format for the new release of EnterpriseOne. It also updates the Table Conversions and Controls detail records to reflect completion.
table design aid (TDA)	An EnterpriseOne GUI tool for creating, modifying, copying, and printing database tables.
table event rules	Use table event rules to attach database triggers (or programs) that automatically run whenever an action occurs against the table. An action against a table is referred to as an event. When you create an EnterpriseOne database trigger, you must first determine which event will activate the trigger. Then, use Event Rules Design to create the trigger. Although EnterpriseOne allows event rules to be attached to application events, this functionality is application-specific. Table event rules provide embedded logic at the table level.
table handle	A pointer into a table that indicates a particular row.
table space	[In relational database management systems] An abstract collection of containers in which database objects are stored.
task	[In Solution Explorer and EnterpriseOne Menu] A user defined object that can initiate an activity, process, or procedure.
task view	A group of tasks in Solution Explorer or EnterpriseOne Menu that are arranged in a tree structure.
termo de abertura	In Brazil, opening terms for the transaction journal.
termo de encerramento	In Brazil, closing terms for the transaction journal.
three-tier processing	The task of entering, reviewing, approving, and posting batches of transactions.
three-way voucher match	The process of comparing receipt information to supplier's invoices to create vouchers. In a three-way match, you use the receipt records, the purchase order, and the invoice to create vouchers.

threshold percentage	In Capital Asset Management, the percentage of a service interval that you define as the trigger for maintenance to be scheduled. For example, you might set up a service type to be scheduled every 100 hours with a threshold percentage of 90 percent. When the equipment accumulates 90 hours, the system schedules the maintenance.
throughput agreement	A service agreement in which a business partner agrees to store and manage product for another business partner for a specified time period. The second partner actually owns the stock that is stored in the first partner's depot, although the first partner monitors the stock level; suggests replenishments; and unloads, stores, and delivers product to the partner or its customers. The first partner charges a fee for storing and managing the product.
throughput reconciliation	Reconcile confirmed sales figures in a given period with the measured throughput, based on the meter readings. This process is designed to catch discrepancies that are due to transactions not being entered, theft, faulty meters, or some combination of these factors. This reconciliation is the first stage. See also operational reconciliation.
token	[In Object Management Workbench] A flag that is associated with each object which indicates whether you can check out the object.
tolerance range	The amount by which the taxes that you enter manually can vary from the tax that is calculated by the system.
TP monitor	Transaction Processing monitor. A monitor that controls data transfer between local and remote terminals and the applications that originated them. TP monitors also protect data integrity in the distributed environment and can include programs that validate data and format terminal screens.
tracing	The act of researching a lot by going backward, to discover its origin.
tracking	The act of researching a lot by going forward, to discover where it is used.
transaction set	An electronic business transaction (EDI Standard document) composed of segments.
transclude	To include the external data in the displayed content through a linking mechanism.
transfer order	An order that is used to ship inventory between branch/plants within your company and to maintain an accurate on-hand inventory amount. An interbranch transfer order creates a purchase order for the shipping location and a sales order for the receiving location.
translation adjustment account	An optional G/L account used in currency balance restatement to record the total adjustments at a company level.
translator software	The software that converts data from an application table format to an EDI Standard Format, and from EDI Standard Format to application table format. The data is exchanged in an EDI Standard, such as ANSI ASC X12, EDIFACT, UCS, or WINS.

tree structure	A type of graphical user interface that displays objects in a hierarchy.
trigger	Allows you to attach default processing to a data item in the data dictionary. When that data item is used on an application or report, the trigger is invoked by an event which is associated with the data item. EnterpriseOne also has three visual assist triggers: Calculator. Calendar. Search form.
two-way voucher match	The process of comparing purchase order detail lines to the suppliers' invoices to create vouchers. You do not record receipt information.
universal batch engine (UBE)	[In EnterpriseOne] A type of application that runs a noninteractive process.
unnormalized	Data that is a random collection of data elements with repeating record groups scattered throughout. Also see Normalized.
user overrides merge	The User Overrides merge adds new user override records into a customer's user override table.
user-defined code (UDC)	A value that a user has assigned as being a valid entry for a given or specific field.
utility	A small program that provides an addition to the capabilities which are provided by an operating system.
variable numerator allocations	A procedure that allocates or distributes expenses, budgets, adjustments, and so on, among business units, based on a variable.
variable quantity	A term that indicates the bill of material relationship between a parent item and its components or ingredients. When a bill of material component has a variable quantity relationship to its parent, the amount of the component changes when the software calculates parts list requirements for different work order quantities. Contrast with fixed quantity.
variance	1. In Product Costing and Manufacturing Accounting, the difference between the frozen standard cost, the current cost, the planned cost, and the actual cost. For example, the difference between the frozen standard cost and the current cost is an engineering variance. Frozen standard costs come from the Cost Components table, and the current costs are calculated by using the current bill of material, routing, and overhead rates. 2. In Capital Asset Management, the difference between revenue that is generated by a piece of equipment and costs that are incurred by the equipment.
versions list merge	The Versions List merge preserves any non-XJDE and non-ZJDE version specifications for objects that are valid in the new release as well as their processing options data.
VESR	Verfahren Einzahlungsschein mit Referenznummer. The processing of an ESR pay slip with reference line through accounts receivable and accounts payable.

visual assist	Forms that can be invoked from a control to assist the user in determining what data belongs in the control.
voucher logging	The process of entering vouchers without distributing amounts to specific G/L accounts. The system initially distributes the total amount of each voucher to a G/L suspense account, where it is held until you redistribute it to the correct G/L account.
wareki date format	In Japan, a calendar format, such as Showa or Heisei. When a new emperor begins to reign, the government chooses the title of the date format and the year starts over at one. For instance, January 1, 1998, is equal to Heisei 10, January 1st.
wash down	A minor cleanup between similar product runs. Sometimes used in reference to the sanitation process of a food plant.
wchar_t	An internal type of a wide character. Used for writing portable programs for international markets.
web server	A server that sends information as requested by a browser and uses the TCP/IP set of protocols.
work order life cycle	In Capital Asset Management, the sequence of events through which a work order must pass to accurately communicate the progress of the maintenance tasks that it represents.
workfile	A system-generated file that is used for temporary data processing.
workflow	According to the Workflow Management Coalition, worlflow means "the automation of a business process, in whole or part, during which documents, information, or tasks are passed from one participant to another for action, according to a set of procedural rules."
workgroup server	A network server usually containing subsets of data that are replicated from a master network server.
WorldSoftware architecture	The broad spectrum of application design and programming technology that PeopleSoft uses to achieve uniformity, consistency, and complete integration throughout its software.
write payment	A step in processing payments. Writing payments includes printing checks, drafts, and creating a bank tape table.
write-off	A method for getting rid of inconsequential differences between amounts. For example, you can apply a receipt to an invoice and write off the difference. You can write off both overpayments and underpayments.

Z file	For store and forward (network disconnected) user, EnterpriseOne store-and-forward applications perform edits on static data and other critical information that must be valid to process an order. After the initial edits are complete, EnterpriseOne stores the transactions in work tables on the workstation. These work table are called Z files. When a network connection is established, Z files are uploaded to the enterprise server; and the transactions are edited again by a master business function. The master business function then updates the records in your transaction files.
z-process	A process that converts inbound data from an external system into an EnterpriseOne software table or converts outbound data into an interface table for an external system to access.
zusammenfassende melding	In Germany, the term for the EU Sales Listing.

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