Infor System21 Style Production Data Management

Product Guide

Contents

About this guide

The purpose of this document is to describe the functions that can be used within the Production Data Management Module.

Intended audience

The guide is intended for any users of the P1 Production Data Management 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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Style Production has been developed specifically to meet the needs of organisations engaged in the production of items such as clothes (apparel), footwear and soft furnishings, where, although the products are diverse, the manufacturing requirements are similar.

In common with other System21 applications, a single copy of Style Production can be operated for any number of companies, the characteristics of each being determined by a number of control parameters. These parameters are held in the Style Production company profile and in the Organisational Model.

System Overview

Style Production comprises the following integrated applications:

- Production Definition Management
- (Production Planning) Forecasting
- (Production Planning) Master Production Scheduling
- (Production Planning) Material requirements Planning
- Production Control

Production Definition Management (PDM)

This may be run in stand-alone mode if required. It offers a self-contained environment for the definition and management of products, processes, resources and costs. It is the source of control parameters and reference information for all Style Production applications.

The maintenance functions of PDM enable the creation and amendment of reference information critical to the functioning of Style Production. Once this data has been set up, PDM is enabled to generate product costs (standard and non-standard) and provide extended analysis of product definitions and processes.

(Production Planning) Forecasting

This provides the facility to forecast demand to style/colour/size level, with products optionally grouped into product families. Such forecast demand is then input into MPS and MRP processing.

(Production Planning) Master Production Scheduling

This provides a top-level master production schedule (MPS) for your critical production items.

(Production Planning) Material Requirements Planning

This provides a detailed material plan for your business via a material requirements planning (MRP) run.

Production Control

This controls and maintains all aspects of the production cycle; from the manual creation and/or maintenance of suggested production orders, through material issuing, to work-in-progress reporting (booking), to the receipt of finished goods into inventory.

Production Control also provides comprehensive enquiries and reports to monitor not only the progress of individual production orders, but also the performance of your factory/production unit(s).

The Production System Applications

The Production system, illustrated in Figure 1-1, comprises four core applications, governed by a company profile. The link between Style Production applications and Style Inventory Management is mandatory, whilst the others shown are optional but functionally desirable for the effective integration of management information.

Company Profile

The Production system, in common with all System21 applications, operates within a multi-company environment.

A company profile sets the basic system defaults and operation policies relevant to each Production company, defines the costing elements and defines base calculation parameters which are used by all Production functions.

Access to the company profile is usually restricted to system managers and implementation project managers who will require a comprehensive understanding of the implications of each if its parameter settings. However, awareness of the company profile's purpose and features is relevant to all users.

In addition, further parameters effecting control over how the system operates are found within the Organisational Model.

The Production System (Figure 1-1)
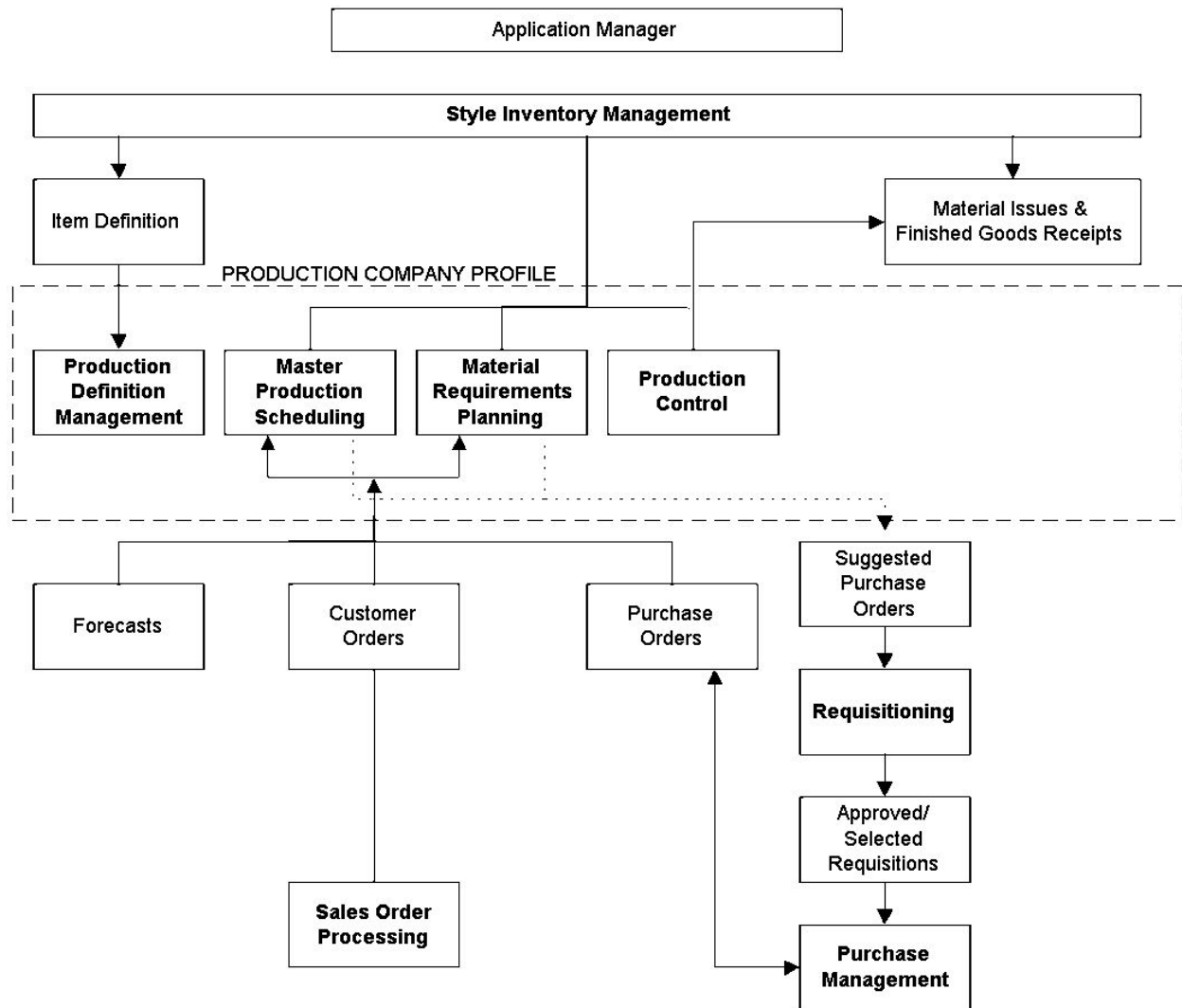
The Operation Management Cycle

The Operation Management cycle addressed by the Production system is summarised in Figure 1-2.

Sales orders and forecasts are combined to create a demand input to the Master Production Scheduling (MPS) application. A high level plan is created which suggests production and purchase order quantities and dates. This plan normally consists of manufactured items.

The capacity of the facility to implement the high level plan may then be checked using the inherent Capacity Planning facility.

Once a plan is agreed, the suggested orders output from the MPS cycle are then combined with associated component items and raw materials to create a demand input to the Material Requirements Planning (MRP) application. MRP reconciles existing production commitments with the revised MPS demand to create a detailed purchase order plan. This plan suggests all purchase orders relevant to a user-defined planning horizon.

When the production plan is finally approved, production and purchase orders are created and the planning cycle passes to the Production cycle.

The Production cycle enables orders of varying status to be released to production. Once released, orders can be tracked by notifying the system of operations and transactions completed though the Maintenance and Transactions functions. Additional facilities enable the entry of transactions and interrogation of the system through enquiry windows. Production reports may also be created. Completed items pass into Inventory to complete the Operations cycle.

The Operation Management Cycle (Figure 1-2)
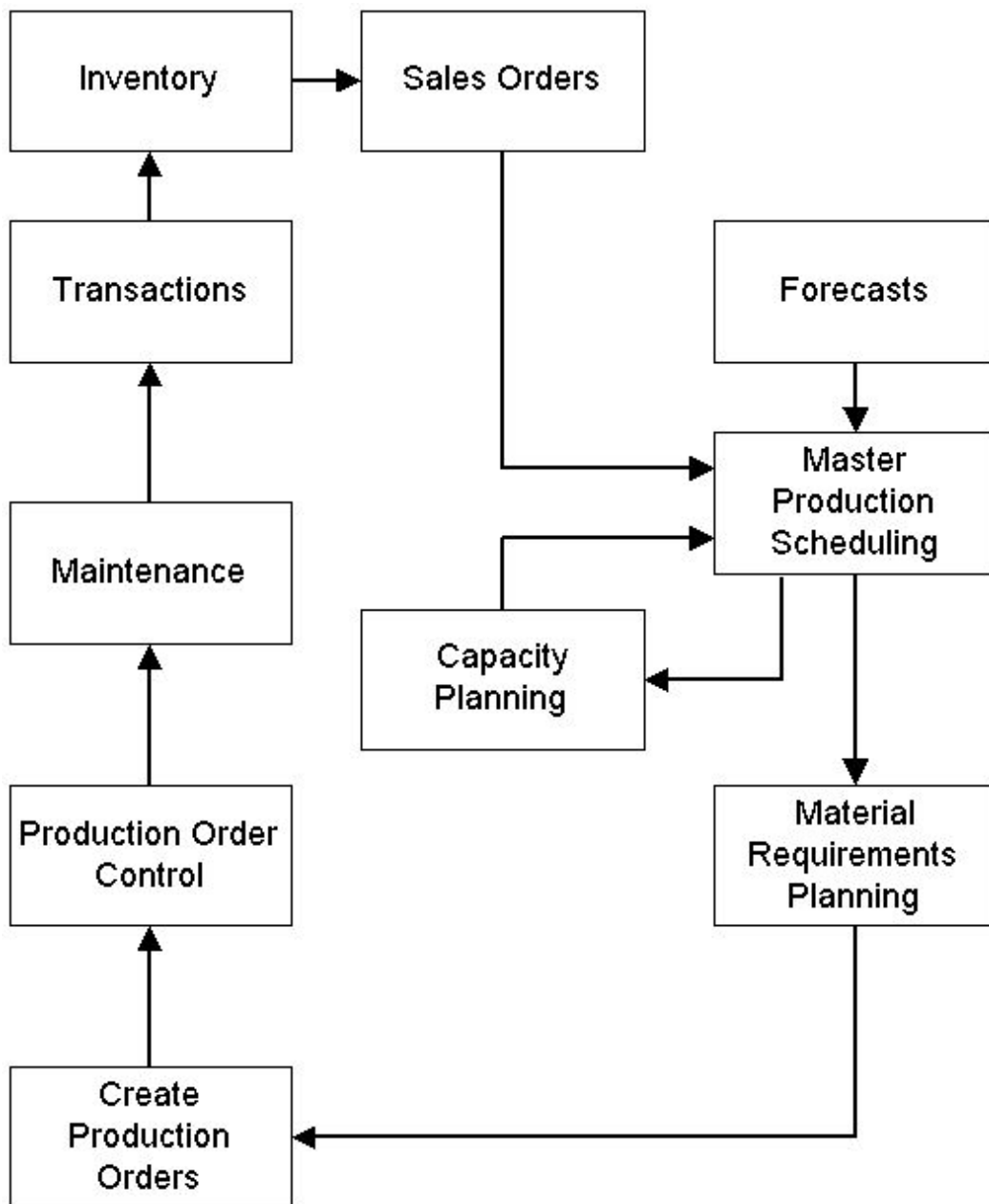
Production Definition Management

Style Inventory Management is the source of the primary item database within the overall system environment for both purchased and production items. Every item to be referenced within Production must first be defined to Inventory.

Production Definition Management (PDM), Figure 1-3, manages the Production database which contains extended, production-specific details of all items that will be used by the Production applications, definitions of the resources that will be used to combine materials into finished products; and provides facilities to cost products.

Resources are classified as machines (which may be grouped to form work centres), the cost basis of each machine being defined by an assigned cost centre, departments, labour skills and profiles, operators and teams, and subcontractors.

Single-level production routes entered within PDM define the operations required to make an item: the machines at which the work will be carried out and materials necessary to complete the operation. The end result, or output, of a production route may be multiple items such as different colours and sizes of jumpers, shirts or pairs of shoes, or a component (for use in the manufacture of a finished product). The single-level production routes are automatically extended into full multi-level structures by the system where required.

Database configuration, in conjunction with the default settings in the company profile, is fundamental to an effective business management system. A clear understanding of the database, its links to Style Inventory Management and the company profile is prerequisite to determining the system to be implemented.

Production Definition Management (Figure 1-3)
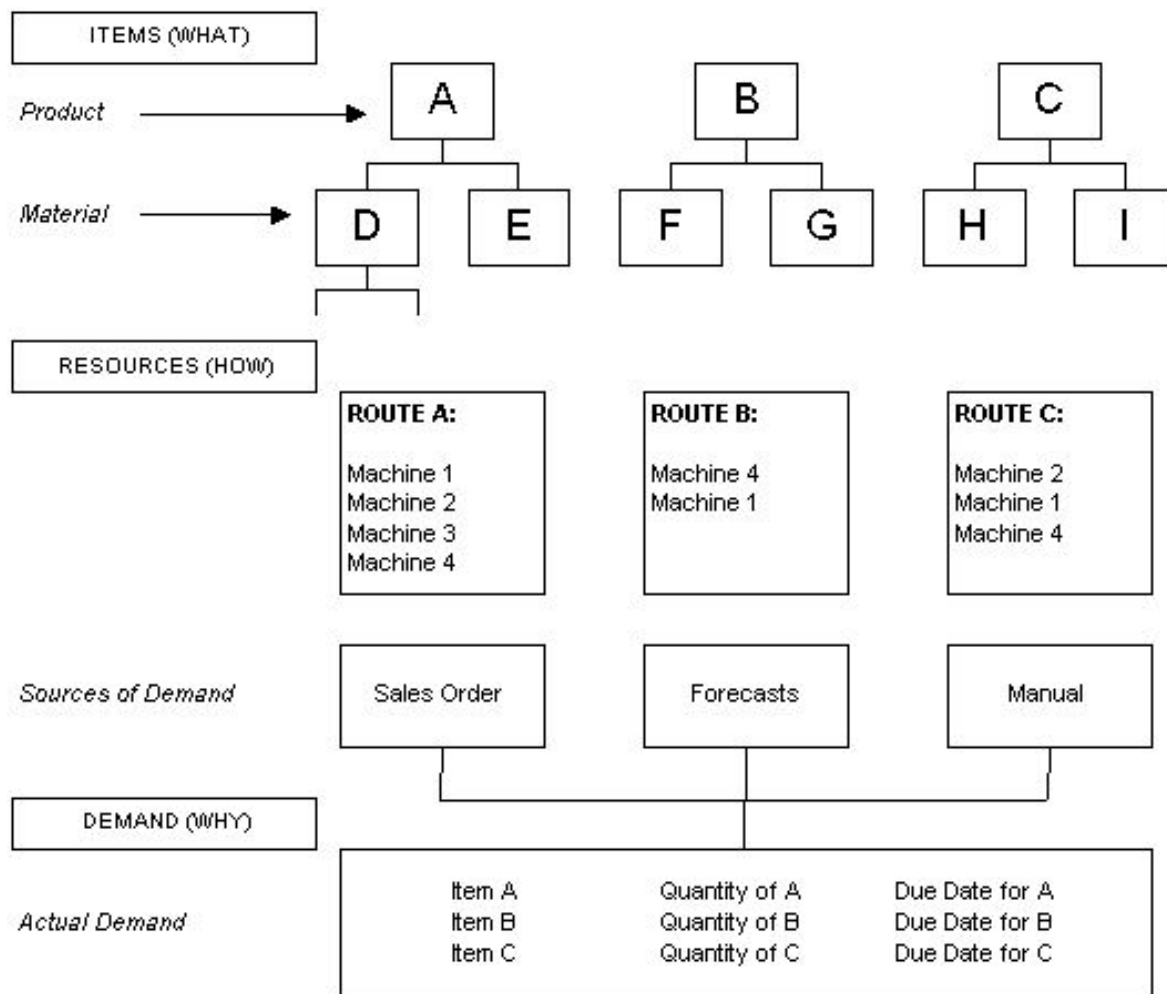
Master Production Scheduling

The Master Production Scheduling (MPS) application, Figure 1-4, produces a high-level production plan for manufactured items. The system then matches the projected demand for designated products to the ability to supply based on user-defined planning models and planning horizons.

Demand is a function of sales orders, forecast, and/or manual entries or a user-defined combination. The ability to supply is a function of the availability of associated items and resources defined within the Production Definition Management application. The resulting plan will, where necessary, suggest amendments to current production orders, and/or suggest the generation of new production and purchase orders. The calculation process for the respective plan generations is simply:

Demand - Availability = Requirement

A demand forecast may be determined using a simple annual forecast defined within MPS.

MPS is a time-based plan of suggestions to meet customer due dates. The plan is derived by the system by working backwards from the customer due date specified, taking account of product lead times, to suggest a latest start date that will achieve completion by the due date.

In each case, a plan is derived that includes suggested purchase orders and Production resource requirements across the chosen time horizon. Production orders may be individually confirmed or may be confirmed en masse and purchase orders can be automatically passed through to the Requisitioning application for subsequent confirmation and transfer to the Purchase Management application in advance of further MRP planning, if required.

MPS also incorporates capacity planning. MPS can use summary routings to determine the loading in hours on the Production facility resources relative to their capacity in hours. It takes account of machine capacities when assessing the demand proposed by MPS plans and determines a loading factor for each machine. Capacity planning also determines labour loading.

Item planning route information is accessed to convert demand (in quantities) into the number of hours required (the load) at each machine.

Planned supply dates are used to schedule these required hours into appropriate weekly production time slots at each machine, with reference to machine standard capacities and with due regard to planned down times and non-working days affecting the planning run timescales.

Reports and enquiries are available to compare the weekly machine/work centre hours required and available within the planning run timescales, so that it is possible to determine whether over or under load capacity situations at machines and for labour skills occur and thus to decide on the action required.

The routine enables finite capacity planning by individual order, but assumes infinite capacity of the facility. It is therefore the responsibility of the planner to complete any fine-tuning of the workload to optimise the loading factor and hence utilisation of production capacity.

MPS (Figure 1-4)
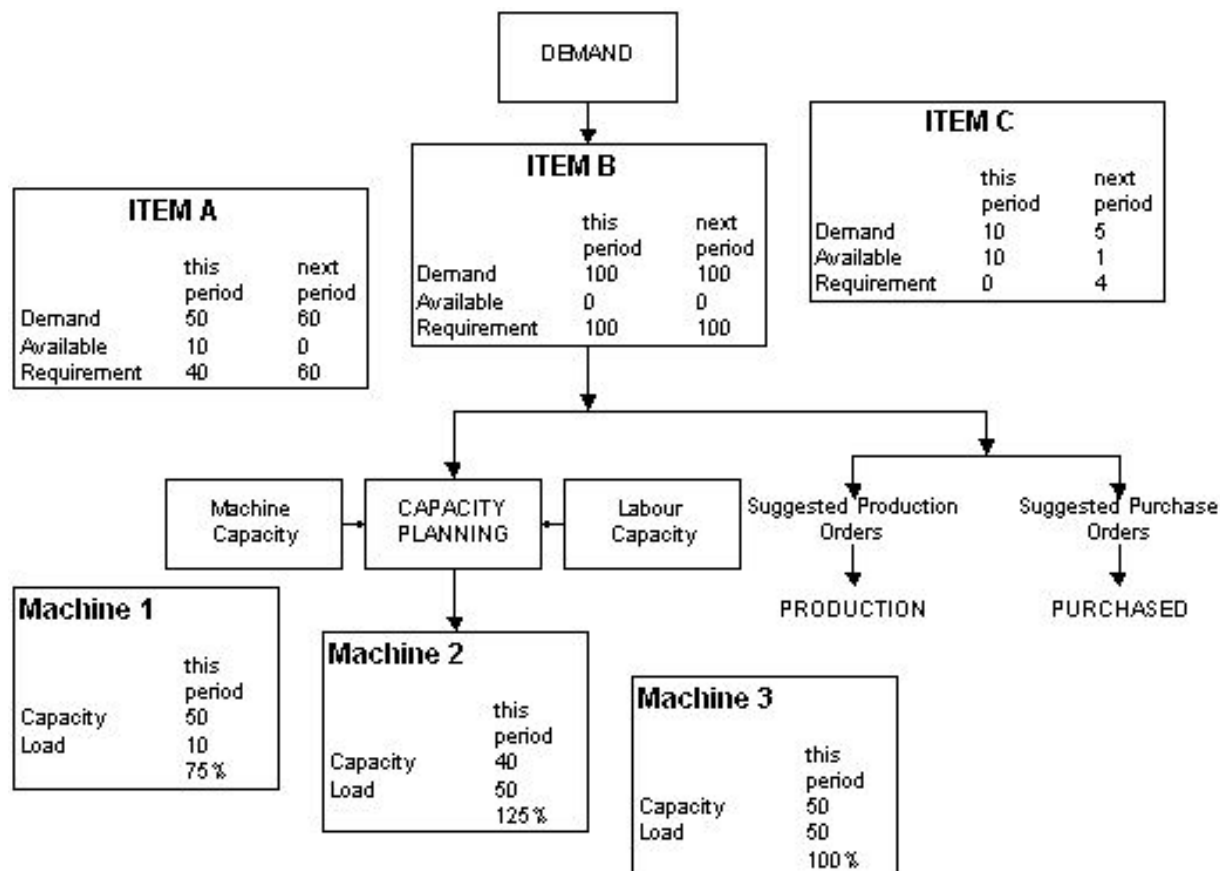
Material Requirements Planning

Material Requirements Planning (MRP), Figure 1-5, produces a detailed plan for the purchase of all the lower level items, sub-parents and raw materials. Planning is again based upon user-defined models.

MRP differs from MPS in two key respects. Firstly, it includes all items in a structure. Secondly, there is a choice of modes of processing:

- Regenerative: Plan for all items across all structures
- Selective: Plan only selected items and hence selected structures

MRP and MPS are autonomous applications; either may be used stand-alone. However, MRP is normally driven by MPS demand as shown in Figure 1-5. A separate MRP demand may be used to enhance the requirements for dependent MRP items.

MRP and MPS plans are based upon independent user-defined models and reporting profiles. The reporting profiles may be based on a non-linear time horizon; for example, a three-month plan might be structured as follows:

Next Week	Daily Detail
Week 2-4	Weekly detail
Week 5-8	Fortnightly detail
Week 8-12	Monthly detail

MRP (Figure 1-5)
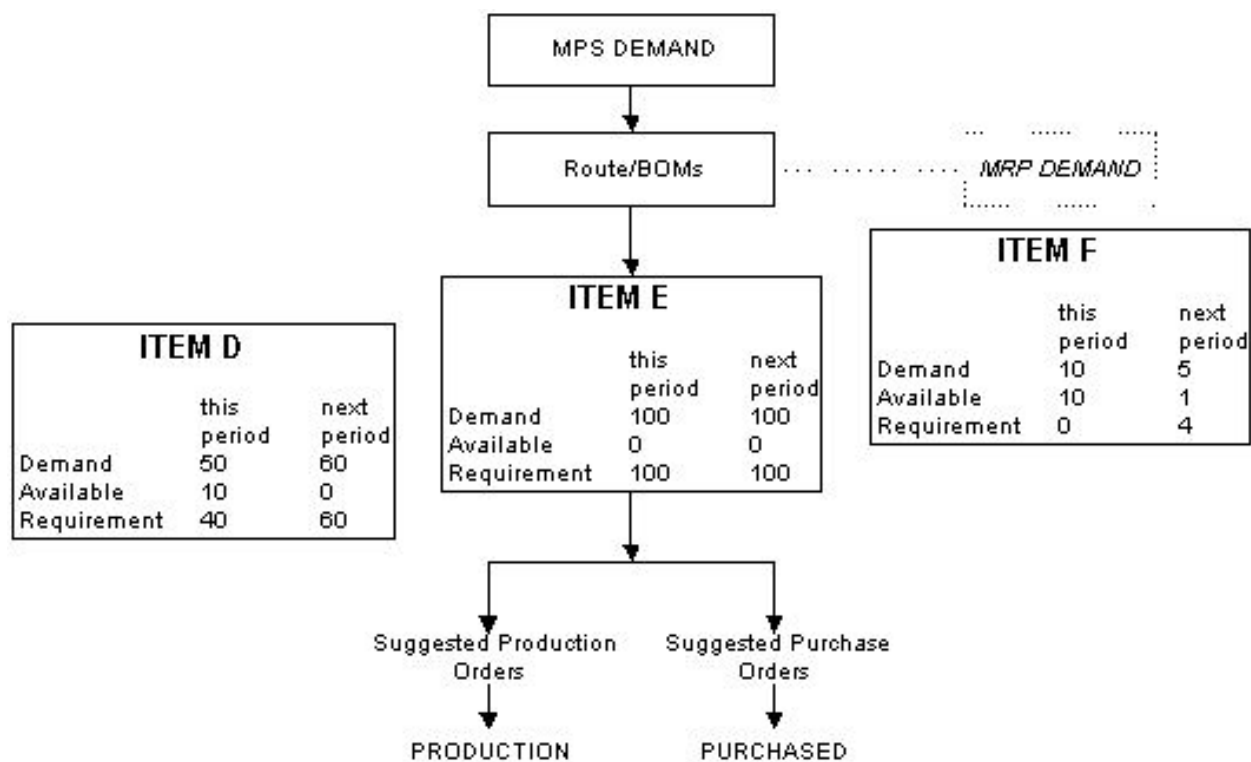
Production Control

Production Control, Figure 1-6, provides the means to record the 'real world' implementation of the production plan and permits operational transactions to be made against the plan.

Production Control enables the system to monitor the progress of orders through the Production facility by logging the status of each order at a machine. The order status can be:

- Suggested
- Planned
- Confirmed
- Released
- Active
- Completed
- Cancelled

In addition, Production Control facilitates the recording of operational transactions, such as the issue of materials, backflushing of bulk issues, scrap, re-work and placing unused materials back in stock.

Facilities are available to assist in the management of machines, work-in-progress inventory (WIP), and inventory stocks. Production-related reports can be generated to show costing and efficiency

information. The accuracy of these reports is dependent on maintaining good discipline in booking operations. The rigor of such discipline has to be balanced with the demands of the Production environment.

Production Control (Figure 1-6)


```
Raise production order
(MPS or manual)          ───►  print initial production order
        │
        ▼
Check material
availability and allocate
at batch level
        │
        ▼
Release production
order                    ───►  print final production order
        │                                    │
        ▼                                    ▼
Issue materials                auto bundle creation ────┐
        │                                               │
        ▼                                               │
Report production pre                                   │
or non bundle control    ───►  at style/colour/size or at style
        │                                               │
        ▼                                               │
Manual bundle up                                        │
creation                 ───►  print barcoded tickets ◄─┘
        │
        ▼
Report production        ───►  bundle wand barcodes
        │
        ▼
Complete production      ───►  report final operation at style/colour/size
        │                                    │
        ▼                                    ▼
Receive stock at         ◄───  report final operation at style/colour/size
style/colour/size
```

Implementation

This section provides an overview of the critical path to follow in setting up a Style Production company, managing data take-on and ultimately shipping your finished goods to a customer.

The path described also assumes you are working within a fully comprehensive, integrated system, where the following applications are available:

- Style Inventory Management
- Style Sales Order Processing
- Style Purchase Management
- (and by implication: Accounts Payable/Purchase Ledger)

If your system is not as complex as this, non-relevant stages and data definitions may be skipped.

A full description of each data element may be found within this guide, or within associated product guides, prepared specifically for the integrated applications.

The Critical Path to Production

Each of the following stages is numbered consecutively in the order in which data definition should take place.

Note: Do not assume that you must complete all prior stages before lower level stages can be started. This is a guide, not an absolute order.

You may want to hold discussions with your system consultant with regard to an implementation procedure specific to your requirements.

Step	Description	Menu	Tasks
	Prior to Style Production		
1)	Create a new company via Application Manager.	STRM400	
2)	Authorise the user(s) to the new company in Style Distribution as necessary.	STRM400	
3)	Copy the company in Style Distribution.	STCO	6
4)	Maintain the Style Sales Order Processing, company profile. Set the Style Production in Use flag to 1 (Yes).	STCO	1
5)	Maintain the Style Inventory Management company profile. Create stockroom records, including work-in-progress (WIP) locations and subcontractor materials stockroom.	STCO	2
6)	Maintain the Style Purchase Management, company profile.	STCO	3

Step	Description	Menu	Tasks
7)	Create suppliers, including subcontractors, in Accounts Payable (Purchase Ledger).	APM	1
8)	Create colours for each company.	STINM	2
9)	Create sizes for each company.	STINM	3
10)	Create Style Inventory Management calendars.	STINM	10
11)	Create Style Inventory Management periods.	STINM	11
12)	Create search families.	STINM	12
13)	Create size masks.	STINM	4
14)	Create inventory descriptions.	STINM	1
	Style Production		
15)	Authorise user(s) to Style Production.	STRM400	
16)	Maintain the Style Production company profile.	P1U	1
17)	Create Organisational Models.	P1U	6
18)	Create company parameters: planner codes and production stages.	P1U	2
19)	Create styles and materials.	P1M	1
20)	Create cost centres.	P1M	30
21)	Create calendars.	P1M	31
22)	Create shift profiles.	P1M	32
23)	Create departments.	P1M	33
24)	Create machines.	P1M	34
25)	Create work centres.	P1M	35
26)	Create labour skills.	P1M	37
27)	Create labour profiles.	P1M	38
28)	Create bundle ticket types.	P1M	36
29)	Create resource capacity profiles.	P1M	21
30)	Create critical resources.	P1M	20
31)	Create standard operations.	P1R	1
32)	Create style route/BOMs.	P1R	2
33)	Create price list profiles.	STOEM	5
34)	Create customers.	STOEM	2

Step	Description	Menu	Tasks
35)	Create price lists.	STOEM	6
36)	Enter sales orders.	STOEP	2
37)	Create MPS planning models.	P2M	1,2
38)	Create style forecasts.	P1F	13
39)	Spread forecasts to variants.	P1F	15
40)	Create supply sourcing rules.	P2M	3
41)	Run MPS.	P2M	11
42)	Review MPS.	P2M	15
43)	Review capacity.	P2M	22
44)	Confirm suggested orders.	P2M	14
45)	Create MRP planning models.	P3M	1,2
46)	Run MRP.	P3M	11
47)	Review MRP.	P3M	13
48)	Create purchase orders from suggestions.	STRQP	2,11,21,31
		STPMR	1
49)	Create purchase orders manually.	STPMP	1
		STPMR	1
50)	Enter raw material receipts.	STPMP	3
51)	Transfer purchasing costs.	P1C	3
52)	Full cost roll up.	P1C	1
53)	Create activity types.	P1U	31
54)	Create operators.	P1M	39
55)	Create teams.	P1M	40
56)	Define user authority levels.	STPMM	7
57)	Create manual production orders.	P4M	1
58)	Allocate lot materials.	P4E	2
59)	Release production orders.	P4M	2
60)	Issue materials.	P4T	1
61)	Report (book) production.	P4T	2,3,4
62)	Enter subcontractor WIP shippers.	P4T	6

Step	Description	Menu	Tasks
63)	Progress subcontractor work.	P4T	7
64)	Receive from subcontractor.	P4T	8
65)	Receive into finished goods.	P4T	2,3,4
66)	Enter supplier invoices.	APP	1,2,3
67)	Match invoices to GRNs.	STPMP	6
68)	Despatch to customer.	STOEP	8

Chapter 2   Maintenance

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Introduction to Style Production

Style Production meets the production needs of the clothing, apparel, footwear and soft furnishing industries.

The manufacturing requirements for all these industries are very similar. They require:

- A horizontal sequence of operations defined in the route
- At least two levels of items, the finished goods, known as styles, and the materials used to produce the styles

With Style Production, you can maintain common information for the multiple variations of a style in one action. You can also produce some style variants using different machines.

You can use a single copy of Style Production for any number of companies. You use the company profile and the organisational model to configure the characteristics of each company.

Style Production comprises four integrated modules:

- **P1** - Style Production Definition Management
- Use Production Definition Management (PDM) to define and manage products, processes, resources, costs and forecasts.
- **P2** - Master Production Scheduling
- Use MPS to produce a top-level master production schedule for manufacturing styles.
- **P3** - Material Requirements Planning
- Use MRP to produce a detailed material plan for your business.
- **P4** - Style Production Control
- Use Production Control to control and maintain all aspects of the production cycle, starting from releasing the production orders, through to receiving the finished goods.

Interfaces

To run Style Production, you must have Style Inventory Management. However, for extra data management facilities, you can also integrate Style Production with the following:

- Style Purchase Management

- If you want to define subcontracted operations on routes or Bills of Material, you must have Style Purchase Management.
- Style Sales Order Processing
- Style Warehousing

Style Purchase Management

Style Purchase Management has a two-way interface to Style Production:

- Style Purchase Management provides MPS/MRP with details of current material supply information.
- MPS/MRP generates suggested purchase orders, which when you confirm them, raise purchase requisitions. The purchase requisitions are subsequently converted to firmed purchase orders.

You can arrange to create purchase orders automatically for subcontracted operations. You must also create all supplier records within Accounts Payable.

Style Sales Order Processing

Style Sales Order Processing provides a two-way interface to Style Production:

- Style Sales Order Processing provides MPS/MRP with details of current sales demand information.
- Style Production provides Sales Order Processing, via Style Inventory Management, with current details of how supply will meet sales demand.

You create a forecast of sales demand using either Style Production or Forecasting. Use Style Inventory Management to extract information about styles, and Style Sales Analysis to obtain details of sales history.

Style Warehousing

Style Warehousing is effectively an extension of Style Inventory Management stockrooms. You can use Style Warehousing to designate location details for materials and styles within a stockroom.

You can use Style Warehousing to carry out the following:

- Satisfy material requirements generated by production orders
- Provide a receiving location for finished goods
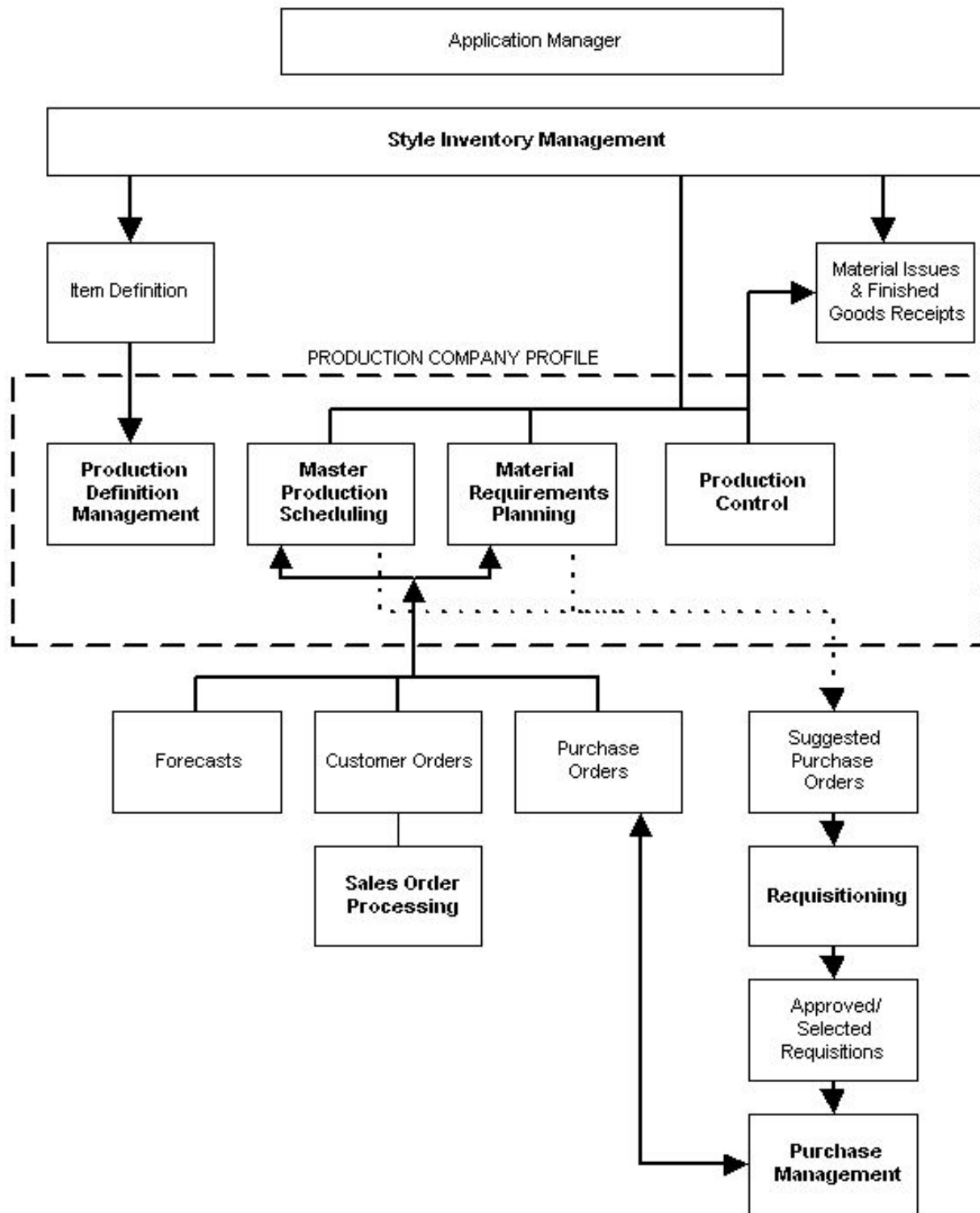
The Business Cycle

Introduction

The following diagram provides an overview of the business cycle:
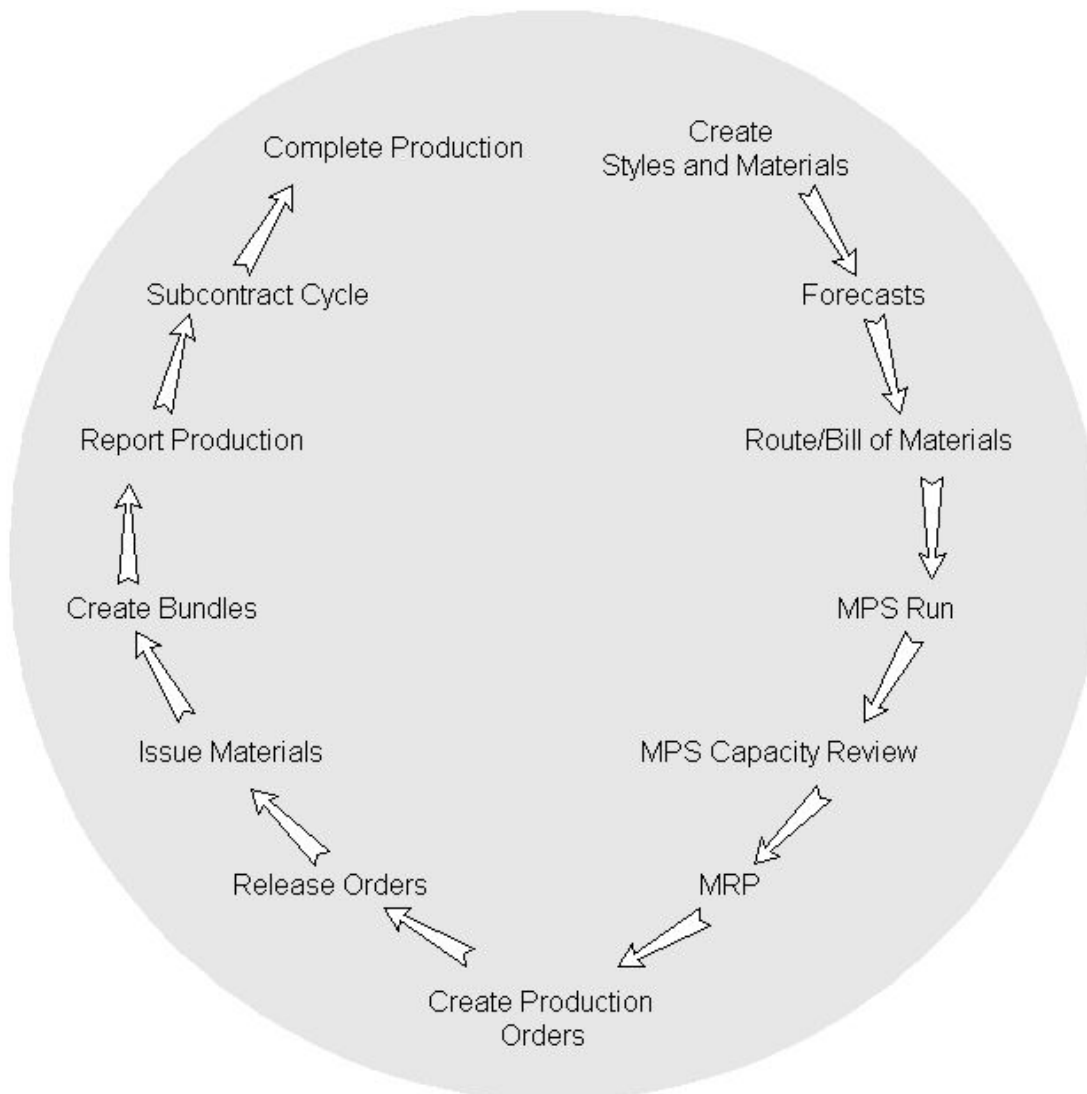
Create Styles and Materials

Styles are the end products that your business sells to customers. Materials are the materials, such as fabric, trims and packaging, which make up the styles.

With Style Production, you can enter information about a style or material all in one go, which means that you do not have to enter information for each colour and size variant separately. For each style and material, you can define colour variants and up to two types of size variant.

You identify each style and material variant with a code in the following format:
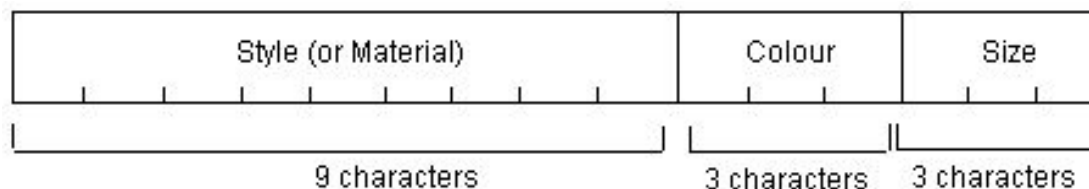
When creating a Style or Material, the Inventory item description for each colour and size variant is built from the description entered for the Style on the initial entry window together with the colour and size descriptions from the colours and size mask/s assigned to the Style during the maintenance.

Forecasts

You can enter forecasts at the following levels:

* Style
* You can spread this forecast to style and colour, or style, colour and size.
* Style and colour
* Style, colour and size
* Style, colour, size and fit
* Product family
* You can spread this forecast to style; style and colour; or style, colour and size.

Routes and Bills of Material

You can produce multiple variations of styles, or components on each production route. The route defines:

* The operations needed to make a style
* The materials needed to complete each operation
* The machines on which the work is scheduled to be carried out

You can have multiple routes for each style. On each route, you can:

* Match style colours to material colours
* Change material quantities per style size
* Change operation details for different style colours and sizes

Style Production caters for multiple plants. If you are making a particular style in more than one plant, you can use multi-plant planning to shift the load from one factory to another factory.

MPS Run and Capacity Review

You can run MPS centrally for multi-plant or from a single plant and then review the capacity loading. For more details on MPS, refer to the Style Production Planning product guide.

MRP

You can run MRP either before or after firming up MPS orders. You can perform a full regenerative run or a selective run. You can also restrict MRP to consider only the changes that have occurred since the last time it was run. For more details on MRP, refer to the Style Material Planning product guide.

Create Production Orders

You can create production orders manually or process production orders suggested by MPS.

Production orders, suggested by MPS, break down to style variant level. MPS calculates supply at style variant level, but presents information at style summary level.

Release Orders

Use the Trial Kit facility to make sure that you have all the materials you require. Within Style Production, you can make lot control an automatic feature. You can also arrange to create bundles at order release.

If a subcontractor is responsible for any of the operations, Style Production issues a purchase order.

Issue Materials

When you issue materials, you can:

- Accept or change the lots that Style allocates
- Issue substitute materials
- Record unplanned issues
- Transfer materials to a subcontractor, for example, if cutting is an outworking operation

Create Bundles

A bundle is a collection of all the fabrics and other materials that you need to produce a garment.

You can create bundles either automatically or manually. You can print bar-coded bundle tickets, which you can then use to track the garment.

Report Production

You can enter time spent in production either by booking actual operator time, or by entering timesheet information. You can also use the bar-coded bundle tickets to enter the information.

Subcontract Reporting Cycle

Where several subcontractors are carrying out consecutive operations, you can define the operations separately. You can check the progress from operation to operation.

Complete Production

You can complete production when you book the final operation. If you book in the full quantity, the software automatically completes the production order. Even if the quantity you book in is short, you can close the order.

At the end of the production cycle, the completed products pass into Style Inventory Management.

The Critical Path to Production

This section provides an overview of the critical path to follow when you set up and manage your Style Production company. This is for a fully comprehensive integrated system, running all of the Style Production modules and:

- Style Inventory Management
- Style Sales Order Processing
- Style Purchase Management and Accounts Payable

If your system is not as complex as this, you can skip irrelevant stages and data definitions.

Note: If you have any specific requirements, check with your software consultant before implementing your system.

Note: For a full description of each step, refer to the product guide for each System21 module.

Before Using Style Production

- Use administration functions to create a new company.
- Use administration functions to authorise users to the new company in Style Distribution.
- Use Style Inventory Management to copy a company into Style Distribution.
- Use the Style SOP Company task to set the Production in Use flag to **1**.
- Use Style IN Company Profile task to create stockroom records, including work-in-process locations and stockrooms for subcontractor materials.
- Maintain Style Purchase Management company profiles.
- Create suppliers and subcontractors.
- Create colours for each company using Style Inventory Management.
- Create Style Inventory Management calendars and periods.
- Create search families.
- Create sizes, size maps and inventory descriptions.

In Style Production

- Authorise users to Style Production.
- Maintain Style Production company profiles.
- Create organisation models.
- Create company parameters.
- Create styles and materials.
- Create cost centres.
- Create calendars and shift profiles.
- Create departments, machines and work centres.
- Create labour skills and profiles.
- Create bundle ticket types.
- Create resource capacity profiles.
- Create critical resources.

- Create standard operations, routes and BOMs.
- Create price list profiles and customers.
- Create price and discount lists.
- Create depot profiles.
- Enter sales orders.
- Create MPS planning models.
- Create Style forecasts.
- Spread forecasts to variants.
- Run and review MPS.
- Review capacity.
- Confirm suggested orders.
- Create MRP planning models.
- Run and review MRP.
- Create purchase orders from suggestions.
- Enter purchase orders manually.
- Enter raw material receipts.
- Transfer purchase costs.
- Perform a full cost roll up.
- Create activity types.
- Create operators and teams.
- Define user authority levels.
- Create manual production orders.
- Allocate lot materials.
- Release production orders.
- Issue materials.
- Report or book production.
- Enter subcontractor WIP shippers.
- Progress subcontractor work.
- Receive from subcontractor.
- Receive into finished goods.
- Enter supplier invoices.
- Match invoices to GRNs.
- Despatch goods to customer.

What is Production Definition Management?

Production Definition Management manages the Style Production database. This database contains:

- Extended production details of all the styles and materials used within Style Production.
- Information about the resources (for example, labour skills and machines) that you use to combine materials into finished products.
- Facilities used to cost products.

Style Inventory Management maintains information about purchased and produced styles and materials. Therefore, you must define in Style Inventory Management every style and material that you use within Style Production.

Resources

You can classify resources as:

- Machines, which you can group into work centres
- The assigned cost centre defines the cost basis of each machine.
- Departments
- Labour skills and profiles
- Operators and teams

Creating Styles and Materials

You must set up two sets of data for each style and material:

- Inventory details
- Production details

Inventory Details

Use inventory details to define how you purchase, manufacture, sell, cost, analyse, stock issue or control a style or material within Style applications. You can then set up the production details for a style.

Style Production only reviews those fields or flag settings that have a direct impact on the production process.

Note: You can define inventory details for both styles and materials from within either the Style Inventory Management module or the Style Production Definition Management module.

Production Details

Production details define how you provide, schedule for production, forecast and cost Style products.

You must set up inventory details beforehand.

Styles [1/P1M, 5/STINM]

Use this task to create and maintain styles and materials.

Product Maintenance Selection Window

To display this window, select the Styles task.

Fields

Style

To maintain an existing style, enter the appropriate code.

Alternatively, use the prompt facility to select from the Item Master Scan pop-up.

To add a new style, enter a new code using up to 9 characters.

Note: The style code is a unique identifier to each style product and each material and breaks down into the following:

Style: You must enter up to nine characters to specify a unique identifier for the style. This is sufficient for one-dimensional styles and materials where colour and size is irrelevant, such as coat hangers and pins.

Colour: You can enter up to three characters.

Size/Fit: You can enter up to three characters. If you only want to use size only, you can use all three of these characters to describe the size (for example, XXL to describe Extra Large). Otherwise, you need to break down the three characters into size and fit (for example 14 to describe size 14 and L to describe long fit).

Note: Style concatenates these code elements to create a full style definition.

Based On

If you want to save time when you create similar styles or materials, you can copy from a style that you have already defined to Inventory Management.

Enter a code for the style you want to copy across.

Alternatively, use the prompt facility to select from the Item Master Scan pop-up.

If you want to amend an existing style, leave this field blank.

Note: We recommend that you use the Based On field if you do not want to change the Search Family for the new style.

Note: The next three fields are only displayed if you are using Enterprise Orders.

Copy from Company

Enter the company code to which you have already defined this style. This is called the source company.

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

Source Stockroom

You must enter the stockroom within your source company from which you want to copy this style.

Alternatively, use the prompt facility to select from the Stockroom Selection pop-up.

Stockrooms

Enter the stockroom, or stockrooms, within the company into which you want to copy this style; these are the target stockrooms.

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

Order Method

Use this to control the way you handle sales orders.

Enter one of the following:

0 - Normal order

1 - Make to order

2 - Buy to order

3 - Direct delivery

4 - Reservations

5 - Enterprise order

6 - Enterprise direct delivery

Alternatively, use the prompt facility to select from the ORDM Order Method pop-up.

Press Enter to display the Product Maintenance Description window.

Production Maintenance Description Window

To display this window, press Enter on the Product Maintenance Selection window.

If you want to amend an existing style, use this window to modify the style description.

If you want to create a new style, use this window to enter a description for the style.

Fields

Style

This field displays the selected style code.

Style Description

Enter up to 17 alphanumeric characters to help you identify the style.

Functions

Text (F21)

Use this to enter additional descriptive text. For more information, see the Maintain Text Pop-up section.

Purchase Text (F22)

Use this to add or update text for a purchased style. For more information, see the Purchase Text Pop-up section.

If you want to update a material or style, press Enter to display the Product Maintenance Option Selection window.

Alternatively, if you want to add a new material or style, press Enter to display the Product Maintenance Static Details window.

Product Maintenance Option Selection Window

To display this window, press Enter on the Product Maintenance Description window if you are maintaining an existing style.

Note: If you are creating a new style, this window is displayed at the end of the creation process, before the style is created.

The options you can choose from on this window depend on the way in which you have set up your style.

- Colour Select
- This option is displayed if you have assigned at least one colour code to the style.
- Size Mask Select
- This option is displayed if you have assigned at least one size mask to the style.
- Warehouse Details
- This option is displayed if you have activated Warehousing for this company and you are authorised to Warehousing.
- Production Details
- This option is displayed if you have activated Style Production and you have defined production details for this style.
- Packaging Usage Details
- This option is displayed if you have specified that you want to record Packaging Usage information for your style.

Caution: Making changes in an option does not save updated details automatically. To save the changes you make to details in a selected option, select **Update (F8)** before you leave this window.

Fields

Option

Select one of the following:

Static Part (1) - To use both the Product Maintenance Static Details window and the Product Maintenance Costing Details window to update Inventory details

Static Warehouse (2) - To use the Stockroom Details Maintenance window to update Inventory costing and provisioning details

Warehouse Select (3) - To use the Product Code Maintenance Warehouse Selection window to update the stockrooms you can use to receive and issue your style

Style only allows balances and transactions against these stockrooms.

Colour Select (4) - To use the Product Code Maintenance Colour Code Selection window to add more colours to the style

Size Mask Select (5) - To use the Product Code Maintenance Size Mask Selection window to update the size masks to cover all the variations in size of the style

Warehouse Details (6) - To use the Maintain Item/Warehouse Details window to identify which warehouses, if any, stock the style

You can then issue from these warehouses and receive into these warehouses. This option is only available if you use Warehousing.

Production Details (7) - To use the Production Details window to update production details for the style

This option is only available if you use Style Production.

Maintain Item Search (8) - To use the Inventory Item Search Words window to enter search words

Delete Style (9) - To use the Style Deletion window to delete the style

Where the style is a piece style, any carton SKUs to which it is linked must have no orders or stock attached, and if the carton SKU is still active, deletion is not allowed. If an active carton SKU is not found, deletion is allowed and carton records for the piece style are also deleted.

Where the style is a carton style, normal Style delete validation prevents it from being deleted if it is still active. Where it can be deleted, all its Carton file definition details are also deleted.

Packaging Reporting (10) - To create packaging usage information for your style

For more information, see the Introduction to Packaging Requirements section in the Packaging Requirements chapter of this product guide.

Carton Maintenance (11) - To display any existing carton styles which are linked to this piece style

Once one is selected, Carton Maintenance is invoked. (See the previous section for details.) On return, with carton(s) successfully defined, the original style is set as a piece style. This is not available for carton styles and kit styles.

Note: If you are creating a new style, the software automatically displays the windows that are available.

Functions

Update (F8)

Use this to save any details that you have added or amended. If you have set up the Inventory company profile to generate article numbers, the software displays a window from which you can select the styles for which numbers will be generated.

No Update (F11)

Use this to leave this window without saving your changes.

If you are amending an existing style, choose an option and then press Enter. The next window displayed depends on the option you have chosen.

Production Details Window

To display this window, if you are amending an existing style, select Production Details in the Option field and then press Enter on the Product Maintenance Option Selection window.

Alternatively, if you are creating a new style and you use Warehousing, select **Complete (F21)** on the Maintain Item/Warehouse Details window.

Alternatively, if you are creating a new style and you do not use Style Warehousing, select **Previous (F12)** on the Maintain Item/Warehouse Details window.

Use this window to enter or maintain the default production details for the style.

Note: This window is only displayed if you use Style Production.

You can use the Full Product Details task in Style Production to change the following fields for individual variants on specific process routes:

- Minor sequence
- Major sequence
- Material and user-defined costs 1 to 4

Critical Fields

You must specify details for:

- Item type
- Planning route
- Costing route
- Planning type
- Demand policy
- Forecast level

Fields

Item Type

Enter one of the following to determine how you use this style:

Bought Out (B) - Styles or materials, for example: buttons, zips, hangers, suit covers, and packaging materials such as boxes, laces, labels and so on

Manufactured (M) - Production styles or materials

These are styles (finished goods) or intermediates used to produce a style, that is, production styles or materials that appear on lower levels of a route/BOM.

Purchased (P) - Styles or materials, for example: lace, leather, cotton, silk, nylon, linings and so on

Consumable Tool (T) - For example: knitting needles, blades, pins and so on

You can use the prompt facility to select from the PIPT Item Type pop-up.

Note: If you use item types P (Purchased) and B (Bought Out), you can use the Indented Cost Simulation task to see the effect on a cost explosion of increasing or decreasing purchased and bought out costs; and apply independent percentages to either or both.

Note: Planning applications consider item types B (Bought Out) and T (Consumable Tools) as purchased styles/materials.

Note: You can re-set this flag at style or material planning route level using the Route/Bill of Material maintenance task.

Planner

Use this field as follows:

- If you have specified that this is a purchased item, enter the buyer responsible for buying the style.
- If you have specified that this is a manufactured item, enter the planner responsible for planning production of the style.

You can use planners in Style Production Planning to sequence MPS and MRP outputs in reports. You can also select a planner on planning enquiries, giving you fast access to schedules for styles/materials under the planner's control.

You define planner codes under the PLAN system parameter using the Maintain Parameter File task.

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

Note: To change the planner for an individual route, use the Route/Bill of Material task.

Specification Ref

You can use up to 15 alphanumeric characters to specify your own or customer or supplier specification.

Planning Route

You use this for manufactured styles and materials only. Enter the planning route you want MPS and MRP to use as a default planning route when suggesting production orders. When you create production orders for this style, Style Production Control nominates this route as the planning route by default. In addition, the Cumulative Lead Time and Production Lead Time

fields on this window use the planning route to calculate lead times when you select **Calc. Production Lead Time (F19)** and **Calc. Cumulative Lead Time (F20)**.

If you use multiple plants rather than a centralised plant, leave this field blank. With MPS multi-plant planning, different plants can use different planning routes. The software determines which planning route to use for each plant by matching the receiving stockroom for a route on the Style Route Header window with the stockrooms set up for a plant's planning model using the Maintain Model Stockrooms task.

Note: Make sure that you create the planning route using the Style Route/Bill of Material task.

Caution: Since you can create a route or bill of material with a blank code, you could define the wrong planning route if you leave this field blank.

Costing Route

Enter the route code to use to roll up costs. Style Production uses this route to calculate standard and non-standard unit costs; it also uses it to calculate the standard cost of a style in its primary stockroom. Make sure you define this route using the Style Route/Bill of Material task.

Planning Type

Select one of the following to indicate whether you want to plan this style as a production style (MPS) or as a material requirement (MRP).

MRP (0) (default) - Material Planning style

MPS (1) - Production Scheduling style

Fabric Type

Use this code to group together styles and materials with the same fabric content, for example, 100% cotton, polycotton, velour and so on. You use this code in Production Scheduling, Material Planning and Production Control to select and sequence styles.

Forecast Level

Use this to determine whether your style has a forecast, and at what level you can maintain that forecast.

Note: This code must be compatible with the code that you specify in the Demand Policy field.

You can maintain forecasts at one of the following levels, or you can spread a forecast down to this level from a product family level forecast.

Enter one of the following:

Blank - No forecast required

You can only use this if you have set the Demand Policy to blank or **0** (Total actual demand) or **3** (Independent demand compared to dependent demand).

0 - To maintain the forecast at style level

Use this for styles/materials with sizes and/or colours.

1 - To maintain the forecast at the style/colour level

Use this for 2-dimensional styles/materials.

2 - To maintain the forecast at the variant level

Use this for 3-dimensional and 4-dimensional styles/materials.

You can define these codes in the Parameter file under type DEMP.

You can use the prompt facility on this field to select from the DEMP Forecast Levels pop-up.

Note: If you set this field to 0, you can enter forecasts at the style level rather than for each variant. Subsequently, use Generate Variant Stock/Style Forecast task to spread the forecast down to variant level.

Minor Sequence

Use this to determine the sequence in which you want styles/materials processed at a machine.

For example, you could use this if you have a mixing process where products range in colour from light to dark, so that you can sequence light coloured styles/materials ahead of dark. Alternatively, you could use it to sequence styles/materials with a long set up time ahead of them, or following those with short set up times, or to sequence high quality output ahead of low.

You can use this in conjunction with the Major Sequence field on the Additional Parameters pop-up. You can use this pop-up to group similar styles/materials so that you can plan and schedule together; with the processing of styles/materials within the group sequenced by the code entered here.

Enter up to six characters to define the sequence number for this style.

Leave this field blank if you do not want to use special sequencing

Note: Although this is the default setting for a style, you can re-set the sequence at style/colour/size level for individual process routes using the Full Product Details task. You can re-set this sequence at individual route level using the Route/Bill of Material task.

Demand Policy

Use this field to control the method the software uses to compare the following types of demand to arrive at the adjusted or net demand that drives MPS and MRP.

You control the method used to calculate forecast demand using the Consume Forecast field in the company profile. This affects those policies that use Planning or external forecasts. You can use this field to select whether you want to adopt a discrete comparison or a cumulative consumption.

The demand policy you choose will also affect the level of forecast you can choose.

You can define these codes in the Parameter file under type MPFF.

Enter one of the following:

0 or Blank - Total actual demand

This is the sum of sales orders *plus* dependent demand with no forecast.

1 - Forecasts compared with independent demand

This is the greater of the forecast *or* sales orders *plus* dependent demand.

2 - Forecasts compared with total demand

This is the greater of the sales orders *plus* dependent demand **or** forecasts.

3 - Independent demand compared with dependent demand

This is the greater of sales orders *or* dependent demand with no forecast.

4 - Make to forecast

This is equal to forecast only, with no sales orders or dependent demand.

6 - Total demand

This is the total demand; that is, the sum of forecasts *plus* sales orders *plus* dependent demand.

You can use the prompt facility on this field to select from the MPFF Planning - Demand Policy pop-up.

Note: You can exclude MPS and MRP recognised demand from the production schedule or material plan because it contravenes the specified demand policy. The software indicates these with X in the supply status code when you process an enquiry or report. For example, WX indicates an excluded production order. You can override this field for individual routes on the Style/Route Override Maintenance window in the Route/Bill of Material task.

Smoothing Policy

Enter one of the following to indicate the demand smoothing policy that you want MPS and MRP runs to use:

0 - No smoothing

By default, this buckets forecasts into weekly requirements

1 - Forecast smoothing

This spreads forecasts evenly over each working day in a week.

You can define these codes in the Parameter file under type FPOL. You can re-set this value at individual route level using the Route/Bill of Material task.

You can use the prompt facility on this field to select from the FPOL Levelling Policy pop-up.

Note: You should only select option 1 after you have carefully reviewed your disk space, because it carries a substantial machine overhead in terms of disk space requirement

Planning Filter

Use this field to specify the style's default re-scheduling policy during MPS and MRP processing. These sensitivity policies determine whether or not you can re-schedule production orders at a particular status, or if you can increase or decrease the order quantity.

You can also choose to exclude recommendations for insignificant or unworkable changes to the quantity or due date of the supply (order).

Enter one of the following:

Blank - If no special conditions apply.

Non-blank - If the software is to generate a parameter code using the filter character as a suffix to the order status

The status/filter combination refers to a particular set of processing rules which MPS and MRP use in preference to the default rules. You must define each filter character against each order status.

Production order status codes are as follows:

41 - Planned

42 - Confirmed

43 - Released

44 - Active

For example, if you enter a planning filter character of **S**, when you confirm a production order it will have a status of **42S**. The effect this will have on planning recommendations will depend on how you have defined **S**.

Although filters are specific to an order status, you can apply them to any style. If you do not define a filter, any code entered here will have no effect on the planning process.

You can define these codes in the Parameter file under type WTYP.

You can use the prompt facility on this field to select from the WTYP Planning Filter pop-up.

Note: You can re-set this filter for a specific production order when you create or maintain an order, using Production Scheduling and Material Planning reviews. You can also re-set this filter at individual route level using the Route/Bill of Material task.

Seasonal Profile

You can enter the default seasonal profile for the style you want to use in Production Scheduling and Material Planning forecasting routines.

Alternatively, use the prompt facility to select from the Select Seasonal Index pop-up.

You can define profile codes via the Maintain Seasonal Indices task within Forecast Management.

Min Order Qty

Use this value at the variant level with ordering policies **B** (Discrete above Minimum) and **H** (Multiples above Minimum) in MPS and MRP to set the minimum quantity for a suggested supply order.

Note: You can re-set this at individual route level and at the item variant/planning route level using the Route/Bill of Material task.

Max Order Qty

This value determines the maximum supply order quantity for this style. MPS and MRP use this value at the variant level as an advisory field. If a suggested order quantity exceeds this value, the system will flag the order for the planner's attention by:

- Printing 'Above Max' on the Material Planning Recommendations report
- Printing an asterisk (*) against the production order on the Production Scheduling Schedule report and the Material Planning Material Plan report

- Highlighting the production order on the Production Scheduling, Review Production Schedule and Material Planning Review enquiries

Note: You can re-set this at individual route level, and at the item variant/planning route level using the Route/Bill of Material task.

Mult Order Qty

The software uses the value you enter here at the variant level in conjunction with order policy code **H** (Multiples above Minimum). This increases the suggested order value in increments of the multiple above minimum order quantity, to meet the demand.

Note: You can re-set this at individual route level and at the item variant/planning route level using the Route/Bill of Material task.

Fixed Order Qty

MRP and MPS use this quantity to generate suggested supply orders for each variant using order policy **D** (Fixed Quantity).

If this requirement is greater than the fixed quantity, the software generates additional batches of the fixed quantity until you meet the requirement.

Note: You can re-set this at individual route level and at the item variant/planning route level using the Route/Bill of Material task.

Safety Stock

If you need to retain a safety or buffer stock, enter a quantity at variant level. This figure is the target Inventory level maintained by MPS and MRP.

Note: You can re-set this at individual route level and at the item variant/planning route level using the Route/Bill of Material task.

No. of Days Supply

This is the period cover. Use this to determine the number of days forward of this date that you need a suggested order to cover. You use this value in conjunction with order policy code **G** (Number of Days Supply).

Note: This flag may be re-set at individual route level and at the item variant/planning route level via the Route/Bill of Material task.

Production Lead Time

This is number of days that production needs to produce a style from the components or raw materials, or both.

Note: You can re-set this at individual route level and at the item variant/planning route level using the Route/Bill of Material task.

You can enter this lead time, or choose to let the software calculate this from the designated planning route and standard lot size, using **Calc. Prod. Lead Time (F19)** or from within the Route/Bill of Material task when you define the style's planning route.

If you select Use Item Time Fence when you run MPS and MRP, the software uses the production lead time, in preference to the default global option, to establish the frozen schedule time fence for the style.

Cumulative Lead Time

This is the total number of days you need to produce the style based on a full explosion of its planning route, including any low level production styles/materials included on the route; and the purchasing lead time of materials and any bought out components.

Note: The software uses the Static Stockroom Lead Time details to produce the Purchasing lead times. You can re-set this at individual route level using the Route/Bill of Material task.

The software calculates this from the longest leg or critical path of the production and procurement process.

You can enter this lead time or choose to let the software calculate this from the designated planning route and standard lot size, using **Calc. Cum. Lead Time (F20)**.

If you select Use Item Time Fence when you run MPS and MRP, the software uses the production lead time, in preference to the default global option, to establish the planning horizon for the style. For non-production styles/materials, the calculation specifies the purchasing lead time.

Primary Stockroom

You can define multiple stockrooms for a style. The software uses the primary stockroom as the default for all issuing and receipt activities for this style. You can override this default during transaction processing and route definition.

You can use the prompt facility on this field to select from the Select Stockroom pop-up.

Mat'l Control Policy

Use this field to define the way you issue this style to production.

Enter one of the following:

0 - Formal issue against a production order

1 - Backflush

These styles have stockroom balances reduced by standard requirement quantities when you book a quantity at a route count point. If you select this, you do not need record a formal issue transaction against a production order. This is commonly used for bulk issue styles/materials. Lot-controlled styles/materials cannot be backflushed.

Note: If you select this, you should assign subcontractor materials to this policy.

2 - Actual issues

You must formally issue these styles.

3 - Shop floor stock

When you issue this style it creates a reservation at a designated holding area (floor stock location). This location is associated with the machine defined on the operation that needs this material. You must enter a floor stock location when you define a machine.

When you use floor stock material it you must record it via the Material Usage window. This window opens automatically when you book work at an operation where such styles are a standard input. Such styles are generally lot-controlled.

You should assign this policy to any materials defined on a route as key styles; these materials must also be lot-controlled.

You can define these codes in the Parameter file under type BLKI.

You can use the prompt facility on this field to select from the BLKI Bulk Issue pop-up.

Order Policy

MPS and MRP use supply order policies to govern suggested order replenishment quantities.

Enter one of the following:

A (default) - Discrete (lot for lot)

Use this to produce a suggested order quantity equal to the demand quantity.

B - Discrete above minimum

Use this to generate a suggested order quantity to meet the requirement that will be at least as large as the stipulated minimum order quantity. If the requirement is less than the minimum, the suggested order is equal to the minimum quantity.

D - Fixed quantity

Use this to create one or more orders of a fixed quantity, with the same due date, until the requirement is met.

G - Number of days' supply (period cover)

Use this to accumulate forward requirements over the specified number of days and generate a single order to satisfy the total demand.

H - Multiples above minimum

This policy takes into account two parameters. It will generate a minimum quantity and plan that any unsatisfied requirement above the minimum be met by increments of the defined multiple order quantity. You should define variations with this policy using Route Overrides Maintenance, if you have defined the standard style with order policy I.

I - Multiples up to a maximum

You can use this at style level only. The software compares the total of the variants to the multiple and maximum order quantities defined for the style. If the total exceeds the maximum, it will split an order into two or more separate orders. If the total is not divisible by the multiple, later supply will be brought back until the next multiple is reached.

J - Variable

You should define variants with order policy **H**, with its multiple the same or a direct division of the style multiple, using Route Overrides Maintenance within the Route/Bill of Material task.

You can define these codes in the Parameter file under type POPC.

You can use the prompt facility on this field to select from the POPC Planning - Order Policy pop-up.

Note: You can re-set this at individual route level and at the item variant/planning route level using the Route/Bill of Material task.

Functions

Grade (F15)

Use this to display the Style Grade Association window.

More Parm (F18)

Use this to display the Additional Parameters pop-up.

Calc. Prod. Lead Time (F19)

Use this to calculate the production lead time. The software updates the Production Lead Time field automatically.

Calc. Cum. Lead Time (F20)

Use this to calculate the cumulative lead time. The software updates the Cumulative Lead Time field automatically.

Text (F21)

Use this to enter additional descriptive text.

Costs (F22)

Use this to review style costs. This displays the Item Cost Maintenance Details window. For more information on this window, please refer to the Item Costs section.

Var Qtys (F23)

Use this to display the Variable Batch Order Quantities pop-up.

Note: This is only available when the order policy is J.

Press Enter to save the details.

Style Grade Association Window

To display this window, select **Grade (F15)** on the Production Details window.

Use this window to enter the style grade details.

Fields

Style

This field displays the selected style.

Grade

Enter the grade code.

Alternatively, use the prompt facility to select from the GRCD Grade Code pop-up.

Graded Style

Enter the graded style.

Alternatively, use the prompt facility to select from the Item Master Scan pop-up.

Note: If the graded style is lot-controlled, the style being maintained must also be lot-controlled.

Colour

Enter the colour code for the graded style.

Size/Fit

Enter the size/fit combination for the graded style.

Description

This field displays the text description for the selected style.

Functions

Delete (F11)

Use this to delete a graded style line. A confirmation pop-up is displayed. Select **Delete (F11)** to confirm the deletion.

Select **Update (F8)** to save the details and return to the Production Details window.

Additional Parameters Pop-up

To display this pop-up, select **More Parm (F18)** on the Production Details window.

Use this pop-up to define a material's material type and to make a material ratio-based.

Fields

Major Sequence

You can group both styles and materials under a common heading so that you can plan and schedule them together. These are planned and scheduled in the order that you specified using the minor sequence on the Production Details window.

Note: This is the default setting for a material. You can re-set the sequence at style/colour/size level for individual process routes using the Full Product Details task. You can re-set this at individual route level using the Route/Bill of Material task.

You can define these entries in the Parameter file under type PRSQ.

You can use the prompt facility on this field to select from the PRSQ pop-up.

Material Type

This defines your style's material type, and determines the cost element into which it accumulates.

Enter one of the following:

0 or blank - Fabric

The style is a single-dimension material. Any costs associated with the style when used on a bill of material are assigned to the Fabric cost element.

1 - Trim

The style is a single-dimension trim or accessory style. Any costs associated with the style when used on a bill of material are assigned to the Trim cost element.

2 - Packaging

The style is a single-dimension packaging material. Any costs associated with the style when used on a bill of material are assigned to the Packaging cost element.

3 - Fabric group

The style is a multi-dimensional material. Any costs associated with the style when used on a bill of material are assigned to the Fabric cost element.

4 - Trim group

The style is a multi-dimensional trim or accessory style. Any costs associated with the style when used on a bill of material are assigned to the Trim cost element.

5 - Packaging group

The style is a multi-dimensional packaging material. Any costs associated with the style when used on a bill of material are assigned to the Packaging cost element.

You can define these codes in the Parameter file under type MATP.

You can use the prompt facility on this field to select from the MATP Material Cost Type pop-up.

Material Usage Policy

Use this to define how you want to determine the material quantity when you specify this style on a bill of material.

Note: You can only view this field if you have defined fabric, trim or packaging group styles or materials.

Enter one of the following:

0 or blank - Quantity per based

You can prompt for variant material quantity. During Route/Bill of Material entry, you are prompted for the quantity per of this material that you need to make each variant of the parent style. You can set up these quantities on the Material Quantity Requirements pop-up in the Route/Bill of Material task.

1 - Ratio-based

Let the system auto-calculate variant material quantity. During Route/Bill of Material entry, the quantity per for each variant is calculated automatically based upon user-defined (on relevant route/BOMs) material usage factors and the quantity per specified for the primary style. You can

set up these quantities on the Enter Material Usage Factors pop-up in the Route/Bill of Material task.

You can define these codes in the Parameter file under type IDXS.

You can use the prompt facility on this field to select from the IDXS Material Usage Policy pop-up.

Discrete Demand

Use this checkbox as follows:

Unchecked - For daily accumulation

This accumulates supply on a daily basis (unless order policy **G** (Number of Days Supply) is used).

Checked - For discrete demand

Supply is created discretely for each Sales Order demand, even when there are multiple demands on the same day.

The default value is obtained from the Parameter file, type STYD, code DSDM. The first character of the parameter code value contains the default.

The parameter can be set on only for Styles which are:

- Manufactured (i.e. this function in not available for purchased items)
- MPS-controlled (i.e. this function is not available in MRP)

Order Method = 1 (Make to Order) (This is necessary to prevent sales order entry functions allocating stock orders to orders that will be supplied by discrete demand linked production orders).

The Discrete Demand parameter cannot be set on if forecasts are consumed on a cumulative basis (company profile field MPS/MRP Consume Forecast is **checked**).

See the Discrete Demand Planning Process section in the Planning Process chapter of the Style Production Planning product guide for further information.

Demand Based Order No

The demand and supply order numbers can be linked for manufactured items by formatting the production order number to include the originating sales order number. This linking by supply number is effected through multiple planning levels so all production orders can be referenced back to the original sales order demand.

The Demand Based Order Number parameter has 3 values:

0 - Production order numbers formatted as normal:

Character 1 = single character prefix of **W**.

Characters 2-7 = unique number incremented from Last Order Number Used control field in the company profile.

1 - Production order number is based on the demand order number:

Characters 1-5 = last 5 numeric characters of the originating sales order number

Characters 6-7 = sequenced AA to ZZ for each supply record generated from the original sales order

2 - Production order is based on sales order reference:

Characters 1-6 = first 6 characters of the originating sales order reference

Character 7 = sequenced A to Z for each supply order created from the originating sales order

Note: If characters 1-6 of the sales order reference contain blanks, or all A to Z suffixes have been used, the next standard format sequential order number will be assigned from the company profile record.

The default value is obtained from Parameter file, type STYD, code DBON. The first character of the parameter code value contains the default.

Suppress Excess Supply

The use of order policy rules or the amendment of supplies and demands may result in excess supply being planned for a demand. (For example. for a sales order of 80 where the minimum order quantity is 100, an excess supply of 20 will be planned). This flag controls the display of exception messages when excess supplies are planned.

Use this checkbox as follows:

Unchecked - To display excess supply messages

When an excess supply is planned by MPS, a demand record with a status of **ES** (excess supply) is written with the excess quantity.

Checked - To suppress the display of excess supply messages

The default value is obtained from the Parameter file, type STYD, code SESM. The first character of the parameter code value contains the default.

The parameter can be set on for both manufactured and purchased items.

Default Order Level

Enter one of the following:

0 - Style

1 - Style/Colour

2 - Full Product

You can use the prompt facility on this field to select from the WORL Production Works Order Level pop-up.

This field defaults from the company profile.

Press Enter to save your entries and return to the Production Details window.

Variable Batch Order Quantities Pop-up

To display this pop-up, select **Var Qtys (F23)** on the Production Details window.

Use this pop-up to define the variable batch sizes.

Fields

Style

This field displays the selected style.

Rounding

Select one of the following:

Rounding Up (0) - To round up the required supply quantity to the nearest batch quantity

Rounding Down (1) - To round down the required supply quantity to the nearest quantity

Quantities

Enter up to 10 quantities to define the variable batch sizes. The quantities must be positive and in ascending sequence and at least two quantities must be entered.

Functions

Delete (F11)

Use this to delete the batch quantities. A confirmation pop-up is displayed. Select **Delete (F11)** to confirm the deletion. This function is only available when variable batch quantities already exist for the style.

Select **Update (F8)** to save the details and return to the Production Details window.

Full Product Details [2/P1M]

Use this task to define production details for styles and costing details for materials for a particular style, route and cost set.

Production Details

Production details relating to maintainable styles are:

- Major sequence
- This field groups items together, to plan and schedule them together.
- Minor sequence
- This field determines the sequence in which machines process items.

You can amend these fields and view the effect on planning functions. You can also amend them to set minor production sequences within a major sequence for individual variants of a style.

Costing Details

You can maintain the following costing details:

- Material cost
- User cost elements 1-4

These costs relate specifically to materials. Style assigns material costs automatically to the correct cost element, depending on whether the material is a fabric, trim or packaging.

Note: Take care not to overwrite landed costs when entering user-defined costs, if you have transferred landed costs from Style Inventory Management via the Purchased Items Re-cost function.

Maintain Production Details at Full Product Window

To display this window, select the Full Product Details task.

Use this window to enter production and material costing details for a specific style, route and cost set.

Fields

Style/Material Group

If you are maintaining production details, enter a style, but if you are maintaining costing details, enter a material.

You can use the prompt facility on this field to select from the Item Master Scan pop-up.

Route

Enter a route for the style or material.

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

Cost Set

Enter a cost set.

Alternatively, use the prompt facility to select from the Cost Set Selection pop-up.

Leave this field blank for standard costs.

Major Sequence

Enter a major sequence code.

Minor Sequence

Enter a minor sequence code to indicate the forecast group in which this item will be included. You can enter up to three characters. You can use this to group certain styles together and produce very specific forecasts.

Material Cost

Enter the cost of the materials.

Note: You can use the following four fields to enter user-defined costs.

User 1

Enter a user-defined cost element.

User 2

Enter a user-defined [cost](#) element.

User 3

Enter a user-defined [cost](#) element.

User 4

Enter a user-defined [cost](#) element.

Maintain

Use this field to specify whether to maintain individual [style](#) [variants](#).

Use these checkboxes as follows:

Unchecked - Not to maintain individual [style](#) [variants](#)

In this case, you cannot change default values for individual [style](#) [variants](#).

Checked - To maintain individual [style](#) [variants](#)

In this case, you can use the [style matrix](#) to change the default value for individual [style](#) [variants](#).

Default Rule

Use the default rule to determine how the default value is used.

Select one of the following:

All (0) -To set all items, with no [costs](#), to these default values

Zero/Blank only (1) - To set all [variants](#) to the default value, whether they are currently valued or not

Press Enter to save the entries and display the Material Cost pop-up.

Material Cost Pop-up

To display this window, **check** the Maintain field against a default and then press Enter on the Maintain Production Details at Full Product window.

You can use this window to enter the material [cost](#) for each [variant](#) of the [style](#).

<u>**Fields**</u>

Cost (Untitled)

You can enter the material [cost](#) for each individual [variant](#) of the [style](#).

Press Enter twice to confirm the [cost](#). You may move through several Material Cost pop-ups for each [variant](#).

Maintain Order Policy Overrides [3/P1M]

This task allows the selection of one or more SKUs from a style and the maintenance of order policy rules for those SKUs selected. This will allow you to have different rules for each colour or SKU.

Maintain Order Policy Overrides Selection Window

To display this window, select the Maintain Order Policy Overrides task.

Use this window to select one or more SKUs to maintain.

Fields

Style

Enter the required style.

Alternatively, use the prompt facility to select from the Item Master Scan pop-up.

Press Enter to display the Multiple Item Selection pop-up.

Multiple Item Selection Pop-up

To display this pop-up, select a style and then press Enter on the Maintain Order Policy Overrides Selection window.

Use this window to select one or more SKUs to maintain.

Fields

Select (Untitled)

Enter **1** against each SKU you want to select.

Note: Selecting multiple SKUs allows the individual SKUs to be processed in sequence.

Press Enter to display the Order Policy window.

Order Policy Window

To display this window, select a SKU or multiple SKUs and then press Enter on the Multiple Item Selection pop-up.

Fields

For a description of the fields, please refer to the Production Details Window section.

When you maintain a style, the software ensures that individual SKU level planning parameters, which were previously changed, are not overlaid during style update in batch.

Select **Update (F8)** to update the values.

Critical Resource [20/P1M]

If you want to use sourcing rule 1 (Critical Resource) within a multi-plant MPS run, critical resources are mandatory.

A critical resource is an activity, labour or machine duration. You can define it in any appropriate unit of measure.

You can define the capacity at one of the following levels:

1 Default standard capacity

2 Default capacity profile

3 Daily capacity profiles, one per day of the week

You can record a tolerance percentage to overload the total capacity for a single order.

Note: The use of standard, default profile and daily profiles works in the same way for critical resources as it does for the definition of capacity for machines.

Critical Resources Maintenance Selection Window

To display this window, select the Critical Resource task.

Use this window to enter the resource code to create or maintain.

Fields

Resource Code

Enter a resource code, using up to two alphanumeric characters.

Alternatively, use the prompt facility to select from the Select Resource Code pop-up.

Based On Code

If you want to copy the details from an existing resource code, enter the code here.

Alternatively, use the prompt facility to select from the Select Resource Code pop-up.

Leave this field blank if you do not want to copy a code.

Press Enter to display the Critical Resources Maintenance Details window.

Critical Resources Maintenance Details Window

To display this window, enter a resource code and then press Enter on the Critical Resources Maintenance Selection window.

Use this window to add or amend the critical resource details.

Fields

Description

You must enter a description of the critical resource.

Capacity Basis Code

You must enter a capacity basis code. This is used to differentiate between different types of resource, for example, time, units, space or cost.

Alternatively, use the prompt facility to select from the CBCD Capacity Basis Code pop-up.

Standard Capacity

Enter the standard capacity available per working day for the resource.

Capacity UOM

Enter the unit of measure for the standard capacity.

Alternatively, use the prompt facility to select from the UNIT Unit Descriptions pop-up.

Tolerance Percentage

The MPS run uses the tolerance percentage to allow you to overload the resource, if an order exceeds the available capacity by less than the value entered here.

The tolerance percentage is only used by MPS. It does not change the standard available capacity.

Profile Code (Default)

You can enter a default profile, instead of entering a standard capacity in the Standard Capacity field.

Alternatively, use the prompt facility to select from the PCOD Capacity Profile Code pop-up.

Functions

Daily Capacity (F20)

Use this to display the Daily Capacity pop-up.

Press Enter to save the details and return to the Critical Resources Maintenance Selection window.

Daily Capacity Pop-up

To display this pop-up, select **Daily Capacity (F20)** on the Critical Resources Maintenance Details window.

Use this pop-up to define different capacity profiles for each day of the week.

Fields

Profile Code

You can enter a default profile code, to use on the days where you have not entered a specific code.

Alternatively, you can enter specific codes for each day of the week.

Note: You must define these codes in the Resource Capacity Profiles task.

Select **Update (F8)** to update the data and return to the Critical Resources Maintenance Details window.

Resource Capacity Profiles [21/P1M]

You can use this task to set up resource capacity profiles, which are very flexible when defining capacities of critical resources.

Resource Capacity Profiles Maintenance Selection Window

To display this window, select the Resource Capacity Profiles task.

Use this window to enter a capacity profile code to create or maintain.

Fields

Profile Code

Enter a profile code to create or maintain, using up to two alphanumeric characters.

Alternatively, use the prompt facility to select from the PCOD Capacity Profile Code pop-up.

Based On Profile

If you want to copy the details from an existing profile, enter the code here.

Alternatively, use the prompt facility to select from the PCOD Capacity Profile Code pop-up.

Leave this field blank if you do not want to copy a profile.

Functions

Add (F8)

Use this to add a new profile.

Enter a new profile code and then select **Add (F8)** or enter an existing profile code and then press Enter to display the Resource Capacity Profiles Maintenance Details window.

Resource Capacity Profiles Maintenance Details Window

To display this window, enter a new profile code and then select **Add (F8)**, or enter an existing code and then press Enter on the Resource Capacity Profiles Maintenance Selection window.

Fields

Description

Enter or amend the description for the resource profile.

Effective From Date

Enter or select the date from which this capacity default is effective.

Effective To Date

Enter or select the date up to which this capacity default is effective.

Capacity

Enter the daily capacity of the profile during the effective date period.

Comment

You can add extra text and information if you wish.

Options

Delete

Use this against a line to delete it.

Select **Update (F8)** to save the profile and leave the task.

Cost Centres [30/P1M]

Use this task to create and maintain cost centres.

You can use cost centres to define standard and current costs for the following:

- Set-up labour time
- Enter rates as a cost per hour.
- Run labour time
- Enter rates as a cost per hour.
- Run machine time
- Enter rates as a cost per hour.
- Overheads
- You can define up to two separate overhead costs, overhead 1 and overhead 2, based on an hourly rate or value or fixed charge for overhead 2. You can choose from six different recovery methods, based on operation time or cost, and four methods based on material quantity.

Note: You can overwrite cost centre rates for individual operators by setting up labour skill rates in the Labour Skills task.

Machines

You can assign a cost centre to any number of machines.

You link each operation to a machine, and cost centres define the cost rates applicable at particular points in the production process. This structure enables you to develop style unit costs, and to record actual costs in production.

Assigning a cost centre to a machine is optional. However, if you wish to derive any costs at the operation other than material costs, subcontract and user-defined costs, a cost centre is mandatory.

Departments

You can link cost centres to departments for performance analysis.

Material Costs

Cost centre definitions do not influence material costs.

Production Costs

Production costs rely on the accurate determination of the following:

- Labour time
- Machine time
- Overheads

Labour Time

Labour time comprises set up time and run time. Team sizes influence labour times for costing purposes.

Standard Operation Labour Time

Op.	Set-up Hours (A)	Set-up Team Size (B)	Set-up Total Time (A*B)	Run Hours (C)	Run Team Size (D)	Run Total Time (C*D)	Labour Time (A*B)+(C*D)
10	1	2	2	2	3	6	8
20	1	3	3	1	4	4	7
30	1	4	4	2	5	10	14
Totals:	**3**		**9**	**5**		**20**	**29**

For example, if the operation machine duration is 8 hours, but this requires 12 full time operators, the cost is not simply 8 hours operator time but 8 x 12 hours operator time.

Machine Time

Machine time is run time only.

Standard Operation Machine Time

Op.	Run Hours (C)	Run Time (C*D)	Machine Time (A*B)+(C*D)
10	2	2	2
20	1.5	1.5	1.5
30	2	2	2
Totals:	**5.5**	**5.5**	**5.5**

Machine time is simply the amount of time a machine is in use.

Standard Operation Costs

Set-up Hourly Rate = 3.78 per hour

Run Labour Hourly Rate = 4.5 per hour

Run Machine Hourly Rate = 5.45 per hour

Op.	Labour Time	Cost	Run Labour Time	Cost	Run Machine Time	Cost	Total Cost
10	2.0000	7.5600	6.0000	27.0000	2.0000	10.9000	45.4600
20	1.5000	5.6700	6.0000	27.0000	1.5000	8.1750	40.8450
30	2.0000	7.5600	12.8275	57.7238	2.5600	13.9520	79.2358
Totals:	**5.5000**	**20.7900**	**24.8275**	**111.7238**	**6.0600**	**33.0270**	**165.5408**

Combined, this gives the total cost of the operation, with a total labour cost you can extract, if required.

Overheads

Overheads are slightly different. You can base them on the following:

- Percentage of machine or labour or total cost
- Rate per machine or labour time
- Fixed cost

You can set these overheads against standard and current costs.

Overhead Reference Data

Op.	Labour Time	Labour Cost	MachineTime	Machine Cost	Total Time	Total Cost
10	8.0000	34.5600	2.0000	10.9000	10.0000	45.4600
20	7.5000	32.6700	1.5000	8.1750	9.0000	40.8450
30	14.8275	65.2838	2.5600	13.9520	17.3875	79.2358
Totals:	**30.3275**	**132.5138**	**6.0600**	**33.0270**	**36.3875**	**165.5408**

Time/Cost Overhead Recovery Methods

A: % OF Machine Costs	B: % of Labour Costs	C: Rate x Machine Time	D: Rate x Labour Time	E: % of Total Costs	F: Rate x Total Time	Fixed
10.00%	10.00%	£2.45	£5.67	10.00%	£2.11	£9.00
1.09	3.46	4.90	45.36	4.55	21.10	9.00
0.82	3.27	3.68	42.53	4.08	18.99	9.00
1.40	6.53	6.27	84.07	7.92	36.69	9.00
3.31	**13.28**	**14.85**	**171.96**	**16.55**	**76.78**	**27.00**

There are several additional rates that may have specialist uses based on fabric, trim and packaging costs.

You enter all cost components into the style cost elements at operational level:

- Fabric
- Trim
- Packaging
- Labour via cost centre
- Machine via cost centre
- Set up via cost centre
- Subcontract
- Variable overhead 1 via cost centre
- *Variable overhead 2 via cost centre
- *Fixed overhead via cost centre

(* Mutually exclusive)

The entry of cost centre rates and recovery methods therefore provides a vital input to the costing process.

Cost Centre Maintenance Selection Window

To display this window, select the Cost Centres task.

Use this window to enter the cost centre to create or maintain.

Fields

Cost Centre

Enter the cost centre to create or maintain, using up to a maximum of five alphanumeric characters.

Alternatively, use the prompt facility to select from the Select Cost Centre pop-up.

Base on Cost Centre

If you want to copy the details from an existing cost centre, enter the code here.

Alternatively, use the prompt facility to select from the Select Cost Centre pop-up.

Leave this field blank if you do not want to copy a cost centre.

Press Enter to display the Cost Centre Maintenance Details window.

Cost Centre Maintenance Details Window

To display this window, enter or select a cost centre and then press Enter on the Cost Centre Maintenance Selection window.

Fields

Cost Centre

This field displays the cost centre, as entered on the Cost Centre Maintenance Selection window.

Description

Enter or amend the description for the cost centre.

Department

The department is an analysis group for cost centres. The department can represent a functional department, a production line, or a site.

Department codes are held in the Parameter file under major type DEPT.

You can use the prompt facility on this field to select from the DEPT Department pop-up.

Note: In the following fields, you can enter both a standard cost and a current cost.

Machine Rate/Hr

Enter the hourly cost rate for running machines at this cost centre.

Labour Rate/Hr

Enter the hourly labour charge rate for this cost centre.

Setting Rate/Hr

Enter the hourly labour rate for setting up machines in this cost centre.

O/H 1 Method

There are many variable overhead recovery methods.

Enter one of the following:

A - % of machine cost

B - % of labour cost, that is, set up plus run labour

C - Cost rate/hour x machine run time

D - Cost rate/hour x (set up + run labour time)

E - % of total cost (set up + run labour + machine)

F - Cost rate/hour x (set up + run labour time + machine time)

I - Cost rate per material unit

J - % of total material value

K - Cost rate per trim and packing unit

L - % of total trim and packing value

X - % of subcontract cost

Y - % of subcontract + fabric cost

Z - % of trim + packaging + subcontract cost

You can use the prompt facility on this field to select from the OHDC Variable O/H Recovery Methods pop-up.

Note: For methods I and K, the rate is applied to the number of units specified in the Quantity Per field on the style route definition; irrespective of the actual material quantity required. This method is not normally used with real material items, but to pick up special costs such as utility charges.

O/H 1 Rate/%

Enter a rate or percentage, depending on the recovery method you have entered.

O/H 2 Method

Enter a method, as described above in O/H 1 Method.

You can use the prompt facility on this field to select from the OHDC Variable O/H Recovery Methods pop-up.

O/H 2 Rate/%

Enter a rate or percentage, depending on the recovery method you have entered.

O/H 2 Value

Note: This field is only used with Overhead 2.

Enter a fixed overhead recovery method. This value does not vary with production volumes or time expended; it is spread over the costing route batch size when generating style unit costs.

Functions

Text (F21)

Use this to add additional text about the cost centre.

Press Enter to save the cost centre information and return to the Cost Centre Maintenance Selection window.

Calendars [31/P1M]

Use this task to set up or maintain a production calendar. The calendar is used to establish operation schedules and material requirement dates.

Note: It is advisable to define calendars well in advance, so that you do not disrupt the planning process in a future period.

You can:

- Identify working and non-working week days
- Specify holidays and shutdown periods
- Incorporate effectivity and year start dates

Note: You can define a number of calendars for different working profiles.

Calendar Maintenance Selection Window

To display this window, select the Calendars task.

Use this window to create or maintain a production calendar.

A list of existing calendars is displayed.

Fields

Calendar Code

If you are creating a new calendar, enter a unique two-character alphanumeric code.

Note: You can use the same code to produce consecutive calendars in different years.

Year

Enter the last two digits of the year for which you are creating the calendar.

Based On Calendar

If you want to use an existing calendar as a template for a new calendar, enter the calendar code to copy.

Options

Select

Use this to maintain a calendar.

Delete

Use this to delete a calendar.

Print

Use this to print a calendar.

Select a calendar or enter a calendar code and then press Enter to display the Calendar Maintenance Details window.

Calendar Maintenance Details Window

To display this window, select a calendar or enter a calendar code and then press Enter on the Calendar Maintenance Selection window.

Use this window to specify holidays and shutdown periods which affect the whole company.

The standard week displayed is the default working week template as defined in the company profile.

Fields

Start Date

Enter or select the start date for this calendar. This must be a Monday.

Note: Calendars may start at any point during the year. You can define several calendars for one year, all with different start dates.

Holidays From

Enter or select the start date for any holiday or shutdown period.

To

Enter or select the end date for any holiday or shutdown period.

*Note: If you copy an existing calendar, you must select **Maintain Week Templates (F18)**, even if you do not need to change the templates.*

Select **Maintain Week Templates (F18**) to display the Calendar Maintenance Week Templates window.

Calendar Maintenance Week Templates Window

To display this window, select **Maintain Week Templates (F18)** on the Calendar Maintenance Details window.

You can use this window to enter up to five alternative weekly templates for a calendar.

The template overrides the default template for specified periods of the year.

For example, you can:

- Plan for Saturday working during a peak season
- Create a calendar for a specific machine or work centre, which needs to operate a different working week from the rest of the factory

Fields

Start Date

Enter or select the start date of this calendar. The date must be a Monday, but it can be at any point during the year.

Monday/Tuesday/Wednesday/Thursday/Friday/Saturday/Sunday

Enter the working pattern for the week.

Use these checkboxes as follows:

Unchecked - To indicate a working day

Checked - To indicate a non-working day

From Date

Enter or select the start date of the corresponding week template. This must be a Monday.

To Date

Enter or select the end date of the corresponding week template. This must be a Sunday.

Select **Update Week Templates (F8)** to save the new templates and return to the Calendar Maintenance Details window.

Shift Profiles [32/P1M]

A shift profile defines the pattern of shifts in a single day. The profile defines shift start and finish times. You can also specify effectivity dates for the profile.

Shift profiles provide the information required to calculate time availability and duration times for scheduling and capacity planning.

You can attach shift profiles to:

- Machines
- Labour profiles
- Teams

Shift Profile Maintenance Selection Window

To display this window, select the Shift Profiles task.

Use this window to create or maintain shift profiles.

Note: You can also use the Maintain Parameter File task to create shift profiles, but you have to add start and end times and effectivity dates here.

Fields

Shift Profile Code

Enter a shift profile code.

Alternatively, use the prompt facility to select from the Shift Profile Code pop-up.

If you are creating a new shift profile, enter up to two numeric characters.

If you have already defined the code in the Maintain Parameter File task, a warning message is displayed. You can enter further details here.

Shift profiles are defined in the Parameter file under major type CSHF.

Based on Profile

If you want to base a shift profile on an existing profile, enter the code of the existing profile here. You can then amend the details.

Alternatively, use the prompt facility to select from the Shift Profile Code pop-up.

Leave this field blank to create a completely new profile or to maintain an existing profile.

Press Enter to display the Shift Profile Maintenance Details window.

Shift Profile Maintenance Details Window

To display this window, press Enter on the Shift Profile Maintenance Selection window.

Use this window to enter start and finish times and effectivity dates for shift profiles.

Fields

Description

Enter or amend the description for this profile.

No.

Enter a unique number to identify each shift. You must order each shift in time sequence.

Start Time

Enter the shift start time. Do not include any punctuation.

Finish Time

Enter the shift finish time. Do not include any punctuation.

Effective From Date

Enter or select the date on which this shift becomes effective.

Effective To Date

Enter or select the date up to which this shift is effective.

Note: Shifts cannot overlap.

Comment

You can enter any extra details about the shift in this field.

Options

Delete

Use this against any shift you want to delete.

Select **Update (F8)** to save the shift profile and return to the Shift Profile Maintenance Selection window.

Departments [33/P1M]

A department consists of various labour skills grouped together to analyse capacity requirements and average performance.

Department Maintenance Selection Window

To display this window, select the Departments task.

Use this window to create or amend department information.

<u>Fields</u>

Department

Enter an existing department to maintain.

Alternatively, use the prompt facility to select from the DEPT Department pop-up.

You can enter a new code, using up to six alphanumeric characters.

Press Enter to display the Department Maintenance Details window.

Department Maintenance Details Window

To display this window, press Enter on the Department Maintenance Selection window.

Use this window to enter details for each department.

<u>Fields</u>

Description

Enter or amend the description for the department.

Organisation Model

Enter the organisation model for this department.

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

Absenteeism Rate

Enter a percentage which can be used to reduce the expected capacity of the department, due to absentee operators. This effectively reduces the standard hours per day.

Utilisation %

Enter a percentage that represents the hours per day available from the department.

Average Performance

This is the average performance of the department, entered as a percentage.

Standard Hours/Day

Enter the standard number of hours per day available from the department, before the above factors are taken into account.

Press Enter to save the details and return to the Department Maintenance Selection window.

Machines [34/P1M]

Use this task to create and maintain machines. Each machine definition can represent one machine or a number of machines of the same type.

The information that you enter about machines is used to ascertain:

- Product costs
- Capacity requirements
- Scheduled dates for production
- Actual production costs

Links

A machine is the lowest level of hard resource. You can link a machine to one or more of the following:

- Organisational model
- This is mandatory.
- Production calendar
- You can define a specific calendar for a machine.
- Department
- You can group machines into departments for performance analysis.
- Shift profile
- You can define the days, and number of hours per day, that a machine is available for work.
- Cost centre
- You can define the cost rates incurred by work carried out at the machine. If you do not specify a cost centre, only material, subcontract and user-defined costs are calculated.

Prerequisites

Before you can create a machine, you must have already defined:

- A department, using the Departments task
- An organisational model, using the Organisational Models task
- A WIP location, in the Inventory company profile
- A floorstock location, in the Inventory company profile
- This can be the same as the WIP location.
- A cost centre, using the Cost Centres task
- To generate costs for each machine, you must enter a cost centre.

Machine Maintenance Selection Window

To display this window, select the Machines task.

Use this window to enter the machine to create or maintain.

Fields

Machine

Enter an existing machine code to maintain or enter a new unique machine code, using up to six alphanumeric characters.

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

Based On Machine

If you want to copy an existing machine, enter the code here. You can amend the details for the new machine.

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

Leave this field blank to maintain an existing machine, or to create a completely new machine.

Press Enter to display the Machine Maintenance Details window.

Machine Maintenance Details Window

To display this window, press Enter on the Machine Maintenance Selection window.

Use this window to enter the details of the machine.

Fields

Description

Enter or amend the description for the machine or resource.

Calendar Code

Enter a calendar code. The calendar is used to schedule all work routed through this machine.

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

If you leave this field blank, the default calendar, held in the company profile, is used.

Org. Model

Enter the organisational model associated with the machine.

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

Note: You must attach all operations on a route to a single organisational model.

WIP Location

Enter the work in progress location for this machine. It must be defined to Inventory. You must enter a WIP stockroom so that WIP Inventory can be tracked.

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

Department

You must enter a department code. It represents a functional or organisational grouping for this machine.

Alternatively, use the prompt facility to select from the DEPT Department pop-up.

You can use the department to for additional analysis and reporting of machine activity. You book production order, actual labour and machine times to a department.

Department codes are held in the Parameter file under major type DEPT and further details are set up via the Departments task.

Foreman

Enter the supervisor responsible for this machine. This is for memo purposes only.

Floor Stock Location

You must enter a floor stock location for this machine. This must be a stockroom defined to Inventory.

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

Materials with a movement type policy of **3** (Issue to Floor Stock) are initially issued or reserved to this location. Production order or operator booking will then consume the quantities at the appropriate time.

Note: You can enter the same WIP location and floor stock location.

Queue Time

Enter the average queue time, in hours, for this machine.

The value is used when calculating operation start and finish dates. It represents an element of inter-operational transit time. WIP time increases to allow for this additional production time.

Std. Efficiency %

Enter the expected efficiency for the machine.

To indicate 100% efficiency, leave this field blank.

To indicate any under-efficiency, enter a value between 1 and 99.

To indicate over-efficiency, enter a value between 101 and 999.

Machine Load Reviews can apply this factor to standard capacity when making comparisons with scheduled loads, depending on the review capacity basis you choose in enquiries.

If you want to compare standard efficiency with standard effective capacity, the software calculates standard effective capacity as:

standard capacity x standard efficiency factor

The software uses unmodified standard capacity details for comparison with standard capacity.

Note: This factor is not included in cost calculations for styles made on this machine. If machine efficiency has significant impact on cost, you should account for it in the overhead rates associated with this particular machine and defined on the linked cost centre.

Max Length

These are the maximum daily shift lengths. Enter up to three theoretical maximum shift lengths. These can all be different. If you do not enter a maximum length, the software defaults to one shift of eight hours duration.

Std Length

Enter up to three standard expected daily shift lengths, which can all be different. If you do not enter a shift length, the software defaults to the maximum shift length, if defined, or to one shift of eight hours.

The expected shift length determines the length of the working day for scheduling calculations and therefore is a factor in determining lead time.

This value represents the effective working day length and is the basis of all operational planning.

Max Capacity

Maximum capacity per shift indicates the theoretical maximum number of output hours generated by this machine.

Note: This is different from the maximum daily shift length in that this machine may represent multiple production resources, for example, a group of machines.

You can also use this field to indicate available working time including overtime and weekends, over and above the standard shift. It indicates how much extra machine capacity is available to meet the load.

You can define a maximum capacity for each shift, or a total daily capacity for the machine. If you leave this field blank, the software defaults to the maximum shift length, if defined, or if not, to one shift of eight hours.

Std Capacity

This is the standard capacity per shift. Enter the standard hours that could be output by this machine.

Note: This is different to the standard daily shift length in that this machine may represent multiple production resources, for example, a group of machines.

Use this when comparing standard or standard effective capacity with the scheduled load to identify capacity imbalances. You can define a standard capacity for each shift, or a total daily capacity for the machine. If you leave this field blank, the software defaults to a shift length, if defined, or to one shift of eight hours.

Duration Calculation Basis (Default)

This field identifies the default machine duration basis code, which is used in the calculation of operation lead time.

The calculation uses combinations of the set-up labour, run labour and run machine times defined at each operation. Use the longest time element, or critical path activity, on the operation to determine the lead time.

You set the duration basis codes at the following levels:

- Operation
- You can allocate a code at each operation. If the machine default does not exist, use the one held in the company profile.
- Machine default
- You can enter a default code against each machine definition. This will override the company profile default. The software prompts this first on all operations using the machine.
- Company profile (default)
- This will be the default code used if not overridden elsewhere.

Enter one of the following:

0 - Set-up labour

1 - Set-up labour + run machine

2 - Set-up labour + run labour

3 - Set-up labour + run labour + run machine

4 - Set-up labour + (greater of run labour or run machine)

Leave this field blank to use the company profile default.

You define these codes in the Parameter file, under major type DUCT.

You can use the prompt facility on this field to select from the DUCT Operation Duration Calc. Basis pop-up.

Shift Profile (Default)

Enter a shift profile, for the software to use the shift pattern associated with this profile on any day where it cannot find a specific shift pattern.

Alternatively, use the prompt facility to select from the Shift Profile Codes pop-up.

If you do not enter a shift profile, and there is no default, the total of the three shift lengths entered above is the number of hours available in a day.

*Note: If you leave this field blank, and use **Profile (F20)** to create a shift/capacity profile, the software displays that default profile; likewise, any standard and maximum capacity factors defined are also displayed.*

Default Shift Profile Capacity Factor

Max

Enter a default shift profile maximum capacity factor; that is, the number of physical machines available. The software multiplies the total number of hours defined on the default profile by this factor to give the maximum capacity for the shifts.

Std

Enter a default shift profile standard capacity factor. The software multiplies the total number of hours defined on the default profile by this factor to give the standard capacity for the shifts.

Cost Centre

Enter a cost centre to provide cost rates for work carried out at this machine. Machine, labour, set up and overhead rates defined in the nominated cost centre are used to create actual and standard costs for styles produced at this machine.

Alternatively, you calculate actual costs by booking work by operator or team.

You can use the prompt facility on this field to select from the Select Cost Centre pop-up.

Note: You must leave this field blank if you are defining a machine for use on subcontract operations.

<u>Functions</u>

Profile (F20)

Use this to display the Shift/Capacity Profile Maintenance pop-up.

Text (F21)

Use this to display the Text pop-up.

Accept Blank Cost Centre (F22)

This is only available if you leave the Cost Centre field blank. Use it to confirm that you do not want to enter a cost centre.

Select **Update (F8)** to save the details and return to the Machine Maintenance Selection window.

Shift/Capacity Profile Maintenance Pop-up

To display this window, select **Profile (F20)** on the Machine Maintenance Details window.

You can create a shift profile to define the shift patterns of a particular day, or even a work area. Use this pop-up to specify which shift profile to use for each day of the week for this machine.

The Capacity Factor fields, when multiplied by the total number of hours on the related shift profile, give the maximum and standard capacities for the machine on any given day.

<u>Fields</u>

Shift Profile

Enter the shift profile to define the shift patterns of each day.

Maximum Capacity Factor

The maximum capacity factor and the total number of hours defined in the related shift profile are multiplied to give the maximum capacity for a machine for that particular day.

For example, if the maximum capacity is three machines working instead of the standard two, enter **3** in this field.

Standard Capacity Factor

The number you enter in this field is multiplied by the total number of hours defined in the related shift profile, which will be either the profile for the same day, or the default profile. The result is the standard capacity for this machine for that particular day.

For example, if the standard capacity is two machines working, enter **2** in this field.

Select **Update (F8)** to save the details and return to the Machine Maintenance Details window.

Work Centres [35/P1M]

Use this task to group machines together for capacity loading analysis. A machine can be part of more than one work centre.

If you link a series of machines to a work centre, you can:

- Consolidate the loading and individual rated capacity of the machines at work centre level
- Assess the capacity requirements in summary

By changing the definition of the work centre, you can quickly perform What-If analyses of capacity adjustments and load spreading.

Capacity planning performs its loading calculations at individual machine level. Therefore, you can modify the work centre without having to regenerate the capacity plan.

Example

Consider a factory with four sets of machines used for the following purposes:

- Machine 1 - Body/sleeve sewing
- Machine 2 - Collar/cuff sewing
- Machine 3 - Body/sleeve knitting
- Machine 4 - Collar/cuff knitting

To aid planning, you could define the following work centres:

- Work Centre A - All machines, comprising machines 1, 2, 3, 4
- Work Centre B - All body/sleeve, comprising machines 1, 3
- Work Centre C - All collar/cuff, comprising machines 2, 4
- Work Centre D - All sewing, comprising machines 1, 2
- Work Centre E - All knitting, comprising machines 3, 4

After review, you can then allocate individual machines to different types of work to balance the load.

Note: You must have already set up machines using the Machines task.

Work Centre Maintenance Selection Window

To display this window, select the Work Centres task.

Fields

Work Centre

Enter a work centre to create or maintain.

Alternatively, use the prompt facility to select from the Select Work Centre pop-up.

If you are entering a new work centre, enter a unique code of up to five alphanumeric characters.

Based on Work Centre

If you want to base a new work centre on an existing work centre, enter the existing work centre in this field.

Alternatively, use the prompt facility to select from the Select Work Centre pop-up.

Leave this field blank to maintain a work centre or create a completely new one.

Press Enter to display the Work Centre Maintenance Details window.

Work Centre Maintenance Details Window

To display this window, press Enter on the Work Centre Maintenance Selection window.

Use this window to specify the details of the work centre.

Fields

Description

Enter or amend the description for the work centre.

Machine

Enter the machines you want to group together.

You can use the prompt facility on this field to select from the Select Machine pop-up.

Note: If you group together machines linked to more than one department, a warning message is displayed. To book work by work centre rather than machine, you must assign all machines in the work centre to the same WIP location.

Select **Update (F8)** to save the details and return to the Work Centre Maintenance Selection window.

Bundle Ticket Types [36/P1M]

Use bundle tickets to track work-in-process along the production route. If you define a route for which parallel processing of operations is a prerequisite, it means that bundle tickets are mandatory.

If you have set the Automatic Bundle Creation at Order Release field to **All Stages** on the Maintain Company Profile Further Production Order Options window, Style creates bundle tickets automatically.

Printing formats are user-defined and may include barcode labels or box end labels if required.

Note: The bundle ticket type entered at operation level must be consistent with the reporting level of the operation on the route.

Prerequisites

Before creating a bundle ticket type, ensure that you have done the following:

- You have set up the search family using search family codes.
- You have specified the bundle ticket document type using parameter BDTP in the Maintain Parameter File task.

Bundle Tickets

You can attach a bundle ticket to each bundle on a production order.

You can automatically print bundle tickets, for example, at order release, or you can print them manually.

The bundle ticket includes basic data such as:

- Production order number
- Style
- Bundle number
- Colour and size of garments in the bundle

Attached to the ticket is an operation stub for each operation performed on the bundle. This stub includes the following information:

- Operation sequence
- Description
- Barcode
- Standard minutes

You can also include a barcode on the stub for speed and accuracy of feedback.

You can create bundle tickets for different purposes, such as:

Bundles with Varying Quantities

When producing socks, you can issue different bundle ticket types for:

- Knitting (120 pieces per bundle)
- Dyeing (750 pieces per bundle)

- Finishing (240 pieces per bundle)

Dividing the Route into Sections

In a cut and sew environment, you issue a cutting instruction to a style. Depending on the mix of sizes and cloth widths, the actual quantities cut may vary from the instruction.

Therefore, you must base all the operations following the cut on the actual cut quantities and not the original order quantities.

Parallel Processing

When producing a shirt, you can simultaneously produce separate components on different machines.

You produce the fronts, backs, sleeves and cuffs separately and then gather them together at an assembly point. In this case:

- Attach a separate bundle ticket to each bundle of fronts (FRS), backs (BCK), sleeves (SLV) and cuffs (CUF).
- Schedule each operation associated with each group of bundles to run in parallel.
- Bring these operations together at a marry-up (MUP) point.

Note: To use parallel processing, you must check the Parallel Ticket Type field on the Maintain Bundle Ticket window.

Maintain Bundle Ticket Type Window

To display this window, select the Bundle Ticket Types task.

Use this window to enter the bundle ticket type to create or maintain.

Fields

Bundle Ticket Type

Enter an existing bundle ticket type or a unique code of up to three alphanumeric characters.

Alternatively, use the prompt facility to select from the Bundle Ticket Type Window pop-up.

Press Enter to display the Maintain Bundle Ticket window.

Maintain Bundle Ticket Window

To display this window, press Enter on the Maintain Bundle Ticket Type window.

Use this window to enter details about the bundle ticket type, including search family and document type.

Fields

Description

You must enter a bundle ticket description.

Search Family

You must enter a search family code. The search family specifies which dimensions determine mixing rules. For example, styles set up as colour only require colour only bundles.

You can use the prompt facility on this field to select from the Search Family Code Selection pop-up.

> **Caution:** When you link a bundle ticket, you link the ticket to an operation against a style. Therefore, the search family you enter here must match the search family set up for the style via the Styles task.

Bundle Quantity

You must enter the standard bundle quantity for the bundle ticket. This is used as a default when using the automatic bundle creation method.

UOM

You must enter the bundle ticket unit of measure for the default bundle quantity.

UOM codes are defined in the Inventory Descriptions file, under type UNIT.

You can use the prompt facility on this field to select from the UNIT Unit Descriptions pop-up.

Bundle Quantity Variance

Enter the maximum difference in quantity that you will allow, above or below the bundle quantity. This quantity determines the minimum and maximum quantities allowed on the final bundle operation when automatically creating bundles.

Note: Bundle quantity variance is only used on the final bundle created and is only used then if the Final Bundle Policy field for the bundle ticket type is set to 0 (Bundle Quantity). Bundle quantity variance must always be less than half of the bundle quantity.

Final Bundle Policy

This determines the quantity of the final bundle on an order when automatically creating bundles.

Enter one of the following:

0 - To change the last bundle by variance, or bundle quantity

1 - To use the quantity left after the last bundle, that is, remaining quantity

You define these codes in the Parameter file, under type FRBO.

You can use the prompt facility on this field to select from the FRBO Final Bundle Policy pop-up.

Here are some worked examples to illustrate the use of this field:

Example 1

Final Bundle Policy = 0 (Bundle Quantity)

Production Order Quantity = 64 pieces

Bundle Quantity = 12 pieces

Bundle Quantity Variance = 0 pieces.

The software will create 6 bundles of 12 pieces.

Example 2

Final Bundle Policy = 0 (Bundle Quantity)

Production Order Quantity = 64 pieces

Bundle Quantity = 12 pieces

Bundle Quantity Variance = 5 pieces

The software will create 4 bundles of 12 pieces and 1 bundle of 16 pieces.

Example 3

Final Bundle Policy = 1 (Remaining Quantity)

Production Order Quantity = 64 pieces

Bundle Quantity = 12 pieces

Bundle Quantity Variance = 0 pieces

The software will create 5 bundles of 12 pieces and 1 bundle of 4 pieces.

Document Type

You must enter the format of the bundle ticket.

The document types are defined on the parameter file, against major type BDTP.

You can use the prompt facility on this field to select from the BDTP Bundle Ticket Document Type pop-up.

Ticket for Finished Goods Receipt

Use this to specify whether a bar-coded stub will be printed on the bundle ticket, to use when receiving styles into finished stock.

Use this checkbox as follows:

Unchecked (default) - Not to print a stub

Checked - To print a stub

Finished Goods-Default Bundle Qty

Use this to specify whether the bar-coded stub printed on the bundle ticket for the finished goods receipt uses the bundle quantity as the default or not.

Use this checkbox as follows:

Unchecked (default) - Not to use the bundle quantity by default

Checked - To use the bundle quantity by default

Barcodes on Ticket

Use this to define whether a barcode should be included on the operation stub of the bundle ticket. This is a unique identifier for the stub - bundle number/operation sequence. The numeric version is always printed.

Use this checkbox as follows:

Unchecked (default) - Not to print a barcode

Checked - To print the barcode

No of Labels per Bundle

Enter the number of bar-coded box end labels printed for each bundle. This is for memo purposes only.

Material Cost %

You can optionally enter a percentage for the material cost.

Operation Level Cost %

You can optionally enter a percentage for the operational level cost.

Parallel Ticket Type

Use this to specify whether you want the bundle ticket processed in parallel with another bundle ticket.

Use this checkbox as follows:

Unchecked (default) - Not to allow parallel processing

Checked - To allow parallel processing

For example, the knitwear industry uses parallel processing to knit materials (front, back, sleeves and collar) for a garment. Each material is knitted on a different set of machines and can be ready for making up at the same time. To use parallel processing, allocate different bundle ticket types to the front, back, sleeves and collar.

The make up point is the focal point. You can back schedule preceding operations from the make up point. You schedule forward the operations that follow, from the make up point.

If you **check** this field, one production order can control the whole process and schedule the operations in parallel.

Select **Characteristics Mix (F18)** to display the Characteristic Mix Rules pop-up.

Characteristic Mix Rules Pop-up

To display this window, select **Characteristics Mix (F18)** on the Maintain Bundle Ticket window.

Use this pop-up to define the dimensions you can combine in a single bundle. For example, you might want to mix colours only or sizes only, or colours and sizes.

Fields

Mix

This field determines mixing rules.

Leave this field blank if you do not mix characteristics of this dimension within a single bundle. To make a bundle single colour, leave a blank against Colour. To make a bundle single size, leave a blank against Size.

Enter **1** in this field to allow mixed characteristics of this dimension within a single bundle. To mix colours, enter **1** against Colour. To mix sizes, enter **1** against Size.

Caution: If you enter 1 against Colour, do not set the Reporting Level field to 1 for this route on Style Route Operation Details window.
If you enter 1 against Size, do not set the Reporting Level field to 2 for this route.

Press Enter to save the mix rules and return to the Maintain Bundle Ticket window.

Labour Skills [37/P1M]

Use this task to define the labour skills your company requires.

You can calculate loads at labour skill level.

You can override cost centre rates for individual labour skills by entering standard hourly rates of pay for use in costing.

A labour skill is the lowest level of soft resource. You can assign it directly one of the following:

Labour Profiles

A labour profile consists of the labour skills of a team of core skill members. By assigning a labour profile to an operation, you can determine how much time someone with that skill level needs to complete the work.

Note: You can also create labour skills via the Labour Profiles task.

Operators

To indicate an operator's specific skills, use the Operators task to assign a labour skill to an operator. You can assign more than one labour skill to an operator, but not in concurrent effectivity periods.

Labour Skill Maintenance Selection Window

To display this window, select the Labour Skills task.

Use this window to create or maintain labour skill definitions.

Fields

Labour Skill

Enter an existing code to maintain a labour skill or enter a unique code using up to two alphanumeric characters.

Alternatively, use the prompt facility to select from the Select Labour Skills pop-up.

Press Enter to display the Labour Skill Maintenance Details window.

Labour Skill Maintenance Details Window

To display this window, press Enter on the Labour Skill Maintenance Selection window.

Use this window to enter details for a labour skill.

<u>Fields</u>

Description

Enter or amend the description for the skill.

Start Date

Enter or select the date on which this skill becomes effective. The default is 0/00/00, which means that the skill is immediately effective.

End Date

Enter or select the last date on which this skill is effective. This must be later than the start date. The default is 99/99/99, which means that the skill has unlimited effectivity.

Select **Skill Rates (F20)** to display the Labour Skill Maintenance Rate window.

Labour Skill Maintenance Rates Window

To display this window, select **Skill Rates (F20)** on the Labour Skill Maintenance Details window.

Use this window to set up multiple pay rates for the labour skill. You can control these rates with effectivity dates. Only one rate is effective on a particular date.

Caution: Enter labour skill rates only if you want to override the cost centre rates.

<u>Fields</u>

Select

Select one of the following:

Select (2) - To display the Labour Skill Rate Maintenance pop-up

Delete (4) - To delete a labour skill rate

Note: You can maintain or delete multiple detail lines by using Select or Delete against several lines.

Press Enter to update the skill rates and return to the Labour Skill Maintenance Details window.

Labour Skill Rate Maintenance Pop-up

To display this pop-up, use Select in the Select field against a labour skill rate on the Labour Skill Maintenance Details window.

Use this pop-up to set up a labour skill rate for this labour skill.

<u>Fields</u>

Start Date

Enter or select the date on which this rate becomes effective. This date must be the same as or later than the previous rate end date on the list. It must also be in the effective date range of the labour skill.

The default is 00/00/00, which means that the rate is immediately effective.

End Date

Enter or select the last date on which this rate will be effective. It must be the same as, or before the effective start date for the next rate on the list. It must be in the effective date range of the labour skill.

The default is 99/99/99, which means that it is infinitely effective.

Standard Rate

Enter the hourly rate chargeable for the skill in the defined period.

Select **Update (F8)** to save the labour skill details and return to the Labour Skill Maintenance Details window.

Labour Profiles [38/P1M]

Use this task to create and maintain labour profiles. You can also define labour skills.

A labour profile defines a number of different skills that a company requires to perform multi-faceted operations. You can specify the relative involvement of each skill.

For example, the profile may need one person to carry out the operation and another person to act as supervisor.

You can vary the time spent by each labour skill. For example, an operation may require 100% of an operator's time. However, for a supervisor who is supervising 20 people simultaneously, you would only allot 5% to a single labour profile.

You attach profiles to individual operations on route/BOMs. The profiles are used for scheduling and capacity planning functions.

You can link a labour profile directly to one or more of the following:

- Shift Profile
- This is mandatory.
- Production calendar
- You can define a specific calendar to the labour profile, for memo purposes only.
- Department
- You can group labour profiles by department for performance analysis and capacity requirements planning.

- Labour skills

- These identify the skills required to carry out the tasks.

Prerequisites

Before creating a labour profile, make sure that you have:

- Set the calendar up using Maintain Company Profile and Calendars tasks

- Set the shift profile up using the Shift Profiles task

- Set up the departments using the Departments task

Labour Profile Maintenance Selection Window

To display this window, select the Labour Profiles task.

Use this window to enter the labour profile to create or maintain.

Fields

Labour Profile

Enter a labour profile. If you are creating a new profile, enter a unique code using up to two alphanumeric characters.

Alternatively, use the prompt facility to select from the Labour Profile Selection pop-up.

Based on Profile

If you are creating a new labour profile and you want to copy an existing one, enter the code of the existing labour profile here.

Alternatively, use the prompt facility to select from the Labour Profile Selection pop-up.

Leave this field blank to maintain an existing labour profile.

Press Enter to display the Labour Profile Maintenance Details window.

Labour Profile Maintenance Details Window

To display this window, press Enter on the Labour Profile Maintenance Selection window.

Use this window to enter or amend the description, calendar, shift profile and department for the labour profile.

Fields

Description

Enter or amend the description for the labour profile.

Calendar

Enter a calendar code. The default is the calendar specified in the company profile, but you can enter any calendar.

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

Shift Profile

You must enter the shift profile to use when scheduling work for this labour profile.

Alternatively, use the prompt facility to select from the Shift Profile Codes pop-up.

Department

You must enter a department, so that you can view capacity loading by labour department, as well as by labour skill.

Alternatively, use the prompt facility to select from the DEPT Department pop-up.

Standard Efficiency

Enter the expected average efficiency for the labour profile.

Leave this field blank for 100% efficiency.

To indicate under-efficiency, enter a value between 1 and 99.

Enter a value between 101 and 999 to indicate an over-efficient labour profile.

Note: This factor is not included on cost calculations for styles made using this profile.

Options

Delete

Use this to display the Labour Profile Labour Skill Details pop-up where you can delete the labour skill by selecting **Delete (F11)**.

Functions

Add Labour Skill (F20)

Use this to display the Labour Profile Labour Skill Details pop-up. You can use this to add a labour skill to the skill mix.

Select **Update (F8)** to save the labour profile changes and return to the Labour Profile Maintenance Selection window.

Labour Profile Labour Skill Details Pop-up

To display this pop-up, select Add **Labour Skill (F20)** on the Labour Profile Maintenance Details window or select Delete against a line on the Labour Profile Maintenance Details window.

Use this pop-up to define additional labour skills for the labour profile.

Fields

Labour Skill

Enter a labour skill to create or maintain.

Alternatively, use the prompt facility to select from the Select Labour Skills pop-up.

If you enter a new labour skill, press Enter to display the Labour Skill Maintenance window, so that you can quickly enter the basic details for the new skill and return to maintain the labour profile.

Note: You must return to the Labour Skill task if you want to add further details about the new skill.

No. Required

Enter the number of people with this labour skill who will work in this labour profile. Use this figure to calculate standard labour costs and labour load requirements in capacity routines.

% Time Required

Enter the standard percentage of time that this labour skill can work in this labour profile. Use this figure to calculate standard labour costs and labour load requirements in capacity routines.

Effective From

Enter or select the date on which this labour skill becomes effective.

Effective To

Enter or select the date up to which this labour skill is effective.

Select **Update (F8)** to save the details and return to the Labour Profile Maintenance Details window.

Operators [39/P1M]

Use this task to identify an employee as a Style Production operator. You can then specify who carried out the work when you enter a production transaction booking.

You can use effectivity dates to set up one or more pay rates. You then use the pay rates to record production activity costs.

Note: Alternatively, specify a labour skill rate that you have already set up via the Labour Skills task.

Prerequisites

You must have set up a department, using the Departments task, so that you can specify who is responsible for meeting the cost of the operator.

Note: Use the Teams task to group operators into teams. You can then make team bookings rather than individual operator bookings.

Note: An operator can only have one skill at any one time.

Operator Maintenance Selection Window

To display this window, select the Operators task.

Use this window to enter the operator code to create or maintain.

Fields

Operator Code

Enter an operator code. If you are defining a new operator, enter a unique code using up to nine alphanumeric characters.

Alternatively, use the prompt facility to select from the List/Select Operator Codes pop-up.

Press Enter to display the Operator Maintenance Details window.

Operator Maintenance Details Window

To display this window, press Enter on the Operator Maintenance Selection window.

Fields

Name

Enter or amend the operator's name.

Start Date

Enter or select the first date on which this operator can work. The default is 0/00/00, which means that the operator is effective immediately.

End Date

Enter or select the last date on which this operator can work. The default date is 99/99/99, which means that the operator is effective indefinitely.

Functions

Operator Rates (F20)

Use this to display the Operator Rates Maintenance window.

Press Enter to update the data you have entered and then select **Previous (F12)** to return to the Operator Maintenance Selection window.

Operator Rates Maintenance Window

To display this window, select **Operator Rates (F20)** on the Operator Maintenance Details window.

Use this window to specify pay rates for the operator. You can set up multiple rates by specifying effectivity dates.

Fields

Select

Select one of the following:

Select (2) - To maintain an operator rate

Delete (4) - To delete an operator rate

You must select **Delete (F11)** to confirm the deletion.

Note: You can maintain multiple lines by selecting more than one item.

Use Select in the Select field and then press Enter to display the Update/Add Operator Rates pop-up.

Update/Add Operator Rates Pop-up

To display this pop-up, use Select in the Select field and then press Enter on the Operator Rates Maintenance window.

Fields

Start Date

Enter or select the date from which the rate is effective for the operator. This date must be within the operator's effective date range.

The default date is 0/00/00, which means that the rate is effective immediately.

End Date

Enter or select the date up to which this rate is effective for the operator. This date must be within the operator's own effective date range.

The default date is 99/99/99, which means that the rate is effective indefinitely.

Labour Rate

Enter the operator rate for the period. If you leave this field blank, you must enter a labour skill instead. The software uses the effective rate for the skill in this period.

Labour Skill

Enter a labour skill to identify the operator's abilities.

Alternatively, use the prompt facility to select from the Select Labour Skills pop-up.

If an operator has more than one labour skill, you must use effectivity dates for each one, as only one skill can be effective at any time.

If you leave this field blank, you must enter a labour rate instead.

Department Code

Enter the labour department for which this operator is charged in this period.

Alternatively, use the prompt facility to select from the DEPT [Department](#) pop-up.

Select **Update (F8)** to save the operator rate details and return to the Operator Maintenance Details window.

Teams [40/P1M]

Use this task to define operator teams.

A team is any grouping of operators who can perform a range of skills. You can book in work carried out by an operator or a team during production activity. You can also request production reporting by team.

An operator can be part of more than one team.

Prerequisites

Before you set up teams, you must have already set up:

- A Calendar
- Use the Calendars task to specify working patterns for the team.
- A Shift Profile
- Use the Shift Profiles task to generate shift requirements.

Team Master Maintenance Selection Window

To display this window, select the Teams task.

Use this window to enter a team to create or maintain.

Fields

Team Code

Enter an existing team to maintain, or enter a new code of up to five alphanumeric characters.

Alternatively, use the prompt facility to select from the List/Select Team Codes Window pop-up.

Press Enter to display the Team Master Maintenance Details window.

Team Master Maintenance Details Window

To display this window, press Enter on the Team Master Maintenance Selection window.

Use this window to enter details of the team.

Fields

Description

Enter or amend the description for the team.

Shift Profile

You must enter a shift profile to define the working pattern for the team.

Alternatively, use the prompt facility to select from the Shift Profile Codes pop-up.

Calendar Code

Enter the calendar for this team to use.

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

If you leave this field blank, the calendar in the company profile is used.

Functions

Team Details (F20)

Use this to enter or maintain members of the team.

Press Enter to save the data and leave the task.

Team Details Maintenance Window

To display this window, select **Team Details (F20)** on the Team Master Maintenance Details window.

Fields

Select

Select one of the following:

Select (2) - To add an operator or select one to maintain

Delete (4) - To remove an operator from the team

Use Select in the Select field and then press Enter to display the Team Detail Maintenance pop-up.

Team Detail Maintenance Pop-up

To display this window, use Select in the Select field and then press Enter on the Team Details Maintenance window.

Use this window to add effectivity dates for operators.

Fields

Operator

If you are maintaining dates for an existing operator, the operator code is displayed. If you are adding an operator, enter the new code.

Start Date

Enter or select the date from which operator is included in the team, which must be within the operator's own effective date range. The default is 0/00/00, which means effective immediately.

End Date

Enter or select the date after which the operator will no longer be included in the team. This must be within the operator's own effective date range. The default is 99/99/99, implying unlimited effectivity.

Functions

Add Operator (F8)

Use this to display the Operator Maintenance Details window. You can quickly set up new operators to add to the team and then return to this task.

Press Enter to save the details and return to the Team Details Maintenance window.

Text Types [50/P1M]

You can use text types to link text to certain functions within Style processing. Use this task to define the text categories you want use to build text. Each function can have multiple text types, although you can only use one text type combination interactively with the function at any time. You define the active text type combination for the function in the company profile.

Each major type can be sub-divided into minor categories, or sub-types. These sub-types can represent different logical or operational groupings of textual information.

These can represent logical groupings of text relating to the system function. For example, Production Details Maintenance can have text relating to planning information in one sub-type category, and text relating to item costs in another.

Text Type Selection Window

To display this window, select the Text Types task.

Use this window to select the text type to maintain.

Fields

Major Typ

Enter a major text type to create or maintain.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

The major and sub-types defined in the [company profile](#) determine the text to be used by the software. You can have different bodies of text for a particular system entity (for example, item), but only one set only is the [operational](#) text.

Note: You cannot enter a text sub-type until you have created the major text type.

Sub-type

Enter a text sub-type to create or maintain.

Functions

Display Sub-types (F17)

Select this to display the Text Type Maintenance Sub-types window. This displays all the sub-types currently defined to the selected major type.

Press Enter to display the Text Type Maintenance Details window.

Text Type Maintenance Details Window

To display this window, press Enter on the Text Type Maintenance Selection window.

Use this window to enter or amend the description for a major text type.

Fields

Text Description

Enter or amend the description for the major type.

Press Enter to save the text description changes and return to the Text Type Maintenance Selection window.

Text Type Maintenance Sub-types Window

To display this window, enter a major type and then select **Display Sub-types (F17)** on the Text Type Maintenance Selection window.

This window displays all the text sub-types currently defined to a major type.

Fields

Enter Sub-type to Maintain or Add

Enter a text sub-type to create or maintain. The sub-type is a sub-division of the major text type.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

Enter or select a sub-type and then press Enter to display the Text Type Maintenance Sub-type Description window.

Text Type Maintenance Sub-type Description Window

To display this window, enter or select a sub-type and then press Enter on the Text Type Maintenance Sub-type window.

Use this window to add descriptions for the sub-types.

Fields

Sub-type Description

Enter or amend the description for this text sub-type.

Functions

Delete Sub-type (F11)

Use this to delete the sub-type. No confirmation is required.

Reselect Major Type (F13)

Use this to re-display the Text Type Maintenance Selection window.

Press Enter to save the sub-type description.

Maintain Text [51/P1M]

Use this task to maintain standard text, which can be used throughout Style Production.

Text Maintenance Selection Window

To display this window, select the Maintain Text task.

Use this window to enter the text type.

Fields

Major Type

Enter the text major type to maintain.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

This identifies members of certain activity categories, and will include:

- Items
- Routes/Bills of Materials
- Operations within routes
- Machines
- Work Centres
- Cost Centres
- Production Orders

Sub-Type

Enter the text sub-type code.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

File Key

Enter a third level of code for recording text.

Alternatively, use the prompt facility to select from the Select Text Key pop-up.

For example, you can record a style against the Major Type field, a material against the Sub-type field and a choice of materials against the File Key field.

Press Enter to display the Text Maintenance Details window.

Text Maintenance Details Window

To display this window, press Enter on the Text Maintenance Selection window.

Use this window to enter standard text.

Fields

Position at Line No

Enter the line number to position at the top of the window.

Text (Untitled)

Enter the text.

Insert/Lines after Line No

Enter the number of blank lines to insert and the line number after which to add them.

Delete Lines - From/To

Enter the range of lines to delete.

Select **Return & Update Text (F8)** to save the text and return to the Text Maintenance Selection window.

Chapter 3   Route/BOM Maintenance

3

Style Production Routes

With Style Production you can define production routes in a variety of ways. You can produce an integrated model of product and process with links to materials and operations. With this integrated structure, you can plan, produce and cost products with precision and control.

For each style production route, you define the:

- Route (a series of consecutive operations to turn materials into a finished product)
- And
- Bill of materials (a list of materials with each material linked to an operation, so you can use MRP to plan when you need the material)

You must define at least one production route for each style. However, you can set up multiple routes, for example:

- To contract out certain operations
- To maintain separate costing and planning routes
- To define summary route/BOMs for rough cut capacity planning
- To include capacity constraints or alternative processes
- To accommodate different batch sizes
- To model different costing strategies

Note: *Routes are the fundamental building blocks of Style Production, so make sure they are accurate, complete and kept up to date.*

Building a Style Production Route

You can build a route or BOM by:

- Entering operations manually
- Copying in operations from groups of standard operations
- Copying in operations from existing routes and then maintaining the details

You can define production routes at style level. This saves time, since you do not have to define a production route for every style variant.

If an individual colour, size, or group of colours and sizes use a variant of the standard route, you can do one of the following:

- Build a separate route
- Or
- Specify variant operations on the same route

Standard Operation Groups

To save time re-entering similar operation definitions, you can define standard operation groups.

These standard operation groups can include both primary and variant standard operations. You can copy standard operations as primary or variant operations to a live production route or model planning route.

Through a unique Specification ID, you can retain a link between route operations and the standard operations from which they originate. Then, when you make changes to a standard operation, you can perform a mass update on the route operations. You have control over which fields you update during a mass update run.

Extended Text Descriptions

You can use an extended text description to enter information for each operation. This information may be essential for complex or commercially sensitive processes, where additional technical or procedural instructions are necessary. You can print this information on the production order documentation.

Materials

When you define a route, you enter the details of the materials needed to make styles and individual style variants.

Some products may need common materials for all style and colour variants. For example, if you make shirts in blue, green and red variants, each variant needs the same fabric (100% cotton) but a different colour. In this case, you use a matrix to relate the material characteristics to the style characteristics, so you can specify green fabric for a green shirt.

You can specify different materials for individual colour or size variants or both.

In addition, the amount of material you need could vary between variants. You can define the quantity needed for a primary variant and then specify a ratio to determine the remaining variant requirements. From this the software can calculate material requirements for all variants.

You can specify each requirement individually; the software defaults to the standard material requirement you enter when you define the material code against the operation.

Updating Material Details on Routes

To identify and update materials on a route where-used basis, you can use the Material Mass Replace task.

Operations

You can define two types of operation on a route:

- Primary
- This field displays the default used to produce the style variants. Style uses primary operations to cost the style.
- Variant
- A variant operation is specific to a certain colour or size variant. The operation details can vary significantly from those defined for the primary operation.

For each primary or variant operation, you need to define:

- Where the operation takes place
- How long the operation takes to complete
- What materials the operation uses
- How to report completed work
- The machine used for the operation

The software uses this information to determine the time-phased load calculated by the production plan and calculate anticipated production costs.

Lead Time and Cost

For each operation, you specify the standard machine and labour time taken to complete the operation. You can base machine and labour time on one of the following units:

- Time taken to produce a standard batch
- Time taken to produce 1
- Time taken to produce 100
- Time taken to produce 1000

The software uses this information to determine the lead time of the operation for scheduling and the cost of the operation.

The software also uses:

- Number of machines available
- For example, if the labour time is 10 hours but there are 2 machines, the lead time is only 5 hours.
- Move days factor
- This factor shows any time lost transferring work from a previous operation. You can add in this factor by assigning a queue time to the machine.

You can qualify the cost of the operation by team size or labour profile. The costing routines multiply the number of people by their charge rates to calculate the labour cost involved in production.

You can also include a wastage percentage in both costing and lead time values. This results in extra time spent at the operation due to inefficiency.

Bundle Operations

Validation is carried out as follows:

Reporting levels may not change during a stream of bundle operations.

Bundle streams need not end in a count point; but if they do not, there must a count point between them and a following bundle-up.

A change of bundle ticket type requires either that the new ticket is parallel or is preceded by a bundle-up.

Constraints are:

Variant bundle ticket types are supported; but they will only be applied to parallel streams at the same point as the primary ticket changes.

A variant may fail to participate in any bundle operation, but bundles will be created for all parallel streams and for all variants active on the bundle-up.

Variant Operations

The information for a primary operation applies to all variants of the style, which is unrealistic if you cater for a large number of colours or sizes.

To record varying operation details for specific colours or sizes, you can set up one or more variant operations. Variant operations run parallel to a style route operation. From a primary operation, you can define one or more variant operations for certain colours or sizes or colour and size combinations.

Use variant operations to specify:

- Alternative standard production times
- A different machine
- A different labour profile (that is, skill mix)
- Changes to required materials, covering quantity per size and matching the colour of the style to that of the material

Calculating Operation Lead Time

Operation lead time is the time taken to complete an operation. Lead time is critical for:

- Scheduling and planning
- The software uses the lead time for each operation to determine when to start a production order to achieve the due date. This process fits the number of hours required into the number of hours available at the appropriate machine on each working day.
- Capacity loading
- The software checks the available hours available with the required hours.
- Costing
- The software multiplies the machine lead time and the labour lead time by a rate to obtain a cost.

The software uses this formula to calculate the lead time:

Operation Lead Time = Queue Time + Operation Duration + Move Time

Where:

Queue time is the time that WIP inventory must wait before work can start on the current operation.

Operation duration is the time worked on WIP during the current operation.

Move time is any long inter-operational delays; for example, moving work between sites.

Standard Operation Lead Time

Op.	Queue Time (Hrs)	Operation Duration (Hrs)	Move Days	Std Shift Length	Move Time (Hrs)	Total Lead Time (Hrs)
10	2.0000	4.0000	1.000	8.0000	8.0000	14.0000
20	3.0000	4.0000	0.000	8.0000	0.0000	8.0000
30	4.0000	6.0000	3.000	8.0000	24.0000	34.0000
40	2.0000	3.0000	0.000	8.0000	0.0000	5.0000
Totals:	**11.0000**	**18.0000**	**4.000**		**32.0000**	**61.0000**

Operation Duration Time

To match the wide variety of methods you can employ to calculate duration time, Style Production has a very flexible operation definition.

For scheduling, you can split the workload between machines and you can run operations concurrently (that is, parallel processing). This reduces the actual lead time dramatically, but it does not affect the duration of the operation; nor does it affect costing routines.

To define standard operation duration, enter the set-up and run labour time and the run machine time for each operation. You can enter the time in hours or minutes, depending on the company default.

The exact meanings of these times are not immediately obvious. You can use time basis codes to specify exactly what the time means. You must enter one time basis code per operation.

Time Basis

Lot	Time Basis Code and Batch No Description	Batch Quantity	No	Set-up Labour	Run Labour	Run Machine
1000	0 Time per parent lot			1.10	12.00	12.00
1000	1 Time each			1.10	0.005	0.0065
1000	2 Time per 100			1.23	2.333	1.98
1000	3 Time per 1000			1.34	4.560	3.5
1000	4 Quantity per hour (n/a)					
1000	5 Fixed time operation			1.45	7.800	12.00
1000	6 Time per operation batch	500	2	1.22	1.678	0.96

You must also consider whether set-up labour time, run labour time and run machine time run alternately or concurrently. For example, you might have a run labour time of 5 hours and a run machine time of 7 hours; but the labour time is a 5-hour requirement within the 7 hours of machine time. Your operation duration is the total of set-up time plus 7 hours. However, you still need the run labour time to cost the operation correctly. To determine exactly how to combine the three time components, there is a series of duration basis codes:

Duration Basis

Duration Basis Code	Set up Time	Run Machine Time	Run Labour Time	Duration
0 Set up	1.00	2.00	3.00	1.00
1 Set up + Run Machine	1.00	2.00	3.00	3.00
2 Set up + Run Labour	1.00	2.00	3.00	4.00
3 Set up + Run Labour + Run Machine	1.00	2.00	3.00	6.00
4 Set up + > (Run Labour or Machine)	1.00	2.00	3.00	4.00

Wastage

To compensate for expected wastage, you can increase the duration time. This increases the WIP inventory requirement at each operation to achieve the operation target. You specify the wastage percentage at operation level.

Wastage Example

Run Quantity = 100

Standard Lot Size = 100

Op.	Std Duration (Hours)	Wastage (%)	Cumulative Wastage Factor	Inflate Run Qty	Inflate Std Duration (Hours)
10	5.0000	20	1.25	125.0	6.2500
20	8.0000	5	1.32	131.6	10.5263
30	3.0000	10	1.46	146.2	4.3860
Totals:	**16.0000**				**21.1623**

Subcontract Operations

You can carry out some processes off-site at subcontractors. You can include these processes as operations on route/BOMs.

You can track and monitor:

- Movement of materials to a subcontractor
- Transfer of WIP inventory to a subcontractor
- Progress of WIP inventory at a subcontractor
- Receipt of WIP inventory from the subcontractor

To define subcontracted operations you must:

1 Set up Route/BOM.

2 Release the production order.

3 Create purchase orders for all subcontracted operations.

4 Allocate lots.

5 Issue materials.

6 Report preceding operation.

7 Ship WIP to the subcontractor.

8 Progress at subcontractor.

9   Receive from subcontractor.

10   Create GRN for purchase order.

System Set Up

You must have access to Style Purchase Management and Accounts Payable. You must also set up each subcontractor as a valid supplier. You can automatically raise purchase orders for all subcontracted operations.

Define a subcontractor stockroom on the organisational model for all the material needed by the subcontractor.

Set up the Shipper Tracking flag on the organisational model, to do either or both of the following:

- Track the movement of WIP inventory, or materials, or both. You can use one shipper number to track WIP from more than one production order or many numbers within the same order.
- Print shipper, or despatch, notes to accompany each shipment.

Route/BOM Set-Up

You can define any primary or variant operations as subcontracted operations, other than the first operation. If you need to subcontract the first operation, create a dummy count point operation to register the work-in-progress to ship.

To include the capacity and loading of subcontracted work when planning, record the standard labour, machine and set up time.

During material issuing, the software transfers materials to the subcontractor stockroom, defined on the organisational model. When you book an operation with materials attached, using either the Progress at Subcontractor task or the Receive from Subcontractor task, the software backflushes the materials out of the stockroom. The software holds the material balances by subcontractor and material within the stockroom.

Validation is made to ensure that the first and last operations of a subcontract stream are count points. Subcontract operations must be preceded and followed by in-house count points.

Order Release

Use the Release Orders task to identify subcontracted operations on the production route. This generates purchase orders automatically for all operations, where you set the Key Operation field to **2** or **3**.

Create Purchase Orders

The software automatically creates purchase orders for the supplier defined on the production route.

Allocate Lots and Issue Materials

If you ship batch-controlled or lot-controlled materials, you must allocate the materials to the production order. The software can then transfer the correct lots to the subcontractor stockroom.

When you issue any materials required by the subcontractor, the software transfers the materials from the issuing stockroom to the subcontractor stockroom.

Report Preceding Operation

You must report the preceding operation to determine the quantity of Available WIP to move to the subcontractor.

WIP Shipper

This task reduces the Available WIP quantity balance at the operation before the subcontracted operation, and increases the subcontractor WIP quantity. You must enquire on subcontractor WIP inventory balances for the operation before the subcontract operation and not the subcontracted operation itself.

Progress at Subcontractor

If you subcontract consecutive operations, you can record bookings at each operation, thereby simulating work carried out on-site.

Receive from Subcontractor

When you receive from a subcontractor, the software increases the available WIP inventory balance at the subcontracted operation and decreases the subcontractor WIP balance at the previous operation. It also downdates subcontractor material issue balances with material quantities. You can override these quantities at the point of receipt. You can receive the inventory as held status and returned for rework.

Create GRN for Purchase Order

Style Purchase Management creates the Goods Received Note. Within Style Production, you can report receipts without a GRN if you entered a different purchase order to that raised by the release procedure.

Standard Operations [1/P1R]

Use this task to create groups of operations which are not part of any particular style or route.

You can then copy these operations into individual style routes.

For example, you could define a generic operation for making skirts and then copy the operation, or part of it, into the style route for each style of skirt that you produce.

You can maintain primary and variant operations. You could create a primary operation to produce skirts and then variant operations to produce skirts of different colours, lengths, fit and so on.

Standard Operations Maintenance Selection Window

To display this window, select the Standard Operations task.

Use this window to enter the operation group to create or maintain.

<u>Fields</u>

Operation Group

Enter an operation group.

Alternatively, use the prompt facility to select from the Select Operation Group pop-up.

If you are creating a new group, enter a unique one-character alphanumeric code.

Group Description

If you are creating a new operation group, you must enter a description.

<u>Functions</u>

Text (F21)

Use this to display the Text Maintenance window, which you can use to add any text to the operation. This may be useful for complex or commercially sensitive processes, where additional technical or procedural instructions are necessary.

Select a group or enter a group and then press Enter. If you have entered a new group, the Standard Operations Maintenance Warning Message window is displayed. If you have entered an existing group, the Standard Operations Maintenance window is displayed.

Standard Operations Maintenance Warning Message Window

To display this window, enter a new group code and then press Enter on the Standard Operation Maintenance Selection window.

Use this window to select the way in which to create the new operation group.

Press Enter to display the Standard Operation Maintenance Details window.

Alternatively, select **Copy From Std. Operations (F17)** to display the Select Operation Group to Copy pop-up.

Standard Operation Maintenance Details Window

To display this window, press Enter on the Standard Operations Maintenance Warning Message window (for a new group) or select an existing group with 1, 2, or 3 on the Standard Operations Maintenance window.

Use this window to enter or amend details of an operation.

If you adding an operation, the literal "ADD" will be displayed at the top of the window. If you are maintaining an existing operation, the literal "UPDATE" will be displayed.

<u>Fields</u>

Group

This field displays the group you are creating or amending.

Operation Sequence

This field displays the operation sequence in this group.

Std Lot Size

This field displays the standard lot size.

Operations Code

Enter a code for this operation.

Machine Quantity

Enter the number of machines that are used in the operation. This is used when calculating lead time.

For example, if an operation takes 10 hours on one machine, you could use five machines simultaneously, reducing the lead time to two hours.

If you enter a machine with a default shift profile, the machine quantity must not exceed the standard capacity factor defined on the Shift/Capacity Profile Maintenance pop-up.

Operation Description

You must enter a description for this operation.

Machine

Enter the standard machine that this operation uses.

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

If the machine is defined to more than one work centre, do not enter a work centre, as this limits the types of analysis available.

Work Centre

Enter the work centre that this operation uses.

Alternatively, use the prompt facility to select from the Select Work Centre pop-up.

If you have not specified a machine, the first machine in the work centre sequence is used to calculate capacity loading and costing. If you change the work centre definition, this machine will still be used for this operation.

Note: If you specify a machine, you can leave Work Centre field blank.

Bundle Ticket Type

Enter a bundle ticket type to associate this operation with a bundle ticket. This is the standard bundle ticket for planning purposes.

Alternatively, use the prompt facility to select from the Bundle Ticket Type Window pop-up.

Caution: The bundle ticket search family must be the same as the search family for the style.

When bundle tickets are printed, all the operations that you have associated with the bundle ticket are included.

If you enter a bundle ticket type for a primary operation, you must also enter types for variant operations.

Note: You cannot enter a bundle ticket type for a bundling-up operation.

Reporting Type

Use this to specify whether the operation is a count point or a backflushed operation.

Enter one of the following:

0 (default) - Count Point Type A

1 - Count Point Type B

2 - Backflushed Operation Type A

3 - Backflushed Operation Type B

Note: A complete short or over operation must be a count point. A bundling-up operation or the last in the group must also be count point.

Reporting type codes are defined in the Parameter file, under type RPNT.

You can use the prompt facility on this field to select from the RPNT Reporting Types pop-up.

Reporting Level

Enter the level of detail you want to record at operation booking. If you have set the Operation Type to 8, you must set this field to the highest level possible for the number of dimensions for the style.

Enter one of the following:

0 - Style

1 - Style/colour

2 - Style/size

3 - Style/colour/size

Note: You cannot report at both style/colour and style/size levels on the same route.

Note: If you are mixing colours within a bundle, do not set the Reporting Level field to 1. If you are mixing sizes, do not set the Reporting Level field to 2.

You can specify different reporting levels for each operation you enter.

Caution: Once the production process has reached a certain reporting level, it is not possible to return to a previous level. You can either stay at the same level or progress to the next level.

For example, if you are making shirts in a range of colours and sizes:

- Report Operation 10 at style level means that you lay out all the material ready for working.
- Report Operation 20 at style/size level as you separate all the various sizes.

- Report Operation 30 at style/colour/size level as you dye the finished shirts.

Note: You must report the last operation on the route at full product detail level, that is, style/colour for styles without sizes; style/colour/size for styles with sizes.

Reporting levels are defined in the Parameter file, under type BKOP.

You can use the prompt facility on this field to select from the BKOP Reporting Level pop-up.

Key Operation

This field is important if you are subcontracting the operation.

Note: You can only define key operations at count points.

Key operation codes are defined in the Parameter file, under type CROP.

A route may comprise a large number of operations. You can limit the number of operations that appear on enquiries and reports. To select an operation to be included, mark the operation as a key operation.

Enter one of the following:

0 - Only to display the operation selectively

1 - Always to display the operation on all reports and enquiries

2 - To raise and display subcontract purchase orders

Use this for subcontracted operations only. The operation is displayed on all enquiries and reports. When you release a production order, a purchase order is generated for any subcontracted work.

3 - To raise and display the purchase order and lot

The operation is displayed on all enquiries and reports. When you book an operation, a purchase order is raised for subcontracted work and prompts for a WIP lot number. You can make the lot number specific to the subcontractor, that is, supplier.

4 - To display the lot and update point

The operation is displayed on all enquiries and reports. It prompts for a WIP lot number. If you are using lot tracking, you can change the tracked WIP lot number.

You can use the prompt facility on this field to select from the CROP Key Operations pop-up.

Lab Profile

Enter a labour profile to identify the skills required by the operation, and the number of operators needed.

Alternatively, use the prompt facility to select from the Labour Profile Selection pop-up.

Note: If you enter a labour profile, it overrides any entry in the Team Size field.

Labour Time

Enter the standard run labour time, per lot, for this operation, in the units defined on the Additional Operation Values pop-up.

Formula Code (Labour)

Enter an allowance formula code. These are defined in the Parameter file under type ALLW.

Alternatively, use the prompt facility to select from the ALLW Allowance Formula pop-up.

Machine Time

Enter the standard machine time per lot for this operation in the units defined by the Time Basis Code field on the Additional Operation Values pop-up.

Style uses the machine time to calculate the load on hard resources.

Formula Code (Machine)

Enter an allowance formula code. These codes are defined in the Parameter file, under type ALLW.

Alternatively, use the prompt facility to select from the ALLW Allowance Formula pop-up.

Team Size

Enter the number of operators in the team assigned to this operation.

Team size is used to work out the standard labour requirement for this operation.

You can enter decimal figures to represent an operator who manages more than one task or machine at this operation.

Move Days

Enter the move time between operations for capacity planning purposes. Move time is the time required between the end of one operation and the start of the next, for example, for cooling or drying.

Move days are useful when you are scheduling operation start and finish dates.

Wastage %

Operation wastage is the estimated product loss at this operation.

For example, if you have 100 units initially and specify 5% wastage, you would expect an output of 95 units.

The wastage percentage is used to calculate the required level of machine, labour and material resource based on the standards you have specified to achieve the desired output.

Caution: During planning, the software over-schedules to compensate for the expected wastage.

Note: Parent styles are costed at inflated operation standards and extended quantity of material inputs. These extended costs are spread over the standard lot size for the process, to obtain a standard unit cost.

Step

This is only displayed if you are adding an operation. Use it to increase or decrease the increment for the operation sequence number.

To re-adjust operations to standard increments of 10, select **Resequence (F18)** on the Style Route Maintenance Operations and Materials window.

Specification ID

You can enter a unique specification ID for this operation.

The ID must be unique to this operation but you can have many operations on the same route with this ID, to link them together.

Functions

User Pgm (F15)

This is only displayed if you have set up a user-developed program defined under the USER parameter in the Maintain Parameter File task. You use it to display new field values returned by the program.

*Note: The USER parameter allows you to define a program separately for primary operations and variant operations. **User Pgm (F15)** is only displayed if you have defined the appropriate user program for this type of operation.*

Time Calcs (F16)

Use this to re-calculate the values entered in the Labour Time and Machine Time fields on this window. It also re-calculates the Set Up Labour Time field on the Additional Operation Values pop-up.

Note: This function is available only if you have defined one or more user programs under the ALLW parameter to perform the re-calculation. For more information, refer to the Maintain Parameter File section in the Utilities chapter of this product guide. If you are maintaining a standard operation, this function is not available.

Op. Text (F21)

Use this to display the Text Maintenance window, which you can use to enter any additional operation text to be printed on orders.

Additional Parms (F22)

Use this to display the Additional Operation Values pop-up.

Variant Opn. (F23)

This is not displayed if you are creating a new operation. Use this to display the Maintain Variant Operations pop-up.

Characteristics (F24)

This is not displayed if you are creating a new operation. Use this to display the Operation Characteristics Values pop-up.

Press Enter to save the operation. If you are adding a new operation, select **Previous (F12)** to return to the previous window.

Additional Operation Values Pop-up

To display this pop-up, select **Additional Parms (F22)** on the Standard Operations Maintenance Details window, or the Variant Operation Maintenance window, or the Style Route Enquiry Operations window.

Use this pop-up to enter further details about a primary or variant operation.

Fields

SET-UP Labour Time

Enter the elapsed set-up labour time for this operation, that is, any time spent preparing machines and processes for production. This time is added to the duration of the operation.

Note: Set-up time is a fixed duration.

Formula Code

Enter an allowance formula code.

Alternatively, use the prompt facility to select from the ALLW Allowance Formula pop-up.

These are defined in the Parameter file under type ALLW. They are user-defined calculations to re-calculate set up labour time.

Team Size

Enter the number of operators required to perform the set-up for this operation.

Lab Profile

Enter a labour profile to identify the number of operators and the labour skills required to set up the operation.

Alternatively, use the prompt facility to select from the Labour Profile Selection pop-up.

Note: If you enter a labour profile, it overwrites any value entered in the Team Size field.

Time Basis Code

Use this to specify the units to use to define labour and machine production rates.

Enter one of the following:

0 or Blank - Time per parent lot

This is the time it takes to complete a standard lot, as defined on the Style Route Header window.

1 - Time each

This is the time it takes to produce one item.

2 - Time per 100

This is the time it takes to produce 100 items.

3 - Time per 1000

This is the time it takes to produce 1000 items.

4 - Quantity per hour

The number of operations performed over a specified length of time is recorded, which is then used to calculate a rate per hour.

5 - Fixed time operation

The time taken is the same, regardless of quantity.

6 - Time per operation batch

Select this if there is a limit to the quantity that can be produced in a single fixed time.

For example, if you produce a maximum of 100 per hour, and want to make 101, the fixed time taken to make the complete quantity is 2 hours.

Time Basis codes are held in the Parameter file, under type TBCD.

You can use the prompt facility on this field to select from the TBCD Time Basis Code pop-up.

Enter the time in hours or minutes, depending on how you have set the Time Units field in the company profile.

Note: You cannot use this field for variant operations.

Batch Qty

Note: You only need to enter a batch quantity if you are using time basis code 6.

The batch quantity is used to calculate the number of batches required to make the operation quantity. Style multiplies the number of batches required by the machine and labour production rates to determine their duration.

For example, if the operation quantity is 100 and the batch quantity is 50, and the production rate is one hour per batch, the number of batches required is two, and the labour duration will be two hours.

Note: If the operation is a variant operation, you cannot update this field.

Duration Basis

Enter the duration basis to use when calculating operation lead time. Set-up labour, run labour and run machine time details are all part of the calculation.

If you leave this blank, the machine default will be used. If there is not a machine default, the company profile default is used.

Enter one of the following:

0 - Set-up labour

1 - Set-up labour + run machine

2 - Set-up labour + run labour

3 - Set-up labour + run labour + run machine

4 - Set-up labour + (greater of run labour or run machine)

Duration basis codes are maintained in the Parameter file under type DUCT.

You can use the prompt facility to select from the DUCT Operation Duration Calc. Basis pop-up.

Note: You cannot use this field if you are maintaining a variant operation.

Costing Analysis

You can enter a costing analysis code for a further analysis of cost.

Costing Analysis codes are maintained in the Parameter file, under type CSOP.

You can use the prompt facility on this field to select from the CSOP Costing Analysis pop-up.

Note: You cannot use this field if you are maintaining a variant operation.

Operation Type

Enter the type of operation; you can override this when you create a production order.

Enter one of the following:

8 - Complete short/over operation

This must be a count point operation. Where there is a surplus or shortfall, a completed quantity on this operation adjusts subsequent planned production order quantities.

9 - Bundle-up operation

This operation is a point where you bundle WIP up before proceeding to the next operation.

Operation codes are maintained in the Parameter file, under type ATS1.

You can use the prompt facility on this field to select from the ATS1 Operation Types pop-up.

Studied/Est Times

Select one of the following:

Studied (1) - Time and motion study

Use empirical methods to calculate the standard times for this operation.

Estimated (2) - Estimated

Estimate standard times for this operation.

Report Non-Bundle

Use this field to specify how to book in transactions for this operation, if it is linked to a bundle ticket.

Use this checkbox as follows:

Unchecked - To use Manual Timesheet Booking

Checked - To use any of the following:

- Production Order Booking
- Operator Booking
- Manual Timesheet Booking

End

Enter or select the date on which this operation ceases to be effective. Leave the default to use the operation on all dates.

Note: You cannot use this field if you are maintaining a variant operation.

Inbound Stock Area

This is a memo field. Use it to record the WIP location of the previous operation, to indicate where WIP items are located.

You can use the prompt facility on this field to select from the Select Stockroom pop-up.

Outbound Stock Area

This is a memo field. Use this field to record the WIP location associated with this operation. This is the same as the WIP location of the machine that is used.

You can use the prompt facility on this field to select from the Select Stockroom pop-up.

Effective Start

Enter or select the date on which this operation becomes effective. Leave the default to use the operation on all dates.

Note: You cannot use this field if you are maintaining a variant operation.

Sub-Contract Cost

Enter the subcontract cost for a single item.

This is used to estimate the total cost for the route, as well as the standard order variance analysis cost. It is used to compare against actual subcontract charges.

Sub-Contract

Use this field to specify whether this is a subcontract operation.

The following rules apply to subcontract operations:

The first and last operations on the route must be in-house operations.

The subcontracted operation must be a count point.

The previous operation must not be a backflushed operation.

Use this checkbox as follows:

Unchecked - If this is not a subcontract operation

Checked - If this is a subcontract operation

You can still enter standard labour, machine and set-up time for a subcontract operation, to analyse the capacity and loading of subcontractors.

Caution: If you enter 1, do not attach the machine to a cost centre, as machine, labour setting and overheads are costed as well as the subcontract cost.

Sub-Contract Supplier

Enter the supplier code for the sub contractor.

Alternatively, use the prompt facility to select from the Supplier Search pop-up.

Material Cost %

Enter a percentage.

Operation Level Cost %

Enter a percentage.

Press Enter to save the information you have entered and return to the Standard Operations Details Maintenance window.

Maintain Variant Operations Pop-up

To display this pop-up, select **Variant Opn. (F23)** on the Standard Operations Maintenance Details window or the Style Route Enquiry Operations window.

Use this pop-up to add a new variant operation to the operation or update an existing variant operation.

A primary operation defines a standard method for processing one part of the route. However, you may wish to vary the operation for one or more style variants.

You can add a variant operation for style variants which require a different machine or work centre or take less or more time to complete than the primary operation.

Caution: You are creating a variant operation for one or more style variants. Therefore, you must have already removed these style variants from the primary operation, using the Operation Characteristics Values pop-up.

Fields

Variant

This field displays the sequence number for the variant operation.

Colour

This field displays the colour, if the variant operation is to make a single colour.

Size

This field displays the size, if the variant operation is to make a single size.

Enter Variant to Maintain

Enter the variant to maintain or enter a new operation number to add a new variant operation.

Options

Select

Use this to display the Variant Operation Maintenance window.

Values

Use this to display the Operation Characteristics Values pop-up.

This is not available if you are maintaining a standard operation.

Delete

Use this to delete the operation.

Press Enter to record the variant details.

Select Operation Group to Copy Pop-up

To display this pop-up, select Copy from **Std. Operations (F17)** on the Standard Operations
Maintenance Warning Message window.

Use this pop-up to select the existing operation group from which to copy new operations.

Fields

Position To

Enter the operation group at which to start the display list.

Specification ID

Enter a full specification ID to display the Copy Operation Group window.

You can enter * as a wildcard to display a list of matching operations. For example, to list all
standard operations with specification IDs prefixed by BUNDLE, enter **BUNDLE***.

Include at Operation Number

You must enter the sequence number of the first operation to copy.

Options

Select

Use this against the operation group to copy.

Select an operation group or enter a full specification ID and then press Enter to display the Copy
Operation Group window.

Copy Operation Group Window

To display this window, select an operation group or enter a full specification ID and then press
Enter on the Select Operation Group to Copy pop-up.

Use this window to select the operations to copy. Any variant operations are also copied.

Fields

Seq

Use this field to specify the standard primary and variant operations to copy.

To link together several standard operations for copying across to the same operation as a primary and several variants, enter the same sequence number against the standard operations.

You can enter multiple sequence number sets. Style copies over sets of operations in order, beginning with the lowest sequence number.

The first operation within a sequence number set copies over as the primary operation. Any other operations in the sequence number set copy over as variant operations of this primary operation. To define a specific standard operation within the sequence number set as the primary operation, use the Primary Operation field.

If the style route operation you entered in the Include at Operation Number field on the Select Operation Group pop-up already exists, all standard operations in the first sequence number set copy over as variants of this operation.

All subsequent sequence number sets of operations appear as new operations after the first sequence number set.

Primary Operation (P)

To identify an operation or one of its variants as the primary operation, enter **1**. If the operation has variants, the Maintain Variant Operations pop-up is displayed.

To copy over the first standard operation in each sequence number set as the primary operation, leave this field blank.

Enter Operation to Copy From/To

Enter the first and last operations to copy.

Position To

Enter the operation at which to start the display.

Note: If you entered an operation number that already exists in the Include at Operation Number field on the Select Operations Group to Copy pop-up, you cannot enter a range here.

Press Enter to copy the operations.

Copy from Selected Std. Operations Window

To display this window, enter part of a specification ID and a wildcard and then press Enter on the Select Operation Group to Copy pop-up.

Use this window to select the standard operations to copy. Any variant operations are also copied.

Fields

Seq

To link together several standard operations for copying across to the same operation as a primary and several variants, enter the same sequence number against the standard operations.

You can enter multiple sequence number sets. Sets of operations are copied in order, beginning with the lowest sequence number.

The first operation within a sequence number set copies over as the primary operation. Any other operations in the sequence number set end up as variants of this primary operation. To define a specific standard operation within the sequence number set as the primary operation, use the Primary Operation field.

If the style route operation you entered in the Include at Operation Number field on the Select Operation Group pop-up already exists, all standard operations in the first sequence number set copy over as variants of this operation.

All subsequent sequence number sets of operations are inserted as new operations after the first sequence number set.

Alternatively, enter a range in the Enter Operation to Copy From field and leave this field blank.

Primary Operation (P)

To mark a standard operation or one of its variants as the primary operation within a sequence number set, enter **1**. If the operation has variants, the Variant Operation Selection Standard Operation pop-up is displayed.

To copy over the first standard operation in each sequence number set as the primary operation, leave this field blank.

Press Enter to copy the standard operations. If any of the operations contains variant operations, the Variant Operation Selection Standard Operation pop-up is displayed.

Standard Operations Maintenance Window

To display this window, select an existing operation or enter an existing operation and then press Enter on the Standard Operations Maintenance Selection window.

This window is displayed if you are maintaining an existing operation or operation group.

Additional options and functions are available on this window. You can define these under major type STDO in the Parameter file.

Fields

Group

This field displays the operation group code.

Opsq

This field displays the operation sequence.

Opcode

This field displays the operation code.

Description

This field displays the description of the operation.

Labour

This field displays the labour time assigned to this operation.

Specification ID

This field displays the specification ID.

Options

Maintain

Use this to update the selected operation.

Add Oper Before

Use this to add a new operation before the operation you have selected.

This displays the Standard Operations Maintenance Details window.

Add Oper After

Use this to add an operation following the operation you have selected.

This displays the Standard Operations Maintenance Details window.

Delete

Use this to delete an operation.

Note: You can make as many of your selections as you want before you press Enter. Each window is displayed in turn.

Note: Options Add Oper Before and Add Oper After are only displayed for single operation groups, where the list contains all the standard operations in one operation group.

Functions

Position to Operation (F13)

Use this to display the Position To pop-up and enter the operation sequence or group at which to start the display.

Copy from Standard Operations (F17)

Use this to display the Select Operation Group to Copy pop-up.

Note: This is only displayed for single operation groups, where the list contains all the standard operations in one operation group.

Resequence (F18)

This re-sequences operations if you have inserted or deleted any operations. Operations are re-sequenced in increments of 10.

Note: This is only displayed for single operation groups, where the list contains all the standard operations in one operation group.

More Options (F23)

Use this to display further options.

Note: This is only displayed for single operation groups, where the list contains all the standard operations in one operation group.

More Keys (F24)

Use this to display the Available Function Keys pop-up. You can select functions directly from this pop-up.

Note: This is only displayed for single operation groups, where the list contains all the standard operations in one operation group.

Select an option to display the Standard Operations Maintenance Details window.

Standard Operations Maintenance Mass Update Window

To display this window, select **Update (F8)** on the Standard Operations Maintenance window.

You can use this window to select the operation you want to update. When you select a standard operation, it will be updated across all the routes on which it is included.

Note: This only updates the fields defined to the MASU parameter.

Options

Update without Text (1)

For standard operations to be updated across all routes

Standard operation text is not copied with the update.

Update with Text (2)

For standard operations to be updated across all routes

Standard operation text is copied with the update.

Functions

Bypass (F10)

If you select this, none of the style route operations is updated.

Select **Update (F8)** to update all the route operations listed on window.

Routes and Bills of Materials [2/P1R]

Use this task to create or maintain a route for producing a style.

A route is a series of operations: the route, combined with a list (or bill) of materials. Each material is linked to a specific operation, so that MRP can schedule for future material requirements.

You can vary the quantities of material required on each route by size, or size and fit.

You can define up to 36 alternative routes for one style, so you can create different routes for costing, rough cut capacity planning, design and so on.

There are three tasks that you can use to create and maintain routes and bills of material for your styles:

* Route/Bill of Material
* Use this task to create and maintain standard production planning routes.
* Model Route/Bill of Material
* Use this task to create and maintain model planning routes.
* Maintain Capacity Bill
* This task is part of Master Production Scheduling. Use this task in capacity planning to create a summary capacity route for a style. You can link each operation to a machine representing the total capacity of a group of similar resources.

Multi-plant

If you are using multi-plant, you must define separate routes for each of the plants or lines that you intend to use to manufacture styles.

Routes/Structures Maintenance Selection Window

To display this window, select the Route/Bill of Material task.

Use this window to enter the style and production route to create or maintain.

<u>**Fields**</u>

Style

Enter an existing style.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

The item type must be M (Manufactured) on the Styles record.

Route

Enter the route code. This must be a single alphanumeric character.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Routes & Items pop-up if the Style field has been left blank.

Note: If this is a model planning route, make sure that you have added the route under the VMDR parameter. If this is a live production route, do not define the route under the VMDR parameter. For more information, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Note: If you are defining only one or two routes, make sure they match either the planning or costing routes, or both, that you entered for the style in the Styles task.

Press Enter to display the Style Route Header window.

Style Route Header Window

To display this window, press Enter on the Routes/Structures Maintenance Selection window.

Use this window to enter the route details for the style.

Fields

Receiving Stockroom

Enter the stockroom in which the style is stored when this route is complete.

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

The default is the sourcing warehouse, defined on the Styles record.

If you are using multi-plant MPS planning, this is the receiving stockroom used by a particular plant. You also enter this receiving stockroom for a specific plant in the Maintain Model Stockrooms task.

This information is used to determine which plant uses which planning route.

Note: You can override the receiving stockroom for style variants.

Planning Route

Use this checkbox as follows:

Unchecked - If this route is not the planning route for a particular plant

Checked - If this route is the planning route for a particular plant

In a multi-plant environment, you need to define a separate planning route for each plant, or line, that you use to manufacture styles.

Note: If this route is the planning route, make sure that it matches the planning route set up under Production Details in the Styles task. You can only have one planning route per plant and only one planning route per stockroom.

Unit of Measure

Enter the unit of measure for this style.

Standard Lot Size

Enter the standard lot size that will be produced by this route.

You can enter a numeric value of up to 11 characters, including three decimal places.

Caution: This is critical for backflushed materials, because the software bases production quantities on the requirements to make this lot size.

Note: If you have set the Quantity per Basis field in the company profile to Per 1, you cannot amend this field.

Economic Order Quantity

Enter an economical order quantity (EOQ) to use for the style, when producing amounts using this route. You use this quantity as a default when ordering and making enquiries.

To use the economic order quantity to amortise any fixed costs, set the Fixed Cost Amortisation Basis flag in the company profile to **EOQ**. If you set the flag to **Lot Size** costs, Style breaks down costs over the standard lot size.

Effective From Date

Enter or select the first date on which this route is operational. If you want to use the route on all dates, leave the default of 0/00/00.

Effective To Date

Enter or select the last date on which this route is operational. If you want to use the route on all dates, leave the default of 99/99/99.

Reference

Enter a reference for this particular route. You can enter any text you want.

Average Costing Colour

Enter a colour variant to base average costs for a style on this particular colour.

Note: If you enter a colour variant in this field, you can enter cost weightings for the different sizes produced in the colour. The software costs size variants produced in other colours in the same way. You can enter different cost weightings for size variants, using the Maintain Variant Weighting task.

Average Costing Size/Fit

Enter a size variant here to base average costs for the style on this particular size.

Note: If you enter a size variant here, you can enter cost weightings for the different colours produced in the size. The software costs other colour variants the same way. You can enter cost weightings for colour variants, using the Maintain Variant Weighting task.

Functions

Note: If you are creating a new route, the functions are not displayed until you press Enter.

9BRoute/BOM Maintenance

Update Only (F7)

Use this to update route details without re-calculating lead time. The Routes/Structures Maintenance window is displayed.

Update+Lead Time (F8)

Use this to update route details and re-calculate lead time.

Delete Entire Route (F11)

Use this to delete the route.

Variants/Spreads (F14)

Use this to display the Product Selection pop-up, which you can use to specify which variants of the style to make using this route.

Overrides (F15)

Use this to display the Style/Route Override Selection window, which you can use to define MPS and MRP rules for this route.

Note: This is only displayed for planning routes.

Resources (F16)

Use this to display the Style/Route Resources Maintenance window, which you can use to maintain critical resources for multi-plant planning.

Note: This is only displayed for planning routes.

Text (F21)

Use this to display the Text Maintenance window.

Qty Per Rules (F22)

Use this to display the Quantity Per Rules pop-up.

More Keys (F24)

Use this to display all the functions available on this window.

If you are creating a new route, press Enter to display the Quantity Per Rules pop-up.

If you are maintaining an existing route, press Enter to display the Route Maintenance Operations and Materials window.

Quantity Per Rules Pop-up

To display this window, press Enter on the Style Route Header window. If this is a new route, you must have set up QPER in the CALL parameter. If this is an existing route, select **Qty Per Rules (F22)** on the Style Route Header window.

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Use this pop-up to create the Style matrix that will appear on the Material Quantity Requirements pop-up. You can use the Material Quantity Requirements pop-up to specify the different quantities of material that style variants require.

Depending upon how you set up the style, you must include one or both of the following dimensions:

- Colour
- This dimension refers to the colour code that you set up on the Colour Code Selection window.
- Size
- This dimension refers to the size masks that you set up on the Size Mask Selection window. If you have set up two size masks, for example, size and fit, you can vary material quantities for each size and fit variant.

Example

If you are making leather shoes, the quantity of leather required to make a pair of adult size 10 shoes is much greater than that required to make a child's size 3 shoe on the same route. In this case, you would include Size on the matrix, but you might not include Colour.

Note: This pop-up is not displayed for one-dimensional styles.

Fields

Qty Per

Select one of the following against Colour, Size and Fit:

Note: Only two of the three characteristics may be selected for defining the quantity per rules.

Do not include this dimension (0)

Use this as the Y dimension (1) - That is, the Y-axis on the left side of the matrix

Use this as the X dimension (2) - That is, the X-axis, across the top of the matrix

If you are creating a new route and you enable ITMSEL under the CALL parameter on Maintain Parameter File Details window, press Enter to display the Product Selection pop-up.

Product Selection Pop-up

To display this window, select **Variants/Spreads (F14)** on the Style Route Header window or press Enter on the Quantity Per Rules pop-up.

Use this pop-up to specify the style variants that will be produced by this route. You can also remove the style variants that you do not want to produce on this route.

Note: You can select a single style variant on this pop-up to create a route for a sample.

Fields

Select (Untitled)

Enter **1** against a style variant to include it on this route/BOM.

Functions

Select All (F13)

Use this to select all the style variants.

Left (F19)

Use this to scroll left on the pop-up.

Right (F20)

Use this to scroll right on the pop-up.

If you are creating a new route, enter 1 in one or more of the Select fields to display the Variant Spread pop-up.

Variant Spread Pop-up

To display this pop-up, press Enter on the Product Selection pop-up, or select **Variant Spread (F15)** from one of the following windows:

Style Route Maintenance Operations and Materials window

Style Route Maintenance Materials window

Style Route Maintenance Operations List window

Single Product Operations and Materials window

This pop-up displays the style variants that you have selected for this route on the Product Selection pop-up.

Use the pop-up to specify how you want to spread the demand down to style variant level when making the style using this route.

Note: If this is a planning route, Style uses the quantities that you enter here, where appropriate, to spread forecasts down to full product level.

Fields

Ratio (Untitled)

Enter the ratio of each style variant to produce on this route. For example, if you want to produce 10 of everything and 20 black you can enter **1** for everything and **2** for black.

Functions

Change Matrix (F10)

Use this to change the view of the matrix.

If you are creating a new route and you enable MTLUSG under the CALL parameter on Maintain Parameter File Details window, press Enter to display the Enter Material Usage Factors pop-up.

Enter Material Usage Factors Pop-up

To display this window, press Enter on the Variant Spread pop-up or select **Material Usage Factors (F14)** on one of the following windows:

Style Route Maintenance Operations and Materials window

Style Route Maintenance Materials window

Style Route Maintenance Operations List window

Single Product Operations and Materials window

You can use this pop-up to vary the quantities of material used for style variants. Style uses the information you enter here to calculate the quantity of fabric required to make each variant of the parent style.

Style displays the characteristics either from the dimensions you select in the Qty Per Rules pop-up or from those held under the CALL type parameter in the Parameter file.

Caution: If, subsequently, you change the material usage factors, Style does not re-calculate the quantity pers. You must delete the ratio-based materials and create them again.

Ratio-Based Materials

To make a material ratio-based, set the Material Usage Policy on the Additional Parameters pop-up to **1**, using the Styles task.

<u>Fields</u>

Factor (Untitled)

Enter a factor against the primary style variant you have selected using **Select Primary (F24)**. For the non-primary style variants, enter ratios against the primary.

Note: You cannot enter decimal factors.

For example, for jacket sizes of Small, Medium, Large, Extra Large and Extra Extra Large, you could select Large as the primary and define the following factors:

Size	Factor	Indicating a material usage of:
Small	80	0.8
Medium	90	0.9
Large	100	1
Extra Large	110	1.1
Extra Extra Large	120	1.2

The default is **1**; that is that there is no material requirement difference between size variants.

Functions

Window Left (F19)

Use this to scroll left.

Window Right (F20)

Use this to scroll right.

Select Primary (F24)

Use this to select the primary size to which the factors relate.

To identify the mid-point factor, enter a primary factor against this primary variant.

Enter a non-decimal factor against each characteristic to identify how the material quantities vary from the mid-point factor.

If you are creating a new route, press Enter to display the Style Route Maintenance Operations and Materials window.

Style/Route Override Selection Window

To display this window, select **Overrides (F15)** on the Style Route Header window. The route must be live.

Use this window to define different MPS and MRP rules for a planning route. You can enter an effectivity date range to limit the changes to a particular period.

For multi-plant production, you can have different order policies for different plants.

Note: Style/Route overrides do not apply to model planning routes. If you have not overridden MPS and MRP rules for this route, a warning message is displayed.

Options

Select

Use this to maintain existing overrides for this effectivity date range. The Style/Route Override Maintenance window is displayed.

Functions

Add (F10)

Use this to display the Style/Route Override Maintenance window.

Select a route to display the Style/Route Override Maintenance window.

Style/Route Override Maintenance Window

To display this window, select a route on the Style/Route Override Selection window.

Alternatively, select **Add (F10)** on the Style/Route Override Selection window.

Use this window to override, for this route only, the existing MPS and MRP details that you set up for the style in the Styles task.

You can update at style level and style variant level.

Fields

Effective From/To

Enter or select the first date and last dates on which these overrides will be effective.

Untitled

Enter a description for the override, using up to 35 alphanumeric characters.

Item Type

Enter an item type. This is a general classification of use for this style or material.

Enter one of the following:

M - For production items, for example styles, finished goods, or intermediates used in the production of a style

P - For purchased items or materials, for example: lace, leather, cotton, silk, nylon, and linings

B - For bought out items, for example: buttons, zips, hangers, suit covers, and packaging materials such as: boxes and laces

T - For consumable tools, for example: knitting needles, blades and pins

Item type codes are defined in the Parameter file, under type PITP.

You can use the prompt facility to select from the PITP Item Type pop-up.

Planner

Enter a planner code to organise items into categories for management and planning. For example, you can use the planner code to designate the production planner or buyer responsible for controlling the item.

The planner code is used to sort Production Scheduling and Material Planning reports, and as a selection parameter on planning enquiries. Therefore, a planner can have fast access to schedules for items under his or her control.

Planner codes are defined in the Parameter file, under type PLAN.

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

Min Order Qty

Enter the minimum order quantity. This is used with order policies B and H in MPS and MRP, to set the minimum quantity for a suggested supply order.

Demand Policy

Enter the demand policy to use when comparing sales, forecasts and dependent demand to calculate a net demand for MPS and MRP.

The Consume Forecast flag in the company profile controls how you calculate forecast demand. It affects those policies that utilise planning or external forecasts. The Consume Forecast flag allows you to adopt either a discrete comparison or a cumulative consumption.

Demand policy codes are defined in the Parameter file, under type MPFF.

You can use the prompt facility to select from the MPFF Planning - Demand Policy pop-up.

Code	Description	Demand Definition
0 / blank	Total actual demand	Sum of sales orders + dependent demand; no forecast
1	Forecasts compared with independent demand	Greater of (forecast or sales orders) + dependent demand.
2	Forecasts compared with total demand	Greater of (sales orders + 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: Sum of forecasts + sales orders + dependent demand.

Max Order Qty

Enter the maximum supply order quantity to use.

Smoothing Policy

Enter a smoothing policy, if required.

Alternatively, use the prompt facility to select from the FPOL Levelling Policy pop-up.

Mult Order Qty

Enter a multiple order quantity, to be used with order policy code H. The suggested order value is increased by increments of the multiple above minimum order quantity, to meet the demand.

No. of Days Supply

If you are using order policy **G**, enter a number of days supply. MRP can project requirements a number of days forward to determine the requirement.

Fixed Order Qty

Enter a fixed order quantity to use with order policy D. This quantity is used by MPS and MRP to generate suggested supply orders. If the requirement is greater than the fixed quantity, additional batches of the fixed quantity are ordered until the requirement is met.

Safety Stock

Enter a quantity of safety or buffer stock that should always be maintained. This is the target Inventory level maintained by MPS and MRP.

Order Policy

MPS and MRP use the order policy to suggest supply orders.

Enter one of the following:

A - Discrete

This generates a suggested order quantity equal to the demand quantity.

B - Discrete above minimum

This generates a suggested order quantity, at least as large as the minimum order quantity. If the requirement is less than the minimum, the suggested order is equal to the minimum order quantity.

D - Fixed quantity

This creates one or more orders of a fixed quantity, to meet all the requirements.

G - Number of days' supply, or period cover

This accumulates forward requirements over a specified number of days and generates a single order to satisfy the total demand.

H - Multiples above minimum

This generates a suggested order quantity for the minimum order quantity and then adds increments of the defined multiple order quantity to meet any outstanding requirement.

Note: If you have defined the standard style to use Order Policy I, set the order policy to H for the variants.

Note: For the multiple order quantity use either the same value, or a direct division, of the style level.

I - Multiples up to a maximum

This compares the total of the style variants with the multiple and maximum order quantities defined for the style. If this total exceeds the maximum order quantity, this policy splits the order into two or more separate orders. If the total is not divisible by the multiple, this policy brings back later supply until the next multiple is reached.

J - Variable Batch Quantities

You define codes in the Parameter file, under type POPC.

You can use the prompt facility to select from the POPC Planning - Order Policy pop-up.

Functions

Delete (F11)

Use this to delete an existing override record. You must select **Delete (F11)** to confirm the deletion.

Variants (F16)

This is not displayed until you select **Update (F8)** at style level. The Multiple Item Selection pop-up is displayed and you can enter the details for each variant level.

Var Qty (F23)

Use this to display the Variable Batch Order Quantities pop-up.

Press Enter to display the Style/Route Override Details window.

Multiple Item Selection Pop-up

To set up Order Policy overrides for an SKU, select **Variants (F16)** on the Style/Route Override Maintenance window. Remember that you can only select this if an override already exists.

Use this pop-up to select a single SKU or a number of SKUs to be processed with different Order Policy requirements.

Select each required SKU with 1 and then press Enter to display the Maintain MPS & MRP values at SKU window.

Maintain MPS & MRP Values at SKU Window

To display this window, select each required SKU with 1 and then press Enter on the Multiple Item Selection pop-up.

The following order policy overrides can be maintained for the selected SKU/route:

- Order Policy
- Minimum Order Quantity
- Maximum Order Quantity
- Multiple Order Quantity
- Fixed Order Quantity
- Safety Stock
- Number of Days Supply

If Order Policy **J** is entered, a pop-up is displayed to enter the required variable batch quantities for the SKU.

Note: Initial values are defaulted from any already defined at SKU level via the Maintain Order Policy Overrides task. If none are defined for the selected SKU, the values are defaulted from the values set up for the style on the selected route.

Caution: Order policy I is only valid at style level. Entry of SKU level quantities when the order policy is set to I is not allowed.

Functions

Update (F8)

Use this to update each SKU in turn and display the next SKU for input. When all selected SKUs have been processed, the Planning Override Maintenance window is displayed. Select **Update (F8)** to update.

Caution: If you select **Previous (F12)** on the Planning Override Maintenance window, any order policy override changes made at SKU level are lost.

Variable Batch Order Quantities Pop-up

To display this pop-up, select **Var Qty (F23)** on the Style/Route Override Maintenance window.

Use this pop-up to enter the variable batch quantities.

Fields

Route

This field displays the selected route.

Rounding

Select one of the following:

Rounding Up (0) - To round up the required supply quantity to the nearest batch quantity

Rounding Down (1) - To round down the required supply quantity to the nearest batch quantity

Effective From/To

These fields display the route override effective date range.

Quantities

Enter up to 10 quantities to define the variable batch sizes. The quantities must be positive and in ascending sequence and at least two quantities must be entered.

<u>**Functions**</u>

Delete (F11)

Use this to delete the batch quantities. A confirmation pop-up is displayed. Select **Delete (F11)** to confirm the deletion. This function is only available if variable batch quantities already exist for the route override.

Select **Update (F8)** to save the details and return to the Style/Route Override Maintenance window.

Style/Route Override Details Window

To display this window, press Enter on Style/Route Override Maintenance window.

Use this window to define MPS and MRP rules for this route only. You can also apply special conditions to the re-scheduling policy used during MPS and MRP processing.

<u>**Fields**</u>

MPS/MRP Filter

Enter a re-scheduling policy to override the default, for this route only.

Alternatively, use the prompt facility to select from the WTYP Planning Filter pop-up.

Note: The MPS/MRP filter forms the third character of the codes set up under the WTYP parameter on the Maintain Parameter File Details window.

Production Lead Time

Enter a lead time. This overrides the production lead time you set up for the style using the Styles task.

The lead time is the time in days required to produce the style from its raw materials.

When you run MPS and MRP, you can select the Use Item Time Fence option instead of the default global option. If you do choose this, Style uses the production lead time to calculate the frozen schedule time fence.

Cumulative Lead Time

Enter a cumulative lead time. This overrides the cumulative lead time you set up in the Styles task.

The cumulative lead time is the total time required in days to produce the item based on a full explosion of its planning route. This includes any low-level production items included on the route, as well as the purchasing lead time of materials and any bought out components.

The longest part, or critical path, of the production and procurement process defines the cumulative time.

If you select the Use Item Time Fence option, when using MRP or MPS, in preference to the default, the production lead time is used to establish the planning horizon for the item. For non-production items, the calculation returns the purchasing lead time.

Major Sequence

Enter a major sequence. This overrides the major sequence you set up for the style on the Additional Parameters pop-up.

You can group items under a common heading to plan and schedule them together.

You can set up entries under major type PRSQ in the Parameter file. This is a user-defined parameter.

Minor Sequence

You can enter up to six characters to override the minor sequence you set up for the style using the Styles task.

Use this field to determine the sequence in which you process items at a machine. The field has several uses.

For example:

- If you have a mixing process, where products range in colour from light to dark, you can sequence light-coloured items ahead of dark-coloured items.
- You can sequence items with a long set-up time ahead of, or following, items with short set-up times.
- You can sequence high-quality output ahead of low-quality output.

Use this field in conjunction with the Major Sequence field to group similar items for planning and scheduling together. The minor sequence code sequences the processing of items within the group.

Functions

Calc. Production Lead Time (F19)

Use this to calculate the production lead time, in days, from the materials making up the style. You cannot see the results of the calculation here, but the styles are updated.

Calc. Cumulative Lead Time (F20)

Use this to calculate the total time, in days, to produce the style based on a full planning route. You cannot see the results of the calculation here, but the styles are updated.

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

Style/Route Resources Maintenance Window

To display this window, select **Resources (F16)** on the Style Route Header window.

If you use multi-plant planning, use this window to define critical resource requirements for style routes. You must do this to consume the critical resource capacity; otherwise only the primary route is used.

You can link multiple resources to an effectivity date range.

Fields

Select

Select **Delete** against an effectivity date range to delete it.

Sequence

Enter a numeric sequence that determines the order in which resources appear, regardless of their effectivity.

Effective From Date

Enter or select the first date on which resources will be effective.

Effective To Date

Enter or select the last date on which the resources will be effective.

Resource Code

Enter the code used to identify the resource. You must set up the codes using the Critical Resources task.

You can use the prompt facility to select from the Select Resource Code pop-up.

Production Rate

Enter the number of UOMs of the resource you need to make the standard lot quantity of the style.

UOM

This displays the capacity unit of measure from the critical resource definition.

Select **Update (F8)** to save the details.

Style Route Maintenance Operations and Materials Warning Message Window

To display this window, press Enter on the Enter Material Usage Factors pop-up.

Use this window to select the way in which you will create operations for this route.

Press Enter to create a new operation, using the Style Route Maintenance Operations and Materials window.

Select Copy From **Style Route (F16)** to display the Select Operation Group pop-up.

Select Copy From **Standard Operations (F17)** to display the Copy from Route pop-up.

Style Route Maintenance Operations and Materials Window

To display this window, press Enter on the Style Route Header window.

This window displays the operations defined to this route. If you have not attached operations to the route yet, the window is blank.

Note: The setting of the STYL parameter on the Maintain Parameter File Details window determines what functions and options are available from this window.

Options

Maintain Record

Use this to maintain an existing operation.

This displays the Style Route Operations Details window.

Add Operation Before

Use this to add a new operation before the current operation.

This displays the Style Route Operations Details window.

Add Operation After

Use this to add an operation following the current operation.

This displays the Style Route Operations Details window.

Delete Operations/Materials

Use this to delete an operation.

You must confirm this.

Associate Style/Material

You can only use this for a material

Use this to display the Associate pop-up for you to link individual style variants with their material characteristics.

Material Quantity Requirements

You can only use this for a material.

Use this to display the Material Quantity Requirements pop-up.

Add Material

Use this to add a material to an operation.

This displays the Material Maintenance pop-up.

Note: You can maintain or delete multiple detail lines by selecting more than one item.

Functions

Update (F7)

Use this to update operation details but not re-calculate lead time.

Upd & Lead Time (F8)

Use this to update operation details and re-calculate lead time.

Position to Operation (F13)

Use this to enter the operation sequence number from which to start the display.

Material Usage Factors (F14)

Use this to display the Enter Material Usage Factors pop-up, on which you can specify how to distribute quantities of material amongst style variants.

Variant Spread (F15)

Use this to display the Variant Spread pop-up, on which you can specify how you wish Style to distribute quantities for each of the style's variants when creating a production order.

Copy from Route (F16)

Use this to display the Copy from Route pop-up, on which you can copy operation(s) from an existing route.

Copy from Standard Operations (F17)

Use this to copy operations from an existing operation group.

Reseqence (F18)

Use this to re-sequence operations and materials following insertion or deletion. Operations and materials will be re-sequenced in standard increments of 10.

Materials Only List (F19)

Use this to display the Style Route Maintenance Materials window.

Operations Only List (F20)

Use this to display the Style Route Maintenance Operations List window.

Operations and Materials List (F21)

Use this to display the Style Route Maintenance Operations and Materials window.

Selective View of Route (F22)

Use this to request a selective view of the route for one specific style variant.

More Opt. (F23)

Use this to display the Available Options pop-up, which lists all the options available.

More Keys (F24)

Use this to display all the functions available from this window.

Style Route Operations Details Window

To display this window:

If this is a new route, press Enter on the Style Route Maintenance Operations and Materials Warning Message window.

For an existing route, select Maintain Record, Add Operation Before or Add Operation After on the Style Route Maintenance Operations and Materials window.

Use this window to maintain the primary operations on the route. Primary operations are the default operations that you use on the route to make the style variants.

Style uses primary operations to calculate costs at style level. Therefore, for the primary operation, you should select the average details. For example, if you are defining operations for Small, Medium and Large sizes, you should relate the primary operation definition to the Medium size.

Field Protection

You can protect any of the fields on this window through the MASU parameter. For more details, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Variant Operations

You can set up a variant operation to produce one or more style variants in a different way from the primary operation. To set up variant operations for specific style variants, select **Variant Opn. (F23)** to display the Maintain Variant Operations pop-up.

You assign variant operations a variant sequence number, within the sequence number for the primary operation.

For example, consider the following production matrix:

Colour \ Size	6	17	28
Red	1	1	1
Blue	1	1	1
Green	1	1	1

At operation 10, say, the time taken to make a size 28 is significantly longer than that taken to make a size 17 and considerably shorter than to make a size 6. Therefore, you could define variant operations as follows:

- Define the primary operation to produce a size 17.
- Define a variant operation (0010) for size 6.
- Define a variant operation (0020) for size 28.
- Select **Characteristics (F24)** on this window to display the Operation Characteristics Values pop-up and select size 17.
- Select **Variant Opn (F23)** on this window to display the Maintain Variant Operations pop-up. Select **Values** against variant operations 0010 and 0020 and select sizes 6 and 28 respectively.

Subcontracted Operations

You can define primary operations and variant operations as subcontracted operations.

If a route is to include one or more subcontracted operations, make sure that the route satisfies the following conditions:

- The first and last operations on the route must be in-house operations. However, you can create a dummy count point operation at which to register the work-in-progress to ship.
- Both the subcontracted operation and a prior operation must be count points.
- The last operation on the route must be a count point.
- The previous operation must not be a backflushed operation.

In addition:

- Any materials that are required by the subcontractor to complete the operation should have a material control policy of **1** (Backflushed). Set up the material control policy on the Production Details window in the Styles task.
- Since scheduling routines do not use this time, you must record the expected duration time of the subcontracted work by entering the default move days. Move days is the time that WIP takes to move from the previous operation to the subcontractor and received back to the subcontracted operation.
- You can define consecutive subcontracted operations and use Style to monitor progress at each progressive operation. Alternatively, you can separate subcontracted operations with on-site operations, including intervening backflushed operations if required.

Caution: Do not attach a cost centre to the machine on a subcontract operation.

To subcontract an operation, do the following:

- Set the Key Operation field to **2** or **3**.
- Select **Addit. Parameters (F22)** and set up the following fields on the Additional Operation Values pop-up:
- Sub-Contract
- Sub-Contract Cost
- Sub-Contract Supplier

Bundling Up Point

To create bundle tickets for an operation, you need to define the previous operation as a bundling-up point.

You can either identify an existing operation as a bundling-up point or add a new operation for bundling-up only. For example, you could add a bundling-up point between the cutting and sewing operations.

To make an operation into a bundling-up point:

- Select **Additional Parameters (F22).**
- On the Additional Operation Values pop-up, set the Operation Type field to **9**.

Formula Codes

You use formula codes to point to user-defined programs containing calculations. You need to set up the formula codes with the ALLW parameter in the Maintain Parameter File task. To use formula codes to re-calculate labour time and machine time, select **Time Calcs (F16)** on this window. This can also re-calculate the SET-UP Labour Time field on the Additional Operation Values pop-up.

If you choose to use formula codes, adopt one of the following methods only:

- On this window, select **Time Calcs (F16)** on individual style route operations. In this case, set Formula Codes to **0** under the MASU parameter.
- Alternatively, perform re-calculations via a mass update from the Standard Operations Maintenance Mass Update window. In this case, set Formula Codes to **2** under the MASU parameter.

For more information about the MASU parameter, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Fields

Style

This field displays the style for which you are maintaining a route.

Operation Sequence

This field displays the position of the operation in the style.

Route

This field displays the route that you are creating or maintaining.

Std Lot Size

This field displays the standard lot size entered on the Style Route Header window.

Operations Code

Enter a code to help identify the operation. The operations code appears on:

- The style route list
- The bundle tickets
- Most enquiries and reports that include the operation
- Any variant operations of this primary operation

Machine Quantity

Enter the number of machines to use for this operation. This helps to determine the operation lead time.

For example:

If an operation requires 10 hours of work, that is a 10-hour lead time on one machine. If five machines are available and do the work simultaneously, you only require a reduced lead time of two hours.

Note: If you enter a machine with a default shift profile in the Machine field, enter a machine quantity that does not exceed the standard capacity factor. You define this factor in the Machines task.

Note: Alternatively, if you enter a machine without a default shift profile in the Machine field, enter a machine quantity that does not exceed (Std Capacity divided by Std Length). You can define Std Capacity and Std Length in the Machines task.

Operation Description

Enter a description to appear on the style route list. Style uses this description for any variant operations that you define for this primary operation.

Machine

Enter the standard machine that this operation will use.

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

Note: If you specify a work centre in the Work Centre field, you can leave the Machine field blank. In addition, if you do enter a machine in the Machine field, as well as a work centre in the Work Centre field, the machine must be a member of that work centre.

Work Centre

Do not enter a work centre in the Work Centre field if the machine belongs to more than one work centre. If you do, you limit the types of analysis available.

Enter the work centre that this operation will use.

Alternatively, use the prompt facility to select from the Select Work Centre pop-up.

If you do not enter a machine in the Machine field, the first machine in the work centre sequence is used to calculate capacity loading and costing. If you change the work centre definition, this machine is used for the operation.

Note: If you specify a machine in the Machine field, you can leave the Work Centre field blank.

Bundle Ticket Type

Enter a bundle ticket type to associate with the operation. This is the standard bundle ticket for planning purposes.

Alternatively, use the prompt facility to select from the Bundle Ticket Type Window pop-up.

When you print bundle tickets for a production order, the tickets include all the operations that you have associated with the bundle ticket.

Note: The bundle ticket's search family must match the search family set up for the style. If you enter a bundle ticket type for a primary operation, you must also enter a bundle ticket type for all variant operations. For bundle tickets to print, you must have defined a bundling-up operation earlier in the route sequence. You cannot record a bundle ticket type against an operation defined as a bundling-up operation (see Operation Type).

Reporting Type

This field indicates whether the operation is a count point or a backflushed operation.

Enter one of the following:

0 (default) - Count point type A

1 - Count point type B

2 - Backflushed operation type A

3 - Backflushed operation type B

Note: A complete short or over operation must be a count point. To mark an operation as complete short or over, set the Operation Type field to 8 on the Additional Operation Values pop-up. A bundle-up operation must also be a count point, as must the last operation. There is no functional difference between types 0 and 1 (count point) and 2 and 3 (non-count point). You can apply more meaningful descriptions to these codes if you want to distinguish between two types of count points and backflushed operations.

You maintain codes in the Parameter file, under type RPNT.

You can use the prompt facility to select from the RPNT Reporting Types pop-up.

Reporting Level

Use this field to choose the level of operation booking detail at which you wish to report.

Enter one of the following:

0 - To report at style level

1 - To report at style/colour level

2 - To report at style/size level

3 - To report at style/colour/size level

You can report on different operations at all the reporting levels throughout the production process.

However, once the production process has reached a certain reporting level, it is not possible to return to a previous level. You can either stay at the same level or progress to the next level.

As an example, assume that you are making shirts in a range of colours and sizes:

- Report Operation 10 at style level means that you lay out all the material ready for working.
- Report Operation 20 at style/size level as you separate all the various sizes.
- Report Operation 30 at style/colour/size level as you dye the finished shirts.

Note: You cannot report at both style/colour and style/size levels on the same route.

Note: If you are mixing colours within a bundle, as defined on the Characteristic Mix Rules pop-up in the Bundle Ticket Types task, do not set the Reporting Level field to 1. If you are mixing sizes, do not set the Reporting Level field to 2.

Note: You must report the last operation on the route at full product detail level. That is, style/colour for styles without sizes; style/colour/size for styles with sizes.

Note: If you have set the Operation Type field on the Additional Operation Values pop-up to 8 (Complete Short/Over), you must set the Reporting Level field to the highest level possible for the number of dimensions for the style.

Key Operation

This field is important if you are subcontracting the operation.

Note: You can only define key operations at count points.

A route may comprise a large number of operations. Therefore, it makes sense initially to limit the number of operations that appear on enquiries and reports. To select an operation for display, mark the operation as a key operation.

Enter one of the following:

0 - Only to display the operation on request

1 - Always to display the operation on all enquiries and reports

2 - To raise and display subcontract purchase orders

This operation is displayed on all enquiries and reports. Only use this setting for subcontracted operations. When you release the production order, a purchase order is generated for any subcontracted work.

3 - To raise and display the purchase order and lot

The operation is displayed on all enquiries and reports. When you book the operation, a purchase order is raised for subcontracted work and you must enter a WIP lot number. You can make the lot number specific to the subcontractor, or supplier.

4 - To display the lot and update point

The operation is displayed on all enquiries and reports. You must enter a WIP lot number. If you are using lot tracking, you can change the tracked WIP lot number.

You define these operation codes in the Parameter file, under type CROP.

You can use the prompt facility to select from the CROP Key Operations pop-up.

Lab Profile

Enter a labour profile to identify the labour skills required by the operation, and the number of operators needed. The number of operators defined in this labour profile overwrites the value entered in the Team Size field.

You can use the prompt facility to select from the Labour Profile Selection pop-up.

Labour Time

Enter the standard run labour time per lot for this operation. Use the units defined in the Time Basis Code field on the Additional Operation Values pop-up.

The labour time is used to calculate the load on labour.

You calculate duration time using the operation quantity and labour rate. Allow for wastage at various operations on the route.

The software also uses this time to calculate standard costs for the operation.

Formula Code (Labour)

Enter an allowance formula code, as defined under the ALLW parameter in the Maintain Parameter File task. This code should point to a user-defined program that contains a calculation. To use this calculation in re-calculating the labour time entered above, select **Time Calcs (F16)**.

You can use the prompt facility to select from the ALLW Allowance Formula pop-up.

Machine Time

Enter the standard run machine time per lot for this operation in the units defined in the Time Basis Code field on the Additional Operation Values pop-up. The operating unit description displays for reference next to the input field.

Style uses the machine time to calculate the load on hard resources.

Style calculates the duration of the operation from:

- The operation quantity, after accounting for wastage at this and all subsequent operations
- The machine rate

The duration can be an element of the total lead time for this operation on this route. The Duration Basis field on the Additional Operation Values pop-up determines whether or not to use this field when scheduling the operation.

Machine time is part of the operation standard costs calculation.

Formula Code (Machine)

Enter an allowance formula code, as defined under the ALLW parameter in the Maintain Parameter File task. This code should point to a user-defined program that contains a

calculation. To use this calculation in re-calculating the machine time entered above, select **Time Calcs (F16)**.

You can use the prompt facility to select from the ALLW Allowance Formula pop-up.

Team Size

This field displays the run labour team size. Enter the standard number of operators assigned to this operation. This affects capacity.

Costing and the Capacity Requirements Planning software use the Team Size field to work out the standard labour requirement for this operation.

You can enter a decimal team size to represent an operator who manages more than one task or machine at this operation.

Note: If you enter a labour profile, this field is overwritten with the number of operators effective in the labour profile.

Move Days

Enter the move time between operations to aid capacity planning. This value includes the time that the materials sit between machines.

Use Move Days when scheduling to determine planned operation start and finish dates.

Wastage %

Operation wastage is the planned rate of product loss from the process at this operation.

Style uses the wastage percentage to calculate the required level of machine, labour and material resource, based on the standards you have specified to achieve the desired output.

In addition to operational losses, you also monitor losses of component materials through a wastage percentage associated with each material. This is defined on the style route.

Caution: The implications of the use of this field are significant. During planning, Style will over provide to compensate for the expected loss.

Note: During costing, the parent style is costed at the inflated operation standards and extended quantity per requirements for material inputs. The software spreads the resultant extended costs over the standard lot size *for the process, to obtain a standard unit cost.*

Step

Use this field, when adding operations, to increase or decrease the increment for the operation sequence number.

Specification ID

You can enter a unique ID for this operation.

If you later change an operation that is included in many routes, you can update all style route operations with the ID, instead of changing the operations individually.

Functions

The functions available on this window depend on whether you are adding or maintaining operations.

User Pgm (F15)

Use this to call a user-developed program defined under the USER parameter in the Maintain Parameter File task, and to display new field values returned by the program.

*Note: The USER parameter allows you to define a program separately for primary operations and variant operations. **User Pgm (F15)** is only displayed if you have defined the appropriate user program for this type of operation.*

Time Calcs (F16)

Use this to re-calculate the values entered in the Labour Time and Machine Time fields on this window. It also re-calculates the SET-UP Labour Time on the Additional Operation Values pop-up.

Note: This function is available only if you have defined one or more user programs under the ALLW parameter to perform the re-calculation. For more information, refer to the Maintain Parameter File section in the Utilities chapter of this product guide. If you are maintaining a standard operation, this function is not available.

Op. Text (F21)

Use this to display the Text Maintenance window, which you can use to enter additional operation text for production orders.

Additional Parms (F22)

Use this to display the Additional Operation Values pop-up.

Variant Opn. (F23)

Use this to add a variant operation. This displays the Maintain Variant Operations pop-up. This is not available if you are creating the primary operation.

Characteristics (F24)

Use this to display the Operation Characteristics Values pop-up. This is not available if you are creating the primary operation.

Press Enter to validate the information and return to the Style Route Maintenance Operations and Materials window.

Maintain Variant Operations Pop-up

To display this window, select **Variant Opn. (F23)** on the Style Route Operations Details window.

You can use this pop-up to enter the code for this variant operation.

Across the top of the pop-up, the details for the primary operation are displayed. *ALL is displayed in the variant columns to show that the primary operation affects all variants of this style.

Fields

Variant

This field displays the variant operation code.

Note: The following two fields depend on the variants you have set up for this style.

Colour

If this operation affects the colour variant, it is displayed here. If it affects more than one, **MANY** is displayed; if it affects all the colour variants, ***ALL** is displayed.

Size

If this operation affects the size variant, it is displayed here. If it affects more than one, **MANY** is displayed; if it affects all the size variants, ***ALL** is displayed.

Enter Variant to Maintain

Enter the variant operation to create or maintain.

Options

Select

Use this to display the Variant Operation Maintenance window.

Values

Use this to display the Operation Characteristics Values pop-up.

Delete

Use this to delete this variant from the route.

Enter a new variant or select an existing variant to display the Variant Operation Maintenance window.

Variant Operation Maintenance Window

To display this window, enter a new variant operation number or select a variant on the Maintain Variant Operations pop-up.

Use this window to define the variant operation to the route, or update an existing variant operation.

The fields on this window work in the same way as those on the Style Route Operations Details window. The Variant field displays the number of this variant operation.

Caution: You must select which style variants the new variant operation is going to produce. To do this, select **Characteristics (F24)** to display the Operation Characteristics Values pop-up.

Fields

Note: Please refer to the Style Route Operations Details Window section for a full description of the fields on this window.

Variant

This field displays the sequence number assigned to the variant operation. You cannot update it.

Step

You can only use this field when adding operations. You use it to increase or decrease the increments in which you add sequence numbers assigned as operations.

<u>**Functions**</u>

User Pgm (F15)

Use this for a user-developed program. Refer to the Style Route Operations Details Window section for further information.

Time Calcs (F16)

Use this to re-calculate the values entered in the Labour Time and Machine Time fields.

Additional Parameters (F22)

Use this to display the Additional Operation Values pop-up.

Characteristics (F24)

Use this to specify which individual variants of the whole style will use this operation. The Operation Characteristics Values pop-up is displayed,

Note: If you are maintaining an operation as a variant of a standard primary operation, this function is not available.

Press Enter to validate the data you have entered and enter the next variant. Select **Previous (F12)** to return to the Style Route Operations Details window.

Operation Characteristics Values Pop-up

To display this window, do one of the following:

If the current operation is a primary operation, select **Characteristics (F24)** on the Style Route Operations Details window.

If the current operation is a variant operation, select **Characteristics (F24)** on the Variant Operation Maintenance window.

If the current operation is a variant operation, select Values against a line on the Maintain Variant Operation pop-up.

Select **Characteristics (F24)** on the Style Route Enquiry Operations window. This is useful when enquiring on a single variant.

Use this pop-up to specify the style dimensions whose characteristics you want to mark as the style variants produced by the current operation.

Caution: If you do not specify which style variants you want the primary operation to produce, Style uses the same primary operation for all style variants, even if variant operations exist.

> Therefore, select the style variants that the primary operation does produce and then select the style variants that each separate variant operation produces.

<u>Fields</u>

Select

Use this field to specify the dimensions to include. If you want to include all the characteristics, leave the dimension blank.

For example, if you leave the colour dimension blank, this operation will make all the colour variants.

Enter **1** against a dimension to display the Select Values pop-up, which you can use to select characteristics for that dimension.

Enter 1 against a dimension and then press Enter to display the Select Values pop-up.

Select Values Pop-up

To display this pop-up, enter 1 in the Select field and then press Enter on the Operation Characteristics Values pop-up.

Use this pop-up to define the variants of the style dimension this primary or variant operation will produce.

The pop-up displays characteristics of the dimensions that you selected on the Operation Characteristics Values pop-up.

<u>Fields</u>

Select

Enter **1** against each characteristic to select.

Press Enter to save the values and to return to the Operation Characteristics Values pop-up

Associate Pop-up

To display this pop-up, select Associate Style/Material on the Style Route Maintenance Operations and Materials window or press Enter on the Relate Material to Style Characteristics pop-up.

Having specified which style dimensions you want to match to which material dimensions, use this pop-up to associate style variants with material characteristics.

For example, if you selected colour on the Relate Material to Style Characteristics pop-up, you can now define which material colour relates to which style colour.

This pop-up may be displayed more than once, depending upon how many dimensions you selected on the Relate Material to Style Characteristics pop-up.

For example, on the Relate Material to Style Characteristics pop-up, you might specify that shoelace colours vary with shoe colours. You would use this pop-up to relate shoe colour to shoelace colour. For example, you could specify beige laces on beige, black and blue shoes and burgundy laces on brown and burgundy shoes.

Fields

Style Colour

This field displays the colour of the style.

Material Colours

This field displays the material colour and size. Enter the code for the required size or colour of material against each style colour or size.

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

Material Colour/Size (Untitled)

Enter one of the following in one field in each row:

0 or Blank - Not to associate a material characteristic with the style characteristic on this row

1 - To associate the style characteristic on this row with this material characteristic

Note: Do not leave a line completely blank. If you are not using the material for a style characteristic, enter 0 under one of the material characteristics in the right box.

Functions

Window Left (F19)

Use this to scroll left.

Window Right (F20)

Use this to scroll right.

Press Enter to display the Material Quantity Requirements pop-up.

Material Maintenance Pop-up

If you are adding a new operation, to display this window, select Add Material on the Style Route Maintenance Operation and Materials window or on the Style Route Maintenance Materials window.

If you are updating an operation, select Maintain Record against a material on the Style Route Maintenance Operations and Materials window, or on the Style Route Maintenance Materials window.

Use this pop-up to identify the materials to use at each operation. The operation number and the material sequence number are displayed.

Fields

Operation

This field displays the sequence number of the operation to which you are adding a material.

Sequence

This field displays the unique number applied to a material when added to an operation. This field is sometimes displayed as the InSq field (input sequence) or Csq field (component sequence).

Material

Enter the material to add.

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

Note: If you checked the Allow Duplicate Items on Operation field in the company profile, you can include the same material against different sequence numbers at the same operation. Otherwise, you can only specify each material once on an operation.

Material Type

This field displays the material type set up for this material on the Additional Parameters pop-up.

Note: You cannot update the Material Type field here.

Issuing Stockroom

Enter the stockroom that is to issue this material.

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

You must have assigned the stockroom to the material already, using the Styles task.

If you leave this field blank, the default stockroom is used.

All material requirements planning using this stockroom places a requirement on the stockroom for the material.

Quantity Per Lot

Enter the standard quantity of material required at this operation to produce the parent standard lot size. If you make the parent style in lot sizes greater than 1, enter the quantity required per lot. Enter the quantity in terms of the issuing unit of measure used in the issuing stockroom. The software uses the quantity per lot when calculating the cost of the style.

Style uses the Quantity Per Lot field according to how you have set the material's Material Usage Policy on the Additional Parameters pop-up in the Styles task:

- If it is set to **0** (Qty Per Based), the Quantity Per Lot value is used as a default for all material variants.

- If it is set to **1** (Ratio Based), the Quantity Per Lot value is used as the quantity per for the primary variant. To calculate quantities, Style uses the factors that you set up on the Enter Material Usage Factors pop-up.

Fixed Quantity Per

Use this to specify whether or not the quantity per varies per standard lot size.

Use this checkbox as follows:

Unchecked - If the quantity required varies in proportion to the quantity of the parent

Checked - If a constant quantity, the number entered in the Quantity Per field, is always be the requirement quantity, regardless of the standard lot size of the parent

Note: If you check this field, it invalidates wastage.

Unit of Measure

This field displays the unit of measure for the item in the issuing stockroom.

Wastage %

If this material is subject to wastage, enter the percentage you expect to lose or waste at this operation. The software uses the percentage to plan the correct amount of available material in order to achieve the target quantity. When costing, you can choose to include wastage as part of the standard cost roll-up to establish the correct material usage.

You apply the material wastage percentage after operational wastage reduces the operation quantity. You define the operational wastage at machine level.

Note: If you checked the Fixed Quantity Per field, the percentage you enter here is not used.

Operation Type Use

This field displays one of the following values to indicate the operation type.

8 - Complete short/over operation

Where there is a surplus or shortfall, a completed quantity on this operation adjusts subsequent planned production order quantities.

9 - Bundle-up operation

This operation is a point where you bundle WIP up before proceeding to the next operation.

Change Reference

Enter a reference to group together all the materials you amend, delete, or add as a result of a change in the production process. You only enter upper case characters in this field.

Effective From Date

Enter or select the first date on which this material will be used at this operation. To use the material on all dates, leave this at 0/00/00.

Effective To Date

Enter or select the last date on which the material will be used at this operation. You can leave the default of 99/99/99 if the material is to be used indefinitely.

Material Usage Policy

This field displays the materials that have various characteristics. You can set this up on the Additional Parameters pop-up in the Styles task.

Key Material

This field is displayed when you add a lot-controlled material. This is used to define the materials that carry a lot number. You use this lot number to track work-in-progress and finished goods.

You can only define one effective key material per route.

Note: Only use lot-controlled material, which means a material control policy of 3 (Issue to Floor Stock), as key material.

Functions

Relate Material to Style (F14)

Use this to display the Relate Material to Style Characteristics pop-up.

If the material only has one dimension, press Enter to return to the Style Route Maintenance Operations and Materials window. If there is more than one, the window is re-displayed so that you can enter the material details for each dimension.

Relate Material to Style Characteristics Pop-up

To display this pop-up, select **Relate Material to Style (F14)** on the Material Maintenance pop-up.

Fields

Enter Fixed Attribute

Enter a value.

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

Associate with Characteristic(s)

Select one or more style characteristics to associate with each material characteristic, or enter a fixed attribute.

Use these checkboxes as follows:

Unchecked - Not to select the style characteristic

Checked - To select the style characteristic

Select Quantity Per Rules

Enter one of the following against Colour, Size and Fit:

Note: Only two of the three characteristics may be selected for defining the quantity per rules.

0 - Not to include this dimension

1 - To use this as the Y dimension, that is, the Y-axis on the left side of the matrix

2 - To use this as the X dimension, that is, the X-axis, across the top of the matrix

Note: This is an override to the settings made on the route header and applies to this material only.

Press Enter to update and display the Relate Material to Style Characteristic Associate pop-up.

Relate Material to Style Characteristics Associate Pop-up

To display this pop-up, press Enter on the Relate Material to Style Characteristic pop-up.

Fields

Select (Untitled)

Select one or more style characteristics to associate with each material characteristic.

Press Enter to update and display the Relate Material to Style Characteristic Material Quantity Requirements pop-up.

Relate Material to Style Characteristics Material Quantity Requirements Pop-up

To display this pop-up, press Enter on the Relate Material to Style Characteristic Associate pop-up.

Where more than one characteristic has been selected against the style, a matrix is presented, where the selected style characteristics are concatenated.

Fields

Select (Untitled)

Select the required associations with **1** or enter the characteristic directly in the left-hand column. Null entries are allowed by entering **0** in the first column.

Note: The sequence of presentation utilises the colour and sequences set in the style profile/size mask.

Once accepted, the full material association is built up of these entries, plus any one-for-one associations selected within previous or subsequent matrices.

When amending existing material associations by using **Maintain Record** and **Relate Material to Style (F14)**, the previously selected association's rules are re-displayed. It is possible to change the previously selected structure of the associations. In this case, existing associations are used for the unchanged attributes but where they have changed, you are forced to establish new associations.

Note: If the Stop/Sell field on a SKU is checked, this SKU is not available for selection as an output within route maintenance. Therefore, this SKU is not present when associating materials

Material Quantity Requirements Pop-up

To display this pop-up, select Material Quantity Requirements against a material on the Style Route Maintenance Operations and Materials window, or select Material Qtys against a line on the Style Route Maintenance Materials window.

Use this pop-up to vary the quantity of material you require to produce each style variant. For example, if the dimension is size, you may wish to specify more material for the Extra Large size. You would then enter an extra amount under Extra Large.

If the material is very expensive, you may want to adjust every quantity to make more effective use of the material.

This pop-up is only relevant to fabric, trim and packaging items that have more than one dimension and are not ratio-based.

The characteristics shown on this pop-up depend on the dimensions you selected on the Quantity Per Rules pop-up. Otherwise, they default to those held in the CALL type parameter.

Fields

Quantity (Untitled)

Enter the relevant quantity for each variant characteristic. Quantities usually vary by size. If this is a new material with more than one dimension, this field defaults to the default quantity you entered in the Qty Per Lot field on the Material Maintenance pop-up.

Functions

Window Left (F19)

Use this to scroll left.

Window Right (F20)

Use this to scroll right.

Select **Previous (F12)** to return to the Style Route Maintenance Operations and Materials window.

Copy from Route Pop-up

To display this pop-up, select **Copy from Route (F16)** on the Style Route Maintenance Operations and Materials window or the Style Route Maintenance Operations List window.

Use this pop-up to select a style and route from which to copy one or more operations.

Caution: If you are copying operations from another style, the two styles may use different materials. Therefore, Style does not copy over any materials associated with the operations.

Fields

Include at Operation Sequence Number

You must enter the sequence number to insert the copied operations.

Copy from Style

Enter the style from which you want to copy operations.

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

Route

Enter the route for the style from which you want to copy.

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

Functions

Item Search (F16)

Use this to use the standard Inventory item search.

Press Enter to display the Copy Route window.

Copy Route Window

To display this window, press Enter on the Copy from Route pop-up.

Use this window to copy operations from an existing route.

You can select the operations you require by:

- Entering a range of operation sequences
- Or
- Selecting operations individually by inserting a sequence number against each operation

You can insert the selected operations at any point in the route you are building or maintaining.

Note: Remember to change the Reporting Level and Bundle Ticket fields.

Fields

Seq.

Use this field to specify the operations to copy.

To link together several standard operations for copying across to the same operation as a primary and several variants, enter the same sequence number.

You can enter multiple sequence number sets. Style copies over sets of operations in order, beginning with the lowest sequence number.

The first operation within a sequence number set copies over as the primary operation. Any other operations in the sequence number set are duplicated as variants of this primary operation. To define a specific standard operation within the sequence number set as the primary operation, use the Primary Operation field.

If the style route operation you enter in the Include at Operation Number field on the Select Operation Group pop-up already exists, the software copies all standard operations in the first sequence number set as variants of this operation.

All subsequent sequence number sets of operations convert as new operations after the first sequence number set.

Alternatively, enter a range in the Enter Operation to Copy From field and leave this field blank.

Enter Operation to Copy From/To

Enter a range of operations to copy.

Note: If you entered an operation number that already exists in the Include at Operation Number field on the Copy from Route pop-up, you cannot enter a range here.

Or Position To

Enter an operation sequence number at which to start the display.

Exclude Material Details

Use this checkbox as follows:

Unchecked - To copy materials on the route

Checked - Not to copy materials on the route

To copy the operations, press Enter. If any of these operations contains variant operations, the Variant Operation Selection Standard Operation pop-up is displayed.

Select Operation Group Pop-up

To display this pop-up, select **Copy from Std. Operations (F17)** on the Style Route Maintenance Operations and Materials window, or the Style Route Maintenance Operations List window.

This pop-up lists all the standard operation groups that you have set up. Use this pop-up to select an operation group to copy one or more operations to the route.

You can copy over standard operations as variants of an existing operation. Alternatively, you can insert new primary operations, with variant operations also, into the route's operation sequence.

Caution: If you subsequently change any of the standard operations you copy across to a route, Style does not copy those updates to this route.

Options

Fields

Position To

Enter an operation group at which to start the display.

Specification ID

Select a standard operation group by entering a specification ID. This displays the Copy Operation Group window.

You can include * as a wildcard to display a list of matching operations. For example, to list all standard operations with specification IDs prefixed by BUNDLE, enter **BUNDLE***. This displays the Copy from Selected Std. Operations window.

Include at Operation Number

You must enter starting sequence number from which to include the copied operations.

You can enter an existing operation sequence number. Style inserts the first standard operation as a variant of the existing operation. Any subsequent operations you wish to add appear between this existing operation and the next existing operation.

Otherwise, you can enter a new sequence number, either within the sequence or at the beginning or end. In this case, Style adds the standard operations as primary operations at the point indicated by the sequence number.

Note: If you enter an existing operation sequence number, you cannot select operations by entering a range from the Copy Operations Group pop-up.

To display the Copy Operation Group window, type in a full specification ID and then press Enter or select an operation group and then press Enter.

Alternatively, to display the Copy from Selected Std. Operations window, enter part of a specification ID with a wildcard and then press Enter.

Copy Operation Group Window

To display this window, select one standard operation group and then press Enter on the Select Operation Group pop-up, or enter a full specification ID and then press Enter on the Select Operation Group pop-up.

This window lists primary operations for the selected operation group or Specification IDs.

Use this window to select the standard operations to copy into the route. If any of the operations has variant operations, they are also copied.

Both standard primary and variant operations can become either primary or variant operations on the style route.

Note: When copying standard operations, Style uses the programs you have defined under the USER parameter. For more details, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Fields

Seq.

Use this field to specify the standard primary and variant operations to copy.

To link together several standard operations for copying across to the same operation as a primary and several variants, enter the same sequence number against the standard operations.

You can enter multiple sequence number sets. Style copies over sets of operations in order, beginning with the lowest sequence number.

The first operation within a sequence number set copies over as the primary operation. Any other operations in the sequence number set copy over as variant operations of this primary operation. To define a specific standard operation within the sequence number set as the primary operation, use the Primary Operation field.

If the style route operation you entered in the Include At Operation Number field on the Select Operation Group pop-up already exists, all standard operations in the first sequence number set copy over as variants of this operation.

All subsequent sequence number sets of operations appear as new operations after the first sequence number set.

Alternatively, enter a range in the Enter Operation to Copy From field and leave this field blank.

Primary Operation (P)

To mark a standard operation or one of its variants as the primary operation, enter **1** against it. If the operation has variants, the Variant Operation Selection Standard Operation pop-up is displayed. You can use this pop-up to copy over a variant operation as the primary operation instead.

To copy over the first standard operation in each sequence number set as the primary operation, leave this field blank.

Enter Operation to Copy From/To

Enter a range of operations.

Note: If you entered an operation number that already exists in the Include at Operation Number field on the Select Operations Group pop-up, you cannot enter a range here.

Or Position To

Enter an operation sequence number at which to start the display.

To copy the chosen standard operations, press Enter.

Variant Operation Selection Standard Operation Pop-up

To display this pop-up, select a standard primary operation that has variant operations and then press Enter on the Copy Operation Group window, or select a style route primary operation that has variant operations and then press Enter on the Copy Route window.

This pop-up is displayed when you select a primary operation with variant operations to copy to the standard operation group or route that you are currently updating.

Use the pop-up to select one standard operation on the list as the primary operation. You can select the primary operation or one of the variant operations as the primary operation to copy. The other operations on the list are copied as variant operations.

You can also de-select an operation so that it is not copied.

Fields

Select As

Enter one of the following:

Blank (0) - Not to copy this operation

Primary (1) - To copy the operation as the primary operation

You can only have one primary operation.

Variant (2) - To copy the operation as a variant of the primary operation

Var Seq

This field displays the variant sequence and you cannot update it.

Press Enter to save the details.

Copy from Selected Std. Operations Window

To display this window, enter part of a specification ID and a wildcard on the Select Operation Group pop-up and then press Enter.

This window lists the standard operations that match the specification ID you entered on the Select Operation Group pop-up.

Use this window to select one or more of these operations to copy into the current style route. If any of the selected operations has variant operations, these are also copied.

Both standard primary and variant operations can become either primary or variant operations on the style route.

Note: *When copying* *standard operations, Style* *runs the programs you have defined under the USER parameter. For more details, refer to the Maintain* *Parameter File* *section in the Utilities chapter of this product guide.*

Fields

Seq.

Use this field to specify the standard primary and variant operations to copy over to the sequence of operations you are currently maintaining.

To link together several standard operations to copy to the same operation as a primary and several variants, enter the same sequence number against the standard operations.

You can enter multiple sequence number sets. Style copies over sets of operations in order, beginning with the lowest sequence number.

The first operation within a sequence number set copies over as the primary operation. Any other operations in the sequence number set end up as variants of this primary operation. To define a specific standard operation within the sequence number set as the primary operation, use the Primary Operation field.

If the style route operation you entered in the Include at Operation Number field on the Select Operation Group pop-up already exists, all standard operations in the first sequence number set copy over as variants of this operation.

All subsequent sequence number sets of operations are inserted as new operations after the first sequence number set.

Alternatively, enter a range in the Enter Operation to Copy From field and leave this field blank.

Primary Operation (P)

To mark a standard operation or one of its variants as the primary operation, enter **1** against it. If the operation has variants, the Variant Operation Selection Standard Operation pop-up is displayed. You can use the pop-up to copy over a variant operation as the primary operation.

To copy over the first standard operation in each sequence number set as the primary operation, leave this field blank.

To copy over your chosen standard operations, press Enter.

Style Route Maintenance Materials Window

To display this window, select **Materials Only List (F19)** from the Style Route Maintenance Operations and Materials window or the Style Route Maintenance Operations List window or the Single Product Operations and Materials window.

This window displays all the materials attached to the route.

Options

Maintain

Use this to amend material details.

This displays the Material Maintenance pop-up.

Delete

Use this to delete material details.

Associations

Use this to display the Associate pop-up, which you can use to associate individual style variants with the material characteristics.

Material Qtys

Use this to display the Material Quantity Requirements pop-up.

Add Material

Use this to display the Material Maintenance pop-up, which you can use to add a material to the selected operation.

Note: You can maintain or delete multiple lines by selecting more than one item.

Functions

For a description of the functions available on this window, please refer to the Style Route Maintenance Operations and Materials Window section.

Select Maintain or Add Material against a line to display the Material Maintenance pop-up.

Style Route Maintenance Operations List Window

To display this window, select **Operations Only List (F20)** from the Style Route Maintenance Operations and Materials window, or the Style Route Maintenance Materials window, or the Single Product Operations and Materials window.

This window lists primary operations and shows run labour time, machine and the operation wastage percentage.

Note: To maintain variant operations, use the Style Route Operations Details window.

Options

Maintain

Use this to maintain an operation.

Add Oper Before

Use this to add an operation before the current operation.

This displays the Style Route Operations Details window.

Add Oper After

Use this to add an operation after the current operation.

This displays the Style Route Operations Details window.

Delete

Use this to delete an operation.

You must confirm this using the Deletion Confirmation pop-up.

Functions

For a description of the functions available on this window, please refer to the Style Route Maintenance Operations and Materials Window section.

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

Item Selection Pop-up

To display this pop-up, select **Selective View of Route (F22)** from the Style Route Maintenance Operations and Materials window or the Style Route Maintenance Materials window or the Style Route Maintenance Operations List window.

Use this pop-up to select a selective view of the route for a specific style variant, for example, a particular colour and size.

Fields

Select (Untitled)

Enter **1** against each of the dimensions for which you want to see a selective view of the route.

Press Enter to display the Single Product Operations and Materials window.

Single Product Operations and Materials Window

To display this window, press Enter on the Item Selection pop-up.

This window displays a selective view of the route for one specific style variant.

Where you have defined materials, this window shows the material variant and actual quantity required for the selected style variant. You can omit operations if you do not want them included on the style variant you have selected.

Options

Select

Use this against an operation to display the Style Route Enquiry Operations window.

Functions

Position To (F13)

Use this to display the Position To pop-up. You can use this to enter the operation sequence number at which to start the display.

Select an operation sequence to display the Style Route Enquiry Operations window.

Style Route Enquiry Operations Window

To display this window, select an operation sequence on the Single Product Operations and Materials window.

This window displays details for a single style variant.

Fields

Note: For more details on the fields on this window, please refer to the Style Route Operations Details Window section.

Functions

Additional Params (F22)

Use this to display the Additional Operation Values pop-up.

Variant Opn. (F23)

Use this to display the Variant Operation Enquiry pop-up.

Characteristics (F24)

Use this to display the Operation Characteristics Values pop-up.

Select **Previous (F12)** to return to the Style Route Maintenance Operations and Materials window.

Variant Operation Enquiry Pop-up

To display this pop-up, select **Variant Opn. (F23)** on the Style Route Enquiry Operations window.

Use this pop-up to select a variant operation on which to enquire.

Options

Select

Use this to display the Variant Operation Enquiry window.

Values

Use this to display the Operation Characteristics Values pop-up.

Delete

Use this to delete a variant operation.

Select an operation to display the Variant Operation Enquiry window.

Variant Operation Enquiry Window

To display this window, select an operation on the Variant Operation Enquiry pop-up.

This window displays all the information you entered about this variant operation on the Variant Operation Maintenance window.

Functions

Additional Parameters (F22)

Use this to enter additional operation parameters. Please refer to the Additional Operation Values Pop-up section for more details.

Characteristics (F24)

Use this to display which of the style's variants uses this operation during production. Please refer to the Operation Characteristics Values Pop-up section for more details.

Select **Previous (F12)** to return to the Single Product Operations and Materials window.

Material Mass Replace [3/P1R]

Use this task to update bills of materials to reflect changes in design or material specification on a mass update basis. You can:

- Replace materials either directly or by using effectivity change over dates
- Replace single or multiple variants of a material, e.g. one shade for another shade
- Make changes to wastage, stockroom or quantity pers
- Delete or make materials non-effective
- Produce audit reports for all changes

Materials with 2, 3 and 4 dimensions can only be replaced with a material with the same number of dimensions in order that the material associations are not compromised. However, the delete function can be used to delete all occurrences of the material for which details appear on the audit report. New materials can then be added where required via route maintenance.

Note: This task is set to exclusive use to ensure that users are not maintaining routes or orders whilst routes are being updated.

Mass Replace Materials Window

To display this window, select the Material Mass Replace task.

Use this window to specify the material to be replaced and the material with which to replace it. You can also specify further parameters to make sure you only replace what you need to.

Fields

Material to be Replaced

Enter the full material SKU if only one SKU is to be replaced. Enter the first 9 digits (i.e. Style portion) of the material SKU if all, or several, SKUS are to be replaced.

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

Replacement Material

Enter the full replacement material SKU if one SKU was entered in the Material to be Replaced field. Enter the style portion of the replacement material SKU if only the style portion was entered in the Material to be Replaced field.

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

*Note: To remove a material from all routes en masse without providing a replacement, leave this field blank. A warning message will be displayed and you must select **Continue (F8)** to confirm the action.*

Delete Old Material

Select one of the following:

Old material will be deleted (1) - If you want to make a direct replacement without the application of an expiry date for the old material.

Superseded (0) - If the old material is to be replaced by setting an Effective To Date on the old material and adding the new material with an Effective From Date

Caution: If you set the Delete Old Material field to Old Material will be Deleted, a warning is displayed, as deleting old materials may impact on the costs of the route affected.

Wastage

When replacing a material, you can retain the material wastage percentage defined or set it to zero for the new material.

Select one of the following:

Set to Zero (Blank) - To set the wastage to zero

Replaced Material's Values (1) - To retain the existing wastage

Issuing Stockroom

You can use this field to determine the issuing stockroom to use for the replacement material.

Select one of the following:

New Item's Primary Store (0 or blank) - To use the replacement material primary stockroom

From Original Material (1) - To retain the existing issuing stockroom

Entered Stockroom (2) - To enter a new issuing stockroom for the replacement material

Stockroom (Untitled)

If you selected **Entered Stockroom** in the Issuing Stockroom field, enter a stockroom. This must be a valid stockroom for this material.

Fixed Quantity Per

Use this to change the way in which the software processes the quantity per for the replacement material.

Select one of the following:

From Original Material (Blank) - If the quantity per for the replacement material is to be treated in the same way as for the material to be replaced, that is, variable with standard lot size or fixed regardless of lot size

Fixed Quantity Per (1) - To change the quantity per to a fixed basis

Variable Quantity Per (2) - To change the quantity per to a variable basis

Effective Date

Enter or select the date on which your updates become effective. When you are replacing materials, this date becomes the effective stop date of the replaced material and the effective start date of its replacement. For quantity per changes, it becomes the stop date of the former quantity per definition and the start date of the new one.

This field defaults to the current date.

Replacement Expiry Date

Enter or select the last date on which the update, or replacement, is effective.

If you leave this as zeroes, the change is effective indefinitely.

Change Reference

Enter a reference to identify the replacement, or update, on all bills of materials specifications.

Quantity Per Change Factor

Enter a factor to control the quantity per change to apply. For example, if you require the quantity per relationship to double, enter 2.00; to half it, enter 0.50.

Functions

Automatic Update (F8)

Use this to update style routes automatically.

Press Enter to display the Material Mass Replace Materials window.

Material Mass Replace Materials Window

To display this window, press Enter on the Mass Replace Materials window.

If a style code has been entered, a full list of the old material SKUs is displayed in presentation sequence for you to make a selection.

Fields

Select (Untitled)

Select all SKUs which are to be replaced.

The pop-up allows you to enter the new colour and size details against each old colour or size that is being replaced.

Press Enter to display the Material Mass Replace Old/New pop-up.

Material Mass Replace Old/New Pop-up

To display this pop-up, press Enter on the Material Mass Replace Materials window.

If there is a matching characteristic between the old and replacement material, the pop-up defaults to this and prefills the New values.

Fields

New

Col/Size/Fit

Amend any as required. Anywhere there is no match, the new characteristics are set to blank and a valid characteristic for the new material must be entered or selected using the prompt facility.

Once the selections are made and **OK** is selected (or if a full replacement material was entered on the Mass Replace Materials window), a list of routes on which the old material appears is presented so that you can select which styles/routes are to be updated.

Press Enter to display the Material Mass Replace Review Replacement window.

Material Mass Replace Review Replacement Window

To display this window, press Enter on the Material Mass Replace Old/New pop-up.

Fields

Select

Enter **1** to select routes/operations that are to be updated.

Note: Updates are performed interactively so there may be some delay if a large number of routes are being updated.

Note: Full details of all deletions, additions and amendments are provided on the Audit report.

Note: If the option is to use expiry dates (i.e. the Delete Old Material field was set to Superseded), these are also shown on the report.

Note: Details also include old/new stockrooms and quantity per values if these have been changed.

Select **Update (F8)** to make the changes.

Model Route/Bill of Material [4/P1R]

Use this task to create and maintain model planning routes and bills of material.

Subsequently, you can copy the model planning route to a live production route.

To copy a live production route to a model planning route, use the Copy Production Route to Model task. When you have finished making changes to the model route, use the Copy Model Route to Production task to copy the route back to a live production route.

Note: Model planning routes can provide system managers with a certain degree of flexibility. You can authorise users to copy to and maintain model planning routes, but not live production routes.

Caution: Before you can create a model planning route, you must add the route under the VMDR parameter. For more information, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Model Routes Selection Window

To display this window, select the Model Route/Bill of Material task.

Fields

Style

Enter a style.

Alternatively, use the prompt facility to select from the Select Routes & Items pop-up.

Route

Enter a route.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Press Enter to display the Style Route Header window.

Copy Production Route to Model [5/P1R]

You can use this task to copy a live production route to a model planning route. You can include or exclude materials.

Copy Production Route to Model Selection Window

To display this window, select the Copy Production Route to Model task.

Use this window to select the style and route to copy.

Note: When you have finished making changes to the model planning route, use the Copy Model Route to Production task to copy the route to a live production route.

Fields

Copy from Production

Style

Enter a style to copy.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

Enter the route for the style.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Note: If the route is a model planning route, you must define it under the VMDR parameter. If the route is a live production route, do not define it under the VMDR parameter. For more details, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Copy To Model

Style

Enter a style.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

Enter a route.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Note: If the route is new and the From and To styles are different, the style characteristics must match.

Note: If the route already exists, the two routes must produce the same style characteristics.

Note: If the route is a model planning route, define the route under the VMDR parameter. If the route is a live production route, do not define the route under the VMDR parameter. For more details, refer to the Maintain Parameter File section in the Utilities chapter of this product guide.

Exclude Materials

Use this checkbox as follows:

Unchecked - To copy over materials on the route

Checked - Not to copy over materials on the route

Functions

Item Search (F16)

Use this for the standard Inventory item search.

To submit the batch job, press Enter and then select **Submit (F8).**

Copy Model Route to Production [6/P1R]

You can use this task to copy a model planning route to a live production route.

Copy Model Route to Production Selection Window

To display this window, select the Copy Model Route to Production task.

Use this window to select the style and route to copy to a live production route.

Fields

Copy From Model

Style

Enter the style from which to copy.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

Enter the route from which to copy.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Note: The From and To styles must be the same to make sure that material associations are copied.

Copy To Production

Style

Enter the style.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

Enter the route code for the style.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Exclude Materials

Use this checkbox as follows:

Unchecked - To copy over materials on the route

Checked - Not to copy over materials on the route

Press Enter and then select **Update (F8)** to copy the details.

Copy Model to Model [7/P1R]

You can use this task to copy a model planning route to another model planning route.

You can also choose whether to include or exclude materials.

Copy Model to Model Selection Window

To display this window, select the Copy Model to Model task.

Use this window to select the models from which to copy and to which to copy.

Fields

Copy From Model

Style

Enter the style to from which to copy.

Alternatively, use the prompt facility to select from the Select Routes & Items pop-up.

Route

Enter the route from which to copy.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Copy To Production

Style

Enter the style.

Alternatively, use the prompt facility to select from the Select Routes & Items pop-up.

Route

Enter the route code for the style.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Select Routes & Items pop-up if the Style field is blank.

Exclude Materials

Enter one of the following:

Unchecked - To copy over materials on the route

Checked - Not to copy over materials on the route

Press Enter and then select **Update (F8)** to copy the details.

Copy Production Route to Production Route [8/P1R]

You can use this task to copy a live production route to another live production route.

Copy Production Route to Production Selection Window

To display this window, select the Copy Production Route to Production Route task.

Fields

Copy From Production

Style

Enter the style from which to copy.

Alternatively, use the prompt facility to select from the Select Routes & Items pop-up.

Route

Enter the route from which to copy.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Routes & Items pop-up if the Style field has been left blank.

Note: The From and To styles must be the same to make sure that material associations are copied.

Copy To Production

Style

Enter the style.

Alternatively, use the prompt facility to select from the Select Routes & Items pop-up.

Route

Enter the route code for the style.

Alternatively, use the prompt facility to select from the Select Route pop-up, or the Routes & Items pop-up if the Style field has been left blank.

Exclude Materials

Use this checkbox as follows:

Unchecked - To copy over materials on the route

Checked - Not to copy over materials on the route

Press Enter and then select **Update (F8)** to copy the details.

Mass Route Copy [9/P1R]

Use this task to copy existing routes to a new route code for a range of styles.

Copy Route Data Window

To display this window, select the Mass Route Copy task.

Fields

From Route Code

Enter an existing route code from which to copy the route data.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

To Route Code

Enter the new route code to which the From Route is to be copied.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Styles to Process

From/To

Enter a single style or a range of styles to process. Leave these fields blank to process all styles.

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

Note: Only those styles which have the entered From Route code defined will be copied.

Process Option for Existing Routes

Select one of the following:

Do Not Overwrite Data (0) - If, should a route to which you are copying already exist, you do not want to overwrite the existing route data but print an exception on the audit report

Overwrite All Data (1) - If you want routes to be copied regardless of whether the To Route already exists

All updates are reported on the audit report.

Overwrite but not Costing Route (2) - If you want routes to be overwritten unless the To Route is defined on the Styles Production Details as the costing route for the style

Caution: If the Derivation of Standards flag in the company profile is set to Routes (0), overwriting route data may affect the standard production costs.

Select **Submit (F8)** to submit a batch job which checks each style in the range. If the From Route is found, it copies the full details of the route, including materials, to the To Route, replacing all existing data if any is found.

A report is printed, detailing each style processed and the action taken.

Mass Update of Waste [10/P1R]

Mass Update of Route/BOM Wastage Selection Window

To display this window, select the Mass Update of Waste task.

Fields

Route

You must enter the route code to which the default wastage percentages are to be applied.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

From Style/To Style

Enter a single or a range of styles to process. Leave these fields blank to process all styles.

You can use the prompt facility on these fields to select from the Routes & Items pop-up.

Reset Wastage to Zero

The mass update can re-set wastage percentages to zero. This will change the function of the Update Wastage By field described below.

Use this checkbox as follows:

Unchecked - Not to re-set the wastage percentages to zero

Checked - To re-set the wastage percentages to zero

Update Purchased Items Only

The material updated can be restricted to item types **P** and **B** only.

Use this checkbox as follows:

Unchecked - Not to restrict the update to purchased items

Checked - To restrict the update to purchased items

Update Wastage By

You can select a previously defined material type code for update. Alternatively, a single material can be selected.

If material type code is selected, the Default Material Wastage percentages defined previously are displayed. If none were defined previously, they can be set up now.

If the Reset Wastage to Zero field is **checked**, the window is used to select the materials which are to be set to zero by analysis code. In this case, the percentage field is input inhibited.

Select one of the following:

Material Type Code (0) - To update by material type code

Material Style Code (1) - To update by individual material code

Select **Submit (F8)** to submit a batch job which checks each style in the range. If the From Route is found, it copies the full details of the route, including materials, to the To Route, replacing all existing data if any is found.

A report is printed, detailing each style processed and the action taken.

Mass Update by Material Type Code Window

To display this window, select Material Type Code in the Update Wastage By field. If there are no previously defined percentages, you can set them up now.

Fields

Waste %

Enter a percentage.

You can only update this field if the Reset Wastage to Zero field was left **unchecked** on the previous window.

Update

Enter **1** to select a code for processing.

Select **Update (F8)** to submit a batch job to update the routes for the range of styles entered.

Material Entry Panel Pop-up

To display this pop-up, select Material Style Code in the Update Wastage By field. If there are no previously defined percentages, you can set them up now.

Fields

Material

Enter the material to be updated.

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

Wastage %

Enter a percentage.

You can only update this field if the Reset Wastage to Zero field was left **unchecked** on the previous window.

Select **Update (F8)** to submit a batch job to update the routes for the range of styles entered.

Update Material Wastage [20/P1R]

Use this task to update the default wastage percentages.

Material Wastage Update Operation Selection Window

To display this window, select the Update Material Wastage task.

Note: Before you use this task, you must maintain the MATW parameter via the Maintain Parameter File task. This defines the analysis code used for wastage definition. Within this parameter, a further parameter PTYP is required.

You use this window to select a route code.

Fields

Route

Enter the route for which you want to maintain default wastage values.

Press Enter to display the Material Wastage Update Selection window.

Material Wastage Update Selection Window

To display this window, press Enter on the Material Wastage Update Operation Selection window.

A list of all the analysis codes as defined in the Inventory Descriptions file is displayed.

The values entered on this window are used to provide a default whenever any material defined with one of these analysis codes is added to a route or an order with the route code specified.

Fields

Waste %

Enter the percentage to be applied to all materials defined with the associated Analysis Code on the item's product details within style/material maintenance.

Date Last Changed

This field displays the date on which the percentages were last changed.

Select **Update (F8)** to update the data.

Chapter 4   Enquiries and Reports

<div style="text-align: right">4</div>

Enquire on Item Master [1/P1E]

You can use this task to check all the details currently held on the Item Master file.

Item Master Enquiry Selection Window

To display this window, select the Enquire on Item Master task.

Use this window to select the item on which you wish to enquire.

Fields

Item

Enter the item on which you want to enquire.

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

Functions

Item Search (F16)

Use this to use the standard Inventory item search.

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up.

Select an item or enter an item and then press Enter to display the Item Master Enquiry Details window.

Item Master Enquiry Details Window

To display this window, select an item or enter an item and then press Enter on the Item Master Enquiry Selection window.

This window displays all the details held in the Item Master file for this item.

Fields

Item

This field displays the item you have specified.

Description

This field displays the item description.

Item Type

This field displays the item type.

Planner

This field displays the planner responsible for this item.

Planning Route

This field displays the planning route used by this item.

Forecast Level

This field displays the forecast level.

Production Sequence

This field displays the production sequence of the item.

Min Order Qty

This field displays the minimum order quantity.

Mult Order Qty

This field displays the multiple order quantity. This item is always ordered in multiples of this number.

Safety Stock

This field displays the safety stock, that is, the amount that should always be held in your stockrooms.

M/F Lead Time

This field displays the manufacturing lead time, that is, the amount of days it takes to produce the item.

Primary Stockroom

This field displays the primary stockroom in which the item is held.

Order Policy

This field displays the order policy.

Specification Ref.

This field displays the specification reference.

Fabric Type

This field displays the main fabric used in the item.

Costing Route

This field displays the route used to cost the item.

Planning Type

This field displays the item planning type.

Demand Policy

This field displays the demand policy used by the item.

Smoothing Policy

This field displays the smoothing policy used by the item.

Planning Filter

This field displays the planning filter used by the item.

Seasonal Profile

This field displays the seasonal profile used by the item.

Max Order Qty

This field displays the maximum quantity of the item to be ordered.

Fixed Order Qty

This field displays the fixed quantity of this item that should always be ordered.

No. of Days Supply

This field displays the number of days' supply you should always aim to have in stock.

Cumulative Lead Time

This field displays the total lead time for this item.

Mat'l Control Policy

This field displays the material control policy, which defines how materials are issued.

One of the following is displayed:

0 - Formal issue against a production order

1 - Backflushed

2 - Actual issue

3 - Issue to floor stock

Low Level Code

This displays the lowest level at which the item appears on any route/BOM and is used by MPS and MRP. This is the only field maintained by the software.

Functions

Graded Item (F15)

Use this to display the [Style](#) Grade Association Enquiry window.

Add Parms (F18)

Use this to display the Additional Parameters pop-up

Costs (F22)

Use this to display the Item [Cost](#) Enquiry window.

Variable Qtys (F23)

Use this to show variable batch quantity details. This is used with [Order Policy](#) Code J.

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

Style Grade Association Enquiry Window

To display this window, select **Graded Item (F15)** on the Item Master Enquiry Details window.

This window displays the graded item details.

Fields

Style

This field displays the selected [style](#).

Grade

This field displays the grade code.

Graded Style

This field displays the graded [style](#).

Colour

This field displays the [colour](#) code.

Size/Fit

This field displays the size/fit combination.

Description

This field displays the text description.

Select **Previous (F12)** to return to the Item Master Enquiry Details window.

Additional Parameters Pop-up

To display this pop-up, select **Add Parms (F18)** on the Item Master Enquiry Details window.

This pop-up displays additional details about this item.

<u>Fields</u>

Major Sequence

This field displays the major sequence code for the item, defined on the Additional Parameters pop-up in the [Styles](#) task.

Material Type

This field displays the [material type](#), defined on the Additional Parameters pop-up in the [Styles](#) task.

Material Usage Policy

This field displays the [material usage policy](#) code, defined on the Additional Parameters pop-up in the [Styles](#) task.

Discrete Demand

This field displays the discrete [demand](#) code, defined on the Additional Parameters pop-up in the [Styles](#) task.

Demand Based Order No

This field displays the information defined on the Additional Parameters pop-up in the [Styles](#) task.

The [demand](#) and [supply](#) order numbers can be linked for manufactured items by formatting the [production order](#) number to include the originating sales order number. This linking by [supply](#) number is effected through multiple planning levels so all [production orders](#) can be referenced back to the original sales order [demand](#).

Suppress Excess Supply

This field displays the suppress excess [supply](#) policy, defined on the Additional Parameters pop-up in the [Styles](#) task.

The use of [order policy](#) rules or the amendment of supplies and [demands](#) may result in excess [supply](#) being planned for a [demand](#). (For example. for a sales order of 80 where the [minimum order quantity](#) is 100, an excess [supply](#) of 20 will be planned). This flag controls the display of exception messages when excess supplies are planned.

Default Order Level

This field displays the default order level policy code, defined on the Additional Parameters pop-up in the [Styles](#) task.

One of the following will be displayed:

0 - [Style](#) code

1 - [Style](#)/[Colour](#) code

2 - Full Product code

Select **Previous (F12)** to return to the Item Master Enquiry Details window.

Cost Set Selection Pop-up

To display this pop-up, select **Costs (F22)** on the Item Master Enquiry Details window.

Use this pop-up to select the cost set on which to enquire.

*Note: This pop-up is only displayed if you have set up more than one cost set. You can define cost sets using the Item Costs task. If you have not set up more than one cost set, the Item Cost Enquiry window is displayed when you select **Costs (F22)**.*

Fields

Item

This field displays the item you have specified.

Rte

This field displays the route for which the cost set is defined.

C.Set

This field displays the cost set code.

Description

This field displays the cost set description.

Recosted

This field displays the last date on which this item was re-costed using the cost set.

Changed

This field displays the last date on which cost set was changed.

Options

Select

Use this to check the details for this set.

Select a cost set to display the Item Cost Enquiry window.

Item Cost Enquiry Window

To display this window, select a cost set on the Cost Set Selection pop-up.

If you have not set up more than one cost set, this window is displayed when you select **Costs (F22)** on the Item Master Enquiry Details window.

This window displays any costs associated with this item.

Fields

Item

This field displays the item you have specified.

Route

This field displays the route on which this item is included.

UOM

This field displays the primary UoM for this item.

Cost Set

This field displays the cost set in which this item is included.

Cost Element

This field displays the description of the cost element.

Selected Costs

This field displays the actual cost of this element.

Total Cost: (excludes **)

This displays the total amount of all cost elements listed on the window.

*Note: Any cost elements marked with ** are excluded from this total.*

Cost Calculated As At

This displays the date on which the costs were calculated.

Functions

Comparison (F15)

Use this to display the Select Comparison Cost Set pop-up.

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

Comparison Cost Set Pop-up

To display this window, select **Comparison (F15)** on the Item Cost Enquiry window.

You can use this window to select another cost set, so that you can compare costs.

Fields

Item

Enter the item to compare.

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

Route

Enter the route to compare.

Alternatively, use the prompt facility to select from the Select Route pop-up (or the Routes & Items pop-up if you have not specified an item).

Cost Set

Enter the cost set to compare.

Alternatively, use the prompt facility to select from the Cost Set Selection pop-up.

Press Enter to display the Item Cost Enquiry Comparison window.

Alternatively, select **Previous (F12)** to return to the Item Cost Enquiry window.

Item Cost Enquiry Comparison Window

To display this window, enter a cost set and then press Enter on the Comparison Cost Set pop-up.

This window displays the two cost sets you have specified, so that you can compare them on window.

For more information on the fields on this window, please refer to the Item Cost Enquiry Window section.

Select **Previous (F12)** to return to the Item Master Enquiry Details window.

Enquire on Cost Centres [2/P1E]

You can use this task to enquire on all existing cost centre details.

This enquiry displays the current values of standard and current rates for:

- Machines
- Labour
- Set up
- Fixed and variable overheads

Cost Centre Enquiry Selection Window

To display this window, select the Enquire on Cost Centres task.

Fields

Cost Centre

Enter the cost centre on which you want to enquire.

Alternatively, use the prompt facility to select from the Select Cost Centre pop-up.

Select a cost centre or enter a cost centre and then press Enter to display the Cost Centre Enquiry Details window.

Cost Centre Enquiry Details Window

To display this window, select a cost centre or enter a cost centre and then press Enter on the Cost Centre Enquiry Selection window.

This window displays all the costs information held at the cost centre you have specified.

Fields

Cost Centre

This field displays the cost centre you have specified.

Description

This field displays the description of the cost centre.

Department

This field displays the department linked to the cost centre.

Note: Standard and current totals are shown for all of the following costs.

Machine Rate/hr

This field displays the machine rate per hour.

Labour Rate/hr

This field displays the labour rate per hour.

Setting Rate/hr

This field displays the setting rate per hour.

O/H 1 Method

This field displays the overhead method defined in the Parameter file, under major type OHDC.

O/H 1 Rate

This field displays the overhead rate you have defined for this cost centre.

O/H 2 Method

This field displays the overhead method, defined for O/H 2 in the Parameter file, under type OHDC.

O/H 2 Rate

This field displays the overhead rate you have defined for this cost centre.

O/H 2 Value

This field displays the overhead value you have defined for this cost centre.

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

Enquire on Machines [3/P1E]

You can use this task to check current machine definition.

Machine Enquiry Selection Window

To display this window, select the Enquire on Machines task.

Use this window to enter the machine on which you want to enquire.

Fields

Machine

Enter the machine on which to enquire.

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

Select a machine or enter a machine and then press Enter to display the Machine Enquiry Details window.

Machine Enquiry Details Window

To display this window, select a machine or enter a machine and then press Enter on the Machine Enquiry Selection window.

This window displays the way in which the machine is currently set up.

Fields

Machine

This field displays the machine you have specified.

Description

This field displays the description for the machine.

Org. Model

This field displays the organisational model with which the machine is associated.

Calendar Code

This field displays the calendar code used for this machine.

Department

This field displays the department with which the machine is associated.

WIP Location

This field displays the work in progress location for this machine.

Floor Stock Location

This field displays the floor stock location for this machine.

Foreman

This field displays the supervisor responsible for this machine.

Queue Time

This field displays the average queue time, in hours.

Std. Efficiency

This field displays the standard, expected efficiency factor for the machine.

Note: The following four fields display information for three shifts.

Max Length

This field displays the maximum daily shift length.

Std Length

This field displays the standard daily shift length.

Max Capacity

This field displays the [maximum capacity](#) per shift, that is, the theoretical maximum number of hours generated by this [machine](#).

Std Capacity

This field displays the [standard capacity](#) per shift.

Duration Calculation Basis (Default)

This field displays the default [machine](#) duration basis code, which can be set up at [operation](#), [machine](#) or [company profile](#) level.

Shift Profile (Default)

This field displays the default shift profile, to be used at all times when no specific profile is defined.

Default Shift Capacity Factor

Max

This field displays the default shift profile [maximum capacity factor](#), which is the number of physical [machines](#) [available](#).

Std

This field displays the default shift profile [standard capacity factor](#). The software multiplies the total number of hours defined on the default profile by this factor to give the [standard capacity](#) for the shifts.

Cost Centre

This field displays the [cost centre](#) for this [machine](#), that is, the [cost centre](#) used to define rates for work at the [machine](#).

Functions

Daily Profile (F20)

Use this to display the Shift/Capacity Profile Enquiry pop-up.

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

Shift/Capacity Profile Enquiry Pop-up

To display this pop-up, select **Daily Profile (F20)** on the [Machine](#) Enquiry Details window.

This pop-up displays the standard and [maximum capacity](#) rates for this [machine](#).

Fields

Shift Profile

This field displays the shift profile for the [machine](#), if you have attached one. The default profile is shown, as well as those for each day of the week.

Maximum Capacity Rate

This field displays the maximum capacity rate, for the default and for each day of the week.

Standard Capacity Rate

This field displays the standard capacity rate, for the default and for each day of the week.

Select **Previous (F12)** to return to the Machine Enquiry Details window.

Enquire on Work Centres [4/P1E]

Use this task to enquire on existing work centre details.

Work Centre Enquiry Selection Window

To display this window, select the Enquire on Work Centres task.

Use this window to enter the work centre on which you want to enquire.

Fields

Work Centre

Enter the work centre on which to enquire.

Alternatively, use the prompt facility to select from the Select Work Centre pop-up.

Select a work centre or enter a work centre and then press Enter to display the Work Centre Enquiry Details window.

Work Centre Enquiry Details Window

To display this window, select a work centre or enter a work centre and then press Enter on the Work Centre Enquiry Selection window.

This window displays all the machines currently linked to a work centre.

Fields

Work Centre

This field displays the work centre code you have specified.

Description

This field displays the description for the work centre.

Machine

This field displays a machine linked to this work centre.

Machine Description

This field displays the description of the machine.

Functions

Text (F21)

Use this to display text associated with this work centre.

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

Enquire on Shift Profiles [5/P1E]

Use this task to display the details of current shift profiles.

Shift Profile Enquiry Selection Window

To display this window, select the Enquire on Shift Profiles task.

Use this window to enter the shift profile on which you wish to enquire.

Fields

Shift Profile

Enter the shift profile.

Alternatively, use the prompt facility to select from the CSHF Shift Profile Code pop-up.

As At Date

You can optionally enter or select a date. Only shift profiles effective on this date are included in the enquiry. If you leave this field blank, all current shift profiles are displayed.

Press Enter to display the Shift Profile Enquiry Details window.

Shift Profile Enquiry Details Window

To display this window, enter a shift profile and optionally a date and then press Enter on the Shift Profile Enquiry window.

This window displays all the details of this shift profile.

Fields

Profile Code

This field displays the profile code you have specified.

Description

This field displays the description for the work profile.

As At

This field displays the effective date for the enquiry. You can enter or select a different date to change the criteria for the enquiry.

No.

This field displays the sequence number of this shift within this profile.

Start Time

This field displays the start time of the shift.

Finish Time

This field displays the finish time of the shift.

Effective From Date

This field displays the date from which this shift is effective.

Effective To Date

This field displays the date up to which this shift is effective.

Comment

Any additional comments about this shift are displayed here.

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

Enquire on Bundle Ticket Types [6/P1E]

Use this task to enquire upon bundle ticket set-up.

Bundle Ticket Type Selection Window

To display this window, select the Enquire on Bundle Ticket Types task.

Use this window to enter the bundle ticket type on which you wish to enquire.

Fields

Bundle Ticket Type

Enter the bundle ticket type.

Alternatively, use the prompt facility to select from the Bundle Ticket Type Window pop-up.

Select a bundle ticket type or enter a bundle ticket type and then press Enter to display the Bundle Ticket Type Enquiry Details window.

Bundle Ticket Type Enquiry Details Window

To display this window, select a bundle ticket type or enter a bundle ticket type and then press Enter on the Bundle Ticket Type Enquiry Selection window.

This window displays all the details you have set up for this bundle ticket type.

Fields

Bundle Ticket Type

This field displays the bundle ticket type you have specified.

Description

This field displays the bundle ticket description.

Search Family

This field displays the search family code. The search family specifies which dimensions determine mixing rules.

Bundle Quantity

This field displays the quantity that can be included on the bundle.

Bundle Quantity Variance

This field displays the maximum amount of variance, up or down, that is allowed on the bundle quantity.

Final Bundle Policy

This field displays the quantity of a final bundle, when it is automatically created.

Document Type

This field displays the physical format of the printed bundle ticket document.

Ticket for Finished Goods Receipt

This indicates whether a bar-coded stub appears on the bundle ticket for receiving finished styles into stock.

Finished Goods - Default Bundle Qty

This indicates whether or not the bar-coded stub uses the bundle quantity as the default.

Barcodes on Ticket

This indicates whether or not the operation stub on the bundle ticket will include a barcode.

No. of Labels per Bundle

This field displays the number of barcode boxed end labels printed for each bundle.

Parallel Ticket Type

This indicates whether or not the bundle ticket can be processed in parallel with another bundle ticket.

Material Cost %

This field displays the material cost percentage.

Operation Level Cost %

This field displays the operation level cost percentage.

Functions

Characteristics Mix (F18)

Use this to display the Characteristics Mix Rules pop-up. For more information on this pop-up, please refer to the Bundle Ticket Types section in the Maintenance chapter of this product guide.

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

Enquire on Labour Skills [7/P1E]

Use this task to view current labour skill and rate definitions.

Labour Skills Enquiry Selection Window

To display this window, select the Enquire on Labour Skills task.

Use this window to enter the labour skill on which you wish to enquire.

Fields

Labour Skill

Enter the labour skill.

Alternatively, use the prompt facility to select from the Select Labour Skills pop-up.

Select a labour skill or enter a labour skill and then press Enter to display the Labour Skills Enquiry Details window.

Labour Skills Enquiry Details Window

To display this window, select a labour skill or enter a labour skill and then press Enter on the Labour Skills Enquiry Selection window.

This window displays the details for the labour skill you have specified.

Fields

Labour Skill

This field displays the labour skill you have specified.

Description

This field displays the description of the labour skill.

Effective Date

This field displays the first date on which this labour skill was or will be used.

Expiry Date

This field displays the last date on which this labour skill was or will be used.

Functions

Skill Rates (F20)

Use this to display all the different effective and expiry dates for this labour skill and the labour rate associated with each one.

For further information, see the Labour Skills section in the Maintenance chapter of this product guide.

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

Enquire on Labour Profiles [8/P1E]

Use this task to view current labour profile details. Labour profiles define the number of skills that a company requires for it to perform a wide range of tasks.

Labour Profile Enquiry Selection Window

To display this window, select the Enquire on Labour Profiles task.

Use this window to enter the labour profile on which you wish to enquire.

Fields

Labour Profile

Enter the labour profile.

Alternatively, use the prompt facility to select from the Labour Profile Selection pop-up.

Select a labour profile or enter a labour profile and then press Enter to display the Labour Profile Enquiry Details window.

Labour Profile Enquiry Details Window

To display this window, select a labour profile or enter a labour profile and then press Enter on the Labour Profile Enquiry Selection window.

This window displays all the current details held against this labour profile.

Fields

Labour Profile

This field displays the labour profile you have specified.

Description

This field displays the labour profile description.

Calendar

This field displays the calendar that this labour profile uses.

Shift Profile

This field displays the shift profile that this labour profile uses to schedule work.

Department

This field displays the department associated with this labour profile.

Standard Efficiency

This field displays the standard expected efficiency factor of the labour profile. 100% is full efficiency.

Labour Grades Included

Grade

This field displays a labour skill code, associated with this labour profile.

Description

This field displays the description for the labour skill.

Qty

This field displays the number of people with this labour skill who are included in this labour profile.

Time %

This field displays the standard percentage of time that this labour skill can work in this labour profile.

From

This field displays the date on which this labour skill is first effective within the labour profile.

To

This field displays the last date on which this labour skill will be effective within this labour profile.

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

Enquire on Subcontractors [9/P1E]

You can use this task to check all the existing subcontractor details.

Subcontractor Enquiry Selection Window

To display this window, select the Enquire on Subcontractors task.

Use this window to enter the details for the subcontractor about whom you wish to enquire.

Fields

Item

Enter the style code that uses a subcontract operation.

Alternatively, use the prompt facility to select from the Select Item/Route/Operation pop-up.

Route

Enter the route of the style/route/operation on which to enquire. It is possible to define separate subcontractors for the same style on different routes.

Alternatively, use the prompt facility to select from the Select Item/Route/Operation pop-up.

Operation

Enter the specific subcontract, or prior, operation.

Alternatively, use the prompt facility to select from the Select Item/Route/Operation pop-up.

Subcontractor

Enter the subcontractor code.

Alternatively, use the prompt facility to select from the Subcontractor Scan pop-up.

Press Enter to display the Subcontractor Enquiry Detail window.

Subcontractor Enquiry Detail Window

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

This window displays details of the subcontractor.

Fields

Style (Untitled)

These fields display the selected style code and its description.

Route

This field displays the selected route.

Operation

These fields display the selected operation and its description.

Subcontractor

These fields display the selected subcontractor code and its description.

Description

This field displays the description.

Unit Cost

This field displays the unit cost of the operation.

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

Enquire on Standard Operations [10/P1E]

Use this task to enquire upon a standard operation group. You can also display all the operation details defined to the group.

Standard Operations Enquiry Selection Window

To display this window, select the Enquire on Standard Operations task.

Use this window to enter the operation group on which you wish to enquire.

Fields

Operation Group

Enter an operation group code.

Alternatively, use the prompt facility to select from the Select Operation Group pop-up.

Select an operation group or enter an operation group code and then press Enter to display the Standard Operations Enquiry Details window.

Standard Operations Enquiry Details Window

To display this window, select an operation group or enter an operation group code and then press Enter on the Standard Operations Enquiry Selection window.

This window displays the standard operation details for the selected operation group.

Fields

Group

This field displays the standard operation group you have specified.

Group

This field displays the operation group code for this group of standard operations.

Opsq

This field displays the sequence code for this operation.

OpCode

This field displays the code for this operation.

Description

This field displays the description for this operation.

Labour

This field displays the standard run labour time per lot for this operation.

Caution: This total can indicate different labour time depending on the time basis codes you have defined for this item and route on the Additional Operation Values pop-up. The time basis codes are held in the Parameter file under major type TBCD.

Specification ID

If you have added a specification ID it is displayed here.

Options

Select

Use this against an operation to display the Standard Operation Enquiry window.

Functions

More Options (F23)

Use this to display a list of options available from this window. For a further description of these options please refer to the Standard Operations section in the Route/BOM Maintenance chapter of this product guide.

More Keys (F24)

Use this to display a list of functions available from this window. For a further description of these functions please refer to the Standard Operations section in the Route/BOM Maintenance chapter of this product guide.

Select a line to display the Standard Operation Enquiry window.

Standard Operation Enquiry Window

To display this window, select a line on the Standard Operations Enquiry Details window.

This window displays all the details you have entered for this specific operation.

Fields

Group

This field displays the operation group of which this operation is part.

Operation Sequence

This field displays the sequence number for this operation.

Operations Code

This field displays the operation code.

Operation Description

This field displays the description of the operation.

Machine

This field displays the standard machine used by the operation.

Work Centre

This field displays the work centre used by this operation.

Bundle Ticket Type

This field displays the bundle ticket type used by the operation.

Reporting Type

This field indicates whether the operation is count point or backflushed.

One of the following is displayed:

0 - Count point type A

1 - Count point type B

2 - Backflush operation type A

3 - Backflush operation type B

Reporting Level

This field indicates the level of detail required at operation booking.

One of the following is displayed:

0 - Style details

1 - Style/colour details

2 - Style/size details

3 - Style/colour/size details

Key Operation

This field indicates whether the operation has been defined as a key operation.

Lab Profile

This field displays the labour profile used by the operation.

Labour Time

This field displays the standard run time per lot for this operation.

Machine Time

This field displays the standard run machine time per lot.

Note: This is displayed in the units defined by the time basis code entered on the Additional Operation Values pop-up.

Team Size

This field displays the standard number of operators assigned to this operation.

Move Days

This field displays the time that must elapse between the end of one operation and the start of another.

Wastage %

This field displays the estimated product loss at this operation.

Specification ID

If you entered a specification ID for this operation, it is displayed here.

Std Lot Size

This field displays the standard lot size produced by this operation.

Machine Quantity

This field displays the number of machines used by the operation.

Formula Code

This field displays a user-defined code to re-calculate labour time.

Formula Code

This field displays a user-defined code to re-calculate machine time.

Functions

Additional Parms (F22)

Use this to display the Additional Parameters pop-up.

Variant Opn. (F23)

Use this to display the Variant Operations pop-up.

Select **Previous (F12)** to return to the previous window and then select **Exit (F3)** to leave the task.

Enquire on Style Route/Bill of Materials [11/P1E]

You can use this task to review style routes/bills of materials.

Style Route/Bill of Materials Enquiry Selection Window

To display this window, select the Enquire on Style Route/Bill of Materials task.

Use this window to enter the criteria for your enquiry.

Note: Additional options and functions are available. You can use the STYE type parameter in the Parameter file to define options and functions in addition to those supplied as standard.

Fields

Style

You must enter a style.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

You must enter a route.

Alternatively, use the prompt facility to select from the Select Route pop-up (or the Routes & Items pop-up if you have not specified an item).

Functions

Item Search (F16)

Use this to use the standard Inventory Item Search.

Select an item and route or enter an item and route and then press Enter to display the Style Route Header Enquiry window.

Style Route Header Enquiry Window

To display this window, select an item and route or enter an item and route and then press Enter on the Style Route/Bill of Materials Enquiry Selection window.

This window displays the header details for the route you have specified.

Fields

Parent Item

This field displays the item you have specified.

Route

This field displays the route you have specified.

Receiving Stockroom

This field displays the stockroom in which finished styles are stored.

Planning Route

This field is **checked** if this is a planning route.

Unit of Measure

This field displays the unit of measure for this style.

Standard Lot Size

This field displays the standard lot size, that is, how many of these items are produced by this route.

Economic Order Quantity

This field displays the economical order quantity to use for this style when producing amounts on this route.

Effective From Date

This field displays the first date on which this route will be used.

Effective To Date

This field displays the last date on which this route will be used.

Reference

This field displays a text reference for the route.

Average Costing Colour

This field displays the colour that is used to calculate average costs for this style.

Average Costing Size

This field displays the size that is used to calculate average costs for this style.

<u>**Functions**</u>

For a description of the functions available, refer to the Style Route Header Window section in the Route/BOM Maintenance chapter of this product guide.

Select **Previous (F12)** to return to the previous window and then select **Exit (F3)** to leave the task.

Enquiry on Text [12/P1E]

You can use this task to check the text file.

Text Enquiry Selection Window

To display this window, select the Enquiry on Text task.

Use this window to enter the criteria for your text enquiry.

Fields

Major Text Type

Enter the major text type on which to enquire. This field is the first level of the text key.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

Text Sub-Type

Enter the text sub-type for the major type on which to enquire. This field displays the second level of the text key.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

File Key

Enter the last part of the text key on which to enquire.

Alternatively, use the prompt facility to select from the Select Text Key pop-up.

Press Enter to display the Text Enquiry Details window.

Text Enquiry Details Window

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

This window displays the contents of the text file you have specified.

Fields

No of Lines to Roll

If there are many lines of text, you can enter a line number at which to start the display.

Select **Previous (F12)** to return to the previous window and then select **Exit (F3)** to leave the task.

Enquire on Indented Materials [13/P1E]

This task displays all the components of an item; each displayed indented one position from its immediate parent.

Indented Materials Enquiry Selection Window

To display this window, select the Enquire on Indented Materials task.

Use this window to enter the style and route on which you wish to enquire.

Fields

Style/Material

Enter one of the following:

- The style for which an indented list is required

Or

- The material for which an indented, where-used retrieval, is required

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Route

Enter the route.

Alternatively, use the prompt facility to select from the Select Route pop-up (or the Routes & Items pop-up if you have not specified an item).

Materials Route

- This field displays the route that will be broken down for materials found in the first level parent style.
- For where-used enquiries, it displays each style for which this material is used, using this route.

Select one of the following:

- Costing Route (1)
- Planning Route (2)
- Entered Route (3)

Quantity

Enter the lot size on which you want to base the material requirement calculations. You can specify a quantity to reflect the different usage of your routes. For example, you can enter a formulation batch size, a production batch size or an accounting batch quantity. The material requirements will be adjusted according to the quantity selected.

The quantity defaults to the economic order quantity defined for the selected route. In the case of where-used enquiries, this is the economic order quantity of the identified parent routes.

Enquiry Type

You can perform both types of enquiry taking into account or excluding wastage. The With Wastage options show material requirements based on the occurrence of planned operational and material wastage in the selected routes.

Select one of the following:

Explosion without wastage (1) (default) - You can use this to drill down from the style level and display all the components of a style. Wastage is not taken into account for this enquiry.

Explosion with wastage (2) - You can use this to drill down from style level and display all the components of a style. Wastage is taken into account.

Where-used without wastage (3) - This displays a where-used enquiry, so you can see every route on which this material is used. Wastage is not taken into account.

Where-used with wastage (4) - This displays every route on which this material is used. Wastage is taken into account.

As At

Enter or select a date to establish the effectivity of materials in explosion or where-used enquiries. Only materials effective on this date will be selected for extraction and display.

This defaults to the current date.

Ignore Effectivity

Use this checkbox as follows:

Unchecked - To view only those materials effective on the specified date

Checked - To view all materials regardless of their effectivity dates

Functions

Item Search (F16)

Use this for the standard Inventory Item Search.

Press Enter to display the Indented Materials Enquiry Details window.

Indented Materials Enquiry Details Window

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

The window displays the total material structure of a style, broken down to the lowest level material, displayed as an indented list.

Fields

Style

This field displays the style you have specified.

Quantity

This field displays the quantity you have specified.

UOM

This field displays the unit of measure you have specified.

Level

This field displays the level of the item, for the purposes of the enquiry.

Input

This field displays the material, or part, used to make the style.

St

This field displays the stockroom for the material or part.

Description

This field displays a description of the material or part.

T

This field displays the item type.

One of the following is displayed:

P - Purchased, for example, cotton, silk and so on

B -Bought out, for example, buttons, laces, zips and hangers

M - Manufactured, for example, production styles or materials

T - Consumable tools, for example, needles, blades and pins

Quantity

This field displays the quantity used to make a standard lot of this style.

UOM

This field displays the unit of measure for the material.

Functions

Item Search (F16)

Use this for the standard Inventory Item Search.

Note: You can use the Item, Route, Qty, Material Route and Enquiry Type fields in the same way as on the Indented Materials Enquiry Selection window to display the details for more styles.

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

Single Level Materials Where Used [14/P1E]

Use this task to identify all styles for which a material is used.

Material Where-used Enquiry Selection Window

To display this window, select the Single Level Materials Where Used task.

Fields

Material

Enter a material code. This enquiry is single level, and will identify all immediate parents of the style.

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

As At

Enter or select a date to control the selection of parents for this material. Only style routes where the material is effective as at this date will be selected for display. The date defaults to the current date.

Ignore Effectivity

Use this checkbox as follows:

Unchecked - To view only materials effective on the specified date

Checked - To view all parents regardless of the material effectivity

Functions

Item Search (F16)

Use this to for the standard Inventory Item Search.

Press Enter to display the Material Where-used Enquiry Details window.

Material Where-used Enquiry Details Window

To display this window, press Enter on the Material Where-used Enquiry Selection window.

Fields

Parent Item

This field displays the parent item.

Route

This field displays the route on which the material is used.

Operation/Description

These fields display the operation code and its description.

Quantity

This field displays the quantity of the material required for the operation.

Fix

One of the following is displayed:

0 - If the quantity per for the replacement material is to be treated in the same way as for the material to be replaced, that is, variable with standard lot size or fixed regardless of lot size

1 - If the <u>quantity per</u> is on a fixed basis

2 - If the <u>quantity per</u> is on a variable basis

UOM

This field displays the <u>unit of measure</u> in which the quantity is expressed.

<u>Functions</u>

Item Search (F16)

Use this for the standard Inventory Item Search.

Note: You can use the Material, Ignore Effectivity and Effectivity Ign fields in the same way as on the <u>Material Where-used</u> Enquiry Selection window to display the details for more materials.

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

Enquire on Order Policy Overrides [15/P1E]

Use this task to enquire <u>on order policy</u> overrides for a <u>SKU</u>.

Display MPS & MRP Values at SKU Selection Window

To display this window, select the Enquire <u>on Order Policy</u> Overrides task.

Use this window to enter the item on which you want to enquire.

<u>Fields</u>

Style

Enter the <u>SKU</u> on which you want to enquire.

Alternatively, use the prompt facility to select from the Item Master Scan pop-up.

Press Enter to display the Display <u>MPS</u> & <u>MRP</u> Values at <u>SKU</u> Details window.

Display MPS & MRP Values at SKU Detail Window

To display this window, press Enter on the Display <u>MPS</u> & <u>MRP</u> Values at <u>SKU</u> Selection window.

This window displays details of any overrides to the <u>order policy</u> for the selected <u>SKU</u>.

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

Item Master Listing [20/P1E]

Use this task to produce a full report of the Item Master file.

Item Master Report Selection Window

To display this window, select the Item Master Listing task.

Use this window to specify the item, or items, on which you want to report, plus the details to be included on the report.

Fields

Item Range

From

If you want to produce a report for a specific item, enter the item code. If you want to produce a report on a range of items, enter the first item.

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

To

If you are reporting on a range of items, enter the last item.

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

Note: You can leave both Item Range fields blank to produce a report on all items.

Print Production Details

Use this checkbox as follows:

Unchecked - To produce a summary report which includes standard and current costs

Checked - To produce a detailed style report which includes all current database values

Print Costing Details

Select one of the following:

Print no costs (0) - Not to include any costing details

Standard costs only (1) - To include standard costs only

Entered Cost Set range only (2) - To include only the entered cost set range

Standard and Entered Cost Set range (3) - To include the standard costs and the entered cost set range

All costs (4) - To include all costs

Note: If you select Entered Cost Set range only or Standard and Entered Cost Set range, you must enter a cost set range in the Cost Set Range fields.

Cost Set Range

If you selected **Entered Cost Set range only** or **Standard and Entered Cost Set range** in the Print Costing Details field, you must enter a cost set range.

From

Enter the first cost code.

To

Enter the last cost code to be included.

Functions

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up, which you can use to choose the specific breakdown of cost elements that you want to include in the report. You can also consolidate some elements into others.

Press Enter to submit the report.

Cost Presentation Pop-up

To display this pop-up, select **Cost Presentation (F18)** on the Item Master Report Selection window.

You can use this pop-up to change the format of costing information on the enquiry.

You can define:

- Which cost elements to include in the enquiry
- The order the elements are displayed
- How cost elements are calculated

Fields

Order

Enter the order in which to include the cost elements on the enquiry, where 1 is first, 2 is second and so on.

Add To

Enter a cost element to add that element to another. You must define a sequence number for the total.

Roll To

This displays the element into which the elements are rolled. You cannot exclude an element referred to as a roll-to element, unless you exclude the roll-to element itself.

Fixed

This field indicates whether this is a fixed cost element.

Description

You can enter or amend the description for the cost element.

Functions

Save (F15)

Use this to save the format, so that you can use it for other enquiries.

Restore (F16)

Use this to return to the default format.

Select **Previous (F12)** to return to the Item Master Report Selection window.

Report of Cost Centres [21/P1E]

You can use this task to print out the details of existing cost centres.

Cost Centres Report Selection Window

To display this window, select the Report of Cost Centres task.

Use this window to enter the cost centres you want to include on the report.

<u>**Fields**</u>

Select

From

If you want to produce a report on a specific cost centre, enter the cost centre code. If you want to report on a range of cost centres, enter the first centre.

You can use the prompt facility on this field to select from the Select Cost Centre pop-up.

Note: You can leave both fields blank to produce a report on all cost centres.

To

If you want to report on a range of cost centres, enter the last cost centre.

You can use the prompt facility on this field to select from the Select Cost Centre pop-up.

Press Enter to submit the report.

Report of Machines [22/P1E]

You can use this task to report on all the machines you are using.

Machines Report Selection Window

To display this window, select the Report of Machines task.

Use this window to specify the machines on which you wish to report.

Fields

Select

From

If you want to produce a report on a specific machine, enter the machine. If you want to report on a range of machines, enter the first machine.

You can use the prompt facility on this field to select from the Select Machine pop-up.

Note: You can leave both Select fields blank to produce a report on all machines.

To

If you want to report on a range of machines, enter the last machine to be included.

You can use the prompt facility on this field to select from the Select Machine pop-up.

Report Sequence

You can sequence the report in three ways.

Select one of the following:

Cost Centre (1) - To sequence the report by cost centre, that is, to show all machines in a cost centre

Department (2) - To sequence the report by department, that is, to show all machines in a department

Machine (3) - To sequence the report by machine

Report Type

You can produce a detailed report or summary listing.

Select one of the following:

Detail (1) - To produce a detailed report

Summary (2) - To produce a summary report

Press Enter to submit the report.

Report of Work Centres [23/P1E]

You can use this task to report on existing work centres.

Work Centres Report Selection Window

To display this window, select the Report of Work Centres task.

Use this window to select the work centres to include in the report.

Fields

Select

From

If you want to produce a report on a specific work centre, enter the work centre code. If you want to report on a range of centres, enter the first centre.

You can use the prompt facility on this field to select from the Select Work Centre pop-up.

Note: You can leave both Select fields blank to produce a report on all work centres.

To

If you want to report on a range of work centres, enter the last centre to be included.

You can use the prompt facility on this field to select from the Select Work Centre pop-up.

Press Enter to submit the report.

Report of Shift Profiles [24/P1E]

You can use this task to produce a report on existing shift profiles. Current shift patterns for each profile are printed.

Shift Profiles Report Selection Window

To display this window, select the Report of Shift Profiles task.

Use this window to select the shift profiles to include on the report.

Fields

Shift Profile Code

From

If you want to produce a report on a specific shift profile, enter the profile code. If you want to report on a range of shift profiles, enter the first profile.

You can use the prompt facility on this field to select from the CSHF Shift Profile Code pop-up.

Note: You can leave both Shift Profile Code fields blank to produce a report on all shift profiles.

To

If you want to report on a range of shift profiles, enter the last profile to be included.

You can use the prompt facility on this field to select from the CSHF Shift Profile Code pop-up.

As At Date

You can enter or select a date to only report on the shift patterns effective on that date.

Print Where Used

Use this checkbox as follows:

Unchecked - Not to include a list of machines

Checked - To include a list of all the machines that use the specified profile or profiles

Press Enter to submit the report.

Report of Labour Skills [25/P1E]

You can use this task to report on current labour skill definitions and hourly rates.

This report includes information on labour skills and hourly rates for these skills. There are no selection criteria.

Select Confirm **Submit (F8)** to submit the report.

Report of Labour Profiles [26/P1E]

You can use this task to report on current labour profile details.

Labour Profiles Report Selection Window

To display this window, select the Report of Labour Profiles task.

Use this window to enter the labour profiles you want to include on the report. You can also specify effectivity dates, to make the report as specific as possible.

Fields

Enter From Labour Profile

If you want to produce a report on a specific labour profile, enter the profile code. If you want to report on a range of labour profiles, enter the first profile.

You can use the prompt facility on this field to select from the Labour Profile Selection pop-up.

Note: You can leave both Labour Profile fields blank to produce a report on all labour profiles.

To Labour Profile

If you want to report on a range of labour profiles, enter the last profile to be included.

You can use the prompt facility on this field to select from the Labour Profile Selection pop-up.

Effective From

You can enter or select a date range to only include labour profiles effective between these dates. Enter or select the first date here.

Effective To

Enter or select the last date here.

Note: If you want to include all labour profiles, leave the default values in the Effective From and Effective To fields.

Press Enter to submit the report.

Report of Subcontractors [27/P1E]

You can use this task to print details of all the current subcontractors you use.

There are no selection criteria.

Select Confirm **Submit (F8)** to submit the report.

Report by Style Route/Bill of Material [28/P1E]

You can use this task to produce a report listing route and bill of material details.

Style Route/Bill of Materials Report Selection Window

To display this window, select the Report by Style Route/Bill of Material task.

Use this window to select the level of detail you want to include on the report.

Fields

Print Items in the Range From

If you want to report on a single item, enter the item code. To report on a range of items, enter the first item in the range here.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

To

If you want to report on a single item, enter the item code. To report on a range of items, enter the last item in the range here.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Note: *If you want to include all items on the report, leave both Item fields blank.*

Print Route Code

Enter the route on which you wish to report.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Or Print All Route Codes

Use this checkbox as follows:

Unchecked - To produce a report only for the route you have specified

Checked - To produce a report for all routes

Quantity

Enter the batch size of the route or routes on which you are reporting. Material requirements are based on this quantity. The default quantity is the economic order quantity defined for the selected route.

Include Wastage

You can base the material requirements on any planned wastage defined at operation or material level on the selected routes.

Use this checkbox as follows:

Unchecked - Not to include any planned wastage

Checked - Include any planned wastage on the selected routes

Effective As At

You can enter or select a specific date to only include routes effective on this date. Only materials effective on this date are included. The default is the current date.

Ignore Effectivity

Use this checkbox as follows:

Unchecked - To report only on materials effective on the specified date

Checked - To report on all materials in selected style routes, regardless of effectivity

Detail Level

You can print the report at three levels of detail.

Select one of the following:

All (0) - To include all operations (routes) and bill of materials details

Operations (1) - To include operation (route) details only

Materials (2) - To include bills of materials (BOMs) details only

Press Enter to submit the report.

Report of Text [29/P1E]

You can use this task to print details of all text files.

Text Report Selection Window

To display this window, select the Report of Text task.

Use this window to select the text categories on which you wish to report.

Fields

Major Type

Enter the major text type on which you wish to report.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

Sub-Type

Enter the sub-type text type on which you wish to report.

Alternatively, use the prompt facility to select from the Select Text Type pop-up.

From File Key

Enter the key of the text entity on which you wish to report. Leave this field blank to print all text entities for the major/sub-type combination.

You can use the prompt facility on this field to select from the Select Text Key pop-up.

To File Key

Enter the file key of the text entity you want to print up to. Leave this field blank to print to the end of the file for the major/sub-type combination.

You can use the prompt facility on this field to select from the Select Text Key pop-up.

Press Enter to validate your entries and then press Enter again to submit the report.

Report of Indented Materials [30/P1E]

This task produces an indented cost report for styles. All levels of the requested routes are processed to provide a simulation of the cost of production without reference to recorded style unit costs, except for bottom level material costs. You can:

- Use alternative methods of production
- Use alternative material costing methods
- Specify material effectivity dates
- Simulate different batch and unit costs, by changing the batch quantity size

The report provides a detailed analysis of operation and material costs in an indented format, so it is easy to see how costs are built up through successive levels of product definition.

You determine the cost element analysis by using default cost element management rules, which are defined on the company profile. However, you can tailor these rules to suit your requirements for a specific report, without changing the company profile settings.

Indented Materials Report Selection Window

To display this window, select the Report of Indented Materials task.

Use this window to specify the details you want to include in the report.

Fields

From Style

Enter a style on which to report.

If you want to report on an individual style, you must enter the code in the To and From fields. If you want to report on a range of styles, enter the first code here.

You can use the prompt facility on this field to select from the Routes & Items pop-up (or the Select Item pop-up if you have already specified a route).

To Style

If you are reporting on a range of styles, enter the last style.

You can use the prompt facility on this field to select from the Routes & Items pop-up (or the Select Item pop-up if you have already specified a route).

Note: You can leave both Style fields blank to report on all styles.

Route

Enter the route code to be used, or enter **ALL** after the forward slash to include all routes defined to the styles you have specified.

You can use the prompt facility on this field to select from the Select Route pop-up.

Material Route

Select one of the following:

Planning (1) - To use the planning route

Costing (2) - To use the costing route

Entered route (3) - To use the route you have specified

Batch Quantity

Enter the batch quantity you want to cost. If you leave this field blank, the software uses the economic order quantity defined for each selected style and route. The batch quantity determines all lower level material usage.

Fixed costs are derived from the following:

- Set up labour time
- Fixed time, operation, labour and machine costs
- Fixed user-defined costs
- Fixed overheads

Costing Method

You can specify which costing method to use to calculate production costs.

Select one of the following:

Standard (1) - To use standard costs

Entered cost set (2) - To use the entered cost set

No costing (3) - Not to include costs

Note: If you select Entered cost set, you must enter a cost set in the Cost Set field.

Cost Set

If you selected **Entered cost set** in the Costing Method field, you must enter a cost set. This field is used to determine material costs:

- If the Material Route field is set to **Planning**, the software uses standard cost centre rates and standard material costs.
- If the Material Route field is set to **Costing**, the software uses current cost centre rates and non-standard material costs from the entered cost set.

Inc. Wastage

You can generate costs that take account of operational and material wastage. You define the default value of this parameter in the company profile.

Use this checkbox as follows:

Unchecked - Not to include wastage

Checked - To include wastage

Material Costs

Use this to specify where the unit material costs are derived.

Select one of the following:

Production (1) - To use the production standard, or entered, cost set

Inventory (2) - To use the Inventory stockroom value

This uses the cost held on the primary stockroom record for each material input.

Note: These are the only recorded costs used to calculate style costs.

Operation Details

Use this checkbox as follows:

Unchecked - Not to include summary operation details

Checked - To include summary operation details

As At

You can enter or select a date here, so that only materials effective on this date are included on the report. The default is the current date.

Ignore Effectivity

Use this checkbox as follows:

Unchecked - To include only materials effective on the specified date

Checked - To include all materials regardless of their effectivity

Functions

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up.

Press Enter to submit the report.

Report of Materials Where Used [31/P1E]

You can use this task to produce a report that details every instance in which specified materials are used.

Materials Where Used Report Selection Window

To display this window, select the Report of Materials Where Used task.

Use this window to enter the materials to include in the report.

Fields

From Material

If you want to report on an individual material, enter the same code here and in the To Material field. If you want the report to include a range of materials, enter the first material here.

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

To Material

Enter the last material of the range.

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

Note: Leave both the Material fields blank to include all materials.

Route

Enter the route to use to identify the materials and the styles they are used on. Only styles with this route will be reported.

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

Or Type 'ALL' for All Routes

If you want to include all routes, enter **ALL** in this field. The report includes all parents of selected materials on all defined routes where used.

As At Date

You can enter or select a date to only include routes where materials are effective on that date.

Ignore Effectivity

Use this checkbox as follows:

Unchecked - To include only those materials that are effective on the specified date

Checked - To include all routes and materials, regardless of effectivity dates

Press Enter to submit the report.

Mach/WC Where Used Report [32/P1E]

You can use this task to generate details of routes that use specified work centres and machines. It identifies where machines and work centres are defined on style route operations. You can use this to assess the operational impact of changing a machine or work centre.

Machine/Work Centre Where Used Selection Window

To display this window, select the Mach/WC Where Used Report task.

Use this window to specify the machines and work centres you want to include on the report.

Fields

Select

From

If you want to report on an individual machine or work centre, enter the same code both here and in the To field. If you want the report to include a range of machines or work centres, enter the first one here.

You can use the prompt facility on this field to select from the Select Machine pop-up.

To

Enter the last machine, or work centre, of the range.

You can use the prompt facility on this field to select from the Select Machine pop-up.

Note: Leave both the Select fields blank to include all machines and work centres.

Sequence

Select one of the following:

Machine (1) - To sequence the report by machine

Work Centre (2) - To sequence the report by work centre

Press Enter to submit the report.

Print Company Profile [33/P1E]

You can use this task to review all the information held on your company profile.

There are no selection criteria.

Select Confirm **Submit (F8)** to submit the report.

Chapter 5   Product Costing

5

Style Costing

Style Production stores costs separately from those in Inventory Management.

Within Style Production, you can define material unit costs and calculate production costs. You can then combine those elements in order to arrive at a total style cost.

This is how total costs are calculated:

1   Enter material unit costs as inventory details using the Styles task in Style Inventory Management or the Styles task in Style Production. Unit costs can be held at standard, latest, average or FIFO and depend on the costing method employed within the relevant issuing stockroom. However, you can override the costing method for each individual material.

2   The software multiplies the material unit costs by the quantities required to obtain the total material cost.

3   Production costs are calculated from production routes by determining labour, machine and overhead costs.

Note: The costs attributable to planned wastage are routinely calculated and held separately for each element. You can optionally consolidate the wastage cost into the corresponding cost element.

Cost Sets

The software supports standard and non-standard costing of items.

Actual costs are calculated from the bookings you make against production orders in Style Production Control.

You can define one standard cost to a style, as well as many non-standard cost sets for each of its production routes. Each cost set has 14 cost elements, 10 of which are standard and 4 of which are user-defined. You can operate with any number of cost sets.

Standard operation labour, machine and overhead costs come from standard cost centre rates and values, as well as overhead methods.

Non-standard costs, that is, any cost set other than standard, use current rates and values. The software holds these non-standard costs on the same cost centre record, and may derive material costs from standard or non-standard sources.

Style Average Costs

For any one style, costs generated for producing style variants can differ because of one of the following:

- The style route has variant operations.
- The style route has varying material quantities per style or size.
- Material variant costs differ.

Style cost is generated using the colour and size defined for the primary operation. Each variant uses the operation costs for its colour and size.

To generate a style cost based on the true average cost of the style's variants, you can select a variant weighting option. This option calculates the average cost as follows:

- Weight the cost of variants for a style by forecast quantities.
- Total the weighted cost.
- Divide the weighted cost by the total forecast quantity.

Alternatively, you can enter weighting quantities directly and not use extracted forecasts. You can create weightings for a single style or for a range of styles.

Re-costs

Re-costs are performed for production styles on a single level basis, where all identified materials on the designated costing route for a style have their recorded cost elements rolled into the cost elements of the parent.

You re-cost styles on a roll up basis, beginning with materials having the greatest low-level code. This ensures cost integrity.

Re-cost functions are available for:

- A single style
- All styles

FIFO Costing

For FIFO controlled styles, Style Production can calculate the actual cost of receipts into stock from a production order.

FIFO costs are calculated and recorded when a good quantity is booked on the final operation of a production order.

You build the FIFO from all the cost elements existing for the style.

The total material cost of a production order is the sum of all the inventory movement costs caused by material issues. The movement cost of one material depends upon its actual costing method. For standard costing, the stockroom's standard cost is used. For FIFO costing, the appropriate actual cost is used.

You take subcontract costs from the subcontract operations on production orders. The cost defaults from the standard route when you create the order, but you can also amend it.

As there are normally several receipts into finished goods from one production order, you have to apportion the total order costs. You consider each variant on the order as a separate receipt.

To use FIFO costing, you must do the following:

- Set the FIFO Receipt Costing Method to **Actual** on the Maintain Company Profile Production Order Options window.
- Define the style as being FIFO costed by setting the Costing Method to **FIFO** on Product Maintenance Costing Details window in the Styles task.

FIFO Cost Calculations

First Receipt

FIFO Cost = Material Cost + Subcontract Cost + Other Costs (for example, machine, labour and overhead) where:

Material Cost = Total Material Issue Cost / Production Order Qty x Qty Received

Subcontract Cost = Production Order Subcontract Unit Cost x Qty Received

Other Costs = Machine Costs + Set Up Costs + Labour Costs + Overheads

This field displays the total cost of the receipt; you derive the unit cost by simply dividing the receipt quantity into the total cost. You write this total cost to the production order as the current order cost.

Subsequent Receipts

FIFO Cost = New Order Cost (including this receipt) - Previous Order Cost

You calculate this as follows:

The software records the cost before receipt takes place.

The new order cost is then calculated as Material Cost + Subcontract Cost + Other Costs where:

- Material Cost = Total Material Issue Cost / Production Order Qty x Total Qty Received against the order
- Subcontract Cost = Production Order Subcontract Unit Cost x Total Quantity Received against the order
- Other Costs = Machine Costs + Set Up Costs + Labour Costs + Overheads

The FIFO transaction cost calculates as:

- New Order Cost - Previous Order Cost

The production order then updates with the new order cost.

FIFO Cost Transactions

The material cost portion of the FIFO cost is more evenly spread if all production order issues are made before the first receipt is carried out. If you issue materials after this time, which can happen if some materials are backflushed, you do not get an even spread for the material element of the FIFO cost transactions.

FIFO cost transactions, produced from production order over receipt situations contain costs for:

Subcontract + additional material costs + recovery of additional costs that are added to the order (where subcontracts are always unit cost-related and additional material costs are actual unit costs multiplied by the over receipt quantity)

FIFO costs do not account for outstanding material and subcontract costs on orders closed out early.

If a production order is completed, through entry of bookings or through the Order Completion task, an additional report is produced to show the planned, actual and recovered material quantities and costs. You use the report to identify whether existing FIFO costs need adjusting for General Ledger journals.

Scrap costs of items scrapped after receipt for a subcontractor are not included in the subcontract cost portion of the FIFO cost.

Item Master File Re-cost [1/P1C]

This task is similar to the Single Item Re-cost task. However, you can include all styles here.

For each style, the software uses the costing route specified in the Styles task to calculate the costs at each operation level and to sum the overhead at variant level.

All operational cost elements are calculated for the parent level and corresponding material cost elements are added. The result is a new current cost for the parent.

Caution: If you select some styles and not others, inconsistencies may occur within a style. Styles processed via this task reflect the latest costing routes and rates whilst other styles will reflect the conditions at the time of their re-cost. Therefore, the cost of styles that contain a mix of such item costs may differ from costs shown on other cost enquiries and reports.

Before you use this task, make sure that you have established costs for non-production materials, by:

• Using the Purchased Item Re-cost task to transfer costs from Style Inventory Management

Or

• Entering costs manually using the Maintain Item Costs task

Item Master File Cost Update Selection Window

To display this window, select the Item Master File Re-cost task.

Use this window to enter the details of the re-costing.

Fields

Option

Select one of the following:

Standard costing only (1) - To re-cost standard costs only

Entered cost set only (2) - To re-cost the entered cost set only

In this case, you must enter a set in the Cost Set field.

Standard and Entered cost set (3) - To re-cost standard costs and an entered cost set

Note: If you select Entered cost set only or Standard and Entered cost set in this field, you should also specify whether to use standard costs as a cost set for the materials, in the Material Costs field.

Use Costing Route

Use this checkbox as follows:

Unchecked - To cost the entered route for a style or range of styles

Checked - To use the costing route as defined on the Style Production details

Or Entered Route

Enter a route.

Cost Set

If you selected **Entered cost set only** or **Standard and Entered cost set** in the Option field, you must enter the cost set to update.

Note: If you enter a cost set in this field, Style uses current cost centre rates to calculate operation costs.

Material Costs

If you selected **Entered cost set only** or **Standard and Entered cost set** in the Option field, select one of the following:

Standard Costs (1) - To use the Standard Cost field for materials to re-calculate non-standard costs for styles

Entered Cost Set (2) - To use the cost set that you enter in the Cost Set (Materials) field to re-calculate non-standard costs for styles

In this way, you can generate many different cost sets for the parent style using different routes, without having to set up multiple cost sets for the same route/styles.

Note: Style uses current cost centre cost rates and recovery methods to calculate production costs for non-standard cost sets.

Cost Set (Materials)

If you selected **Entered Cost Set** in the Material Costs field, enter a cost set to use for the material costs.

Cost As At

Enter or select a date. Only materials on a costing route which is effective on this date are included in the cost roll-up. The default is the current date.

Consolidate Wastage

Style always calculates and records costs caused by planned operational and material wastage. However, you can specify whether these wastage costs are to contribute to style unit costs.

Select one of the following:

Exclude wastage (0) - To exclude wastage costs from style unit costs

Include wastage (1) - To consolidate wastage costs within style unit costs

You can set up a default value for this parameter in the company profile.

Styles to Process

From

If you want to re-cost a specific style, enter the same code here and in the To field. If you want to re-cost a range of styles, enter the first in the range.

To

If you want to re-cost a range of styles, enter the last in the range.

Note: you can leave these fields blank to re-cost all styles.

Uncosted Styles Only

Use this checkbox as follows:

Unchecked - To generate costs for all styles

Checked - To generate costs for new styles without affecting established style costs

Low Level Code Calc

Use this checkbox as follows:

Unchecked - To rebuild low-level codes in the re-cost process

Checked - If you do not want to rebuild low-level codes in the re-cost process

Press Enter and then select **Continue (F8)** to update all selected costs.

Single Item Re-cost [2/P1C]

This task performs a full re-cost for one style. Style calculates the costs at each operation level and sums the overhead at variant level. The task allows you to anticipate the Item Master File Re-cost task calculation for a style.

Style calculates operational costs from the specified route using the appropriate cost centre rates; standard for standard costing, and current rates for any other cost set. The software then incorporates material costs into the parent style costs.

You can perform a re-cost simulation in several ways:

- Select alternative routes.
- Include or exclude wastage.
- Use standard or non-standard cost sets.

Prerequisites

Make sure you have recorded costs against all the materials on the selected style. Otherwise, the style cost calculation will be incomplete.

You should also have set up user-defined costs, if required, for production. To do this, either transfer costs from Style Inventory Management via the Purchased Item Re-cost task, or enter costs manually via the Maintain Item Costs task.

Single Item Re-cost Selection and Update Selection Window

To display this window, select the Single Item Re-cost task.

Use this window to select a style, route and costing method for re-costing.

Fields

Style

Enter the style for which to re-calculate costs.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

Enter the route for which to re-calculate the costs.

Alternatively, use the prompt facility to select from the Select Route pop-up or from the Routes & Items pop-up if you have left the Style field blank.

Cost As At

You can optionally enter or select a date so those only materials on the costed route that are effective on that date are included in the cost re-calculation.

The default is the current date.

Include Wastage

Style always calculates and records costs caused by planned operational and material wastage. However, you can specify whether these wastage costs are to contribute to style unit costs.

Use this checkbox as follows:

Unchecked - To hold wastage costs separately from style unit costs

Checked - To consolidate wastage costs within style unit costs

You can set up a default value for this parameter using the Hold Costs with Wastage field in the company profile.

Costing Method

Select one of the following:

Standard costs only (1) - To re-cost standard costs only

Entered cost set only (2) - To re-cost the entered cost set only

In this case, you must enter a set in the Cost Set field.

Both (3) - To re-cost the standard costs and the entered cost set

Note: *If you select Entered cost set only or Both in this field, you must use the Material Costs field to specify whether to use standard costs as a cost set for the materials.*

Cost Set

If you selected **Entered cost set only** or **Both** in the Costing Method field, you must enter the cost set to update.

Material Costs

If you selected **Entered cost set only** or **Both** in the Costing Method field, select one of the following:

Standard Costs only (1) - To use the Standard Cost field for materials to re-calculate non-standard costs for styles

Entered Cost Set (2) - To use the cost set entered in the Cost Set (Materials) field to re-calculate non-standard costs for styles

In this way, you can generate many different cost sets for the parent style using different routes, without having to set up multiple cost sets for the same route/style.

Cost Set (Materials)

If you selected **Entered Cost Set** in the Material Costs field, enter the cost set from which to use material costs.

Functions

Item Search (F16)

Use this for the standard Inventory item search.

Press Enter to display the Single Item Re-cost Selection and Update Details window.

Single Item Re-cost Selection and Update Details Window

To display this window, press Enter on the Single Item Re-cost Selection and Update Selection window.

This window displays the re-calculated costs for selections you entered on the previous window. The window breaks the total cost down to cost elements and displays the total cost after the last cost element.

The value selected in the Costing Method field on Single Item Re-cost Selection and Update Selection window determines what is displayed here.

Fields

Style

This field displays the style you have selected.

Route

This field displays the route you have selected.

UOM

This field displays the unit of measure.

Cost As At

If you have specified an effective date, it is displayed here.

Standard Cost Set

If you are using standard costs, the cost set description is displayed. You can change the description.

Selected Cost Set

If you are using selected costs, the cost set description is displayed. You can change the description.

Description

This field displays the cost description.

Standard

This field displays the standard cost.

Selected

This field displays the selected cost.

Select **Update (F8)** to update the cost set descriptions.

Purchased Item Re-cost [3/P1C]

You can use this task to copy material costs, for non-production items, from Style Inventory Management to Style Production. This avoids having to enter each material cost individually using the Maintain Item Costs task.

Note: You must establish material costs for non-production items before you can derive costs for styles in Production.

When you use this task, you do not change any costs other than material costs that you have set up for the styles.

The designated primary stockroom for the selected item is accessed according to the Costing Method set up for each style in Inventory Details under the Styles task:

- **FIFO** - The software uses the first FIFO record. If there is no FIFO cost, Style uses the price from the latest purchase order for the item, if you are using Style Purchase Management. If no purchase order price is available, the price from the Supplier Price file is used. Discounts are applied, if applicable.
- **Latest cost** - Latest costs are taken from the stockroom records. If no latest cost is available, the software obtains a purchase price in the same way as for FIFO costs.
- **Average cost** - Average costs are taken from the stockroom records. If no average cost is available, the software obtains a purchase price in the same way as for FIFO costs.
- **Standard cost** - Standard costs are taken from the stockroom records. If there is no standard cost recorded, no further retrieval is attempted.

Style converts all costs from the Style Inventory Management purchasing UOM to the issuing UOM in the primary stockroom. The software updates the material cost element with the cost; this may be, for example, Fabric, Trim or Packaging.

Purchase Items Costing
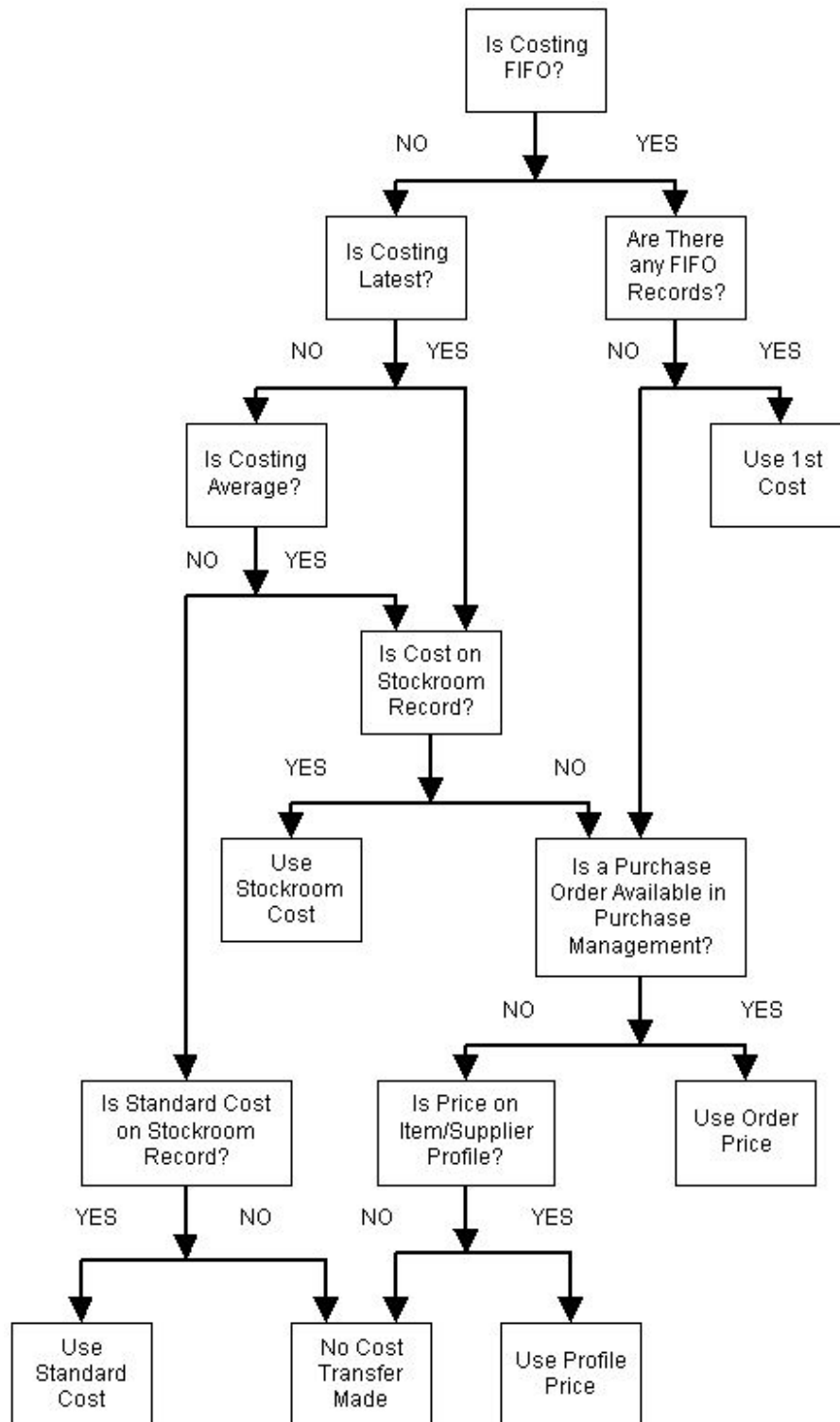
Purchased Items Costing Update Selection Window

To display this window, select the Purchased Item Re-cost task.

Use this window to enter the purchased items to re-cost.

Fields

Range of Styles to Process

Enter the first item in the range you want to re-cost. If you just want to re-cost one item, enter the same item in both fields.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Note: All materials with an Item Type other than M (Production) are re-costed.

To

Enter the last item in the range to be re-costed.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Create Costs For

Select one of the following:

Standard costs (1) - To re-cost standard costs only

Entered Cost Set (2) - To re-cost the entered cost set only

In this case, you must enter a set in the Cost Set field.

Both (3) - To re-cost standard costs and the entered cost set

Cost Set

If you selected **Entered Cost Set** or **Both** in the Create Costs For field, you must enter the cost set to update.

Inventory Costs to Copy

Use this to specify which Inventory cost types to copy.

Select one of the following:

Default setting from inventory (0 or blank) - To use the cost defined in the Costing Method field in the Style Inventory Management company profile

Standard (1) - To copy standard costs

Latest (2) - To copy latest costs

Average (3) - To copy average costs

FIFO (4) - To copy FIFO costs

Styles without Costs

You can restrict the re-cost to purchased items that have no material costs for the requested cost set, or sets.

Use this checkbox as follows:

Unchecked - To re-cost all selected items

Checked - To re-cost styles without costs only

Cost Set Description

If you selected **Entered Cost Set** or **Both** in the Create Costs For field, enter a description for the cost set. For standard costs, you can leave the description blank.

Transfer Landed Costs

Use this checkbox as follows:

Unchecked - Not to copy landed costs

Checked - To copy landed costs

This displays the Landed Cost Transfer Rules pop-up.

Note: Remember that landed costs are only associated with standard costed items.

Press Enter and then select **Submit Job (F8)** to update the purchased item costs.

Landed Cost Transfer Rules Pop-up

To display this pop-up, check the Transfer Landed Costs field on the Purchased Items Costing Update Selection window.

Use this pop-up to select one or more landed costs for inclusion as cost elements in the purchase costs for purchased items.

The pop-up displays the landed costs set up against the LAND code in the Descriptions file in Style Inventory Management.

The task produces a control report detailing the results of the re-cost.

Fields

Copy to Cost Element

Enter the cost element in which to include this landed cost.

You define the cost elements in the company profile under User 1, User 2, User 3 and User 4.

Select **Previous (F12)** to return to the Purchased Items Costing Update Selection window.

Transfer Costs to Inventory [4/P1C]

You can use this task to transfer the standard style costs, which you have set up in Style Production, to your Inventory stockrooms. Inventory uses style costs for stock valuation, determining profit margins and determining selling prices.

The cost transferred is the sum of the cost elements designated in the Style Production company profile. The task copies the selected cost set to each standard costed stockroom defined for a style. If there is no production cost for a style, the existing standard cost in Inventory stays the same.

You can specify whether to update only those styles costed at standard in Inventory or whether to process all styles, regardless of Inventory costing methods.

You can transfer costs for production items only or for a mixture of production, purchased, bought out and consumable items.

For every standard costed Inventory style updated, the task creates an audit report.

Inventory Standard Cost Update Selection Window

To display this window, select the Transfer Costs to Inventory task.

Use this window to enter the styles for which to copy costs.

Fields

Inventory Styles to Process

Use this to specify which Inventory styles to update.

Select one of the following:

Standard costed only (1) - To update costed Inventory styles at standard only

This updates the selected production unit cost in each stockroom for standard costed styles. An Inventory audit is generated for each stockroom re-valuation.

All cost methods (2) - To update all cost methods

This updates costed Inventory styles at standard. It also updates the standard cost for Inventory styles costed by other methods, that is average, latest and FIFO, but does not create an audit record, because changes to standard do not affect the valuation.

From Style

If you want to just process an individual style, enter the same code in the To and From fields. If you want to transfer a range, enter the first item.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

To Style

Enter the last item in the range.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Note: You can leave both Style fields blank to include all styles.

Style Types

Use this field to restrict the transfer to certain item types.

You can enter up to four of the following:

M - Production items

This is the default setting.

P - Purchased items

B - Bought out items

T - Consumable tools

These codes are defined via the Maintain Parameter File task, major type PITP.

Styles without Costs

Select one of the following:

Styles with and without costs (0) - To update styles that you have already costed and styles that do not yet have costs

Styles without costs only (1) -To update only styles that do not have costs yet

Primary Stockroom Only

Use this field to specify whether only the primary stockroom for each style is updated, or all stockrooms.

Use this checkbox as follows:

Unchecked - To update all stockrooms

Checked - To update only the primary stockroom for each style

Production Cost Set

Enter a cost set, if you want to transfer costs from a non-standard cost set.

Leave this field blank to transfer costs from the Production standard cost set.

Print Exception Report

Use this field to specify whether an Exception report is required. The Exception report will report any Styles within the range entered which are not processed.

Use this checkbox as follows:

Unchecked - If an Exception report is not required

Checked - If an Exception report is required

Exception Report Detail Level

If the Exception report has been selected, select one of the following:

Style (1) - To print detail of each style

Full Product (2) - To print detail of each SKU

Press Enter and then select **Submit Job (F8)** to submit the batch job.

Copy Cost Sets/Rates [5/P1C]

Use this task to copy cost centre rates and style costs, where these are set up, between cost sets.

You can choose to copy costs and rates for production items only or for a mixture of production, purchased, bought out and consumable items.

Copy Cost Sets/Rates

To display this window, select the Copy Cost Sets/Rates task.

Use this window to enter the details to copy.

Fields

Copy Function

Select one of the following:

Cost centre rates and Style costs (1) - To copy both cost centre rates and style costs

Costs only (2) - To copy style costs only

Rates only (3) - To copy cost centre rates only

Copy From Set

If you only want to copy a specific cost set, enter that cost set in the To and From fields. If you want to copy a range of cost sets, enter the first set in the range.

Note: Leave this field blank to include all cost sets.

To Set

Enter the last cost set in the range.

Styles to Process

From

If you want to copy a specific style, enter the same code in the From and To fields. If you want to copy a range, enter the first item.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

To

Enter the last item in the range.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Note: You can leave both of these fields blank to include all styles.

Style Types

If you selected **Cost centre rates and Style costs** or **Costs only** in the Copy Function field, use this field to restrict the copy to styles of a particular item type.

Enter one or more of the following:

M (default) - Production items

P - Purchased items

B - Bought out items

T - Consumable tools

You define these codes via the Maintain Parameter File task, major type PITP.

Note: To copy current costs for all styles in the selected range, leave this field blank.

Press Enter and then select **Submit Job (F8)** to submit the batch job.

Annual Standard Cost Transfer [6/P1C]

This task updates the standard costs for a style both in Production and Inventory with the costs from entered route/cost set. It also updates the costing routes for the style and copies the cost centre current rates to become new standard rates.

Annual Standard Cost Transfer Window

To display this window, select the Annual Standard Cost Transfer task.

Fields

Inventory Styles to Process

Select one of the following:

Standard costed only (1) - To update styles which in Inventory are costed at standard only

All cost methods (2) - To update styles regardless of their costing method in Inventory

From Style/To Style

Enter a single style or a range of styles to process. Leave these fields blank to process all styles.

You can use the prompt facility on these fields to select from the Routes & Items pop-up.

Style Types

Select the style type to process.

Entries can be **M**, **P**, **B**, or **X**.

If this field is left blank, all styles defined as **M** (Manufactured) will be processed.

Styles without Costs

If you select **Styles** **without** **costs** only, user-defined costs will only be updated for styles without user-defined costs already set.

Primary Stockroom Only

Use this checkbox as follows:

Unchecked - To update all stockrooms

Checked - To update the primary stockroom for each style only

Change Costing Route

Select **Yes** if the costing route on the Style Production details is to be changed to the new costing route entered previously.

Select **No** to leave the costing route on the Style production details as it is.

Caution: Leaving the costing route on the style as the old route will impact on the standard costs used for the transactions in Production Control.

New Costing Route

Enter the route code which has previously been costed, which is to be used for the new standard cost.

You can use the prompt facility on this field to select from the Select Route pop-up, or the Routes & Items pop-up if you have left the Style fields blank.

Caution: This is a mandatory field. If it is left blank, the route code 'Blank' will be assumed.

Production Cost Set

You must enter the cost set containing the non-standard costs which are to be used for the new standard cost.

Update Cost Centres with New Rates

Use this checkbox as follows:

Unchecked - Not to replace the rates

Checked - To replace the standard labour, machine and overhead rates with the current rates set on each cost centre

Existing Costing Route Code

Enter a route code to limit the styles processed to those with a specific costing route. Enter **ALL** to process all styles within the range entered previously regardless of their costing route.

You can use the prompt facility on this field to select from the Select Route pop-up, or the Routes & Items pop-up if you have left the Style fields blank.

Caution: This is a mandatory field. If it is left blank and ALL is not entered, the route code 'Blank' will be assumed.

Print Exception Report

Use this if an Exception report is required. The Exception report will report any styles within the range entered which are not processed.

Use this checkbox as follows:

Unchecked - If an Exception report is not required

Checked - If an Exception report is required

Exception Report Detail Level

If the exception report has been selected, select one of the following:

Style (1) - To print detail for each Style

Full Product (2) - To print detail for each SKU

Press Enter and then select **Submit Job (F8)** to submit a batch job.

User Cost Mass Update [7/P1C]

Use this task to perform a mass update of the four user cost elements for a specific route over a range of styles.

Caution: This task should be taken after rolling up the costs for an item.

User Defined Cost Elements Update Selection Window

To display this window, select the User Cost Mass Update task.

Fields

Costing Route

Use this checkbox as follows:

Unchecked - To cost the entered route for a style or range of styles

Checked - To use the costing route as defined via the Style Production details

Or Entered Route

Enter a route.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Cost As At

You can optionally enter or select an effective date.

This defaults to the current date.

Costing Method

Use this field to select the costing method used previously when rolling up the style costs.

Select one of the following:

Standard costing only (1)

Entered cost set only (2)

Both (3)

Cost Set

Enter the cost set created previously when rolling up the style costs. Leave this field blank for standard costs.

Alternatively, use the prompt facility to select from the Cost Set pop-up.

Styles to Process

From/To

Enter a single style or a range of styles to process. Leave these fields blank to process all styles.

You can use the prompt facility on these fields to select from the Routes & Items pop-up.

Style Types

Select the style types to process.

Entries can be **M**, **P**, **B**, or **X**.

If this field is left blank, all styles defined as M (Manufactured) will be processed.

Uncosted Styles Only

Use this checkbox as follows:

Unchecked - To update all user-defined costs

Checked - User-defined costs will only be updated for styles without user-defined costs already set

Press Enter to see the User Defined Cost Elements Update window.

User Defined Cost Elements Update Window

To display this window, press Enter on the User Defined Cost Elements Update Selection window.

Fields

Unit Costs

Enter the four user cost values to be applied to all selected styles.

> **Caution:** All four user costs are applied as a set. This means that any left as zero will override previously set values and be set to zero.

Select **Update (F8)** to submit a batch job which checks each style in the range. If costs for the route are found, it adds the user costs to the rolled up costs for each style and its SKUs.

Indented Cost Simulation [11/P1C]

You can use this task to simulate the unit and batch cost of a style.

> **Caution:** Before you attempt to generate style costs using re-cost routines, you should define production style routes and material costs for non-production items fully.

You can:

- Experiment with alternative routes/pricing and cost policies

This option does not restrict you to the costing route.

- Include or exclude wastage
- Try different effectivity dates
- Try different batch sizes
- Substitute or remove materials
- Use different material issuing stockrooms
- Apply percentage cost changes by item type and stockroom

Rolling up the costs from the lowest level generates the elements of cost for the selected style. Single level and rolled up costs are visible for all styles in the enquiry.

The only recorded costs used by this task are the material costs for purchased items and any user-defined costs. The software calculates all other elements of cost according to your selection parameters.

Note: You can save your changes under new cost sets.

Indented Cost Simulation Style Selection Window

To display this window, select the Indented Cost Simulation task.

Use this window to cost a style through a specific route. You can return to this window to cost styles through alternative routes.

Fields

Style

Enter the style for which to simulate costs.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Route

Enter the route for which to simulate costs.

You can use the prompt facility on this field to select from the Select Route pop-up, or the Routes & Items pop-up if you have left the Style fields blank.

Material Route

Select the route to use.

Select one of the following:

Planning Route (1) - To use the planning route, as defined in the Styles task

Costing Route (2) - To use the costing route, as defined under the Styles task

Entered Route (3) - To use the route that you have entered in the Route field

As At

If you enter or select a date in this field, only materials that are effective on that date are included in the calculations.

The default is the current date.

Quantity

Enter the size of the batch you want to cost for the style. The batch quantity determines all lower level material usage.

To use the economic order quantity defined for the style route, leave this field blank.

Costing Method for Production Costs

Use this field to specify the required production costing method.

Select one of the following:

Standard Production Rates (1) - To use standard production rates, that is, standard cost centre rates

Current Production Rates (2) - To use current production rates, that is, current cost centre rates

Costing Method for Material Costs

Use this to specify the required material costs.

Select one of the following:

Production Standards (1) - To use production standard costs

Entered Cost Set (2) - To use the cost set you enter in the Cost Set field

Cost Set

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

Include Wastage

You can generate costs that take account of operational and material wastage.

Use this checkbox as follows:

Unchecked - Not to include wastage

Checked - To include wastage

Functions

Item Search (F16)

Use this to use the standard Inventory item search.

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up.

Press Enter to calculate the costs and display the Indented Cost Simulation window.

Indented Cost Simulation Window

To display this window, press Enter on the Indented Cost Simulation Style Selection window.

This window lists the materials on the Bill of Material for the selected style and route.

The top right displays a total cost. The **T** (Type) field indicates the setting of each material's Item Type flag: **B** (Bought Out), **P** (Purchased), **M** (Production) or **T** (Consumable Tool). The values in the Original Cost field remain unaltered throughout the simulation for the purposes of comparison.

Initially, the values in the Simulated Line Cost field and Original Cost field are equal.

When you manipulate the data, the Simulated Line Cost field displays the values that may have changed during the simulation.

Note: Items with inadequate cost definitions are highlighted.

Options

Item Change

Use this to display the Item Change pop-up, which you can use to enter a replacement material or change its cost details or issuing stockroom.

Remove

Use this to display the Remove Item pop-up, which you can use to remove a material from the indented list.

Item Cost Detail

Use this to display the Cost Elements pop-up, which displays rolled-up cost elements.

*Note: If you select any of these options, you must select **Simulate Costs (F15)** to see the new simulation on window.*

Note: You can only remove or replace low level materials. You cannot alter any items that have process routes.

Functions

Reset (F5)

Use this to re-set the costs to their original values.

Simulate Costs (F15)

Use this to apply your changes. Costs are simulated based on changes made in stockroom issuing costs, or in adding or changing material requirements and costs.

Cost Changes (F17)

Use this to perform global cost changes. This applies percentage increases to those purchased and production items that are materials on this style. This displays the Cost Changes on Stockroom Items window.

Parent Detail (F21)

Use this to display the Cost Elements pop-up.

Item Details (F22)

Use this to display the following material cost details on a separate line underneath each material: issuing stockroom, wastage percentage, description and unit cost.

Save Costs (F23)

Use this to save these costs to an existing cost set, or save these costs with a new cost set name. This displays the Save Simulated Costs pop-up.

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

Item Change Pop-up

To display this pop-up, select Item Change against a line on the Indented Cost Simulation window.

Use this pop-up to do one of the following:

- Specify a substitute material
- Change the cost details of a material
- Change the quantity of material used

Fields

Enter Item

You can enter a substitute material. You cannot enter any production items (item type M).

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

Stockroom

If you are substituting the material, enter an issuing stockroom for the substitute material.

Alternatively, you can enter an alternative stockroom to pick up different costs for the same material.

You can use the prompt facility on this field to select from the Select Stockroom pop-up.

Note:** To simulate the cost effect of removing this material, select Remove against a line on the Indented Cost Simulation window and then select **Simulate Costs (F15).

Quantity

Enter a quantity for the substituted item. If you are not substituting a material, you can change the current quantity.

Select **Change Costs (F8)** to display the Change Unit Cost Elements pop-up or select **Previous (F12)** to return to the Indented Cost Simulation window.

Change Unit Cost Elements Pop-up

To display this pop-up, select **Change Costs (F8)** on the Item Change pop-up.

Use this pop-up to adjust each cost element associated with the material manually.

Fields

Cost Element

Enter a cost element.

Functions

Refresh (F5)

Use this to display the original costs (as they were before you made any changes).

Total (F8)

Use this to total the costs after adjustment.

Select **Previous (F12)** to return to the Item Change pop-up.

Remove Item Pop-up

To display this pop-up, select Delete against a line on the Indented Cost Simulation window.

Use this pop-up to remove a material from the indented list.

Fields

Item

This field displays the item code and description.

Stockroom

This field displays the stockroom for the item.

Quantity

This field displays the quantity of the item.

Functions

Remove (F11)

Use this to delete the material, for the purposes of this enquiry only.

Select **Previous (F12)** to return to the Indented Cost Simulation window.

Cost Elements Pop-up

To display cost elements for a material, select Item Cost Detail against a line on the Indented Cost Simulation window or on the Single Level Cost Enquiry Details window.

Alternatively, select **Parent Detail (F21)** on the Indented Cost Simulation window.

Alternatively, select **Rolled Up Costs (F17)** or **This level Costs (F21)** on the Single Level Cost Enquiry Details window.

This pop-up displays the simulated costs by element for the selected material or style on a particular route. The displayed elements contain the rolled-up/single level costs for the indented bill of material, plus any user defined costs for the style. The pop-up does not display any zero cost elements.

Wastage

If you are costing with wastage included, and have defined a wastage bucket in cost element management, the software only separates certain portions of wastage cost. Any wastage due to an inflated quantity per does not accumulate into the wastage bucket, but consolidates into the appropriate cost elements for roll-up. Operational wastage that inflates the operational costs at any level rolls up into the wastage total element.

Fields

Item

This field displays the item you have entered.

All the cost element descriptions and costs are listed.

Functions

Other Costs (F21)

Use this to view additional cost elements; that is, those that have been designated as non-contributory to unit costs in cost element management.

Select **Previous (F12)** to display the Indented Cost Simulation window.

Cost Changes on Stockroom Items Window

To display this window, select **Cost Changes (F17)** on the Indented Cost Simulation window.

Use this window to simulate the effect of both material and production cost changes on style unit costs. You can apply percentage cost changes by item type within specified stockrooms. Purchased items include all materials with item type P and T.

Therefore, you can simulate changes caused by production labour cost increases, or material price amendments. For example, you can apply a cost uplift of 20% to all purchased items in a particular stockroom.

Fields

Stockroom (St)

This field displays the primary stockroom of materials used on this route. You can issue costs to simulate a potential cost increase or possible decrease.

Purchased % Chg

Enter a positive percentage. Use this field to apply a percentage change to the cost of purchased items from the stockroom displayed in the Stockroom field. Apply a percentage in relation to the base of 100 to reflect an increase or decrease in costs for each displayed stockroom. For example, to decrease costs by 10% enter 90; to increase costs by 10% enter 110.

Items Type

This field determines which costs to use for particular item types and specific stockrooms.

Enter one of the following:

1 - To use the standard cost set

This extracts costs from standard costs for items from this stockroom.

2 - To use the entered cost set

This extracts costs from the cost set entered on the Indented Cost Simulation Style Selection window.

Select **Update (F8)** to process the cost changes.

Save Simulated Costs Pop-up

To display this pop-up, select **Save Costs (F23)** on the Indented Cost Simulation window.

Use this pop-up to save, under a new cost set, the costs you have simulated. You can use these costs to overwrite the costs in an existing cost set.

Fields

Cost Set (Untitled)

To save the costs obtained from the simulation under a new cost, enter a new cost set name and description.

Select **Update (F8)** to save the new costs.

Product Costing Report [12/P1C]

This report lists all factors contributing to the cost of a style. The cost method is a single level retrieval of materials on the route specified for the selected styles.

Material costs are the latest standard and current unit costs.

Note: Run this report before re-costing styles, to identify any material costs that may be missing.

Product Costing Report Selection Window

To display this window, select the Product Costing Report task.

Use this window to enter the details you want to include on the report.

Fields

From Item

If you want to report on a single item, enter the item in the From and To fields. If you want to report on a range of styles, enter the first item.

You can use the prompt facility on this field to select from the Item Master Scan pop-up.

To Item

If you are entering a range of styles, enter the last item here.

You can use the prompt facility on this field to select from the Item Master Scan pop-up.

Note: You can leave both Item fields blank to include all styles.

Route

Enter the route to cost.

Alternatively, use the prompt facility to select from the Routes & Items pop-up.

Note: By specifying the designated costing route, you can simulate the Style Master File Re-cost task, which always uses the costing route for re-cost calculations.

All Routes

Use this checkbox as follows:

Unchecked - To list costs for the route entered in the Route field only

Checked - To list costs for every route for every style

Costing Method

Use this to select the required production costing method.

Select one of the following:

Standard (1) - To use standard cost centre rates

Entered Cost Set (2) - To use the cost set that you enter in the Cost Set field

Cost Set

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

Material Costs

Use this to decide how to re-calculate non-standard costs for styles.

Select one of the following:

Standard (1) - To use the Standard Cost field for materials

Entered Cost Set (2) - To use the cost set that you enter in the Cost Set (Materials) field

Cost Set (Material)

If you selected **Entered Cost Set** in the Material Costs field, enter a cost set for material costs.

Quantity

Enter the batch quantity to use to calculate costs. To use the EOQ defined for the selected style route as the costing batch size, leave this field blank.

Note: To simulate the re-cost function, specify the standard lot size defined on the designated costing route for a style. Other batch sizes will result in different unit cost calculations if fixed costs contribute to a style cost, because they are amortised over the specified batch size.

Include Wastage

You can generate costs that take account of operational and material wastage.

Use this checkbox as follows:

Unchecked - To hold wastage costs separately from style unit costs

Checked - To include wastage costs within style unit costs

Effective As At

You can optionally enter or select a date so that only materials effective on this date are included on the report.

The default is the current date.

Functions

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up.

Press Enter to validate the entries and then press Enter again to submit the report.

Report of Indented Cost Rollup [13/P1C]

This task produces an indented cost report for selected styles. The task processes all levels of the requested routes to provide a simulation of the cost of production without reference to recorded style unit costs, except for bottom level material costs.

Indented Bill of Materials Report Selection Window

To display this window, select the Report of Indented Cost Rollup task.

Use this window to enter the details required on the report.

Fields

From Style

If you want to report on a single style, enter the style in the From and To fields. If you want to report on a range of styles, enter the first style.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

To Style

If you are entering a range of styles, enter the last style here.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Note: You can leave both fields blank to include all styles.

Route

Enter a route.

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

To select all routes, type **ALL** in the second field.

Material Route

Use this to select the route you wish to use to calculate low-level material costs.

Select one of the following:

Planning (1) - To use the route nominated as the planning route via the Styles task

Costing (2) - To use the route nominated as the costing route via the Styles task

Entered Route (3) - To use the route that you have entered in the Route field

Batch Quantity

Enter the size of the batch to cost for the selected style. The batch quantity determines all lower level material usage.

To show the effect of economies of scale, Style breaks down fixed costs over this batch quantity and calculates a batch cost for the style.

To use the EOQ defined for the selected style route, leave this field blank.

Costing Method

Use this to select the costing method you wish to use to calculate production costs.

Select one of the following:

Standard (1) - To use standard costs

Entered cost set (2) - To use the cost set you entered in the Cost Set field

No costing (3) - To exclude costs

Cost Set

If you selected **Entered cost set** in the Costing Method field, enter the cost set on which to report.

Inc. Wastage

You can generate costs that take account of operational and material wastage.

Use this checkbox as follows:

Unchecked - To ignore wastage

Checked - To include wastage

Material Costs

These are the only recorded costs used to calculate style costs.

Select one of the following:

Production (1) - To use unit material costs from production

Inventory (2) - To use Inventory stockroom values

In this case, the cost held on the primary stockroom record for each material input is used.

Operation Details

You can decide whether to include summary totals of operation costs in the report.

Use this checkbox as follows:

Unchecked - Not to include summary operation costs

Checked - To include summary operation costs

As At

You can optionally enter or select a date, so that only materials effective on that date are included in the report.

The default is the current date.

Ignore Effectivity

Use this checkbox as follows:

Unchecked - To exclude ineffective materials

Checked - To report on all materials regardless of their effectivity

This is only available if you are producing an indented report without costs.

Functions

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up.

Press Enter to validate the entries and then press Enter again to submit the report.

Enquire on Single Level Cost [14/P1C]

This enquiry provides an online version of the Single Style Re-cost task. The task uses the same style selection parameters but does allow you to update costs.

Use this task to review costs for a single style, with no indents, before updating them.

Prerequisites

Make sure you have recorded costs against all the materials on the selected style. Otherwise, the style cost calculation will be incomplete.

You should also have set up user-defined costs for production, if they are required. To do this, either transfer the costs from Style Inventory Management via the Purchased Item Re-cost task, or enter the costs manually using the Maintain Item Costs task.

Single Level Cost Enquiry Selection Window

To display this window, select the Enquire on Single Level Cost task.

Use this window to select a style, route and costing method for costing.

Fields

Item

Enter the style for which to re-calculate costs.

Alternatively, use the prompt facility to select from the Select Item pop-up and the Routes & Items pop-up.

Route

Enter the route to use for calculating costs.

You can use the prompt facility on this field to select from the Select Route pop-up, or the Routes & Items pop-up if you have left the Style fields blank.

As At

You can optionally enter or select a date so that only materials effective on this date are included.

The default is the current date.

Costing Method

Use this field to select the costing method to use.

Select one of the following:

Production Standard (1) - To use the production standard

This re-costs standard costs only.

Entered Cost Set (2) - To use the entered cost set

This re-costs the cost set that you enter in the Cost Set field.

Cost Set

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

Include Wastage

Style always calculates and records costs caused by planned operational and material wastage. However, you can control whether these wastage costs are to contribute to style unit costs.

Use this checkbox as follows:

Unchecked - To hold wastage costs separately from style unit costs

Checked - To consolidate wastage costs within style unit costs

Material Costs

If you selected **Entered Cost Set** in the Costing Method field, select one of the following:

Standard (1) - To use the Standard Cost field for materials to re-calculate non-standard costs for styles

Entered Cost Set (2) - To use the cost set that you enter in the Cost Set (Materials) field to re-calculate non-standard costs for styles

In this way, you can generate many different cost sets for the parent style using different routes, without having to set up multiple cost sets for the same route/style.

Note: Style uses current cost centre cost rates and recovery methods to calculate production costs for non-standard cost sets.

Cost Set (Materials)

If you selected **Entered Cost Set** in the Material Costs field, enter a cost set from which to find material costs.

Functions

Item Search (F16)

Use this to use the standard Inventory Item Search.

Cost Presentation (F18)

Use this to display the Cost Presentation pop-up.

Press Enter to display the Single Level Cost Enquiry Details window.

Single Level Cost Enquiry Details Window

To display this window, press Enter on the Single Level Cost Enquiry Selection window.

This window lists all materials for the selected style and route, their quantities and unit costs, and the calculated unit cost of the selected parent style. The **T** (Type) field indicates the setting of each material's Item Type flag: **B** (Bought Out), **P** (Purchased), **M** (Production) or **T** (Consumable Tool).

Fields

Options

Select **Cost Detail** against a selected material to display the Cost Elements pop-up, showing style cost elements for the materials. Zero costs are not displayed. The cost element presentation is either as defined by default on the company profile, or as amended for the purposes of this enquiry by selecting **Cost Presentation (F18)** on the Single Level Cost Enquiry Selection window.

Functions

Rolled Up Costs (F17)

Use this to display the Cost Elements pop-up.

This Level Costs (F21)

Use this to display the Cost Elements pop-up.

Select an option or function to display the Cost Elements pop-up.

Cost Elements Pop-up

To display this window, select **Rolled Up Costs (F17)** or **This Level Costs (F21)** or select Cost Detail against a line on the Single Level Cost Enquiry Details window.

This window displays slightly different information depending on which option or function you selected on the Single Level Cost Enquiry Details window.

If you selected **Rolled Up Costs (F17)**, this window displays all the costs you have defined for this route, including material costs.

If you selected **This Level Costs (F21)**, this window displays all the costs defined for this item on this route, except materials, that is, the cost of the route minus materials.

Fields

Item

This field displays the item you have specified.

Cost Element/Cost

The cost description and value are listed.

Select **Previous (F12)** to return to the Single Level Cost Enquiry Details window.

Cost Sheet [15/P1C]

Use this task to produce a report listing detailed operation and material costs for average costed styles.

You can print a cost sheet for either styles or variants. Style uses the costing details you provide to calculate average costs.

Cost Sheet Selection Window

To display this window, select the Cost Sheet task.

Use this window to enter the details you want to include on the report.

Fields

From Style

You can enter an item in the From and To fields to report on a specific style. To report on a range of styles, enter the first in the range.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

To Style

Enter the last item in the range.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Note: If you want to include all styles, leave both Style fields blank.

Route

Enter a route.

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

To select all routes, type **ALL** in the second field.

Batch Quantity

Enter the size of the batch that you wish to cost for each selected style. The batch quantity determines all lower level material usage.

To use the EOQ defined for each of your selected style/routes, leave this field blank.

Manufactured Items

Use this to select the production costing method to use.

Select one of the following:

Standard (1) - To use standard cost centre rates

Manuf. Item Cost Set (2) - To use the cost set that you enter in the Manuf. Cost Set field

Manuf. Cost Set

If you selected **Manuf. Item Cost Set** in the Manufactured Items field, enter the cost set to use in this field.

Purchased Items

Use this to select the costing method to use.

Select one of the following:

Standard (1) - To use standard cost centre rates

Purchased Item Cost Set (2) - To use the cost set that you enter in the Purch. Cost Set field

Purch. Cost Set

If you selected **Purchased Item Cost Set** in the Purchased Items field, enter the cost set to use in this field.

Inc. Wastage

Style always calculates and records costs caused by planned operational and material wastage. However, you can control whether these wastage costs are to contribute to style unit costs.

Use this checkbox as follows:

Unchecked - To hold wastage costs separately from style unit costs

Checked - To consolidate wastage costs within style unit costs

Material Costs

These are the only recorded costs used to calculate style costs.

Select one of the following:

Production (1) - To use the production standard or entered cost set

Inventory (2) - To use the Inventory stockroom value

This uses the cost held on the primary stockroom record for each material input.

Press Enter and then select **Submit (F8)** to submit the cost sheet report.

Maintain Item Costs [21/P1C]

Use this task to enter or maintain costs. You can:

- Review and modify all the cost elements for a particular style
- Enter values against user defined cost elements
- Manually enter material costs
- Break down costs to the level of a particular variant

Note: You calculate base costs for styles by running the re-cost functions, and transferring material costs from inventory where applicable.

If a cost description is blank, it denotes standard costs. A style has a standard cost defined for its costing route. It can also have standard costs for other routes.

The costs displayed for an existing cost set may have been either entered directly or generated via a style re-cost task.

Item Cost Selection Window

To display this window, select the Maintain Item Costs task.

Use this window to select a style or variant or material. You can also select a route or cost set, or both.

Fields

Item

Enter the style or material.

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

If you leave the Route and Cost Set fields on this window blank, Style uses the standard costs for the item.

If there is more than one standard cost, you need to be specific about which costs you wish to maintain.

Note: To break down costs down to variant level, enter the full product code.

Route

Enter the route.

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

Cost Set

Enter the cost set to maintain.

Alternatively, use the prompt facility to select from the Cost Set Selection pop-up.

The same combination of styles and routes can hold multiple cost sets. If you leave this field blank, the software displays standard costs for the style and route.

Press Enter to display the Item Cost Maintenance Details window.

Item Cost Maintenance Details Window

To display this window, press Enter on the Item Cost Selection window.

This window displays all the cost elements for the chosen style. You can use this window to modify these cost elements, ignoring the bill of materials on the route. You can then make comparisons between the two.

Fields

Cost Set

Enter a description for the cost set that you are updating or creating. To use the standard cost, leave this field blank.

Selected Costs

The cost element values provide a breakdown of the total style costs.

The Total Cost field displays the sum of all the cost elements selected for inclusion in costing. You maintain these elements using the company profile. Inclusion or exclusion of wastage depends on how you set the Hold Costs with Wastage flag in the company profile.

You must enter user-defined costs, other than landed costs, manually. You can copy landed costs from Inventory, although the roll-up process includes them, if requested, during cost calculations.

Functions

Calculate Totals (F7)

Use this to calculate a total cost for the selected style, variant or material, after you have manually created or updated the element costs.

Comparison (F15)

Use this to compare costs with another cost set or style, and display them with the maintained cost set, side by side. For example, you can compare different colours and sizes of the same style.

This displays the Select Comparison Cost Set pop-up.

Enter Costs (F20)

Use this to maintain an existing cost, or enter costs against non-calculated or copied costs, such as user-defined elements.

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

Select Comparison Cost Set Pop-up

To display this window, select **Comparison (F15)** on the Item Cost Maintenance Details window.

Use this pop-up to specify selection criteria so that you can compare cost elements between the current style/material/variant and a second style/material/variant.

Alternatively, you can compare the cost of production of the same style or variant, but using a different route.

Subsequently, use the Item Cost Comparison window to display the two sets of cost elements.

Fields

Item

Enter a style, variant or a material.

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

Note: To break down costs down to variant level, enter the full product code.

Route

Enter the route of a style/variant for comparison.

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

Cost Set

Enter a cost set for comparison.

Alternatively, use the prompt facility to select from the Cost Set Selection pop-up.

Leave this field blank for standard costs.

Press Enter to display the Item Cost Comparison window.

Item Cost Comparison Window

To display this window, press Enter on the Select Comparison Cost Set pop-up.

This window is similar to the Item Cost Details window. In addition, this window displays a field itemising cost elements for the style/variant/material, route and cost set which you have selected from the Select Comparison Cost Set pop-up.

You can compare cost elements between two styles or variants or materials.

Functions

For more details on the functions available on this window, please refer to the Item Cost Details Window section.

Copy Comparison Costs (F18)

Use this to copy comparison costs to maintained costs. For more details, refer to the Indented Cost Simulation Window section.

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

Maintain Variant Weighting [22/P1C]

Use this task to obtain a ratio for calculating average costs across the variants of a style. You have two options:

- To copy sales forecasts over a selected date range
- The forecasts are summarised by variant to produce forecast weighting quantities. You can modify these forecast quantities.
- To enter variant weightings directly, as forecast quantities, without using forecasts

You can create weightings for a single style or for a range of styles.

Variant Weighting Selection Window

To display this window, select the Maintain Variant Weighting task.

Use this window to select the style, or range of styles, for which you want to add or maintain variant cost weightings.

You can also specify whether to copy sales forecasts.

Fields

Copy Forecasts

Use this checkbox as follows:

Unchecked - To display the Variants pop-up, which you use to add or edit weighting quantities directly, without using forecasts

Checked - To display the Forecast Selection pop-up, which you can use to enter a range of forecast periods

Single Style Review

Style

Enter a single style, variant or material. Alternatively, enter a range of styles/variants/materials in the Style Range fields.

You can use the prompt facility on this field to select from the Routes & Items pop-up.

Route

Enter a route for the style. Alternatively, enter a range of routes in the Route/To field.

You can use the prompt facility on this field to select from the Select Route pop-up, or the Routes & Items pop-up if you have left the Style field blank.

Multiple Style Review or Batch Update

Style Range/To

Enter a range of styles. If you enter a range of styles, rather than a single style, a batch job copies forecast quantities. If you do not want to do this, **check** the Review field.

Route To

Enter a range of routes.

Review

Use this checkbox as follows:

Unchecked - To submit a batch job to extract forecasts and update variant weightings

You must also **check** the Copy Forecasts field. This displays the Variants pop-up.

Checked - To enter a range of forecast periods

This displays the Forecast Selection pop-up.

Functions

Item Search (F16)

Use this to use the standard Inventory Item Search.

Press Enter to display the Variants pop-up.

Variants Pop-up

To display this pop-up leave the Copy Forecasts field unchecked on the Variant Weighting Maintenance window, or press Enter on the Forecast Selection pop-up.

Use this pop-up to enter or amend forecast quantities for the style variants. Style totals the extended cost and divides it by the total forecast quantity to obtain the average cost.

As an example:

	Forecast Qty	Cost	Extended Cost
Variant 1	4500	9.103	40963.5
Variant 2	3200	9.203	29449.6
Variant 3	1200	9.153	10983.6
Variant 4	2500	9.253	23132.5
Total	**11400**		**104529.2**

Style average cost = 104529.2 / 11400 = 9.169

Note: Depending upon the settings of the Average Costing Colour and Average Costing Size fields, this pop-up may not display all variants for the style. To look at these two fields, refer to the Style Route Header Maintenance Window section under the Style Route/Bill of Materials task.

Fields

Untitled

Enter a variant weighting under variants.

Press Enter to update the variant weightings.

Forecast Selection Pop-up

To display this pop-up, checked the Copy Forecasts field on the <u>Variant</u> Weighting Maintenance window.

Use this pop-up to enter a range of forecast periods.

Fields

Model

Enter the <u>organisational model</u>.

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

From/To Year/Period

Enter the year and period range of forecasts that you want to use.

Press Enter to copy the forecasts.

Chapter 6   Utilities

<div style="color:red; font-size:3em; text-align:right">6</div>

Maintain Company Profile [1/P1U]

Use this task to set up and maintain how Style Production works for your company. This is where you make many key decisions about how you operate Style Production.

Style Production works within a multi-company environment. For each production company, you need to create a company profile to:

- Set the basic system defaults and operation policies relevant to the company
- Define the costing elements
- Define base calculation parameters used within Style Production

In addition, to specify how you want to carry out production at each plant, you can create organisational models.

Within the Style Production company profile, there are 14 cost elements you can use to use build up and analyse item unit costs. Ten elements are standard within Style and four elements are user-defined.

Note: Before you can define the Style Production company profile, the production company must exist within Style Inventory Management.

Maintain Company Profile Cost Elements Window

To display this window, select the Maintain Company Profile task.

Use this window to maintain cost elements. You can modify the Order, Add To and Description fields. If you change the presentation format of a report or enquiry, it does not affect the default you set here.

Fields

Order

Enter the default cost element presentation sequence to be used by enquiries and reports. If you leave this blank, the element does not appear on enquiries and reports, although it will still be calculated by the re-costing routines.

Add To

Use this field to control the presentation of cost elements.

You can accumulate costs in reports and enquiries by entering the number of the element that you want to include this cost in here. For example, to accumulate Overhead 1 into Overhead 2 Variable, enter 11 against Overhead 1.

You must display the accumulated cost. To do this, complete the Order field for the accumulated element. You cannot display an element you want to accumulate into another element.

However, the re-costing routines re-calculate all elements, so you can report on the individual elements at any time by changing the settings of this field and the Order field.

Roll To

This field is only applicable to user-defined costs, and defines which standard cost element to roll a cost into other than itself. You use this to preserve costs for user-defined elements entered at a particular level on the route/BOM.

Note: If you do not specify a Roll To element for a user-defined cost, the window displays the warning message: "User cost rolled into self". You can only enter cost at the lowest level each time you access the company profile; select Reset to continue.

If you leave this field blank, the software rolls up user-defined costs and accumulates them at each level, thereby losing this level cost definition, except at the lowest level. You can use the special value **99** to indicate a non-roll-up cost.

Fixed

This field is only applicable to user-defined costs. You can flag each user-defined element as a fixed or variable cost here. Use this facility to distinguish between overheads not directly related to production, for example, Research and Development and activity costs that are directly attributable to the production process.

Enter one of the following:

0 or blank - To extend the cost by the material requirement quantity and wastage on a process route

1 - If quantities or wastage on a process route do not modify the cost.

Description

If you want to report this element, you must enter a cost element description. If you leave this field blank, the software cannot report on the cost element, although it will still be part of the calculation. Your description is displayed against the cost and printed on reports where applicable, rather than the standard element description. You can update any standard or user-defined element with a description within the Item Costs maintenance task. However, the software accumulates any visible cost elements with an Order or Add To entry to arrive at a unit cost.

Note: If you enter a description against the Wastage cost element, you can view it but not maintain it within the Maintain Item Costs task.

Press Enter to display the Maintain Company Profile Database Options window.

Maintain Company Profile Database Options Window

To display this window, press Enter on the Maintain Company Profile Cost Elements window.

Use this window to maintain database options.

Fields

Time Units

Use this field to specify whether routing standards should be defined in minutes or hours, that is, whether:

- You should set up labour time in hours or minutes.
- You should express machine and labour production rates in hours per lot or minutes per lot, that is, where the definition of lot is qualified by a time basis code.
- You convert the costing for an environment scheduled in minutes to hourly costs.

Note: This flag setting has no impact on cost centre or labour rates, or production order or operator booking, which always use hours.

Select one of the following:

Hours (1) - To define the standards in hours

Minutes (2) - To define the standards in minutes

Quantity Per Basis

You can define process routes based on a unit end product or a user-defined standard lot size. This only applies to styles and not materials.

Select one of the following:

Per 1 (1) - To base on a one-for-one relationship

When defining a route or BOM, the standard lot size field will default to 1.000.

Per Standard Lot Size (2) - If you must enter the standard lot size when defining a route/BOM

Duration Calculation Basis (Default)

This field identifies the company's default duration basis code, which is used to calculate operation lead time.

The software bases this calculation on combinations of the set-up labour, run labour and run machine times, which are defined at each operation. The longest time element, or critical path activity, on the operation is used to determine the lead time.

Duration basis codes may be set at the following levels:

- Operation - You can allocate a code to each allocation. If a code is not entered, the machine default is used. If the machine default does not exist, the Company Profile default is used.
- Machine (default) - You can enter a default code against each machine definition. This overrides the company profile default and the software prompts for them on operations using the machine.
- Company Profile (default) - This will be the default code used.

Select one of the following:

No elapsed time (Setting only) (0) - Set-up labour

Mach + Setting Time (1) - Set-up labour + run machine

Run Labour + Setting Time (2) - Set-up labour + run labour

Mach + Run Labour + Setting Time (3) - Set-up labour + run labour + run machine

Greater of Mach or Labour + Setting (4) - Set-up labour + (greater of run labour or run machine)

You define codes in the Parameter file, under type DUCT.

Allow Duplicate Items on Operation

This field indicates whether you can specify the same material more than once at an operation on a route or BOM. For example, the material may be required at different stages in the operation process, in relevant quantities, if the operation lead time is long.

Use this checkbox as follows:

Unchecked - If a material must be unique on an operation

Checked - If you can use the same material many times on an operation

Hold Operation Costs

To cost production order bookings correctly at an operation, you must hold style costs at operation level as well.

Use this field to indicate whether you wish to generate costs at operation level.

Use this checkbox as follows:

Unchecked - Not to generate operation costs

Checked - To create operation cost details

Hold Costs with Wastage

You can specify whether you want material and operation wastage costs to be included in element costs.

Note: The wastage cost element is always calculated irrespective of this flag setting, and held as a separate value for consolidation if required.

This flexibility allows you to hold standard costs without wastage for inventory valuation purposes, and report costs including wastage to determine the effect of process efficiency, or supplier quality, on product costs.

Use this checkbox as follows:

Unchecked - To exclude wastage cost

In this case, any unit transaction will exclude the cost of wastage.

Checked - To include wastage costs

Reports Include Wastage

You can produce cost enquiries and reports with or without the proportion of cost attributable to material and operation wastage, for each element being included. The software uses this setting as the default when it displays either an enquiry or a report selection window with an override option.

Note: For reports that print (or optionally print) costs, but do not prompt for inclusion of wastage, the default set here is automatically applied.

Use this checkbox as follows:

Unchecked - To exclude wastage

Checked - To include wastage

Fixed Costs Amortisation Basis

Use this to specify the method used to spread fixed production costs. Fixed costs may be amortised over the standard lot size or the EOQ (economic order quantity) defined on a style's costing route. You can use the latter option when you define production routes for a unit parent, and the fixed costs spread over an economic order quantity.

Select one of the following:

Lot size (0) - To base on standard lot size

EOQ (1) - To base on EOQ

Derivation of Standards

This field relates to:

- Generating standard or expected costs and material usage
- Comparing standard costs and material usage with actual costs and material usage

Select one of the following:

Routes (0 or blank) - To use the costing route for deriving standard costs

Production Orders (1) - To use the production order to derive standard costs

Note: If you set this to Production Orders, you must avoid making large changes to the route once you have created a production order. For example, if you add a new operation or re-sequence operations, the operations on the route may no longer match the operations on the order.

Production Control Method

This is a system-maintained field. It displays **Orders** for production orders.

Press Enter to display the Maintain Company Profile Planning Options window.

Maintain Company Profile Planning Options Window

To display this window, press Enter on the Maintain Company Profile Database Options window.

Use this window to maintain planning options.

Fields

Model

This field defines the live MPS, MRP and organisational model. You must create an MPS and MRP model of the same code before you define the organisational model, with the same code. The model you enter here is the one whose suggested orders the software uses when confirming purchase requisitions and production orders.

Note: You can create other MPS and MRP models, but you cannot use them to confirm suggestions.

MPS/MRP Consume Forecast

The consumption of forecast is the process of comparing forecasts with sales orders to determine which to use to provide Production and Material Planning demand.

Use this checkbox as follows:

Unchecked - For discrete comparison

This method compares the forecast for the period with the total demand in the same period. The greater of these is used.

Checked - For cumulative consumption

This method compares the cumulative forecast at the end of each period and the cumulative demand to the same date. The greater of these is used.

Production Order Level

Production Order Level is used when it is not desirable to have an order with more than one variant. Certain other constraints may also make it undesirable or impossible to have more than one colour on an order. Some products may have a mix, where some items may be planned at the style level, while others may be planned at the colour or SKU.

Select one of the following:

Style (0) - To use style code

Style/Colour (1) - To use style/colour code

Full Product (2) - To use full product code

Note: For this field, system parameter WORL must be maintained via the Maintain Parameter File task.

Press Enter to display the Maintain Company Profile Production Orders Options window.

Maintain Company Profile Production Order Options Window

To display this window, press Enter on the Maintain Company Profile Planning Options window.

Use this window to maintain production order options.

Fields

Order Number to be System Generated

You can either assign [production order](#) numbers manually or specify that the software should automatically generate them.

The format generated by the software is W999999, where 999999 is the next unused number. The software assigns numbers sequentially.

Each [production order](#) must have a unique number.

Use this checkbox as follows:

Unchecked - To enter numbers manually

Checked - To use system-generated numbers

You can override the generated number if you need to.

Last Order Number Used

This field displays the last number allocated to an order and is automatically maintained by the software.

Allocation of Materials At

You can allocate materials automatically from the issuing [stockroom](#), either at order confirmation or [order release](#).

Select one of the following:

Confirm (1) - To allocate at order confirmation

Release (2) - To allocate at [order release](#)

Warehouse Issue Requirements at Release

Note: This field is only relevant if you use [Style](#) Warehousing.

Requirements for [warehouse](#)-controlled materials can be passed in total to [Style](#) Warehousing at [order release](#), or requested manually in stages. You can override this flag for a specific order at the point of release.

Select one of the following:

Manually (0) - To request [warehouse](#) requirements manually

Release (1) - To generate [warehouse](#) requirements automatically at [order release](#)

Materials to be Issued at Order Release

You can automatically issue all materials at [order release](#). The exceptions to this rule are [warehouse](#)-controlled and [backflushed](#) materials. The software issues quantities as defined on the production [route](#). You can override this for a specific order at the point of release. The software displays a warning message if issuing will cause, or increase, a negative stock [balance](#). Lot-controlled materials are issued on a [FIFO](#) basis.

Enter one of the following:

No (0 or blank) - For no automatic issue of materials

All ops. (1) - To issue materials to all operations on the order

First op. only (2) - To issue material to the first operation only

Order Priority Default Value

Use this to specify the default priority for production orders. When you release a production order, you can override the priority default.

You use this priority in two ways:

- On enquiries, to display orders in sequence according to priority
- Orders are assigned to workstations in order of priority
- Enter or select a number between 0 and 9, where 0 is high priority and 9 is low.

Note: The default can be overridden at order release.

FIFO Receipt Costing Method

Finished goods receipts generate stock movement valuations, and stockroom revaluation, based on the costing method used in the receiving stockroom.

- Standard
- Average
- Latest
- FIFO

For Standard Costed stockrooms, the movement value is based on the recorded standard cost in the stockroom. The standard unit cost is not updated.

For Average and Latest Cost stockrooms, the inventory movement is based on the actual or estimated cost of production of the received batch. The software bases the updated average or latest cost of the style upon the batch cost.

For FIFO costed stockrooms, the processing depends upon the parameter value selected here.

Select one of the following:

Actual (1) - To calculate actual costs when receiving stock from production orders

Standard (2) - To value the receipt by multiplying the production standard unit cost for the style by the receipt quantity, and create a FIFO cost record for the standard value of the receipt

Print Documentation at Confirmation/Release

Enter the system default for printing documentation automatically upon order confirmation and release. The documentation comprises:

- Production orders, which may include text
- Pick lists, which detail materials for one or more operations

Select one of the following:

No (0 or blank) - Not to print documentation at order release

Confirmation (1) - To print documentation automatically when you confirm the order

Release (2) - To print documentation automatically when you release the order

Both (3) - To print documentation automatically when you confirm the order, and when you release the order

At the point of release of an order, you can re-set this flag.

Issuing/Printing Interactive or Batch

Select one of the following:

Interactive (1) - After requesting documentation printing or material issuing, the software processes the job on line. You cannot select any other functions until the job ends.

Batch (2) - After requesting documentation printing or material issuing, the software submits a batch job. You can then continue working immediately.

Order Archive

Print Variance Report for Purged Orders

You can generate a variance report for every archived production order. The report shows variances between planned and actual bookings.

Use this checkbox as follows:

Unchecked - Not to produce a variance report

Checked - To produce a variance report automatically following a production order archive

Archive Operations Booking History

You can either delete operation booking history when production orders are archived, or retain them in an archive file.

Use this checkbox as follows:

Unchecked - Not to update the Archive file

All operations booking history information will be purged from the system.

Checked - To update the Archive file with operations booking history and delete live operations history records

Archive Stores History

You can create an archive version of production order stockroom history when archiving production orders.

Use this checkbox as follows:

Unchecked - Not to archive stockroom history

All production order stockroom transaction history will be deleted.

Checked - To archive order stockroom history

Press Enter to display the Maintain Company Profile Further Production Order Options window.

Maintain Company Profile Further Production Order Options Window

To display this window, press Enter on the Maintain Company Profile Production Order Options window.

Use this window to maintain production order print options.

Fields

Print Operations on Production Order

Use this field to enter the default for printing operation details on production orders. You can print additional text, depending on the setting of the Print Operation Text on Production Order flag.

Select one of the following:

All (1) - To print details for all operations

Key Only (2) - To print details for key operations only

Print Operation Text on Production Order

Use this field to specify whether extended operation descriptions, which you may enter using the text options, should be included with the standard details when production orders are printed.

Use this checkbox as follows:

Unchecked - Not to print operation text

Checked - To print operation text

Print Pick Lists

Use this field to specify whether pick lists, or material requisitions, should be printed.

Use this checkbox as follows:

Unchecked - Not to print pick lists with documentation

Checked - To print pick lists when producing order documentation

Suppress Backflush Items on Pick List & Production Order

Backflushed, or bulk issue, materials may be included or excluded from printing on pick lists and production orders.

Use this checkbox as follows:

Unchecked - To print backflushed materials

Checked - To exclude backflushed materials

Suppress Warehouse Items on Pick List & Production Order

This field is only relevant if you are using Style Warehousing.

You can exclude warehouse-controlled materials from pick lists and production orders.

Note: [Pick lists](#) produced by [Style](#) Warehousing relating to [production orders](#) are not affected by this option, which refers only to [Style](#) Production [pick lists](#), or material requisitions.

Use this checkbox as follows:

Unchecked - To print [warehouse](#)-controlled materials

Checked - To exclude [warehouse](#)-controlled materials

Allow Bundle Tracking

This field indicates whether [WIP](#), or Work-In-Process, requires [bundle tracking](#).

Use this checkbox as follows:

Unchecked - If [bundle tracking](#) is not required

Checked - If [bundle tracking](#) is allowed

Last Bundle Number Used

This displays the last allocated bundle number, which is automatically maintained by the software.

Bundle Creation Method

Select one of the following bundle creation methods:

Manual (1) - To specify the required bundle size for each [production order](#)

Automatic (2) - To create bundles automatically of a pre-determined size for each [production order](#)

Automatic Bundle Creation at Order Release

If you set the Bundle Creation Method field to **Automatic**, you can automatically create [bundle tickets](#) when releasing a [production order](#).

Select one of the following:

1st Stage (1) - To produce [bundle tickets](#) for the first stage only

All Stages (2) - To produce all the required [bundle tickets](#)

Note: You can override this default when you release a [production order](#).

Press Enter to display the Maintain Company Profile Text Types window.

Maintain Company Profile Text Types Window

To display this window, press Enter on the Maintain [Company Profile](#) Further [Production Order](#) Options window.

Use this window to maintain text types.

The software holds all text on the same file and a mechanism is needed to differentiate between the different types. This mechanism is the Text Type.

You can hold free format text against the following:

- Styles and Materials
- Routes/Bills of Material
- Operations
- Machines
- Cost Centres
- Work Centres
- Production Orders

Caution: You should not need to change the Text Types.

Note: If you change a Text Type, you cannot use text entered under the previous Text Type.

Fields

Major Text Type

Use this type code to locate text associated with the function.

Additional major type classifications can be defined in Text Management, but this text type is used when the functions are being used.

Text Sub-Type

This field displays the default major type sub-division that Style Production will search for when extracting and maintaining text.

You can define additional sub-types within the major type in Maintain Text, but you must define the current sub-type classification here to inform the software which sub-type to extract for processing.

Press Enter to display the Maintain Company Profile Calendar Parameters window.

Maintain Company Profile Calendar Parameters Window

To display this window, press Enter on the Maintain Company Profile Text Types window.

Use this window to maintain calendar details.

With Style Production you can specify multiple production calendars, especially if you have different departments working different hours. Each calendar is identified by a calendar code.

You can define the default calendar code, and the default working week template to be used in calendar creation. You can also define and describe your operating periods in terms meaningful to you.

Note: The total of the days entered will be used when creating new calendars and forecasts. If a 53-week calendar is required, the days must total 371. If a 52-week calendar is required, the days must total 364.

Fields

Calendar Code

Enter the default calendar code to be used by the software for date validation and <u>scheduling</u>.

Note: Before you can define your default calendar here, you must have created your default calendar using the Calendars maintenance task.

Number of Periods per Year

Enter the number of operating periods in your company year. You can specify up to 13 periods.

Period Name

You can enter descriptive names for each period to match your internal reporting procedures.

Days

Enter the number of days in each period. Because forecast routines allow period, weekly and daily forecasts, the number of days in each period must be divisible by 7, and the maximum number of days per period equal to 98. The total number of days entered must not exceed 371 (53 weeks).

Standard Week Template

Define the standard week template in terms of working and non-working days. This field displays the default template. However, you can define additional templates to reflect different working patterns during a year.

Enter one of the following:

Blank - For a working day

1 - For a non-working day

Press Enter to perform the updates.

Maintain Parameter File [2/P1U]

Use this task to maintain user parameters and system parameters.

User Parameters

You can create user parameters and descriptions as and when required. Use these parameters to control user-maintained information. Examples of user parameters are:

- Planner codes (PLAN)
- Production stages

Note: <u>Style</u> validates <u>planner</u> codes and production stages whenever you enter them in any <u>Style</u> Production application. Therefore, you must define these user parameters before you use them.

System Parameters

Style uses system parameters to validate data entries in certain functions. You can maintain descriptions for these parameters in order to make them more meaningful within your working environment. For certain parameters, you can also define control parameters.

Examples of system parameters are:

- Item type (PITP)
- Planning filters (WTYP)
- Material control policy (IDXS)

User Parameter List

ALLW - Allowance Formula

This parameter allows you to define formula codes that call user-defined programs when you select **Time Calcs (F16)** on, for example, the Standard Operations Maintenance Details window. Each program contains a calculation that you can use to re-calculate labour time, machine time and set-up labour time.

ATS1- Operation Type

This parameter identifies an operation in the following ways:

8 - An operation that can be completed short or over

9 - An operation that is a bundle up stage, where bundles will be created

BUCS - Business Unit Code

You can use these codes within multi-plant planning to define additional parameters for MPS models.

CBCD - Capacity Basis Code

If you use multi-plant planning, you must define at least one capacity basis code. You link capacity basis codes to the definition of critical resources.

CSHF - Shift Profile Code

Shift profile codes identify working day shift patterns.

Note: You should define these entries using the Shift Profiles maintenance task, not here. The software updates the Parameter file following any file maintenance.

If you create codes here, you must further define them within the Shift Profiles maintenance task before you can use them. That is, you have to enter start and end times as well as effectivity dates.

CSOP - Costing Analysis

You can setup costing analysis codes here and use them against operations.

CTOL - Completion Tolerances

Use this to calculate whether the actual total completed quantity for an operation falls outside the tolerances allowed. The parameter has two possible functions:

OVER - For tolerance above completion, Enter a value between 00 and 99.

UNDER - For tolerance below completion, Enter a value between 00 and 99.

Note: Always enter two digits. For example, enter 5% as 05.

The following examples show how the software measures tolerances on a production order of 100:

- If the tolerance is 0% (entered as 00), the quantity falls outside that tolerance if it is not equal to 100.
- If the tolerance is 5% (entered as 05), the quantity falls out outside that tolerance if it is less than 95 or greater than 105.
- If the tolerance is 99% (entered as 99), the quantity falls outside that tolerance if it is equal to 1 or greater than 199.

Note: When deciding whether to adjust quantities, the software always compares against the original planned quantity, rather than the current planned quantity.

DEPT - Department

Departments are used to group and subsequently report and analyse production booking.

Define these entries using the Departments task. The software updates the Parameter file following any maintenance.

PCOD - Capacity Profile Code

You must define these if you intend to enter profiles against critical resources.

Note: Define these entries using the Resource Capacity Profiles task. The software updates the Parameter file following any file maintenance.

PLAN - Planner Code

Use this to identify:

- Buyer - A buyer of material
- Planner - A planner for production of a style

You can associate a planner code with a style or a material. Use planner codes within MPS/MRP to review production load and material requirements by planner or buyer.

PSEQ - Primary Scheduling Sequence

Use this to define sequences for scheduling work in production. You can assign a sequence to an item definition for use within MPS and MRP, as well as Production Control.

STES - Site Code

These are optional codes used when defining additional parameters for MPS models.

VMDR - Valid Model Routings

This parameter defines the style routes that are model routes rather than planning routes.

VPOL - Batch Length Component

This parameter has two possible functions:

- It determines how automatic batch allocation is used. The Enquire on Material Availability task within Production Control uses the Batch Length entry to group together batches of material into summary batches, that is, dye lots, merges and supplier references.

- The Batch Length identifies the common portion (that is, the number of characters) of the batch lot numbers. It will automatically allocate the required batches, with the same common portion, to meet the total quantity requirement for the production order.

- You should fill the Batch Length field with 2 characters (these represent the first two characters of the Code field); for example, 05 denotes 5 characters.

- You can set the Component entry (the last character of the Code field) either to 0 (allocate up to the quantity required), or 1 (allocate the full batch quantity). You can then use the Component entry on the last batch required within the common portion.

- It may be used in conjunction with the user parameter WORF, to determine the content of Reference 1 and Reference 2 fields on production orders.

WORF - Works Order Reference Descriptions

This parameter operates in conjunction with the user parameter VPOL, and provides the text displayed in production order Reference 1 and Reference 2 fields.

System Parameter List

For most of the system parameters you can only change the descriptions.

BKPR - Background Processing Parameter

This includes parameter code PRBM Bulk Move Processor Job that may be set to:

0 - If bulk move updates will be performed interactively

1 - If bulk move updates will be processed by the background processor

CALL - Conditional Calls

For the Route/Bill of Material task, you can set the following pop-ups to appear automatically from the Style Route Header Maintenance window. Subsequently the pop-ups are, in all but one case, available via functions.

ITMSEL - Product Selection pop-up

ITMSEL – Product Selection

This call indicates what style variants the route produces. If the call is set not to display, the software assumes that you are making all the variants.

MTLUSG - Enter Material Usage Factors pop-up

This call indicates, for ratio based material requirements only, how much primary material you need and the ratio for every variant. If the call is set not to display, the software assumes that material requirements for variants do not differ.

PRDDST - Variant Spread pop-up

This call indicates the quantities of each variant produced by the route. If the call is set not to display, the software assumes an even spread over all variants.

QPER - Qty Per Rules pop-up

This call determines which style dimensions (size for example) place different material quantity requirements on style variants. It does not apply to ratio-based materials. The most usual setting for this call is to state that the material requirements vary by size.

CBAR - Code for [Capacity](#) Bar Chart

This parameter determines which alpha characters are shown, in columns displaying [capacity](#) and work [load](#), in [capacity planning](#) reviews in the [MPS](#) and Production Control.

CNOR - Confirm Order Defaults

This controls whether the sales order number or customer order reference is displayed when confirming suggested or planned orders in MPS.

The default value for Parameter Code Value for ORDREF may be set to:

0 - To display the sales order number/line

1 - To display the customer order reference

CNTI - Count Reporting Policy

This controls whether the production order count entry.

0 – Total Quantity

1 – Count in/Count out

COST - Costing Method

This parameter allows you to define the method of calculating [style](#)-level production [costs](#). This parameter is company dependent, and the settings are user-defined.

Details of the four records are as follows:

Full item cost roll-up

Enter **0** to calculate costs without averaging the style cost. Enter **1** to calculate the cost as an average by using the variant weightings.

Inventory standard cost update

Enter **0** to transfer costs to inventory at variant level. Enter **2** to transfer the style costs to all variants for the style.

Single item re-cost

Enter **0** to calculate the costs without averaging the style cost. Enter **1** to calculate the costs as an average by using the variant weightings.

Build costed BOM file for the Item Cost report

Enter **0** to calculate costs without averaging the style cost. Enter **1** to calculate the costs as an average using the variant weightings.

DTYP - Override Planning Filter Policy (see also WTYP Planning Filter)

The filter DTYP allows the suggestions for changes to existing planned or confirmed Production orders produced by MPS to be processed automatically as part of the MPS run. It adds an additional level of flexibility to planning which removes the need for manual intervention by the planner to change existing orders, thus making considerable savings in time and effort. Full audit reporting at either style or full product level is provided for any changes made automatically.

- This functionality is optional and in addition to the manual filter using **WTYP**.

- This feature does not impact the operation of the system unless it is used. However, it does increase the processing time of the MPS run. The automatic update is performed after the full planning process is complete so that the planning exception/action codes are available to the planner for reference.

- A full review of the use of planning filters is recommended before the use of this additional feature is considered. This is especially important for suggested changes to orders which are already reserved against sales orders, as the changes may have an impact on the quantities available to meet the requirements of the demand order(s). Where the use of back-to-back processing is used, without discrete demand functionality being utilised in MPS, these orders may have recommended changes on them which may necessitate analysis and follow-up actions.

- Changes are not made automatically to orders which have got planning exception codes which indicate that effectivity dates need reviewing. These orders will need to be changed manually.

Changes are not made automatically to released or active orders.

The MPS application produces suggestions for the creation of new supply orders and changes to existing orders. Where changes to existing production orders are recommended, they can be made manually or automatically. The option to process changes automatically is only applicable to Planned and Confirmed Production orders and allows the following types of change to be automated:

SKU quantities to be increased

SKU quantities to be decreased

SKUs to be removed from an order

SKUs to be added to an order

Orders be cancelled

Orders to be re-scheduled "In"

Orders to be re-scheduled "Out"

The parameter DTYP, Override Planning Filter Policy, holds indicators to control this function. The settings are similar to those on WTYP planning filters. When submitting an MPS run, the user can choose to automate the suggested changes. Each order is tested against the DTYP

parameter settings to determine whether the change can be automated and if conditions have been met it automatically acts on the associated suggested action. The supply file used for MPS review and reports is then updated to reflect the changes made to the orders. The exception codes are not changed apart from cancellations, however, so that visibility of the recommendation is available for review after the MPS run is complete.

> **Caution:** Quantity change conditions are tested for at order level, for the whole order. This means that, for example, where there is an overall quantity increase on an order, but one SKU is decreased or cancelled, the change will occur if the '+' on DTYP is set on. Similarly if there is overall quantity decrease and one SKU is increased, the change will occur if the '-' on DTYP is set on.

Only two codes are allowed for the Auto Planning Filter parameter:

41 = Planned Production Orders

42 = Confirmed Production Orders

The specific effect of each Auto Planning Filter Code is controlled by the values in the Quantity Re-schedule fields headed **+**, **-** and **C** (Increase Quantity, Decrease Quantity and Cancel) and the Date Re-schedule fields **I** and **O** (Re-schedule IN, Re-schedule OUT). A value of **0** (default) means no automatic re-scheduling will take place, whereas a value of **1** will automatically action the MPS suggestions for that field.

MASU - Mass Update Function Control

This parameter performs the following two functions in the Route/Bill of Material task:

- Mass Update - Controls which style route operation fields to update with standard operation changes when performing a mass update
- Route Input Protection - Controls which style route operation fields you can enter or update

You can set each field that appears on Style Route Operation Details window and Standard Operations Maintenance Mass Update window as follows:

- For no mass update and no route input protection
- To be updated by a mass update
- To be updated by a mass update and also protected in the Route/Bill of Material task

MATW - Default Material Wastage

Percentages can be entered against a selected analysis code. The code to be used can be defined under this parameter. The valid values are:

- PTYP - Product Type
- PCLS - Product Class
- PGMJ - Product Group Major
- PGMN - Product Group Minor
- DIVN - Division
- SDIV - Sub-division

Note: Within MATW, the code PTYP has been set up as the default. This can be amended as required.

Caution: Only one code can be entered from the above list.

PDSC - Planning Demand Status

This parameter defines demand status codes within MPS and MRP. Examples of codes are as follows:

- 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

Note: Codes that include the term (Excluded) relate to demand or supply excluded from the review.

Note: For example:

On one particular day, there is a sales forecast of 30 items and a sales order demand of 60 items. The demand policy utilises the greater of actual demand or forecast. The software displays the sales order demand of 60 with a status of SO. The forecast demand of 30 appears with a status of FX, because it is not used (excluded).

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

PEXC - Planning Exception/Action Code

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

The following list of action codes indicate the recommendations you can make. These codes can appear in combination; and examples are given to illustrate the sort of actions the software can suggest.

Note: Codes shown comprising of 4 consecutive characters, for example ROCQ, are displayed as individual elements separated by a date, and with a suggested change quantity where applicable, for example RO11/09 CQ 23.

Typical action codes are as follows:

- CA - Cancel order
- CQ - Change quantity (mix)
- EF - Check effectivity
- EI - Re-schedule IN and check effectivity
- EICQ - Re-schedule IN, change quantity and check effectivity
- EO - Re-schedule OUT and check effectivity
- EOCQ - Re-schedule OUT, 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

Refer to the action codes above in the following two examples:

Work Order Number = W000156, Quantity = 122, Status = CW; results in an Action = RI 15/08 CQ 1180, which means a re-schedule order due date IN to 15 August, and a change quantity from 122 to 1180.

Work Order Number = W0007716, Quantity = 30, Status = IW; results in an Action = RO 11/09 CQ 25, which means a re-schedule order due date OUT defer until 11 September, and a change quantity from 30 to 25.

Material Effectivity

If, as a result of a recommendation, material effectivity is compromised, that is, the material is not effective on the route/BOM on that date, warning codes are also displayed (these are included in the table).

Re-schedule IN or OUT

Expedite or defer:

References to re-schedule IN indicate that the run is suggesting that the due date is brought forward (into the schedule) or expedited.

References to re-schedule OUT indicate that the run is suggesting that the due date is deferred (out from the schedule).

The review facilities for both MPS and MRP enable you to view orders in both original and suggested due date sequence.

PSSC - Planning Order Status

This parameter defines the following 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

PSTK - Planning – Stock Policies

This parameter defines how stock is treated in MPS and MRP.. Codes are:

- FRZN Frozen Stock

Set to **0/Blank** – To exclude Frozen stock from vailable stock figure.

Set to **1** – To include Frozen stock in the available stock figure.

RTUP - Refresh Route on Confirmation

Use this parameter to decide if a refresh of route details on confirmation of orders is required. This is particularly useful when creating Planned Orders from Back-to-Back Processing, since there may be some delay before the orders are confirmed, during which time changes may have been made to the route. This parameter allows the route refresh on confirmation to be switched on or off as required. Codes are

- ROUTE - Update from route

Set to **0** - To prevent refresh

Set to **1** - To update route details on confirmation of orders

STDE - Standard Operations Enquiry

Use this parameter to define what functions and options you make available to users within the Standard Operations Enquiry tasks, that is, what entries are valid in the Option field, and what functions are displayed. Functions can be associated with user-written programs.

STDO - Standard Operations Maintenance

Use this parameter to define what functions and options you make available to users within the Standard Operations task. Functions can be linked to user-written programs.

STYE - Style Route Enquiry

Use this parameter to define what functions and options you make available to users within the Enquire on Style Route/Bill of Materials task. Functions can be associated with user-written programs.

STYL - Style Route Maintenance

Use this parameter to define what functions and options you make available to users within the Route/Bill of Material task. Functions can be associated with user written-programs.

USER - User Defined Program Names

Use this parameter to specify the user-defined programs called by selecting **User Pgm (F15)** on the Style Route Operation Details window and on the Standard Operation Maintenance Details window. You can enter one program name for primary operations and another for variant operations.

WOM2 - Pre-Released Order Maintenance

Use this parameter to define what functions and options you make available to users within the Maintain Orders task for confirmed orders.

WOM3 - Post-Released Order Maintenance

Use this parameter to define what functions and options you make available to users within the Maintain Orders task for released and active orders.

STDE, STDO, STYE, STYL, WOM2 & WOM3

Parameter definitions are relevant to all of the programs indicated, that is, those programs which enable you to add to, or amend, functions or Option/Select fields. There is a specific format to the code structure.

Function Keys:

- Position 1 to 2 - Values F1 to FC refer to functions F1 to F12.
- Position 1 to 2 - Values S1 to SC refer to functions F13 to F24.
- Position 3 to 4 - Value 99 is always set.
- Position 5 to 10 - Value 999999 means the function is available on all windows.
- Position 5 to 10 - Value of *program name* means the function is only available on specified windows.

Options:

- Position 1 to 2 - Values 01-09 refers to options 1 - 9.
- Position 3 to 4 - Value 24 means the line is an operation.
- Position 3 to 4 - Value 27 means the line is a variant operation.
- Position 3 to 4 - Value 28 means the line is a material.
- Position 3 to 4 - Value 41 means the line is an order operation.
- Position 3 to 4 - Value 42 means the line is an order variant operation.
- Position 3 to 4 - Value 47 means the line is an order material.
- Position 5 to 10 - Value 99999 means the option is available on all windows.

- Position 5 to 10 - Value of *program name* means the option is only available on specified windows.

Process Program:

- Position 1 to 5 - Value of *program name* refers to the program called if you take the function or option.
- Position 10 - Value D refers to the validation of functions and options being passed to the program being called.
- Position 10 - Value L refers to the validation of functions and options remaining with this list.

WORL - Works Order Planning Level

This may be set to:

0 - For style

1 - For style/colour

3 - For full product

Note: There is also provision when using the Confirm Suggested Orders task to select All Levels. This displays all suggestions, each at the production order level view set for its item.

WTYP - Planning Filter

You use the WTYP parameter to create MPS/MRP planning filters. These planning filters determine how you re-schedule an item, production order, or purchase order during MPS/MRP processing. Planning filters support two different types of re-scheduling policies: date and quantity.

For the date re-schedule policy, production and purchase order dates can be expedited (or the due date brought IN, scheduled earlier) or delayed (deferred, the due date pushed OUT). Date re-scheduling recommendations can be restricted 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 as long as the resulting value of the order (Order Value = Suggested Quantity x Inventory Standard Cost) is greater than the extended value
- For the quantity re-schedule policy, production and purchase order quantities can be increased, decreased or cancelled. Quantity re-scheduling recommendations can be restricted 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 control additional processing by using parameter values (Quantity Percent of Safety, Percent of Lead Time, Days, or Order Value). These determine when or how the planning filter is applied.

You can modify the MPS/MRP processing globally by changing the re-scheduling rules for standard production order types, or it may be modified to vary according to specific situations using the planning filter.

For example, such modifications could be used to inhibit all changes to production orders which have a status of Active (work-in-process has been reported) and to treat all orders of Planned and Released status as confirmed and therefore not subject to recommendations.

When this is applied to an item at item level, or specifically for an individual order, you can control how to maintain an item or order using planning filters. Planning filters determine whether production orders at a particular status can be re-scheduled. For example, for each relevant order, do not allow it to be cancelled, or quantities to be increased or decreased, or exclude recommendations for insignificant or unworkable changes to the quantity or due date of the supply (order).

These modifications are available not only for production orders using the planning filter, but also for purchase orders. Different rules may govern the scheduling of normal, schedule, blanket and user-defined purchase orders.

Planning Filter Control Parameter Definitions							
	Quantity Reschedule			Date Rescheduled	Required Control Parameter Values			
Value	(+) Increase	(-) Decrease	(C) Cancel	(I,O) In or Out	Qty % of	% of Lead	Days	Order
0	No change allowed	No change allowed	No change allowed	No change of date allowed				
1	Any change allowed	Any change allowed	Any change allowed	Any change allowed				
2	Increase less than the minimum order qty for the item not allowed	Decrease less than the minimum order qty for the item not allowed		Date changed may not be less than number of days entered			Y	
3	Increase less than defined Qty % of Safety not allowed	Decrease less than defined Qty % of Safety not allowed		Date changed may not be less than % of Lead Time	Y	Y		
4				Value of order must not be greater than Order Value				Y

The Production Details window defines the Item minimum order quantity.

- Order Value = Suggested Order Quantity x Inventory Standard Unit Cost

Pre-defined production order status codes come supplied with the Style Production software. The two-digit numeric order status code identifies the order type and status.

Production and purchase order status codes are as follows:

- 11, 12, 13, 14 - Purchase orders (lines)
- 19 - Purchase orders (schedules)
- 40 - Suggested (MPS/MRP)
- 41 - Planned

- 42 - Confirmed
- 43 - Released
- 44 - Active
- 50 - Suggested purchase order

You create a user-defined planning filter in WTYP by attaching a single alphanumeric character (B) to a two-digit production order status code (41 - Planned Work Order). The effect is to create a unique planning filter code: 41B - Planned Work Order with no increases in quantity and no expediting.

The specific filtering effects of each planning filter code are controlled by the values in the Quantity Re-schedule fields headed **+**, **-**, **C** (Increase Quantity, Decrease Quantity and Cancel) and the Date Re-schedule fields **I** and **O** (re-schedule IN, re-schedule OUT).

Depending on the value set in each column (0-4), a control parameter value (Qty % of Safety, % of Lead time, Days, or Order Value) may be required as well. The Planning Filter Control Parameter Definitions table (shown above) demonstrates the relationship between the quantity and Date Re-schedule field values, and the required control parameter values.

For 41B, the re-scheduling fields are as follows:

(+) Increase Quantity = 0 No Change Allowed

(-) Decrease Quantity = 1 Any Change Allowed

(C) Cancel Order = 1 Any Change Allowed

(I) Move Date In = 0 No Change Allowed

(O) Move Date Out = 1 Any Change Allowed

You can set a default planning filter to any item using Production Control, Production Scheduling (MPS and Capacity Reviews) and Material Planning (MRP Review).

The planning filter assigned to an item, or individual order, conditions the MPS or MRP run response. If the re-schedule policy is defined both for the order type and for the assigned planning filter, the rules defined on the planning filter will be used. Where a planning filter is not used, the rules applying to the order type will be used. If neither order type nor planning filter has a policy defined, the order is not subject to recommendation. Recommendations for the cancellation of an order may also be either allowed or restricted. However, cancellation is necessary when re-scheduling OUT (deferring).

Note: Although it is possible to define recommendations for changes to suggested orders - SP (suggested purchase) and SW (suggested production order) - the software ignores such recommendations.

Note: If multi-plant functionality is required, the following planning filters must be set up. The +, -, C, I, and O parameters must be set to zero (0) 41M planned production order (multi-plant), 42M confirmed production order (multi-plant), 43M released production order (multi-plant), 44M active production order (multi-plant).

Maintain Parameter File Selection Window

To display this window, select the Maintain [Parameter File](#) task.

This window lists all parameters that can be updated. Use **Page Up** and **Page Down** to see more parameters.

Fields

ADD

The first five input fields described below are untitled, but are placed under the appropriate fields in the displayed list of parameters.

Type

Enter the parameter type you want to maintain.

Descriptions

Enter a parameter type description.

Code Length

Enter the maximum length of codes assigned to the parameter.

Max Codes

Enter the maximum number of codes which may be defined for the parameter. A maximum of 99999 may be specified.

Code

Enter parameter code headings.

System Screen

Enter one of the following:

Blank - For a user-defined parameter

1-9 - For an internal, system-defined parameter

Company Dependent

This field defines whether the parameter is company-based or global.

Select one of the following:

Blank - If the parameter is global

Yes (1) - If the parameter is company dependent

Password

You can enter a password to prevent unauthorised alteration. If you enter a password, a password pop-up prompt is displayed each time the parameter is selected.

Validation Program

Enter a program number that will validate the Rate and Value fields.

Or Rules

Alternatively, use this field to define validation rules for rate and value details.

Screen Format

Enter the format ID you want to use when maintaining details.

Rate 1 Description

Enter a heading or prompt used for rate 1 when maintaining detail.

Rate 2 Description

Enter a heading or prompt used for rate 2 when maintaining detail.

Value 1 Description

Enter a heading or prompt used for value 1 when maintaining detail.

Value 2 Description

Enter a heading or prompt used for value 2 when maintaining detail.

Options

Select

Use this to display and maintain codes assigned to the parameter.

Maintain

Use this to maintain the parameter definition.

Delete

Use this to delete a parameter.

Print

Use this to print out codes and definitions assigned to the parameter.

Functions

System/User (F17)

Use this to change the display between the Maintain Parameter File Selection window and the Maintain Parameter File System window. The window layout does not change, but the parameter list displayed changes between user-maintained parameters and system-maintained parameters.

Print All (F21)

Use this to print all user or system parameters and their values.

Select a parameter to display the Maintain Parameter File Details window.

Maintain Parameter File Details Window

To display this window, select a parameter on the Maintain Parameter File Selection window.

This window contains a list of codes and definitions for the selected parameter. Use this window to amend the parameter. You can add codes, delete codes and update codes.

Fields

ADD

The input fields described below are untitled, but are placed under the appropriate fields in the displayed list of codes.

Code

Enter a two-digit code to identify the order type and status.

Description

Enter a description for the code.

Options

Maintain

Use this to amend the code.

Delete

Use this to delete this code.

You will have to select **Delete (F11)** on the pop-up to confirm deletion.

Note: When you select Maintain against a code, the Code field is no longer input-capable. Any remaining fields on the window are dependent on the parameter and code selected for maintenance.

Press Enter to add or amend the code and then select **Previous (F12)** to return to the Maintain Parameter File Selection window or select **Exit (F3)** to leave the task.

Delete Planning Model [3/P1U]

Use this task to purge the planning models that you require no longer.

Caution: You must not delete the live planning model.

Forecast Model Deletion Utility Window

To display this window, select the Delete Planning Model task.

Note: Make sure that you have a current security copy of your data files library before using this task. A window will be displayed on entry to the task to warn you to do this.

Fields

Company Code

Enter the company code.

Model Number

Enter the [planning model](#) you want to delete.

Caution: This task permanently deletes this model.

Select **Delete Model (F11)** to confirm the deletion and leave the task.

Delete Company [4/P1U]

Use this task to delete redundant companies from the [Style](#) Production system.

Caution: This task permanently deletes this company from the software.

Company Deletion Utility Window

To display this window, select the Delete Company task.

Note: Make sure that you have a current security copy of your data files library before using this task. A window will be displayed on entry to the task to warn you to do this.

<u>Fields</u>

Company Code

Enter the company you wish to delete.

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

Select **Delete Company (F11)** to confirm the deletion and leave the task.

Generate Low Level Code [5/P1U]

You can run the low-level code routines independently using this task. These routines are normally run as part of [MPS](#) processing, [MRP](#) processing, or both, and also as part of the Item Master File Re-[cost](#) task.

Where product structures are stable, these routines can be safely excluded. You can use this task after major structure changes, to avoid adding this overhead to the next [MPS](#) or [MRP](#) run.

The [MPS](#) and [MRP](#) Run Parameters windows display a warning message if there are product structure changes and you can exclude the function from the run. However, you should only exclude regeneration if you are certain that the changes will not compromise the effectiveness of the run.

Low-level codes are used by:

- Planning: MPS and MRP
- and
- Product costing

They are used to make sure that items are processed in the correct sequence:

- Planning uses the lowest level code first.
- Costing uses the highest level code first.

Low Level Code Generation Selection Window

To display this window, select the Generate Low Level Code task.

Use this window to specify which route to use to generate the low level code.

Fields

Material Route

Use this field to specify a route for low level code calculation.

Select one of the following:

Planning Route (1)

Costing Route (2)

Select **Submit (F8)** to submit a batch job to create the codes and leave the task.

Maintain Organisational Models [6/P1U]

Use this task to specify a set of production policies and controls that, other than default scrap and hold reason codes, cannot be overridden within the application.

Multiple Organisational Models

You can define more than one organisational model. Organisational models should represent the different plants or lines to plan or control.

Each machine that you set up using the Machines task is attached to an organisational model.

Maintain Organisational Model Selection Window

To display this window, select the Maintain Organisational Models task.

Use this window to enter an organisational model.

Fields

Model

Enter a model to create or maintain.

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

If you are creating a new model, you can enter up to two alphanumeric characters.

Press Enter to display the Maintain Organisational Model Details window.

Maintain Organisational Model Details Window

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

Use this window to define and maintain details of the organisational model.

Fields

Description

Enter or amend the description of the model.

Scrap Reason Code

Enter the default reason code to be used when booking scrap. You can override this.

Alternatively, use the prompt facility to select from the MOVR Transaction Reason Code pop-up.

Transaction Number

This field displays the last transaction number used; and is automatically maintained by the software. It is updated by 1 each time you record a work-in-process booking, and provides an audit trail of all transactions.

Hold Reason Code

Enter the default reason code for when booking held WIP. You can override this at the time of entry.

Alternatively, use the prompt facility to select from the MOVR Transaction Reason Code pop-up.

Subcontractor Stockroom

This field is only relevant if subcontract operations will be included on routes/BOMs. The subcontractor stockroom holds balances of all materials issued to subcontractors, in order that they might complete the operations. Those materials must be backflushed materials; you transfer them initially to the subcontractor stockroom during formal issuing routines.

The software holds material stocks by subcontractor code or item code within the stockroom; they are backflushed when subcontracted operations are booked using the Production Control, Receive from Subcontractor, and Progress at Subcontractor routines.

WIP inventory is despatched to a subcontractor via the Production Control Subcontractor WIP Shipper facility, and affects the subcontractor balance at the WIP location for the operation

before that designated as subcontract. The subcontractor stockroom contains no WIP inventory balances.

You can use the prompt facility on this field to select from the Select Stockroom pop-up.

Shipper Number

This displays the last shipper number, or despatch note, recorded against a subcontract transaction. You can use shipper numbers to track shipments of WIP and materials to subcontractors.

Time Reporting Policy

This policy determines the method by which operator, team and machine hours (or any combination of these three) at an operation are entered within the production order and operator booking routines. You always enter operator and machine hours independently.

Enter one of the following:

0 - To enter the time taken to carry out the work

You can also enter decimal hours and minutes depending on the setting of the Time Booking Policy flag.

1 - To enter a start (in) and finish (out) time

The software calculates the elapsed time.

You define codes in the Parameter file, under type TIMI.

You can use the prompt facility on this field to select from the TIMI Time Reporting Policy pop-up.

Plant Indicator

Use this field to specify whether work-in-progress (WIP) locations are linked to the organisational models.

Use this checkbox as follows:

Unchecked - Not to link the WIP locations to the model

Checked - To link the WIP locations to the model

Shipper Tracking

Use this to specify whether issues to, and receipts from, subcontractors are to be recorded against a shipper number, and shipping documentation, or shipper notes, produced.

You can compare receipts to issues to make sure that the amount received is equal to the amount despatched by the shipper, or that the correct lot is returned.

A shipper number is generated with each despatch. You can enter your own number, if preferred. You can record a number of shipments on the same shipper number.

WIP shipping transactions are the movements of production lots from production sites to a subcontractor. You ship WIP inventory from the operation prior to that designated as subcontracted, following booking at that operation.

Material shipping transactions are those recorded when you issue materials, instead of WIP, to subcontractors from stockrooms.

Completed subcontract work, or WIP inventory, is booked using the Receive from Subcontractor task, rather than the production order or operator booking routines, at the final subcontract operation.

You define codes in the Parameter file, against type SHPI

Enter one of the following:

0 - If no tracking is required

1 - If a shipper number is assigned and a shipping note printed for each despatch to a subcontractor

In this case, you compare WIP receipt quantities to despatch quantities when the subcontractor returns them.

2 - If no shipper number is assigned and a shipping note is printed for each despatch to a subcontractor

In this case, the software does not compare WIP receipt quantities to despatch quantities when the subcontractor returns them.

3 - If a shipper number is assigned but no shipping note is printed for each despatch to a subcontractor

In this case, WIP receipt quantities are be compared to despatch quantities when returned by the subcontractor.

You can use the prompt facility on this field to select from the SHPI Shipper Tracking Flags pop-up.

Held Inventory Tracking

Use this field to indicate whether WIP inventory held pending a decision, for example, whether or not it passes quality checks, must have a tracking reference associated with it.

Use this checkbox as follows:

Unchecked - If no tracking is required

Checked - If you must enter a reference when booking held quantities

You also need to specify a WIP held reference for any WIP inventory transactions involving held quantities, before the transaction can be completed.

WIP Lot Tracking

Use this field to indicate whether lot traceability is required when reporting or booking WIP inventory at a count point operation.

Use this checkbox as follows:

Unchecked - If non-lot-controlled materials will only require designation of a lot number when received into inventory

You can optionally enter a reference in two places: either against a booking transaction or at an operation designated a type 4, lot update point, key operation.

Checked - If lot-controlled materials in Style Inventory Management will be tracked by lot in WIP booking

Quantities of a lot must be booked at a prior operation before you can report on them at the operation to which you are currently booking.

For example, to book a quantity of 400 against LOT01 at operation 20, a minimum of 400 must have been booked against LOT01 at operation 10 (or prior designated count point operation).

Note: Make sure that earlier operations are booked before later operations. For example, you will not be able to book operation 30 on an order before you have updated operation 20.

Generate Cost Recovery

Use this field to specify whether you create standard production activity cost records when you book WIP inventory at a count point operation. These records show the standard value of the work, fully dissected at elemental level, and represent the potential inventory value at the operation stage reached. The software generates costs for the reported operation and previous non count points. It then calculates the cost at a reported operation, with wastage entered explicitly as the quantity scrapped.

Use this checkbox as follows:

Unchecked - For no generation

Checked - If you require cost accounting at an elemental level

Backflush Material Usage Including Wastage

Use this to determine whether the software inflates material usage in inventory by operational wastage factors defined for the production route/BOM.

Use this checkbox as follows:

Unchecked - Not to use operational wastage

If wastage at an operation is a process efficiency factor, do not inflate the material usage, because the effect is to inflate standard production times and not to increase the usage of material.

Checked - To use operational wastage if wastage at an operation is the scrap rate of WIP

The reason is that additional input material is required to make good the predicted loss of WIP.

Backflush Operation Times Including Wastage

Use this to indicate how standard operation times are determined for efficiency calculations.

Note: These standard times are calculated for all actual production bookings, if efficiency reporting is requested on the activity type against which the booking is made.

Use this checkbox as follows:

Unchecked - To exclude wastage

In this case, operational wastage is assumed to be the same as WIP scrap rate, and not machine or labour inefficiency.

Checked - To include wastage

In this case, operational wastage is considered a processing inefficiency, that is, inefficient labour or machine activity, so that operation times are inflated by operation wastage.

Time Booking Policy

Use this field to indicate how time is to be booked at an operation, when the Time Reporting Policy flag is set to **0** (Elapsed Time).

Select one of the following:

Decimal Hrs (0 or blank) - To enter decimal hours

For example, to enter 45 minutes, type 0.75

HH.MM (1) - To enter in hours and minutes

For example, to enter 45 minutes, type 0.45

Press Enter to save the details and return to the Maintain Organisational Model Selection window and then select **Exit (F3)** to leave the task.

Maintain Machine Locations [7/P1U]

A WIP location is an Inventory Management stockroom that you have logically associated with one or more machines. It is the stockroom that receives all WIP inventory produced from count point operations by those machines.

Note: WIP inventory is not visible within Inventory Management. It is data kept entirely within the Production software. The software does not validate this condition, so you must make sure that these definitions are complete.

These stockrooms are the same as other stockrooms defined in Inventory Management. They are capable of supporting on hand balances for any type of item, purchased or manufactured. The difference is that in Production Control, these stockrooms are designated as repositories of WIP inventory.

Note: You cannot define a warehouse as either a WIP or floor stock location.

You must link every machine used on a process route to a WIP stockroom.

You can link a machine to a single WIP location only. The link between a machine and WIP stockroom dictates which stockroom receives WIP inventory produced by any count point operation.

You must link every WIP location (stockroom) to the organisational model, using this task. You can select and sequence many of the schedule reports and enquiries by WIP location.

Machine WIP Locations Selection Window

To display this window, select the Maintain Machine Locations task.

You use this window to enter the machine for which you want to maintain locations.

Fields

Machine

Enter the machine for which you want to maintain locations.

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

Press Enter to display the Machine WIP Locations Details window.

Machine WIP Locations Details Window

To display this window, press Enter on the Machine WIP Locations Selection window.

Use this window to link a machine to a WIP location, the live organisational model and a floor stock location. The machine code that you entered on the first window is displayed, together with a description of it. You must have already set it up in Machine Maintenance.

Note: If a machine has been deleted, a message is displayed next to the machine, and all fields are for enquiry only. Machine deletion does not delete the machine WIP location details. You have to delete them here.

Fields

WIP Location

Enter the logical WIP location that is linked with this machine and holds all WIP inventory balances. You must already have set up the stockroom in Stockroom Details within Inventory Management.

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

Organisational Model

Enter the live organisational model that will be linked with this machine and WIP location. You must have already set up and validated the organisational model in the Maintain Organisational Model task.

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

Floor Stock Location

Enter the floor location or stockroom.

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

When you issue materials with a Material Policy Code 3 (usually from the raw material stockroom), they do not go directly to WIP but are transferred to the floor stock location associated with the machine.

You must have already set up this stockroom in Stockroom Details.

Press Enter to validate your entries and return to the Machine WIP Locations Selection window.

Maintain Activity Control [8/P1U]

Production activity reporting is supported by a transaction processing system. It comprises four basic elements.

Activity Types

These are definitions of activities that you report, and they are based upon system-defined reporting types. A basic set of activity types is provided with the system, which make use of all of the reporting types. Examples of specific activities that you might want to define further include:

- Production order bookings
- Production schedule bookings
- Setting time
- Re-work

You can change these definitions to make them more meaningful to your business. The activities defined for reporting can be very specific user activities. However, every activity type must be linked to a single reporting type.

Reporting Types

These are system definitions. Reporting types are definitions that support groups of activity types, which you define. Reporting types cannot be maintained by the user. Examples of reporting types include:

- Production (for activities like manufacture or packing, for example)
- Work-in-progress (WIP) movement (for shop floor progress tracking)
- Indirect labour (for activities like cleaning or maintenance, for example)

With this design, you can define additional activities very flexibly.

Transaction Types

Each reporting type is defined in the system to perform a specific set of detailed processing activities known as transaction types. A single reporting type may consist of many different transaction types. For example, the booking of a manufacturing operation may cause a reduction of WIP at the previous operation, an increase of WIP at the booked operation, labour and machine times, and consumption of materials. Each of these is a separate transaction, all invoked by a single reporting type. The Transaction Manager (see below) determines which transaction types are required when processing a reported transaction of a certain reporting type, from the list of possible transactions, by analysing the booked information and the relevant data relationships.

Transaction Manager

This is the program that manages the processing of transactions reported in Production Activity Reporting. This program runs in its own subsystem and attempts to process transactions that have been reported every 60 seconds.

System-defined transaction types are also available for use within Advanced Financial Integration (AFI) for the purpose of making postings into Financial Accounts.

Transaction Costs

Cost transactions are created as a result of the booking of production activity and material movements. They can be recorded at two levels. Material and WIP movements are generated with a total movement value. You can optionally dissect this value into its elements. The standard movement value is derived from the standard costs of the items and operations, and the actual movement value is derived from the cost rates currently in force.

Caution: The installation instructions for Production include a list of activity codes that you must create, as they are required by the software.

Note: If you have created more than one Production company, you must create a full set of activity codes for each company, based on the codes that are shipped with the software. You can also create additional codes.

Production Activity Control Maintenance Selection Window

To display this window, select the Maintain Activity Control task.

Use this window to select an activity type to be maintained.

Fields

Activity Type

Enter the activity type to be maintained. If this is a new activity type, the Description and Reporting Type fields are displayed.

You can use the prompt facility to select from the Select Activity Code pop-up.

Description

This field is displayed if you enter a new activity type. Enter a text description of the activity type.

Reporting Type

This field is displayed if you enter a new activity type. Enter the reporting type.

Many activity types can be defined with the same reporting type. This can be useful because analysis can be performed by reporting type or by activity type. Production booking could be analysed as a whole using the reporting type, or within subsets by using activity types. For example, each department could have its own activity type defined for production reporting, thereby enabling analysis by department.

Press Enter to display the Production Activity Control Maintenance Details window.

Production Activity Control Maintenance Details Window

To display this window, press Enter on the Production Activity Control Maintenance Selection window.

The activity and reporting types entered on the previous window are displayed for your information only.

Fields

Display Sequence

The display sequence value controls two things. The activity type with the lowest sequence number is the default activity type displayed when you enter the Production Recording window. A refinement to this is that schedule booking defaults to the first activity sequence number for which work order entry is not mandatory. In addition, this number controls the sequence of activities listed within the Select Activity Code pop-up.

Activity Indicators

This is where you specify, as allowed by the reporting type, which data elements you want to prohibit, allow, or require in the reporting carried out in your business.

The activity indicator streamlines data entry by requiring you to enter only appropriate data. Each reporting type imposes mandatory requirements upon certain data elements (for example, Production Reporting requires an item code), but supports variations for other elements.

Actual activity reporting occurs within certain Production Order Control options. The software validates the information you enter against the activity indicator settings of the activity type being reported.

The activity indicators are:

- Employee No.
- Employee Hours
- Item No.
- Operation
- Work Station
- Work Station Hours
- Department
- Quantities
- Shift
- Work Order

Each activity indicator has an associated reporting type indicator, which may be 1 (Mandatory), 2 (Prohibited) or 3 (Optional). You cannot amend reporting type indicators that are set to 1 or 2. However, indicators set to 3 (Optional) can be changed to a different value if necessary.

Note: *Employee Hours are called Operation Elapsed Time, and Work Station Hours are called Work Station Elapsed Time on the Production Order Booking window.*

Reporting Type Ind

This field displays the default data entry characteristic defined for the data element by the reporting type definition. If a data element is mandatory or prohibited, you cannot define the reporting type indicator any differently. If it is optional for the reporting type, however, you can define the data elements as mandatory, optional or prohibited.

The reporting type indicators are:

1 - Mandatory

2 - Prohibited

3 - Optional

Reporting Type Indicator Defaults

Each data element associated with a reporting type is assigned a reporting type indicator, which can be 1 (Mandatory), 2 (Prohibited) or 3 (Optional). When you select an activity, the activity has an associated reporting type, and the default values for the reporting type indicators are displayed on the Production Activity Control Maintenance Details window.

Note: The Quantity policy should be set to 3 (Optional) for all booking activities where the independent booking of outputs is required. You will then be able to leave the WIP quantity blank when booking outputs.

Inventory Movements

Use this checkbox as follows:

Unchecked - If the activity allows you to report production quantities for efficiency reporting purposes only

WIP inventory balances are not updated. This option allows activity types that support production reporting to be established without concurrent WIP inventory movements.

Checked - If WIP inventory balances are updated when production quantities are entered under this activity type through shop floor reporting

Note: A special case of this is the Backflush Production Receipts reporting type. If this is checked for this reporting type (50) the Inventory is updated using the Transaction Manager as normal. If it is left unchecked, the Transaction Manager will not create Inventory movements, but they still will be created by the interactive booking process itself.

Press Enter to save your changes and return to the previous window.

Order Archive Selection [11/P1U]

During archiving, a copy version of the order header and details is created, and the live production records deleted. The task deletes cancelled orders, but does not create an archived version. You can also:

- Print a variance report of all archived orders.

- Archive operation booking history records for each order.
- Archive stockroom transaction history for each order.

You can set these options in the company profile.

A variance report can be set to print automatically as part of the archiving procedure. The report details variances between planned and actual bookings.

Production Order Archiving Selection Window

To display this window, select the Order Archive Selection task.

Use this window to enter the production orders that are not to be archived, and the date up to which completed orders should be archived.

Fields

Company to be Processed

This field displays the company, or companies included in the archive.

Last Run Date

This field displays the date on which the last archive took place.

Last Cut-off Date

This field displays the cut-off date that was used for the last archive.

Any orders made after this date were excluded.

Orders to be Excluded

Enter any production orders that you do not want to archive.

Note: All orders must be completed to qualify for selection.

Date Up to Which Completed Orders Are to be Archived

Enter or select a cut-off date for orders to be archived. Any completed orders with a completion date inside this horizon will be archived, unless specifically excluded.

Select **Submit Job (F8)** to submit the archive job and leave the task.

Enquire on Route/Order Processor [29/P1U]

This task provides a list of the routes or production orders currently being maintained or awaiting processing by the background processor. It gives details of the time, user ID, style and, if it is displaying routes, the route code, or if it is displaying orders, the order number.

Note: Failed maintenance sessions will also appear on this list until record locks are cleared from the record locking file (MSP99).

Route/Order Processing Enquiry Selection Window

To display this window, select the Enquire on Route/Order Processor task.

Use this window to select a list of the routes or production orders currently being maintained or awaiting processing by the background processor.

Fields

User

Enter a user ID or leave this field blank to display all IDs. The default is the current user ID.

Routes/Orders

Select one of the following:

Routes (1) - To display routes currently being processed

Production Orders (2) - To display production orders currently being processed

Press Enter to display the Route/Order Processing Enquiry Detail window.

Route/Order Processing Enquiry Detail Window

To display this window, press Enter on the Route/Order Processing Enquiry Selection window.

Use this window to see the details of the routes or production orders currently being maintained or awaiting processing by the background processor.

The window heading will show whether you have chosen to display routes or production orders.

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

Reconcile WIP Inventory [41/P1U]

Use this task to reconcile held and subcontractor WIP inventory balances. You can run the task in trial mode or audit mode, or you can update balances.

WIP Inventory Reconciliation Selection Window

To display this window, select the Reconcile WIP Inventory task.

Use this window to specify the inventory balances are to be reconciled.

Fields

Held Inventory

This field is only effective if the Held Inventory Tracking field in the Organisational Model task is **checked**.

Use this checkbox as follows:

Unchecked - Not to reconcile total held balance with WIP inventory detail balances

Checked - To reconcile the total held balance with the WIP inventory detail balances

Subcontractor Inventory

This field is only effective if the Shipper Tracking field in the Organisational Model task is set to require shipper tracking.

Use this checkbox as follows:

Unchecked - Not to reconcile the total subcontractor balance with the subcontractor WIP inventory detail balances

Checked - To reconcile the total subcontractor balance with the subcontractor WIP inventory detail balances

Report or Update

Select one of the following:

Trial Report only (1) - To produce a trial report only

Update (2) - To update

Press Enter to submit the job and leave the task.

Delete Subcontractor Shipper [42/P1U]

Use this task to delete all closed shipper records, if you have already printed shipper notes with material or WIP inventory shipments, or both, to subcontractors.

Delete Subcontractor Shippers Window

To display this window, select the Delete Subcontractor Shipper task.

Caution: This task deletes all closed shipper records permanently.

Use this window to confirm the deletion of subcontractor shippers.

Press Enter to delete the shipper records.

Delete Held Inventory References [43/P1U]

Use this task to delete all held inventory references that relate to inventory that has since been scrapped, released or transferred.

Delete Held Inventory References Window

To display this window, select the Delete Held Inventory References window.

Caution: This permanently deletes all held inventory references.

Use this window to confirm deletion of held Inventory references.

Press Enter to delete the records and leave the task.

Delete Cost Transactions [44/P1U]

Use this task to delete all cost transactions prior to a specified date.

Delete Movements Window

To display this window, select the Delete Cost Transactions window.

Caution: This permanently deletes cost transactions.

Use this window to specify a date and confirm deletion of cost transactions.

Fields

Posting Date

Enter or select a cut-off date. All cost transactions prior to this date will be deleted.

This field defaults to the current date.

Note: If AFI is active, transactions which have not been posted to AFI will not be deleted by this task.

Press Enter to submit a job to delete the records and leave the task.

Chapter 7   Advanced Financial Integrator

7

Introduction to AFI

Advanced Financial Integrator, or AFI, provides a framework within which to post details of costs incurred in the manufacturing process to the General Ledger. AFI uses user-defined journal rules to create auditable General Ledger account postings for production tasks.

Each link from Style Production to AFI has a specific application code defined to it. The Style Production AFI application codes are:

- P1 - WIP movements
- P2 - Material movements
- P3 - Labour and machine movements
- P4 - Setting and overhead movements
- P5 - Scrap movements
- P6 - Subcontract movements

These movements can be processed using the standard AFI application and standard General Ledger functions to create trial or actual (live) postings in the General Ledger.

All processed movement records are marked with:

- A General Ledger Update indicator (trial or live)
- A General Ledger session number

This makes sure that you cannot update records more than once.

AFI is a structured application; therefore each production application has its own:

- Application reference data
- Extract task
- General Ledger update program
- Utilities

Considerations

- AFI does update the General Ledger, so you should use it with caution. We recommend that you restrict access to the update tasks.

- The purpose of the Initiate Extract in Test Mode task is to ensure that the data extraction is correct by providing a simulation of the postings that are about to be made. Use this facility to verify the integrity of the journals before committing a live update.
- In a Co-product environment, multiple Standard and Actual Co-product Output Inventory Receipts may exist for a given transaction event. You should take care that you identify all relevant receipts.
- The software takes the posting period used by the standard AFI application. This posting period comes from the current period, which is set in Inventory.

Initiate Production Extracts [1/P1A]

Use this task to extract live data. The way this is done depends on the setting of the Automatically Update GL field on the Application Maintenance window.

- If this field is set for immediate update, the General Ledger updates when the job is complete.
- If this field is not set for immediate update, the data is extracted and made available for review using the Enquire on Extract Sessions Transactions task.

Note: To extract the data without updating the General Ledger, select the Initiate Extract in Test Mode task.

Production Data Extract Selection Window

To display this window, select the Initiate Production Extracts task.

Use this window to enter the information you want to extract.

Fields

Source Company

Enter the company.

Alternatively, use the prompt facility to select from the Company Selection pop-up.

Organisational Model From

Enter the first organisational model in the range.

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

To

Enter the last organisational model in the range.

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

Post WIP Movements

Check this field to extract WIP Movements for review or for updating the General Ledger

Post Material Movements

Check this field to extract material movements for review or for updating the General Ledger

Post Labour & WS Movements

Check this field to extract labour and machine movements for review or for updating the General Ledger

Post Setting & OH Movements

Check this field to extract setting and overhead movements for review or for updating the General Ledger

Post Scrap Movements

Check this field to extract scrap movements for review or for updating the General Ledger

Post Subcontract Movements

Check this field to extract subcontract movements for review or for updating the General Ledger

Select **Submit Job (F8)** to submit the job.

Initiate Extract in Test Mode [21/P1A]

Use this task to carry out a trial extract of data without updating the General Ledger.

Advanced Financial Integrator Trial Posting Window

To display this window, select the Initiate Extract in Test Mode task.

Use this window to select the type of movements on which to perform a trial extract.

Fields

Application Code

Use this to specify the AFI application code for the type of movement you require.

Select one of the following:

WIP Movements (P1)

Material Movements (P2)

Labour/Machine Movements (P3)

Setting/Overhead Movements (P4)

Scrap Movements (P5)

Sub-Contract Movements (P6)

Press Enter to display the Advanced Financial Integrator Trial Posting WIP Movements Header window.

Advanced Financial Integrator Trial Posting WIP Movements Header Window

To display this window, press Enter on the Advanced Financial Integrator Trial Posting window.

Use this window to enter the source company for the trial extract.

Fields

Source Company

Enter the company containing the data you want to extract.

Alternatively, use the prompt facility to select from the Company Selection pop-up.

Press Enter to display the Advanced Financial Integrator Trial Posting WIP Movements Details window.

Advanced Financial Integrator Trial Posting WIP Movements Details Window

To display this window, press Enter on the Advanced Financial Integrator Trial Posting WIP Movements Header window.

Use this window to select the transactions to include in the extract trial data process.

Note: You must specify whether you want to extract test journals, live journals, or both.

Fields

Organisation Model

Enter the live organisational model.

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

Select Transactions

Select one of the following:

All transactions inside Range (0) - To select all the transactions within the specified range

Transactions not yet processed (1) - To select all the unprocessed transactions

Transaction Range From

Enter the first transaction in the range.

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

To

Enter the last transaction in the range.

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

Note: To include all transactions, leave both these fields blank.

Journal Type

Select one of the following:

Test (1) - To extract test journals

Live (2) - To extract live journals

Both (3) - To extract test and live journals

Consolidate Postings

Use this checkbox as follows:

Unchecked - To post entries to the same account individually

Checked - To consolidate postings to the same account

Select **Submit Job (F8)** to start the process.

Enquire on Extract Sessions Transactions [31/P1A]

Use this task to view data extracted by the Initiate Production Extracts task.

AFI Session Enquiry Window

To display this window, select the Enquire on Extract Sessions Transactions task.

This window displays the data extracted by the Initiate Production Extracts task.

<u>Options</u>

Display Session Details

Use this to display details of the transaction session.

These details include:

- The session number
- The terminal ID
- The session opening and closing times
- The total debit and credit values
- The user identity of the person creating the transaction

Display Session Transactions

Use this to display transaction information.

This includes:

- The G/L company
- The transaction source, and source reference
- The posting type
- The posting value and the codes posted to

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

Enquire on Archive Sessions Transactions [32/P1A]

Use this task to archive previous session transactions.

Prompt for AFI-GL/Costing Update

To display this window, select the Enquire on Archive Sessions Transactions task.

Use this window to specify the information to archive.

Fields

Source Application

Enter one of the following AFI application codes for the type of movement you want to view:

P1 - WIP Movements

P2 - Material Movements

P3 - Labour and Machine Movements

P4 - Setting and Overheads Movements

P5 - Production Scrap Movements

P6 - Sub-Contracted Production

Alternatively, use the prompt facility to select from the Application pop-up.

Consolidate GL Postings

Use this checkbox as follows:

Unchecked - Not to consolidate GL postings

Checked - To consolidate GL postings

Run-time Options

Select one of the following:

List only (0) - To review the transactions only

Update (1) - To update the archived transactions

Update and list (2) - To review the transactions and update the archived transactions

Select **Proceed (F8)** carry out the archive.

Install AFI Control Data [41/P1A]

Use this task to set up the link between the Style Production and the AFI applications.

Note: You must select this task when you first set up the AFI links. Subsequently, you should only need to select this task again either if you make changes to the Data Date task in AFI Utilities or if you add new applications.

Select Confirm **Submit (F8)** to submit the batch job.

Change Application [89/P1A]

Use this task to select an AFI application to which to link before using the other AFI tasks.

Select Application Pop-up

To display this pop-up, select the Change Application task.

This pop-up will also be displayed when you select certain AFI tasks, if you have not selected this task first.

Use this pop-up to select an AFI application to which to link.

Options

Select

Use this against the AFI application to which you wish to link.

When you select an AFI application, you will automatically return to the menu. If you do not want to select an application, you can select **Previous (F12)** to leave the task.

Chapter 8   Forecast Management

8

Forecasting within Style Production

Both MPS and MRP use the forecast management tasks in Style Production Definition Management.

You can use:

- Product families, to group related styles together, for forecasting and planning purposes
- Seasonal profiles, to set up a series of demand quantities over contiguous periods

You can then enter a single forecast covering all of the periods within a specified date range. Style uses the seasonal profile to spread demand over the date range.

- Sales forecasts, to represent an anticipated level of sales
- Stock forecasts, to represent planned stock figures

Note: The use of forecasts is not mandatory.

Note: You can use System21 Forecasting to obtain even more detailed forecasting data. You can transfer a forecast from Forecasting to Style Production. Then, either manipulate the forecast within Style Production Forecasting or input the forecast to MPS and MRP.

Prerequisites

The forecasts you create must relate to a specific planning model and year.

To set up a planning model, use the following two tasks:

- Maintain Model Stockrooms
- Use this to set up a planning model and specify the stockrooms you want to include.
- Maintain Reporting Profile
- Use this to set up time buckets for the planning model.

Product Families

A general forecast for a group of related styles can be more accurate than individual forecasts. To this end, you can group related styles into product families.

For example:

- Jackets:
  - Anoraks
  - Ski coats
  - Duffel coats

If you want to use product families, follow the procedure below:

- Use the Descriptions task in Style Inventory Management to set up product family codes under type PGMN.
- For each style that you want to include in a product family, enter the product family in the Minor Sequence field in the Styles task.
- For each style, enter one of the following forecast demand policies in the Demand Policy field on the Production Details window in the Styles task:
  - 1 (forecast compared with independent demand)
  - 2 (forecast compared with total demand)
  - 5 (make to forecast)
  - 6 (total demand)
- For each style, enter a forecast level policy in the Forecast Level field on the Production Details window in the Styles task. To enter forecasts at style level, which Style can explode down to variant level, enter 0 in this field. Otherwise, you can enter forecast levels of 1 or 2 for each style variant.
- Use the Maintain Product Family task to define a percentage distribution of forecast for each style in the product family for a particular planning model. Depending upon the setting of the Forecast Level field for each style, this task creates forecasts at style level or style variant level.

Note: Style does not generate a forecast for a product family as an entity in its own right. That is, a forecast of 50,000 against product family ELF generates individual member forecasts that total 50,000. How the software distributes this 50,000 depends upon the percentage set for each style or style variant.

For example:

A product family called ELF has a total forecast quantity of 100,000. The members of this family consist of pumps, shoes and boots and the percentage distribution for these members is 20%, 20% and 60% respectively.

Therefore, the generated forecast for each member is as follows:

- ELF pumps - 20,000
- ELF shoes - 20,000
- ELF boots - 60,000

Sales and Stock Forecasts

Forecasts project the level of stock you want to maintain and can either be sales projections, or stock production forecasts.

The differences between sales and stock forecasts are as follows:

- A sales forecast is a demand that the software has to meet within a given period. For example, a sales forecast for 3,000 spread evenly over three periods will produce a quantity of 1,000 in each of the three periods.
- A stock forecast is a target level that the software has to maintain during a given period. For example, a stock forecast for 3,000 spread evenly over three periods will result in a stock level of 3,000 in each period.

Either you can generate sales and stock forecasts for quantities, or you can enter a value within a period. Values are converted to quantities for planning purposes by dividing the value entered by either the base list price for sales items or the standard unit cost for stock forecasting.

Note: To determine the start and end dates for a forecast, Style uses the start date from the default production calendar and the days defined in the Maintain Company Profile task.

Sales Forecasts

If the demand policy for a style includes forecasting, Style Production Planning compares sales forecasts with existing sales orders to determine a net demand.

Stock Forecasts

The software does not net stock forecasts against sales orders in the planning process. Consider stock forecasts as orders you use to replenish stock.

Caution: To avoid building excessive levels of inventory, use stock forecasts carefully. Treat stock forecasts as a means of buffering demand uncertainty in the market place.

Forecast Method

You can generate forecasts at daily, weekly and period level, where a period is any length of time exceeding a week.

There are three basic ways of approaching forecasting:

Method 1

Use the Maintain Family Sales Forecast task to create forecasts at product family level, apportioning quantities or values across periods.

Use the Generate Style Sales Forecast task to generate or manipulate a style forecast for each product family member.

Method 2

In addition to the ways described in Method 1, you can use the Spread Style Sales Forecast task to spread the forecast to daily and weekly levels.

Method 3

Use the Maintain Style Sales Forecast task to create and manipulate forecasts specifically at style or style variant level.

If you have entered forecasts at style level, use the Generate Variant Sales Forecast task to explode forecasts down to style variant level.

Note: At whatever level you enter a forecast, you can use the Generate Variant Sales Forecast task to explode forecasts down to each style variant.

Note: Even if you do not explode forecasts down to style variant level, Style Production Planning will generate a variant level forecast.

Indices

You must spread each forecast quantity or value over a number of daily, weekly or longer periods.

You can enter forecasts for these individual periods in the following ways:

- Manually
- Period by period
- By entering a series of indices against each period

This automatically spreads the forecast according to the index values.

For example:

Spread Forecast Using Indices											
Forecast Total Quantity = 100 Index Total = 200											
Indices	10	20	10	20	10	10	10	10	30	30	40
Generated Forecast	Days					Weeks			Periods		
	5	10	5	10	5	5	5	5	15	15	20

Where Index / Index Total x Forecast Total Quantity = Generated Forecast

Smoothing Policy

When you use weekly forecast figures in a forecast, Style Production Planning assumes that you want to generate the demand on the Monday of that week.

You can set the Smoothing Policy field on the Production Details window in the Styles task to spread a weekly forecast evenly over each working day in a week.

Caution: Take care over smoothing the forecast over a long period, as a considerable amount of additional data has to be stored. In general, use the smoothing option and the ability to

generate daily forecasts for short-term forecasts, ideally for a maximum period of 2-3 months.

Maintain Product Family [1/P1F]

Use this task to define percentages for each style or style variant in a particular product family. The percentages reflect the relative market popularity or production volume of each style.

Style uses these percentages to apportion the forecast total across the whole product family.

Prerequisite

To add a style to a product family, enter the product family in the Minor Sequence field in the Styles task.

Maintain Product Family Selection Window

To display this window, select the Maintain Product Family task.

Use this window to enter the model.

Fields

Model

Enter a planning model.

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

Press Enter to display the Maintain Product Family List window.

Maintain Product Family List Window

To display this window, enter a model and then press Enter on the Maintain Product Family Selection window.

Use this window to select the product family.

Fields

Profile

If you have already defined a percentage breakdown for a product family, **Y** is displayed against it in this field.

Options

Select Product Family

Use this to display the Maintain Product Family Percentage window.

Use Select Product Family against a product family to display the Maintain Product Family Percentage window.

Maintain Product Family Percentage Window

To display this window, use Select Product Family against a product family on the Maintain Product Family List window.

This window displays a list of styles, or style variants, which are included in the selected product family.

Note: The level at which each style is displayed depends on the forecast level for the style, which is set up in the Styles task.

Fields

Type

This field displays the item type as follows:

MAN - For a manufactured product

PUR - For a purchased item

B/O - For a bought out item

MPS

This field displays the planning type as follows:

0 - For a Material Planning (MRP) item

1 - For a Production Scheduling (MPS) item

Percentage

Enter a percentage against each of the styles.

Note: You can enter a zero percentage against a style or variant.

The total percentage you enter must equal 100%.

Functions

Delete (F11)

Use this to delete the information on the window. You will be asked to select **Delete (F11)** again to confirm the deletion.

Select **Update (F8)** to save the percentages and leave the task.

Maintain Seasonal Indices [2/P1F]

Use this task to create and maintain a seasonal profile. You can use seasonal profiles as templates to break down forecasts to period, weekly and daily levels.

A seasonal profile holds a range of indices against daily, weekly or period buckets. You can apply a seasonal profile to any product family or style

Seasonal profiles are not mandatory, but if you use them, you can represent seasonal variations in the forecast. You can also use a seasonal profile to define a default forecast profile that is not subject to seasonal variation.

Use of seasonal profiles speeds up the forecasting process. If you enter a forecast total for a style, the forecast is automatically spread by the defined seasonal profile.

You can also enter period level forecasts using the Maintain Family Sales Forecast task and the Maintain Style Sales Forecast task.

You can assign a default seasonal profile to a style via the Styles task.

Note: Seasonal profiles are specific to a particular year and planning model. Therefore, create one seasonal profile per model per year.

Maintain Seasonal Indices Selection Window

To display this window, select the Maintain Seasonal Indices task.

Use this window to specify the seasonal profile you want to create or maintain.

Fields

Model

Enter the planning model to which the seasonal profile relates.

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

Profile Code

Enter a profile code to create or maintain. If this is a new seasonal profile, you can enter a maximum of 2 characters.

Alternatively, use the prompt facility to select from the Select Seasonal Index pop-up.

Note: The profile code itself does not have to be unique; it is possible to have additional profiles with the same code if the associated model and year are different.

Year

Enter the year to which the profile is relevant. This default is the current year.

Entry Level

Select one of the following:

Period (1) - To display the Maintain Seasonal Period Indices window

You can use this to define the profile by period. You can then break the profile down to weekly periods.

Weekly (2) - To display the Maintain Seasonal Weekly Indices window

You can use this to define a weekly profile.

Note: You can enter daily indices for both period and weekly profiles.

Base On Profile

If you are creating a new profile based on an existing profile code, enter the existing profile code here.

Alternatively, use the prompt facility to select from the Select Seasonal Index pop-up.

Note: The model, year and entry level of the new profile code must match the model, year and entry level of the existing profile code.

epending on what you entered in the Entry Level field, press Enter to display the Maintain Seasonal Indices Period window or the Maintain Seasonal Indices Weekly window.

Maintain Seasonal Indices Period Window

To display this window, select Period in the Entry Level field on the Maintain Seasonal Indices Selection window.

Use this window to break down forecasts to period level. From this window, you can also refine the period profile to weekly periods, and enter daily indices.

<u>Fields</u>

Profile

If this is a new profile, you must enter a profile description. Enter up to 30 alphanumeric characters to describe this seasonal profile.

Calendar

This displays the calendar you have defined for this planning model in the company profile. If you have not defined one, the default company profile calendar is displayed.

Daily Indices

You can optionally enter indices against each day of the week that you want to include in the forecast.

Index

Enter indices against the periods that you want to include in the forecast.

%

This field is displayed when you select **Display Percentages (F18)**. It indicates the percentage distribution represented by your period index entries.

Functions

Delete (F11)

Use this to delete the information on the window. Select **Delete (F11)** on the Confirm Delete pop-up to confirm the deletion.

Period Indices (F16)

Use this to input period indices when weekly indices are displayed.

Weekly Indices (F17)

Use this to display the weekly indices fields for input.

Display Percentages (F18)

Use this to calculate period indices as percentages and display the results in the **%** field.

Select **Add (F8)** or **Update (F8)** to save the indices and return to the Maintain Seasonal Indices Selection window.

Maintain Seasonal Indices Weekly Window

To display this window, select Weekly in the Entry Level field on the Maintain Seasonal Indices Selection window.

Use this window to break down forecasts to weeks rather than periods. You can enter relative values, which can be converted to percentages, rather than absolute values.

You can also enter indices for each day of the week.

Example

Take a profile covering 10 weeks. The index values that you might enter and the resulting percentages are as follows:

- Period 1 - 3, with an index value of 1, results in 4%.
- Period 4 - 6, with an index value of 2, results in 8%.
- Period 6 - 10, with an index value of 4, results in 16%.

Fields

Profile

If this is a new profile, you must enter a profile description. Enter up to 30 alphanumeric characters to describe the seasonal profile.

Calendar

This field displays the calendar you have defined for the selected planning model in the company profile. If you have not defined a calendar for the model, the default company profile calendar is displayed.

Daily Indices

You can optionally enter indices against the days of the week you want to include in the forecast.

Index

Enter indices against the weeks that you want to include in the forecast.

%

This field is displayed when you select **Display Percentages (F18)**. It displays the percentage distribution represented by your weekly index entries.

Functions

Delete (F11)

Use this to delete the information on the window. Select **Delete (F11)** on the Confirm Delete pop-up to confirm the deletion.

Display Percentages (F18)

Use this to calculate weekly indices as percentages and display the results in the **%** field.

Select **Add (F8)** or **Update (F8)** to save the indices and return to the Maintain Seasonal Indices Selection window.

Maintain Family Sales Forecast [11/P1F]

Use this task to create and maintain sales forecasts at product family level.

Note: Maintain Family Stock Forecast (31/P1F) is the equivalent task for stock forecasts.

Prerequisites

You must have set up:

- A planning model, using the Maintain Model Stockrooms task
- A product family, using the Maintain Product Family task

Maintain Family Sales Forecast Selection Window

To display this window, select the Maintain Family Sales Forecast task.

Use this window to select a planning model, year, product family and seasonal profile for the forecast.

Fields

Model

Enter the planning model to which the forecast applies.

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

If you are using the forecast to drive MPS and MRP, enter the live planning model.

Year

Enter the year to which the forecast relates.

Note: You should have already defined a production calendar for the year that you enter here for the calendar specified on the model's reporting profile.

Product Family

Enter a product family code.

Alternatively, use the prompt facility to select from the Select Product Family pop-up.

Forecast Basis

Select one of the following:

Quantity (1) - To base the forecast on quantity

Value (2) - To base the forecast on value

Seasonal Profile

You can optionally enter a seasonal profile.

Alternatively, use the prompt facility to select from the Select Seasonal Index pop-up.

This seasonal profile can act as a template for forecasts.

By entering a seasonal profile, you specify the level that you can maintain the forecast:

- **Weekly seasonal profile** - You can only enter daily and weekly intervals.
- **Period seasonal profile** - You can enter daily, weekly and period intervals.

Note: To spread values for the forecast evenly, leave this field blank.

Maintain Intervals

Use this to define how to spread the forecast total, without entering each spread figure individually.

Use this checkbox as follows:

Unchecked - To display the Maintain Family Sales Forecast Period window

Checked - To display the Maintain Family Sales Forecast Intervals window, on which you can specify the total forecast quantity or value and define how to spread the daily, weekly and period time buckets

Include Backlog

Use this to display the outstanding sales orders form the last planning run for the forecast model selected.

Use this checkbox as follows:

Unchecked - Not to view the backlog

Checked - To view the backlog

Leave the Maintain Intervals field unchecked and then press Enter to display Maintain Family Sales Forecast Period window.

Maintain Family Sales Forecast Intervals Window

To display this window, check the Maintain Intervals field on Maintain Family Sales Forecast Selection window.

Use this window to spread a revised forecast over selected intervals, and to replace any existing forecast values.

If you are using a seasonal profile, the forecast is broken down according to the indices defined on the profile. Otherwise, the software spreads the forecast evenly over the existing forecast time intervals.

It is usual when spreading forecasts to select daily intervals for the earliest week or weeks in the forecast, weekly intervals for intermediate weeks, and periods for the longer-term part of the forecast.

Note: You cannot use period buckets if you have selected a weekly-based seasonal profile, as these do not include periods.

The Control Details section of the window displays the last week for which a forecast has been set up and, where relevant, the daily and weekly forecast boundaries as generated by the last item batch spread.

Note: If you have maintained a particular style forecast interactively, via the Maintain Style Sales Forecast task, the control details displayed may not represent the current status of the forecast. If this is the case, you should examine the forecast details separately.

You can display the calendar structure, showing start and end weeks in each period, for forecasts containing period level details.

Fields

Planning Model

This field displays the planning model you have specified.

Year

This field displays the year you have specified.

Calendar

This field displays the calendar used by this model.

Product Family

This field displays the product family to forecast.

Total Forecast

This field displays the total forecast quantity. The amount you enter in the Forecast Quantity to Spread field is added to this Total Forecast field if it applies to a period not already covered by the existing total.

Control Details

Daily Forecasts to Week

This field displays the week number up to which the software has generated daily forecasts.

Weekly Forecasts to Week

This field displays the week number up to which the software has generated weekly forecasts.

Last Week of Forecast

This field displays the last week of the forecast that has a non-zero balance. If this is a period forecast, the last week will be the end week of the period.

Spread Details

You must spread the forecast figure across a range of daily, weekly and period intervals. The intervals must be contiguous and, for calculation purposes, some intervals are limited to period start and end weeks.

For forecasts that include period intervals, the software can display the production calendar to show period start and end weeks.

The information presented on the window defaults to the selections previously made for this family, planning model and year.

Forecast Quantity to Spread

The forecast quantity you enter here splits according to the seasonal profile you select, or if you enter no profile, the figure spreads evenly across all the intervals in the forecast period.

Daily Forecasts From Week/To Week

Enter the number of weeks for which daily forecasts are required, in terms of start and stop weeks.

Weekly Forecasts From Week/To Week

Enter the number of weeks for which weekly forecasts are required, in terms of start and stop weeks.

Period Forecasts From Week/To Week

Enter the number of weeks for which period forecasts are required, in terms of start and stop weeks.

Press Enter to build the forecast and display the Maintain Family Sales Forecast Period window.

Maintain Family Sales Forecast Period Window

To display this window, press Enter on the Maintain Family Sales Forecast Intervals window.

Alternatively, leave the Maintain Intervals field unchecked on the Maintain Family Sales Forecast Selection window.

Use this window to see the effects of the forecasting indices you have put in place.

The information displayed depends on how you access the window:

- If you are creating a forecast without having maintained intervals or specifying a seasonal profile, all data input fields are blank and you need to enter a total forecast figure and indices.
- If you are creating a forecast without having maintained intervals, but you have specified a seasonal profile, the indices are displayed automatically and all other input fields are blank.
- If you are creating a forecast having maintained intervals, but you have not applied a seasonal profile, the total quantity without indices is displayed.
- If you are creating a forecast having maintained intervals, and you have applied a seasonal profile, the indices are displayed automatically.

Note: If you want to use the Spread Style Sales Forecast task to generate daily and weekly forecasts, enter a total forecast value only.

Note: The Generate Style Sales Forecast task spreads this forecast to each family member prior to creating detailed forecasts.

Fields

Total Forecast Quantity

This applies to sales forecasts only.

Enter or update the total forecast figure and then enter an index against each forecast time bucket.

Stock Target Quantity

This applies to stock forecasts only.

This field displays the Inventory target quantity within each period.

Seasonal Profile

You can enter a different seasonal profile. This is the profile used if you select a period to week or week to day breakdown.

If you leave this field blank, the software spreads the forecast figure evenly across the selected forecast periods.

You can use the prompt facility on this field to select from the Select Seasonal Index pop-up.

Position to Period

Enter a period number at which to start the display.

Period

This field displays the forecast breakdown in terms of daily, weekly and period intervals, or time buckets.

Daily buckets are displayed in the same format as weekly buckets except that the start field shows the day and not a start date. You cannot maintain or select these buckets.

Weekly buckets are displayed in the format PPnn, where PP is the period number and nn is the week number. To break down these periods into daily buckets, use Select to Spread.

Period buckets use a period number to indicate buckets, for example, 01 or 02 or 10. To break down these periods into weekly buckets, use Select to Spread.

If no seasonal profile is used, or if the profile has no daily indices set up, the company profile weekly template of working and non-working days is used to distribute the forecast figure over the daily forecast.

Start

This field displays the first day in the period or week. If it is a daily bucket, this field displays the day.

Index

Enter an index value to determine how the forecast spreads over a period.

If you entered a seasonal profile on Maintain Family Sales Forecast Selection window, this field is automatically completed.

Quantity

Enter the quantity.

Backlog At

This field applies to sales forecasts only and is only displayed if you select the Include Backlog field on Maintain Family Sales Forecast Selection window.

This field displays the outstanding sales orders, due from the last MPS run for the selected planning model.

Options

Select to Spread

Use this against a period, or weekly, forecast to break down the total to weekly or daily buckets respectively. The Daily Spread pop-up is displayed.

Functions

Barchart (F14)

Use this to display the Forecast Barchart window.

Apply Index (F17)

Use this to re-calculate the quantities based on the index values.

Stock Forecasts (F18)

Use this to change the display between quantity and value. You can only use this for stock forecasts.

Update/Style Level Forecasts (F20)

Use this to save the current forecast details and to create style level forecasts. This works in the same way as the Generate Style Sales Forecast task.

Select **Update (F8)** to update the forecast.

Weekly Spread Pop-up

To display this pop-up, use Select to Spread against a period forecast on the Maintain Family Sales Forecast Period window.

Use this pop-up to spread period forecasts over weeks. You can also spread weekly intervals down to days.

Fields

Total Quantity

This field displays the total figure for the period you have selected. You can adjust this figure and spread the total across each week in the period.

Seasonal Profile

This field displays the default seasonal profile for the forecast. You can change it if necessary.

You can use the prompt facility on this field to select from the Select Seasonal Index pop-up.

Index

This field displays the sum of all the indices in the period.

(Entered) Quantity

This field displays the sum of all the quantities in the period.

Index

You can enter or update the index for the week.

Quantity

You can enter or update the quantity.

Options

Select to Spread

Use this to display the Daily Spread pop-up, which you can use to spread weekly forecasts to days.

Functions

Apply Index (F17)

Use this to re-calculate the quantities when a change has been made to the index figures.

Select **Previous (F12)** to return to the Maintain Family [Sales Forecast](#) Period window.

Daily Spread Pop-up

To display this pop-up, use Select to Spread against a weekly forecast on the Maintain Family [Sales Forecast](#) Period window, or on the Weekly Spread pop-up.

Use this pop-up to spread weekly forecasts down to a daily level.

Fields

Week Total

This field displays the quantity for the week you select. You can adjust this figure and spread the total across each day in that week.

Entered

Index

This field displays the sum of all the indices for the week.

Quantity

This field displays the sum of all the quantities for the week.

Index

You can enter or update the index for the day.

Quantity

You can enter or update the quantity for the day.

Functions

Apply Index (F17)

Use this to re-calculate the quantities when a change has been made to the index figures.

Select **Previous (F12)** to return to the Maintain Family [Sales Forecast](#) Period window.

Forecast Barchart Window

To display this window, select **Barchart (F14)** on the Maintain Family [Sales Forecast](#) Period window.

This is a graphical representation of the yearly forecast.

Note: Scroll left and right to see more weeks on the bar chart.

<u>Fields</u>

Planning Model

This field displays the planning model to which the forecast applies.

Calendar

This field displays the calendar to which the forecast applies.

Year

This field displays the year to which the forecast applies.

Product Family

This field displays the product family to which the forecast applies.

Alter Scale

Enter a figure to change the default scaling rule. Because a weekly increment is used, the following rules apply to period and daily forecasts:

- The software divides period forecasts by the number of weeks contained in the period. For example, if a period of 4 weeks has a forecast of 200, each week is displayed as 200/4=50.
- Daily forecasts accumulate throughout the week and the software displays the resulting weekly total.

The maximum forecast quantity controls the Y-axis. You can change it by entering a figure in the Alter Scale field.

Select **Previous (F12)** to return to the Maintain Family Sales Forecast Period window.

Select Item Pop-up

To display this pop-up, select **Update/Style Level Forecasts (F20)** on the Maintain Family Sales Forecast Period window.

Use this pop-up to update forecasts at style level. The pop-up displays all the styles in the product family and the percentage distribution to use when calculating the forecast spread.

You can calculate and display forecast quantities relevant to each style.

<u>Fields</u>

Position To

Enter the style or variant at which to start the display.

Select

Enter **1** against a style to maintain a specific forecast quantity.

Select **Previous (F12)** to return to the Maintain Family Sales Forecast Selection window.

Stock Level Profile Pop-up

To display this pop-up, select **Stock Profile (F22)** on the Maintain Family Stock Forecast Period window.

This is only available in the Maintain Family Stock Forecast task.

You can use this pop-up to build a stock profile, using:

- A date range
- A target date
- A target quantity

The date ranges define the dates for which you want to build the forecast, and the quantity specifies the stock level that you should reach on the target date.

A stock forecast is generated to meet the profile. It is possible to build a stock profile over more than one forecast year. You do this by defining the same four parameters over consecutive years.

Fields

From Date

Enter or select the start date of the forecast profile.

To Date

Enter or select the last date of the forecast profile.

Target Date

Enter or select the date by which you want to achieve the target.

Target Quantity

Enter the stock level to achieve by the target date.

Press Enter to update the data and return to the Maintain Family Sales Forecast Period window.

Generate Style Sales Forecast [12/P1F]

Use this task to generate a style level forecast, for one or more product families. The task breaks down each product family you select into forecasts for each individual family member in proportion to the percentages you defined using the Maintain Family Sales Forecast task.

Note: Generate Style Stock Forecast (32/P1F) is the equivalent task for stock forecasts.

You can use the Maintain Style Sales Forecast task to view the forecast.

Note: This task is only relevant to product families.

Caution: This task regenerates forecasts for ALL selected styles. If you have amended individual member forecasts, they are overridden.

Generate Style Sales Forecast Selection Window

To display this window, select the Generate Style Sales Forecast task.

Use this window to select a planning model, a year and a range of product families, for the forecast.

Fields

Model

Enter a planning model.

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

Year

Enter the year to forecast.

Family

Enter the first product family to include in the forecast.

Alternatively, use the prompt facility to select from the PGMN Product Group - Minor pop-up.

To

Enter the last product family to include in the forecast.

Alternatively, use the prompt facility to select from the PGMN Product Group - Minor pop-up.

Note: You can leave both of these fields blank to include all product families.

Press Enter to display the Generate Style Sales Forecast Details window.

Generate Style Sales Forecast Details Window

To display this window, press Enter on the Generate Style Sales Forecast Details window.

This window displays the selected product families.

Fields

Select (Sel)

Enter **1** against the product families for which you want to generate forecasts.

Select **Submit Job (F8)** to start the forecast batch process.

Maintain Style Sales Forecast [13/P1F]

Use this task to generate sales forecasts at style or style variant level:

Note: Maintain Style Stock Forecast (33/P1F) is the equivalent task for stock forecasts.

- If you want to use style level, the Forecast Level field for the style must be set to **0** in the Styles task.

- If you want to use style variant level, the Forecast Level field must be set to either **1** (style/colour) or **2** (style/colour/size) in the Styles task.

Note: If you enter forecasts at style level, you can use the Generate Variant Sales Forecast task to spread the forecast to style variant level.

Maintain Style Sales Forecasts Selection Window

To display this window, select the Maintain Style Sales Forecast task.

Use this window to enter the selection criteria for the style sales forecast you want to maintain.

Fields

Model

Enter the planning model to which the forecast applies.

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

If you are using the forecast to drive MPS and MRP, enter or select the live planning model.

Year

Enter the year to which the forecast applies.

Item

Enter the style, or style variant, you want to use when creating or maintaining a forecast. The level must be the same as the forecast level set in the Styles task.

For example:

- If the Forecast Level field for a style is set to **0** (Style), enter the style.
- If the Forecast Level field for a style is set to **1** (Style/Colour), enter a style/colour variant.
- If the Forecast Level field for a style is set to **2** (Style/Colour/Size), enter a style, colour or size variant.

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

Caution: If you enter a style level that does not match the style's forecast level, an error message is displayed: "Item is not a Forecast Item".

Forecast Basis

Select one of the following:

Quantity (1) - To base the forecast on quantity

Value (2) - To base the forecast on value

Seasonal Profile

You can optionally enter a seasonal profile.

Alternatively, use the prompt facility to select from the Select Seasonal Index pop-up.

By entering a seasonal profile, you also determine the level to which you can maintain the forecast:

- If the seasonal profile is weekly, you can only enter daily and weekly intervals.
- If the seasonal profile is by period, you can enter daily, weekly and period intervals.

Note: Leave this field blank to spread the forecast values evenly.

Maintain Intervals

You can use this field to define how to spread the forecast total, without having to enter each spread figure individually.

Use this checkbox as follows:

Unchecked - To display the Maintain Family Sales Forecast Details window

Checked - To display the Maintain Family Sales Forecast Maintain Intervals window

Include Backlog

You can include outstanding sales orders, specifically, those due within the run dates of the last planning run, for the forecast model you have selected.

Use this checkbox as follows:

Unchecked - Not to include the backlog

Checked - To include the backlog

Check the Maintain Intervals field and then press Enter to display Maintain Style Sales Forecasts Maintain Intervals window.

Alternatively, leave the Maintain Intervals field unchecked and then press Enter to display Maintain Style Sales Forecasts Details window.

Maintain Style Sales Forecasts Maintain Intervals Window

To display this window, check the Maintain Intervals field and then press Enter on the Maintain Style Sales Forecasts Selection window.

This window is the same as the Maintain Family Sales Forecast Intervals window. For more details, refer to the Maintain Family Sales Forecast section of this guide.

Press Enter to display the Maintain Style Sales Forecasts Details on window.

Maintain Style Sales Forecasts Details Window

To display this window, press Enter on the Maintain Style Sales Forecasts Maintain Intervals window.

Alternatively, leave the Maintain Intervals field unchecked and then press Enter on the Maintain Style Sales Forecasts Selection window.

> For more details regarding the fields on this window, please refer to the Maintain Family Sales Forecast Period Window section of this guide.

Only the fields and functions which differ from those on the Maintain Family Sales Forecast Period window section are described below.

Fields

% of Group

This field displays the proportion percentage that this style makes up of its product family.

Functions

Display Values (F18)

Use this to change the display between quantity and value.

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

Spread Style Sales Forecast [14/P1F]

You can use this task to produce a horizontal spread by breaking down total, or gross, forecasts to daily and weekly intervals.

You could enter these forecasts at product family level, and then generate them for each style. However, they would not contain a detailed breakdown to style variant level.

You can also use this task to spread forecasts entered at style level, rather than by product family.

Breakdown intervals must be contiguous and you must enter at least one set of intervals.

Note: Spread Style Stock Forecast (34/P1F) is the equivalent task for stock forecasts.

Spread Style Sales Forecast Selection Window

To display this window, select the Spread Style Sales Forecast task.

Fields

Model

Enter the planning model to which this forecast applies.

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

Year

Enter the year to which this forecast applies. The default is the current year.

Product Family

Enter a product family.

Alternatively, use the prompt facility to select from the Select Product Family pop-up.

Note: You can leave this field blank to include all selected styles that have forecasts.

From Style

Enter the first style to include.

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

To Style

Enter the last style to include.

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

Note: To include all styles, leave both these fields blank.

Forecast Basis

Select one of the following:

Quantity (1) - To base the forecast on quantity

Value (2) - To base the forecast on value

Press Enter to display the Spread Style Sales Forecast Details window.

Spread Style Sales Forecast Details Window

To display this window, press Enter on the Spread Style Sales Forecast Selection window.

This window displays the styles you selected on the Spread Style Sales Forecast Selection window.

Use this window to:

- Select the styles for which to spread forecasts
- Enter the seasonal profile you want to use for each style

Fields

Select

Use **Select** against a style to create daily and weekly forecasts.

Seasonal Profile

Enter or update the seasonal profile.

The default is the seasonal profile, if any, entered on the styles.

Total Forecast Quantity

This field displays the generated total forecast quantity.

Note: This field displays a value only if you have generated a value forecast.

Intervals

Daily Forecasts From Week

Enter the first week number, within the planning model, for which you want to produce daily forecasts.

To Week

Enter the last week number, within the planning model, for which to produce daily forecasts.

Weekly Forecasts From Week

Enter the first week number, within the planning model, for which you want to produce weekly forecasts.

To Week

Enter the last week number, within the planning model, for which you want to produce weekly forecasts.

Functions

Select All (F15)

Use this to select all the styles for the forecast spread process.

Display Values/Display Quantities (F18)

Use this change the display between total forecast quantity and total forecast value.

Select **Submit Job (F8)** to process the forecast spread.

Generate Variant Sales Forecast [15/P1F]

Use this task to break down all forecasts to variant level.

Note: Generate Variant Stock Forecast (35/P1F) is the equivalent task for stock forecasts.

To determine how to spread forecasts from style to variant level, the software uses the information entered for routes on the Variant Spread pop-up.

Subsequently, there is no real way to look at forecasts at variant level. However, this task may make slight modifications to the forecast at style level. To view these modifications, you need to use the Maintain Style Sales Forecast task.

Caution: If you do not run this task, MPS considers the variant level forecasts as a demand. However, the MPS output window will show forecasts as unexploded forecasts with code YF alongside. MPS will suggest production orders to satisfy this demand, but cannot

> suggest the variant ratio; that is, the production order at style level. In addition, MPS cannot consider any existing stocks that you might already have.

Spread Style Forecast Selection Window

To display this window, select the Generate Variant Sales Forecast task.

Use this window to enter the selection criteria for spreading the style forecast.

Fields

Model

Enter the planning model.

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

Year

Enter the year.

Press Enter to display Spread Style Forecast Details window.

Spread Style Forecast Details Window

To display this window, press Enter on the Spread Style Forecast Selection window.

This window displays style forecasts at variant level.

Fields

Total Forecast Quantity

This field displays the total forecast quantity spread between each variant, in accordance with the variant spread defined on the style's planning route/BOM.

Current Spread

If you have already spread a style forecast down to variant level, **1** is displayed against it in this field.

Options

Select

Use this against a style to select it.

Select **Submit Job (F8)** to submit the job to generate the forecast.

Maintain Model Stockrooms [21/P1F]

Use this task to set up a planning model.

For more information, please refer to the Maintain Model Stockrooms section in the Style Production Planning product guide.

Appendix A Glossary

A

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 re-calculated 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 seven 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 issued automatically 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 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, before 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 work flow.

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 task.

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 re-opened 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 the Production Details window in the Style/Material Details task 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 in the Style Route/Bill of Materials task.

Change Item Type descriptions through the PITP parameter in the Maintain Parameter File task.

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. 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 re-scheduling logic when balancing supply and demand. Set up planning filters under the WTYP parameter in the Maintain Parameter File task. Allocate a planning filter to a style on the Production Details window in the Style/Material Details task. To override a planning filter on an individual route, use the MPS/MRP Filter field on Style/Route Override Maintenance window 3 in the Style Route/Bill of Material task.

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 in the Style/Material Details task.

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 on the Production Details window in the Style/Material Details task.

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 work flow. 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 task. The Profile Code field under this task identifies each seasonal profile. To allocate a seasonal profile to a style, enter the Profile Code in the Seasonal Profile field in the Style/Material Details task.

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 before 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:

Style is the System21 Style product

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

These 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.