Infor System21 Style Material Planning

Product Guide

Contents

About this guide

The purpose of this document is to describe the functions that can be used within the Material Planning Module.

Intended audience

The guide is intended for any users of the P3 Material Planning business module.

Related documents

You can find the documents in the product documentation section of the Infor Xtreme Support portal, as described in the "Contacting Infor" section.

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Chapter 1   Overview

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Planning Process Introduction

Within Style Material Planning, there are two modules: Master Production Scheduling (MPS) and Material Requirements Planning (MRP). These share a great deal of common logic. You can use either of the processes, or both; however, MPS demand normally drives MRP.

The MPS or MRP runs build a future production requirement using data entered in Style Production and other applications, such as Style Sales Order Processing, Style Forecasting and Style Purchase Management.

Note: Before you can run MPS or MRP, you must define planning models and reporting profiles and enter current sales, purchase and forecast data.

The output from the runs is a series of suggestions which:

- Suggest new production and purchase orders to meet required demand
- Re-plan any existing orders, by suggesting changes to order quantities and due dates

Although both MPS and MRP use the same processing rules, MPS gives a high level review of demand for sales, and items, critical to production. MRP extends that plan to include the demand for all materials. You can also use MPS for capacity planning.

Planning Models

To use MPS and MRP, you define planning models, which include:

- Stockrooms
- The planning process considers only materials in, or finished styles received into, stockrooms in the planning model.
- Calendar
- This is the production calendar for scheduling work and defining forecasting week numbers.
- Reporting profile
- This is the reporting period used on reports, enquiries and MPS/MRP reviews.

Use planning models to view the results of different plans. You can perform planning runs on different areas of your data and analyse the results of different runs.

Note: If you run MRP using the Include Suggested MPS parameter, you must define identical MPS and MRP models.

The Live Model

You can define three types of model: centralised, multi-plant and plant. You can also specify whether the plants are live. You must define at least one planning model as the live model in the company profile. From the live model, you can change or confirm resulting plans and schedules.

In a non multi-plant environment, you normally have one live planning model that you use to manage your ongoing production. To try other plans without changing the day-to-day operation, you can set up other planning models.

Types of Demand

Within MRP and MPS, there are three types of demand:

- Independent
- Dependent
- Actual

Independent Demand

Independent demand is demand entered for the item, such as sales orders or forecasts. Independent demand does not involve any other item and you cannot calculate or derive it. It must originate from an external source.

Dependent Demand

Dependent demand is demand on an item resulting from a plan to produce another. For example, if you produce an item, you must issue materials. The demand for the materials is dependent demand.

You can have any number of dependent demands associated with a single supply, or production order. If you cancel the production order, all of the dependent demands disappear.

For example, if you manufacture shoes, including all components, you have a sales or forecast demand for your shoes. Since you also manufacture the soles of your shoes, they have their own route and BOM.

You must balance an independent demand for shoes by a supply, or production, order. This creates a dependent demand for soles, balanced by a supply, or production, order and a dependent demand for laces, balanced by a supply, or purchase, order. There is also a dependent demand for rubber balanced by a supply, or purchase, order.

However:

- You can also sell laces independently, so they are also subject to independent demand, as sales orders or forecasts.

- You can place purchase orders for rubber well in advance. Therefore independent demand, as stock orders, also controls the orders by stock forecasts.

Actual Demand

Actual demand is the sum of independent and dependent demand on an item.

Common Processes

Note: The MPS and MRP runs generate data specific to a *planning model*; the *planning model* defines the *stockrooms* to consider.

The MPS/MRP runs comprise two distinctive stages:

- Pre-processing
- Processing

After completing these stages, you review the output produced and make scheduling and procurement decisions based on the recommendations.

Pre-processing

Pre-processing accumulates the reference data for the processing stage and consists of a number of steps:

1 Low level code analysis

2 Item selection and stock consolidation

3 Extraction of sales orders

4 Extraction of production orders

5 Extraction of demand from MPS (MRP only)

6 Extraction of purchase orders

7 Extraction of sales and stock forecasts

Processing

Processing provides the analysis and produces the recommendations, and consists of a number of phases:

1 Consumption of forecast

2 Calculation of daily demand

3 Adjustment of supply to meet net demand

4 Summarisation of variant details to style level

5 Explosion of recommendations

6 Generation of daily machine and labour loading requirement

Run Parameters

When you submit the MPS and MRP run, you enter parameters to determine the scope of the run. These user-defined dates and periods are shown in the following example:
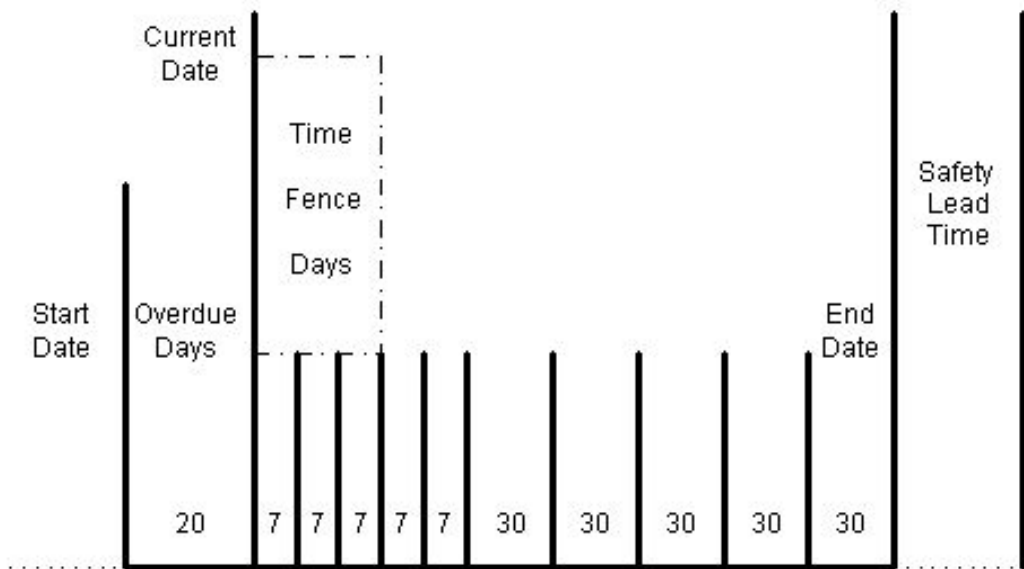
User Defined Reporting Type 'Buckets'

Current Date

This is the live date for the plan. The start date and frozen period, or time fence days are calculated from this date.

Overdue Days

This is the number of days of overdue supply and demand you want to consider.

Start Date

Note: This is not displayed for MRP.

This is the first date considered for the run. Any orders before this date are ignored. This is the current date minus overdue days.

Time Fence Days

The period between the current date and the time fence date is fixed. This is a frozen period, or schedule, in which the MRP or MPS run does not make any recommendations. You can either enter the time fence days, or use the production lead time for each style.

If you want to use the production lead time, **check** the Use Item Time Fence field. You define the production lead time in the Item Master file. If you do not enter a time, or it cannot be calculated, the run uses the global, default time fence days.

Safety Horizon Days

This extends the end date to include all generated demand in the lower level analysis.

End Date

This is the last date considered in the run. You can either enter the date directly, in which case the date is added to the safety lead time, or leave the software to calculate this date as the cumulative lead time for each style added to the safety lead time.

If you want to calculate the end date, **check** the Use Item End Date field. You enter the cumulative lead time in the Item Master file. If you do not enter a time, or it cannot be calculated, the run uses the global, default end date.

Note: When calculating the time fence days and end date for non-production items, the software uses the purchasing lead time.

Pre-processing

Both MPS and MRP explode high level demand into lower level supplies and demands. Demand is an anticipated event that reduces the stockroom inventory of an item, for example issues to satisfy customer sales or production orders.

Supply is an anticipated event that increases the stockroom inventory of an item, for example, receipt from a production order or a purchase order.

Note: Sales forecasts also represent demands.

Style Material Planning processes all the demands and supplies for all your styles and identifies where you need to change your plans. To do this, the software calculates the expected stock level of every style throughout a specified period. The software compares the existing stock level with the required stock of the style and displays suggested actions whenever you cannot meet requirements.

The software first considers the demand on your finished products, so that it can determine whether your current plans will provide enough stock. If not, the software recommends suggested supplies, usually by production orders.

All existing production orders and new suggestions create demands on component items. Therefore when the software has reviewed all finished products, it then reviews the components.

This process continues until all items have been reviewed.

Step 1: Low Level Code Analysis

This step checks the database to make sure that there are no conditions present that will cause the planning run to fail. It validates the data and then assigns the low level codes.

Note: To check all routes and BOMs, run the Generate Low Level Codes task before running MPS and MRP.

Note: If you check the Suppress Low Level Code Generation field on the MRP Run Details Selection window, this phase is skipped.

Note: For MPS, the Lowest Level to Review field on the MPS Run Options window determines how many levels, within routes and BOMs, the software searches for occurrences of items.

Note: If you have multi-level routes and BOMs, make sure you set the level to include the lowest level at which an item occurs.

Low Level Code Integrity Checking

The run examines all planning routes, and changed production order routes, for a parent and child relationship inconsistent with other defined relationships. For example:
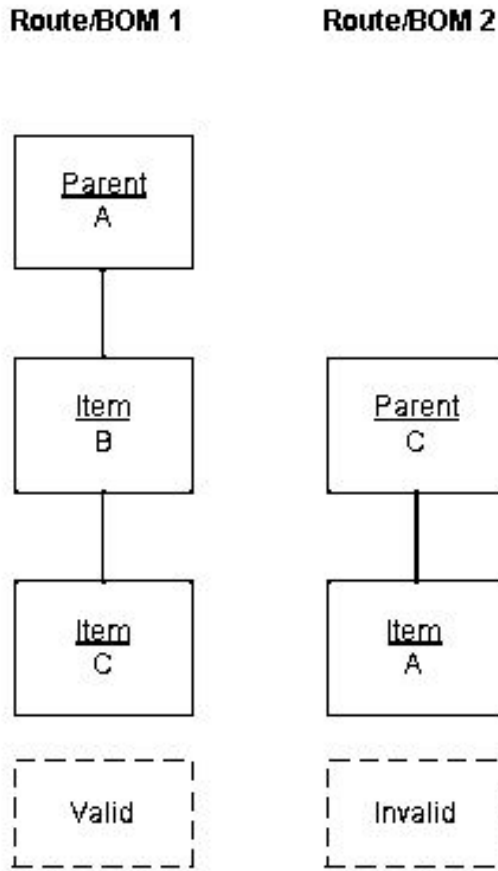
Route/BOM 2 is invalid, as A is a parent of C in route/BOM 1. An item cannot be both the child and the parent.

Caution: Invalid routes generate an exception report, which shows all invalid parent and child relationships. The MPS or MRP run terminates. You must correct your route or BOMs before re-submitting the job.

Assignment of Low Level Codes

The low level code of an item shows the lowest level at which the item appears in any route or BOM. This is held in the Item Master file. The planning routines review the items in a sequence based on the low level code. This makes sure that all higher level, dependent demand is generated before an item is reviewed.

When you maintain the route or BOM, you can change the lowest position of an item. Therefore, the planning routines start by reviewing the low level codes. Any changes are updated in the Item Master file.

Note: You can review the lowest level code using the Enquire on Item Master.

Items with no parents in the route and BOMs have a low level code of zero (0). Items with one level of parent are level 1, and so on.
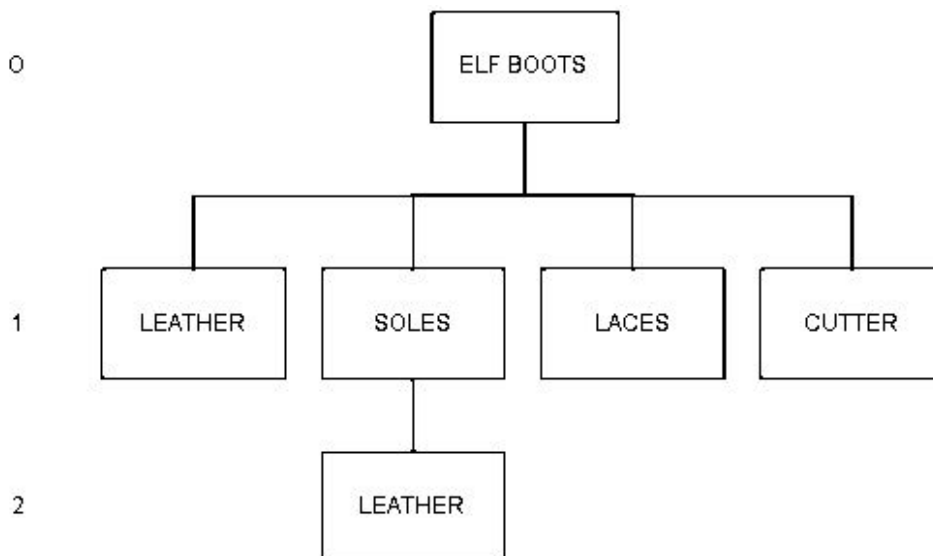
For example, Leather is at levels 1 and 2, so the low level code is 2.

Note: It is unusual for route and BOMs within Style Production to create levels lower than 2.

Step 2: Item Selection and Stock Consolidation

This step reviews all items in the Item Master file and extracts the items to include in the run and any items you want to review.

Note: You use the Planning Type field in the Item Master file to define an item as MPS or MRP. You normally define manufactured items as MPS items, and purchased items as MRP items.

<u>**Item Selection**</u>

The MPS review selects items that meet the following criteria:

- MPS items with a low level code less than or equal to the specified low level code cut-off, and which have a stockroom balance in at least one of the stockrooms defined in the planning model
- MRP items with a low level code less than the selected cut-off level, which have MPS items as components with low level codes less than or equal to the cut-off level

This traps all possible dependent demand for MPS items.

The MRP review selects items which meet the following criteria:

- MRP items residing in stockrooms defined in the planning model
- Items, not in the planning model, with dependent items that meet the above criteria
- If you are running an MRP selective run, MRP items which meet user selection criteria
- MRP items dependent on selectively reviewed items

Stock Consolidation

The opening stock balance for the MPS or MRP review is the total physical stock for each valid stockroom. Frozen stock is included if the Parameter file type PSTK/FRZN parameter is switched on.

The software uses the lead time defined on the first supplier in the item/supplier profile for the primary stockroom. If this does not exist, the software uses the lead time defined for the stockroom.

If you use Requisitioning, the software uses the supplier on the item/supplier profile for the stockroom. If none exists, the software uses the first supplier it can find for the item. Otherwise, it uses the first supplier defined to the stockroom. If there are no suppliers defined to the stockroom, the software leaves the supplier blank.

Step 3: Extract Sales Orders

This step selects the outstanding sales order balances for the items selected in Step 2. It summarises every order line for each extracted item, colour and size. The routine extracts the item, size and colour record according to the following criteria:

- The order status is blank.
- There is an outstanding ship quantity.
- The shipment date is within the start and end date of the run.

You define the stockroom, warehouse or depot on the planning model.

Step 4: Extract Production Orders

Within MRP and MPS, this step selects:

- Supplies associated with the MRP or MPS items selected in Step 2
- Dependent demands on items, selected in Step 2, emanating from supplies of MPS or MRP items

The software checks each order to see if:

- The due date is within the start and end date of the run
- The receiving stockroom is in the planning model
- If the stockroom is not in the model, the order is exploded down to its material demand. (For MPS this is dependent on the low level code specified for the run.)

The routine also checks whether the materials are a selected item (Step 2), the issuing stockroom is in the planning model, and that there is a required date within the start and end dates of the run. This identifies all generated demand.

Step 5: Extract Demand from MPS (MRP only)

This step is only present in MRP and extracts dependent demand generated in MPS applicable to relevant MRP items.

It reviews every suggested order for an MPS item and determines if it has a dependent demand for an MRP item selected in Step 2. If so, the software checks the demand record to establish the issuing stockroom. If the stockroom is used in the planning model, it extracts the demand for review.

If you **checked** the Include Suggested MPS (Production Orders) field, the software also reviews the MPS planning model and extracts the suggested MPS production orders. The MRP run uses the

planning route of the MPS parent item to identify the MRP item material requirement. It uses the MPS suggested due date and quantity as the basis of the requirement calculation.

The software also checks whether you can use the MRP materials at the time of the requirement (see Phase 4 of processing).

Step 6: Extract Purchase Orders

The software first extracts scheduled and blanket orders and then extracts outstanding orders.

Extract Scheduled and Blanket Orders

Scheduled and blanket orders are extracted if the deliver-to stockroom is defined in the planning model. The uncommitted quantity outstanding on the schedule is planned for receipt at the end of the run. This is so that you can re-schedule the uncommitted portion to meet earlier shortages.

Extract Outstanding Orders

This extracts outstanding orders and goods received not booked into stockrooms. Outstanding orders with a receipt date within the run date range are also extracted. The receipt date is the latest of the due date, expected date and promised date.

The software only extracts purchase orders for common materials, material group items, finished goods and subcontracted items. It also extracts goods inwards and inspection status purchase orders even though you cannot re-schedule these orders.

The outstanding quantity on extracted orders is taken from Style Purchase Management or Style Inventory Management.

Step 7: Extract Sales and Stock Forecasts

This step extracts the sales and stock forecasts for items within the planning model.

Note: Forecast data is only extracted if you have generated item forecasts or transferred forecasts from Style Forecasting.

The processing depends on the levels of forecast you generated:

- For variant level forecasts only, this step automatically generates a style level forecast.
- For style level forecasts only, these forecasts are style level only. The processing routines do not include them in the netting phase. In addition, the Phase 3 processing stage generates a style level only supply order (production or purchase).
- If style and colour, and style, colour and size, but not style level forecasts exist, a style level forecast is generated from the style, colour and size forecast.

Style level only forecasts are identified by a demand status code, with a Y prefix, for example, YF STYLE forecast.

The forecast extraction and generation process is summarised as follows:

Style	Style/Colour	Style/Colour/Size	Extract	Generate Style From
No	No	Yes	S/C/S	S/C/S
No	Yes	No	Nothing	S/C

Yes	No	No	Style	
No	Yes	Yes	S/C/S	S/C/S
Yes	No	Yes	S and S/C/S	
Yes	Yes	No	Style	
Yes	Yes\	Yes	S and S/C/S	

Where:

S/C/S is [Style](), [Colour]() and Size

S/C is [Style]() and [Colour]()

S is [Style]()

Processing

Phase 1: Consumption of Forecast

You use the [MPS]()/[MRP]() Consume Forecast field in the [company profile]() to determine whether the forecast comparison is a discrete comparison or a cumulative consumption.

The comparison is also governed by the [demand policy]() setting in the Item Master file, which can modify the consumption process for an item or range of items.

Note: If you do not want to forecast an item, the [demand]() is from sales orders only and the cumulative consumption of forecast is forced. If you want to include forecasting, you must have generated the forecasts before running [MRP]() or [MPS]().

Discrete Comparison

This method compares the forecast with the actual [demand]() for a forecast period. The greater of the forecast and the [demand]() becomes the [demand]() figure for the item. The discrete method is only used where a [sales forecast]() exists as an element of [demand](); if a forecast is not present, the cumulative method will be forced.

Cumulative Consumption

This method compares the cumulative forecast [demand]() and the cumulative actual [demand]() to the end of the forecast period.

The [demand]() is calculated as follows:

- Operation 1 calculates the cumulative forecast.
- Operation 2 is the cumulative actual demand.
- Operation 3 sets the cumulative demand to the greater of the cumulative forecast or cumulative actual demand.
- Operation 4 calculates the consumed cumulative as the sum of the consumed cumulative demand excluding the current period.
- Operation 5 calculates the current period demand.

Demand Policy

The consumption of forecast calculation depends on the demand policy set in the Item Master file, which defines the actual demand calculation for each period. Demand can comprise one or more of sales demand, forecast demand and dependent demand.

Demand Policies

Code	Description	Demand Definition
0 or blank	Total actual demand	Sum of sales orders plus dependent demand; no forecast
1	Forecasts compared with independent demand	Greater of (forecast or sales orders) plus dependent demand
2	Forecasts compared with total demand	Greater of (sales orders plus dependent demand) or forecasts
3	Independent demand compared with dependent demand	Greater of sales orders or dependent demand; no forecast
5	Make to forecast	Equal to forecast only; no sales orders or dependent demand
6	Total demand	Total demand; that is sum of forecasts plus sales orders plus dependent demand

Demand Policies and Consumption of Forecast

For Discrete Comparison, the total demand is calculated, for each demand policy, as follows:

- Policy 0: Sales Order + Dependent Demand
- Policy 1 without Dependent Demand: the greater of Forecast or Sales Orders
- Policy 1 with Dependent Demand: (the greater of Forecast or Sales Orders) + Dependent Demand
- Policy 2: the greater of (Sales Order + Dependent Demand) or Forecast
- Policy 3: the Greater of Sales Orders or Dependent Demand
- Policy 5: Forecast
- Policy 6: Sales Orders + Dependent Demand + Forecast

For Cumulative Consumption, the total demand is calculated, for each demand policy, as follows:

- Policy 0: (Cumulative Sales + Cumulative Dependent Demand) - Previous Period's Consumption
- Policy 1 without Dependent Demand: (the greater of Cumulative Sales or Cumulative Forecast) - Previous Period's Consumption
- Policy 1 with Dependent Demand: (the greater of Cumulative Sales or Cumulative Forecast) - Previous Period's Consumption + Dependent Demand
- Policy 2: The greater of ((Cumulative Sales + Cumulative Dependent Demand) or Cumulative Forecast) - Previous Period's Consumption

- Policy 3: (the greater of Cumulative Sales or Cumulative Dependent Demand) - Previous Period's Consumption
- Policy 5: Cumulative Forecast - Previous Period's Consumption
- Policy 6: Cumulative Sales + Cumulative Dependent Demand + Cumulative Forecast - Previous Period's Consumption

Phase 2: Calculate Daily Net Demand

The run calculates, on a daily basis, the gross and net demand, and the available stock for each selected item.

Gross Demand = (netted sales forecasts, sales orders and dependent production order demand) + safety stock (target inventory level) + stock forecast

Available Stock = (physical stock (for the first period in the run) or projected available stock (for future periods in run)) + outstanding production or purchase order quantities

Net Demand = Gross Demand - Available Stock

Note: The physical stock includes Frozen stock if the Parameter file type PSTK/FRZN parameter is switched on.

Phase 3: Adjust Supply to Meet Net Demand

After calculating the net demand, the run makes recommended changes to supply orders to correct any imbalance. The time fence, planning filter and order policy codes influence these recommendations.

Net Demand < 0

If net demand is negative, you have an over supply condition. The run recommends you reduce the supply quantity, or cancel an order if the demand is non-existent.

Net Demand > 0

If net demand is positive, you have a supply shortage. The run attempts to cover the shortage by re-scheduling any cancelled orders, then re-scheduling live orders. It also recommends a quantity change. Finally, it generates suggested supply orders to meet the deficit.

New order quantities depend on the order policy code set in the Item Master file.

Net Demand = 0

If net demand is zero, the supply and demand are in balance and the current plan does not need modification.

Time Fence Days

The run makes no recommendations to change orders, in either timing or quantity, within the time fence days; it does not re-schedule orders into the frozen period; or suggest new orders due inside this period.

Planning Filters

You can use planning filters to control the re-scheduling of any MPS or MRP recommendations. You define planning filters in the Parameters file (type WTYP). You can specify default values for an item in the Item Master file or for a specific production order.

Planning filters also control the MPS or MRP re-scheduling of production order dates or quantities or both.

Date Reschedule Policy

You can expedite (bring due date in, schedule earlier) or delay (defer, take due date out) production orders. You can restrict date re-scheduling recommendations as follows:

- No re-schedule allowed
- Any re-schedule allowed
- Re-schedule allowed if not less than a specified number of days
- Re-schedule allowed if not less than a specified percentage of the lead time
- Re-schedule allowed if the resulting order value is greater than the extended value, where order value = (suggested quantity x Inventory standard cost)

Quantity Reschedule Policy

You can increase, decrease or cancel production order quantities. You can restrict quantity re-scheduling recommendations as follows:

- No re-schedule allowed
- Any re-schedule allowed
- Re-schedule allowed if not less than minimum order quantity
- Re-schedule allowed if not less than the entered percentage of an item's safety stock

You can change the global operation of the software by changing the rules for standard order types, or use the planning filter to vary the operation according to specific situations.

You can allow or restrict recommendations to cancel an order. You can also use these modifications with purchase orders although different rules may govern the scheduling of normal, schedule, blanket and user defined purchase orders.

The planning filter, assigned to an item or individual order, conditions the run response. If you define the re-schedule policy for the order type and the assigned filter, the filter rules are used. If you are not using a filter, the rules applying to the order type are used. If neither order type nor filter has a policy defined, the order is not subject to recommendation. For additional information on planning filters, see the Style Production Definition Management product guide.

Order Policy Codes

The Item Master file production details include an order policy code and associated parameters for the suggested orders.

Code	Description	Recommended Quantity	Example	
A	Discrete	Required quantity	Actual demand	100
			Recommended quantity	100

B	Discrete above minimum	Greater of Required quantity or Minimum Order Quantity	Minimum order quantity	200
			Actual demand	100
			Recommended quantity	200
D	Fixed quantity	Enough batches of the Fixed Order Quantity to satisfy the required quantity	Fixed quantity	80
			Actual demand	100
			Recommended quantity	160
G	Number of days supply	Enough to satisfy all requirements for the specified number of days from the initial shortage date	Number of days supply	3
			Monday	20
			Tuesday	20
			Wednesday	30
			Recommended quantity	70
H	Multiples above minimum	Greater of enough batches of the Multiple Order Quantity and the Minimum Order Quantity	Minimum order quantity	200
			Multiple order quantity	500 50
			Actual demand	101
			Recommended quantity	200
			Actual demand	501
			Recommended quantity	550
I	Multiples up to a maximum	Maximum is the physical maximum possible in a factory	Max order quantity	500

	Multiple order quantity	50
	Actual demand	101
	Recommended quantity	200
	Actual demand	501
	Recommended quantity	500 50

Phase 4: Summarise Variant Details to Style Level

The software processes the first three phases at style, colour and size level, whereas Phase 4 updates at style level. The information summary depends on whether you are processing new suggested orders or changing existing orders (production or purchase).

Suggested Order

The software accumulates quantities from all colour and size records for the same style and date and creates a style record for the total.

Change to Existing Order

The software can suggest different changes for each colour and size on a single order. For example, on some colours, you need bring in the due date and on others, you need to take out the due date or change the quantity.

The software changes the original order to match the date to which most colours and sizes are linked. It then creates suggested orders for the other dates, changing the original order status to Suggested for all colours and sizes.

Phase 5: Explode Recommendations

This phase generates dependent demand records for the supply changes identified in Phase 3.

Suggested and Planned Orders

First, the software back-schedules each suggested and planned order to determine the planned start date of each operation. Then it examines the materials issued at that operation to determine whether they are effective on the specific date. If so, it creates a dependent demand record.

Using the suggested due date as a basis, the software explodes the route/BOM through its operations. It calculates the lead time of each operation, using the standard times, and applies the recommended order supply quantity to inflate or deflate the times. The actual route used depends on the settings on the Additional Parameters MPS Run pop-up:

- If you **check** the Include Capacity field, the software uses the capacity route entered in the Capacity Route field.
- If you **check** the Include Capacity field and the Use Planning Route field, the item's planning route is used.
- If you leave the Include Capacity field **unchecked**, the item's planning route is used.

To get an operation start date, the software also applies any wastage defined to the cycle times. The lead time calculation includes any parallel processing operations, defined by the bundle ticket type. The software checks the dates against the calendar for the machine, to make sure the operation start date is a working day.

The routine also creates operation load records (for suggested production orders only); that is, start and end dates, machine, labour profile, machine and labour time (run and setting). Phase 6 uses these records.

Back scheduling Example

Move Time	Specified in route/BOM maintenance.
Queue Time	Specified by machine, in machine maintenance.
Duration Time	Calculated from the times specified in the route.
Order Due Date	30/10/06
(A) Order Quantity	10
(B) Standard Lot Size	1
(C) Standard Machine Time	3 hours
(D) Operational Wastage	10%
(E) Machine Duration Time	((C x A)/B) x ((100/(100-D)) ((3x10)/1) x (100/(100-10)) 33.33 hours
(F) Standard Shift Length	7 hours
Duration Days	E/F 33.33/7 4.76 days 5 days (rounded up)
Start Date	25/10/06

Material Effectivity Check

After establishing the planned start date, the run extracts all the materials required at the operation and checks their effectivity.

The run generates a requirement if the material's effectivity start date is less than, or equal, to the calculated operation start date, and its effectivity stop date is greater than the operation start date. It then checks the effective materials for an issuing stockroom in the planning model. The quantity of material required is calculated as:

Recommended order quantity x cumulative operation wastage x quantity per standard lot size x material wastage

Material Requirement Calculation

Order quantity	100
Cumulative wastage at operation	15%
Lot size on planning route	10
Quantity per standard lot size	10
Material wastage	5%
Cumulative operation wastage	100/(100-B)=100/(100-15)=1.1764
Material wastage	100/(100-E)=100/(100-5)=1.0526
Requirement	A x F/C x D x G = 123.8

Note: If you check the Fixed Quantity Per field for a material on a route/BOM, the requirement is always the Quantity Per Lot size; wastage is not calculated

Firm, Released and Active Production Orders

These orders are exploded down to the material requirements defined on production orders.

To establish the operation start and material requirement dates, the starting point for the back-scheduling routine is the current order due date, or the run suggested due date. The software also calculates the outstanding operation lead time and the material requirements at operations.

Calculate Outstanding Operation Lead Time

The outstanding time at an operation is based on the amount of work completed. Rather than using a fixed lead time, the operation lead times are examined when back-scheduling.

The operation start dates are calculated using the order quantity. If the run recommends a change of order quantity, the existing operation lead times are re-calculated.

Calculate Material Requirements at Operations

The re-calculated operation start dates are the revised demand dates for all materials scheduled at an operation. The software uses these demand dates when analysing the demands for the materials. The run includes any changes at the parent level in the generated demand at the material requirement level. To produce an integrated material plan, this effect is cascaded down the levels of the process structure.

Requirement quantities are re-calculated based on suggested order quantity changes at the production order level.

If the run suggests cancelling a production order, it does not explode the route, and the material demand is dropped from the plan. If you have already issued materials, you should return these to the issuing stockrooms.

Purchased Items

Recommendations for purchased items (item types **B** (Bought out), **P** (Purchased) or **T** (Consumable tool)) are not exploded through routes, and the review does not include these items.

The software calculates the lead times for purchased items as follows:

- For existing orders, the software uses the receipt due date, except for unscheduled schedule or blanket orders where the due date is the end date of the run.
- If no purchase orders exist for an item, the software uses the Style Purchase Management item/supplier profile. If this is not available, it uses the lead time for the item and stockroom.

Phase 6: Generate Daily Machine or Labour Loading

This phase spreads the operation load for suggested orders, generated in Phase 5, into daily machine and labour loadings.

Note: The run only includes this phase if you check the Include Capacity flag on the Additional Parameters Run pop-up.

Daily Machine Loadings

This is the operation loading for machines split into individual days.

Daily Labour Loadings

Using the operation loads, the run generates separate records for each labour skill, within the labour profile defined at the operation.

Demand, Supply and Action Codes

MPS and MRP reviews, and reports, display, or print, the following status codes:

- Demand status codes
- Supply status codes
- Action codes

You define these codes in the Parameters file.

Note: Codes including the term Excluded refer to demand or supply excluded from the review.

Note: Codes which include the term STYLE relate to demand which is at style level only; that is, there is no defined requirement at style, colour and size level.

Demand Status Codes

You define demand status codes in the Parameters file, under type PDSC.

Demand Status Codes

CA	Cancelled
CD	Cumulative demand, if cumulative consumption of forecast
CW	Confirmed production order
FC	Sales forecast
FS	Stock forecast
FX	Forecast (excluded)
IW	Active production order
MA	[MPS] Manual adjustment
MX	[MPS] Manual adjustment (excluded)
PW	Planned production order
PX	Suggested purchase order (excluded)
RW	Released production order
SO	Sales order
SP	Suggested purchase order
SW	Suggested production order
SX	Sales order (excluded)
WX	Production order (excluded)
YF	STYLE sales forecast
YP	STYLE suggested purchase order
YS	STYLE stock forecast
YW	STYLE suggested production order

Supply Status Codes

You define supply status codes in the Parameters file, under type PSSC.

Supply Status Codes

CN	Cancelled
CO	Complete production order
CP	Confirmed purchase
CW	Confirmed production order
GI	Goods inwards

IS	In inspection
IW	Active production order
PW	Planned production order
RW	Released production order
SP	Suggested purchase order
SW	Suggested production order
YW	STYLE suggested production order
YP	STYLE suggested purchase order

Action Codes

MPS and MRP runs provide planning support. The advice given is based on the latest status of material requirements and the current order status.

The action codes are the recommendations that the runs can make. The software can combine these codes; some examples are shown later in this section.

You define action codes in the Parameters file, under type PEXC.

Note: *If the recommendation compromises material effectivity, that is, the material is not effective on the route/BOM on that date, warning codes are also displayed.*

You can use the review facilities, for both MPS and MRP, to view orders in original and suggested due date sequence.

Note: *The four letter codes shown in the table, for example ROCQ, can be displayed separated by date, with a suggested change quantity.*

Note: *Example: RO11/09 CQ 2.*

Action Codes

CA	Cancel order
CQ	Change quantity (mix)
EF	Check effectivity
EI	Re-schedule in and check effectivity
EICQ	Re-schedule in and change quantity and check effectivity
EO	Re-schedule out and check effectivity
EOCQ	Re-schedule out and change quantity and check effectivity
EQCQ	Change quantity and check effectivity
RI	Re-schedule in

RICQ	Re-schedule in and change quantity
RO	Re-schedule out
ROCQ	Re-schedule out and change quantity

Action Recommendation Examples

Order	Qty	St	Action
W000156	122	CW	RI 15/08 CQ 1180
			Re-schedule order due date in to 15 August, and change quantity from 122 to 1180
W0007716	30	IW	RO11/09 CQ 25
			Re-schedule order due date out; defer until 11 September, and change quantity from 30 to 25

MPS Specific Processes

You can use the MPS specific processes for:

- Capacity planning
- MPS items selection, planning type 1
- Amendments to suggested production orders; such as changes in quantities, routes, due dates and planning filters
- Definition of a cut-off low level code as a parameter; below which the run will not look for any occurrence of MPS items
- Saving different versions of the Master Production Schedule against revision level codes
- Reviewing demand part way through the run; so you can make changes to incorporate when the run begins

Capacity Planning

This is a unique function within Master Production Scheduling. You use this to compare available machine and labour capacity against projected workloads.

You can use either standard planning route/BOMs or specially derived capacity routes. You can then use the Capacity Review facility to change the workload schedule at production order level.

MPS uses capacity planning to:

- Take account of machine capacities when assessing the demand proposed by MPS plans
- Determine a loading factor for each machine
- Determine labour loading

MPS can use summary routings to determine loading on Style Production resources.

Capacity planning:

- Uses planning route information to convert demand, in quantities, into the number of hours required at each machine
- Uses planned supply dates to schedule required hours into weekly production time slots at each machine. It takes account of machine standard capacities, planned down times and non working days.
- Creates reports and enquiries that you can use to compare the required and available machine and work centre hours within the planning run timescales
- From these reports and enquiries, you can search for overload and underload at machines and for labour skills. Then, choose any action required.

Although you can finite capacity plan by individual order, the software assumes infinite capacity of the facility. Therefore the planner must fine-tune the workload to optimise the loading factor and utilisation of production capacity.

MRP Specific Processes

You can use the MRP specific processes for:

- MRP items selection, planning type 0
- Running selective MRP, based on a range of items
- Directly entering the MPS suggestions into the material plan

You can choose from the following processing modes:

- Regenerative - To plan for all materials
- Selective - To plan for a range of materials in the planning model
- Net Change - To consider only materials with a change of demand or supply since the last MRP run

Chapter 2   Maintenance

2

Material Requirements Planning Overview

Material Requirements Planning has three functions:

- Run MRP
- Review MRP
- Confirm suggested orders

Run MRP

There are three types of MRP run:

- Regenerative MRP Run

This examines all current supplies and demands against items designated as MRP items. This can take a long time, so we recommend that you run this once a month over a weekend.

- Net Change MRP Run

This only checks those materials that have changes to their demand or supply since the last MRP run. This run is shorter than a full MRP run. If you run the Net Change MRP run frequently, for example, daily, you can immediately revise the plan for any materials affected by a change in demand or supply. We suggest that you run the Net Change MRP run weekly.

- Selective MRP Run

Use this type of run to run MRP for selected items.

Each type of run generates suggestions for actions you must take to satisfy the plan.

Caution: If you run a number of Net Change MRP runs in succession, they will become slower than a Regenerative MRP run.

Review MRP

Use the Review MRP task to examine the results from the MRP run to check whether you have the orders needed to meet the plan. You can then cancel, add or change any of the orders, as the plan suggests.

Confirm Suggested Orders

You can confirm suggested orders either individually, using the review processes, or altogether using the stand alone routine.

Maintain Model Stockrooms [1/P3M]

Use this task to create and maintain MRP planning models.

You can use the same model for MRP as for MPS, or you can have a separate MRP model with different stockrooms and planning periods.

In both cases, you must define the model in both MPS and MRP.

This task is the same as the Maintain Model Stockrooms in MPS. For more information, refer to the Maintain Model Stockrooms section in the Production Scheduling Maintenance chapter of the Style Production Planning product guide.

Maintain Reporting Profile [2/P3M]

Use this task to specify how the planning functions summarise the supply and demand information for enquiries and reports.

This task is the same as the Maintain Reporting Profile task in MPS. For more information, refer to the Maintain Reporting Profile section in the Production Scheduling Maintenance chapter of the Style Production Planning product guide.

Note: You must run this task for MPS first and then for MRP.

Net Change Reason Codes [3/P3M]

Use this task to activate or de-activate triggers upon events for a Net Change MRP run. You do this by maintaining reason codes, which control the triggers for certain events.

You must create the reason codes using this task before you first run a Net Change MRP.

Caution: The first time you use this task, you must select **Update (F8)** to create the reason codes, even if you do not make any changes. Until you do so, the Net Change MRP run ignores all the triggers.

A Net Change MRP run is restricted to certain specified events which have taken place since the last Net Change MRP run. Within the manufacturing system, whenever an event for which you have selected a reason code takes place, a trigger is created.

For example, if you select the reason code for Production Order Triggers and create an unplanned production order, the software activates a trigger for the next Net Change MRP run.

When you request a Net Change MRP run, you can view the number of triggers set against each of your selected reason codes.

Note: The events listed below activate triggers for MRP-controlled items only.

Sales Order Triggers

Because MRP is restricted to planning of materials only, a trigger is only generated in exceptional cases, such as for sales orders where the ordered item is also an MRP component. In these cases, any of the following generate a trigger:

- Creating a sales order
- Changing the date of the sales order
- Changing the order quantity
- Adding order lines
- Deleting order lines

Unplanned Inventory Transactions Triggers

If you make sundry issues and receipts, they force a change in the demand for materials and can generate triggers.

Purchase Order Triggers

If you order an MRP item outside of planned changes, or change the expected supply of materials, any of the following events can generate a trigger:

- Creating an unplanned purchase order
- Changing the purchase order date
- Changing the order quantity

Production Order Triggers

If you create an unplanned production order for an MRP item, any of the following events can generate a trigger for the ordered style. If you order an MPS item, any of the following events can generate a trigger for the MRP components only:

- Creating an unplanned production order
- Changing the production order date
- Changing the order quantity

Completing a production order can also generate a trigger for any MRP materials, if you issued less than the required quantity, or if you do not use all of the material.

Unplanned Issues and Receipts Triggers

You may want to capture any materials issues above or below the planned quantity. This helps you identify and plan for any extra material required, or any surplus material you can then issue against another order.

You can capture the following unplanned issues and receipt changes:

- If you issue more materials than required
- Overriding the backflush quantities
- Completing a production order short, that is, where the quantity produced is less than the quantity ordered
- Completing or re-opening a production order when the quantity is over the planned quantity

Net Change Reason Codes Maintenance Window

To display this window, select the Net Change Reason Codes task.

Use this window to maintain the net change reason codes for the MRP run. This window displays the code number and description for each available reason code.

Note: The spare lines on this window are for the future development of new reason codes.

Fields

Description

Enter a new description for the reason code. You can use a maximum of 36 characters.

Note: You cannot add a new description to the blank lines

Active

This field determines whether changes to supply and demand create triggers for the events identified by the reason code.

Use these checkboxes as follows:

Unchecked - Not to create triggers for supply and demand changes for this group of events

Checked - To create triggers for supply and demand changes for this group of events

Note: If you check this field against a reason code, you can change this setting to unchecked for an individual Net Change MRP run. An individual Net Change MRP run ignores any triggers set up for the reason code. For more information, see the Net Change Trigger Selection Pop-up section in the Material Planning Processing chapter of this product guide.

Select **Update (F8)** to save your changes.

Chapter 3   Processing

<div style="text-align:right;">3</div>

Run Material Planning [11/P3M]

Use this task to:

- Take all demand on top-level MRP items
- Compare the demand with the available supply and generate suggested demand where appropriate
- Display the supplies down to SKU level demand
- Compare the demands with supplies for lower level items

The software generates an MRP Reporting Profile report, which details the run dates and the reporting periods for the planning model.

At the end of the run, you can review and action MRP's suggestions.

Prerequisites

For each style you want MRP to consider, you must have defined:

- A planning route for the style using the Styles task
- A list of materials on the planning route using the Route/Bill of Material task

In addition, make sure you define your calendars to cover the duration of the review.

Caution: You should define all manufactured items as MPS items and all purchased items as MRP items. The software does not prevent you from breaking this rule. If you do, the Review Capacity task does not include the production load for wrongly coded items and recommendations for actions on wrongly coded purchased items are generated during the MPS run, not the MRP run.

MRP Model Selection Window

To display this window, select the Run Material Planning task.

Use this window to enter the planning model for which you want to run MRP.

Note: If you have not defined a planning route or materials for a style, the MRP run does not include any supply or existing production orders for the style.

Fields

Planning Model

Enter the planning model to run

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

If you want to confirm any planning suggestions, this must be the planning model defined in the company profile.

The stockrooms you define on the selected model determine the scope of the material plan. The reporting profile defines how the information is presented on reports and enquiries. The software only plans for items with defined item and stockroom relationships within the selected model.

Press Enter to display the MRP Run Details Selection window.

MRP Run Details Selection Window

To display this window, press Enter on the MRP Model Selection window.

Use this window to select the type of MRP run you require and to enter a start date and end date. By default, this window displays the current date and end date from the last MRP run and the selected planning model and associated production calendar.

Fields

MRP Run Type

Select one of the following:

Regenerative (1) - To run MRP for all items within the planning model

Note: *As this can take a long time to run, we suggest you schedule a regenerative run over the weekend.*

Net Change (2) - To run MRP for those items with changes to their demand or supply since the last MRP run

Select **Review Selection (F16)** to display the Net Change Trigger Selection pop-up, from which you can de-select trigger reason codes.

Selective (3) - To run MRP only for those items in the planning model that are within the selection parameters defined

Select **Review Selection (F16)** to display the Enter Selection Criteria pop-up, from which you can define your selection.

Include Suggested MPS

This field is only available for a regenerative run.

Use this checkbox as follows:

Unchecked - To exclude MPS suggested orders

Checked - To include MPS suggested orders

The setting of this field is retained after the MRP run. The value is retrieved each time the task is selected. This stored value will then automatically become the default for that run unless changed by the user.

Current Date

This field is the live date for the plan. The start date and frozen period (Time Fence Days) are calculated from this date. The run ignores any orders before this date. The start date is the current date less overdue days.

Overdue Days

This is the number of days of overdue supply and demand you want to consider. The accumulated supply and demand for this period are displayed in the Overdue column on the MRP Enquiry Summary window.

Time Fence Days

The period between the current date and the time fence date is fixed or frozen; that is, the run makes no recommendations for this period.

If you want to include a time fence, enter the number of days.

Use Item Time Fence

Use this checkbox as follows:

Unchecked - To use the value entered in the Time Fence Days field

Checked - To use the production lead time for each style set up via the Styles task

The production lead time is the time taken to produce an item from its immediate components. If the style does not have a production lead time, the MRP run uses the global default Time Fence Days setting.

Safety Horizon Days

Enter the number of days' safety horizon. This extends the end date to make sure all the generated demand is included in the lower level analysis.

End Date

Enter the last date for the run. To include a safety lead time, enter a value in the Safety Horizon Days field.

To use a cumulative lead time for each style plus a safety lead time, **check** the Use Item End Date field.

Use Item End Date

Use this checkbox as follows:

Unchecked - To use the global default end date

Checked - To use the cumulative lead time set up in the Styles task

The cumulative lead time is the total lead time needed to produce an item, based on a full explosion of its planning route. It includes any low level production items on the route, and the purchasing lead time of materials and bought out components. If the cumulative lead time is not set up for a style, the MRP run uses the global default end date.

Note: For non-production items, the purchasing lead time is used for production and cumulative lead times.

Suppress Low Level Code Generation

Use this checkbox as follows:

Unchecked - If you want to generate the low level codes

This is the default if you have made changes to the planning routes.

Checked - If you do not want to generate the low level codes

This is the default if you have not made changes to the planning routes.

If you run the Generate Low Level Codes task before running MRP, you can suppress the low level code generation here.

Caution: Only suppress the generation of the codes if you are sure that the planning process will not be compromised by the lack of up-to-date data on planning routes.

Functions

Review Selection (F16)

If you selected **Net Change** in the MRP Run Type field, use this to review the net change triggers using the Net Change Trigger Selection pop-up.

If you selected **Selective** in the MRP Run Type field, use this to enter the items required on the Enter Selection Criteria pop-up.

Print Details (F22)

Use this to print the run parameters without starting an MRP run.

Select **Start Run (F8)** to submit the batch job to start the MRP run The software automatically produces a report detailing the parameters set for the run.

Net Change Trigger Selection Pop-up

To display this pop-up, select Net Change in the MRP Run Type field and then select **Review Selection (F16)** on the MRP Run Details Selection window.

Use this window, for a net change MRP run only, to view the number of unprocessed triggers set by each net change reason code and the total number of styles triggered. You can also select the trigger types you want the net change MRP run to process.

This window displays a list of the trigger reason codes and descriptions. If you have set the trigger for a reason code to inactive, it cannot be processed and is not displayed on this window. For more

information, see the Net Change Reason Codes Maintenance Window section in the Material Planning Maintenance section of this product guide.

Fields

Select (Sel)

Choose **Select** against a reason code to include all triggers covered by the reason code in the net change MRP run.

Trigger Reason

This field displays the trigger reason code.

Description

This field displays the text description for the trigger reason code.

Unprocessed Triggers

This field displays the number of unprocessed triggers.

Functions

Select All (F18)

Use this to select all the available reason codes and therefore all the unprocessed triggers.

Press Enter to validate the changes and display the MRP Run Details Selection window.

Enter Selection Criteria Pop-up

To display this pop-up, select Selective in the MRP Run Type field and then select **Review Selection (F16)** on the MRP Run Details Selection window.

*Note: You can also access this window by selecting **Additional Parameters (F14)** on the MRP Schedule Report and MRP Planner Action Report windows.*

Use this window to define the items to include in the MRP run or reports.

You can define all the selection parameters, except the Value/Usage Class, which are in the Styles task. You define value and usage classes, by stockroom, in Style Inventory Management.

Note: If you intend to process all MRP items, carry out a regenerative MRP run instead by selecting Regenerative in the MRP Run Type field on the MRP Run Details Selection window.

Fields

Style/To

Enter a range of styles. Leave these fields blank to include all styles.

You can use the prompt facility on these fields to select from the Select Item pop-up.

Planner/To

Enter a range of planners. Leave these fields blank to include all planners.

You can use the prompt facility on these fields to select from the PLAN Planner Code pop-up.

Style Group/To

Enter a range of minor product groups. Leave these fields blank to include all minor product groups.

You can use the prompt facility on these fields to select from the PGMN Product Group - Minor pop-up.

Note: You use minor product groups to group styles into product families for sales and stock forecasting.

Value/Usage Class/To

Enter a range of value and usage classes. Leave these fields blank to include all values and usage classes.

Preferred Supplier/To

Enter a range of preferred suppliers. Leave these fields blank to include all suppliers.

Fabric Type/To

Enter a range of fabric types. Leave these fields blank to include all fabric types.

Press Enter to save the information and return to the previous window.

Confirm Suggested Orders [12/P3M]

Use this task to confirm selected or all suggested orders. Once you have confirmed the orders, all future MRP runs include these orders.

If you have coded your items as recommended, that is, manufactured items as MPS and purchased items as MRP, you should not need to use this task from within MRP.

Note: If you set the Allocation of Materials At field to Confirm (allocate at order confirmation) in the company profile, the software automatically allocates material for the production orders when you confirm them.

MRP Confirmation of Suggested Orders Window

To display this window, select the Confirm Suggested Orders task.

Use this window to select a range of dates and planners whose orders you want to confirm.

Fields

From Start Date/To Start Date

Enter or select the range of start dates you want to include. Leave these fields blank to include all dates.

Note: If you enter a date, it must be within the date range of the last MRP run.

From Planner/To Planner

Enter the range of planners for which you want to include orders. Leave these fields blank to include all planners.

You can use the prompt facility on these fields to select from the PLAN Planner Code pop-up.

Work Order Planning Level

Enter a work order planning level. Alternatively, use the prompt facility to select from the WORL Production Works Order Level pop-up.

This field can be set to **0**, **1** or **2** to display orders suggested at style, colour or full product respectively.

All Levels

Alternatively, this field can be set to **Yes**, which displays ALL suggestions, each at the production level view set for its item. The order creation and flagging window then shows additionally the colours or SKU details respectively for suggestions generated for items with production order levels **1** or **2**.

Press Enter to display the Confirm Orders window.

Confirm Orders Window

To display this window, press Enter on the MRP Confirmation of Suggested Orders window.

Use this window to select the orders you want to confirm and to submit a batch job to mark all selected orders as confirmed orders.

This window displays all suggested production orders that meet the selection parameters entered on the MRP Confirmation of Suggested Orders window.

Fields

Model (in Heading)

This field displays the model code.

Start Date Range/To

This field displays the start date range.

MRP Start

This field displays the MRP start date.

MRP End

This field displays the MRP end date.

Select (Sel)

Select one of the following:

0 or Blank - If you do not want to confirm this order

1 (default) - To confirm an order

Start

This field displays the start date.

Quantity

This field displays the quantity.

Item

The field displays the item.

Description

This field displays the item text description.

Select Update and **Submit Job (F8)** to submit the batch job to confirm all the selected orders.

Review MRP [13/P3M]

Use this task to review the results of an MRP run. For a live planning model, you can create and maintain actual supply.

MRP Enquiry Model Selection Window

To display this window, select the Review MRP task.

Use this window to select the model for which you want to review the MRP details.

Fields

Planning Model

Enter the planning model you want to review.

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

Press Enter to display the MRP Enquiry Selection window.

MRP Enquiry Selection Window

To display this window, press Enter on the MRP Enquiry Model Selection window.

Use this window to enter a material, a planner and a date range.

Note: You do not need to complete any of the fields on this window.

Fields

Select Item

You can optionally enter a material.

Note: If there is no detail available for the selected material, the MRP Enquiry Summary window is displayed.

Planner

You can optionally enter a planner, as set up under Production Details within the Styles task.

Alternatively, use the prompt facility to select from the PLAN Planner Code pop-up.

Date Last Planned From/To

Enter a range of dates to display materials that were last planned within a specific date range. The default is the run date of the last MRP process.

Note: If you enter a style or material in the Select Item field, leave these fields blank.

Press Enter to display the MRP Enquiry Detail window.

MRP Enquiry Detail Window

To display this window, press Enter on the MRP Enquiry Selection window.

This window displays a summary of all supply and demand details for a material, including recommendations and time-projected inventory balances. This window displays, for each demand or supply, the quantity, status, order number, and action.

Note: For more details on the status codes, see the Demand, Supply and Action Codes section in the Module Overview chapter of this product guide.

The MPS Item field shows whether or not the item is MPS: 0 for an MRP item or 1 for an MPS item.

If a production order suggestion exceeds the maximum order quantity defined for a material, the production order is highlighted.

The demand does not include stock forecasts, but there may be a supply order which is scheduled to provision the stock level defined in the forecast. This stock is additional to safety stock, so the quantity available reflects the stock forecast demand. Use stock forecasts as an additional hedging technique, to amend the desired stock level by week.

The date displayed is:

- For dependent demand, the required date and reflects a higher level MPS demand

- For independent demand, the forecast due date, or sales order shipment date
- For a supply, either the MPS recommended due date or the current date of the order
- For supplies with no recommended date change, the sequence remains the same.

Note: If the date is 99/99, this is a zero demand, with an existing supply.

For MRP recommended due date sequence, the Available figure is the planned available stock, and shows the MRP supply recommendations. Since MRP aims to protect the defined safety stock level, the balance normally shows the safety stock.

For the current date sequence, the current supply schedule is shown as quantities and due dates and the Available figure is the resultant availability against demand. It is calculated for each day that a demand or supply line is present and represents the style phased projected inventory level.

Note: The software always generates dependent demand from higher-level recommendations and represents the MPS suggested schedule. This does not change when you change the supply sequence.

Fields

Planning Model

This field displays the selected planning model.

Start

This field displays the start date.

Time Fence

This field displays the time fence.

End

This field displays the end date.

Item

This field displays the selected item code along with its description.

MPS Item

This field displays **0** for an MRP item and **1** for an MPS item.

MRP Date

This field displays the MRP date.

Demand Order

This field displays the order number.

Demand Quantity

This field displays the quantity.

Demand Status

This field displays the demand status.

Supply Order

This field displays the order number.

Supply Quantity

This field displays the quantity.

Supply Status

This field displays the supply status.

Supply Action

This field displays the action.

Available

This field displays the quantity available.

Options

Note: If no options are available against a line, it is an accumulated demand or supply on the first item.

Maintain Supply

Use this to maintain the supply.

This is only available for the live planning model.

You can:

- Amend the details of an existing production order, using the standard Production Order Maintenance window
- Change the status of a suggested order to Planned or Confirmed.
- You can confirm multiple orders using the Confirm Suggested Orders task.
- Change a suggested purchase order
- You must enter the new due date and quantity.

Peg Demand

Use this to display the review details for a parent that generated a particular demand against a material requirement.

The demand item must be a material requirement on a production style and have a low level code of **1** or greater. Use **Previous (F12)** to return to the originating item in a chain of pegging requests.

Note: You can only use this option for material items.

Supply Breakdown

Use this to display the variant breakdown of the material in the Suggested W/O pop-up.

You cannot make any changes. If a material has no variants, this option is not available.

Demand Breakdown

Use this to display a drill down of demand.

Functions

Refresh (F5)

Use this to update the display.

Higher (F6)

This is available from Colour and Full Product views, and changes the view and control to Style and Colour level respectively.

Lower (F7)

This is available from Style and Colour views, and changes the view and control to Colour and Full product respectively.

Combine (F9)

This summarises like demand for the same day, into one record on the window. The individual demand reference is lost and is replaced with text indicating that the demand has been combined.

Prv Item (F16)

Use this to cause the display to move backward at the current viewing level until a change of style is encountered, when viewing resumes at the entry level.

Summary (F17)

Use this to display the MRP Enquiry Summary window.

Header (F18)

Use this to display the Header Details pop-up. This is only available for Style and Full Product levels.

Nxt Item (F19)

Use this to cause the display to move forward at the current viewing level until a change of style is encountered, when viewing resumes at the entry level.

Planner (F20)

Use this to display the next planner in the sequence.

Chg Seq. (F21)

Use this to toggle the display between details in MPS recommended due date sequence and current due date sequence.

Detail (F22)

Use this to display more demand information for each supply and demand line.

The information displayed is:

- Additional Demand Information - Displays the style creating a particular generated demand for a material
- Additional Supply Information - Displays the current due date of the order and the earliest and latest start date
- For purchased orders, it shows the receipt date, which can be the due date, promised date or expected date, whichever is the greatest.

Select **Exit (F3)** to leave the task.

Suggested W/O Pop-up

To display this pop-up, select Supply Breakdown against a supply order on the MRP Enquiry Detail window.

This pop-up displays the breakdown of quantities for each variant of the style.

Note: You cannot change any of the information on this pop-up.

Select **Previous (F12)** to return to the MRP Enquiry Detail window.

MRP Enquiry Summary Window

To display this window, select **Summary (F17)** on the MRP Enquiry Detail window.

This window displays a summary of the item supply and demand schedule, using the reporting periods defined for the planning model. The opening and safety stock are displayed. The window also shows inventory and production details defined for the item.

This displays the quantity overdue, at specific dates, and the total quantity of:

- Actual demand
- Forecast
- Adjusted demand
- Supply
- Available
- Net requirement
- Planned receipt and available

Note: If you cannot see all the period details, use Page Up and Page Down to display the next and previous period details.

Fields

Planning Model

This field displays the selected planning model.

Start

This field displays the start date.

Time Fence

This field displays the time fence date.

End

This field displays the end date.

Item

This field displays the selected item code and text description.

MPS Item

This field displays **0** for an MRP item and **1** for an MPS item.

Planner

This field displays the selected planner.

Product Group

This field displays the selected product group.

UOM

This field displays the unit of measure.

GT Family

This field displays the GT family.

Last Planned

This field displays the last planned date.

Order Policy

This field displays the order policy.

Type

This field displays the order type.

Production Seq

This field displays the production sequence.

Lead Time

This field displays the lead time.

Opening Stock

This field displays the opening stock balance.

Safety Stock

This field displays the safety stock balance.

Avg. Wkly Usg

This field displays the average weekly usage.

Supplier

This field displays the supplier.

Fixed Qty

This field displays the fixed quantity.

Min. Batch

This field displays the minimum batch quantity.

Max. Batch

This field displays the maximum batch quantity.

Multiples

This field displays the multiples quantity.

Actual Dem

This field displays the actual demand quantities overdue and for specific dates.

Forecast

This field displays the forecast quantity overdue and for specific dates.

Adj. Demand

This field displays the adjusted demand quantities overdue and for specific dates.

Supply

This field displays the supply demand quantities overdue and for specific dates.

Available

This field displays the available quantities overdue and for specific dates.

Net Reqmt

This field displays the net requirement quantities overdue and for specific dates.

Plan Recpt

This field displays the planned receipt quantities overdue and for specific dates.

Plan Avail

This field displays the planned available quantities overdue and for specific dates.

Functions

Prv Item (F16)

Use this to display the previous material in the sequence.

Detail (F17)

Use this to display the MRP Enquiry Detail window.

Header (F18)

Use this to display the Header Details pop-up. This is only available for Style and Full Product levels.

Nxt Item (F19)

Use this to display the next material in the sequence.

Next Planner (F20)

Use this to display the next planner in the sequence.

Select **Exit (F3)** to leave the task.

Header Details Pop-up

To display this pop-up, select **Header (F18)** on the MRP Enquiry Detail window or the MRP Enquiry Summary window.

This pop-up displays inventory and production details for the parent style selected.

These details include:

- The order and lead time policies
- The fixed, minimum and maximum quantities
- Physical and safety stock levels

Fields

Planner

This field displays the planner.

UOM

This field displays the unit of measure.

Order Policy

This field displays the order policy.

Item Type

This field displays the item type.

Supplier

This field displays the supplier.

Fabric Type

This field displays the fabric type.

Item Group

This field displays the item group.

Physical Stock

This field displays the physical stock.

Safety Stock

This field displays the safety stock.

Lead Time

This field displays the lead time.

Value/Usage Class

This field displays the value/usage class.

Delivery Days Basis

This field displays the delivery days basis.

Date Last Planned

This field displays the last planned date.

Fixed Qty

This field displays the fixed quantity.

Minimum Qty

This field displays the minimum quantity.

Maximum Qty

This field displays the maximum quantity.

Multiples

This field displays the multiples quantity.

Delivery Lead Time

This field displays the delivery lead time.

Select **Previous (F12)** to return to the previous window.

Chapter 4   Reports

4

Material Scheduling Report [21/P3M]

This report produces a full listing of the material requirements plan so that you can review and evaluate it.

MRP Schedule Report Window

To display this window, select the Material Scheduling Report task.

Use this window to select the planning model and planning date range you want to include in the report.

Fields

Model

Enter the planning model

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

Date Last Planned/To

Enter or select the date range for the plan

Only items planned during the date range are included on the report.

Print Items with No Details

You can decide whether to include items for which there is no supply or demand.

Use this checkbox as follows:

Unchecked - If you only want to include items with a supply or demand

Checked - If you want to include items with no supply or demand

Planning Level

Select one of the following:

Style Level (1) - To report at style level

Default Planning Level (3) - To report at default planning level

Functions

Additional Selection (F14)

Use this to display the Enter Selection Criteria pop-up.

Press Enter to generate a Material Plan report.

Enter Selection Criteria Pop-up

To display this pop-up, select **Additional Selection (F14)** on the MRP Schedule Report window.

Use this pop-up to enter selection criteria for the report.

Fields

Style/To

Enter a range of styles to restrict the report.

You can use the prompt facility on these fields to select from the Select Item pop-up.

Planner/To

Enter a range of planners to restrict the report.

You can use the prompt facility on these fields to select from the PLAN Planner Code pop-up.

Style Group/To

Enter a range of style groups to restrict the report.

You can use the prompt facility on these fields to select from the PGMN Product Group - Minor pop-up.

Value/Usage Class/To

Enter a range of values and usage classes to restrict the report.

Preferred Supplier/To

Enter a range of suppliers to restrict the report.

Fabric Type/To

Enter a range of fabric types to restrict the report.

Report Sequence

You can sequence your report by entering up to three sequence fields. Enter **1** against the primary report sequence, then **2** and **3** against the minor sequences.

For example, to produce a report showing items in value and usage class sequence within planner responsibility, enter **1** alongside Planner and **2** alongside Value/Usage Class.

Press Enter to save the information and return to the MRP Schedule Report window. Press Enter to generate the report.

Recommendation Report [22/P3M]

This report produces a summarised action list of recommended changes to supply in the planning model.

You can use this report to highlight overdue supplies, that is, production orders with a due date earlier than the current date.

MRP Planner Action Report Window

To display this window, select the Recommendation Report task.

Use this window to enter the parameters for the Recommendation report.

Fields

Model

Enter the planning model

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

Planner Action Review/To

This is established by review period. Enter or select the earliest and latest start dates to include in the report.

Include Overdue Orders

You can include details of orders with a due date earlier than the current date.

Use this checkbox as follows:

Unchecked - Not to include overdue orders

Checked - To include orders with a due date before the current date

Detail Level

Select one of the following:

Style / Material Group (1) - To report at style and material group level

Full Product (2) - To report at full product detail level

Print Prior Values

Use this checkbox as follows:

Unchecked - To not print prior values

Checked - To print prior values

Functions

Additional Selection (F14)

Use this to display the Enter Selection Criteria pop-up, which you use to select the range of styles to include in the report.

Press Enter to submit the batch job to generate the Recommendations report.

Valuation Report [23/P3M]

Use this task to produce a MRP Valuation report.

The report assesses the inventory and purchase order commitment of a proposed production schedule in standard or current cost terms. The selected schedule is translated from a quantitative plan by extending quantities by the unit cost of items.

You can select which elements of cost to include in the unit cost and you can include cost elements which are excluded from the normal cost by default. In addition, you can increase any cost element by a specified percentage (uplift).

MRP Valuation Report Window

To display this window, select the Valuation Report task.

Use this window to select the parameters for the Valuation report.

Fields

Model

Enter the planning model

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

Basis

This is the basis used to round the cost values.

Select one of the following:

One Thousands (3) - To round to the nearest thousand

Ten Thousands (4) - To round to the nearest ten thousand

Hundred Thousands (5) - To round to the nearest hundred thousand

Millions (6) - To round to the nearest million

Detail Level

Select one of the following:

Summary (1) - To print calculated total model information only

Detail (2) - To include detail item values in the report

Costing Method

Select one of the following:

Standard Cost (1) - To cost using the standard costs from the specified cost set

Cost Set (2) - To cost using non-standard costs from the specified cost set

Cost Set

If you selected **Cost Set** in the Costing Method field, enter the cost set to use for the calculations.

Select MRP Item Types

Select one of the following:

Manufactured (1) - To include only production items (item type **M**)

Purchased (2) - To include only purchased items (item types **P** (purchased materials), **B** (bought out components) and **C** (consumable tools))

Both (3) - To include all items

Select **Submit Job (F8)** to generate the report.

Reporting Profile [24/P3M]

Use this report to print the profile details for a selected model.

Print MRP Reporting Profile Window

To display this window, select the Reporting Profile Report task.

Use this window to select the model for which you want to produce the report.

Fields

Model

Enter the model for which you want to produce the report.

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

Press Enter to submit the job and display the Print MRP Reporting Profile Confirmation window.

Print MRP Reporting Profile Confirmation Window

To display this window, enter a model and press Enter on the Print MRP Reporting Profile window.

This window displays the report confirmation.

Select **Exit (F3)** to leave the task.

Log History Report [25/P3M]

This report prints MRP run information, which you can use to decide whether to carry out a Net Change MRP run or a full MRP run. If you need to process a large number of styles, it could be more efficient to perform a full regeneration. This report includes the actual times of MRP runs and their modes.

The report lists the following MRP run information:

- Start date and time
- End date and time
- Run time and type
- Styles triggered
- MRP and MPS styles processed
- Total styles processed

MRP Log History Selection Window

To display this window, select the Log History Report task.

Use this window to select the model and date on which you want to report.

Fields

Planning Model

Enter the planning model

Alternatively, use the prompt facility to select from the Select Base Model pop-up.

From Date

Enter or select the date from which you want to start the report.

Press Enter to validate your entries and generate the MRP Log History report.

Appendix A Glossary

<div style="text-align: right">A</div>

Active Production Order

A production order which has associated work-in-progress

Activity Types

These are user definitions of activities to be reported. Activity types can be system dependent or user-defined. System dependent activity types are mandatory for the system to function. You may define user-defined activity types to suit your requirements. Activity types are linked to a System21 reporting type that defines how the activity effects updates to the database.

Advanced Financial Integrator

This processes transactions generated by production bookings, using user-defined Journal rules, to create auditable General Ledger account postings for production activities.

Advice Note

A document received from a subcontractor giving details of goods delivered

AFI

An acronym for Advanced Financial Integrator

Allocated Stock

This is the quantity of a style or material that is allocated to customer orders or production orders. This quantity is expressed as a balance at both item/stockroom level and item/stockroom/lot level.

Allocations

This is inventory currently reserved against a production order. Allocations can change and an allocated material may become available again and then allocated to another production order. Style uses allocations to calculate how much material is currently available.

Alternative Material

This is a material nominated as an alternative for a material used in production, when stock of the original material is insufficient. You can issue alternative material in whole or part to a production order.

Amortised Fixed Costs

This is a method of spreading fixed production costs over a designated batch size to ascertain the effect on unit product costs of the economies of scale production. See also Fixed Costs.

Archived Production Orders

These are production orders which have been saved in an archive file and removed from the live order database. They are available for detailed enquiry.

Automatic Batch Allocation

This is the process of allocating batches/lots of materials against a production order. The allocation is done by grouping together a number of batches according to a common identification code.

Available

This is the quantity calculated by Planning to represent current availability on a given day equal to previous period available + supply – demand.

Available Stock

This is the quantity calculated by subtracting allocations from the physical stock balance. It represents uncommitted inventory which may be used to satisfy production demand.

Average Cost

This is a costing method employed by Style Inventory Management, whereby the weighted average unit cost of an item is recalculated every time a stock receipt is made.

Average Usage

This is the average usage per week/period of an item in a stockroom. The weeks or periods which are included in this calculation are defined by the usage profile.

Backflush

This is the automatic generation of standard material issues based on production quantities reported. This is usually done for low cost materials. For example, a shirt has 7 buttons. If you make 100 shirts, you require 700 buttons. Instead of counting out the buttons, you can make a backflush issue from a bucket of 1000. When the operation is complete, Style accounts for taking 700 buttons out of stock automatically.

Backflush Item

An item that is designated to be automatically issued in production recording

Backflushed Operation

A backflushed operation is a non-count point operation. The operation gets booked in automatically at the next count point operation.

Backschedule

The calculation of operation and order start dates from the due date, using the lead time elements of the operations

Balance

This may be used either to signify a database record holding summary information, such as a stockroom balance, or a single summary quantity field on such a record, such as allocated stock.

Batch Control

See Lot Control.

Bill of Material

The definition of the materials that are required to make a product

BOM

Acronym for Bill of Material

Booking

Work-in-progress reporting

Booking History

A record of all material and production transactions posted during the progress of a production order

Bottleneck

This term is generally used to refer to a position on a production line where the production flow is constrained in some way. This can lead to build-ups of work and potentially have an adverse effect on the efficiency of a line or plant, and ultimately on profitability.

Bucket

In MPS and MRP, the period of time for which supply and demand are summarised for presentation

Bucketless

This describes the MPS/MRP review process, which balances supply and demand on the date it is scheduled, rather than accumulating it into greater time periods.

Budget Capacity

This is the capacity of a machine that is compared with its load. It represents the capacity you expect to obtain from a machine. This can be 100% of stated capacity or a factor above or below 100% (see Standard Capacity).

Bundle Ticket

This is a document printed by Production Control that is attached to a bundle on the factory floor. It has barcoded stubs which can be wanded in directly by the operator or are attached to the operator's timesheet. It identifies the production order, style, colour, size and quantity to be processed.

Bundle Tracking

This is the method of identifying the stage that a bundle has reached in the production process. In addition, the processes that have been completed are also identified.

Bundling-Up Point

This is an operation at which the materials are bundled together, prior to the issuing of bundle tickets.

Cancelled Production Order

This is a production order which has been aborted, and cannot be reopened.

Capacity

This is the amount of time that a machine or work centre or labour skill or labour department is available for work in a given period.

Capacity Planning

This is the option of calculating machine and labour capacity requirements by comparison of duration for planned work with the capacity available for the planning period. The work schedule or the capacity may then be adjusted to obtain a balanced workflow.

Capacity Requirement

The time required at a machine (or for a labour skill) by a particular piece of work

Characteristic

Characteristics are related to the dimensions you define for a style or material. For example, if you define colour as a dimension, then red, black and blue might be characteristics of that dimension.

Characteristic Mix

These are the rules that determine the level of detail that exists for a bundle - single colour, unknown size, single size, unknown colour, single colour, single size.

Colour

Throughout Style Production, colour generally refers to the colour code you may have specified for a style under the Style/Material Details activity.

Company Profile

This is a collection of control parameters specific to a Production company.

Completed Production Order

These are production orders which have been completed. They cannot have bookings made against them. They may be reopened for further processing.

Component

Any item that is used in the production of another item

Confirmed Production Order

A production order with a firm commitment to produce an item, which cannot be changed in date or quantity except by explicit planner intervention

Cost

This is a value associated with an item in a stockroom, or a movement. It is usually a value related to a single item (a unit cost), but may refer to a quantity of items (a movement cost or value).

Cost Centre

This is a functional or organisational area defined for the purposes of defining production costs. Each cost centre defines standard rates for labour, machine, set up and overheads. A cost centre is assigned to a machine and is used to calculate all standard production costs associated with that machine.

Cost Elements

15 cost elements are available to analyse costs. These are: fabric, trim, packaging, labour, machine, set up, subcontract, variable overhead 1, variable overhead 2 (variable), overhead 2 (fixed), user-defined 1-4 and wastage.

Cost Roll-up

This is the method of generating product costs by calculating and accumulating costs of materials and operations required at each level of manufacture.

Costing Method

This refers to the method used to establish a cost for stock movements or stock balances. The methods available are latest, average, standard and FIFO (First In First Out).

Costing Route

The route designated for an item to calculate its unit cost within a stockroom

Count Point

This is an operation at which WIP inventory is counted or reported. A count point operation helps to identify how the production order is progressing.

Creation Date

The date on which a production order is entered

Cumulative Lead Time

This is the amount of time required to produce an item from scratch. It is based on a full explosion of the bills of material of the item and its sub-assemblies and includes the purchasing lead time of raw materials.

Current Cost

This is a category of cost. The application generates values for current and standard cost control. Current cost may be considered as the proposed standard cost for the next accounting period. See Standard Cost.

Current Date in Planning

This is the datum point of an MPS/MRP plan. The start date is determined by subtracting Overdue Days from this date. The Time Fence date is calculated from this date by adding the frozen Lead Time.

Demand

The forecast or actual requirement for an item

Demand Policy

This is the policy which controls the comparison of sales forecasts with sales orders, and dependent demand to arrive at the demand to drive MPS or MRP. This may be: no forecast, independent demand only, dependent and independent demand, dependent demand, make to forecast only or total demand.

Department

This is a collection of labour skills that have been grouped together for capacity requirement analysis purposes. Departments also define certain parameters to allow the calculation of capacity, namely: standard hours per day; absenteeism rate, utilisation %; standard performance %

Dependent Demand

Demand for an item which is derived from the manufacture of a parent

Descriptions File

This is a file maintained within the Style Inventory Management application which defines a number of parameter codes and their descriptions.

Dimension

A style always has at least one dimension, which is the style itself. A style may have additional dimensions, such as colour, size and fit. Each style can have up to 4 dimensions.

Materials such as fabric and trim may also have more than one dimension.

Direct Labour

Operatives used in production of an item in terms of performing work on operations

Down Time

This is the amount of time that a machine is out of action. The application provides the facility to record both planned and Actual Down Time.

Duration Calculation Basis

This is the method by which the duration of an operation is calculated for scheduling purposes. This may be: set up time only; machine time + set up time; direct labour time + set up time; machine time + direct labour time + set up time; greater of machine time *or* direct labour time + set up time.

This can be set at Company Profile, Machine or Route Operation level.

Dye-lot Control

See Lot Control.

Economic Order Quantity

This is an optimum quantity of a style to be produced by a style route or supplied on an order. It may be entered for each style route and may be used as the basis of apportioning fixed costs for an item.

Efficiency

The ratio of standard to actual performance

Efficiency Variance

The difference between standard and actual performance in quantity and cost terms

End Date (Planning)

This is the last date to be considered by the run. It can be entered or calculated as Current Date plus item cumulative lead time. It can be extended by setting a number of safety days.

EOQ

See Economic Order Quantity.

Exception Events

Transactions which are likely to cause a change in the supply and demand status of an item

Fabric Type

Production classification used in MRP as a selection parameter for a Selective MRP run

FIFO

This is an acronym for First In First Out - one of the costing methods available in the Style Inventory Management application. Using this method, each stock receipt is valued at actual cost, and issues are valued using these receipt batch costs on a First In First Out basis.

Finished Goods Receipt

This is the receipt of a quantity of a production item into an Inventory stockroom, as a result of a production order.

Firm Planned Production Order

This is a production order which remains under the control of the planner in terms of timing and quantity and is not recommended for change by Planning functions, unless Planning Filters are set to allow this.

Fixed Cost

This is an element of item cost that does not vary with the volume of production. Fixed elements of costs are; set up, fixed overhead, fixed user-defined costs.

Fixed Order Quantity

This is an ordering policy used by MPS and MRP to control suggested replenishment orders. It is used to generate suggested supplies of a pre-defined size.

Fixed Quantity Per

Any material to a bill of material whose requirement will not vary with batch size

Floor Stock

This is inventory which is issued to a designated floor stock location (logical or physical stockroom) on the shop floor rather than directly for immediate consumption. Floor stock is consumed as it is used at a particular operation.

Floor Stock Location

This is a logical or physical stockroom where items with a Material Control Policy of issue to floor stock are issued and consumed.

Forecast Level

This is the level at which forecasts can be maintained at; or the level to which a family forecast can be spread to. It is defined within the production Details of a style. The available levels are: style, style/colour, SKU or full product.

Frozen Stock

This is the quantity of an item which is designated as 'frozen' and thus not available for issue or allocation. It is expressed as a balance quantity at item/stockroom level, or item/lot level.

Generated Demand

See Dependent Demand.

Goods Inward

This is an area within a warehouse in which incoming materials are received, prior to being put away in their warehouse locations.

Goods Receipt Note

This is a document produced when receiving work back from a subcontractor which provides details of the goods received.

GRN

Acronym for Goods Receipt Note

Gross Requirement

The total demand for an item in a given time period before stock on-hand and supplies are netted

Held Inventory Tracking

This is a regimen imposed by the system to force entry of a reference code/description each time a WIP quantity is booked as 'held'. This reference may be for the whole booked quantity or specific to one or more items in the total quantity. Any further movements of Held WIP Inventory (for example, transfer or scrap) necessitate the specification of the held inventory reference.

Held WIP Inventory

This is WIP inventory which is not available to progress to the next operation until released from held status. This may be because it is awaiting quality control inspection or rework.

In Transit

This is the quantity of an item which is currently in transit between two stockrooms. It is expressed as a balance quantity at the target item stockroom.

Indented Bill of Material

This is a multi-level explosion of an end item (finished product or style) or sub-assembly, showing all the levels of materials, each of which is displayed indented one position from its immediate parent.

Indented Cost Roll-up

This is a method of simulating the cost of an end item (finished product or style) or sub-assembly with reference to its bill of material and manufacturing operations at all levels, and then rolling up the costs of all its materials and operations.

Indented Where-Used

This is the inverse of the indented bill of material. It shows the parent item of a material. Each parent item is indented one position from the level below. The analysis can be multi-level, and identifies the parents, grandparents, great grandparents, etc., of a material.

Independent Demand

This is demand for an item originating from sales orders or forecasts. That is, direct demand for the item itself.

Indirect Labour

This is work performed in a factory that is not directly linked to the production of items, for example, cleaning, sweeping or polishing.

Inventory Audit Record

When a revaluation of Inventory takes place during a transfer of standard costs from Production, a control record is created for each stockroom revaluation.

Item Group Minor

This is a Style Inventory Management classification used in Production Forecasting to define the product family to which an item belongs.

Item Stockroom

This is the highest level at which costs and inventory balances are held. The item/stockroom record also defines stock management rules for an item in a stockroom used within Style Inventory Management.

Item Type

Within Style Production, Item Type classifies items into made items (manufactured or produced), bought out items, consumable tools and purchased items.

Use Production Details under the Style/Material Details activity to set the Item Type for a style or material to one of the following:

M - Production Items (styles or intermediates used in the production of a style)

P - Purchased items (examples are materials such as lace, leather and silk)

B - Bought out items (examples are buttons, zips, hangers, suit covers and packaging materials such as boxes and labels)

T - Consumable tools (examples are knitting needles, blades and pins)

You can override Item Type for an individual route on Style/Route Override Maintenance window 2 under the Style Route/Bill of Materials activity.

Change Item Type descriptions through the PITP parameter under the Maintain Parameter File activity.

Key Material

This is a specific material on a route that is used to control the lot characteristics of the finished product. Only one material per route may be defined.

Key Operation

This is an operation on a route identified as a special progress point; used in various enquiries and reports to limit the number of operations shown. It can additionally be used to specify that non-stock purchase orders should be created for subcontract operations.

Labour

Work performed by operators

Labour Profile

A Labour Profile defines a group of labour skills that work together in a team. It is linked to an operation on a style route to enable the calculation of labour capacity requirements.

Labour Skills

An operator's skill that is required to perform an operation

Labour Time

The length of time required by an operation in terms of labour

Landed Costs

These are costs in the receiving of purchased items. These are user-defined costs such as freight, carriage or insurance.

Latest Cost

This is one of the Costing Methods available in the Style Inventory Management application. Using this method, each stock receipt is valued at actual cost and all issues are valued at this cost. In addition, total inventory is valued at this cost.

Lead Time

This is the amount of time required to produce or procure a style or material. For production items, lead time is derived from the sum of the lead times of the individual operations required to produce the item and any sub-assemblies. Lead time also relates to procurement times for purchased items. See also Production and Cumulative Lead Times.

Load

This is the capacity requirement on a machine or work centre or labour skill or labour department in terms of time arising from an operation scheduled at that machine or against a labour profile.

Logical Stockroom

This is a stockroom which does not physically exist but is used as a reference for the recording of WIP inventory, or floor stock. Recordings may be made to physical stockrooms if they exist; logical stockrooms are simply an alternative.

Lot Control

This is a level of stock control to ensure that fabric is issued out of a common batch, indicating that the fabric has been dyed in the same dye vessel. It is also referred to as batch control, dye-lot control, piece control, shade control, roll control and merge.

Lot Traceability

Where stock control is specified at batch or lot level, this refers to the ability to trace the movement of stock at this detailed level.

Low Level Code

This is the lowest point in bills of material or production orders at which an item exists. It indicates the maximum level at which the item resides. It is used by MRP to determine when to plan the item in the fully exploded product sequence.

Machine

A piece of equipment upon which or with which work is performed, and capacity requirements are measured

Machine Schedule

A daily work plan for a machine, containing item and order quantities and duration of set up and operating hours

Machine Time

The length of time consumed by an operation in terms of machine work

Marshalling Area

An area within a warehouse that stores materials temporarily when they have been picked from their warehouse locations but have not yet been sent out

Master Production Schedule

MPS calculates and balances demand and supply for master scheduled items, and generates a production schedule with suggested dates and quantities.

Material Control Policy

This parameter defines the method of item issues to production. This may be: formal issue, backflush or floor stock issue.

Material Requirements Planning

MRP calculates and balances demand and supply for purchased materials and lower level manufactured items and generates a suggested schedule for production and purchases, with suggested dates and quantities for actions.

Material Route

The route to be exploded in indented bill of material functions for identified materials to establish lower level materials

Material Type

This is a parameter used to determine an item's material type. This may be: fabric, trim, packaging, fabric group, trim group or packaging group.

Material Usage Policy

This is a parameter which determines how the material quantity is determined when an item is specified on a bill of material. This may be: quantity per based or ratio based.

Material Wastage

The planned or anticipated percentage of a quantity of material that will be unusable when it is issued to the production process

Material Where-Used

The identification of where a material is used in assemblies and sub-assemblies

Matrix Type

This is the display mode of the matrix for a style, this can be: a maximum of 15 sizes with quantities up to 999; a maximum of 10 sizes with quantities up to 99,999; a maximum of 6 sizes with quantities up to 99,999.999.

Maximum Capacity

The theoretical capacity of a machine in hours when working at its peak rate

Maximum Capacity Factor

This factor may be applied to a shift profile to allow calculation of the maximum number of hours available at a machine, if for example, the machine consists of several machines or multiple operators. For example, if the machine has a standard shift profile which defines 8 working hours per day, applying a factor of 3 would indicate that 3 x 8 (24) hours are available.

Maximum Order Quantity

This is a value set for an item to control the suggested supply batch sizes suggested by MPS and MRP. It is an advisory parameter, and does not restrict the size of the suggested batch, but a warning is shown on the plan reports when a batch size exceeds it.

Maximum Stock

This is the preferred maximum stock balance of an item in a stockroom. This may be set manually for each item.

Merge

See Lot Control.

Minimum Order Quantity

This is a control parameter set for an item to manage the suggested supply batch sizes recommended by MPS and MRP. It ensures that a supply is never less than the defined minimum order value.

Move Days

This is the length of time required to transport work or cool down or dry out after an operation has been performed and before the following operation can start. This is an element of inter-operation time.

Movement Type

This refers to the classification of movements by type of transaction, for example, sundry receipts, customer order issues.

MPS

Acronym for Master Production Scheduling

MPS Item

This is an item which is under the scheduling and planning control of Master Production Scheduling. It is typically an end product, critical sub-assembly, or key material.

MRP

Acronym for Material Requirements Planning

Multi-plant

Use multi-plant planning to share the load between different plants or factories.

Multiple Order Quantity

This is a control parameter set for an item to control the suggested supply batch sizes recommended by MPS and MRP. It defines the increments that are applied to a batch to meet a demand quantity. It sets a defined batch quantity and the ruling that a demand quantity must be supplied in whole batches of the set quantity. For example, demand equals 110, multiple order quantity equals 20, required equals 110/20=5.5, which would convert to 6 batches.

Net Change MRP Run

A net change MRP run considers only those materials that have had any changes to their demand or supply since the last MRP run. A net change MRP run is shorter than a full MRP run and therefore allows you to run MRP more frequently.

Net Change Reason Code

Identifies the transactions that can generate triggers for net change MRP runs

Net Demand

Net demand equals gross demand less available stock, adjusted by demand policy parameters.

Net Requirements

The difference between net demand due on a day and the total suggested supplies planned to be available on that day, adjusted by pre-set Order Policy parameters

Off Standard

This is production work that is performed by a piecework paid Operator who is not being paid 100% of the standard minutes for the operation. There are many reasons for work being off standard, such as training, unfamiliar work etc.

On Order

This is the quantity of an item for which outstanding purchase or production orders exist. It is expressed as a balance quantity at item/stockroom level.

On Standard

Production work that is performed by a piecework-paid Operator who will be paid 100% of the standard minutes for the operation

On-Hand Quantity

This is the quantity shown in Inventory as being physically in stock. For WIP inventory this is calculated as the sum of the Available + Subcontractor + Held balances.

Operation

A stage in the production route of an item

Operation Costs

These are the costs specific to individual production stages. In the Extended edition of the software, costs can be held at route and operation level as well as item level.

Operational Wastage

Percentage loss of work-in-progress as a result of performing an operation

Order Policy

Order policy is used by MPS and MRP when building a suggested schedule. Policies may be: discrete; discrete above minimum; fixed quantity; number of days supply or multiples above minimum.

Order Release

This is the point at which a production order is made available for processing on the shop floor. Materials may be allocated and issued at this point.

Order Status

This identifies the stage that a production order has reached. The status may be one of the following: suggested, planned, confirmed, released, active, cancelled or completed.

Organisational Model

The organisational model is a control mechanism based on a view of production resources. The model enables the setting of important default values, and definition of certain procedures and policy issues which will be implemented at resource group level. To use this facility, machines must be defined to an organisational model.

Overdue Days (Planning)

Indicates the number of days of overdue supply and demand to be considered in MPS/MRP runs

Overhead Rate

This is the rate per hour or % rate applied to absorb production overhead costs in to the item unit cost. It is specified on Cost Centres together with an Overhead Recovery Method.

Overhead Recovery Methods

Different recovery methods are available based on production costs, process time, materials or outputs in terms of values or quantities.

Overload

The condition where a machine has more work scheduled to be performed than it has available time in a given period

Pack Type

A category of standard outer packing, such as a box or a pallet, used for storing finished styles within a warehouse

Parallel Operations

As an alternative to consecutive operations, certain tasks may be carried out in parallel, for example, completing fronts, backs, sleeves and collars for shirts and then marrying up at a subsequent operation for completion.

Parallel Processing

This is the method of enabling groups of operations within the same production order to be active at the same time. This is also used to reduce the overall duration lead time for an operation.

Parameter File

Contains system and user-defined codes which set control parameters or allow the amendment of standard code descriptions

Physical Stock

This is the total quantity of an item in a stockroom. It is expressed as a balance quantity at item/stockroom level and also at item stockroom lot level.

Pick

The process of issuing materials from a warehouse to a production order

Pick Face

Within a warehouse, a fixed location from which most picking takes place for a material

Pick List

This is an instruction document detailing how much material is required and where it should be picked from. This is also referred to as a pulling list.

Piece Control

See Lot Control.

Planned Available

The quantity calculated to be available at any point in time if MRP or recommendations are implemented

Planned Material Scrap Rate

This is another way of expressing material wastage.

Planned Production Order

This is a production order that is not yet confirmed, but represents an intention to generate a supply. It does not have material and operation details, and is based on a standard production route.

Planner

There are two types of planner: firstly, a production planner is responsible for planning production of styles and secondly, a buyer is responsible for who plans a group of items and is linked to styles.

Planning Filter

This filter determines the sensitivity of MPS and MRP rescheduling logic when balancing supply and demand. Set up planning filters against the WTYP parameter under the Maintain Parameter File activity. Allocate a planning filter to a style on the Production Details window under the Style/Material Details activity. To override a planning filter on an individual route, use the MPS/MRP Filter field on Style/Route Override Maintenance window 3 from the Style Route/Bill of Material activity.

Planning Horizon

The end date of an item planning run in MPS or MRP

Planning Model

This is a method of defining a view of supply and demand for planning purposes. It is defined in terms of stockrooms. Multiple planning models may be defined to produce differing views of the production environment. One particular model must be defined as that from which MPS or MRP suggestions may be confirmed to production.

Planning Route

This is the route nominated for a style. The planning route is used to plan materials and schedule manufacturing dates and times in MPS and MRP. For a centralised plant, you can nominate the planning route on the Production Details window under the Style/Material Details activity.

For multi-plant MPS planning, however, multiple plants can have different planning routes. Therefore, Style establishes a link between the Receiving Stockroom nominated for a route and the stockrooms nominated for each plant's planning model.

Planning Type

This indicates whether the item is MPS or MRP controlled. This field is set up in Production Details under the Style/Material Details activity.

Primary Operation

This is a standard method for processing one part of the route. The primary operation is used for all the style variants, unless you have set up variant operations. The primary operation is used to calculate costs for the style.

Primary Stockroom

This is the default stockroom for issuing and receipt of an item, when defining a route. On costing routes, the issuing stockroom for a material must be its primary stockroom.

Priority

This is the relative importance of an order in the workflow. It is used to control the sequence of jobs queuing at machines.

Process Route

This is a definition of the processes (operational stages) and materials required to produce an item or set of items. It may also be referred to as a production route.

Product Family

A product family is a group of similar items whose demand follows a similar pattern. Group codes are defined on the Style Inventory Management, Descriptions File, and entered against items in the Style Inventory Management Product Group Minor field.

It is possible to maintain forecasts against families, thereby achieving reduced maintenance combined with an equivalent level of forecast accuracy.

Production Calendar

This is the definition of the production environment in terms of working days, non-working days, holidays and shutdown periods. Production calendars, once defined may be assigned to: Company Profile, Machines and MPS/MRP reporting profiles.

Production Lead Time

This is the amount of manufacturing time required to produce an item from its immediate materials and operations. No reference is made to the lead time of its materials.

Production Order

This is a document which sets out the details of the production of a specific style in specific quantities and which is used as an authority to carry out the work. It is also known as a works order.

Production Schedule

The plan which contains the sequence and timings of items and operations to achieve the planned production output

Production Sequence (Major)

An item parameter which controls the sequence in which items are planned in MPS and MRP

Production Sequence (Minor)

An item parameter which controls the sequence in which item operations are performed, recognising the need to make products in a preferred sequence due to, for example, colour change or set up costs

Put Away

For incoming materials, this is the process of moving the materials from the goods inward area in a warehouse to a location area within the warehouse. For received finished styles, this is the process of moving the styles from the receipt area in a warehouse to a location area within the warehouse.

Quantity Per

This is the standard quantity of a material that is required to make its standard parent lot size.

Queue Time

This is the length of time that a job will wait on average at a machine after arrival before it is worked upon. This is an element of inter-operation time, and should be reduced wherever possible.

Re-order Point

This is the quantity of an item in a stockroom which, when reached, should trigger a re-order action. This may be set manually. Safety stock is taken from the production item master file.

Receipt Area

An area within a warehouse in which finished styles are stored initially after production until they are put away in a warehouse location

Receiving Stockroom

Used in multi-plant MPS planning to link a planning route with the stockroom associated with a specific plant

Recommended Supply Orders

Suggested replenishments generated by MPS and MRP to support defined inventory stocking policies and to meet outstanding demand

Regenerative

An MRP planning method which re-plans every MRP controlled item, regardless of its demand and supply status

Released Production Order

This is a production order which has been released to the production (shop floor) process. Materials may be allocated and issued to it, and production activities may be booked against it. Any bookings of material or production will automatically change its status to Active.

Reporting Level

This is the level at which an operation will be reported. This may be style, style/colour, style/size or style/colour/size.

Reporting Profile

Although MPS and MRP calculate demand/supply on a daily basis, information pertaining to the production plan may be 'bucketed', that is, grouped into time slots, in accordance with a reporting profile defined for each planning model. Usually, this requires the grouping of data into small time periods at the start of the plan; then longer time periods as the plan moves out into future periods.

Reporting Types

This is a set of predefined transaction types which Transaction Manager uses to perform required updates. Examples are WIP scrap, down time, set up time and subcontractor rework.

Resources

These are the facilities which contribute to the production of items. Within the Production system, these comprise: cost centres, machines, work centres, production calendars, shift profiles, labour skills, operators, teams and subcontractors.

Rework

Work that is necessary to correct a sub-standard item rejected during/after its manufacture

Roll Control

See Lot Control.

Route

A definition of the operational stages involved in producing an item, sequenced in order of manufacture, and specifying the materials required in terms of materials and resources

Route Code

This is the identification code representing an item structure and production method. There can be different routes created for an item. A preferred planning and cost route can be defined.

Route/BOM

Defines both the route (production stages) and material requirements (BOM, recipe, formula) required to produce an item

Run Time

The length of time required by an operation

Safety Lead Time (Planning)

This is used to set an end date beyond the cumulative lead time of an item. The end date is calculated as item horizon plus safety lead time.

Safety Stock

The desired level of stockholding for an item to support a customer service or availability policy

Sales Forecast

This is a statement of the anticipated market demand for a product. It can be compared with actual sales orders, in MPS/MRP calculations to determine the net demand to be met by production. This is dependent upon the Demand Policy code set for the item.

Scheduled Receipt

A planned supply in MPS/MRP; this may be a released or active production or purchase order

Scheduling

The process of calculating and suggesting due dates, quantities and action dates for the supply of an item to meet required demand quantities and dates

Search Family

This is linked to a style. It defines the descriptions for each of the style's dimensions, i.e., colour and size.

Seasonal Profile

Use a seasonal profile to represent seasonal variations in forecasting. To create and update seasonal profiles, use the Maintain Seasonal Indices activity. The Profile Code field under this activity identifies each seasonal profile. To allocate a seasonal profile to a style, enter the Profile Code in the Seasonal Profile field under the Style/Material Details activity.

Serial Number Control

A form of lot control which maintains single, uniquely identified (serialised) units

Set Up

This is the option of preparing machines or processes for production. Set up time forms part of the lead time of an operation.

Set Up Time

This is the duration of the set up for a machine. This is expressed as a labour time.

Shade Control

See Lot Control.

Shift Length

The duration of an individual working shift for a machine

Shift Profiles

These describe the pattern of shifts in a day. Shift profiles use effectivity dates to reflect planned changes in patterns. A default shift profile may be assigned to a machine; or a shift profile assigned to each working day within a week at a machine. The shift profile defines the number of productive hours available on a working day.

Shipper Number

A number assigned to each shipment of items to or from a subcontractor if Shipper Tracking is in use

Shipper Tracking

A method of tracking materials or WIP inventory to or from subcontractors

Simulated Cost

A function which projects product costs by applying variables to the cost structure to ascertain likely future costs, or by changing materials to ascertain the cost impact of the changes

Single Level Enquiry

A one level explosion of a bill of material and route which costs the materials and operation processes required to make the parent item

Size Mask

This is linked to a style and is a group of sizes (in sequence) in which the style is produced.

SKU

Acronym for Stock Keeping Unit - an individual stock item

For styles of more than one dimension, the SKU represents the lowest level of definition for a style. For example, a 3-dimensional skirt (i.e. skirt/colour/size) may have various SKUs including black size 10, black size 12, black size 14, red size 10, red size 12, red size 14 and so on.

An SKU is also called a variant.

You can control production at the SKU level.

Smoothing Policy

A planning policy which smoothes sale forecast demand to provide a level production schedule

Standard Capacity

The daily capacity in hours of a machine when operating at its normal rate, and normal shift patterns

Standard Capacity Factor

This is a number that you can specify against a shift profile. This number is multiplied by the total number of hours defined in the shift profile to calculate the standard capacity of a machine. For example, for a shift profile of 8 hours at a machine where 2 persons operate, you would enter a factor of 2 to indicate a standard capacity of 16 hours.

Standard Costs

This is a costing method available in Production and Inventory. Standard costs are calculated for items based on standard cost rates and operation times and the standard costs of materials. They form the yardstick for performance measurement in a given period.

Standard Efficiency

This is the percentage of the standard capacity of a machine which you expect to achieve under normal operational circumstances. This percentage may be used in capacity planning enquiries and reports.

Standard Lot Size

Standard batch size in terms of which material quantities and operation times are expressed in a route/BOM

Standard Operation

This is an operation that can be included in individual style routes. The operation belongs to a standard operation group.

Standard Operation Group

These are standard operations that are grouped together, for example, a group of cutting operations. A standard operation group might also contain a generic sequence of operations. You can include one or more standard operations in individual style routes.

Standard Production Orders

Production orders which are based on a standard route to obtain material requirements and operation details

Start Date

The scheduled release date of a production or purchase order

Start Date (Planning)

This is the first date considered by MPS and MRP. Demand and Supply prior to this date is ignored. It is the Current Date less Overdue days set for the planning run.

Stock Forecast

A forecast used in MPS and MRP to plan variable levels of inventory availability to maintain desired customer service levels over and above standard safety stock

Stock Item

See SKU.

Stock Movement

This is a movement of a quantity of an item into or out of a stockroom. More particularly, this will refer to the recording of such a movement in the application, and the transaction record created as a result.

Stockroom

This is a discrete area where stock for an item is recorded and controlled separately from other company stocks. Stockroom codes are also used to define 'logical' stockrooms used to hold WIP inventory, and Floor Stock Locations which may be physical or logical stockrooms.

Stockroom Balance

See Balance and Item Stockroom.

Style

Style has two definitions. Firstly, Style is the System21 Style product. Secondly, a style is an end product with one or more dimensions.

Style Matrix

The style matrix is fundamental to System21 Style and occurs throughout System21 Style Distribution and System21 Style Production. A style matrix can have a maximum of 4 dimensions.

The first dimension of every matrix is always the style or the product itself. The second dimension (e.g. colour) sits on the X-axis of the matrix. The third and fourth dimensions (e.g. size, fit) sit on the Y-axis of the matrix.

Each cell in the matrix represents a single stock item or SKU (e.g. a size 12 black skirt).

The big advantage of the Style matrix is that, once the matrix is defined, the individual cells of the matrix are automatically created as the SKUs. Therefore, the Style matrix enables you to define vast numbers of individual stock items quickly and efficiently.

You can also make sensible decisions at the level of the style matrix rather than having to deal with each individual stock keeping unit.

Subcontract Operation

This is work on the production of an item that is carried out by another manufacturer. This entails sending materials or WIP which are worked on by the subcontractor before being returned for further operations, or quality inspection or receipt into stock.

Subcontractor Stockroom

This is a logical stockroom which holds all subcontractor material balances. Subcontractor WIP inventory balances are held as balances at operations in the associated machine WIP location.

Subcontractor Shipper

A document that goes out, together with the partly completed goods, to the subcontractor

Suggested Production Order

An MPS or MRP recommendation to create a production order to satisfy a shortage identified by the planning process

Suggested Purchase Order

An MPS or MRP recommendation to create a purchase order to satisfy a shortage identified by the planning process

Sundry Issue

Any receipt of materials that is unrelated to either a purchase order or a production order

Sundry Receipt

Any receipt of materials that is unrelated to either a purchase order or a production order

Supplier

A code representing the vendor/supplier

Supply

The planned receipt of item quantity from a purchase order or production order

Team Size

The standard number of operatives scheduled to work on an operation, either as direct labour or set up labour

This Level

The final level of manufacture for an item with a multi level route/BOM, as opposed to 'lower' levels of manufacture such as sub-assemblies

Time Basis Code

This is a code indicating how operation times are expressed on a route. These are: time per lot; time each; quantity per hour; fixed time, time per 1000; time per 100; time per fixed batch.

Time Booking Policy

This is a parameter set on the Organisational Model to control the time booking format in Production reporting. This may be in decimal hours or hours and minutes. This policy is set only if the Time Reporting Policy is set to elapsed time.

Time Fence

The date which the schedule is fixed no recommendations are made by MPS or MRP to change existing production or to suggest new production

Time Fence Days (Planning)

The number of days that are added to the Current Date to calculate the Time Fence Date

Time Fence Policy

Parameter set at item level indicating whether shortages occurring within the time fence should be ignored, or satisfied on the Time Fence date

Time Reporting Policy

This is a parameter set on the Organisational Model to control the format in which operator and machine times at an operation are entered. This may be set for entry as elapsed time or as work start time and stop time.

Time Units

These are the units in which operation times are expressed. This is defined on the Company Profile and can be in hours or minutes.

Transaction Manager

This is the function that processes production and WIP inventory transactions, generating movement records and updates balances. It runs in its own subsystem and may be started and stopped. It must be running in order to keep balances and transaction details up-to-date during production bookings.

Transaction Number

Each production booking entered on the system is allocated a system transaction number which may be accessed and displayed for subsequent reference in enquiries and reports.

Transaction Type

There are System21 transaction codes which represent a particular balance update or movement generation. The transaction type calls a program which ultimately updates the database.

Trial Kit

This is a method of simulating material allocation to a production order or route to assess availability to meet the requirements. It is also known as Material Availability Enquiry.

Trigger

Marks a change to the demand or supply of a Style item since the last net change MRP run

Unit Cost

The amortised cost of a single unit of an item

Unit of Measure

The unit in which a balance quantity or unit cost is expressed

Unplanned Issue

Issue of materials to a production order which has not been previously allocated

Unplanned Receipt

Receipt into inventory of an item or items not expected at the booking operation, that is, not standard on the route, or order

Usage

The quantity of an item issued from a stockroom in a given period

Usage Profile

A user-defined profile which specifies the pattern of periods to be included in the calculation of average usage

Utilisation

The extent to which the capacity of a machine is expended by actual work performed

Value/Usage

This is the value/usage setting for an item in Inventory. It positions the item in a matrix of value/usage. It is a selection criterion for selective MRP.

Variance

A difference between the standard cost or volume of a process and the actual recorded cost or volume

Variant

These are the different colours and sizes which make up a style or material. A variant is equivalent to a SKU. Each variant has a cell in the Style matrix.

Variant Operation

This is an operation that produces one or more style variants in a different way to the primary operation. Style calculates costs separately for style variants produced by a variant operation. Scheduling of work is also done separately for these style variants.

Variant Spread

This is a distribution of variant quantities that is used to break down a total quantity for the style. For example, if you wish to make twice as many red shirts as green shirts, you can enter 2 under red and 1 under green. Then, if blue shirts are ten times more popular than green shirts, you need to enter 10 under blue. Style uses this variant spread to distribute a forecast down to variant level. In addition, when you create a production order, Style distributes the total quantity amongst the variants according to this variant spread.

Warehouse

If you have Warehousing installed, you can use warehouses to stock materials and finished goods.

Wastage (Material)

The planning factor applied to any material on a route to reflect expected loss

Wastage (Operation)

This is the planning factor applied to an operation to reflect expected losses. Scheduling uses the factor to inflate the standard times to make the required lot size.

Wastage Cost

This is the amount of item unit cost attributable to operational or material wastage in the production process. It is held by Cost Element and can optionally be consolidated into the item cost elements. A wastage element can be configured to display the total wastage cost.

WIP

Acronym for Work-in-Progress

WIP Inventory

Work-in-progress inventory - transparent to Style Inventory Management, but accessible through enquiries in Production WIP Inventory Control

WIP Location

A WIP location defines a location, either logical or physical, on the shop floor where inventory is stored between operations. The location may be associated with one or more machines.

Initially, inventory balances at a given WIP location are maintained as a result of booking inventory against a count point operation. Quantities may be entered for good, scrap and held inventory. WIP Inventory Management allows inventory to be changed in a variety of ways prior to its reaching the next operation in the route.

WIP Shipper

See Subcontract Shipper.

Work Centre

This is a collection of machines grouped together for capacity requirements analysis. Work centres are not used in planning or machine scheduling.

Work-in-Progress

This is the value of work currently underway in the factory in terms of the material issued, and the operations performed. For a given order, WIP valuation is calculated as the value of material and work material less the value of receipts made into stock. Work-in-progress (WIP) can be valued at standard or current cost.

Works Order

See Production Order.