Just-in-time/Repetitive Manufacturing Run Instructions

Publication Information

Document code	UjitA US
Release	8.4
Publication date	December 5, 2023

Change History

Rv.		Date	Au-thor	Name	Description	Reqmt.	Project	Page
1	Added	2012-02-01	MGetty	MR76077	Action code 22=Serial Numbers	REQ_ 00111	STTi	*119*

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Chapter 1
Introduction to Infor LX

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Overview of Infor LX

This topic contains information that pertains to all applications of the Infor LX product. This information enables you to perform the following tasks:

- Navigate through menus and screens
- Specify information in the fields on the screens
- Use the screen actions
- Access the online help text
- Become familiar with terms used throughout Infor LX

Navigation

The features described in the following paragraphs help you navigate within and between Infor LX screens and programs quickly and easily.

Menus

Use Infor LX menus to choose individual programs to process or view information. You can call individual applications directly from any menu.

Dates

Infor LX includes full support for dates up to and beyond the year 2000. Although most date fields display six characters, Infor LX stores the date as eight characters to include century information. Use Company Name and Date Format, SYS820, in the System Parameters Generation program, SYS800, to configure century dates and specify dates beyond 1999.

Attention key and quick access icon

The character-based user interface uses the attention key to directly access other programs, menus, and applications. On an Infor LX screen, press the Esc key.

The Webtop user interface uses the Quick Access icon to directly access programs. On an Infor LX screen, click the Quick Access icon.

You must have security authorization to use these features.

Look-up features

On the character-based user interface, a plus sign (+) indicates a prompt-capable field. Use F4 to display a look-up screen.

On the Webtop user interface, an arrow indicates a prompt-capable field. Click the arrow to display a look-up screen.

Most screens called from inquiry programs allow you to search for alphanumeric strings.

Remembered keys

Infor LX remembers certain key values, such as item number, salesperson, or container, in your workstation memory as you process information in certain programs. You can assign one of the following values to each field:

- 0. Infor LX automatically retrieves this value from remember key memory. Infor LX updates this value on a continual basis.
- 1. Infor LX automatically retrieves the value you specify in Display Remembered Keys, SYS080. It does not update the value from any other program.
- 2. Infor LX does not retrieve or update remembered key fields.

Use the Display Remembered Keys program, SYS080, to set up remembered keys.

Standard online help features

Many Infor LX programs display generic help text. Use F1 from within a field on the character-based user interface. Click the Show/Hide Help icon on the Webtop user interface. This generic help text includes help for standard line actions, standard screen actions, which are also called function keys or F keys, the run time parameter, and some screens types.

The information in the generic help text for line actions and screen actions in this document is not included in the help text for individual Infor LX programs and screens. If a line action or screen action other than those defined in the generic help text occurs in a program, the help text for that program describes the specific action.

Additional generic help text is stored in the SSARUNHT document for users of the character-based UI. You can print this document and the individual application run instructions, SSARUN01, SSARUN02, and so on, from the DOC menu on the IBM(R) iSeries(TM) in the character-based user interface.

Generic help text for line actions

Line actions

The following line actions are valid in numerous screens. They have the functions described in the following sections.

1=Create

Specify Create on the prompt line and a value in at least one key field to add new information to the file. The system displays maintenance screens on which you can specify the new data. The system prints the new data on the audit report.

Note: You cannot specify Create next to existing data.

1=Select

On a prompt screen, specify 1 to return the selected data to the original screen.

2=Revise

Specify Revise to change the information for a line. Specify 2 and a value in at least one key field or specify 2 next to a line. The audit report lists the change. If you specify Revise next to a line with inactive information, the system reactivates the information.

3=Copy

Specify Copy to copy existing information. You can specify 3 and a value for at least one key field or you can specify 3 next to a line. The system displays a maintenance screen on which you can specify new data and change existing data.

4=Delete

Specify Delete to deactivate the information on a line. You can specify 4 and a value in the key fields or you can specify 4 next to the line to delete. Use Revise to reactivate deleted information.

5=Display

Specify Display to view information. You can specify 5 and a value in the key fields or you can specify 5 next to a line.

6=Print

Specify Print to print information on the audit trail. You can specify 6 and a value in the key fields or you can specify 6 next to a line.

8=Position To

Specify Position To to move a line to the top of the list. You can specify 8 and a value in the key fields or you can specify 8 next to a line. The system repositions the list to begin with the requested line or, if the line does not exist, to the line that is next in sequence.

After you use the Position To feature, you can page down or you can use the Position To action with a different value, but you cannot page up. You can return to the top of the list if you specify Position To but do not specify a value in the key fields on the prompt line.On a prompt screen, display details matching the information you specified.

10=Search

On the top line of a prompt screen, use 10 and known field data to locate specific information.

Additional line actions

If a program contains additional line actions, see the line actions help text in that specific program for descriptions of those line actions.

Generic help text for screen actions

Many screen actions, also called F keys, perform the same function for every program or screen in Infor LX. Definitions for these screen actions follow.

Enter

Proceed to the next screen of a maintenance program. On the final screen, press Enter to update the file and return to the first screen of the program for additional maintenance activity.

Enter

Validate data in a screen. This function of Enter generally occurs in transaction programs that have an F6=Accept screen action, which saves the data on the screen.

Enter

Send the output from a report or listing program to an output queue for processing.

F1=Help

Display help text. This screen action applies to the character-based user interface only.

F3=Exit

Exit a program and do not record, update, or print the information you specified on the program screens.

F4=Prompt

Display a pop-up screen that lists existing values for the field. A plus (+) character denotes a prompt-capable field in the character-based user interface. In the Webtop user interface, the prompt-capable field has a small arrow that points to the right .

F5=Refresh

On a list screen, redisplay the screen to check the status of an executed function.

On a maintenance screen, redisplay the original values on the screen.

F6=Accept

Accept your changes and exit the program.

F7=Backward

Display previous lines, that is, those alphanumerically closer to A or those with earlier dates.

F8=Forward

Display additional lines, that is, those alphanumerically closer to Z or 9, or those with later dates.

F11=Fold

Display a folded view of the screen that contains additional information. Use F11 again to return the screen to its previous format.

F12=Cancel

Return to the previous screen and do not save values you specified on this screen. If you use F12 to return to a selection screen in a maintenance program, you cancel changes you made to any screens in the program.

F23=More Actions

Display additional line actions. If a screen has many screen actions, you may need to press F24 to see that there is an F23 action, which indicates that additional line actions are available.

F24=More Keys

Display additional function keys.

Generic help text for standard screens

Several categories of screens have identical functionality, though the content differs. These types of screens are explained in the following sections.

Generic help text for list screens

Many Infor LX programs contain screens with lists of information to specify for maintenance or inquiry. You have two options to specify the information to process on a list screen:

- Use the Act field and the key fields that appear at the top of the list.
- Specify a line action in the Act field of the line with the information you want to process.

After you make your entries, press Enter to perform the line action.

Generic help text for filter screens

Some Infor LX programs feature a filter screen, which you can access with F13. The filter screen enables you to filter the data to display. For example, if you use F13 in Warehouse Master Maintenance, INV110, you can display all records by warehouse or active records by warehouse or active records by description. Some filter screens provide sort or sequence options.

Generic help text for the run time parameter

Run Time Parameter (1,0):

Specify interactive to process the data in real time or batch to process the data in the job queue. If you specify interactive processing, your session is unavailable for other tasks until the job finishes.

Infor LX menus

This section describes the menus in Infor LX.

ERPLX main menu

The ERPLX Main Menu is the first of five master menus. You can access the four major Infor LX application groups from this menu:

- Configurable Enterprise Financials, CEF
- Multi-Mode Manufacturing, MMM
- Supply Chain Management, SCM
- Cross-Product Applications, XPA

Specify the abbreviated application group fast path code to access the master menu for the desired application group.

Configurable enterprise financials menu

Use the Configurable Enterprise Financials menu, CEF, to access Infor LX financial applications. Specify the application fast path code to access the desired application menu.

Multi-mode manufacturing master menu

Use the Multi-Mode Manufacturing master menu, MMM, to access Infor LX manufacturing applications. Specify the application fast path code to access the desired Infor LX application menu.

Supply chain management master menu

Use the Supply Chain Management master menu, SCM, to access Infor LX supply chain management applications. Specify the application fast path code to access the desired Infor LX application menu.

Cross-product application menu

Use the Cross Product Application menu, XPA, to access, analyze, and transmit information within Infor LX. Specify the application fast path code to access the desired Infor LX application menu.

Commonly used terms in Infor LX

Reference only

Reference only indicates that the system uses the information for the given field only for reference and does not use it for processing.

Extreme values by default

Some fields display extreme values by default. The system uses an alphanumeric or numeric extreme in these fields if you do not override the value. Use these default values, which are usually specified as ranges, to include all information in the range. The defaults values or any other values specified to designate a range do not have to be valid values in a database file.

(Y/blank)

If the screen displays (Y/blank) for a field, specify Y or Yes for a particular action to take place. Otherwise, leave the field blank. The screen displays (Y/N) if the field requires a Y or an N.

Ranges

Ranges refer to fields you can use to limit an inquiry or report or to display specific data. If there are multiple range fields in a program, you can tailor your inquiry or report to produce only the data you need.

Infor LX sorts the information alphanumerically. Therefore, the value in the From field must be a lower alphanumeric value than the value in the To field.

Infor LX usually inserts extreme values as defaults in the lower and upper fields. See the description for Extreme values by default. The entries you make in range fields do not have to be valid values in a database file.

Review the following suggestions to limit the information:

Specify the first value to include on the inquiry or report in the From field. Leave the To field blank to include all information to the end of the file. For example, you can print a report that starts with the customer number you specify in the From field and stops at the end of the Customer Master file.

Specify the last value to include on the inquiry or report in the To field. Leave the From field blank to start at the beginning of the file. For example, you can perform an inquiry that starts with the beginning of the Customer Master file and ends with the customer number you specify in the *To* field.

Specify the same value in both the *From* and *To* fields. For example, you can limit a display to one customer.

To include a group of items, specify a value in the *From* field and another value in the *To* field. For example, you can perform an inquiry that starts with the first of the month and ends with the last day of the month.

Alphanumeric

Alphanumeric refers to text that contains letters, letters and numbers together, and numbers arranged uniformly with special characters, such as dates in MM/DD/YY format. Infor LX sorts reports and inquiries in ascending alphanumeric order, unless indicated otherwise. Ascending order arranges items from the lowest value to the highest value. Alphanumeric text is sorted in ascending order according to the following rules:

- Special characters, such as $, %, - (hyphen), comma, and period, come before all others
- Lowercase letters come before uppercase letters
- Uppercase letters come before numbers
- Numbers, that is, 0 through 9, come last

A/R, A/P

The documentation uses the abbreviations A/R and A/P to denote the terms accounts receivable and accounts payable, respectively. The abbreviations distinguish the terms from the corresponding program indicators of ACR, and ACP, which precede program numbers, for example, ACR500 and ACP150.

Ranges

Ranges refer to fields you can use to limit an inquiry or report or to display specific data. If there are multiple range fields in a program, you can tailor your inquiry or report to produce only the data you need.

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Infor LX usually inserts extreme values as defaults in the lower and upper fields. See the description for Extreme values by default. The entries you make in range fields do not have to be valid values in a database file.

Review the following suggestions to limit the information:

Specify the first value to include on the inquiry or report in the From field. Leave the To field blank to include all information to the end of the file. For example, you can print a report that starts with the customer number you specify in the From field and stops at the end of the Customer Master file.

Specify the last value to include on the inquiry or report in the To field. Leave the From field blank to start at the beginning of the file. For example, you can perform an inquiry that starts with the beginning of the Customer Master file and ends with the customer number you specify in the *To* field.

Specify the same value in both the *From* and *To* fields. For example, you can limit a display to one customer.

To include a group of items, specify a value in the *From* field and another value in the *To* field. For example, you can perform an inquiry that starts with the first of the month and ends with the last day of the month.

Chapter 2
JIT Overview

2

General instructions

This document includes the following topics:

- How-to index lists the programs you can use to set up and run JIT processing.
- System function introduces and describes critical features of the system.
- System flow describes a general sequence you can use to execute the programs. The system flow also describes the procedural relationships between the programs.
- Material allocations and issues logic describes the logic used to issue components from the available inventory allocations.
- Help text provides the detailed operating instructions for each program. The sequence used to present these programs reflects the operating sequence described in the System Flow section.

How-to Index

The following list provides a quick reference to the processes that you can perform in this application. The list also includes programs in related applications

- Add and maintain bill of material - BOM500
- Add and maintain firm-planned orders - JIT510
- Add and maintain production reporting - JIT600
- Cancel firm-planned orders - JIT510
- Delete production reporting - JIT600
- Department maintenance - CAP120
- Define to and from locations - INV170
- Define period length, repetitive - SYS800
- Generate inventory allocations - JIT550
- Group technology report - CAP240
- IDF Enterprise Item

- Location maintenance - INV170
- Material status inquiry - INV300
- Override due date for released orders - JIT540
- Override quantity for released orders - JIT540
- Override warehouse for released orders - INV170
- Perform inv. allocations/released orders - JIT550
- Planning inquiry - MRP300
- Post labor tickets - JIT600
- Print allocation detail report - JIT270
- Print cumulative production by item report - JIT210
- Print cumulative costs by item report - JIT220
- Print cumulative purchasing by item - JIT260
- Print employee efficiency report - JIT280
- Print downtime analysis report - JIT230
- Print Kanban cards - JIT550
- Print production posting report - JIT600
- Print production purchasing planning report - JIT220
- Print shop floor QC/Reject analysis report - JIT240
- Print shop packet - JIT550
- Print yield analysis by operation - JIT250
- Production posting - JIT600
- Production report - JIT600
- Report downtime and quantity rejected - JIT600
- Report machine, labor, and run time - JIT600
- Routing maintenance - SFC100, SFC500
- Select plnd. prod. runs/release to shp. flr. - JIT540
- Set component issuing operation - BOM500, SFC500
- Set item JIT code - IDF Enterprise Item
- Set order policy - IDF Enterprise Item, Facility Items
- Set warehouse default for inventory issue - Facility Items
- Shop packet print - JIT550
- View production inquiry - JIT300
- Warehouse maintenance - INV110
- Warehouse planning maintenance - Facility Items
- Work center maintenance - CAP100

System functions

Infor LX For Just-In-Time (JIT) Manufacturing provides manufactures with a variety of new business processes, but maintains traditional goals. To be competitive, businesses must continue to find ways to improve their costs, quality, and customer service.

Each business has its own expectation for JIT manufacturing: improved profitability, paperless factories, instantaneous production, no inventory investment, Kanban cards, Total Quality, and on-time vendors.

What Is Just-In-Time?

Just-in-Time (JIT) is a management philosophy that focuses on minimizing the resources necessary to add value to your products and to operate your factory in ways that eliminate waste. Resources are labor, materials, equipment, space, and time. Waste is anything that does not add value to your products. Moving work-in-process from place to place, stacking and sorting, investing capital in large work-in-process and raw material inventories, inspecting materials at your vendors' sites, and tying up warehouse space with finished goods are all activities that add cost, not value, to your products.

JIT is a process that reduces lead time. JIT does not replace an MRP, an inventory program, a scheduling technique to bypass your Master Schedule, or a materials management project. JIT is the never-ending commitment of everyone, from top management to your workers on the floor, to maximize your effectiveness through continuous, incremental improvements.

Progress with Problem Solving and Work Improvement

Manufacturers have recognized the dramatic productivity improvements that result when they test Master Schedules to ensure that the schedules are doable. Manufacturers use rough-cut capacity planning to ensure that the bottleneck resources are not overloaded. The result is improved delivery performance, reduced work-in-process inventory, and increased productivity. Problems remain covered up by excess materials, workers, space, etc. In addition to the hidden problems, manufacturers miss thousands of opportunities for other potential improvements.

The following list describes typical problems:

- Machine breakdowns
- High scrap and rework
- Bad raw materials
- No repair parts for machines
- Worn tooling
- Worker tardiness and absenteeism
- Late arrival of parts
- Material handling delays
- Untrained workers

- Waits for inspection or setup people

Traditional manufacturing has attempted to solve problems by using the following methods:

- Buffer stock at each work station

- Backup machines or elaborate, multi-functional machines

- Excess material handling equipment and people

- Excess tooling

- Excess repair parts

- Excess workers

- Elaborate tracking and information systems

Another way to look at JIT is to equate it with enforced problem solving. By eliminating traditional solutions, we force ourselves to recognize, and solve, our real problems.

The JIT uses the following procedures to expose and solve problems:

- Removing excess materials, space, and workers
- Scheduling each workstation below its capacity to ensure flexibility
- Cross-training and developing multi-functional workers
- Adopting Total preventive maintenance in each work station
- Reducing setup and material movement time
- Adopting a pull approach to production, where work is performed only when the customer needs it
- Continuing to remove the excess little by little, year after year

Attacking problems with common sense has resulted in some truly uncommon results. The people most familiar with the problems are encouraged to solve them. The solutions are usually simple. And the cumulative effect of this effort is an organization able to respond to pressure from competition.

The following list describes the benefits of implementing Just-in-Time procedures:

- Faster cycle times
- Reduced rework
- Minimized costs for engineering changes
- Fewer production line stoppages
- Longer machine life
- Higher product quality
- Improved worker response to real needs for flexibility
- Greater sense of importance felt by workers
- Increased labor productivity
- Increased market responsiveness

Benefits are not only internal. Working on Just-in-Time performance with vendors results in shorter deliveries, better prices, and higher quality.

JIT is real. You can apply JIT principles internationally.

One of the keys to implementing competitive strategies is a competitive manufacturing organization. JIT is the key to unlocking the full potential of your organization.

How Does Infor LX Software Fit In With Just-In-Time?

For years, repetitive manufacturing industries have been applying many of the principles in Just-in-Time philosophy. They have established balanced production lines that depend on a steady flow of material to each work station. They schedule production in daily or weekly rates rather than in discrete shop order lots. They track finished inventory by work center rather than by job. They typically backflush stock balances (decrement stock balances upon completion of specific manufacturing steps rather than issued at the beginning of each production run). Costing is typically based upon a daily rate or hourly rate rather than being associated with specific shop orders.

Repetitive manufacturers use MRP II software adaptable to their environments in the following key areas:

- Product definition
- Inventory tracking
- MRP/Master Scheduling
- Shop Floor Control
- Purchasing
- Costing

The following topics discuss these key areas.

Just-in-Time uses the same types of data processing linkages with additional capabilities for timing the flow through the shop.

Infor LX meets these challenges with integrated manufacturing products that accommodate process, repetitive, and job shop production in Just-in-Time environments and in MRP II environments where the manufacturer has not yet implemented JIT processing.

Infor LX Product Definition

Defining products involves creating three information files that describe:

Material content	bill of material
Sequence of steps	routings
Place the labor is performed	work centers

Users often combine work centers into Group Technology cells for scheduling similar items.

The system uses these three information files for the following activities:

- Scheduling requirements for material and capacity
- Detailed scheduling of shop activity
- Developing standard product costs
- Providing the yardsticks used to track actual costs

Users must be able to relate material to specific routing steps and they must describe each work center in the routing. Each work center definition must include the work center capacity, whether the work center depends on labor hours or machine hours, and a method for absorbing overhead costs.

After you define the product, create a master schedule for the JIT item. Specify the quantity of the item and the system creates planned production to match that quantity. When you release planned production, the system can print Kanban cards along with the shop packet. Use Kanban cards on the shop floor to record the quantity of an item received at a work center and operation from another work center and operation.

Infor LX creates component allocations when you release the planned production. Infor LX generates lower-level issues only when you post production for the appropriate operation as specified on the bill of material.

Infor LX includes the following features that help you to meet these needs:

- Optional JIT Planning by item. You can schedule production for some items by using Just-in-Time scheduling and continue to use standard master scheduling for other items.
- Routing operation reference in the bill of material. The system can backflush component item requirements when you post production activity for a given operation.
- Phantom assembly designation. Identify a transitional component that the manufacturing process generates and completely consumes. For example, designate a phantom assembly for transitional components for which you do not want to generate component requirements.
- Work center capacity loading codes. These codes help you to determine the type of labor used at each work center.
- Overhead absorption basis for each work center. You can compute overhead costs by using either a fixed rate or a fixed percentage.
- Group technology code for each item. Select similar items for JIT reports.
- Concurrent operation or overlapping operation capability in the routings. You can track or plan multiple operations occurring on different parts an assembly at the same time (concurrent operations) or a subsequent operation to begin before the preceding operation is complete (overlapping operations)

Infor LX Inventory Tracking

To track inventory you must account for receipts, issues, adjustments, and transfers. You can report these transactions as discrete events or the system infers them from the completion of production activity. Just-in-Time needs inventory tracked to each individual work center or data collection point. Account for scrap and analyze rejected items. You will also want to be able to verify on hand inventory balances.

Infor LX meets these needs with:

- Inventory by work center or data collection point
- QC and inventory transactions that you define
- Backflushing capability
- Optional standard locations by item and warehouse
- Reason codes and account numbers that you define
- Two-step cycle counting with separate verification and update
- Automatic pull-through based on work center production reporting
- Quality control and reject reporting by item, by work-center or by reason code

Infor LX MRP/Master Scheduling

Manufacturers do not usually plan JIT production in discrete production lots. Instead, they set a volume over time. For example, they plan a daily or weekly rate of production. They track production cumulatively to large, blanket schedule quantities. Schedules are usually stable and center on combining Group Technology resources to minimize set-up and change-over times. Rough-cut simulation capability is a must for JIT production; however, the Infor LX scheduling system also accommodates non-JIT production. Time fences are necessary to avoid disruptive rescheduling signals to production.

In addition to standard MRP II Master Scheduling capabilities, Infor LX supports Just-in-Time with:

- Group Technology planning to minimize set-ups
- Full simulation and rough-cut capacity planning capability
- Time fences by item
- On-line release and maintenance of JIT schedules
- System-generated schedules and run rates by item
- Automatic under run planning adjustments

Infor LX Shop Floor Control

For Just-in-Time manufacturing, easy shop floor reporting and tracking are the keys to success. The system must be responsive to change and be able to communicate status and priority changes quickly. JIT streamlines reporting so that workers spend their time on production, not reporting. Reporting adds cost, not value. Infor LX reduces reporting costs with on-line, real-time dispatching and graphic work center load displays.

Infor LX also provides these added Just-in-Time features:

- Daily JIT release schedules and build rates
- Repetitive make-to-schedule
- JIT processing by item
- Kanban card printing
- Automatic container need calculations
- Backflush of material usage based upon reported production
- Material consumption tied to operation steps

- Production reporting by item and work center
- Quality control feedback and analysis
- Work stoppage (red light) analysis
- Data collection interfaces
- Yield analysis by work center or data collection point
- User-defined data collection points with effectivity dates

Infor LX Purchasing

Controlling your vendors' performance is a major factor in improving both your responsiveness to the market and your quality. JIT requires good communications with your vendors to help them simultaneously lower their costs and to provide you with better service. You need to buy capacity, not just quantities of material. And you need to see your requirements in ways that let you negotiate volume purchases and discounts with your vendors.

Infor LX provides you with solid information for effective vendor communications. Infor LX supports your Just-in-Time needs with:

- Blanket purchase orders
- Purchase requisitions
- Ability to combine requirements for negotiating long-term agreements for vendor capacity
- JIT purchase release schedules
- Cumulative reporting and tracking
- Vendor Performance analysis, including quality
- Long-range vendor scheduling
- Vendor by item quotations and history

Infor LX Cost Accounting

The challenge in cost accounting is tracking your manufacturing to the levels needed for useful management information. You need feedback for corrective action; but, you need to minimize the cost of collection. Some parts of your operation require specific job-cost tracking while the Just-in-Time areas require costing in terms of cost per process hour or day. Apply overhead in different ways to different processes and products. Segregate costs into enough detail to provide management with an accurate picture of the contents of your product. Material, material overhead, labor, fixed overhead, variable overhead, outside processing, outside processing overhead, and so forth all have to be considered.

Infor LX meets you cost accounting needs with the following functionality:

- Four sets of costs: actual, standard, frozen standard, and simulated
- Nine user-defined elements per set
- Full and partial cost roll-up and simulation
- Cumulative in-process cost tracking

- Cost summaries by item
- Cost definition tied to work centers or material type
- Process hour costing

Implementing just-in-time in your company

Infor LX can make the journey to Just-in-Time possible - with flexibility, ease of use, fully-integrated information, and on-line real-time processing. You can request Professional Services to provide the implementation and installation support you need - anywhere in the world. Software alone can not solve your problems.

Just-in-Time is a philosophy that you have to support, understand, and adopt if you are to be successful. It requires working, educating, and continuously uncovering and solving the problems hiding under the waste. We want you to be successful. The balance of this information should help you get started.

Implement Just-in-Time manufacturing in five major steps.

1. Organize your people. Establish a steering committee and a project team.
2. Educate them. Learn, plan, and experiment to develop understanding and confidence.
3. Prepare your data and production environment. Prepare your plant layouts, reduce setup times, develop quality programs, level the final assembly schedules, and commit to solving problems.
4. Convert each area. Process to a pull system.
5. Continue the improvements. Expand the pilot programs to cover your entire plant. Work toward continuous improvement.

Education is available from a wide range of sources. The American Production and Inventory Control Society (APICS) is an excellent source for articles, conference proceedings, and bibliographies.

Conclusion

Just-in-Time is the logical continuation of the progress made with a closed-loop approach to business planning and control. It is a proven method for achieving reduction in inventory investment and increasing responsiveness to market demands, product quality, and vendor performance. The greatest financial benefits come from the reduction of work-in-process and from better vendor price performance. Just-in-Time also makes the factory able to respond more rapidly to changes in customer demand. The overall organization produces higher quality products.

Implementing Just-in-Time also takes flexible business planning and control software that lets you run different areas with different degrees of control and software with information that provides value, not just added cost, to your management. Infor LX provides you with this flexibility.

System flow

Before you go live with JIT, you must set up your system to work correctly for JIT processing.

Setting up your system for JIT processing

Before you perform any JIT processing, you must set system parameters to define basic information about the item such as its bill of material and its routing.

Use SYS800 to enter the following system parameters for JIT processing:

1. Multiple Issue from lot/location allocations or the location you enter during inventory posting.
2. Use last cost or weighted average cost in Costing for Update of Material Costs.
3. Allow non-allocated issues during Inventory Posting.
4. Run MPS/MRP by Warehouse.
5. Include planned orders as scheduled receipts.
6. Print Kanban Cards.
7. Sequence Labor Tickets and Kanban Cards by work center or by order number.

Repetitive items use a lot sizing technique that allows variable periods to be established for repetitive, high volume manufacturing. Define items as repetitive in IDF Enterprise Item, or Facility Items. This allows you to create:

- Dynamic period quantities
- Fixed period/variable quantities, or
- Variable periods/fixed quantities

Specify whether the item is a JIT item in IDF Enterprise Item, by entering a J for JIT items or N for non-JIT items.

Enter a default warehouse location for each item in Facility Items. The system uses this default to create allocations.

Specify the number of the operation where each component is issued in the bill of material for the parent item (BOM500).

Define locations in Location Master Maintenance, INV170.

Define to and from machine location codes in Machine Master Maintenance, CAP170. Machine Master Maintenance provides capacity scheduling for a repetitive manufacturing environment. Scheduling is based on the speed and efficiency of machines within a work center. To and from location codes must exist in Location Master Maintenance, INV170.

In Work Center Maintenance, CAP100, enter the work center location and specify from/to locations. Inventory flows through one path during JIT production. You can override the To Location directly at entry time. The system uses the override hierarchy below for the From location.

1. Machine from location

2. Work center from location

3. Previous work center to location

Overriding the To location allows completed items to be directed to a specific inventory location that is not normally part of the production cycle. The system uses the override hierarchy below for the To location.

1. The To location you enter in Production Reporting, JIT600

2. Machine to location

3. Work center to location

If you do not define any of these From or To fields, the system searches for the default in the next level of the hierarchy. For example, Production Reporting, JIT600, does not list a To location, the system searches the Machine to location for a default. Leaving the field blank denotes no override. To override the location code of all From or To fields, enter the special value *BLANK. The system then uses a location master defined with a location code of all blanks.

Define non-collecting (non-reporting) operations in Routing Maintenance, SFC100. You can also override the effective collection period from Production Release, JIT540. The Infor LX JIT product provides pull-through capability that posts standard run, setup, and machine hours for operations that occur between two data-collecting operations. The last operation on the routing must be a collecting operation for the system to function.

IDF Enterprise Item
Bill of Material (BOM500)
Warehouse Maintenance (INV110)
Location Maintenance (INV170)
Machine Master Maint (CAP170)
Department Maintenance (CAP120)
Work Center Maintenance (CAP100)
Routing Maintenance (SFC100)
Facility Items

Before you begin any JIT processing, you may want to view the current status of the purchase orders for a specific warehouse and group of items. Produce the Production Purchasing/Planning report, JIT200. (After viewing this report, you can reschedule firm-planned orders as necessary so that you have realistic

time-phased requirements based on the dates that you expect vendors to deliver materials.) You may also want to view this report after creating manufacturing orders and requirements through JIT to give you an idea of the adjustments you need to make to your purchase orders.

To create a planned production schedule in JIT, use Schedule Maintenance, JIT510. To print the shop packet, you must first select the planned production through Production Release, JIT540. Print the releases by using Production Print, JIT550. At this point, the system creates detail time-phased material allocations. See the Material Issue Logic section of these instructions.

Schedule Maintenance	(JIT510)
Production Release	(JIT540)
Production Print	(JIT550)

When you first create planned production through JIT510, you can view those planned orders from the Planning Inquiry, MRP300. After you produce a shop packet for the production run, the system assigns a number to each released order that is part of the production run and updates the quantity accordingly. At this point, you can select the production to appear on the group technology report. This report produces time-phased order quantities for the item categories you define.

Group Technology Report	(CAP240)
Planning Inquiry	(MRP300)
Production Reporting	(JIT600)

After shop floor operation activity occurs, you can use Production Reporting, JIT600, update or add production reporting. If you link an operation to the bill of material for an item, the system creates inventory allocations to issues for component items when you post labor tickets for the parent item and operation. Production reporting also records cost data for the item.

When you post production reporting for the final operation of the routing for an item, the system updates the inventory status for the appropriate quantity of finished goods from adjustment to received status. The Infor LX JIT product posts standard run, setup, and machine hours for operations that occur between two data-collecting operations (pull-through).

Material allocations and issues logic

The following section discusses allocations and how they are handled in the JIT application.

Allocations

When you print the shop packets for selected planned production Infor LX JIT creates material allocations for the required component items. Run Production Print, JIT550, to create the allocations. These allocations are necessary to reserve the items needed to complete the planned production.

To create the allocations, Infor LX needs to determine the warehouse locations and, if necessary, the lots that it will use.

Infor LX allocation logic supports a wide range of exceptions. These exceptions take the form of forced locations. Forced locations are specified locations from which to issue components. If you define a forced location, the system issues components from that location, and only from that location; it does not perform another search. This form of allocation is useful in situations involving line stocking where it is undesirable to allocate inventory from the main storage locations. Another use occurs when an item is located in one and only one location, and the system always issues it from that location.

The following chart lists the fields and the records or programs in the allocation hierarchy. The listing includes the designated abbreviation for each field.

Definition of Terms:

Record:	Field:	Designated as:
Schedule	warehouse	S/O-WHS
Item Master (IDF Enterprise Item)	default warehouse default location	IIM-WHS IIM-LOC
Item/warehouse planning	default location	IWI-LOC
Work center	from location	LWK-LOC

A location (WHS,LOC) is defined if an ILI record exists for this location. An ILI record exists if any inventory transactions (including opening balance and adjustments) have been performed against this location.

The system uses the hierarchy below to determine if you defined a forced location.

1. The system checks Warehouse Planning record. If IWI-LOC for S/O-WHS is non-blank, and the location S/O-WHS, IWI-LOC exists, Infor LX uses it as the forced location.

2. The system checks Item Level Override. If location IIM-WHS, IIM-LOC exists, Infor LX uses it as the forced location.

3. The system determines the warehouse. At this point, the forced location search continues only in a single warehouse, designated as FRC-WHS. If IIM-WHS is specified, Infor LX uses it as FRC-WHS. If IIM-WHS is NOT specified, Infor LX uses S/O-WHS.

4. The system checks Work Center location. Infor LX determines the routing step associated with the component through its bill of material record. Infor LX determines the work center for that operation. If the location, FRC-WHS, LWK-LOC, is defined, Infor LX uses it as the forced location.

5. No forced location is defined; the system uses the final search logic. For lot-controlled items, Infor LX searches the FRC-WHS for unexpired lots, and consumes them in alpha location sequence. For non-lot controlled items, Infor LX searches the FRC-WHS in alpha location sequence. After Infor LX reaches this point, inventory is consumed from many different locations.

The following example illustrates how the component item allocation process works if you do not specify a default warehouse location. Consider the following inventory status information.

Item	Item	Lot#	Receipt Date	Expiration Date	Qty On Hand
A	AA	LOT1	12/20/04	12/31/04	10
A	AA	LOT2	12/21/04	12/22/04	10
A	AA	LOT3	12/21/04	01/01/05	10
A	BB	LOT1	12/22/04	01/02/05	10

For planned production released on 12/25/04 for a quantity of 25, the system creates the following allocation:

Item	Location	Lot#	Expiration Date	Qty Allocated
A	AA	LOT1	12/31/04	10
A	AA	LOT2	12/22/04	Expired
A	AA	LOT3	01/01/05	10
A	BB	LOT1	01/01/05	5

The system does not allocate inventory from expired lots.

Material Backflush

When you post production activity by using the Production Reporting program, JIT600, Infor LX does the required component item backflush based upon the quantity reported complete and rejected at the operation.

The backflush hierarchy is similar to the allocation hierarchy but with the following differences:

- Use of pre-existing allocations
- Machine level
- Ability to override the forced location at production reporting time directly from entry screen

A summary appears below. All the terms from the previous allocation section apply; however the table includes additional terms.

Definition of Terms:

Record:	Field:	Designated as:
Schedule	warehouse	S/O-WHS
Item Master (IDF Enterprise Item)	default warehouse default location	IIM-WHS IIM-LOC
Item/Warehouse planning	default location	IWI-LOC
Work Center	from location	LWK-LOC
Machine	from location	LMH-LOC

JIT processing tracks the parent item through the production cycle. This unique aspect of JIT processing relates to production reporting. In Infor LX JIT, the system records the quantity of the parent item in production as on hand as soon as you report production activity for any operation in its routing. This is necessary to record the quantity of the item pending completion. However, to indicate that the parent item is not actually completed and that the manufacturing of the item is completed only up to a certain operation, the system uses a concept called adjustments to the on hand balance. Infor LX JIT records the adjustments for the most recently reported operation, and removes the adjustments for the previous operation at the same time, when you post activity through the Production Reporting program (JIT600). Thus by checking the adjustment quantity for a location, you can determine the exact status of the parent item in process.

Specify the work center location used to record the adjustment through Work Center Maintenance, CAP100. The quantity good that you post through JIT600 is the quantity of the parent item recorded as an adjustment for the reporting operation. If there is a previous operation, the system creates a negative adjustment equal to the quantity reported as good plus the quantity rejected at the current operation.

To ensure that the MRP system does not recognize the work-in-process parent item as being currently on hand, use a non-allocatable warehouse for the warehouse location specified through Work Center Maintenance, CAP100.

Chapter 3
Programs

<div style="color:white; background-color:red">3</div>

Planning period maintenance for repetitive items

Access Planning Period Maintenance, JIT100D1, from Parameters Generation, SYS800. Use the Planning Period Maintenance for Order Policy K screen, JIT100D1-01, to subdivide planning horizons into periods that the system uses to consolidate and then evenly redistribute requirements for repetitive items. The system uses these periods to generate a production schedule.

Material Requirements Planning (MRP) and Distribution Requirements Planning (DRP) use these time frames to process requirements for repetitive items. Define repetitive items through IDF Enterprise Item.

Depending on the demand policy code you defined for an item and warehouse through Facility Items planned orders can result in one of the following ways:

- Directly from customer orders, forecasts, and DRP resupply orders
- Indirectly from the requirements generated by parent items

Use the following programs to create or maintain planned orders:

- MRP Generation, MRP600
- MRP/DRP Explosion, MRP500, DRP500
- MRP/DRP Maintenance, MRP510, DRP510

Access: Parameters Generation, SYS800D-01

Maintain planning periods

Specify the start date for the first planning period and the number of days in each period. The system uses the days in each period as calendar days, including holidays and weekends.

Field descriptions - JIT100D1-01

Fields	Description
Start Date (6,0):	Specify the planning start date, that is, the first date of the first period.

Infor LX calculates the Start Date (from date) as the end date in JIT100 plus one day. Any other entry will generate invalid start date message. For example, if the end date in JIT100 is 92304 then the start date must be 92404 for that schedule period.

Update this field at least once a year, even if your calendar exceeds your current year.

Number of Days for Firm Planned Orders (3,0):	This field is reserved for future use.
Per (Period):	The system displays the number of the period. There are 152 available periods.
Days (3,0):	Specify the number of days in each period. The system uses these days as calendar days, not shop floor days. The days specified here include weekends and holidays. Planning is easiest if you enter seven days for each period. Based on the number of days that you enter, the system computes ending dates for each period and displays them in the next column. The system subdivides the planning horizon into the number of periods you define here. The system sums all requirements for repetitive items within a period to create one planned order for each period. The planning date used for these orders is the first date of the period.
End Date (6,0):	The system displays the planning end date.

Screen actions - JIT100D1-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Override location maintenance

Use Override Location Maintenance, JIT110D, to maintain the override location in the Item Warehouse, IWI, and file. Use Facility Items to update the Item/Planning/Costing file, CIC.

Access: JIT Menu

Add or select a JIT override location

Use the JIT Override Location Selection, JIT110D-01, screen to select an item. On the following screens you can maintain the override location.

Field descriptions - JIT110D-01

Fields	Description
Line Actions:	All line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.
Item (35,A):	Specify a valid JIT item number. Define JIT items through IDF Enterprise Item.
Warehouse (3,A):	Specify the code for the warehouse associated with this item. If you leave this field blank, all warehouses print on the report.

Screen actions - JIT110D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

JIT override location maintenance

The system displays the JIT Override Location Maintenance screen, JIT110D2-01, if you press Enter after you select a location to maintain from the JIT Override Location Selection screen, JIT110D1-01.

Use this screen to establish allocation and backflushing functionality and to customize the Infor LX standard inventory search routine. The setup on this screen affects the standard allocation and backflush logic.

The entries on this screen do not affect or supersede allocation logic for managed warehouses.

Field descriptions - JIT110D2-01

Fields	Description
Item Number:	The system displays the item number you are selecting a forced location for.
Item Description:	The system displays a description of the item.
Warehouse Code:	The system displays the warehouse that contains the override location.
Warehouse Description:	The system displays a description of the warehouse.
Location Description:	The system displays a description of the location.
Override Location (10,A):	This field contains the override location for JIT backflushing. If you leave this field blank, no override at the item/warehouse level occurs. To override to the blank location, specify *BLANK.
	A value in this field does not affect the allocation logic for a managed warehouse.
Location Usage (1,0):	The system considers the location associated with a given item or warehouse during Order Warehouse Processing. Specify a Forced Location Search Usage Code.
	Blank
	The system considers all locations in location order until it meets the quantity requirement. Used only with the blank location.
	0
	Forced Location. The system does not consider another location in the current warehouse. The system does not consider another warehouse. The search ends.
	1
	Default Location. The system does not consider another location in the current warehouse. The search continues in other warehouses.
	2
	First Location. This is the first location considered in the current warehouse. The search continues in the same warehouse.
	NOTE: A blank location with a usage code 0 tells the system that the blank location is a forced location. A blank location with a usage code 1 tells the algorithm the blank location is a default location.

Any entry in this field does not affect the allocation logic for a managed warehouse.

Screen actions - JIT110D2-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production/purchasing planning report

Use Production/Purchasing Planning Report, JIT200D, to print a report that shows the current on-hand quantity and the planned receipts by item, with subtotals by item class. In addition, the report lists scheduled receipts period.

Scheduled receipts always include open scheduled orders, open purchase orders, open DRP resupply orders (if running MRP/MPS by facility), firm-planned orders, and requisitions. In addition, planned orders may be included as scheduled receipts if so specified through MRP System Parameters.

The report is useful for the master planner in making planning decisions about future production. Buyers can use the report to decide which materials to purchase and the volumes in which to purchase them based on open purchase orders. The information provided can help buyers take advantage of volume discounts.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the Ranges topic in the overview section of this document.

Access: JIT Menu

Print a production/purchasing planning report

Use the Production/Purchasing Plan screen, JIT200D-01, to specify the range of planners, items, and facilities to include on the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT200D-01

Fields	Description
From Planner (3,A):	Specify a range of values to limit the planners to include in the report.
To Planner (3,A):	Specify a range of values to limit the planners to include in the report.
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
Facility (3,A):	Leave this field blank to print all facilities on the report. Specify a facility code to print only one facility.

Screen actions - JIT200D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Cumulative production by item report

Use Cumulative Production by Item, JIT210D, to print a report that analyzes production after the fact. The report summarizes the total quantity required, quantity finished, quantity remaining, quantity good, quantity rejected, and so on. The report lists all of the production information by item.

Use this report to review and analyze the level and efficiency of production for the due date and warehouses that you specify.

Access: JIT Menu

Print a cumulative production by item report

Use the Cumulative Production by Item screen, JIT210D-01, to specify the range of planners, items, and facilities to include on the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT210-01

Fields	Description
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
From Due Date (6,0):	Specify a range of dates to limit the production due dates to include in the report.
To Due Date (6,0):	Specify a range of dates to limit the production due dates to include in the report.
From Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
To Facility (3,A):	Specify a range of values to limit the facilities to include in the report.

Screen actions - JIT210-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Cumulative costs by item report

Use the Cumulative Costs by Item report, JIT220, to compare the actual shop floor costs incurred to produce a given quantity of an item with the standard costs for that quantity. The actual costs result from the number of hours posted to operations using the Production Reporting program (JIT600/620). The report summarizes all production for the material costs for an item and it shows the total variances and costs for labor and overhead. The report includes cumulative cost data and detail from open scheduled orders only.

Access: JIT Menu

Print a cumulative costs by item report

Use the Cumulative Cost by Item screen, JIT220-01, to specify the report format and to limit the information by facility, date, and item. You can specify the cost information to include on the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT220-01

Fields	Description
Report Format Options (1,0):	Specify the information on the report. Specify one of the following values: ■ Shop Order Variances ■ WIP Valuation ■ Both
Lower Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
Upper Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
Cutoff Date (6,0):	Selection of a cutoff date allows schedule and WIP valuation as of that date. The program calculates the value of labor transactions in the Labor Ticket (FLT) file through the cutoff date. For material cost, the system reduces the cumulative costs stored in the Material Allocation to Shop Orders (FMA) file by the value of Inventory Transaction History (ITH) records effective after the cutoff date. If you purge the ITH or FLT files after the specified cutoff date, the system displays an error message that instructs you to enter a new cutoff date.
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
Print Item Cost Only (1,0):	Specify 0 to print Labor/Overhead, Order Cost, and Item Cost report sections for each shop order/item. Specify 1 to print only Order Cost and Item Cost report sections for each shop order/item.
Print Item Bucket Detail (1,0):	Specify 0 to not print bucket level detail for Order Cost or Item Cost. Only Total Order and Total Item Cost lines are printed. Specify 1 to print both bucket level detail and Total Order and Total Item Cost lines.
Cost Set for Comparison to Actual (2,0):	The screen displays the Inventory and Costing Parameter, SYS800, cost set for Cost Set to Use for G/L Inventory Transaction Costs, ZPA file. You can override the default value with any defined cost set, CSM.
WIP Valuation Cost Set (2,0):	The screen displays the Inventory and Costing Parameter, SYS800, cost set for Cost Set to Use for G/L Inventory Transaction Costs, ZPA file. You can override the default value with any defined cost set, CSM.

Screen actions - JIT220-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Downtime analysis

Use this program to produce the Downtime Analysis report, JIT230. The report uses data from the history file to show production downtime. (When you report production, you can also report downtime. Use reason codes to classify downtime. The report lets you review production results to determine the degree of production downtime and the reasons for non-productivity as revealed by the reason codes attached. This will help you correct production problems and increase efficiency. You can specify a range of dates and departments that you want to see on the report.

Access: JIT Menu

Print a downtime analysis report

Use the Downtime Analysis, JIT230D-01, screen to specify the range of dates and departments to include on the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT230D-01

Fields	Description
From Date (6,0):	Specify a range of dates to limit the production due dates to include in the report.
To Date (6,0):	Specify a range of dates to limit the production due dates to include in the report.
From Department (4,A):	Specify a range of values to limit the departments to include in the report.
To Department (4,A):	Specify a range of values to limit the departments to include in the report.

Screen actions - JIT230D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Shop floor quality control/reject analysis

The QC/Reject Analysis report, JIT240, uses data from the history file to show production rejects. You can review production results to determine the degree of production rejects and the reason codes for production rejects. Define reason codes in Reason Code Maintenance, INV140D1. On the JIT240 report, the reason codes show why you are rejecting material.

Use this report with the Yield Analysis by Operation report, JIT250, to correct production problems and increase efficiency.

Access: JIT Menu

Print a quality control/reject analysis report

Use the JIT Shop Floor QC Analysis, JIT240D-01, screen to specify the information and the sequence of the information to include on the report.

Use the following selection criteria to sequence the information:

- Item/reason code
- Reason code/item
- Department/work center/reason code

Specify one, two, or three of these report options by entering an X in the appropriate area after the Sequence by field. The selected reports print out separately, according to the limits that you specify. The chart below shows the available reports and the limits.

Report:	Limit the data:
Sequence by Item/Reason Code	Items and Warehouses
Sequence by Reason Code/Item	Reason Codes
Sequence by Dept/Wrk Ctr/Reason Cd	Departments

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT240D-01

Fields	Description
From Due Date (6,0):	Specify a range of dates to limit the production rejections to include in the report.
To Due Date (6,0):	Specify a range of dates to limit the production rejections to include in the report.
Sequence by Item/Reason Code? (1,A):	Specify X to select the report.
From Item (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item (35,A):	Specify a range of values to limit the item numbers to include in the report.
From Warehouse (3,A):	Specify a range of values to limit the warehouses to include in the report.
To Warehouse (3,A):	Specify a range of values to limit the warehouses to include in the report.
Sequence by Reason Code/Item? (1,A):	Specify X to select the report.
From Reason Code (2,A):	Specify a range of reason codes to limit the data to include in the report.
To Reason Code (2,A):	Specify a range of reason codes to limit the data to include in the report.
Sequence by Dept /W/C /Reason Cd? (1,A):	Specify X to select the report.

From Department (4,A): Specify a range of values to limit the departments to include in the report.

To Department (4,A): Specify a range of values to limit the departments to include in the report.

Screen actions - JIT240D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Yield analysis by operation

The Yield Analysis by Operation report analyzes the production reject amounts by operation. This report clearly shows where you are losing productive output on the production line. You can select the items and the transaction dates that you want to appear on the report.

Use this report, with the QC/Reject Analysis report, to fully analyze production rejects. The QC/Reject Analysis report shows why you are rejecting material. This combination of reports helps you solve problems and improve the efficiency of your production.

Access: JIT Menu

Print a yield analysis by operation report

Use the Yield Analysis by Operation screen, JIT250D-01, to specify the range of facilities, dates, and items to include on the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT250D-01

Fields	Description
From Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
To Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
From Transaction Date (6,0):	Specify a range of dates to limit the data to include in the report.

To Transaction Date (6,0):	Specify a range of dates to limit the data to include in the report.
From Item (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item (35,A):	Specify a range of values to limit the item numbers to include in the report.

Screen actions - JIT250D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Cumulative purchasing by item

The Cumulative Purchasing by Item program, JIT260D, produces the Cumulative Purchasing by Item report. This report shows the purchased goods that are required to meet the production of a given item.

Access: JIT Menu

Print a cumulative purchasing by item report

Use the Cumulative Purchasing by Item screen, JIT260D-01, to specify the range of items, vendors, and dates to include on the report. You can specify to run the report for a single warehouse.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT260D-01

Fields	Description
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
From Vendor (8,0):	Specify a range of values to limit the vendors to include in the report.
To Vendor (8,0):	Specify a range of values to limit the vendors to include in the report.

From Due Date (6,0):   Specify a range of dates to limit the data to include in the report.

To Due Date (6,0):   Specify a range of dates to limit the data to include in the report.

Warehouse (3,A):   This is an optional field. To run the report for a single warehouse, specify the warehouse code. To run the report for all warehouses, leave this field blank.

Screen actions - JIT260D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Item allocation detail

This program produces the Item Allocation Detail report. This report lists the allocated and on-hand quantities for child items. It also provides the lot number and lot status code for lot-controlled child items. You can select the items that you want to appear on the report. The child items will appear in alphanumeric order, according to item code. The report also lists the name of the parent level item that created the allocation.

Access: JIT Menu

Print an item allocation detail report

Use the Item Allocation Detail screen, JIT270D-01, to specify the range of items, warehouses, and locations to include on the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT270D-01

Fields	Description
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.

From Warehouse (3,A): Specify a range of values to limit the warehouses to include in the report.

To Warehouse (3,A): Specify a range of values to limit the warehouses to include in the report.

From Location (10,A): Specify a range of values to limit the locations to include in the report.

To Location (10,A): Specify a range of values to limit the locations to include in the report.

Screen actions - JIT270D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

JIT work list

JIT Work List, JIT275D, generates the work list, or dispatch list. This list provides a tool you can use to analyze the production plan versus the capacity plan. For each repetitive item, the program sums all the data in the FOD file for the period and prints a line for the total. For non-repetitive items, the program prints one line for each FOD record.

To generate this list, the system retrieves reported shop floor activity from both the FSO and FOD files. The program lists the shop floor activity that you posted against open orders for each work center. It then computes the number of days within the period as well as the number of days remaining. The program computes the daily run rate and the actual run rate by dividing the total shop order quantity by the respective number of days between the start date and the operation end date plus one and the number of days passed in the period. Finally, the system calculates a revised run rate by computing the difference between the quantities reported as finished and the total order quantity and dividing this difference by the number of days remaining in the period.

Date Calculations

The start date is the start date of the period and the end date is the ending date of the period. For the end date, the system uses the end date from the next period that is greater than or equal to the current date.

The system calculates the following fields for JIT items:

TDAYS

TDAYS are the total number of days in the period

SDAYS

SDAYS are the days passed in the period

RDAYS

RDAYS are the days remaining in period

The program prints a line of data for each repetitive item by summing all the FOD records for the period.

The system calculates the following fields for non-repetitive items:

TDAYS

TDAYS are the number of days between operation start date and operation end date plus one.

SDAYS

SDAYS are the number of days since operation start date to the entered current date

RDAYS

RDAYS are TDAYS minus SDAYS

The program prints one line for each FOD record for non-repetitive items.

Access: JIT Menu

Print a just-in-time work list

Use the Just-In-Time Work List screen, JIT275D-01, to specify the range of facilities and work centers to include on the report. You can enter a date to define the timeframe for the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT275D-01

Fields	Description
From Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
To Facility (3,A):	Specify a range of values to limit the facilities to include in the report.
From Work Center (6,0):	Specify a range of values to limit the work centers to include in the report.
To Work Center (6,0):	Specify a range of values to limit the work centers to include in the report.
Current Date (6,0):	Specify a date to determine the time frame for this report. Set up the time frame data through Time Frame Maintenance, JIT100. The system retrieves data only for the period in which this date falls. Initially, the current processing

date displays here, but you can change this date. The program then processes the FSO file by item and warehouse.

Screen actions - JIT275D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Employee efficiency report

This printed report helps you determine the efficiency of your employees relative to the standard hours for the posted quantities. The report lists the employee data in alphabetical order by employee name. The report lists the following information:

Posted values for:	Percent variance from:
number of hours	standard hours
respective quantity	standard pieces produced

Access: JIT Menu

Print an employee efficiency report

Use the Employee Efficiency Report, JIT280D-01, screen to select the employees and the items to include on the report. The report includes only employees who produce the items you specify.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT280D-01

Fields	Description
From Clock No. (8,A):	Specify a range of values to limit the clock numbers to include in the report.
To Clock No. (8,A):	Specify a range of values to limit the clock numbers to include in the report.
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report.

Screen actions - JIT280D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Flow order production report

The Flow Order Production Report program, JIT290D, creates a report of open flow order detail information for each linked shop order.

Access: JIT menu

Print a flow order production list

Use the Flow Order Production List screen, JIT290D-01, to specify selection criteria for information to include in the report. You can limit information to a specific facility or all facilities, and you can set ranges of warehouses, flow orders and items to include. You can also set the report to include all orders, only open orders, or only closed orders, and you can specify the sorting sequence of the list.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT290D-01

Fields	Description
Facility (3,A):	Specify a facility to limit the flow orders in the report to that facility, or leave the field blank to include all facilities.
From Warehouse (3,A):	Specify a range of values to limit the warehouses to include in the report.
To Warehouse (3,A):	Specify a range of values to limit the warehouses to include in the report.
From Flow Order (9,0):	Specify a range of values to limit the flow orders to include in the report.
To Flow Order (9,0):	Specify a range of values to limit the flow orders to include in the report.
From Item (35,A):	Specify a range of values to limit the items to include in the report.
to Item (35,A):	Specify a range of values to limit the items to include in the report.
Report Selection (1,A):	Specify the status of orders to include in the report from the following options:

1	Open Orders
2	Closed Orders
3	Both Open and Closed

Sort Option (1,A):	Specify the status of orders to include in the report from the following options:

1	By Flow Order
2	Due Date
3	By Item

Run Time Parameter (1,0):	Specify Interactive to process the data in real time or Batch to process the data in the job queue. If you select interactive processing, your session is unavailable for other tasks until the job finishes.

Screen actions - JIT290D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Flow order production schedule report

The Flow Order Production Schedule Report program, JIT291D, creates a report of flow order production schedule details for each linked shop order.

Access: JIT menu

Print a flow order production schedule report

Use the Flow Order Production Schedule Report screen, JIT291D-01, to specify selection criteria for information to include in the report. You can limit information to a specific facility or all facilities, and you can set ranges of warehouses, production lines, planners, flow orders and items to include. You can also choose a detail report or a summary report, and you can specify the sorting sequence of the information in the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT291D-01

Fields	Description
Facility (3,A):	Specify a facility to limit the flow orders in the report to that facility, or leave the field blank to include all facilities.
From Warehouse (3,A):	Specify a range of values to limit the warehouses to include in the report.
To Warehouse (3,A):	Specify a range of values to limit the warehouses to include in the report.
From Production Line (4,A):	Specify a range of values to limit the production lines to include in the report.
To Production Line (4,A):	Specify a range of values to limit the production lines to include in the report.

From Planner (3,A):　　Specify a range of values to limit the planners to include in the report.

To Planner (3,A):　　Specify a range of values to limit the planners to include in the report.

From Flow Order (9,0): Specify a range of values to limit the flow orders to include in the report.

To Flow Order (9,0):　Specify a range of values to limit the flow orders to include in the report.

From Item (35,A):　　Specify a range of values to limit the items to include in the report.

To Item (35,A):　　Specify a range of values to limit the items to include in the report.

Report Selection (1,A): Specify 1 to create a detail report or 2 to create a summary report.

Primary Sort Option (1,A):　　Specify the primary sort sequence for the report from the following options:

1	By Planner
2	By Production Line
3	By Item

SecondarySort Option (1,A):　　Specify the secondary sort sequence for the report from the following options:

1	By Release Date
2	By Flow Order Number

The report displays information sorted first by your primary sort option, then by the option you specify here.

Run Time Parameter (1,0):　　Specify Interactive to process the data in real time or Batch to process the data in the job queue. If you select interactive processing, your session is unavailable for other tasks until the job finishes.

Screen actions - JIT291D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production inquiry

Use Production Inquiry, JIT300D1, to view production information about a particular item and operation number. Some of this information is related directly to current production and some information represents summary totals and average production values. View this data to answer the following questions:

- What is the required quantity of the item at this time?
- What is the manufactured quantity of that item at this time?
- How much of the manufactured quantity is available to meet those requirements?
- What are the production quantities of this item year-to-date and month-to-date?
- What is the maximum production rate for the required item?

The maximum quantity is the largest number of pieces per hour reported on any labor ticket since the last production history purge for this item/facility. The purge clears the average/hour and maximum/hour from the history files. Use Production History Purge (JIT900) to perform the purge.

The average quantity is the last per hour computation for labor ticket pieces. The average quantity represents the last reported run rate for the item. If you specify yes to clear average/hour and maximum/hour when you run JIT900, the program resets both the maximum and average values.

Access: JIT Menu

Select item/facility/operation information for inquiry

Use the Production History Selection screen, JIT300D1-01, to select the item for inquiry.

Field descriptions - JIT300D1-01

Fields	Description
Act (2,0):	Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

10=Production Status

Display the production status data for the item/facility/operation.

11=Production History

Display the production history for the item/facility/operation.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Item Number (35,A):   Specify a valid JIT item number. Define JIT items through IDF Enterprise Item.

Facility (3,A):   Specify a facility for inquiry.

Operation (3,0):   Specify a valid operation number for the item. Define valid operations for an item through Routing Maintenance, SFC100.

Screen actions - JIT300D1-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production history inquiry

If you specify 11 next to a line on the Production History Selection screen, JIT300D-01, the system displays the Production History Inquiry screen, JIT300D2-01. The system also displays this screen if you use F14 from the Production Status Inquiry screen.

The screen displays the history for the item and operation you selected.

Field descriptions - JIT300D2-01

Fields	Description
Item:	The screen displays the item number.
Item Description:	The screen displays the description of the item from IDF Enterprise Item.
Facility:	The screen displays the facility where this item is manufactured.

Facility Description: The screen displays a description of the facility.

Operation Number: The screen displays the operation number you are inquiring on.

Operation Description: The screen displays a description of the operation.

Work Center: The screen displays the work center number assigned to the item and operation number combination through Routing Maintenance, SFC100.

Work Center Description: The screen displays a description of the work center.

Qty Required: This field contains the quantity of the item required at the specified operation. This value represents only the quantity required at the operation, not the total quantity of the item required throughout the system. This value results From requirements entered through Schedule Maintenance, JIT510, and released to the shop floor through Production Release, JIT540, and Production Print, JIT550. Requirements do not appear for an operation until you report production for previous operations, as represented on the routing for the item.

Reported Quantity: The system displays the quantity reported for production of this item.

Current Quantity: The screen displays the quantity of the item that was processed for the operation or the work center. Report this quantity through Production Reporting, JIT600. This is the total amount reported as the quantity good for the item since the last time you ran Production History Purge, JIT900.

Current Scrap: The screen displays the amount of the item that was recorded as scrap from Production Reporting, JIT600 for the specified operation or the work center. This is the total amount of the item that was reported as scrap since the last time you ran Production History Purge, JIT900.

Qty Remaining: This value represents the difference between the values in the quantity required field and the current quantity fields. The operation needs to process this quantity to meet requirements.

Max Qty Per Hour: The screen displays the maximum quantity that this operation has processed on an average hourly basis for this item. The system computes the rate for each quantity that you report through Production Reporting, JIT600, and updates this field only if the computed rate is greater than the value already in this field. This value is the computed most-items-ever-processed for this item and this operation.

Average Qty: The screen displays the average quantity processed per hour for this item through this operation for the most recently-posted production activity. This value is the average rate for only the most recent posting for the item and operation through Production Reporting, JIT600.

MTD Quantity:	These fields contain the month-to-date quantity good and quantity scrap for the item and operation that you posted through Production Reporting, JIT600.
MTD Scrap:	These fields contain the month-to-date quantity good and quantity scrap for the item and operation that you posted through Production Reporting, JIT600.
YTD Quantity:	These fields contain the year-to-date quantity good and quantity scrap for the item and operation that you posted through Production Reporting, JIT600.
YTD Scrap:	These fields contain the year-to-date quantity good and quantity scrap for the item and operation that you posted through Production Reporting, JIT600.

Screen actions - JIT300D2-01

Commands	Description
F14=Production Status	Use F14 to display the Production Status Inquiry screen. This screen contains detail inquiry data for all operations for an item.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production status inquiry

If you use 10 next to a line on the Production History Selection screen, JIT300D-01, the system displays the Production Status Inquiry screen, JIT300D2-02. The system displays this screen if you use F14 from the Production History Inquiry screen.

Field descriptions - JIT300D2-02

Fields	Description
Item Number:	The screen displays the item number.
Item Description:	The system displays a description of the item.
Facility:	The screen displays the facility where this item is manufactured.
Facility Description:	The screen displays a description of the facility.
Opr:	This field identifies the operation related to the information in the display line. Establish operations through Routing Maintenance, SFC100.

WrkCtr:	This field contains the work center number assigned to the item and operation number combination. Establish work centers in Routing Maintenance, SFC100.
Operation Description:	This field contains the description of the related operation from Routing Master Maintenance, SFC100.
Current Good:	This field display the quantity of the item that was produced by the operation or its associated work center. This production was reported through Production Reporting, JIT600. This is the total quantity that you reported as the quantity good since you last ran Production History Purge, JIT900.
Current Scrap:	This field contains the quantity of the item that was recorded as scrap for the operation or its associated work center. This scrap was reported through Production Reporting, JIT600. This is the total quantity of the item that you reported as scrap since you last ran Production History Purge, JIT900.
Average/Hour:	The screen displays this field after you use F11 to access the FOLD view. Average/Hour is the average quantity of the item processed per hour through the operation for the most recently posted production activity. This value is the average rate for only the most recent posting for the item and operation through Production Reporting, JIT600.
Maximum/Hour:	The screen displays this field after you press F11 to access the FOLD view. This field contains a value for the maximum quantity processed through the operation on an average hourly basis for the item. The system computes the rate for each quantity reported through Production Reporting, JIT600, but updates this field only if the computed rate is greater than the value already in this field.

Screen actions - JIT300D2-02

Commands	Description
F14=Production History	Use F14 to display the Production History Inquiry screen. This screen contains detailed inquiry data for all operations for an item.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Schedule maintenance

Use Schedule Maintenance, JIT510, to create and maintain daily production schedules for JIT and non-JIT items. Designate JIT items in IDF Enterprise Item. In JIT510, you can create and maintain firm-planned orders, and you can maintain planned orders generated by MRP. You cannot create planned orders in JIT510.

The system creates planned and firm-planned orders for a specified warehouse based on one of the following criteria:

- Beginning and ending plan dates, or
- Number of periods to plan and days per period, or
- Run rate (quantity per day)

The system uses the shop calendar to establish production release dates.

In contrast, the Master Production Schedule program (MRP510) lets you maintain your Master Production Schedule for traditional MRP II scheduling.

Schedule Maintenance, JIT510D1-01, lists items which have a valid bill of material, formula, or recipe. Use this screen to select an item for which you want to view scheduled production information.

Depending on the type of item you choose on this screen, one of two JIT schedule maintenance screens displays when you press Enter. If the item is repetitive, the system displays the Repetitive Schedule Maintenance screen. If the item is not repetitive, the system displays the Non-Repetitive Schedule Maintenance screen.

Access: JIT Menu

Select a schedule to maintain

Use the Schedule Maintenance screen, JIT510D1-01, to select a production schedule to maintain.

Field descriptions - JIT510D1-01

Fields	Description
Act (Action) (2,0):	Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.
	15=Material Status Inquiry
	Display Material Status Inquiry, INV300D2-02, for the inventory position on the parent item.

16=MRP Inquiry

Display MRP Inquiry, MRP300.

17=BOM Inquiry

Display BOM Inquiry, BOM300D1, for the item number.

18=Routing Inquiry

Display Routing Maintenance, SFC100D1, in inquiry mode for the item number.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Item Number (35,A): The screen displays items with a valid bill of material. The screen references all planned orders by item number. If you are creating or revising a record, enter the item number.

Facility (3,A): The system displays this field if your company performs MRP/MPS by facility. The system identified all firm-planned orders by item and facility code. If you enter a facility number, you can perform schedule maintenance for the facility that you specify. If you leave the facility field blank, the system uses the code for the Default Facility for Mass Release of Planned Shop Orders. You can perform schedule maintenance only for the default facility. If the facility enter is not an active facility, the warehouse selected is the mass release warehouse indicated in System Parameters, SYS800.

Description: The system displays the facility description.

Method (2,A): The system displays the bill of material method code. If you are creating or revising a record, specify a material method code for item production scheduling.

Policy Code: The system displays the order policy code of the item. Items can be repetitive or non-repetitive. This value defaults from IDF Enterprise Item.

K

Repetitive

All other letters

Nonrepetitive

Status: The system displays the status of the schedule. Schedules can be active (A) or inactive (I).

Screen actions - JIT510D1-01

Commands	Description
F15=Workcenter Schedule	Display Workcenter/Item Schedule, JIT515D1-01.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Filter schedule information

If you use F13, the system displays Filter Options. Use this screen to limit the information on the screen and to change the order in which it appears.

Field descriptions - Filter

Fields	Description
Sequence Option	Select the order of information you want to view by entering a value to the left of the sequence. Possible sequences are: 1 Active Records by Facility/Item/Method 2 All Records by Facility/Item/Method 3 Active Records by Item/Facility/Method 4 All Records by Item/Facility/Method
Facility (3,A):	Specify a facility to limit the information to one facility. If you leave this field blank, the system displays information for all facilities.
Item Number (35,A):	Specify an item number to limit the information to one item. If you leave this field blank, the system displays information for all items.

Method (2,0):	Specify a method to limit the information to one bill of material method. If you leave this field blank, the system displays all methods.
Select Policy Code	Specify a policy code type. Specify one of the following values: 0 Select all policy code types. 1 Select only repetitive types (order policy K).

Screen actions - Filter

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Schedule maintenance for non-repetitive items

Use Schedule Maintenance For Non-Repetitive Items, JIT510D2-01, to select for maintenance schedules for non-repetitive items. Define item order policy codes in the IDF Enterprise Item. The system displays this screen if the item is not repetitive, that is, the order policy is not K.

To begin creating a schedule from this screen, enter a 1 in the action field, a due date, and press Enter.

You can also select existing orders to recreate, delete, release, or close.

You cannot maintain Item types 3 (Assortments) and 4 (Kits) as defined in the Configurable Order Management product.

Access: Action 2 from the Schedule Maintenance selection screen, JIT510D1-01

Each order represents the quantity of the item specified in the Run Rate field. The system generates one order for each period.

Field descriptions - JIT510D2-01

Fields	Description
Item Number:	The screen displays the number of the item you selected from the Schedule Maintenance List screen, JIT510D1-01. This item is not repetitive.
Description:	The screen displays the item description.

Facility (3,A): The screen displays this field if you specify MRP/MPS by facility in Parameters Generation, SYS800. The system identifies all firm-planned orders created by item and facility code. If you enter a facility number, you can perform schedule maintenance for the facility that you enter. If you leave the facility field blank, the system uses the code for the Default Facility for Mass Release of Planned Shop Orders. You can perform schedule maintenance only for the default facility. If you specify a facility that is not active, the system selects the mass release warehouse that you define SYS800. Define the default facility in SYS800.

Description: The screen displays the facility description.

Warehouse (3,A): The screen displays the warehouse associated with this item and schedule. If you are creating a schedule, specify the code for the warehouse associated with this item.

Run Rate: The screen displays the desired planned order quantity. The system creates a firm-planned order for the specified run rate for each day.

Routing Method (2,A): Specify the routing method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Material Method (2,A): Specify the material method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Action (2,0): Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

10=Delete, Recreate

Delete the schedule and build a new one. You cannot do this if the Order Type is R (released).

11=Release

Release the order so work can begin. The system calls the Production Release and Print program (JIT550B1).

12=Report Production

Display Production Reporting, JIT600D, to report against this schedule.

21=Close

Display Shop Order Header Maintenance, SFC500D2-01, and close a released order. The system displays an X in the Type field and stops any reporting against it.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Due Date (6,0): The screen displays the date the order is due. If you are creating a schedule, specify the date in the time zone for the warehouse. This date is critical for backward scheduling operations, which determine the work center and shop schedules.

Type (1,A): The screen displays one of the following order types:

F

Firm planned

P

Planned

R

Released

If you are creating an order, you can enter only a firm-planned order (F).

Flow Order (9,0): The system creates an order number when you release a planned or firm-planned order from this screen using line action 11. You can view this order in Shop Order Inquiry, SFC300D1, or revise it in Shop Order Entry/Maintenance, SFC500.

Release Date: The screen displays the date you released the schedule. An R in the Type field indicates the schedule is released.

Run Rate: The screen displays the quantity you want to produce for this schedule.

Screen actions - JIT510D2-01

Commands	Description
Enter	After you complete your schedule maintenance through this program, the system automatically prints an audit trail of activities performed
F17=Item/Facility Quality	Access Item/Facility Quality Selection, SFC121D1. You must have group authority to use this function key.
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain schedule detail for non-repetitive items

Use the Schedule Maintenance screen, JIT510D2-02, to maintain the details of schedules for items that are not repetitive. This screen appears in the create, recreate, or delete modes. You must press F6 to complete your work on this screen (create, recreate, delete).

Field descriptions - JIT510D2-02

Fields	Description
Item:	The screen displays the item number you selected on the list screen (JIT510D1-01).
Item Description:	The screen displays a description of the item.
Facility:	The screen displays the facility associated with the item.
Facility Description:	The screen displays a description of the facility.
From Schedule Date (6,0):	The screen displays the beginning date of the period for which you want to schedule. If you are creating a schedule, specify the date in the time zone for the warehouse. Specify either the From Schedule Date and To Schedule Date or the Number of Periods to Plan.
To Schedule Date (6,0):	The screen displays the ending date of the period for which you want to schedule. If you are creating a schedule, specify the date in the time zone for the warehouse.

Specify either the From Schedule Date and To Schedule Date fields or the Number of Periods to Plan field.

Number of Periods to Plan (3,0):

Specify the number of periods for which you want to plan. You can enter a number in this field only in the create mode.

Specify either the From Schedule Date and To Schedule Date fields or the Number of Periods to Plan field.

Days per Period (3,0):

Specify the number of days per period. You can enter a number only in the create mode.

Note: The system uses this field if you enter a value in the Number of Periods to Plan field.

Order Type:

The screen displays the type of order you entered on the Schedule Maintenance screen, JIT510D2-01. The screen displays one of the following valid order types:

F

Firm planned

P

Planned

R

Released

Warehouse (3,A):

Specify the code for the warehouse associated with this item and order.

Routing Method (2,A):

Specify the routing method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Material Method (2,A):

Specify the material method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Run Rate (8,3)

Specify the run rate. The run rate is the quantity you want to produce for this order.

Reason Code (3,A):

Specify the reason code for this order. If you specified yes for either the system parameter or the facility file parameter Reason Code Required when Maintain-

ing Planned or Firm Planned Orders, you must make an entry in this field. Your entry must be a valid reason code in the ZCC table PLOREASN.

Reason Code Comment (30,A): Optional. Specify a comment related to your reason for making revisions to the order.

Screen actions - JIT510D2-02

Commands	Description
F6=Accept	Create a schedule entry if you are in the Create mode. Delete the schedule if you are in the Delete mode. Makes the changes you specify if you are in the Delete, Recreate mode.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Print Kanban cards and release an order

Use the Release Prompt screen, JIT510D2-03, to print KANBAN cards when you release the order.

Field descriptions - JIT510D2-03

Fields	Description
Print KANBAN Cards (1,0)	Specify 1 to release the order and print KANBAN cards. Specify 0 to release the order without printing the cards. The default is 0=No.

Screen actions - JIT510D2-03

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain schedule for repetitive items

The system displays the Schedule Maintenance screen, JIT510D3-01, if the item you specified on screen Schedule Maintenance, JIT510D1-01, is a repetitive item. Define item order policy codes in IDF Enterprise

Item. From this screen you can select for maintenance orders at the summary level. You can maintain the order quantity for the entire planning period and have the system redistribute the production evenly throughout the period rather than maintaining the detail firm-planned order quantities at the detail, or daily, level.

Field descriptions - JIT510D3-01

Fields	Description
Item:	The system displays the number of the item you selected from the Schedule Maintenance List screen, JIT510D1-01. This item is repetitive.
Description:	The screen displays the item description.
Facility (3,A):	The system displays this field if you specify MRP/MPS by facility in Parameters Generation, SYS800. The system identifies all firm-planned orders that it creates by item and facility code. If you enter a facility number, you can perform schedule maintenance for the facility that you enter. If you leave the facility field blank, the system uses the code for the Default Facility for Mass Release of Planned Shop Orders. You can perform schedule maintenance only for the default facility. If you specify a facility that is not active, the system selects the mass release warehouse that you define SYS800. Define the default facility in SYS800.
Description:	The screen displays a facility description.
Warehouse:	The screen displays the code for the warehouse associated with this item.
Description:	The screen displays the warehouse description.
YTD Production:	The system displays the year-to-date quantity produced for the item and operation as posted through Production Reporting, JIT600.
Actual Rate:	The system displays the run rate for this item to date. Infor LX calculates the run rate from the data you enter in the Production Reporting, JIT600.
Min Run Rate:	The system displays the minimum run rate for this item. The minimum and maximum run rates indicate if the orders over-utilize or under-utilize your shop floor capacity. Set and maintain run rates in the IDF Enterprise Item.
Target:	The system displays the Target Annual Quantity from Facility Items. This number is for reference only. The system does not use it in any processing.

Max Run Rate:

The system displays the maximum run rate for this item. The minimum and maximum run rates indicate if the orders over-utilize or under-utilize your shop floor capacity.

The run rates are set and maintained in the IDF Enterprise Item or Facility Items.

Projected Quantity:

The system displays the sum of the net quantities on this screen.

Min Bal:

The system displays the minimum quantity of this item that you should keep in stock. MRP uses this as the minimum stock level or reorder point. Include all safety and contingency stock in the minimum balance. Maintain this number in IDF Enterprise Item.

Min Bal Days:

The system displays the number of days required to determine average demand. Infor LX multiplies the average daily requirement by this number to determine the dynamic minimum balance. The system computes the daily average requirements from the Minimum Balance Horizon.

For order policy K items, this field represents the number of periods you use to determine average demand. You can define up to 152 periods.

The value in this field comes from IDF Enterprise Item.

Max Inv:

The screen displays the target maximum inventory quantity of this order. This field is for reference only. Maintain this number in IDF Enterprise Item.

On Hand Inv:

The system displays the projected quantity of the item on hand when the order is completed. The system performs the following calculation:

On Hand Production = YTD Production + MTD Production + planned

orders + firm-planned orders + released orders

Min Bal Horizon:

The system displays the number of days or periods from the present that defines a time period. This time period (horizon) is the period for which the system computes total requirements, which it in turn uses to calculate the dynamic minimum balance. The system sums the requirements within this period and divides by the number of working days or periods within those days or periods for repetitive specified for repetitive items to determine the daily average requirement.

The value in this field comes from IDF Enterprise Item.

Act (Action) (2,A):

Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

11=Release

Release the order so work can begin. The system calls Production Release and Print, JIT550B1.

12=Report Production

Display Production Reporting, JIT600D1, to report on this schedule.

21=Close

Display Shop Order Header Maintenance, SFC500D2-01, and close a released order. An X in the Type field indicates the order is closed and stops any reporting against it.

All other line actions on this screen perform standard Infor LX functions. See the overview information in this document.

Type (1,A):

The system displays the order type. If you are creating an order, you can enter only a firm-planned order (F).

F

Firm planned

P

Planned

R

Released

For planned orders, the system creates one planned order on the first date of the planning period for the specified quantity. For firm-planned orders, the system distributes the order quantity evenly throughout the dates you enter by creating one firm-planned order per planning period. Maintain planning periods in JIT100 which you access from SYS800.

From Date (6,0):

The dates in the From Date/To Date fields must correspond to production periods that are defined in Time Frame Maintenance (JIT100). You can either enter the dates for a defined period or you can let the system calculate the period dates for you.

To enter a From Date that corresponds to a period starting date, find the Ending date of the previous period and add one day. Press Enter. The system automatically calculates a To Date, if the To Date field is blank.

To let the system calculate the date range, enter any starting date.

If your entry does not correspond to a period starting date defined through JIT100, the system enters the correct starting date for you. The system calculates the starting date as the end date of the prior period in JIT100 plus one day.

Based on this entry, the system automatically calculates a To Date when you press Enter, if you leave the To Date field blank.

You can create a schedule that includes more than one period. Enter both the start and the end dates. When you press Enter, the system calculates a date range that includes production periods as defined in JIT100.

For firm-planned orders, the system schedules production evenly for each day within this period according to either the quantity or the run rate that you specify. For planned orders, the system creates one planned order on the first day of the period for the specified quantity.

To Date (6.0):

The dates in the From Date/To Date fields must correspond to production periods that are defined in Time Frame Maintenance (JIT100). You can either enter the dates for a defined period or you can let the system calculate the period dates for you.

If you enter a To Date, you must enter a From Date. To enter a To Date, enter the ending data defined in JIT100 for the specified period. Then enter a From Date that corresponds to a period starting date. To determine the From Date, find the Ending date of the previous period and add one day.

To let the system calculate the date range, enter any From Date.

If the date does not correspond to a period starting date defined through JIT100, the system enters the correct starting date for you. The system calculates the starting date as the end date of the prior period in JIT100 plus one day.

Based on this entry, the system automatically calculates a To Date when you press Enter, if you leave the To Date field blank.

For firm-planned orders, the system schedules production evenly for each day within this period according to either the quantity or the run rate that you specify. For planned orders, the system creates one planned order on the first day of the period for the specified quantity.

Gross Quantity:

The system displays the quantity of the order. The system bases the quantity on your entry on the Schedule Detail Maintenance screen, JIT510D3-02. On that screen you enter either an order quantity or a run rate.

If you specify an order quantity on Schedule Detail Maintenance, JIT510D3-02, the system displays that value here. The system does not consider the standard yield factor as it does for the Net Quantity field on this screen.

If you enter a run rate on JIT510D3-02, the system multiplies the run rate by the number of work days in the planning period to calculate the gross quantity. The system does not consider the standard yield factor as it does for the Net Quantity field on this screen.

Net Quantity:

The system calculates the Net Quantity based on the quantity or run rate that you enter on JIT510D3-02. The calculation uses the standard yield factor that you define in IDF Enterprise Item.

Net Quantity = (Gross Quantity) X (Standard Yield Factor)

If you change the standard yield factor in IDF Enterprise Item, the Schedule Maintenance program automatically changes the value in this field.

For example, if the quantity you enter on Schedule Detail Maintenance, JIT510D3-02, is 100 and the standard yield factor is 90%, the net quantity is 90.

Daily Run Rate:

The system displays the daily run rate needed to produce the net quantity based on the number of work days in the period. The system uses your entry on the Schedule Detail Maintenance screen, JIT510D3-02, to calculate this amount. On that screen you entered either an order quantity or a run rate.

If you entered a run rate on JIT510D3-02, that is the value that appears here.

If you entered an order quantity, the system computes a daily run rate by dividing this value by the number of work days in the period. For firm-planned orders, the resulting run rate determines the quantity of the individual firm-planned orders to schedule for this item.

Minimum/Maximum Flag:

The system displays a blank, a plus sign (+), or a minus sign (-).

Blank

The Daily Run Rate is within the minimum and maximum run rates specified in IDF Enterprise Item.

(+)

The Daily Run Rate exceeds the maximum run rate specified in IDF Enterprise Item.

(-)

The Daily Run Rate is less than the minimum run rate specified in IDF Enterprise Item.

The system displays the maximum and minimum run rates from IDF Enterprise Item on this screen.

Screen actions - jit510d3-01

Commands	Description
F14=Planning Period Maintenance	Display the Planning Period Maintenance screen, JIT100D1.
F17=Item/Facility Quality	Access Item/Facility Quality Selection (SFC121D1). You must have group authority to use this function key.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain schedule detail for repetitive items

The Schedule Maintenance screen, JIT510D3-02, allows you to maintain the details of schedules for items that are repetitive. The system displays this screen in the create, revise, or delete modes. If you are in the delete mode, use F6 to delete the order.

Field descriptions - JIT510D3-02

Fields	Description
Item:	The screen displays the item number you selected on the list screen. Infor LX references all planned orders by item number.
Description:	The screen displays a description of the item
Facility:	The screen displays the facility associated with this item. The system displays this field if you specified to perform MRP/MPS by facility in SYS800, Parameters Generation, for this company. If the system creates firm-planned orders, it identifies the orders by item and facility code.
Description:	The system displays a description of the facility.
Warehouse:	The system displays the code for the warehouse associated with this item.
Description:	The system displays the warehouse description.
Order Type (1,A):	The system displays the type of order. In the create mode only, you can enter a value here. Orders can be:

F

Firm planned

P

Planned

From Plan Date: The system displays the beginning date of the period that you want to schedule. You entered this date on the Item Build Schedule Maintenance screen, JIT510D3-01.

To Plan Date: The system displays the ending date of the period that you want to schedule. You entered this date on the Item Build Schedule Maintenance screen, JIT510D3-01.

Net Quantity (11,3): You can specify either a net order quantity or a daily run rate in the create or revise mode.

If you specify a net order quantity, the system computes a daily run rate by dividing this value by the number of work days in the period. For firm-planned orders, the resulting run rate determines the quantity of the individual firm-planned orders to schedule for this item.

If you do not specify a net order quantity, you must specify the daily run rate for the production of this order. The system multiplies the specified daily run rate by the number of days in the planning period to determine the net order quantity.

Specify the desired planned order quantity in this field. The run rate represents the quantity of the specified item that the system schedules for each day in the planning period, if the order type is F. The system creates a firm-planned order for the run rate quantity.

Run Rate (11,3): Specify either a net order quantity or a daily run rate in the create or revise mode.

If you enter a run rate, the system multiplies the run rate by the number of work days in the planning period to calculate the net order quantity. The net order quantity appears on the Item Build Schedule Maintenance List screen, JIT510D3-01, as the Gross Quantity.

Routing Method (2,A): Specify the routing method code to override the standard bill of material for planned or firm-planned orders. You can make an entry only in the create or revise mode. If you leave this field blank, the system uses the standard bill of

material value. The routing is the sequence of operations an item undergoes while being produced.

Material Method (2,A): Specify the material method code to override the standard bill of material for planned or firm-planned orders. You can make an entry only in the create or revise mode. If you leave this field blank, the system uses the standard bill of material value. The material method is the list of components that compose the item.

Screen actions - JIT510D3-02

Commands	Description
F6=Accept	In the create mode, use F6 to create an order based on the values you entered. In the revise mode, use F6 to save the changes you made to an order. In the delete mode, use F6 to delete the order.
	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Print Kanban cards

Use the Run Release Prompt screen to print KANBAN cards when you release the order and to verify that you want to release the order.

Access: Specify Release for an order on the Schedule Maintenance list screen, JIT510D3-01.

Field description - JIT510D3-03

Fields	Description
Print KANBAN Cards (1,0)	Specify 1 to release the order and print KANBAN cards. Specify 0 to release the order without printing the cards. The default is 0=No.

Screen actions - JIT510D3-03

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

JIT work bench

Use JIT Work Bench, JIT515D1, to create and maintain daily production schedules for JIT and non-JIT items by work center. In most cases, you use either JIT510 or JIT515, but not both.

Access: JIT Menu

Select a work center

Work Center Schedule Maintenance, JIT515D1-01, is the selection screen. From this screen you can select the work center for which you want to maintain or create a schedule.

Field descriptions - JIT515D1-01

Fields	Description
Act (Action) (2,0):	Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.
	15=Capacity Inquiry
	Display the capacity of the selected work center, CAP300D1.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Work Center: Specify a work center number.

Description: Specify a description of the work center

Status: The screen displays the status of the work center. A work center can be active or inactive. If active, you can maintain scheduling records for this work center. If inactive, you cannot maintain scheduling records.

Screen actions - JIT515D1-01

Commands	Description
F15=Item schedule	Display the Schedule Maintenance screen, JIT510D1-01.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Filter work center information

Use Filter Options, JIT515D1-01, to filter and change the order of information on the list screen. The system redisplays the list screen with the information and in the sequence you specified.

Field descriptions - Filter options

Fields	Description
Option (1,0)	Specify a filter option and press Enter. 1 All records by work center 2 Active records by work center 3 All records by description

4

Active records by description

Screen actions - Filter options

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add or select a work center/item

Use the Run Rate by Work Center/Item screen, JIT515D2-01, to choose the item schedules that you want to maintain for the selected work center. You can create, copy, delete, or revise run rate records by item number within a work center. The run rate records use the effectivity dates to create the JIT schedule.

Access: Revise from the Work Center Schedule Maintenance selection screen, JIT515D1-01.

Field descriptions - JIT515D2-01

Fields	Description
Work Center:	The system displays the work center number.
Facility:	The system displays the facility code.
Act (Action) (2,0):	Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.
	17=Work Center Schedule
	Display the Work Center Schedule screen, JIT515D3-01, for the selected item. This screen shows an overview of the current and future production schedule for this work center and allows you to select a production release for maintenance.
	All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Item Number (35,A): Specify the number of the item to schedule within this work center. A work center can have multiple item numbers scheduled within it, with run rates that vary based on effectivity dates.

Effectivity Start Date (6,0): If you are adding a work center, specify the beginning date of the effective period in the time zone for the warehouse.

Effectivity End Date (6,0): If you are adding a work center, specify the ending date of the effective period in the time zone for the warehouse.

Run Rate: The system displays the number of pieces the work center is scheduled to produce in a day within the effectivity date range.

Total Run: The system displays the total number of pieces scheduled for production. This number is equal to the sum of firm planned and shop orders.

Days: The system displays the total number of days needed to complete this scheduled order. The total days is equal to the Total Run divided by the Run Rate:

Days=(Total Run)/(Run Rate)

Status: The system displays the status of the item schedule. The status can be active (A) or inactive (I).

Screen actions - JIT515D2-01

Commands	Description
F15=Capacity Inquiry	Display the Capacity Inquiry screen, CAP300D1.
F16=Shop Calendar Maintenance	Display the Shop Calendar Maintenance screen, SFC140D1.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain run rate by work center/item detail

The system displays the Run Rate By Work Center/Item Detail screen, JIT515D2-02, in create, revise, copy, delete, or display mode depending on the line action you specified on the list screen.

Use this screen to create or revise run rates for the selected work center.

Field descriptions - JIT515D2-02

Fields	Description
Work Center:	The system displays the number of the work center and its description.
Work Center Description:	The system displays a description of the work center.
Facility:	The system displays the facility number.
Facility Description:	The system displays a description of the facility.
Item Number:	The system displays the number of the item.
Item Description:	The system displays a description of the item.
Start Effectivity (6,0):	Specify the beginning date of the effective period for this item run rate record. Specify the date in the time zone for the warehouse.
Ending Effectivity (6,0):	Specify the ending date of the effective period for this item run rate record. Specify the date in the time zone for the warehouse.
Method Code (2,A):	Specify the material method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the value for the standard bill of material.
Method Code Description (30,A):	The system displays a description of the method code.
Run Rate (11,3):	Specify the number of pieces the work center is scheduled to produce in a day within the effectivity date range.
Minimum Run Rate (11,3):	This is an optional user-defined field. Use this field for planning purposes.
Maximum Run Rate (11,3):	This is an optional user-defined field. Use this field for planning purposes.
Actual Run Rate (11,3):	This is an optional user-defined field. Use this field for planning purposes.
Time Fence in Days (3,0):	This is an optional user-defined field. Use this field for planning purposes.
Comment (30,A):	Specify any comments about this run rate.

Reason Code (3,A):	Specify the reason code for this order. If you specified yes for either the system parameter or the facility file parameter Reason Code Required when Maintaining Planned or Firm Planned Orders, you must make an entry in this field. Your entry must be a valid reason code in the ZCC table PLOREASN.
Reason Code Comment (30,A):	Optional. Specify a comment related to your reason for making revisions to the order.

Screen actions - JIT515D2-02

Commands	Description
F15=Capacity Inquiry	Display the Capacity Inquiry screen, CAP300D1.
F16=Shop Calendar Maintenance	Display the Shop Calendar Maintenance screen, SFC140D1.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add or select a work center schedule

Use the Work Center Schedule Maintenance screen, JIT515D3-01, to build and maintain a production schedule at the detail level and to see an overview of the current and future schedule for this work center.

Access: Work Center Schedule from Run Rate by Work Center/Item, JIT515D2-01

Field descriptions - JIT515D3-01

Fields	Description
Work Center:	The system displays the work center number.
Work Center Description:	The system displays a description of the work center.
Facility Number:	The system displays the number of the facility.
Facility Description:	The system displays a description of the facility.
Item Number:	The system displays the number of the item.
Item Description:	The system displays a description of the item.

Start Effectivity:	The system displays the beginning date of the effective period for this item run rate record.
Ending Effectivity:	The system displays the ending date of the effective period for this item run rate record.
Current Run Rate:	The system displays the number of pieces the work center is scheduled to produce in a day within the effectivity date range on this record.
Action (2,0):	Specify the number for the line action and press Enter. To use the first line, specify the line action and at least one key field value.

10=Delete, Recreate

Delete and recreate the entire schedule for a date range. Use this action to change a run rate within a working schedule.

11=Release

Create a production release and print KANBAN cards if required. A production release collects costs and you can report production against it. You must release to manufacturing planned and firm-planned orders in order to report production.

12=Report Production

Display Report Production, JIT600D1, to allow production reporting against a production release.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Due Date (6,0):	If you are adding a work center schedule, specify the scheduled completion date for the order. Specify the date in the time zone for the warehouse.
Type (1,A):	Specify the order type for the JIT schedules:

P

Planned order/release

F

Firm planned order/release with no replanning by MRP

R

Release to production

Warehouse (3,A): Specify the code for the warehouse associated with this item.

Material Method (2,A): Specify the material method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Routing Method (2,0): Specify the routing method code to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Release Date: The system displays the release date for the order. The system uses this value to create multiple orders for the daily run rate within the date range.

Run Rate: The system displays the run rate. To change the run rate, use the Run Rate by Work Center/Item Detail screen, JIT515D2-02.

Screen actions - JIT515D3-01

Commands	Description
F15=Capacity Inquiry	Display the Capacity Inquiry screen, CAP300D1.
F16=Shop Calendar Maintenance	Display the Shop Calendar Maintenance screen, SFC140D1.
F17=Item/Facility Quality	Display Item/Facility Quality Selection, SFC121D1. You must have group authority to use this screen action.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain work center schedule detail

The system displays the Schedule Detail Maintenance screen, JIT515D3-02, in create, delete, or create/delete mode depending on the action code you specified on the list screen.

Use this screen to create new schedule entries or maintain existing ones.

Field descriptions - JIT515D3-02

Fields	Description
Work Center:	The system displays the work center number.
Work Center Description:	The system displays a description of the work center.
Item Number:	The system displays the number of the item.
Item Description:	The system displays a description of the item.
Facility Number:	The system displays the number of the facility.
Start Effectivity:	The system displays the beginning date of the effective period for this item run rate record.
Ending Effectivity:	The system displays the ending date of the effective period for this item run rate record.
From Schedule Date (6,0):	If you are creating a schedule, specify the first date in your scheduling range. Specify the date in the time zone for the warehouse.
To Schedule Date (6,0):	If you are creating a schedule, specify the last date in your scheduling range. Specify the date in the time zone for the warehouse.
Order Type:	The system displays the order type for the JIT schedules:

P

Planned order/release

F

Firm planned order/release with no replanning by MRP

R

Release to production |
Warehouse (3,A):	If you are creating or recreating a schedule, specify a warehouse code. The warehouse must exist within the facility.
Warehouse Description:	The system displays a description of the warehouse.
Routing Method (2,A):	If you are creating or recreating a schedule, specify a routing method to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Material Method (2,A): If you are creating or recreating a record, specify a material method to override the standard bill of material for planned or firm-planned orders. If you leave this field blank, the system uses the standard bill of material value.

Run Rate: The system displays the number of pieces the work center is scheduled to produce in a day within the effectivity date range.

Reason Code (3,A): Specify the reason code for this order. If you specified yes for the system parameter or the facility file parameter Reason Code Required when Maintaining Planned or Firm Planned Orders, you must make an entry in this field. Specify a reason code valid in the ZCC table PLOREASN.

Reason Code Comment (30,A): Optional. Specify a comment related to your reason for making revisions to the order.

Screen actions - JIT515D3-02

Commands	Description
F6=Accept	Create a schedule entry or a series of entries if you are in the Create mode. Delete the schedule if you are in the Delete mode.
F15=Capacity Inquiry	Display the Capacity Inquiry screen, CAP300D1.
F16=Shop Calendar Maintenance	Display the Shop Calendar Maintenance screen, SFC140D1.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Release an order and print Kanban cards

The system displays this screen if you select type F items for release. You can use this screen to print Kanban cards.

Access: Release from Work Center Schedule Maintenance, JIT515D3-01.

Field descriptions - JIT515D3-03

Fields	Description
Print KANBAN Cards? (1,0):	Specify 0 if you do not want to print KANBAN cards, otherwise, specify 1.

Screen actions - JIT515D3-03

Commands	Description
Enter	If you specify 1 to print KANBAN cards, the system displays the Production Print screen, JIT550D1, and submits the production release to batch processing. If you specified 0, the system submits the production release to batch processing.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Flow order shift/rate maintenance

Use the Flow Order Shift/Rate Maintenance program, JIT541D, to create and maintain flow order rate per shift information for flow/rate-based items.

You can backward or forward schedule new flow orders. You can also override quantity, methods, shift rates, production line, and flow order setup and cleanup before you release the order. The system can process flow order revisions if you have not processed labor or inventory transactions against any of the linked shop orders.

Access

- Schedule Maintenance, JIT510D2-01, with the Release line action
- Production Release, JIT540D-02 with the Forward Schedule or Backward Schedule line action
- Planned Shop Order Release, MRP540D-02, with the Forward Schedule or Backward Schedule line action
- Shop Order Maintenance, SFC500D1-01 and SFC500D2-01
- MRP Workbench, MRP570, with line actions Release Forward and Release Backward

Add or maintain flow orders

Use the Flow Order Shift/Rate Maintenance screen, JIT541D-01, to create or revise flow orders. Most values in the screen default from the preceding screen but can be overridden here.

Field descriptions - JIT541D-01

Fields	Description
Warehouse (3,A):	Specify the warehouse for the flow order. The warehouse that you specify must be valid for the facility indicated on this screen.
Release Date (8,0):	If you selected the forward scheduling method, specify the shop order start date in the time zone for the warehouse.
Start Shift (1,0):	Specify the first shift to use for forward scheduling. The shift must have a quantity/hour greater than zero on this screen.
Start Shift Hours (4,2):	Specify the hour into the first shift to start forward scheduling production for this flow order. Use this field to override hours for the starting shift when you forward schedule. This field allows you to schedule a partial shift. The number of hours you specify must be fewer than or equal to the available hours for the shift. The system multiplies the hours in this field by capacity factors such as desired load percentage (DLP) efficiency, and machine speed factor (MSF) to determine the actual available capacity hours for scheduling purposes.
Due Date (8,0):	If you selected the backward scheduling method, specify the shop order due date in the time zone for the warehouse.
End Shift (1,0):	Specify the first shift/rate to use for backward scheduling. The shift must have a quantity/hour greater than zero on this screen.
End Shift Hours (4,2):	Specify the number of hours available for scheduling the end shift for this flow order. Use this field to override hours for the ending shift when you backward schedule. This field allows you to schedule a partial shift. The number of hours you specify must be fewer than or equal to the available hours for the shift. The system multiplies the hours in this field by capacity factors such as desired load percentage (DLP) efficiency, and machine speed factor (MSF) to determine the actual available capacity hours for scheduling purposes.
Quantity (11,3):	Specify the total quantity to produce for this flow order.
Routing Method (2,A):	Specify the routing method code to use for this flow order. A routing must exist for this item and routing method in the Routing Master file, FRT.

Material Method (2,A):   Specify the material method code to use for this flow order. A bill of materials must exist for this item and material method in the Bill of Materials file, MBM.

Scheduling Method (1,0):   Specify 1 to forward schedule or 2 to backward schedule the flow order.

Production Line (4,A):   Specify a valid production line for this order. The screen displays the production rates for each shift. Note that the value in this field defaults from the primary production line in the Facility Planning file, CIC.

Pre-Assign Serial (1,0):   Specify 1=Yes to create and reserve serial numbers for the parent item on the shop order. The Serial Number Assignment/Confirmation screen, INV599D-01, is displayed. Specify 0=No if you do not want to reserve serial numbers for the parent item.

Flow Order Set Up (8, 3):   This is an optional field used for scheduling purposes.

In create mode, this value defaults from the Routing file, FRT, and displays the remaining setup for the operation where the status is 4, setup. In revise mode, it defaults from the Flow Order file, FFO.

Flow Order Clean Up (8, 3):   This is an optional field used for scheduling purposes.

In create mode, this value defaults from the Routing file, FRT, and displays the remaining cleanup for the operation where the status is 5, cleanup. In revise mode, it defaults from the Flow Order file, FFO.

Quantity/Hour (11,3):   Specify the standard quantity of the item each shift produces per hour. This value, along with the capacity hours available, is used to determine the scheduled quantity for the shift. The capacity hours available do not consider any capacity factors (desired load percentage, efficiency, machine speed factor). The program assumes that the quantity per hour rates you enter here have already considered any capacity factors.

The program uses the following hierarchy to define the default rates for the production line:

- The program checks the Item Production Line file, LIP, for any existing override records for that item/facility combination.
- If no records exist in the LIP file, the program checks the Production Line file, LSP, for that facility.
- If no records exist in the LSP file, the program checks for a global record.

Screen actions - JIT541D-01

Commands	Description
F6=Accept and Release	Accept the information on the screen and release the order.
Standard screen ac-tions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production reporting

Shop floor workers normally write shop floor processing data on printed labor tickets. Use Production Reporting (JIT600) to enter this data to the system. You can enter data by employee or by crew.

When you use JIT600, you are maintaining a work file. The data you enter from this program does not affect the system master files until you post the production. When you post production the system executes the Production Update program, JIT620. You have the option of printing an edit report to review the data before you post it to the system files. If you need to make changes to the data that appears on that report, use JIT600 to update the work file. The following example outlines the production and production reporting sequence. Perform all these tasks in JIT600.

1. Write production activity on the labor ticket.
2. Post values from the labor ticket to the work file.
3. (Optional) Print the data/workfile.
4. (Optional) Make changes to the workfile.
5. Post the workfile data and change the system master files.

Use JIT600 to post collecting operations. The last operation on the routing must be a collectible operation in order for the JIT system to function. A non-collecting operation is an operation for which you do not post production activity. The system can automatically post production activity using backflush for a non-collecting operation.

Note: You cannot issue or receive material from or to a warehouse type 4, Warehouse BOSS-controlled warehouse, or type 5, WMS-4000-controlled warehouse, with this program.

If you installed the Quality Management System, Infor LX automatically triggers quality activities for QA-Controlled items from the production receipt (PR) transaction.

Use JIT600 to add, update, delete, and post production reports for JIT items. You can report production in a variety of ways, depending on the number of production reporting fields you complete or the combination of fields that you complete. You can report production for the following combinations:

■ Item and work center. Use this combination if you are using production schedules instead of Shop Orders, if you are using Kanban cards, or, if you are posting for JIT items.

- Item and operation.
- Shop order and operation. Use this combination if you do not use Kanban cards or if you are posting for non-JIT items.
- Shop order and work center.

If you are using production schedules instead of shop orders, you can report production by item and work center. Set up your system to use Kanban cards through the System Parameters Generation program (SYS800). Specify items as JIT items through IDF Enterprise Item.

Infor LX JIT/Repetitive processing uses the following transaction types:

- **PR:** This transaction receives final product into and increases end item inventory in the production warehouse.
- **RJ:** Use this transaction to report rejected production. This transaction does not update end item inventory; it issues components for the quantity reported.
- **WT:** This transaction reports movement of WIP inventory into the Work Center To Location. This transaction increases end item inventory in the WIP warehouse.
- **WF:** This transaction reports movement of WIP inventory into the Work Center From Location or, if blank, the To Location for the Work Center of the previous Collectible Operation. This transaction decreases end item inventory in the WIP warehouse.
- **CI:** This transaction reports the issue of components actually used in the manufacturing process and decreases component inventory in the issuing warehouse.
- **CS:** This transaction reports the issue of components not used in the manufacturing process, usually because of defects. This transaction decreases component inventory in the issuing warehouse.

Access: JIT Menu

Add or select a labor ticket

Use the Production Reporting screen, JIT600D1-01, to create a new labor ticket or to select an existing labor ticket to revise, copy, delete, display, or post.

Complete the following steps to post individual tickets:

1. Specify Post next to the tickets you want to post.
2. Press Enter.
3. The system displays the Production Register Listing, JIT610D-01 screen. Specify whether or not to print the production report.
4. Press enter to post the tickets and update the system master files.

Complete the following steps to post all tickets created with your user ID:

1. Use F14 to select all tickets created with your user ID.
2. The system redisplays the screen. The letter P next to a ticket number indicates that you selected it.
3. Use F6 to post the tickets.

4. The system displays the Production Register Listing screen, JIT610D-01. Press enter to post the tickets and update the system master files.

Complete the following steps to deselect individual tickets for posting.

1. Specify Deselect next to the tickets you do not want to post.
2. Press Enter. The letter P is gone.

If you use F14, Select for Post, and then use line action 21, Deselect, to deselect some of the tickets, you can use line action 9, Post, to select them again. In this case, the line action Post marks the ticket with a P to indicate that you selected it. It does not post the record.

To deselect all tickets for posting after you used F14 to select them, use F18. The letter P is gone.

Field descriptions - JIT600D1-01

Fields	Description
Code:	The system displays a code that shows the action you have chosen for this ticket. You choose the action if you use F14, F15, F16, or F17.
	D
	Delete
	P
	Post
	R
	Revise
	V
	View
Date:	This field indicates the labor ticket posting date. Various inquiry and report programs include the posting date.
Labor Ticket Number (7,0):	Specify the number of the labor ticket that you want to work with. If you are creating a new labor ticket, the system assigns this number.
User ID:	This is the computer ID of the person who posted the transaction.
Action (2,0):	Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

2=Revise

This action works in two ways.

If you specify Revise next to a ticket, Infor LX displays the Production Reporting maintenance screen, JIT600D2-01, in revise mode.

If you use F16 to select all tickets with your user ID for revision and then deselect some of the lines, specify Revise to select them again. An R next to a line indicates that you selected it for revision. In this case, Revise marks the line with an R to show it is selected for revision. It does not display the Production Reporting maintenance screen, JIT600D2-01.

4=Delete

This action works in two ways.

If you specify Delete next to a ticket, Infor LX displays the Production Reporting maintenance screen, JIT600D2-01, in the delete mode.

If you use F17 to select all tickets with your user ID for deletion, and then deselect some lines, specify Delete to select them again. In this case, Delete marks the line with a D to indicate that you selected it for deletion. It does not display the Production Reporting maintenance screen, JIT600D2-01.

5=Display

This action works in two ways:

If you specify Display next to a ticket, Infor LX displays the Production Reporting maintenance screen, JIT600D2-01, in the display mode.

If you use F15 to select all tickets with your user ID for display and then deselect some of the records, Display selects them again. In this case, Display marks the record with a V, for view, to indicate that you selected it for display. It does not display the Production Reporting maintenance screen, JIT600D2-01.

9=Select for Post

This action works in two ways:

If you have NOT used F14=Select for Post, it displays the Production Register Listing screen (JIT610D-01).

If you have used F14=Select for Post and then used action code 21=Deselect to deselect some of the records, action code 9 selects them again. In this case, action code Post marks the record with a P to indicate that you selected it for posting. It does not display JIT610D-01.

10=Shop Order Maintenance

Display the shop order header maintenance screen, SFC500D2-01. Depending on your security level, you can view or change information on this screen.

11=Shop Order Inquiry

Display the Shop Order Inquiry Transactions screen, SFC300D2-01.

17=Reset Labor Ticket Status

Reset the labor tickets that were in the process of being posted but were not completed.

21=De-Select for Post

Reverse your selection for posting. Specify Deselect for Post and then press Enter to deselect the ticket for posting. The letter P is gone.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Status:	The system displays the status of the labor ticket:
	A
	Active
	I
	Inactive
	P
	Posted
Item:	The system displays the number of the item that goes with the labor ticket.
Operation:	The system displays the number of the operation for this labor ticket. An operation is a specific step an item undergoes during its production.
Fac (3,A):	The system displays the facility associated with the labor ticket.
Work Center:	The system displays the work center for the operation.

Screen actions - JIT600D1-01

Commands	Description
F6=Accept	Process the tickets you selected with F14, F15, F16, or F17.
F14=Select for Post	Select all tickets created with your user ID for posting. The letter P appears next to selected tickets. To post, use F6, Accept. The system displays the Production Register Listing screen, JIT610D-01.
F15=Select for Display	Select all tickets created with your user ID for display. The letter V (for view) appears next to selected tickets. To display, use F6, Accept. The system displays the Production Reporting screen, JIT600D2-01, in display mode for the first ticket. Press Enter to see this screen for the next ticket.
F16=Select for Revise	Select all tickets created with your user ID for revision. The letter R appears next to selected tickets. To revise, use F6, Accept. The system displays the Production Reporting screen, JIT600D2-01, in revise mode for the first ticket. Press Enter to see this screen for the next ticket.
F17=Select for Delete	Select all tickets created with your user ID for deletion. The letter D appears next to selected tickets. To delete, use F6, Accept. The system displays the Production Reporting screen, JIT600D2-01, in the delete mode for the first ticket. Press Enter to delete this ticket and see this screen for the next ticket.
F18=Deselect All	ADeselect all the tickets you selected using F14, F15, F16, or F17. This action removes P, V, R, or D from the ticket.
F19=Material Status Inquiry	Display the Material Status Inquiry-Summary screen, INV300D-02. Use this screen to view the inventory level for an item.
F20=Allocations	Display the Shop Order Allocation Prompt screen, SFC720D1-01. Use this screen to select an item and see allocations against it.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add, maintain, or view a labor ticket

The system displays the Production Reporting screen, JIT600D2-01, in one of the following modes: create, revise, copy, delete, or display. If you are copying or deleting, press Enter to complete the action.

Use this screen to enter a new labor ticket or change an old one. The information you enter on this screen determines the type of posting you are doing. The system displays additional screens depending on your entries. Complete the fields you need to and press Enter to proceed.

You must complete the following fields: Type, Item Number, Operation or Work Center.

If you are posting time to multiple employees, you can leave the Emp\Line\Clock field blank and post the time on the Production Reporting-Employee screen, JIT600D3-01. If you are posting to a single employee, you must complete this field as well as the Hours or Start Time and Stop Time fields.

If you are posting quantities to multiple locations, leave the Quantity fields blank and post quantity on the Production Reporting-Lot screen, JIT600D4-01. If you are posting to a single location, you must complete the Quantity Good and Quantity Bad fields.

Field descriptions - JIT600D2-01

Fields	Description
Labor Ticket:	The system assigns this number automatically. It identifies the transaction you are working on. You cannot enter or change this number in any mode.
Date (6,0):	Specify the transaction date, that is, the actual date the employee worked.
Time (6,0):	If you are creating a labor ticket, the system enters the time of day you are creating it. You can change this time in both the create and revise modes. The times you enter must be in a 24-hour clock format with a decimal point between hours and minutes. The clock ranges from .01 to 24.59 (.01 and 24.01 are both equal to one minute after midnight. Since there is no 0.00, only 24.00 is midnight.) For example, enter 3:30 p.m. as 15.30.
Type (1,A):	Specify the type of labor you are posting. You must specify a type in create mode. R Run hours. Specify run hours to report man hours worked (not machine time). For example, if 5 people each worked 1 hour on a single operation for an order, report 5 run hours for that order. M Machine hours. Specify machine hours to report machine running time. Employee/clock number is optional. If you report machine hours with an employee number, you are viewing the employee not as a person, but as a machine. Use machine hours when you base cost and performance on machine standards, as with a very expensive operation where the labor cost is much lower than the machine cost per time. S Setup hours. Use setup hours to report the time spent preparing a work center or operation for processing an order. Since the time is independent of the

quantity produced, you do not need to complete the Quantity Good field to report setup hours.

I

Indirect labor, or labor not associated with a specific order. Use this labor type to record cost information for general labor activity. When you post indirect hours, you do not need to complete the Shop Order, Operation, Quantity, and Operation Complete fields.

D

Downtime hours. Use this labor type to analyze the unproductive time in the production process. Post downtime to keep the production process as efficient as possible. A variety of reasons can cause downtime: power failure, machine breakdown, labor strike, and so on. Specify a valid reason code when you post downtime.

To report run, setup, or machine hours, you must first enter a valid cost load code for the work center in Work Center Maintenance (CAP100) or a valid labor grade in Define Labor Grades (CST160).

Clock No. (8,A):   The system displays the clock number for this labor ticket. You can report production by individual employee or by production team.

To report production for an individual employee, specify the employee number or the clock number. You must first enter a labor rate in Employee/Clock Number Maintenance (SFC150) or a labor grade in Define Labor Grades (CST160).

To report production for a team, leave the Emp/Line/Clock field blank. Specify a Shift Team.

Note: If you have Using HCM Payroll turned on in your system parameters, this is a required field for all types of labor tickets. If you are reporting Machine or Downtime hours, you must also make an entry in the Payroll Hours field.

Item Number (35,A):   Specify the item number for which you want to post production. The number must exist in IDF Enterprise Item

To Location (10,A):   To override the work center or machine level inventory location, specify a valid location code. The system posts inventory to the location regardless of what you defined elsewhere. Define location codes through Location Master Maintenance, INV170.

F/G Lot#/Lot/QMS (25,A):   If your environment allows non-lot-controlled QMS items, the field name is Lot/QMS. If you environment does not allow this functionality, the field name is F/G Lot#. Quality processing tracks non-lot-controlled QMS item inventory

with a QMS sequence number. The system clears this number from the inventory when QMS processing is complete for this inventory.

If a manufactured item is lot controlled, you can type a lot number into this field when you post labor for the final operation. If it is a non-lot-controlled QMS item for which QMS quality processing is not yet complete, you can type the QMS sequence number here. If the item is not lot controlled or is a non-lot-controlled QMS item for which QMS processing is complete (no QMS sequence number), leave this field blank.

If Multiple Items per Lot is yes in API820 (Advanced Process Industries Parameters in System Parameters), then you can assign the same lot number to multiple items. This setting affects all facilities. You must use multiple items per lot throughout Infor LX. Inter-warehouse, location, and lot transfers must be consistent. The same is true for transaction processing.

Some industries need multiple items per lot because a given batch of material can produce many co-products, by-product, and grades of finished product. Other industries require a single item per lot because of hazardous materials, controlled substances, high monetary value, or a short shelf life. Single-item lot combinations provide simpler tracing of lot history and material use.

From Container (10,0): Specify the container number from which you are moving the item. This field applies only to container-controlled items.

Container ID (10,0): This field shows the container ID of the item, if it is container controlled.

To Container (10,0): Specify the container number to which you are moving the item. This field applies only to container-controlled items.

Operation (3,0): Specify the operation for which you are posting.

Facility (3,A): Specify the facility associated with the item. If you entered a work center, do not use this field.

Work Center (6,0): Specify the work center where the operation occurred. If you entered an operation or facility, do not use this field.

Operation Complete (1,0): Specify 1 if the operation is complete as of the time you are posting the labor ticket. By completing operations, you allow the system to keep track of orders according to their current, or open, operation. When the quantity finished equals the quantity required, the system automatically indicates that the order is complete.

Machine ID (10,A) Specify a valid machine ID if you want the program to perform backflush reporting or to process scrap reporting.

Shift (1,A):	Specify a user-defined shift code to identify the labor shift that processed the order through the operation or work center.
Shift Team (1,A):	Specify a number to report production by team number rather than by employee. The production reports list production hours by team.
Quantity Good (11,3):	You can enter the quantity of good pieces produced for the production release or you can leave this field blank. This field is used to measure standard piece production costs versus actual costs.
	If you update Actual Cost (Cost Set 1) and the Multi Currency System Parameter in MLT800D-01 defines a reporting currency, the system also updates the cost set for this reporting currency.
	Use this field is to update inventory balances and pieces remaining. The actual adjustments to these values occur after you post the production.
	If you enter the quantity of good pieces on this screen, the system does not display the Production Reporting - Lot, JIT600D4-01, screen.
	If you leave this field blank, the system displays the Production Reporting-Lot screen, JIT600D4-01. Use this screen to post the quantity to multiple locations.
	You cannot enter a negative number.
Quantity Rejected (11,3):	In order to analyze and improve production efficiency, it is necessary to track the number of units that were successfully produced and the number that were rejected. In this field, enter the quantity rejected at the specified work center/operation. If you enter a quantity into this field, you must indicate the reason for the rejection by completing the Reason Code field.
	The system uses this information to update the quantity rejected field in the FSO record for this shop order. The system uses the quantity rejected to calculate actual yield.
	If both Quantity Good and Quantity Reject are blank, the system displays the Production Reporting-Lot screen, JIT600D4-01.
Reason Code for Quantity Good (2,A):	If you entered a quantity good or downtime, specify a reason code. This code must be linked to a transaction effect in Reason Code Maintenance, INV140.
Reason Code for Quantity Rejected (2,A):	If you entered a quantity rejected, you must specify a reason code. This entry associates a predefined reason for the reject quantity. The reason code for rejected quantity must be linked to the RJ transaction effect in INV140. Define reason codes in Reason Code Maintenance, INV140. The system uses this code for costing reports to specify why a reject quantity was posted.

Hours (8,3):
Use this field or the Start Time and Stop Time fields to enter the time for the operation you are posting. If you entered an employee number, you must complete this field. If you did not enter an employee number, you are entering time for multiple employees, and you do not need to complete this field. Enter time for multiple employees on the Production Reporting-Employee screen, JIT600D3-01.

Enter your time in decimal format. For example, enter 2 hours and 30 minutes as 2.5. Your entry can be a positive or negative number, but it cannot be zero.

Start Time (4,2):
Use the Start Time and Stop Time fields or the Hours field to enter time. If you enter a Start Time and Stop Time, the system calculate the hours. If you enter an employee number, you must enter time. If you did not enter an employee number, you are entering time for multiple employees, and you do not need to complete this field. You will enter time for multiple employees on the Production Reporting-Employee screen, JIT600D3-01.

To report zero hours for an operation, enter the same start and stop time.

Enter times in a 24-hour clock format with a decimal point between hours and minutes.

The clock ranges from .01 to 24.59. Since there is no 0.00, only 24.00 is midnight. For example, enter 3:30 p.m. as 15.30. If you enter identical values for start and stop, the system posts zero hours. Your input must be a positive number or zero. The clock may span between days but you cannot post more than 23.59 hours between start and stop. The system does not subtract lunch time or break time from the start and stop times you enter. You can manually adjust the times that you enter. For example, if employees work 8:00 am to 4:30 pm with 30 minutes of unpaid lunch, enter 8.00 and 16.00.

Note: When you are revising a labor ticket, you must clear the Start Time and Stop Time fields. These fields must be blank in order for the system to update properly.

Stop Time (4,2):
Use the Start Time and Stop Time fields or the Hours field to enter time. If you enter a Start Time and Stop Time, the system calculate the hours. If you did not enter an employee number, you are entering time for multiple employees, and you do not need to complete this field. You will enter time for multiple employees on the Production Reporting-Employee screen, JIT600D3-01.

To report zero hours for an operation, enter the same start and stop time.

The times entered must be in a 24-hour clock format with a decimal point between hours and minutes. See Start Time for additional information.

Note: When you are revising a labor ticket, you must clear the Start Time and Stop Time fields. These fields must be blank in order for the system to update properly.

Payroll Hours (8,3):

Specify the number of hours of employee time (or fractional hours) for this labor type on this ticket. This is a required field if you are reporting Machine or Downtime hours and the clock number is for a non- Infor LX employee. You can either complete this field or specify both a start and stop time in the next two fields. Enter hours in decimal format: Enter 2 hours and 30 minutes as 2.5 or 2.50. You can enter positive or negative numbers, but you cannot enter zero.

Note: This input need not match the number of down hours for the machine, as entered in the first Hours field. For example, you might have a machine down for 2 hours. The employee payroll hours corresponding to this might be 2 hours (time spent trying to get the machine back up and running, or time waiting for the machine to be available again), or it might be 15 minutes - the employee's downtime until he or she could get to another machine and continue working. If you are reporting Machine type hours, the Payroll hours are for the employee not for the time that the machine was run. For example, one person might run 4 or 5 machines. The hours entered for machine hours could be 40 while the payroll hours for the person running the machines payroll hours could be 8.

Start Time (4,2):

If you do not indicate the specific number of hours in the Payroll Hours field, use these two fields to establish a start and stop time for the employee labor activity. The times entered must be in a 24-hour clock format with a decimal point between hours and minutes. The clock ranges from .01 to 24.59 (.01 and 24.01 are both equal to one minute after midnight; since there is no 0.00, only 24.00 is midnight.) For example, enter 3:30 p.m. as 15.30. Posting identical values for start and stop will post zero hours. The clock may span between days but you must post less than 24.00 hours between start and stop.

Stop Time (4,2):

If you do not indicate the specific number of hours in the Payroll Hours field, use these two fields to establish a start and stop time for the employee labor activity. The times entered must be in a 24-hour clock format with a decimal point between hours and minutes. The clock ranges from .01 to 24.59 (.01 and 24.01 are both equal to one minute after midnight; since there is no 0.00, only 24.00 is midnight.) For example, enter 3:30 p.m. as 15.30. Posting identical values for start and stop will post zero hours. The clock may span between days but you must post less than 24.00 hours between start and stop.

Screen actions - JIT600D2-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add or select employees to maintain hours

Use the Production Reporting-Employee screen, JIT600D3-01, to enter or view hours for multiple employees. On this screen you select an action to perform and then enter the details on the Production Reporting-Employee Detail screen, JIT600D3-02. When you have performed all actions necessary, use F6 to accept your entries on this screen.

The system displays this screen if you made the following entries on the Production Reporting screen, JIT600D2-01:

Type Code. Specify Run, Setup, or Indirect

Clock No. Leave this field blank.

Field descriptions - JIT600D3-01

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation.
Crew (8,A):	Specify the number that identifies the crew for which you want to report time.
	Note: You must enter a clock number that you created in Infor LX.
Operation:	The system displays the operation for which you are posting time.
Operation Description:	The system displays a description of the operation.
Item:	The system displays the item for which you are posting time.
Type:	The system displays the hours type for this transaction.
	R
	Run hours
	M

Machine hours

S

Setup hours

I

Indirect labor, or labor not associated with a specific order

D

Downtime hours

Work Center:	The system displays the work center for which you are posting time.
Shift:	The system displays the shift for which you are posting time.
To Location:	The system displays the location where the quantity was posted.
Team:	The system displays the shift team that you entered on the Production Reporting screen, JIT600D2-01.
Quantity Good:	The system displays the number of pieces that are good. This is the value that you entered on the Production Reporting screen, JIT600D2-01.
Quantity Rejected:	The system displays the number of pieces that are not good. This is the value that you entered on the Production Reporting screen, JIT600D2-01.
Date:	The system displays the date that you are posting this transaction.
Action (2,0):	Specify the number for the line action to perform and press Enter.
	All line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.
Clock No. (8,A):	Specify a clock number.
Description:	The system displays a description of the clock number, such as the labor grade or rate.
Start Time:	The system displays the time that the employee started and ended the operation. Specify these times on the Production Reporting-Employee screen, JIT600D3-02. Time is in a 24-hour format with a decimal point between the hours and minutes. For example, 3:30 p.m. is 15.30 on this screen.
	If you specify Hours, these fields are blank.

End Time:

The system displays the time the employee started and ended the operation. Specify these times on the Production Reporting-Employee screen, JIT600D3-02. Time is in a 24-hour format with a decimal point between the hours and minutes. For example, 3:30 p.m. is 15.30 on this screen.

If you specify Hours, these fields are blank.

Hours:

The system displays the number of hours the employee worked on the operation. Specify this amount on the Production Reporting-Employee screen, JIT600D3-02.

If you specify start and end times, this field is blank.

Reason:

The system displays the reason for the hours worked. Specify the reason on the Production Reporting-Employee screen, JIT600D3-02. Define reason codes in INV140, Reason Code Maintenance. For normal run hours, the default is 01.

Screen actions - JIT600D3-01

Commands	Description
F6=Accept	Accept your entries on this screen and proceed to the next screen.
F11=Fold	Display additional fields.
F21=Cancel Ticket	Cancel all your work on this ticket and return to the JIT600D1-01, Production Reporting screen.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add, maintain, or view employee hours

Use the Production Reporting-Employee screen, JIT600D3-02, to enter time for an individual employee. Specify the employee number, hours worked (or start time and stop time) and press Enter to return to the Production Reporting-Employee list screen, JIT600D3-01.

This screen appears in the create, revise, delete, and display modes.

Access: Specify a line action on the Production Reporting-Employee screen, JIT600D3-01.

Field descriptions - JIT600D3-02

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production that you are posting.
Machine ID:	The system displays the machine for the operation.
Crew:	The system displays the crew number, if any, associated with this transaction. Note: Specify a clock number created in Infor LX.
Operation:	The system displays the operation for which you are posting time.
Operation Description:	The system displays a description of the operation.
Hours:	The system displays the hours that you entered for this operation.
Item:	The system displays the item for which you are posting time.
Type:	The system displays the hours type for this transaction. R Run hours M Machine hours S Setup hours I Indirect labor, or labor not associated with a specific order D Downtime hours
Work Center:	The system displays the work center for which you are posting time.
Shift:	The system displays the shift for which you are posting time.
To Location:	The system displays the location where the quantity was posted.
Team:	The system displays the shift team.

Quantity Good: The system displays the number of pieces that are good. This is the value that you entered on the Production Reporting screen, JIT600D2-01.

Quantity Rejected: The system displays the number of pieces that are not good. This is the value that you entered on the Production Reporting screen, JIT600D2-01.

Date: The system displays the date you are posting this transaction.

Labor Ticket Number: The system displays the system-assigned number for this transaction.

Clock No. (8,A): Specify the clock number of the employee for to record hours worked. Define clock numbers through Employee/Clock Number Maintenance, SFC150. If this is an HCM Payroll employee, define the clock number in the HCM system.

Description: The system displays a description of the employee associated with the clock number.

Start Time (4,2): Specify the time the employee started the operation. Use the 24-hour format with a decimal point between the hours and minutes. For example, 3:30 p.m. is 15.30 on this screen.

Do not specify a start time if you enter Hours.

Stop Time (4,2): Specify the time the employee ended the operation. Use the 24-hour format with a decimal point between the hours and minutes. For example, 3:30 p.m. is 15.30 on this screen.

Do not specify a stop time if you enter the Hours.

Hours Worked (7,2): Specify the number of hours the employee worked on the operation.

Do not specify Hours if you enter a Start Time and Stop Time.

Reason Code (2,A): Specify the reason for the labor time. If you do not make an entry the system defaults to 01.

Maintain reason codes in Reason Code Maintenance, INV140.

Screen actions - JIT600D3-02

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add or select a location

Use the Production Reporting-Lot screen, JIT600D4-01, to enter quantities to locations. Select a line action to perform and then enter the details on the Production Reporting-Lot screen, JIT600D4-02. When you have performed all actions necessary, use F6 to accept your entries on this screen.

The system displays this screen if you leave the Quantity fields blank on the Production Reporting screen, JIT600D2-01.

Field descriptions - JIT600D4-01

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation.
Hours:	The system displays the hours for this transaction.
Operation:	The system displays the operation for which you are posting time.
Type:	The system displays the hours type for this transaction.
	R
	Run hours
	M
	Machine hours
	S
	Setup hours
	I
	Indirect labor, or labor not associated with a specific order
	D

Downtime hours

Item: The system displays the item for which you are posting time.

Shift: The system displays the shift for which you are posting time.

Work Center: The system displays the number of the work center associated with this operation.

Team: The system displays the shift team.

To Location: The system displays the location where the quantity is posted.

Date: The system displays the date you are posting this transaction.

Action: The following line action is available:

22=Serial Numbers

If the item is serial number controlled, the Serial Number Assignment/Confirmation screen is displayed. Use this screen to maintain the serial numbers assigned to this item.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Act (2,0): Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

22=Serial Numbers

If the item is serial number controlled, the Serial Number Assignment/Confirmation screen is displayed. Use this screen to maintain the serial numbers assigned to this item.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Lot Number/QMS Sequence (25,A): Specify a lot number if the parent is a lot-controlled item or the QMS sequence number if it is a non-lot-controlled QMS item.

Location (10,A): Specify the location for posting this lot.

Quantity Good: The system displays the number of pieces that are good. This is the value you entered on the Production Reporting-Lot screen, JIT600D4-02.

Quantity Good Reason Code:	This code shows why the pieces are acceptable. The default is 01. Maintain reason codes in Reason Code Maintenance, INV140.
Quantity Rejected:	The system displays the number of pieces that are not acceptable. This is the value you entered on the Production Reporting-Lot, JIT600D4-02, screen..
Quantity Rejected Reason Code:	This code shows why the pieces were rejected. You maintain reason codes in Reason Code Maintenance, INV140.
Warehouse (3,A):	The system displays the warehouse associated with the location.
	Note: You cannot issue or receive material from or to a warehouse type 4, Warehouse BOSS-controlled warehouse, or type 5, WMS-4000-controlled warehouse, with this program.

Screen actions - JIT600D4-01

Commands	Description
F6=Accept	Accept your entries on this screen and proceed to the next screen.
F21=Cancel Ticket	Cancel all your work on this ticket and return to the JIT600D1-01, Production Reporting screen.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add, maintain, or view locations

Use the Production Reporting-Lot screen, JIT600D4-02, to enter the specific locations for the quantities you are posting. Specify the location information and press Enter. The system saves the location information and returns you to the Production Reporting-Lot screen, JIT600D4-01.

The system displays this screen in the create, revise, delete, and display modes. You can enter information in both the create mode and revise modes. To delete information for a location, review the information and then press Enter to confirm your choice.

The system displays this screen if you specify an action on the Production Reporting-Lot screen, JIT600D4-01.

Field descriptions - JIT600D4-02

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation.
Hours:	The system displays the hours you entered for this transaction on either the Production Reporting-Employee screen, JIT600D3-02 or the Production Reporting screen, JIT600D2-01.
Operation:	The system displays the operation for which you are posting time.
Type:	The system displays the hours type for this transaction.
	R
	Run hours
	M
	Machine hours
	S
	Setup hours
	I
	Indirect labor, or labor not associated with a specific order
	D
	Downtime hours
Operation Description:	The system displays a description of the operation.
Item:	The system displays the item for which you are posting time.
Shift:	The system displays the shift for which you are posting time.
Work Center:	The system displays the number of the work center associated with this operation.
Team:	The system displays the shift team.
To Location:	The system displays the location where the quantity was posted.
Date:	The system displays the date you are posting this transaction.

Receiving Warehouse (3,A): Specify the warehouse code for the receiving warehouse.

Note: You cannot issue or receive material from or to a warehouse type 4, Warehouse BOSS-controlled warehouse, or type 5, WMS-4000-controlled warehouse, with this program.

Receiving Location (10,A): Specify the location code within the warehouse where the quantity is received.

Receiving Lot/Receiving QMS Seq (25,A): Specify the lot number to which the quantity is received for a lot-controlled item or the QMS sequence number to which it is received if it is a non-lot-controlled QMS item. If you do not enter a lot or QMS sequence number, the system creates one.

Quantity Good (11,3): Specify the number of good pieces produced for this operation. If you do not make an entry here, you must make an entry in the Quantity Rejected field.

Quantity Good Reason Code (2,A): Specify the code for the good quantity. The default is 01. Maintain reason codes in Reason Code Maintenance, INV140.

Quantity Rejected (11,3): Specify the quantity rejected. Tracking the number of unsuccessfully produced pieces helps to improve efficiency and quality. If you do not make an entry here, you must make one in the Quantity Good field. If you enter a value here, you must enter a reason code.

The system uses to update the quantity rejected field in the FSO file for this shop order. The system uses the quantity rejected to calculate actual yield.

Quantity Rejected Reason Code (2,A): Specify the reason code for the rejected quantity. The reason code for rejected quantity must be linked to the RJ transaction effect in INV140. Define reason codes in Reason Code Maintenance, INV140. The system uses this code on costing reports to indicate why you posted a reject quantity.

Container ID (10,A): Specify an ID for the container, if this is a container-controlled item.

Container Type (10,A): Specify a container type, if this is a container-controlled item.

From Container (10,A): Specify the container the item is coming from, if this is a container-controlled item.

Screen actions - JIT600DD4-02

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add or select component items to backflush

Use the Production Reporting-Backflush screen, JIT600D5-01, to backflush component items consumed during the operation and all prior non-collectible operations. If you have no changes to the BOM for the parent item for this operation, use F6 to accept and display the next screen.

If you do have changes to the BOM, for example, the operation needed three units of a component item instead of the usual two, you select an action to perform on that component and then enter the details on the Production reporting-backflush, JIT600D5-02 screen. When you have performed all actions necessary, use F6 to accept your entries on this screen.

If you add a component to be backflushed using this screen and the Production Reporting-Backflush screen, JIT600D5-02, the system adds the information to the ITH file and updates the shop order. However, Infor LX does not reflect this addition when you cost the shop order. To properly update costs, you must use a single issue transaction in Inventory Transactions, INV500, or add the component to the shop order prior to reporting production.

The system displays this screen if the Hours Type on the Production Reporting screen, JIT600D2-01, is anything other than setup or indirect hours.

The system calculates the quantity issued by multiplying the quantity required for that component by the percentage of the quantity reported, divided by the quantity required at that operation. The system calculates the quantity scrapped by multiplying the material scrap factor by the quantity issued.

The system does not backflush assigned operation components if a collectible operation specified as non-collectible.

Field descriptions - JIT600D5-01

Fields	Description
Schedule Entry Number:	The system displays the sequence number of the production schedule for this labor ticket.
Schedule Total:	The system displays the total number of production schedules for this labor ticket.
Labor Ticket:	The system displays the labor ticket number for the production you are posting.

Machine ID: The system displays the code that identifies the machine for the operation.

Operation: The system displays the operation that you are reporting on.

Operation Description: The system displays a description of the operation.

Hours: The system displays the hours you entered for this transaction on either the Production Reporting-Employee screen, JIT600D3-02 or the Production Reporting screen, JIT600D2-01.

Item: The system displays the item that you are reporting on.

Item Description: The system displays a description of the item.

Type: The system displays the hours type that you entered on the Production Reporting screen, JIT600D2-01.

R

Run hours

M

Machine hours

S

Setup hours

I

Indirect labor, or labor not associated with a specific order.

D

Downtime hours

Work Center: The system displays the work center you are reporting on.

Work Center Description: The system displays a description of the work center.

Shift: The system displays the shift you are reporting on.

To Location: The system displays the location where you posted the quantity.

Location Description: The system displays a description of the location.

Team: The system displays the shift team.

Quantity Good: The system displays the number of pieces that were good.

Quantity Rejected: The system displays the number of pieces that were not good.

Date: The system displays the date that you are posting this transaction. The system enters this date.

Action: The following line actions are available:

4=Delete

To delete a single item component, specify delete next to it and press Enter.

To delete all, set the issue quantity for at least one component to 0.

22=Serial Numbers

Added: *MR76077 Action code 22=Serial Numbers*

If the item is serial number controlled, the Serial Number Assignment/Confirmation screen is displayed. Use this screen to maintain the serial numbers assigned to this item.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Act (2,0):   Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

4=Delete

To delete a single item component, specify delete next to it and press Enter.

To delete all, set the issue quantity for at least one component to 0.

22=Serial Numbers

If the item is serial number controlled, the Serial Number Assignment/Confirmation screen is displayed. Use this screen to maintain the serial numbers assigned to this item.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Operation (3,0):   Specify the operation code for the component item that you are backflushing.

Item Number (15,A):   Specify the number of the component item that you want to backflush.

FMA: The system displays the sequence number from the Infor LX material allocation file. Each component item has a sequence number.

Warehouse:　　The system displays the warehouse where the item is located.

Note: You cannot issue or receive material from or to a warehouse type 4, Warehouse BOSS-controlled warehouse, or type 5, Infor SCE-controlled warehouse with this program.

Location:　　The system displays the specific location of the item within the warehouse.

Lot Number/Lot/Seq (25,A):　　The system displays the lot number if this is a lot controlled item. The system displays the QMS sequence number if your environment allows non-lot-controlled QMS items and if QMS quality processing is not complete for a non-lot QMS item quantity.

Container:　　If this is a container-controlled component, the system displays its container number.

Reason Code:　　The system displays the reason code for either the Quantity Good or the Quantity Rejected.

Issue Quantity:　　The system displays the amount of the component item that needs to be backflushed.

Type:　　The system displays the type of allocation against the component.

1

Issue

2

Allocated

3

Backflush

4

Unallocated

Screen actions - JIT600D5-01

Commands	Description
F6=Accept	Accept your entries on this screen and proceed to the next screen.
F21=Cancel Ticket	Cancel all your work on this ticket and return to the JIT600D1-01, Production Reporting screen.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Add, maintain, or view component items to backflush

Use the Production Reporting-Backflush screen, JIT600D5-02, to enter the details about each component item you are backflushing. You reach this screen by choosing an action on the Production Reporting-Backflush screen, JIT600D5-01.

This screen appears in the create, revise, delete, and display modes.

Field descriptions - JIT600D5-02

Fields	Description
Schedule Entry Number:	The system displays the sequence number of the production schedule for this labor ticket.
Schedule Total:	The system displays the total number of production schedules for this labor ticket.
Labor Ticket:	The system displays the labor ticket number for the production you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation.
Operation:	The system displays the operation that you are reporting on
Operation Description:	The system displays a description of the operation.
Hours:	The system displays the hours you entered for this transaction on either the Production Reporting-Employee screen, JIT600D3-02 or the Production Reporting screen, JIT600D2-01.
Item:	The system displays the item that you are reporting on

Item Description: The system displays a description of the item.

Type: The system displays the hours type you entered on the Production Reporting screen, JIT600D2-01.

R

Run hours

M

Machine hours

S

Setup hours

I

Indirect labor, or labor not associated with a specific order.

D

Downtime hours

Work Center: The system displays the work center that you are reporting on.

Work Center Description: The system displays a description of the work center.

Shift: The system displays the shift that you are reporting on.

To Location: The system displays the location where the quantity was posted.

Location Description: The system displays a description of the location.

Team: The system displays the shift team.

Quantity Good: The system displays the number of pieces that are good.

Quantity Rejected: The system displays the number of pieces that are not good.

Date: This is the date you are posting this transaction. The system enters this date.

Operation (3,0):   Specify the number of the operation for which you are reporting. You can enter data in this field in the create mode.

Component Item (35,A):   Specify the number of the component item. You can enter data in this field in the create mode.

Component Item De-scription:	The system displays a description of the component item.
Sequence Number (3,0):	The system displays the sequence number from the Infor LX material allocation file. Each component item has a sequence number.
Component Warehouse (3,A):	Specify the warehouse of the component from which you want to backflush the quantity. You can enter data in this field in the create mode.
	Note: You cannot issue or receive material from or to a warehouse type 4, Warehouse BOSS-controlled warehouse, or type 5, WMS-4000-controlled warehouse, with this program.
Warehouse Description:	The system displays a description of the warehouse.
Component Location (10,A):	Specify the location within the warehouse from which you want to backflush the quantity. You can enter data in this field in the create mode.
Component Location Description:	The system displays a description of the location.
Component Lot/Compo-nent QMS Seq (25,A):	If the component item is lot controlled, specify its lot number. If it is a non-lot-controlled QMS item, specify the QMS sequence number. You can enter data in this field in create mode.
Container ID (10,A):	If the component item is container controlled, specify the ID number of its container. You can enter data in this field in the create mode.
Container Type (10,A):	If the component item is container-controlled, specify the type of container.
Container Type Descrip-tion:	The system displays a description of the container.
Quantity Good (11,3):	Specify the number of good component pieces. If you do not make an entry here, you must enter the quantity rejected.
Issue Reason Code (2,A):	Specify the code for the good quantity. The default is 01. Maintain reason codes in Reason Code Maintenance, INV140.
Issue Reason Explana-tion:	The system displays an explanation of the issue code.
Reject Reason Explana-tion:	The system displays an explanation of the reject code.

Quantity Rejected (11,3):	Specify the number of rejected component pieces. Tracking the number of unsuccessfully produced pieces helps to improve efficiency and quality. If you do not make an entry here, you must enter the quantity that is good. If you enter an amount here, you must enter a reason code.
	The system uses this information to update the quantity rejected field in the FSO record for this shop order. The system uses the quantity rejected to calculate actual yield.
Quantity Rejected Reason Code (2,A):	Specify the reason code for the rejected quantity. The reason code for rejected quantity must be linked to the RJ transaction effect in INV140. Maintain reason codes in Reason Code Maintenance, INV140. The system uses this code for costing reports to specify why you posted a reject quantity.

Screen actions - JIT600D5-02

Commands	Description
All Screen Actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Post a production schedule

Use the Production Reporting Schedule screen, JIT600D6-01, to post a labor ticket for an entire production schedule. The system displays this screen if you are posting a new labor ticket, not if you are revising an existing ticket.

Specify the date of the schedule you want to post and press Enter. Use F6 to accept.

This screen displays all orders with the same combination of item, operation, or work center that you entered on the Production Reporting screen, JIT600D2-01. The system displays this screen after you complete the JIT600D2-01 screen.

Field descriptions - JIT600D6-01

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production that you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation.
Operation:	The system displays the operation for which you are posting time.

Operation Description: The system displays a description of the operation.

Hours: The system displays the hours that you entered for this transaction on either the Production Reporting-Employee screen, JIT600D3-02 or the Production Reporting screen, JIT600D2-01.

Item (35,A): The system displays the item for which you are posting time.

Item Description (50,A): The system displays a description of the item.

Type: The system displays the hours type that you entered on the Production Reporting screen, JIT600D2-01.

R

Run hours

M

Machine hours

S

Set up hours

I

Indirect labor

D

Downtime hours

Work Center: The system displays the work center for which you are posting time.

Work Center Description: The system displays a description of the work center.

Shift: The system displays the shift for which you are posting time.

To Location: The system displays the location where the quantity was posted.

Location Description: The system displays a description of the location.

Team: The system displays the shift team.

Quantity Good: The system displays the quantity of pieces that you entered as good.

Quantity Rejected: The system displays the quantity of pieces that you entered as not good.

Date: The system displays the posting date for this transaction.

Schedule Date:	Specify the date of the schedule that you want to post.
Item Number:	The system displays the number of the item from the production schedule.
Operation:	The system displays the operation of the item you are posting.
Work Center:	The system displays the work center associated with the operation.
Date:	The system displays the date of the scheduled order.
Time:	The system displays the time that you posted this labor ticket.
Quantity Good (11,3):	Specify the number of good pieces produced. This number must match what you entered on the Production Reporting screen, JIT600D2-01. If you did not enter a quantity on the Production Reporting screen, JIT600D2-01, you do not have to make an entry here.
Quantity Rejected (11,3):	Specify the number of rejected pieces. Tracking the number of unsuccessfully produced pieces helps to improve efficiency and quality. This number must match the value that you entered on the Production Reporting screen, JIT600D2-01. If you made no quantity entry on the Production Reporting, JIT600D2-01, screen, you do not have to make an entry here.
	The system uses this information to update the quantity rejected field in the FSO record for this shop order. The system uses the quantity rejected to calculate actual yield.
Shift Hours:	The system displays the time worked by the crew.
Complete Flag (1,0):	Specify yes if the operation is complete, otherwise specify no.

Screen actions - JIT600D6-01

Commands	Description
F6=Accept	Accept your entries on this screen and proceed to the next screen.
F21=Cancel Ticket	Cancel all your work on this ticket and return to the JIT600D1-01, Production Reporting screen.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain containers for container-controlled items

The system displays the Parent Container Entry screen, JIT600D9-01, if the item is container-controlled. Designate items as container-controlled in the IDF Enterprise Item.

You can use this screen to create some of the entries automatically or you can enter all the information manually.

- To use the screen to automatically create container IDs for the item, complete the Quantity per Container and the Container Type fields. Press Enter. Infor LX completes the bottom part of the screen by creating enough container IDs to hold the quantity. For example, assume that you enter 100 as the quantity good on the Production Reporting screen, JIT600D2-01 or on the Production Reporting-Lot screen, JIT600D4-02. Assume that the Quantity per Container is 20. Infor LX creates five container IDs, each holding 20 pieces of the item.

- To enter the information manually, leave the Quantity per Container and Container Type fields blank. Specify Create to add a record. The system displays the Parent Container Entry screen, JIT600D9-02. Enter the detail, such as container type, quantity good or bad, and reason code. Press Enter to return to the Parent Container Entry screen, JIT600D9-01.

When you have performed all actions necessary, use F6 to accept the Parent Container Entry screen, JIT600D9-01.

Field descriptions - JIT600D9-01

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation.
Hours	The system displays the hours that you entered for this transaction on either the Production Reporting-Employee screen, JIT600D3-02 or the Production Reporting screen, JIT600D2-01.
Operation:	The system displays the operation for which you are posting time. This is the operation that you entered on the Production Reporting screen, JIT600D2-01.
Type:	The system displays the hours type for this transaction.
	R
	Run hours.
	M
	Machine hours
	S

Setup hours.

I

Indirect labor, or labor not associated with a specific order.

D

Downtime hours

Operation Description: The system displays a description of the operation.

Item: The system displays the item for which you are posting time.

Shift: The system displays the shift for which you are posting time. This is the shift that you entered on the Production Reporting screen, JIT600D2-01.

Work Center: The system displays the number of the work center associated with this operation.

Team: The system displays the shift team for this transaction. This is the team that you entered on the Production Reporting screen, JIT600D2-01.

To Location: The system displays the location where the quantity was posted. This is the location that you entered on the Production Reporting screen, JIT600D2-01.

Quantity Good: The system displays the number of pieces that are good. This is the value that you entered on the Production Reporting screen, JIT600D2-01.

Quantity Rejected: The system displays the number of pieces that are not good. This is the value that you entered on the Production Reporting screen, JIT600D2-01.

Lot: The system displays the lot number associated with the item. You entered it on Labor Ticket Posting by Lot detail screen, JIT600D4-02. Maintain lot numbers in Lot Master Maintenance, INV130.

Date: The system displays the date you are posting this transaction. The system enters this date.

Quantity per Container (11,3): Specify the quantity of the item per container. The default value for this item is in IDF Enterprise Item.

Container Type (10,A): Specify the type of container for this item.

Action: The following line action is available:

22=Serial Numbers

If the item is serial number controlled, the Serial Number Assignment/Confirmation screen is displayed. Use this screen to maintain the serial numbers assigned to this item.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

Act (2,0): Specify the number for the line action to perform and press Enter. To use the first line, specify the line action and at least one key field value.

22=Serial Numbers

If the item is serial number controlled, the Serial Number Assignment/Confirmation screen is displayed. Use this screen to maintain the serial numbers assigned to this item.

All other line actions on this screen perform standard Infor LX functions. See *Generic help text for line actions (p. 15)* in the overview information in this document.

From Container (10,0): Specify the container ID from which you are moving the item.

Container ID (10,0): Specify the number of the container you want to work with.

Container Type (10,A) Specify the type of container for this item.

Quantity Good: The system displays the number of pieces in this container that are good.

Quantity Good Reason Code: The system displays the code for good quantity. The default is 01.

Quantity Rejected: The system displays the number of pieces that were rejected.

Quantity Rejected Reason Code: The system displays the reason the pieces were rejected.

Screen actions - JIT600D9-01

Commands	Description
F6=Accept	Accept your entries on this screen and proceed to the next screen.
F21=Cancel Ticket	Cancel all your work on this ticket and return to the JIT600D1-01, Production Reporting screen.
Standard screen actions	All other screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Maintain container detail for container-controlled items

Use the Parent Container Entry Detail screen, JIT600D9-02, to enter information for each container. When you have completed your entries, press Enter. The system returns you to the Parent Container Entry screen, JIT600D9-01.

This screen appears in the create, revise, delete, and display modes. All fields that are enterable in the create mode are enterable in the revise mode as well. To delete, press Enter to confirm your choice.

You reach this screen by choosing an action from the Parent Container Entry screen, JIT600D9-01.

The top part of this screen displays general information about this ticket that you entered on the Production Reporting screen, JIT600D2-01. Use the bottom portion of the screen to enter container information.

Field descriptions - JIT600D9-02

Fields	Description
Labor Ticket:	The system displays the labor ticket number for the production you are posting.
Machine ID:	The system displays the code that identifies the machine for the operation, if you entered one on the Production Reporting screen, JIT600D2-01.
Hours:	The system displays the hours that you entered for this transaction on either the Production Reporting-Employee screen, JIT600D3-02 or the Production Reporting screen, JIT600D2-01.
Operation:	The system displays the operation for which you are posting time. You entered this on the Production Reporting screen, JIT600D2-01.
Type:	The system displays the hours type for this transaction. R

Run hours.

M

Machine hours

S

Setup hours.

I

Indirect labor, or labor not associated with a specific order.

D

Downtime hours

Item:	The system displays the item for which you are posting time.
Shift:	The system displays the shift for which you are posting time. You entered it on the Production Reporting screen, JIT600D2-01.
Work Center:	The system displays the number of the work center associated with this operation.
Team:	The system displays the shift team that you entered on the Production Reporting screen, JIT600D2-01.
To Location:	The system displays the location where the quantity was posted. You entered it on the Production Reporting screen, JIT600D2-01.
Quantity Good:	The system displays the number of pieces that are good. You entered this value on the Production Reporting screen, JIT600D2-01.
Quantity Rejected:	The system displays the number of pieces that are not good. You entered this value on the Production Reporting screen, JIT600D2-01.
Lot:	The system displays the lot number associated with the item. You entered the lot on the Production Reporting-Lot screen, JIT600D4-02. Maintain lot numbers in Lot Master Maintenance, INV130.
Date:	The system displays the date you are posting this transaction. The system enters this date.
Quantity per Container:	Specify the quantity of the item per container. The default value is in IDF Enterprise Item.
Container Type (10,A):	Specify the type of container for this item.

Receiving Warehouse (3,A): The system displays the code for the warehouse receiving the item.

Receiving Location (10,A): The system displays the location within the receiving warehouse for this item.

Receiving Lot (25,A): The system displays the lot number for this item.

Receiving Item (35,A): The system displays the number of the item you are receiving.

Quantity Good (11,3): Specify the number of good pieces produced.

Quantity Good Reason Code (2,0): Specify a reason code for the good pieces produced. The default is 01. Maintain reason codes in Reason Code Maintenance, INV140.

Quantity Rejected (11,3): Specify the number of rejected component pieces. Tracking the number of unsuccessfully produced pieces helps to improve efficiency and quality. If you do not make an entry here, you must make one in the Quantity Good field. If you enter an amount here, you must enter a reason code.

This information is used to update the quantity rejected field in the FSO record for this shop order. The system uses the quantity rejected to calculate actual yield.

Quantity Rejected Reason Code (2,0): Specify the reason code for the rejected quantity. The reason code for rejected quantity must be linked to the RJ transaction effect in Reason Code Maintenance, INV140. The system uses this code for costing reports to indicate why a reject quantity was posted.

Container ID (10,0): Specify the number of the container for this item.

From Container (10,0): Specify the ID of the container from which you are moving the item.

Screen actions - JIT600D9-02

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production register listing

Use the Production Register Listing screen, JIT610D1-01, to print an edit list of the labor tickets that you added or updated. Use this report to see the data to post before you actually perform the update.

After you print the edit list, you can go back to Production Reporting (JIT600) and change the data before you post the batch. The program assigns a number to each production report that you posted in JIT600. You can use JIT600 to reference the production report that you want to update.

Access: Specify Post on Production Reporting, JIT600D1-01.

Print the production register list

Use the Production Register Listing screen, JIT610D1-01, to submit the job to print the register list.

Field descriptions - JIT610D-01

Fields	Description
Run Production Regis-ter Report (1,0):	Specify 1 to confirm that you want to run the Production Register Report. Specify 0 if you do not want to execute this program now.

Screen actions - JIT610D-01

Commands	Description
Standard screen ac-tions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production Update

This program executes the labor update set up in Production Reporting (JIT600). This program updates the system master files with data from the production report work file.

After you run this program, you cannot go back and change a particular production report. Before you run this program, it is a good idea to print the edit list from the Production Register Listing screen, JIT610D1-01, to verify your posting. You can go back to JIT600 to make any desired changes before you perform the actual update with this program.

As with JIT600, you can run this program from more than one workstation at a time.

When you execute this program, the system performs backflushing or pull-through, depending on the production reports entered from JIT600. Backflushing is the process of transforming component item allocations into issues.

For backflushing to occur, you must have posted a production report for an operation that is linked to the bill of material for the ordered item through Bill of Material Maintenance, BOM500. However, backflushing can only occur if the item is not single-issued, as defined in IDF Enterprise Item.

Issues created by backflushing material requirements are taken from the warehouse from which they were allocated when you executed the Production Print program (JIT550). If there is not enough inventory at that warehouse, the system issues material from the default warehouse location you specified through Facility Items.

Pull-through occurs only for non-reporting operations that appear on a routing between two reporting operations. When production reporting is posted for the reporting operations that occur before and after the non-reporting operation, the system presumes that the non-reporting operation must have been performed since the other two operations were completed normally. When this occurs, the system posts standard machine, labor, and run hours for the non-reporting operation and creates any necessary

material issues to the shop floor (backflushes material requirements). Thus, the reported operations create implied material usage at the non-reporting operations.

There are two conditions that cause the system to view an operation as being non-reporting. If the date on which you execute the Production Update program, JIT620, falls outside of the collection effective period defined for an operation through Routing Maintenance, SFC100, then the operation is non-reporting. You can also use Production Maintenance, SFC500, to specify an operation as being non-reporting by updating the operation data for the order that you specify.

WT and WF transactions update the adjustment field in the Item Warehouse record. If an RJ (Production Reject) transaction is posted prior to a WT transaction, the adjustments field will be out of balance.

When you post transactions for periods that you closed through Inventory Month-End Close, INV900, the system updates the appropriate year-to-date totals. In this case, the posting does not affect the current month totals.

If the transaction updates detail historical records, then it also updates the previous month totals accordingly. Detail historical records are stored in the Inventory Warehouse Master (IWM), Company Master (RCM), and Salesman Master files (SSM).

ACCESS: Specify Post for a production record on Production Reporting, JIT600D1-01. The system displays the Production Register Listing screen, JIT610D1-01. Press Enter.

Post production reports

Use the Production Register Update screen, JIT620D1-01, to submit the job to update the system master files with the data from the production report work files.

Field descriptions - JIT620D-01

Fields	Description
Run Production Update (1,0):	To run the Production Update, enter 1=YES in this field. Press F3 or enter 0=NO to exit without running the update.

Screen actions - JIT620D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Production history purge

Use this program to clear some or all of the values from the fields that appear on the Production Inquiry (JIT300) screens. You can run this program as often as necessary.

Purge production history

Use this screen to select the information you want to purge. After you enter your selections, submit the job to purge the information. See the list below for possible field entries and the information that the system clears.

- If you specify yes in the Day End Run field, the system clears all inquiry fields except the Month-to-date and Year-to-date fields.
- If you specify yes in the Month End Run field, the system clears the Month-to-date fields.
- If you specify yes in the Year End Run field, the system clears the Year-to-date fields.

Field descriptions - JIT900D-01

Fields	Description
Is this a Day End Run? (1,A):	Specify yes to indicate the information that you want to clear for Production Inquiry, JIT300. The system specifies no by default.
Is this a Month End Run? (1,A):	Specify yes to indicate the information that you want to clear for Production Inquiry, JIT300. The system specifies no by default.

Is this a Year End Run? (1,A): Specify yes to indicate the information that you want to clear for Production Inquiry, JIT300. The system specifies no by default.

Clear Avg/Hr and Max/ Hr? Specify yes to clear the average per hour and the maximum per hour fields, otherwise specify no. The system specifies no by default.

Facility to Process (3,A): Specify the facility for the production history purge.

Screen actions - JIT900D-01

Commands	Description
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

JIT run rate audit and delete

Use JIT Run Rate Audit And Delete, to create a report that lists run rate information or to create a report and delete run rate information you no longer need. For example, you set run rates for the month of August and in September you want to delete them and create new ones. You created the records by using the JIT Work Bench application.

Access: SYS01 menu

Print a run rate audit report

Specify the parameters for the report and press Enter. The system checks your entries for valid items and work centers. After the system validates your entries, use F6 to run the report.

This screen contains range fields that you use to limit the data the system selects. For information on range fields, see the *Ranges* topic in the overview section of this document.

Field descriptions - JIT910D-01

Fields	Description
From Work Center (6,0):	Specify a range of values to limit the work centers to include in the report or to include in the report and delete.
To Work Center (6,0):	Specify a range of values to limit the work centers to include in the report or to include in the report and delete.
From Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report or to include in the report and delete..
To Item Number (35,A):	Specify a range of values to limit the item numbers to include in the report or to include in the report and delete.
From Date (6,0):	Specify a range of dates to limit the information to include in the report or to include in the report and delete.
To Date (6,0):	Specify a range of dates to limit the information to include in the report or to include in the report and delete.
Process Type (1,0):	Specify one of the following values: **Valid choices** ■ **0** Print an audit report. The system does not delete the information. ■ **1** Print an audit report and the system deletes the information.
Batch or Interactive Prompt (1,0):	Specify interactive to process the data in real time or batch to process the data in the job queue. If you specify interactive processing, your session is unavailable for other tasks until the job finishes.

Screen actions - JIT910D-01

Commands	Description
F6=Accept	The system submits the report request and processes it.
Standard screen actions	All screen actions on this screen perform standard Infor LX functions. See *Generic help text for screen actions (p. 16)* in the overview information in this document.

Appendix A
Glossary

A

Ranges

Ranges refer to fields you can use to limit an inquiry or report or to display specific data. If there are multiple range fields in a program, you can tailor your inquiry or report to produce only the data you need.

Infor LX sorts the information alphanumerically. Therefore, the value in the From field must be a lower alphanumeric value than the value in the To field.

Infor LX usually inserts extreme values as defaults in the lower and upper fields. See the description for Extreme values by default. The entries you make in range fields do not have to be valid values in a database file.

Review the following suggestions to limit the information:

Specify the first value to include on the inquiry or report in the From field. Leave the To field blank to include all information to the end of the file. For example, you can print a report that starts with the customer number you specify in the From field and stops at the end of the Customer Master file.

Specify the last value to include on the inquiry or report in the To field. Leave the From field blank to start at the beginning of the file. For example, you can perform an inquiry that starts with the beginning of the Customer Master file and ends with the customer number you specify in the *To* field.

Specify the same value in both the *From* and *To* fields. For example, you can limit a display to one customer.

To include a group of items, specify a value in the *From* field and another value in the *To* field. For example, you can perform an inquiry that starts with the first of the month and ends with the last day of the month.

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